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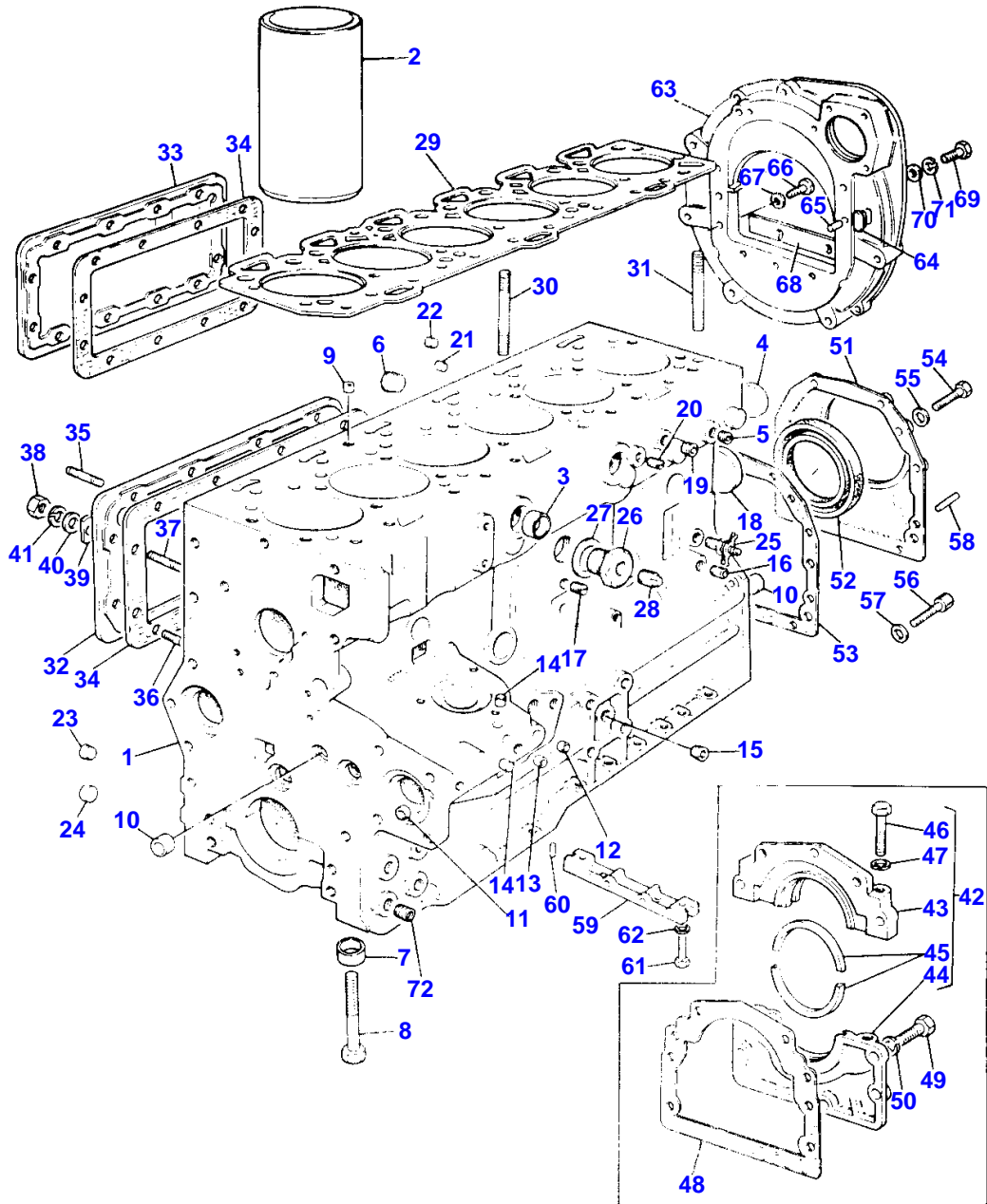
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2

