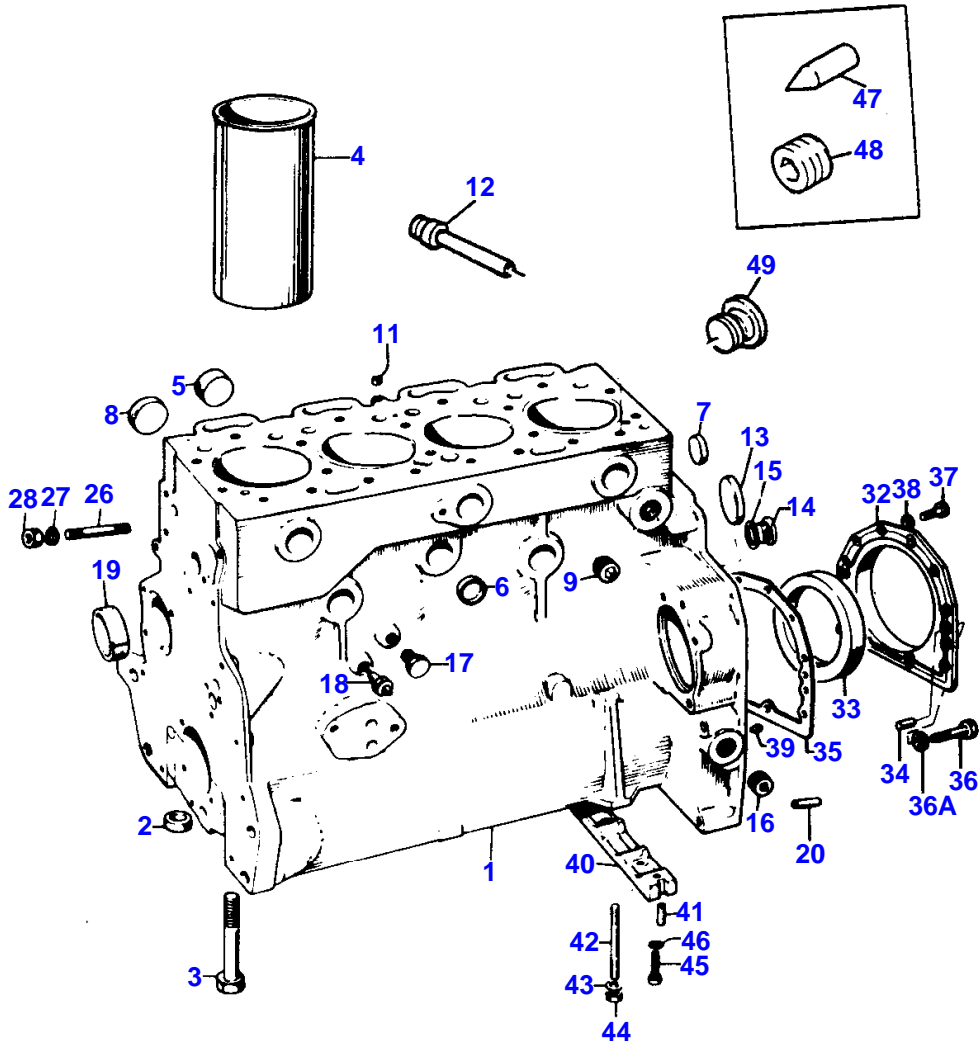


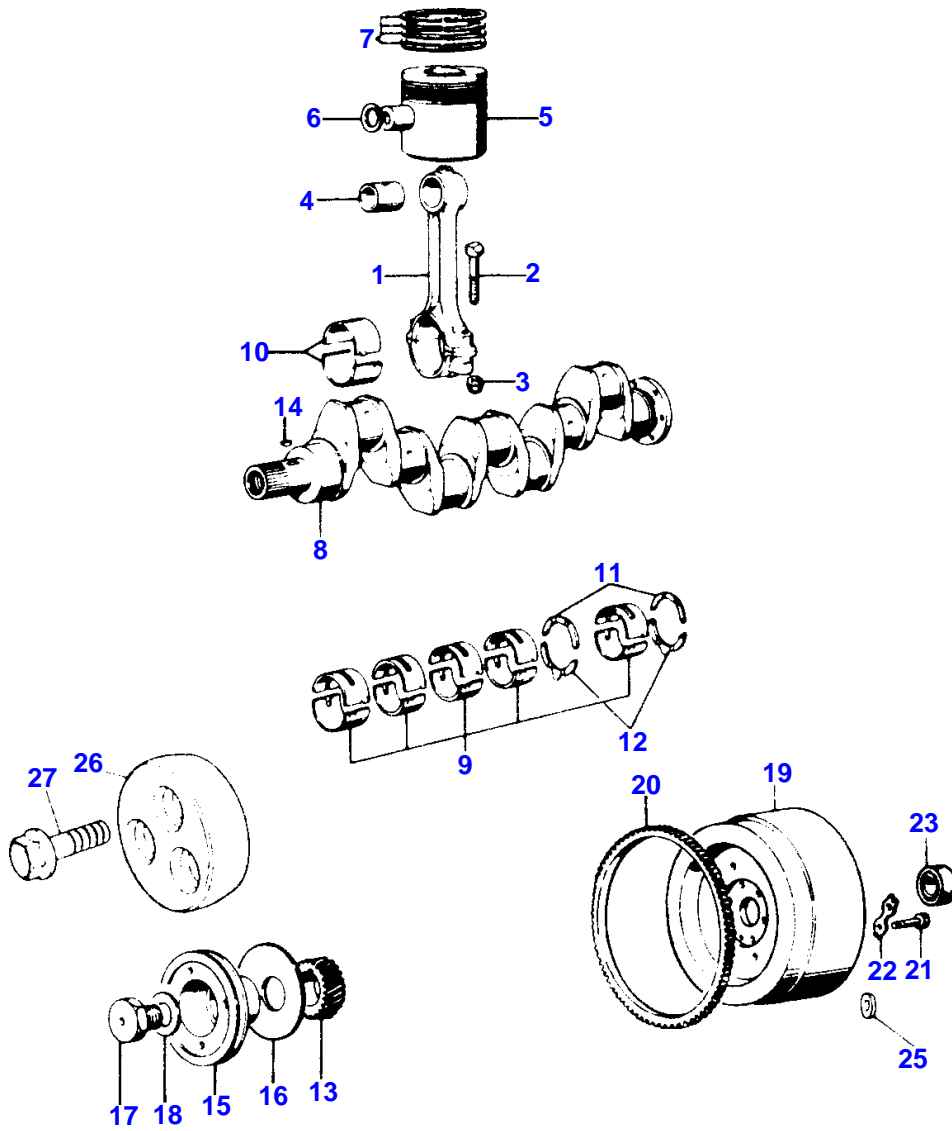
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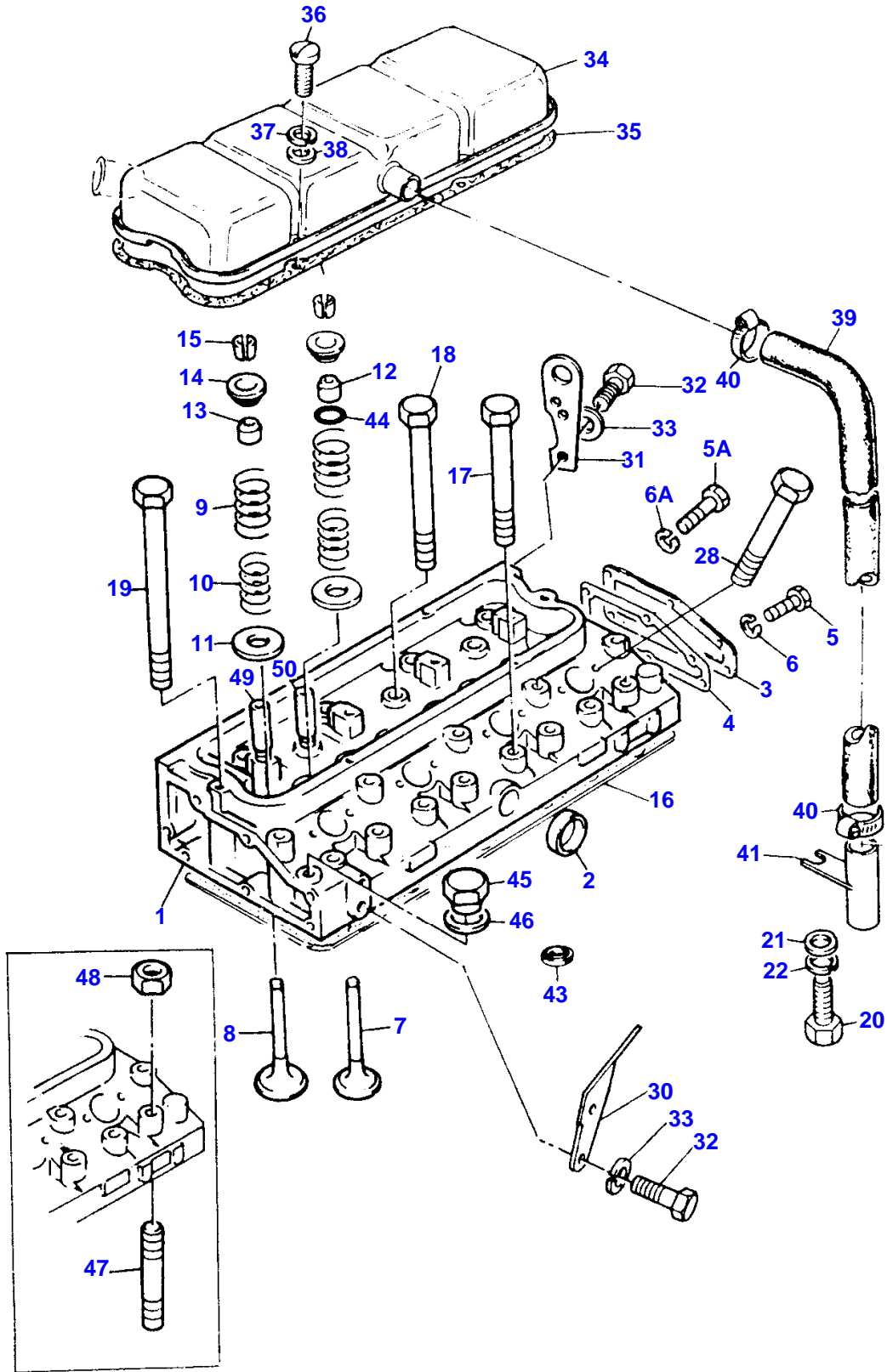
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Item	Part Number	Qty	Description	Comments
				A4.236
1	ZZ50031	1	Kit,Cyl.Block	Up to Serial or Engine Number
	ZZ50114	1	Kit,Cyl.Block	From Serial or Engine Number
2	33142111	10	Thimble	1
3	32166329	10	Bolt	1
4	31358394	X	Liner	(B) Up to Serial or Engine Number U08336N
4	3135X032	X	Liner	(B) From Serial or Engine Number U08337N
4	31358393	4	Liner	(A) 1 Up to Serial or Engine Number U08336N
4	3135X031	4	Liner	(A) 1 From Serial or Engine Number U08337N
5	0650618	4	Plug	1
6	0650563	6	Plug	1
7	0650563	2	Plug	1
8	0650577	4	Plug	
9	0650588	2	Plug	
11	32417134	1	Plug	
