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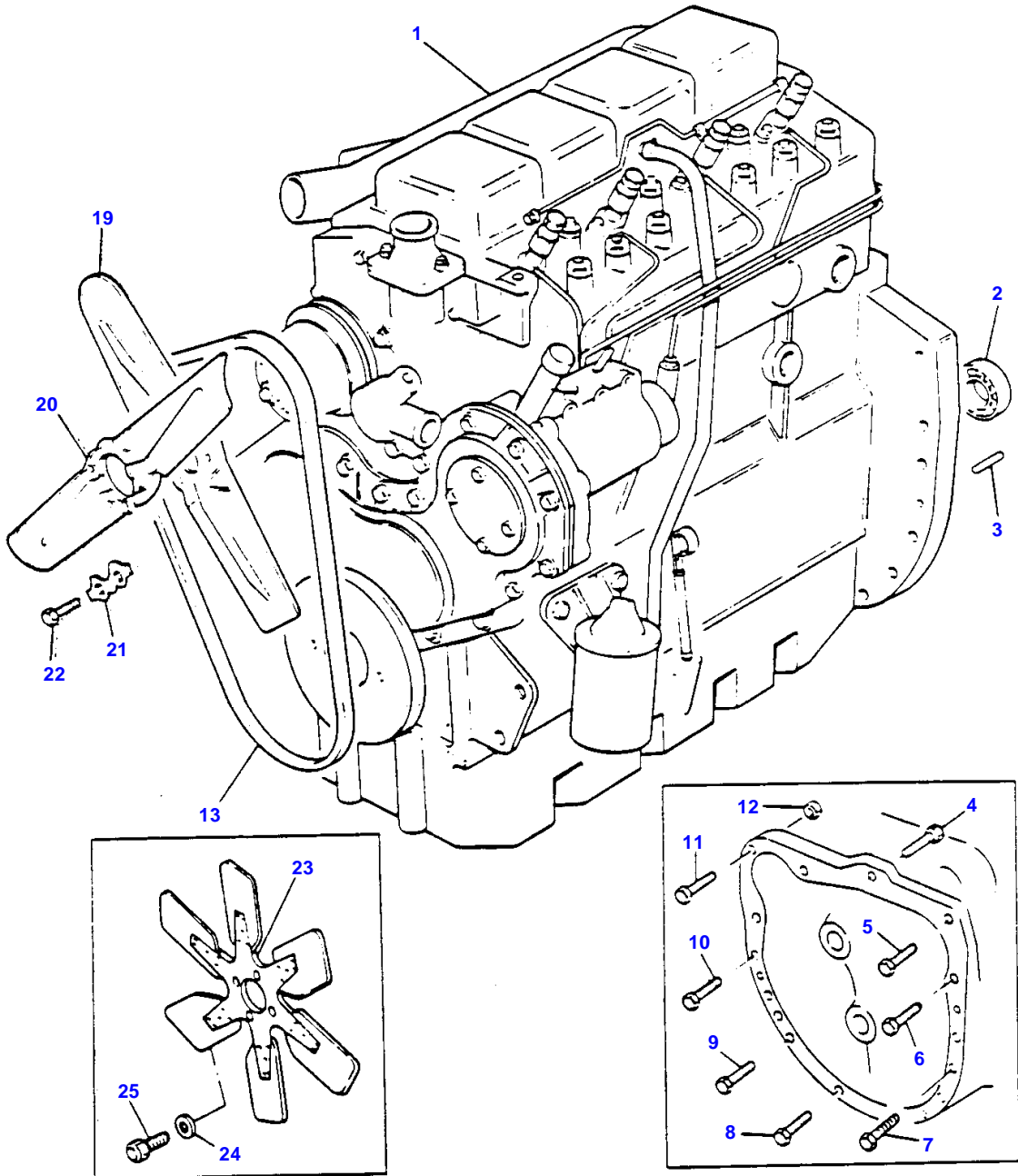
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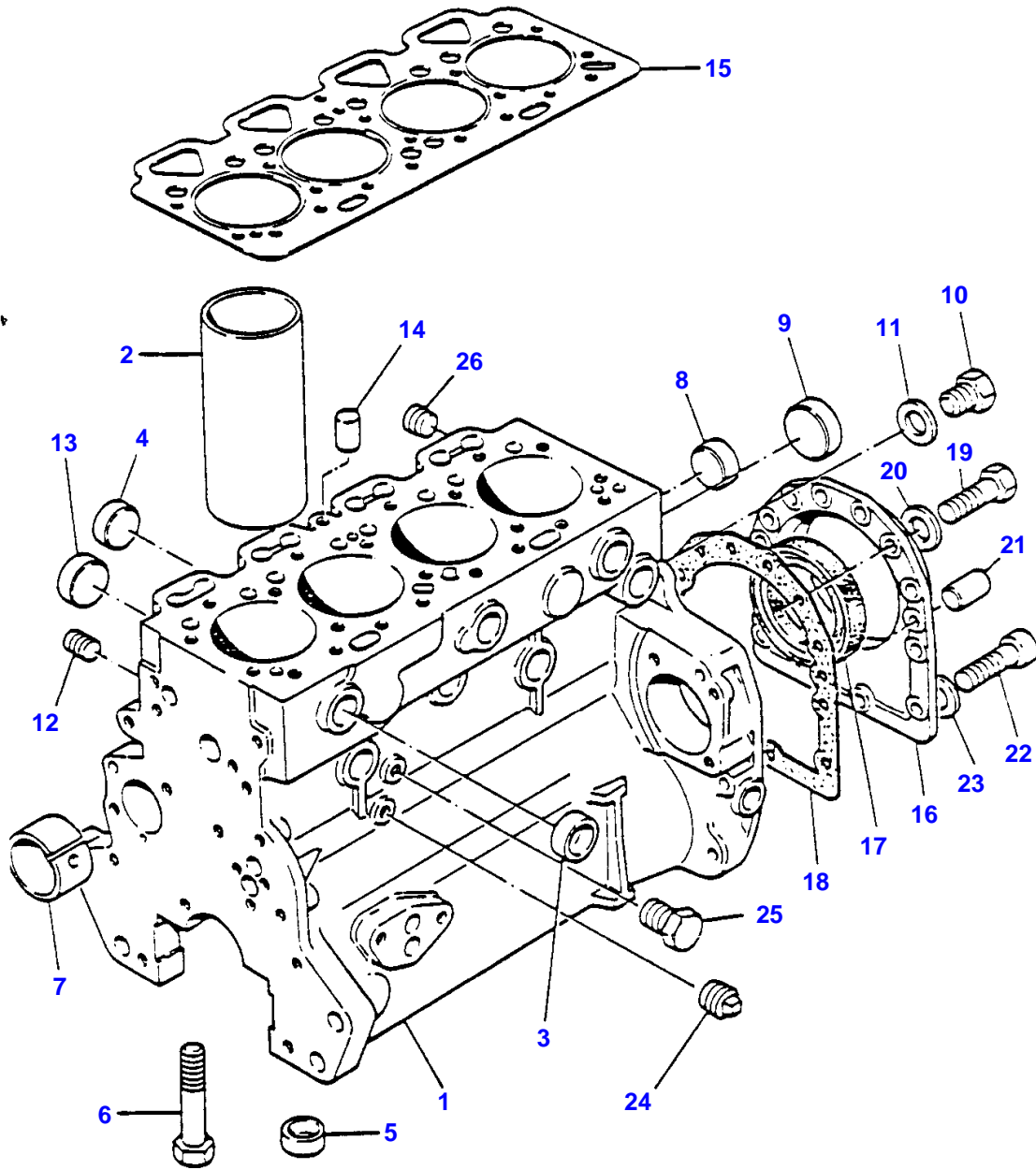
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## ENGINE INSTALLATION

Item	Part Number	Qty	Description
1	1873030M92	1	Engine
2	828123M1	1	Bearing Assy
3	825302M1	2	Dowel
4	353701X1	1	Screw Unc
5	353704X1	1	Bolt Unc
6	353708X1	2	Bolt Unc
7	353711X1	2	Bolt Unc
8	353704X1	2	Bolt Unc
9	353711X1	2	Bolt Unc
10	353708X1	3	Bolt Unc
11	353564X1	1	Bolt Unf
12	353428X1	1	Nut Unf
13	26148159	1	Belt
19	1885173M1	1	Fan
20	1885172M1	1	Fan
21	885476M2	2	Tab Washer
22	353518X1	4	Screw Unf
23	1874995M91	1	Fan
24	353446X1	4	Lock Washer
25	353529X1	4	Bolt Unf

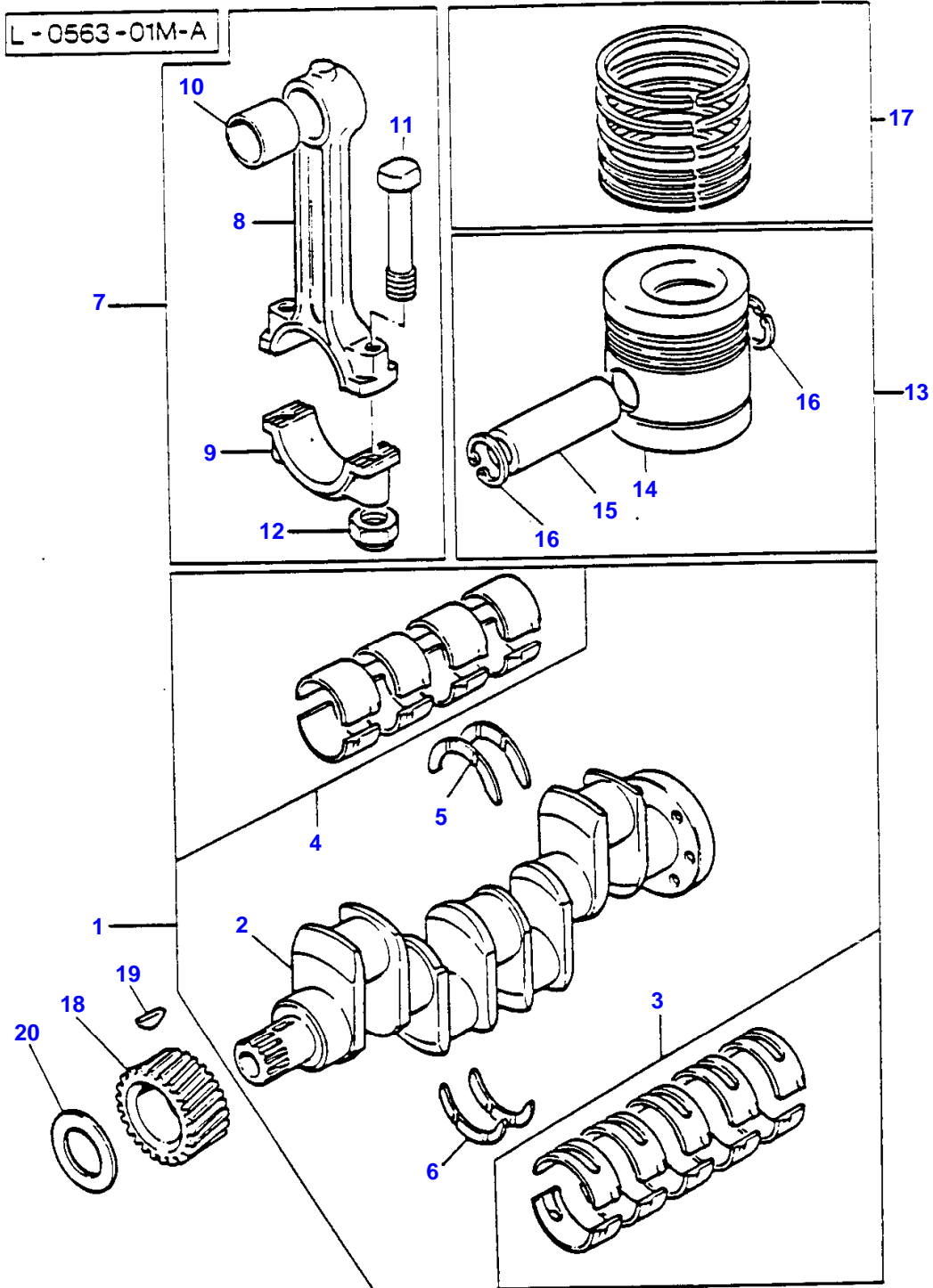
