

Tightening torques	Nm
Self-locking hex. nuts on compensating pipe (model 107 only)	20–25
Self-locking hex. nuts on exhaust manifold to exhaust flange	20–25

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### Note

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Removal and installation of exhaust system is not fully explained, only a few particularly important items are described which must be observed during removal and installation or during partial renewal – e.g. of resonance damper with plug connection.

### Removal

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- 1 If plug connection is hard to separate, heat exhaust pipes. For safety reasons, mount a protective panel prior to heating pipes.
- 2 Check fastening members for re-use and replace, if required.

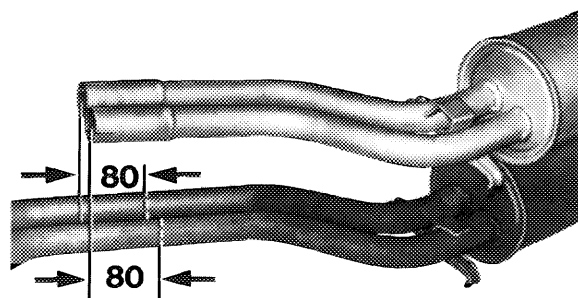
### Installation

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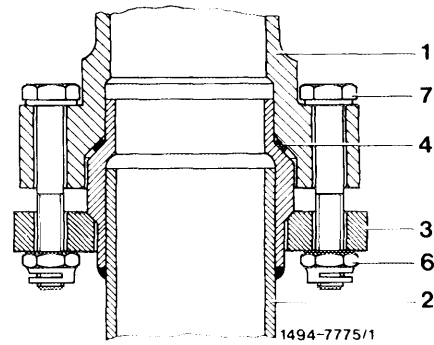
Replacement of resonance damper:

- 3 Place new resonance damper with plug connection accurately on removed installation (standard system) and mark pipe length of new resonance damper on removed unit.

Cut pipe 80 mm from mark minus 10 mm in direction of resonance damper to guarantee a plug-in depth of 70–80 mm.



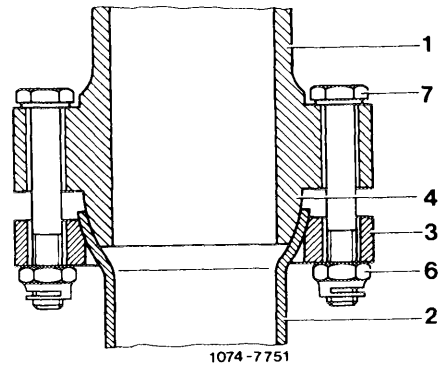
4 Always replace self-locking hex. nuts and sealing rings.



Exhaust pipe-manifold connection 1st version

- 1 Exhaust manifold
- 2 Exhaust pipe with cone
- 3 Flange
- 4 Sealing ring
- 6 Self-locking hex. nut
- 7 Hex. bolt

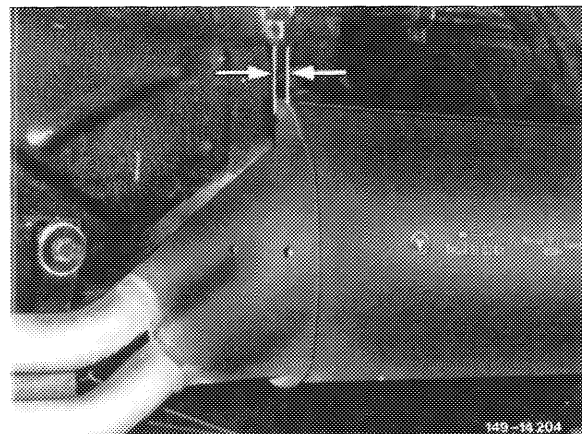
5 Tighten flange connection to exhaust manifold not before the complete system is mounted in rubber rings. Pay attention to correct seat of front exhaust pipe (2). Tightening torque of hex. bolts 20–25 Nm.