12	2485A204	1	Plug	1
13	32416105	1	Plug	
14	0650582	1	Plug	
15	0920130	1	Washer	
16	0650588	1	Plug	
17	2431131	1	Plug	Up to Serial or Engine Number
	0650594	1	Plug	From Serial or Engine Number
18	1423895M91	1	Switch	Up to Serial or Engine Number 12700636/22700784
	1877721M92	1	Pressure Switch	From Serial or Engine Number 12700637/22700785
19	31134132	1	Bush	
20	0350018	2	Dowel	
26	0826469	1	Stud	
27	0920054	1	Washer	
28	0576051	1	Nut	
32	4142V061	1	Kit, Housing	
33	2418F475	1	Seal	32
34	0350009	2	Dowel	
35	36817157	1	Joint	
36	2172530	2	Capscrew	
36A	33112111	2	Washer	
37	0746211	10	Bolt	
38	0920003	10	Washer	
39	32452113	1	Pointer	
40	36277833	1	Bridge Piece	
41	32811408	1	Joint	
42	2217150	2	Stud	
43	0920053	2	Washer	
44	0576002	2	Nut	
45	2176369	2	Screw	
46	0920521	2	Washer	
47	32452113	1	Pointer	
48	0650588	1	Plug	
49	32161114	3	Plug	Repairs and replaces 31261357 (A) PRESS FITTING (B) SLIP FIT



Item	Part Number	Qty	Description	Comments
				A4.236
1	ZZ90009	4	Kit, Conrod	Repairs and replaces M78J0015
2	32762116	8	Bolt	1
3	33221328	8	Nut	1
4	31134123	4	Bush	1
5	68301	4	Kit, Piston	(D)
	68300	X	Kit, Piston	(A)
	68301C	X	Kit, Piston	(D)
				Thickness +0,762 MM
5	68300C	X	Kit, Piston	(A)
				Thickness +0,762 MM
6	0170002	8	Circlip	5
7	41158041	4	Kit, Piston Ring	
	41158041C	X	Kit, Piston Ring	(D)
				Thickness +0,762 MM
8	U5BG0024	1	Kit, Crankshaft	
9	81558	1	Kit, Bearing	(C)
				8
9	81558A	X	Kit, Bearing	(C)
				Thickness -0,254 MM
9	81558B		Kit, Bearing	(C)
				Thickness -0,508 MM
9	81558C	X	Kit, Bearing	(C)
				Thickness -0,762 MM
10	85042	1	Kit, Bearing	(C)
				8
10	85042A	X	Kit, Bearing	(C)
				Thickness -0,254 MM
10	85042B	X	Kit, Bearing	(C)
				Thickness -0,508 MM
10	85042C	X	Kit, Bearing	(C)
				Thickness -0,762 MM
11	31137551	2	Thrust Washer	8
	31137312	X	Thrust Washer	Thickness +0,178 MM
12	31137561	2	Thrust Washer	8
	31137322	X	Thrust Washer	Thickness +0,178 MM
13	31171681	1	Gear	Number of teeth/spines 28
14	0500012	1	Woodruff Key	
15	31148792	1	Pulley	
16	33125416	1	Washer	
17	32162331	1	Screw	(B)
18	33125124	1	Washer	(B)
19	1825511M1	1	Flywheel	
20	0410236	1	Starter Ring	
21	973013M1	6	Bolt	
22	0921062	3	Tab Washer	
23	339599X1	1	Bearing Ball	
25	33117121	6	Washer	
26	3271R021	1	Spacer	(E)
27	32186139	3	Screw	(E)
				(A)
				UNTOPPED
				(B)
				USED ONLY WITH CRANKSHAFTS 68609/94434/U5BG0008/U5BG0009/U5BG0019.