CYLINDER BLOCK
 BLOC CYLINDRE
 ZYLINDERBLOCK
 BLOCCO CILINDRI
 BLOQUE DE CILINDROS

00503004

3-0050-004-A



CYLINDER BLOCK - A6.354

Item	Part Number	Qty	Description	Comments
				A6.354
1	68441	1	Cylinder Block	Up to Serial or Engine Number 354UA48969
	61953	1	Block	(A) From Serial or Engine Number 354UA48970L
2	31358324	6	Liner	(1)
3	0650563	7	Plug	(1) (B)
4	0650712	1	Plug	(1)
5	0650593	1	Plug	(1)
6	0650588	3	Plug	(1)
7	33142111	14	Thimble	(1)
8	32166329	14	Bolt	(1)
9	32417134	1	Plug	
10	0650566	2	Plug	
11	32417115	1	Plug	
12	32417127	2	Plug	
13	32417143	1	Plug	Repairs and replaces 32417127
14	32417134	2	Plug	
15	0650586	1	Plug	
16	2431131	1	Plug	
17	32114116	2	Plug	
18	32416105	1	Plug	
19	0650586	1	Plug	
20	32114116	1	Plug	
21	32417133	1	Plug	
22	2431132	1	Plug	
23	0650586	1	Plug	
24	32417117	1	Plug	
25	31419	1	Cock	
26	33534117	1	Adaptor	(C)
27	2411170	1	Washer	(C)
28	0650588	1	Plug	(C)
29	36812544	1	Gasket	
30	32526311	20	Stud	Up to Serial or Engine Number 354UA32497
31	32526312	12	Stud	Up to Serial or Engine Number 354UA32497
	32526312	2	Stud	From Serial or Engine Number 354UA32498
32	37554114	1	Inspection Cover	
33	37554118	1	Inspection Cover	
34	36846408	2	Joint	
35	0826241	1	Stud	
36	0826220	21	Stud	
37	0826211	2	Stud	
38	0576002	24	Nut	
39	36151505	24	Washer	
40	0920003	2	Washer	
41	0920053	24	Washer	
42	59537	1	Kit, Housing	Up to Serial or Engine Number 354UA48969
43		1	Housing	(42) Not serviced, order 59537
44		1	Housing	(42) Not serviced, order 59537
45	36883108	2	Seal	(42)
46	0096233	2	Bolt	(42)
47	0920053	2	Washer	(42)
48	36817136	1	Joint	Up to Serial or Engine Number 354UA48969
49	0746211	11	Bolt	Up to Serial or Engine Number 354UA48969
50	0920053	11	Washer	Up to Serial or Engine Number 354UA48969
51	37513851	1	Housing	From Serial or Engine Number 354UA48970L
52	2415391	1	Seal	From Serial or Engine Number 354UA48970L
53	36817157	1	Joint	From Serial or Engine Number 354UA48970L
54	0746211	10	Bolt	From Serial or Engine Number 354UA48970L
55	0920003	10	Washer	From Serial or Engine Number 354UA48970L
56	2172530	2	Capscrew	From Serial or Engine Number 354UA48970L
57	33112111	2	Washer	From Serial or Engine Number 354UA48970L
58	0350009	2	Dowel	From Serial or Engine Number 354UA48970L
59	36277831	2	Bridge Piece	
60	32811408	4	Joint	
61	2176369	4	Screw	
62	0920521	4	Washer	