Exhaust pipe-manifold connection of 2nd version

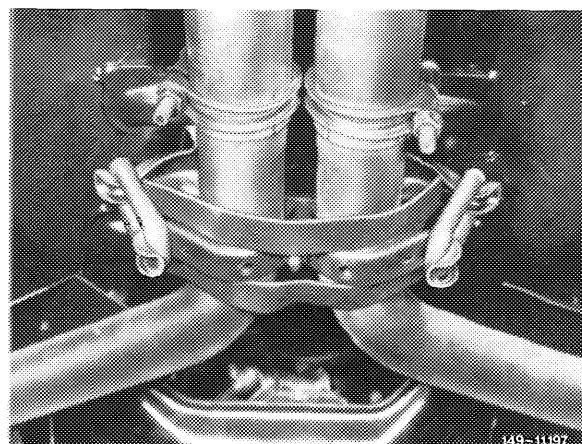
- 1 Exhaust manifold
- 2 Flared exhaust pipe
- 3 Flange
- 4 Ball connection
- 6 Self-locking hex. nut
- 7 Hex. bolt

6 Pay attention to distance between center resonance damper and frame floor (on model 116 distance approx. 20 mm, arrows).



**Note:** Rubber rings are available in two degrees of shore hardness. Hardness is recognized by compressing rings.

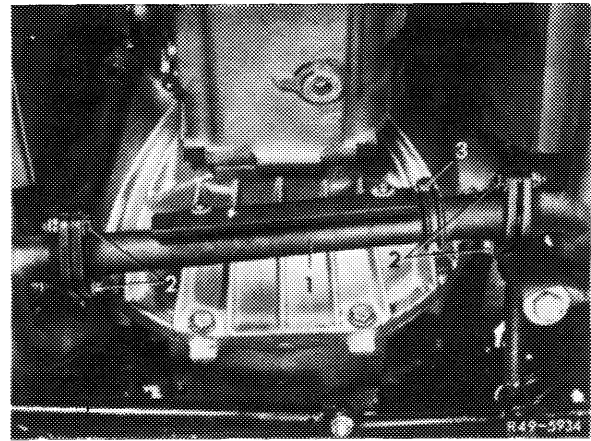
On model 116 use only the softer rubber rings at front exhaust mounting.



Model 116

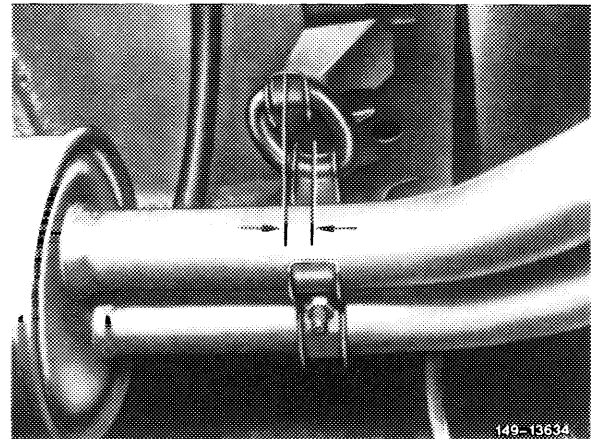
7 Tighten flange connection (2) on compensating pipe only when the complete exhaust system is mounted. Then tighten pipe clamp (3). Tightening torque of self-locking nuts 20–25 Nm (model 107 only).