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CYLINDER BLOCK - A4.236 ENGINE

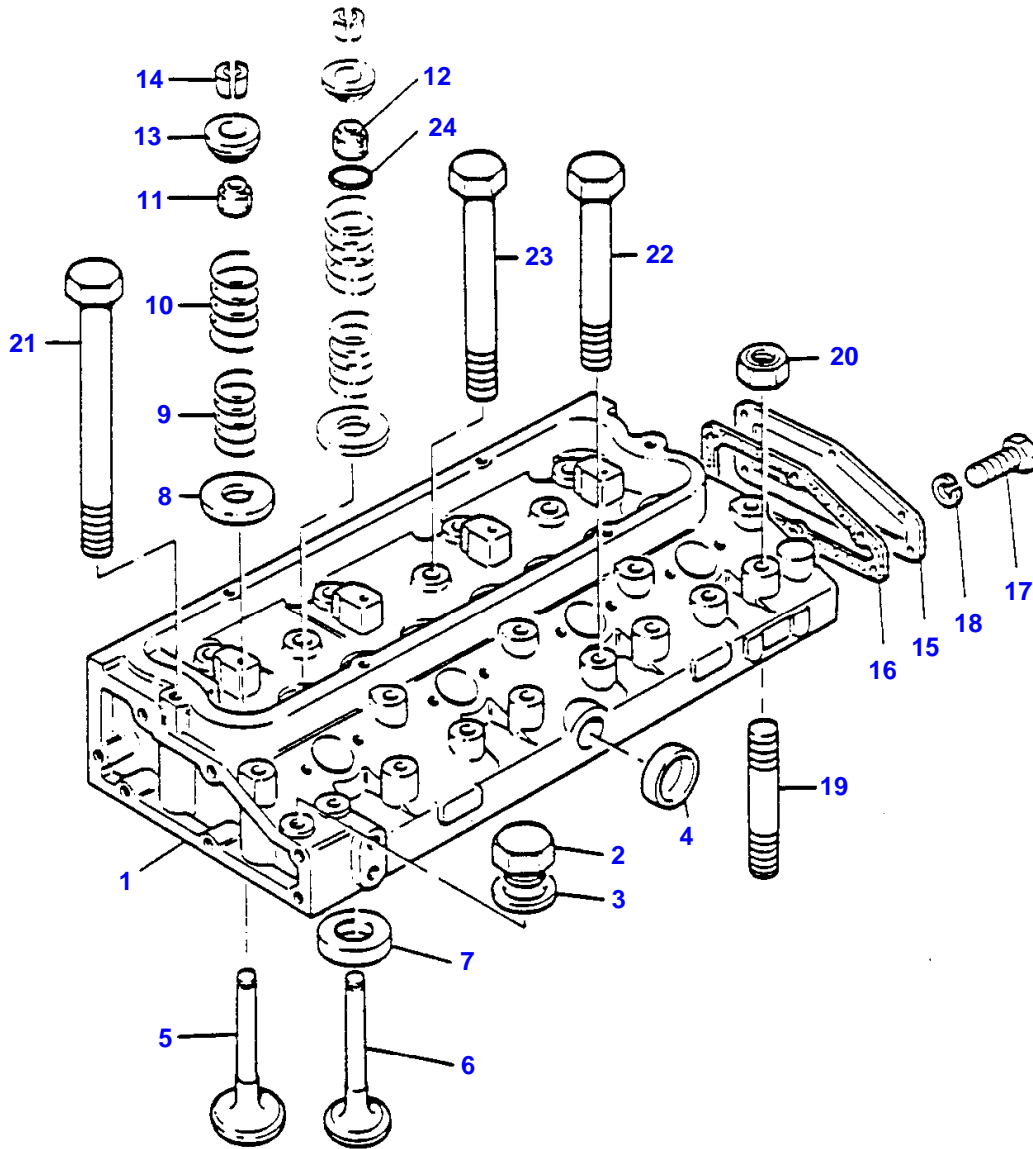
Item	Part Number	Qty	Description	Comments
				A4.236 ENGINE
1	ZZ50031	1	Kit,Cyl.Block	Repairs and replaces 61676 Repairs and replaces M7BA225
2	31358393	4	Liner	1 (A)
2	31358394	X	Liner	(B)
3	0650563	1	Plug	1
4	0650618	4	Plug	1
5	33142111	10	Thimble	1
6	32166329	10	Bolt	1
7	31134132	1	Bush	1
8	0650563	2	Plug	1
9	32416105	1	Plug	
10	0650582	1	Plug	
11	0920130	1	Washer	
12	32114501	1	Plug	
13	0650577	4	Plug	
14	32417134	1	Plug	
15	36812349	1	Head Gasket	
16	4142V061	1	Kit, Housing	Repairs and replaces 4142V031
17	2418F475	1	Seal	16 Repairs and replaces 2415391
18	36817157	1	Joint	
19	0746211	10	Bolt	
20	0920003	10	Washer	
21	0350009	2	Dowel	
22	2172530	2	Capscrew	
23	33112111	2	Washer	
24	0650594	1	Plug	