CYLINDER BLOCK - A6.354

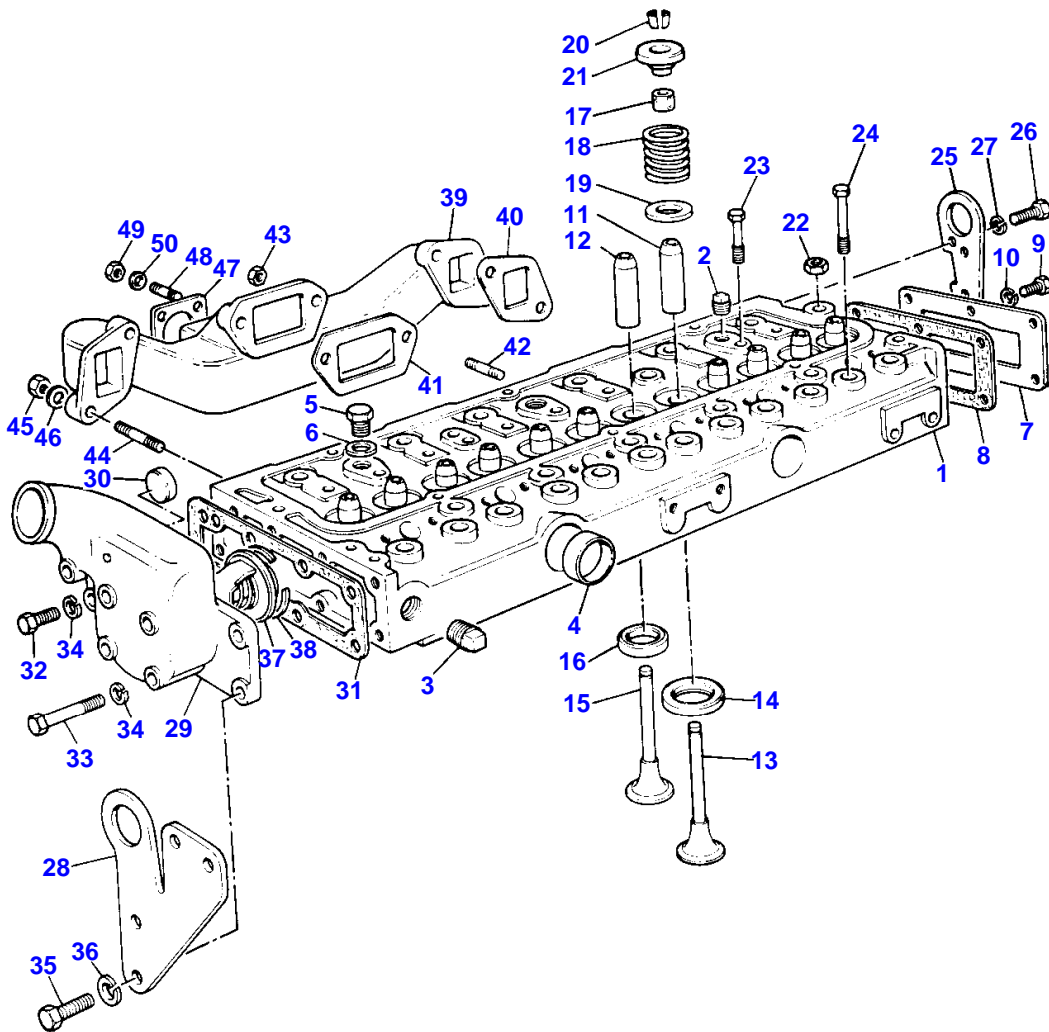
Item	Part Number	Qty	Description	Comments
63	37147644	1	Plate	Repairs and replaces 37147642
64	37813113	1	Plug	
65	32455119	2	Dowel	
66	2185051	6	Screw	
67	0920004	6	Washer	
68	36125305	1	Cover	
69	0746253	3	Screw	
70	0920003	3	Washer	
71	0920053	3	Washer	
72	2138625	8	Adaptor	(D) (A) WAS 94952-USE 61953-2138625-8 OFF (B) 6 OFF USED WITH 68441 OR 94952 (C) USED ONLY WITH 68441 OR 94952 (D) USED ONLY WITH 61953

6

CYLINDER HEAD
 CULASSE
 ZYLINDERKOPF
 TESTATA
 CULATA

00753004

3-0075-004-A



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520 525

810611-H (1)