Model 107



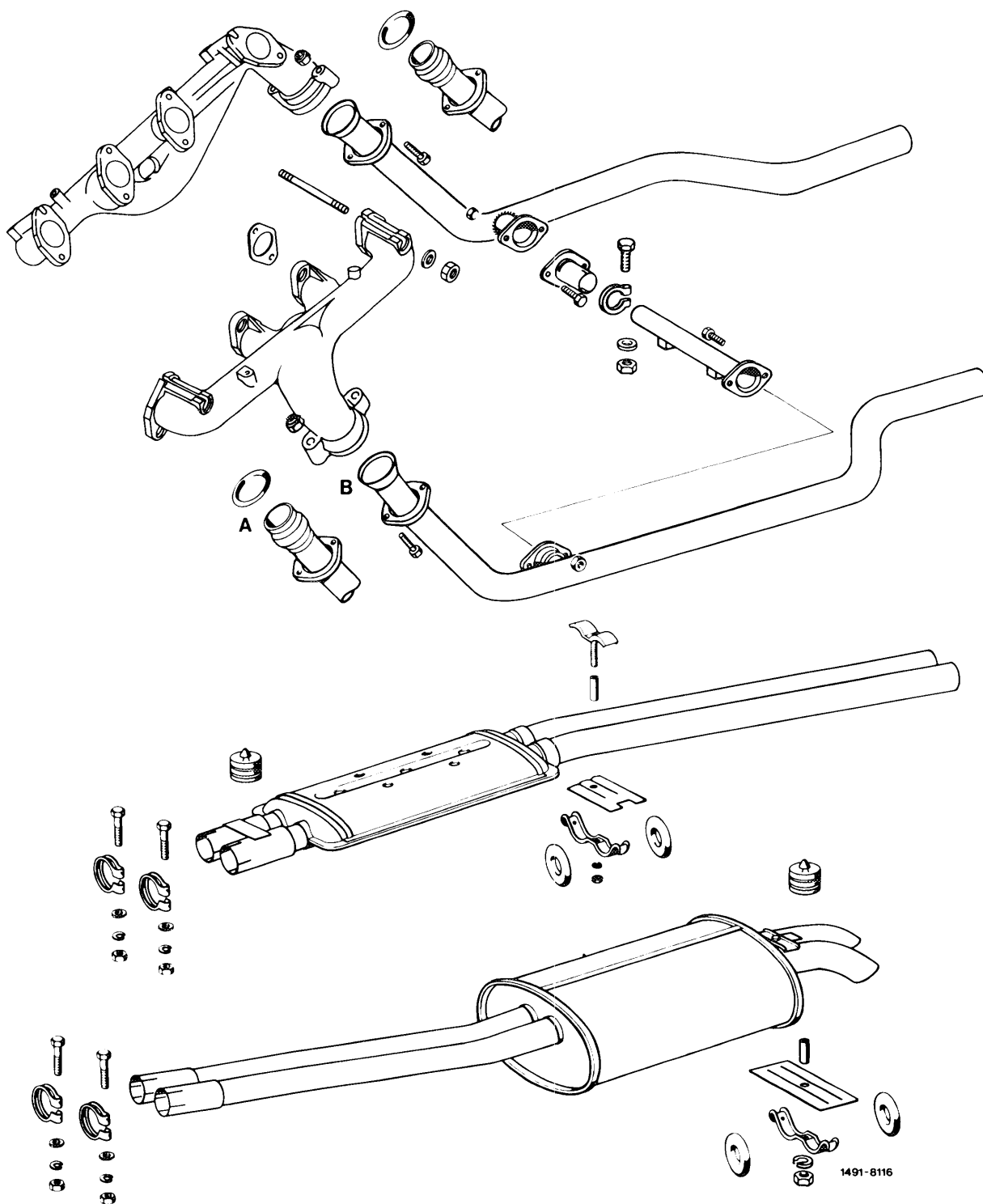
8 Mount resonance damper in such a manner that the holding clips of resonance damper are approx. 10 mm in front of holders on frame floor (arrow), so that in the event of elongation the exhaust system retains its correct installation position.