25	32161114	2	Plug	Repairs and replaces 32161357 Repairs and replaces 32161114
26	0650588	2	Plug	(A) PRESS FIT (B) SLIP FIT



CRANKSHAFT, PISTONS AND CONNECTING RODS - A4.236

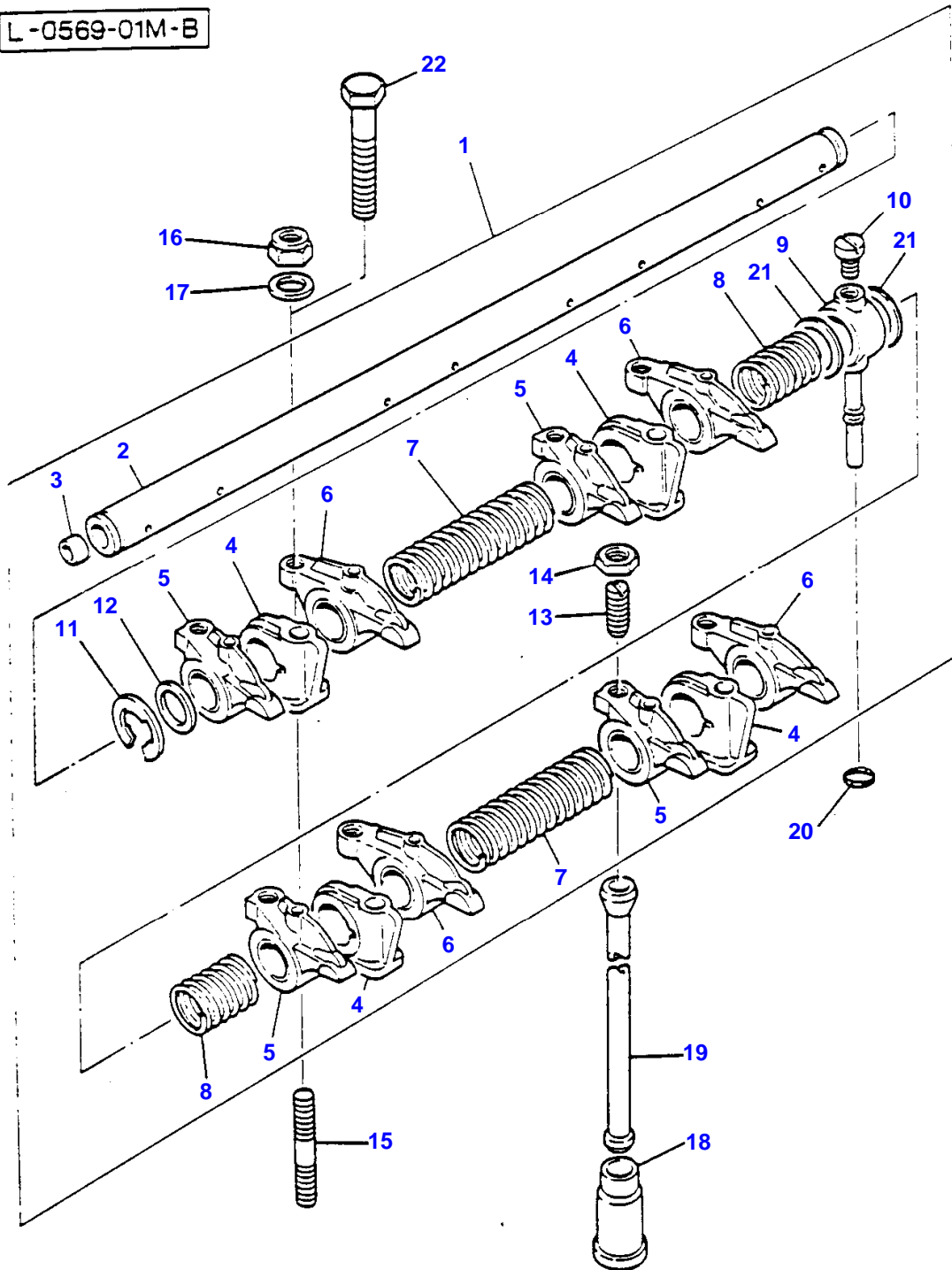
Item	Part Number	Qty	Description	Comments
				A4.236
1	68609	1	Kit, Crankshaft	
2		1	Crankshaft	1 Not serviced, order REF 1
3	81558	1	Kit, Bearing	1 (A)
3	81558A	X	Kit, Bearing	(A) Thickness (-)0.25 MM Thickness (-)0.010"
3	81558B	X	Kit, Bearing	(A) Thickness (-)0.50 MM Thickness (-)0.20"
3	81558C	X	Kit, Bearing	(A) Thickness (-)0.75 MM Thickness (-)0.30"
4	85042	1	Kit, Bearing	(A) 1
4	85042A	X	Kit, Bearing	(A) Thickness (-)0.25 MM Thickness (-)0.010"
4	85042B	X	Kit, Bearing	(A) Thickness (-)0.50 MM Thickness (-)0.20"
4	85042C	X	Kit, Bearing	(A) Thickness (-)0.75 MM Thickness (-)0.030"
5	31137311	2	Washer	1