CYLINDER HEAD - A6.354

Item	Part Number	Qty	Description	Comments
				A6.354
1	94414	1	Cylinder Head	Repairs and replaces 68137
2	2431154	3	Plug	
3	2431154	1	Plug	(1)
4	0650563	2	Plug	(1)
5	0650203	1	Plug	(1)
				(A)
6	2411157	1	Washer	(1)
				(A)
7	0940737	1	Plate	(1)
8	0490485	1	Joint	(1)
9	0746254	6	Setscrew	(1)
10	0920053	6	Washer	(1)
11	33261732	6	Guide	(1)
12	33261752	6	Guide	(1)
13	31431315	6	Valve Inlet	(1)
				Repairs and replaces 31431641
14	33125121	6	Insert	
15	31431851	6	Valve Exhaust	(1)
				Repairs and replaces 31431881
16	33152139	6	Insert	
17	33817125	6	Seal	(1)
	33817117	6	Seal	(1)
18	0780272	12	Spring	(1)
19	33123117	12	Washer	(1)
20	33173108	12	Cotter	(1)
				(B)
21	33423122	12	Cap	(1)
22	33221316	2	Nut	(C)
23	32181424	10	Screw	From Serial or Engine Number 354UA32498
24	32181425	20	Screw	From Serial or Engine Number 354UA32498
25	36177111	1	Plate	
26	0746453	2	Setscrew	
27	0920054	2	Washer	
28	36255519	1	Bracket	
29	41313001	1	Body	Repairs and replaces 37765611
30	0650664	1	Plug	(29)
31	36846113	1	Joint	
32	0746211	1	Bolt	
33	0096239	5	Bolt	
34	0920054	6	Washer	
35	0096433	2	Bolt	
36	0920054	2	Washer	
37	2485662	1	Thermostat	
38	31736112	1	Circlip	
39	37782276	1	Exhaust Manifold	
40	36862124	2	Joint	
41	36862129	1	Joint	
42	0826450	2	Stud	
43	2188135	2	Nut	
44	0826251	4	Stud	
45	2188135	4	Nut	
46	0920469	4	Spacer	
47	36823117	1	Joint	
48	0827818	4	Stud	
49	0576065	4	Nut	
50	0920004	4	Washer	