				(C)
				PRE-FINISHED
				(D)
				PRE-TOPPED
				(E)
				USED ONLY WITH CRANKSHAFT U5BG0022/U5BG0023/U5BG0024/U5BG0025/U5BG0026

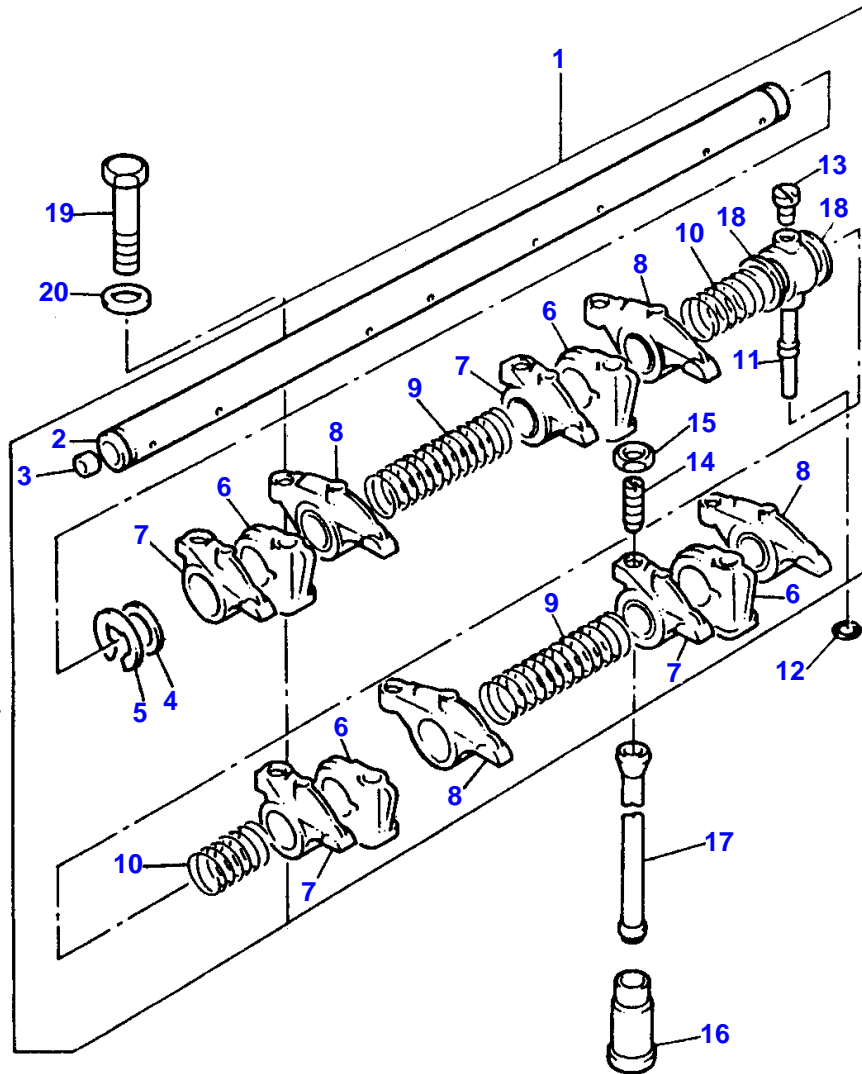


CYLINDER HEAD AND COVER - A4.236

Item	Part Number	Qty	Description	Comments
				A4.236
1	ZZ80015	1	Kit, Cyl. Head	Repairs and replaces A5BD2631
2	0650563	1	Plug	1
3	3621F005	1	Plate	(B) 1
3	3623K007	1	Plate	(C) 1
4	36851409	1	Joint	(B) 1
4	3685R004	1	Joint	(C) 1
5	0746254	6	Setscrew	(B) 1
5	0746254	1	Setscrew	(C) 1
5A	0746452	2	Setscrew	(C) 1
6	0920053	6	Washer	(B) 1
6	0920053	4	Washer	(C) 1
6A	0920054	2	Washer	(C) 1
7	31431641	4	Valve Inlet	1
	31431401	X	Valve Inlet	(D) Thickness +0,076 MM
7	31431402	X	Valve Inlet	(D) Thickness +0,38 MM
7	31431403	X	Valve Inlet	(D) Thickness +0,76 MM
8	31431881	4	Valve Exhaust	1
	31431882	X	Valve Exhaust	(D) Thickness +0,076 MM
8	31431883	X	Valve Exhaust	(D) Thickness +0,38 MM
8	31431884	X	Valve Exhaust	(D) Thickness +0,76 MM
9	31745121	8	Spring	1
10	31744131	8	Spring	1
11	33415118	8	Washer	1
12	33817117	4	Seal	1
13	33817117	4	Seal	1
14	33423147	9	Cap	1
15	33173108	8	Cotter	(A) 1
16	36812349	1	Head Gasket	Up to Serial or Engine Number U08336N
	36812352	1	Head Gasket	From Serial or Engine Number U08337N
17	32181424	8	Screw	
