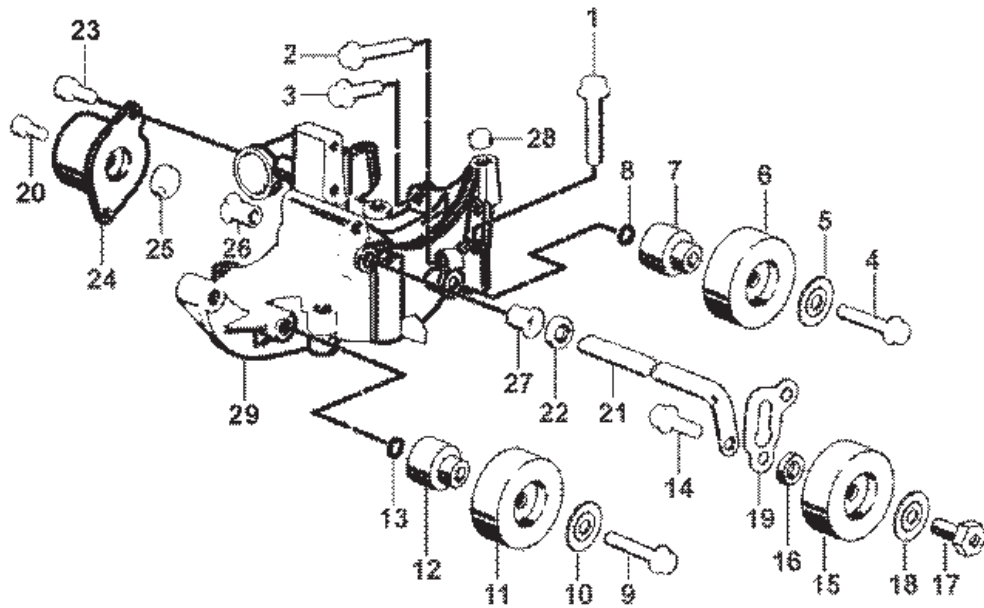


# 13 73 37 Disassembling and assembling belt tensioner

## Assembly note



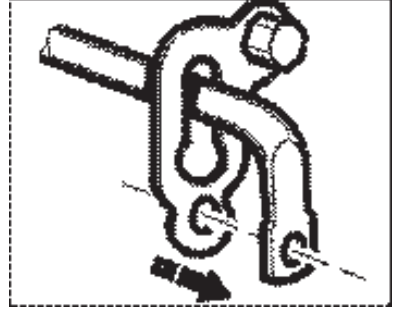
No.	Designation	Qty.	Removal	Installation
1	Hexagon-head bolt M10 x 60	4		Insert the front right hexagon-head bolt (direction of travel) with Loctite 574. Tightening torque: 65 Nm (48 ftlb.)
2	Hexagon-head bolt M8 x 55	1		
3	Hexagon-head bolt M8 x	2		

## einordnung

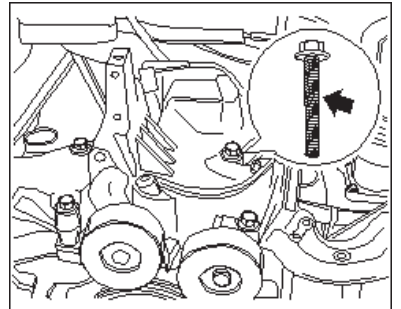
25			
4	Hexagon-head bolt M8 x 55	1	Tightening torque 23 Nm (17 ftlb.)
5	Cover plate	1	
6	Deflection roller	1	Check for smooth running or roughness before undoing
7	Spacer	1	
8	O-ring	1	Check, replace if necessary
9	Hexagon-head bolt M8 x 55	1	Tightening torque: 23 Nm (17 ftlb.)
10	Cover plate	1	
11	Deflection roller	1	Check for smooth running or roughness before undoing
12	Spacer	1	
13	O-ring	1	Check, replace if necessary
14	Hexagon-head bolt (micro-encapsulated) M10 x 30	1	Replace
15	Tensioning roller	1	Undo at the hexagon (wrench size 24) and simultaneously counter at the hexagon-head bolt Tightening torque: 60 Nm (44 ftlb.) Counter at the hexagon-head bolt when tightening (wrench size 15)
16	Spacer ring	1	
17	Threaded sleeve with hexagon (wrench size 24)	1	
18	Cover plate	1	
19	Transmission lever with hexagon (wrench size 15mm)	1	Thread on to tensioning lever (No. 21). See Assembly note
20	Pan-head screw M6 x 16	1	Tightening torque: 9.7 Nm (7 ftlb.)
21	Tensioning lever	1	Drive out of the tensioning element with a drift (ø 5) Fit in correct position; grease in area of bearing
22	Dust cap	1	
23	Pan-head screw M8 x 16	2	Tightening torque: 23 Nm (17 ftlb.)
24	Tensioning element	1	
25	Dust cap	1	
26	Bearing sleeve	1	Grease with Optimol Optipit grease
27	Bearing sleeve	1	Grease with Optimol Optipit grease
28	Dowel sleeve M6 x 10	2	
29	Bracket	1	