	31137312	X	Thrust Washer	Thickness (+)0.19 MM Thickness (+)0.0075"
6	31137321	2	Washer	1
	31137322	X	Thrust Washer	Thickness (+)0.19 MM
7	ZZ90009	4	Kit, Conrod	Repairs and replaces M7BJ0015
8		1	Conrod	7 Not serviced, order REF 7
9		1	Cap	Not serviced, order REF 7 7
10	31134123	1	Bush	7
11	32762116	2	Bolt	7
12	33221328	2	Nut	7
13	68300	4	Kit, Piston	(B) Thickness (+)0.75 MM Thickness (+)0.030"
	68300C	X	Kit, Piston	(B)
13	68301	4	Kit, Piston	(C) Thickness (+)0.75 MM Thickness (+)0.030"
	68301C	X	Kit, Piston	(C)
14		1	Piston	13 Not serviced, order REF 13
15		1	Pin	13 Not serviced, order REF 13
16	0170002	2	Circlip	13
17	41158041	4	Kit, Piston Ring	
	41158041C	X	Kit, Piston Ring	Thickness (+)0.75 MM Thickness (+)0.030"
18	31171681	1	Gear,Crankshaft	Number of teeth/spines 28
19	0500012	1	Woodruff Key	
20	33125416	1	Washer	(A) PRE-FINISHED (B) UNTAPPED (C) PRE-TOPPED

