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# TECHNICAL REPORT

Gaskets assembly of cylinder  
lines in John Deere engines



## SCOPE

Indicate the correct position about how it must be assembled the cylinder liner gaskets in John Deere brand

## DESCRIPTION

The John Deere engines of 3 to 6 cylinders, assembles cylinder liner which mounts 3 gaskets in order to perform the correct sealing with the crankcase.

That is why Ajusa has 3 sets of cylinder liner gaskets, for cylinder diameters of 98, 102 and 106.5 mm.



OEM AR 71617 | AJUSA 60000500



OEM AR 71618 | AJUSA 60000700

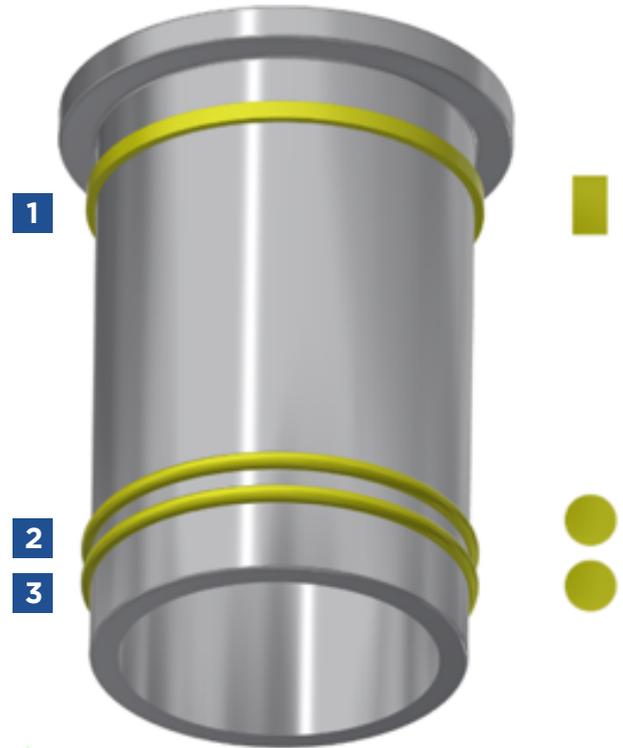


OEM AR 65507 | AJUSA 60000600

## ASSEMBLY

The 3 gaskets have different dimensions apart from being made of different materials, hence the colors do not match.

- **Clean** the contact area of the cylinder liner and block with the gasket.
- **Check** the area of the bearing collar and the o-rings in the sleeve and block. If the support is not completely flat, it will be necessary to repair it.
- **Lubricate** the gaskets with special non-acid grease to improve assembly and prevent damage.
- **Do not apply sealant.**
- **Position:** It is important to be installed following the next picture, respecting the same shape of the gaskets.



CYLINDER DIAMETER	REFERENCE AJUSA SET	REF. OEM SET	POSITION	OEM COLOR	SECTION	AJUSA COLOR	REF.	MEASUREMENTS
98 mm	60000500	AR 71617	1	black	square	green	24015800	98 x 102,4 x 4
			2	red or white	circular	green	16043800	106 x 3,5
			3	black	circular	green	16043800	106 x 3,5
102 mm	60000700	AR 71618	1	black	square	green	24016100	104 x 110 x 3,4
			2	red or white	circular	red	16044300	109 x 3,5
			3	black	circular	red	16044300	109 x 3,5
106,5 mm	60000600	AR 65507	1	black	square	black	28006100	99 x 103 x 3,7
			2	red or white	circular	red	16045400	115 x 3,5
			3	black	circular	green	16073200	117 x 3,5