top of page

## Assembly note



1. Thread transmission lever on to tensioning lever.  
Tightening torque: 65 Nm (48 ftlb.)



2. Insert the front right hexagon-head bolt on the bracket with Loctite 574.

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996420, 996421, 996450, 996451, 996620, 996621, 996650, 996651, 996840, 996841

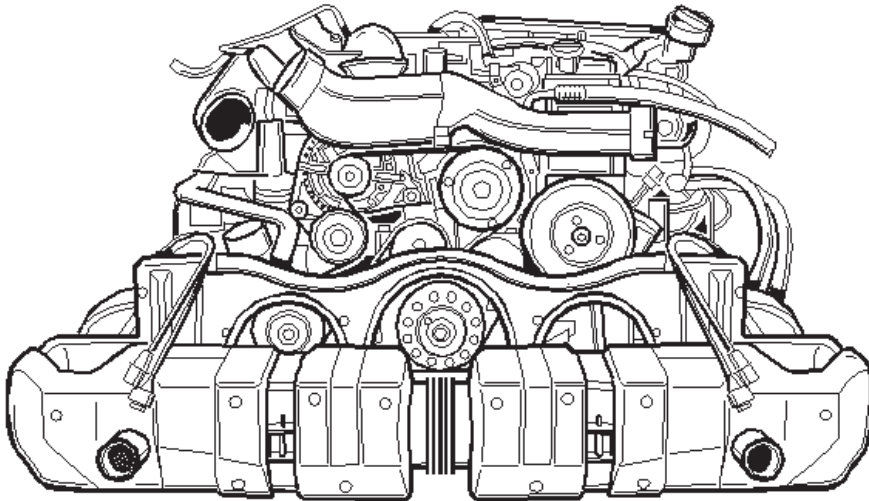
# 13 78 19 Removing and installing drive belt (engine installed)

[Removal overview of the drive belt \(engine installed\)](#)

[Remove drive belt](#)