Model 116



9 Keep engine running and check exhaust system for leaks.

Exhaust manifold with complete exhaust system  
Model 107.023/024/043/044

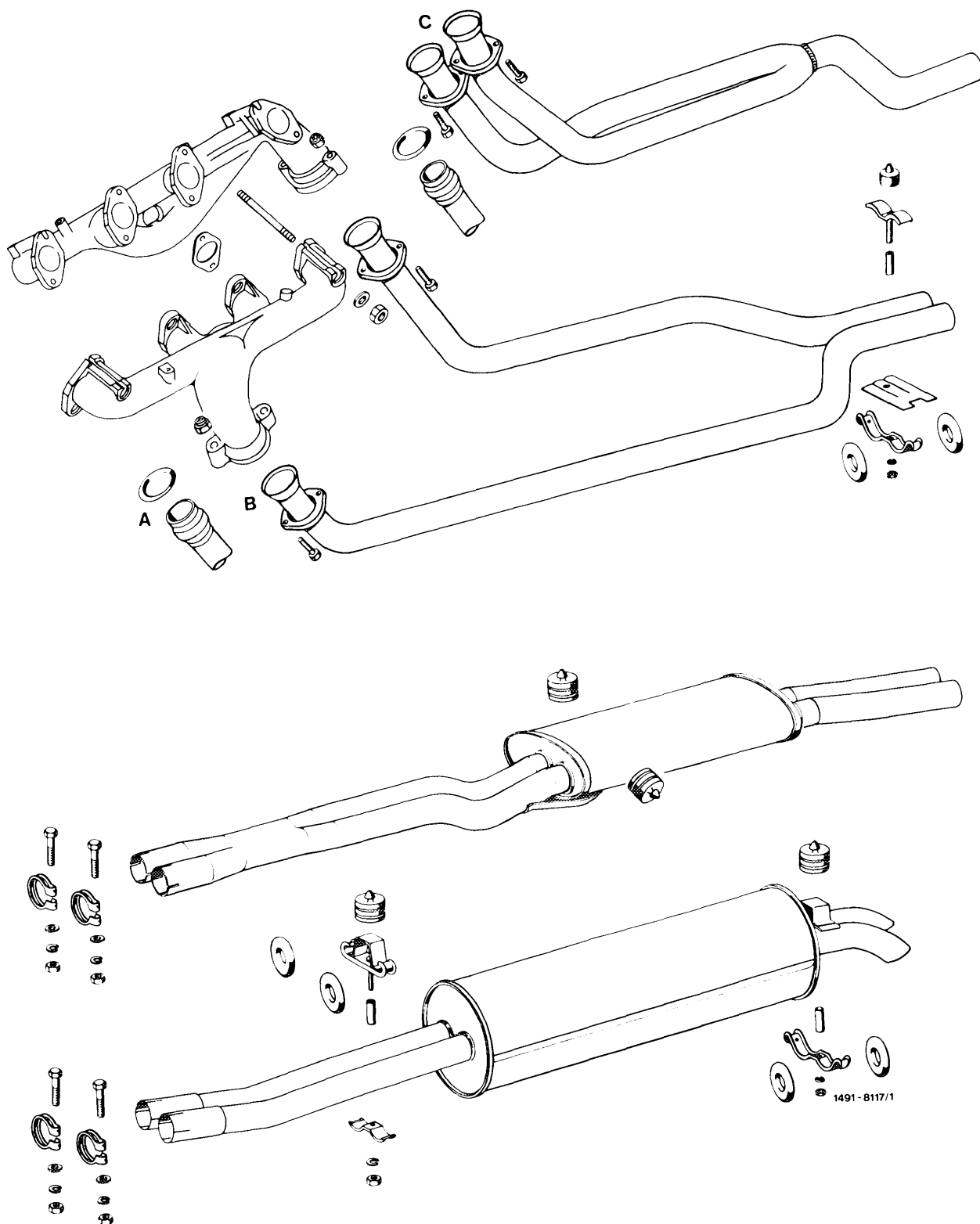


A Front exhaust pipe with trapezoid connection (on vehicles with electronic gasoline injection and CIS-injection system 1st version)

B Front exhaust pipe with flare for ball connection (on vehicles with CIS-injection system 2nd version)

1491-8116

Exhaust manifold with complete exhaust system  
Model 116.028/029/032/033



A Front exhaust pipe with trapezoid connection (on vehicles with electronic gasoline injection and CIS-injection system 1st version)

B Front exhaust pipe with flare for ball connection (on vehicles with CIS-injection system 2nd version)

C Front exhaust pipe – double flow starting January 1978