

2003-05 AUTOMATIC TRANSMISSION

Gear Assembly - E500 - 722.633

MODEL IDENTIFICATION

NOTE: For further information on 722.633 transmission, see GENERAL article.

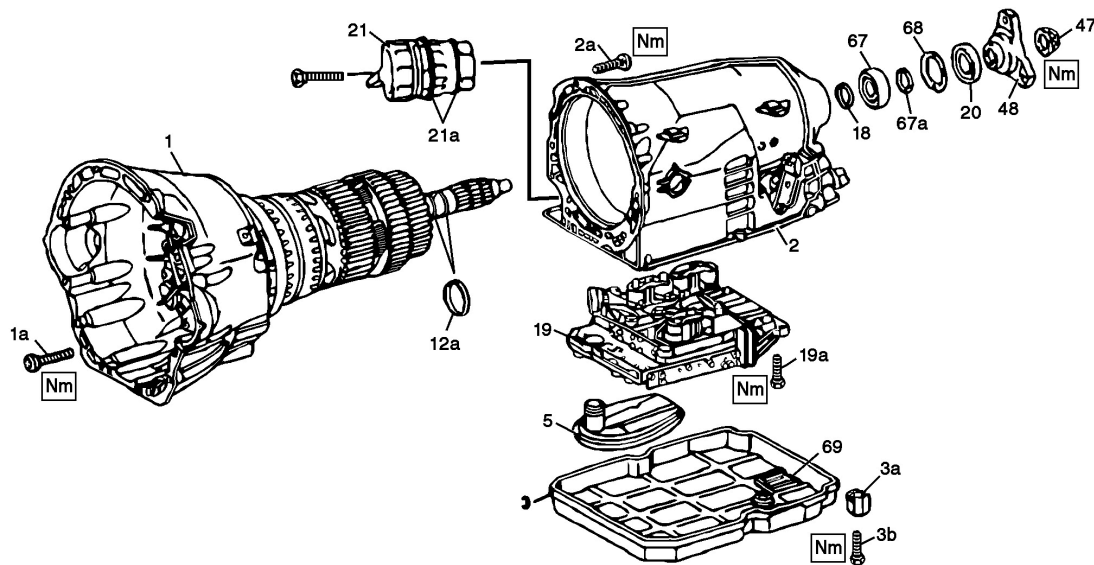
MODEL IDENTIFICATION

Model (Year)	Chassis	Engine	Transmission
E500 (2003-05)	211.070	113.967	722.633
E500 (2005) ⁽¹⁾	211.270	113.967	722.633

(1) Canada only.

GEAR ASSEMBLY

DETACH/ATTACH TRANSMISSION HOUSING ON TORQUE CONVERTER



- | | | |
|---|----------------------------------|----------------------------|
| 1 Torque converter housing | 5 Oil filter | 21a O-rings |
| 1a Internal Torx drive bolts (15 bolts) | 12a Teflon rings | 47 Twelve-point collar nut |
| 2 Transmission housing | 18 Shim | 48 Output flange |
| 2a Torx socket bolts | 19 Electrohydraulic control unit | 67 Grooved ball bearing |
| 3 Oil pan | 19a Torx socket bolts (10 ea.) | 67a Shim |
| 3a Sprag | 20 Radial seal ring | 68 Circlip |
| 3b Torx socket bolts | 21 Pilot bushing | 69 Magnet |

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Fig. 1: Detach/Attach Transmission Housing On Torque Converter Housing

Courtesy of MERCEDES-BENZ OF NORTH AMERICA.

Disassemble

- 1 - Fasten transmission on assembly stand. See **FASTEN TRANSMISSION TO ASSEMBLY STAND**.
- 2 - Loosen guide bush (2) and remove from transmission housing. See **Fig. 1**.
- 3 - Detach oil pan (3).
- 4 - Remove magnet from oil pan.
- 5 - Remove oil filter (5).
- 6 - Unscrew Torx socket bolts (19a) and remove electrohydraulic control unit (19).

NOTE: **According to condition: disassemble and assemble electrohydraulic control unit. See DISASSEMBLE & ASSEMBLE ELECTROHYDRAULIC CONTROL UNIT .**

- 7 - Detach output flange (48) with socket wrench bit (126 589 02 09 00).
- 8 - Press out radial seal ring (20).
- 9 - Remove shim (67a).

NOTE: **As of transmission no. 1658778.**

- 10 - Remove circlip (68).
- 11 - Remove deep-groove ball bearing (67) form transmission housing. See **REMOVE GROOVED BALL BEARING IN REAR OF TRANSMISSION HOUSING**. Use puller (001 589 50 33 00) and tensioning clamp (140 589 06 34 00).
- 12 - Remove shim (18).
- 13 - Unscrew Torx socket bolts (1a, 2a) from converter housing and transmission housing. Use a commercially available Torx inserter for Torx bolts.
- 14 - Remove transmission housing (2) from converter housing (1). Continue operations according to findings:

Remove/install multi-disc clutch K1, K2 and K3. See **REMOVING & INSTALLING MULTIPLE-DISC CLUTCHES K1, K2 & K3**.

Remove/install multi-disc brake B2, multiple-disk pack B3 and park pawl gear. See **REMOVING & INSTALLING MULTI-DISC BRAKE B2, DISC PACK B3 & PARK PAWL GEAR**.

Assemble

- 15 - Using grease, install both Teflon rings (12a) in the groove so that the joints stays together.
- 16 - Mount transmission housing (2) on converter housing (1).

CAUTION: Align discs of multiple-disc brakes B2 and B3.