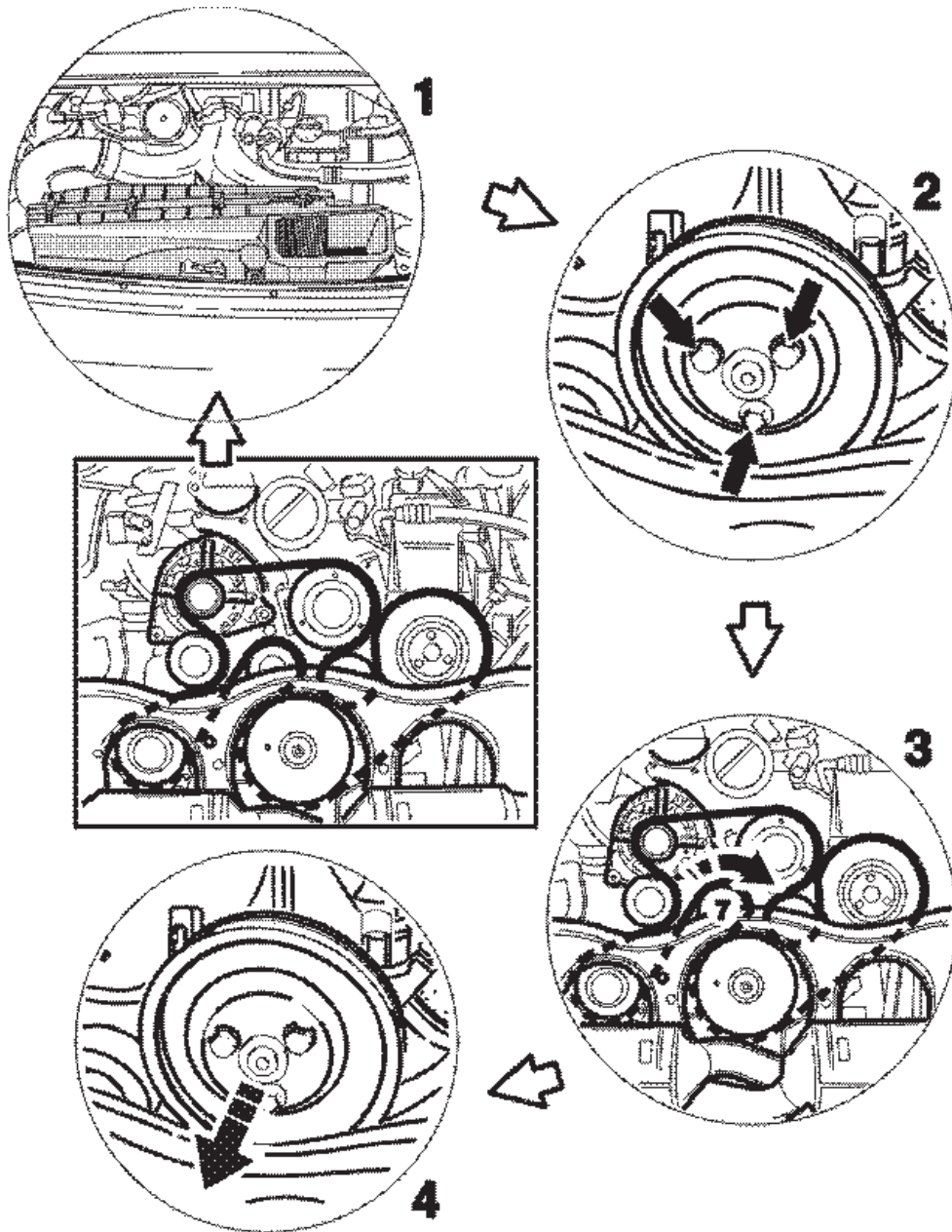
[Installation overview of the drive belt \(engine installed\)](#)

[Install drive belt](#)



[top of page](#)

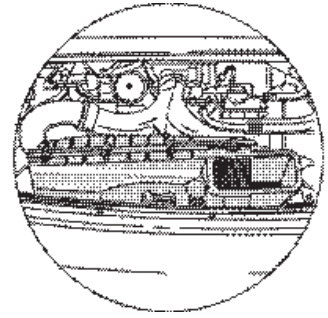
**Removal overview of the drive belt (engine installed)**



- 1 Remove air cleaner assembly
- 2 Loosen servo pump wheel
- 3 Relieve drive belt
- 4 Remove servo pump wheel
- 5 Remove drive belt

[top of page](#)

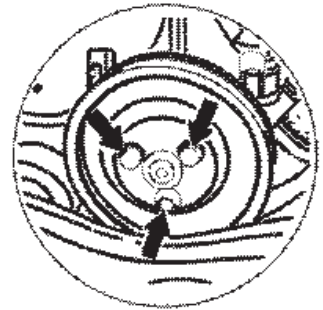
## Remove drive belt



1. Remove air cleaner assembly

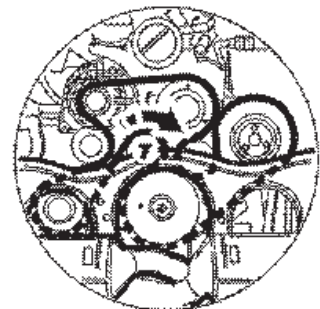
Remove the complete air cleaner assembly.

