

Subject : Engine and Gearbox mountings assembly process.

Dear Customers,

We ask you to pay attention about the right assembly of your engine and gearbox mountings.

A bad assembly process will damaged rapidly engine / gearbox silent-blocks and throttle bodies by bodyshell vibrations.

The entierety of the process, from the distance between side members to the chronology of gearbox and engine mountings assembly are detailed in our technical notice sheet :

« D11 - ENGINE AND GEARBOX MOUNTINGS »

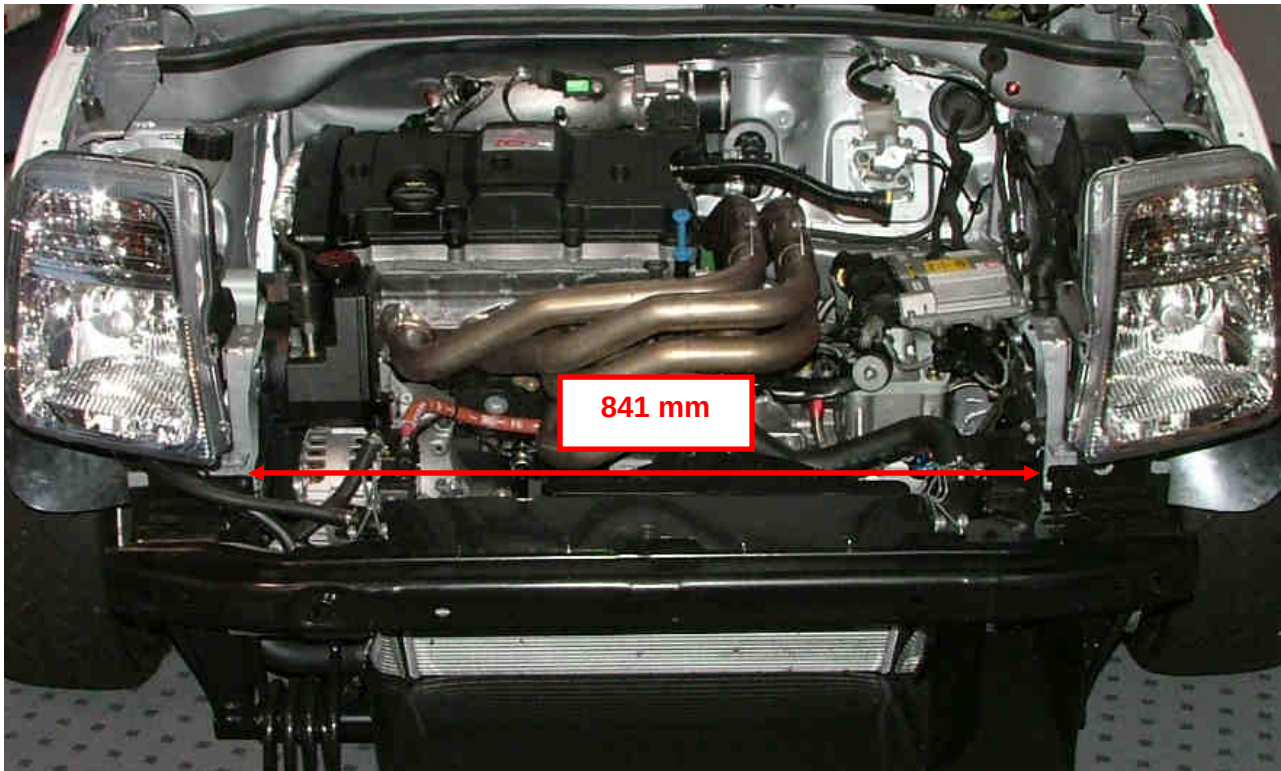
You can download it by the following link :

http://www.piecescitroensport.citroen.com/NR/rdonlyres/51C68D84-FA58-484F-B46F-C1EBAFE48859/167084/D11SUPPORTSMOTEURETBV_300409.pdf

To remind you, you can find below main operations of check and assembly.

I - FRONT SIDE MEMBERS GAP :

Before to assembly the mountings, it is essential to measure the length between side members , as describes below.



Detail :



If necessary, use a jack to get the right measurement.

II - ENGINE MOUNTING ASSEMBLY :

As detailed in the notice sheet, the engine mounting on body must be assembly without torquing, and the axial silent-block screw too.

III - GEARBOX MOUNTING ASSEMBLY :

As detailed in the notice sheet, the gearbox mounting on body must be assembly without torquing, and the axial silent-block screw too.

IV - ANTI-TORQUE LINK ASSEMBLY :

The link can be now assembly and torque to the subframe, and to the gearbox bracket (*torque value and Loctite to apply in the D11 notice sheet*).

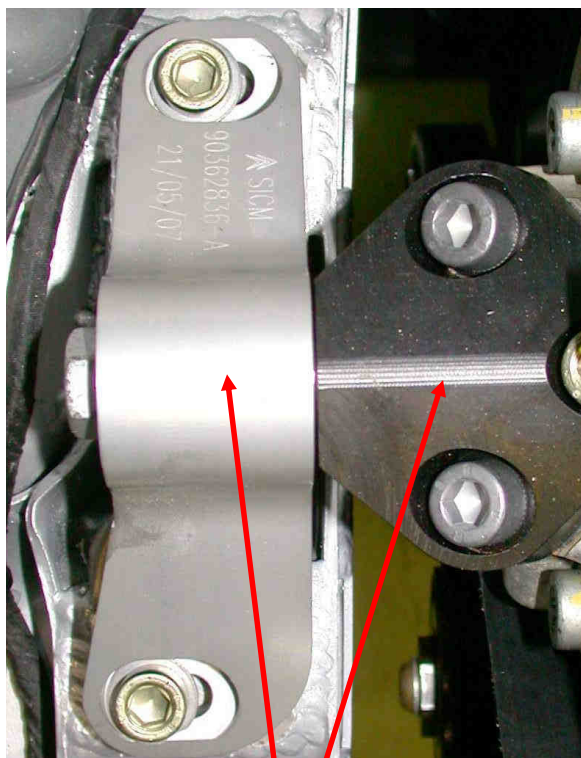
V - ENGINE CENTERING / ENGINE AND GEARBOX MOUNTINGS TORQUING :

Move the engine / gearbox, to be as possible centered in oblong holes of the engine and gearbox mountings.

Then, torque axial silent-blocks screws of the engine and gearbox mountings (*torque value and Loctite to apply in the D11 notice sheet*).

Unscrew, screw by screw, all screws of engine and gearbox mountings, to apply some Loctite and to torque it to the right value. (*torque value and Loctite to apply in the D11 notice sheet*).

Nota : After the right assembly of both mountings, you can see a small gap between the engine mounting on body and the engine mounting. A contact between both parts means a bad assembly, damaged silent-blocks or a wrong lenght between side members.



No physical contact between both parts

Thank you for your attention.