

Drill Holes on the Right-hand Side for Adapter KM-412-2 (Z22 SE)

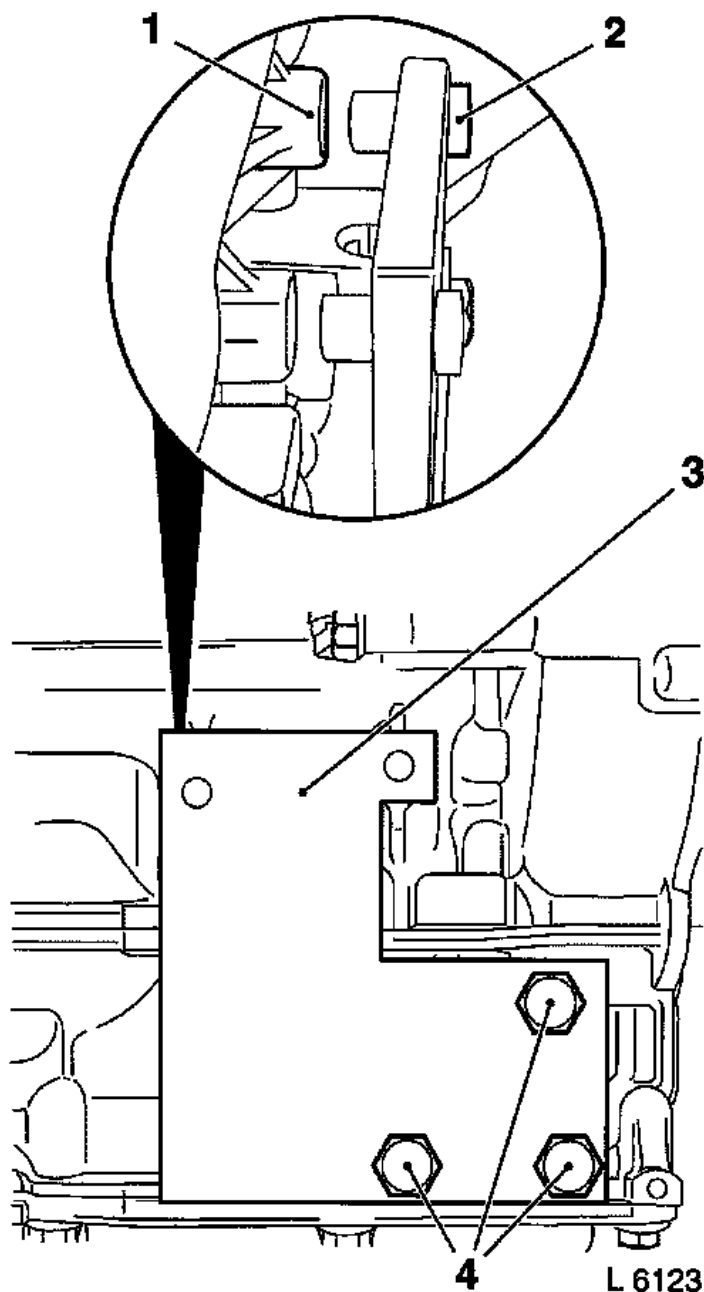
1. Lower the engine onto the workbench.

Note: 2 technicians required.

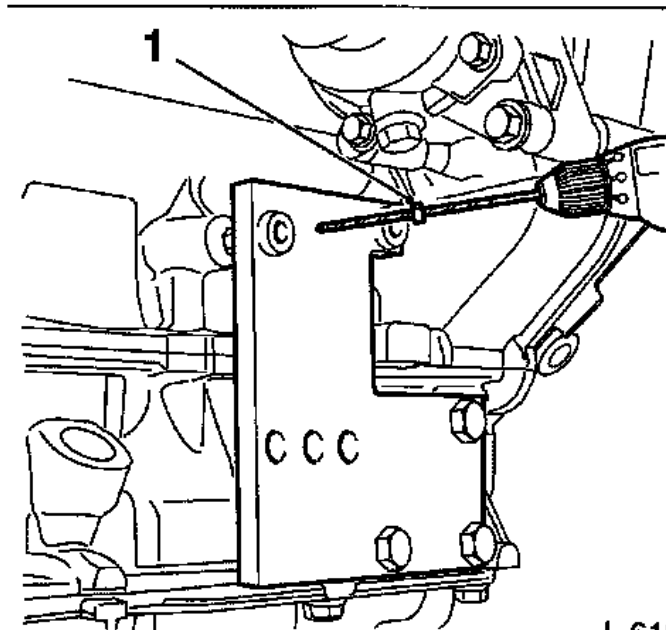
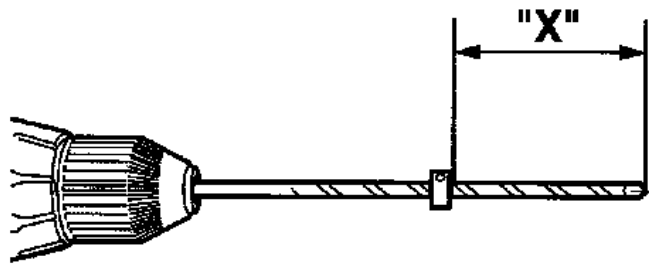
- Support the engine at the transmission and at the oil pan.
- Take the weight with the workshop crane.

Important: The guide sleeve (2) of the drilling template **KM-6213** (3) must be centred on the cast lug (1)

2. Apply the drilling template **KM-6213** (3) to the bearing housing at the cylinder block.
 - Install 3 bolts (4).



3. Adjust the drilling depth.
 - Make adjustments on the drill (1).
 - Use a clip.
 - Dimension "X" = **55 mm**
 - Bolt
4. Drill 2 holes.



L 6124

5. Take off drilling template **KM-6213**.
 - Remove 3 bolts.
6. Cut two M8 x 1.25 threads.
7. Clean the threads.