- a. Undo hexagon-head bolt M6 x 34.
- b. Undo the hose clamp on the throttle body.
- c. Pull off plug from hot film mass air flow sensor and remove air cleaner assembly.



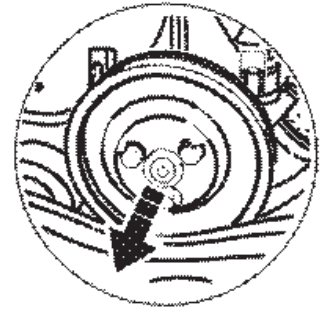
2. Loosen servo pump wheel

- d. Mark belt travel direction with a coloured pen.
- e. Undo the three **hexagon-head bolts** on the servo pump by approx. one half turn.



3. Relieve drive belt

Relieve drive belt. To do this, turn the tensioning roller clockwise and simultaneously remove the belt from the drive pulleys.



4. Remove servo pump wheel



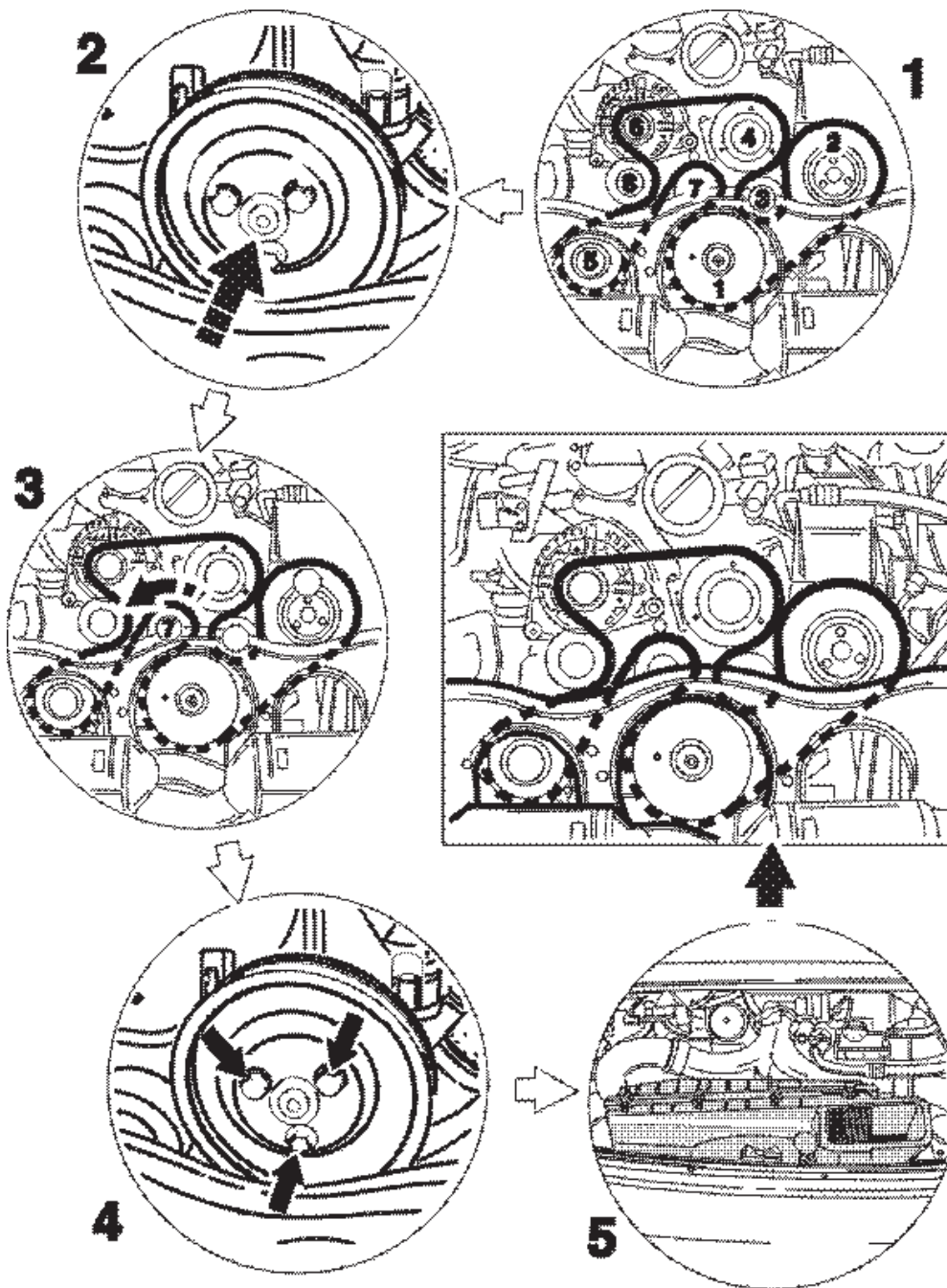
**Note**

- Only remove the servo pump wheel when the drive belt is completely relieved!
- f. Remove servo pump wheel with drive belt to the rear.
- g. Remove the belt from all drive wheels and lift up to remove.

[top of page](#)

## **Installation overview of the drive belt (engine installed)**

einordnung

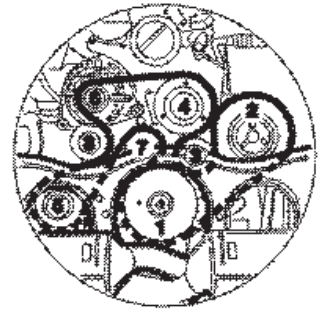


- 1 Fit drive belt
- 2 Position servo pump wheel
- 3 Tension drive belt
- 4 Tighten fastening screws on servo pump
- 5 Install air cleaner assembly

[top of page](#)

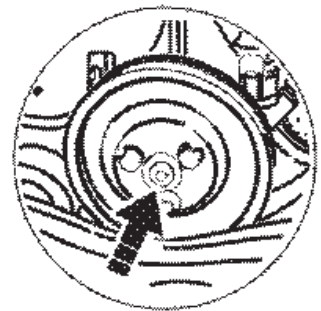


## Install drive belt



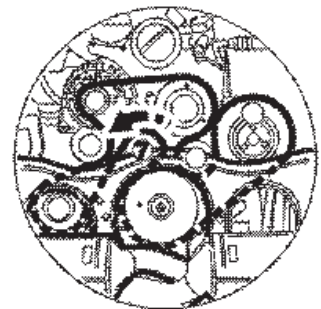