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Item	Part Number	Qty	Description	Comments
				A4.236 ENGINE
1	ZZ80054	1	Kit, Cyl. Head	(D) Repairs and replaces U5BD0004
2	0650203	1	Plug	1
3	2411107	1	Washer	1
4	0650563	1	Plug	1
5	31431641	4	Valve Inlet	1
	31431401	X	Valve Inlet	Thickness (+)0.08 MM Thickness (+)0.003"
5	31431402	X	Valve Inlet	Thickness (+)0.38 MM Thickness (+)0.015"
5	31431403	X	Valve Inlet	Thickness (+)0.75 MM Thickness (+)0.030"
6	31431881	4	Valve Exhaust	1
	31431882	X	Valve Exhaust	Thickness (+)0.08 MM Thickness (+)0.003"
6	31431883	X	Valve Exhaust	Thickness (+)0.38 MM Thickness (+)0.015"
6	31431884	X	Valve Exhaust	Thickness (+)0.75 MM Thickness (+)0.030"
7	33152139	X	Insert	8
8	33415118	8	Washer	1 Repairs and replaces 33123117
9	31744131	8	Spring	1
10	31745121	8	Spring	1
11	33817117	4	Seal	1 Repairs and replaces 33817125
12	33817117	4	Seal	1
13	33423147	8	Cap	1
14	33173108	8	Cotter	1 (A)
15	3621F005	1	Plate	1 Repairs and replaces 37556142
16	36851409	1	Joint	1
17	0746254	6	Setscrew	1
18	0920053	6	Washer	1
19	32526312	2	Stud	(E)
20	33221316	2	Nut	(E)
21	32181426	2	Screw	(E)
	32166337	2	Screw	(F)
22	32181424	6	Screw	(E)
	32166339	8	Screw	(F)
23	32181425	12	Screw	(E)
	32166338	12	Bolt	(F)
24	2415B201	4	O Ring	1 (A)
				SERVICED IN PAIRS (D) WAS A5BD2383 USE U5BD0004 WITH 33813131 AND 338131 29 OR 3281M001 (SEE 0587L01M) (E) Up to Serial or Engine Number U027630M TBA See Page - Reference Number SERV. BULLETIN 21 (F) From Serial or Engine Number U027631M See Page - Reference Number SERV. BULLETIN 21 TBA

L-0569-01M-B



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