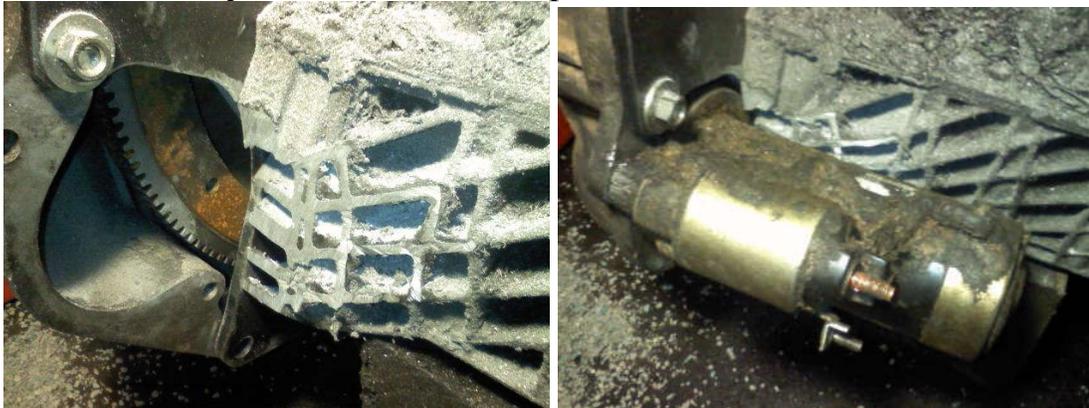


The following MB206 instructions are intended to assist in modifying a vehicle to accept an OM617 diesel engine to an AW4 transmission. Please read through the instructions before you begin. This procedure assumes the OM617 was previously removed from MB vehicle and is ready for installation. The Jeep transmission does not have to be removed from vehicle to complete this installation.

OM617 Engine Preparations.

1. Mark flywheel to crankshaft relationship (to maintain balance).
2. Remove flywheel from OM617 engine.
3. Remove the stock intermediate engine to transmission adapter plate from OM617.
4. Mount the MB114 bell housing adapter to back of the OM617 by lining up two existing dowel pins. Note: These holes have .002 tolerance they may need to be lightly filed with round file for final fit. This fit should be kept as tight as possible.
5. Install and hand tighten the 2- 23mm center Allen head bolts to hold MB114 adapter in place.
6. Grind OM617 oil pan to accept stock Jeep starter motor (see photos below).
NOTE: Grind to just meet MB114 adapter!



- 7.
8. When starter to block clearance is achieved remove the 2- 23mm center Allen head bolts but leave MB114 adapter on the engine.
9. Install 4- 23mm Allen head bolts and apply blue loctite to threads into 2-center and 2-upper block mounting holes and torque to 40 foot pounds.

Flexplate Assembly

1. Test fit the crankshaft adapter center pilot hole to torque converter. Make SURE they fit snug this is .002 clearance. It may require light sanding of torque converter flange.
2. When a Mercedes OM617 leaves the factory the flexplate is balanced to the engine. When replacing a MB flexplate the balance should be maintained as much as possible. The best solution is to take both old and new flexplate to a machine shop and have a 180 degree balancing done. The alternate solution if original balance was not retained is to static balance new assembly to zero (with crankshaft adapter mounted) we static balance our own engine swaps.
3. Mount the MB154 Crankshaft adapter to the OM617 crankshaft, using the 6-M10-1 x 20mm Allen head bolts supplied apply blue loctite and torque to 40ft pounds.
4. Mount flexplate to MB154 Crankshaft adapter with the original Jeep flexplate, re-enforcing ring and bolts, apply blue loctite to threads torque to 60ft pounds.

For more information, technical help, pictures, and accessories visit our website at www.MercedesDiesel4x4.com

You can also email us at sales@MercedesDiesel4x4.com or call 717-448-3800.