18	32181425	12	Screw	
19	32181426	2	Screw	
20	0096215	1	Screw	
21	0920003	1	Washer	
22	0920053	1	Washer	
28	0096232	8	Bolt	
30	3648C004	1	Plate	Repairs and replaces 36475706
31	36177111	1	Plate	
32	0746453	4	Setscrew	
33	0920054	4	Washer	
34	37188549	1	Cyl.Head Cover	
35	36811132	1	Joint	
36	2172513	4	Screw	
37	0920052	4	Washer	
38	0920002	4	Washer	
39	33872516	1	Pipe	
40	0180063	2	Clip	
41	35731144	1	Union	
43	33152139	X	Insert	
44	2415B201	8	O Ring	1
45	0650203	1	Plug	1

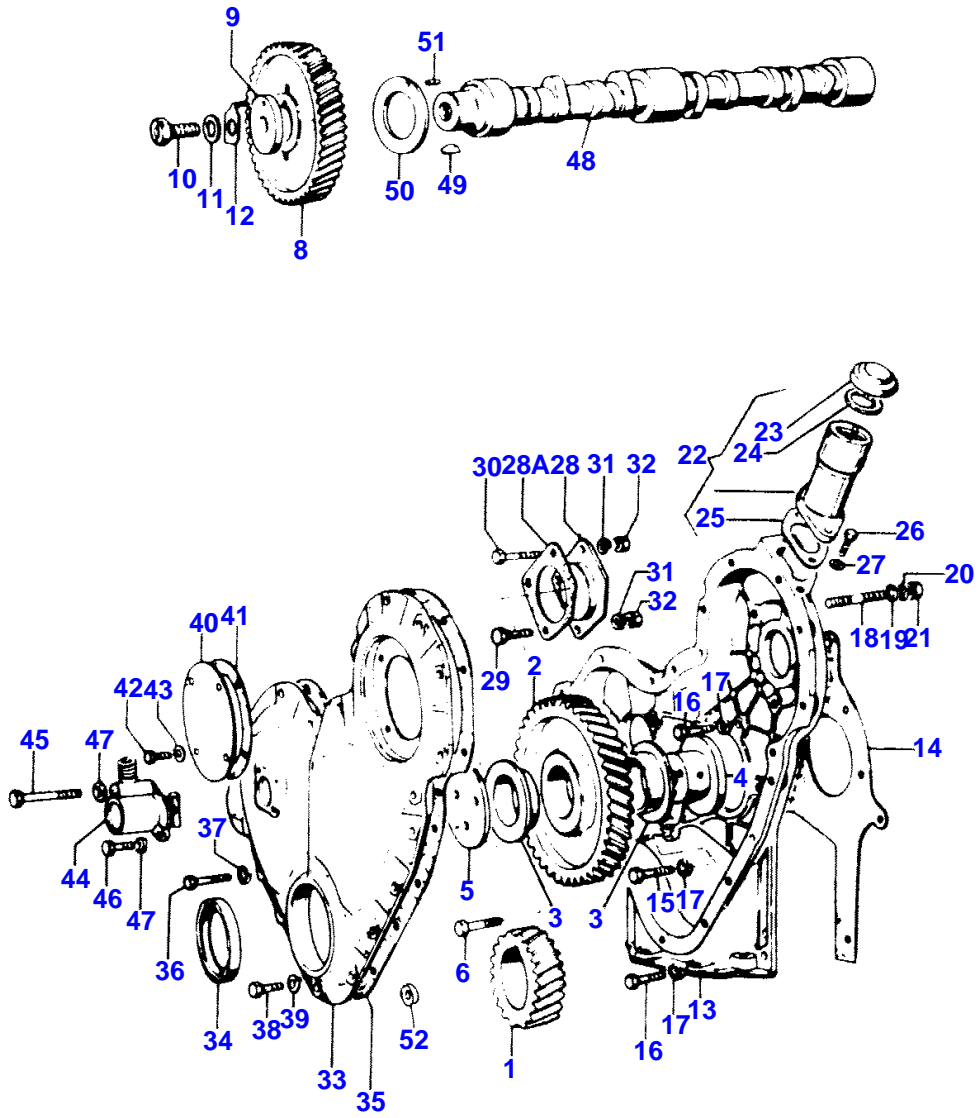
CYLINDER HEAD AND COVER - A4.236

Item	Part Number	Qty	Description	Comments
46	2411157	1	Washer	1
47	32526312	2	Stud	Up to Serial or Engine Number U874811J
48	33221316	2	Nut	Up to Serial or Engine Number U874811J
49	3343F002	4	Guide	(E) 1
50	3343J002	4	Guide	(E) 1 (A) SERVICED IN PAIR (B) USED ON CYLINDER HEADS WITH FIXING HOLES 6 OFF 5/16" (C) USED ON CYLINDER HEADS WITH FIXING HOLES 2 OFF 3/8 " AND 4 OFF 5/16". (D) OVERSIZE VALVES CAN ONLY BE USED WITH CYLINDER HEADS WHEN VALVE GUIDES ARE NOT FITTED. (E) USED ONLY WITH HEADS MACHINED TO ACCOMMODATE VALVE GUIDES



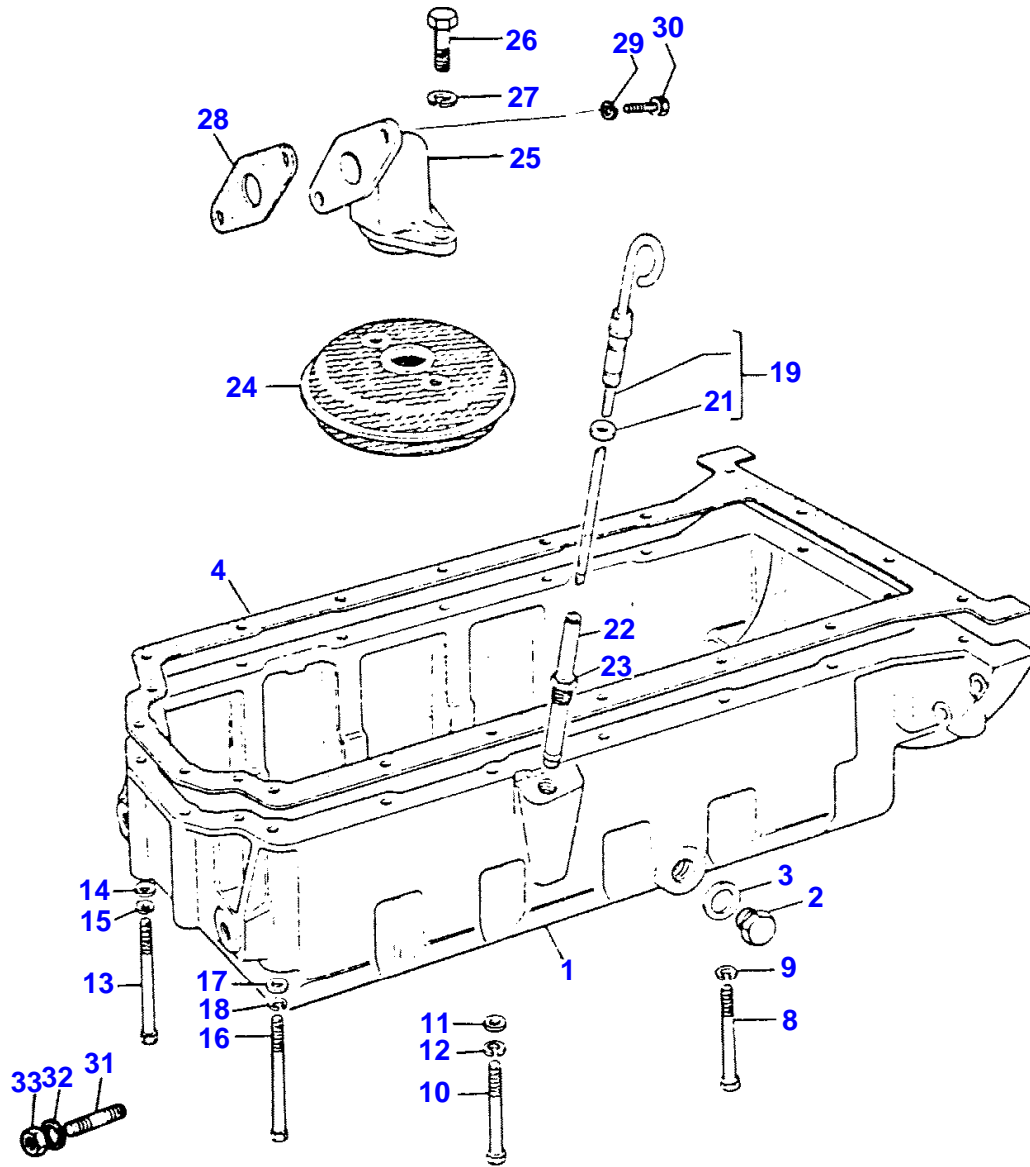
ROCKER ARM - A4.236

Item	Part Number	Qty	Description	Comments
				A4.236
1	ZZ90030	1	Rocker Shaft Ass	