### 1. Fit drive belt

Fit the belt onto the drive wheels.



### 2. Position servo pump wheel

- a. Put on the servo pump wheel together with the drive belt.
- b. Slightly tighten the three fastening screws on the servo pump wheel.

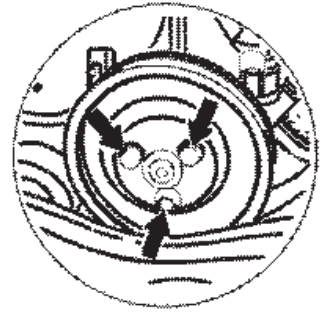


### 3. Tension drive belt



#### Note

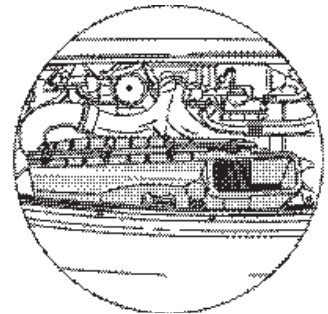
- It is absolutely necessary to check that the drive belt is correctly seated on all belt pulleys!
- c. To tension the drive belt, turn the tensioning roller **-7-** in clockwise direction and simultaneously fit the drive belt on the deflection roller **-8-**.
  - d. Then slowly relieve. To do this, turn the tensioning roller slowly anti-clockwise.



4. Tighten fastening screws on servo pump

Tighten the fastening screws of the servo pump drive wheel.

Tightening torque: 23 Nm (17 ftlb.)



5. Install air cleaner assembly

Install air cleaner assembly completely.

- e. Attach connector onto mass air flow meter.
- f. Tighten the hose clamp on the throttle body.
- g. Tighten the M6 x 34 hexagon-head bolt to 10 Nm (7.5 ftlb.)

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996420, 996421, 996450, 996451, 996620, 996621, 996650, 996651, 996840, 996841