(A)
NOT FITTED ON THIS APPLICATION

(B)
SERVICED IN PAIRS

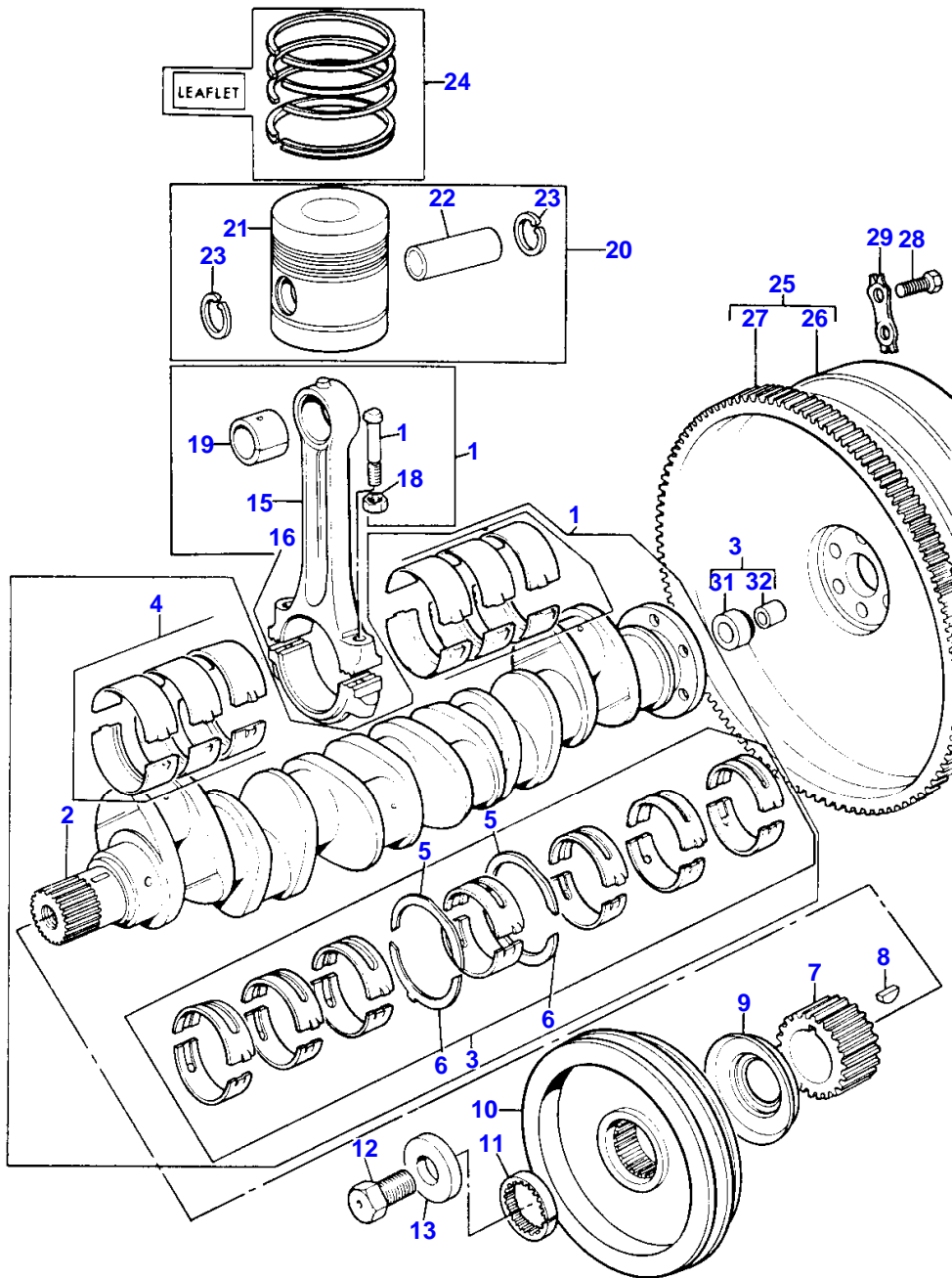
(C)
32 OFF FITTED UP TO ENGINE NO 354UA32497

10

CRANKSHAFT
 VILEBREQUIN
 KURBELWELLE
 ALBERO A MANOVELLA
 CIGUENAL

00803003

3-0080-003-A



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520 525

819611-H (1)

CRANKSHAFT - A6.354

Item	Part Number	Qty	Description	Comments
				A6.354
1	86794	1	Shaft	
	94468	1	Kit, Crankshaft	From Serial or Engine Number 2354UA48970L
2		1	Crankshaft	(1) Not serviced, order 86794/94468
3	85010	1	Kit, Bearing	(1) (A)
3	85010A	X	Kit, Bearing	(A) Thickness -.010"/.25M
3	85010B	X	Kit, Bearing	(A) Thickness -.020"/.51M
3	85010C	X	Kit, Bearing	(A) Thickness -.030"/.76M
4	85043	1	Kit, Bearing	(1) (A)
4	85043A	X	Kit, Bearing	(A) Thickness -.010"/.25M
4	85043B	X	Kit, Bearing	(A) Thickness -.020"/.51M
4	85043C	X	Kit, Bearing	(A) Thickness -.030"/.76M
5	31137311	2	Washer	(1)
	31137312	X	Thrust Washer	Thickness +.007"/.18M
6	31137321	2	Washer	(1)
	31137322	X	Thrust Washer	Thickness +.007"/.18M
7	31171211	1	Gear,Crankshaft	
8	0500012	1	Woodruff Key	
9	33415311	1	Flange	
10	31155272	1	Pulley,Crank	
11	33171116	1	Ring	
12	32162319	1	Screw	
13	33125124	1	Washer	
14	84920	6	Conrod	
15		1	Rod	(14) Not serviced, order 84920
16		1	Cap	(14) Not serviced, order 84920
17	32762116	2	Bolt	(14)
18	33221321	2	Nut	(14)
19	31134123	1	Bush	(14)
20	86740	6	Kit, Piston	(C)
	86740C	X	Kit, Piston	(C) Thickness +.030"/.76M
20	68314	6	Kit, Piston	(D)
	68314C	X	Kit, Piston	(D) Thickness +.030"/.76M
21		1	Piston	(20) (B)
22		1	Pin	(20) (B)
23	0170002	2	Circlip	(20)
24	86776	X	Kit, Ring	
	86776C	X	Kit, Ring	Thickness +.030"/.76M
25	41112713	1	Flywheel	Up to Serial or Engine Number 354UA48969
	41117087	1	Flywheel	From Serial or Engine Number 354UA48970L
26		1	Flywheel	(25) Not serviced, order 41112713/ 41117087
27	0410264	1	Gear,Starterring	(25)
28	32162203	6	Screw	
29	0921062	3	Tab Washer	
30	41425708	1	Adaptor	
31		1	Adaptor	(30) Not serviced, order 41425708
32	2513246	1	Bush	(30) (A) PRE-FINISHED