2	ZZ90032	1	Rocker Shaft	1
3	0650507	2	Plug	2
4	33117434	2	Washer	1
5	0170151	2	Circlip	1
6	37521332	4	Bracket	1
7	37371271	4	Lever	Left Hand 1
8	37371281	4	Lever	Right Hand 1
9	31744123	1	Spring	1
10	31743108	2	Spring	1
11	3775E011	1	Connection	1
12	33811113	1	Olive	
13	2231236	1	Setscrew	1
14	0720579	8	Screw	1
15	0576052	8	Nut	1
16	31434163	8	Tappet	
17	31434307	8	Pushrod	
18	33117426	2	Shim	1
19	0096634	4	Screw	
20	0920006	4	Washer	



TIMING GEAR - A4.236

Item	Part Number	Qty	Description	Comments
				A4.236
1	31171681	1	Gear	Number of teeth/spines 28
2	41115023	1	Idler	Number of teeth/spines 63
3	0050345	2	Bush	2
4	33426161	1	Hub	
5	0941082	1	Plate	
6	0096439	3	Bolt	Up to Serial or Engine Number U08336N
	2184634	3	Screw	From Serial or Engine Number U08337N
8	31171353	1	Gear,Camshaft	Up to Serial or Engine Number U08336N Number of teeth/spines 56
8	3117L011	1	Gear,Camshaft	From Serial or Engine Number U08337N Number of teeth/spines 56
9	33153128	1	Washer	
10	32161209	1	Screw	
11	33115408	1	Washer	
12	31733121	1	Washer	
13	37161642	1	Housing	
14	36814127	1	Joint	Up to Serial or Engine Number U08336N
	36814137	1	Joint	From Serial or Engine Number U08337N
15	0746211	1	Bolt	
16	2183205	8	Screw	
17	0920053	9	Washer	
18	2217138	3	Stud	Repairs and replaces 0826277
19	0920003	3	Washer	
20	0920053	3	Washer	
21	0576002	3	Nut	
22	35784119	1	Filler	
23	2487854	1	Cap	22
24	24870001	1	Joint	23
25	36862138	1	Joint	
26	0746254	2	Setscrew	
27	2411152	2	Washer	
28	37556148	1	Plate	
28A	36861429	1	Joint	
29	0748505	1	Screw	
30	2232151	2	Screw	
31	0920054	3	Washer	
32	2238153	3	Nut	
33	37166401	1	Cover	Repairs and replaces 41422703
34	2418F436	1	Seal	33
35	36813137	1	Joint	
36	0746255	14	Setscrew	Up to Serial or Engine Number
	2183205	10	Screw	From Serial or Engine Number
37	0920053	14	Washer	Up to Serial or Engine Number
	0920053	10	Washer	From Serial or Engine Number
38	0096238	4	Bolt	
39	2411152	4	Washer	
40	3241H004	1	Plate	
41	33825419	1	Joint	
42	0746252	4	Screw	Up to Serial or Engine Number
	2183203	4	Screw	From Serial or Engine Number
43	2411152	4	Washer	Up to Serial or Engine Number
	0920053	4	Washer	From Serial or Engine Number
44	2758346	1	Angle Drive	
45	0746019	1	Screw	
46	0746053	1	Bolt	
47	2411151	2	Washer	
48	31415321	1	Camshaft	Up to Serial or Engine Number U08336N
	31415371	1	Camshaft	From Serial or Engine Number U08337N
49	0500012	1	Woodruff Key	
50	33153121	1	Washer	
51	2116053	1	Pin	



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