CRANKSHAFT - A6.354

10

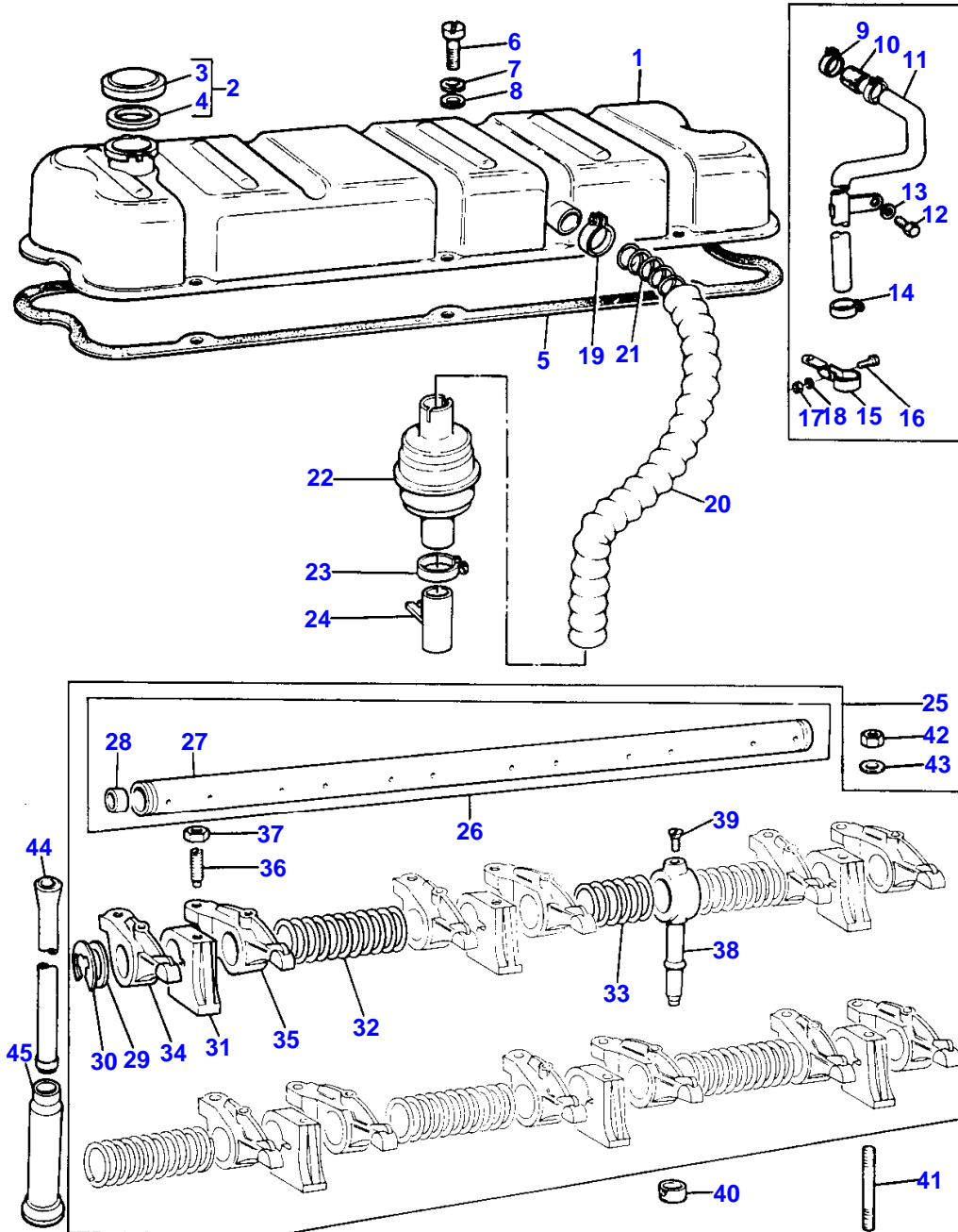
Item	Part Number	Qty	Description	Comments
				(B) ORDER APPROPRIATE ASSEMBLY
				(C) PRE-TOPPED
				(D) UNTOPPED

14

CYLINDER HEAD COVER
 CACHE CULBUTEUR
 ZYLINDERKOPFDECKEL
 COPERCHIO TESTATA
 TAPA CULATA

00853003

3-0085-003-A



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520 525

819611-H (1)

CYLINDER HEAD COVER - A6.354

Item	Part Number	Qty	Description	Comments
				A6.354
1	37188127	1	Cyl.Head Cover	Up to Serial or Engine Number 354UA412211
	37188185	1	Cover	From Serial or Engine Number 354UA412212
2	2487845	1	Cap	
3		1	Cap	(2) Not serviced, order 2487845
4	24870002	1	Joint	(2)
5	36811412	1	Joint	
6	2174018	6	Screw	
7	0920002	6	Washer	
8	0920052	6	Washer	
9	0180106	2	Clip	Up to Serial or Engine Number 354UA412211
10	33851106	1	Connection	Up to Serial or Engine Number 354UA412211
11	35736169	1	Pipe,Breather	Up to Serial or Engine Number 354UA412211
12	0746253	1	Screw	Up to Serial or Engine Number 354UA412211
13	0920053	1	Washer	Up to Serial or Engine Number 354UA412211
14	0180063	1	Clip	Up to Serial or Engine Number 354UA412211
15	37335125	1	Clip	Up to Serial or Engine Number 354UA412211
16	2174565	1	Screw	Up to Serial or Engine Number 354UA412211
17	0576053	1	Nut	Up to Serial or Engine Number 354UA412211
18	0920051	1	Washer	Up to Serial or Engine Number 354UA412211
19	2481804	1	Clip	Up to Serial or Engine Number 354UA412211
20	33872313	1	Pipe	From Serial or Engine Number 354UA412212
21	31754117	1	Spring	From Serial or Engine Number 354UA412212
22	2652845	1	Body	
23	0180103	1	Clip	From Serial or Engine Number 354UA412212
24	35731151	1	Connection	From Serial or Engine Number 354UA412212
25	87255	1	Rocker Shaft Ass	
26	58768	1	Rocker Shaft	(25)
27		1	Shaft	(26) Not serviced, order 58768
28	0650507	2	Plug	(26)
29	33117415	2	Washer	(25)
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32	31744123	4	Spring	(25)
33	31743108	2	Spring	(25)
34	37371281	6	Lever	(25)
35	37371271	6	Lever	(25)
36	0720579	12	Screw	(25)
37	0576052	12	Nut	(25)
38	35511111	1	Pipe	(25)
39	0726504	1	Setscrew	(25)
40	33811113	1	Olive	
41	0826621	6	Stud	
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