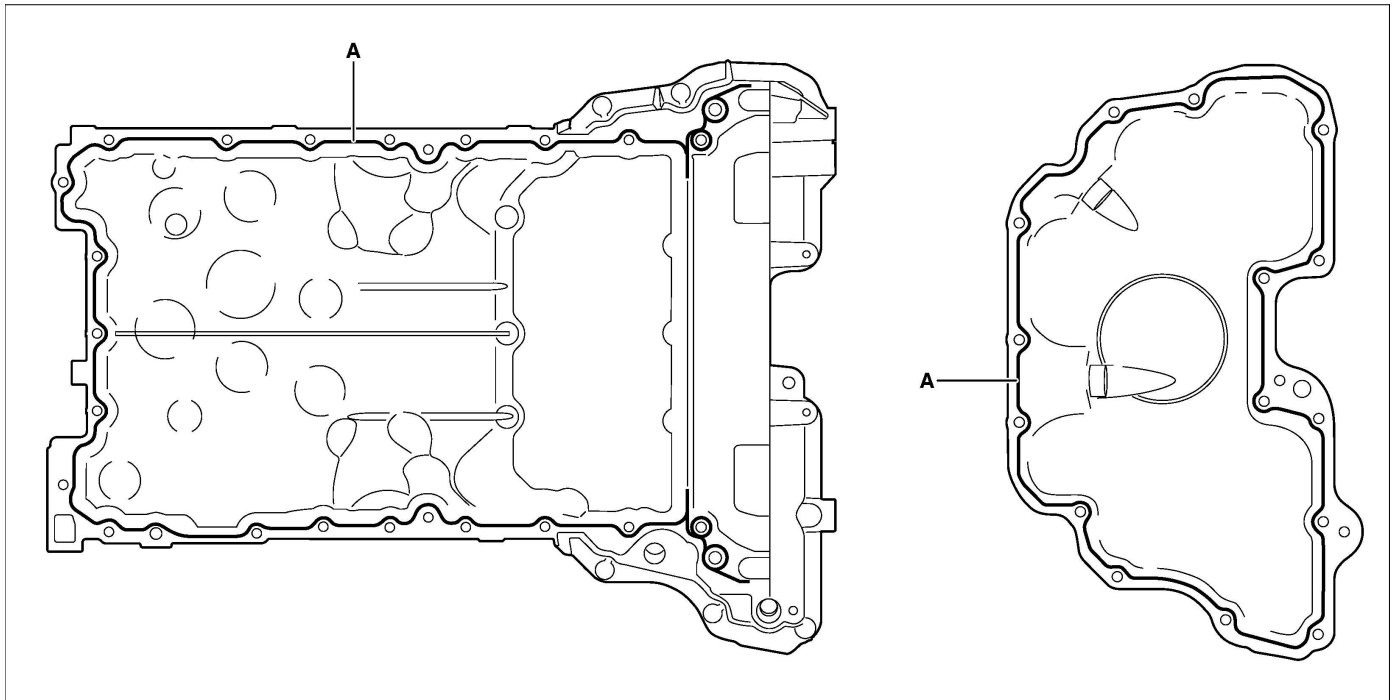
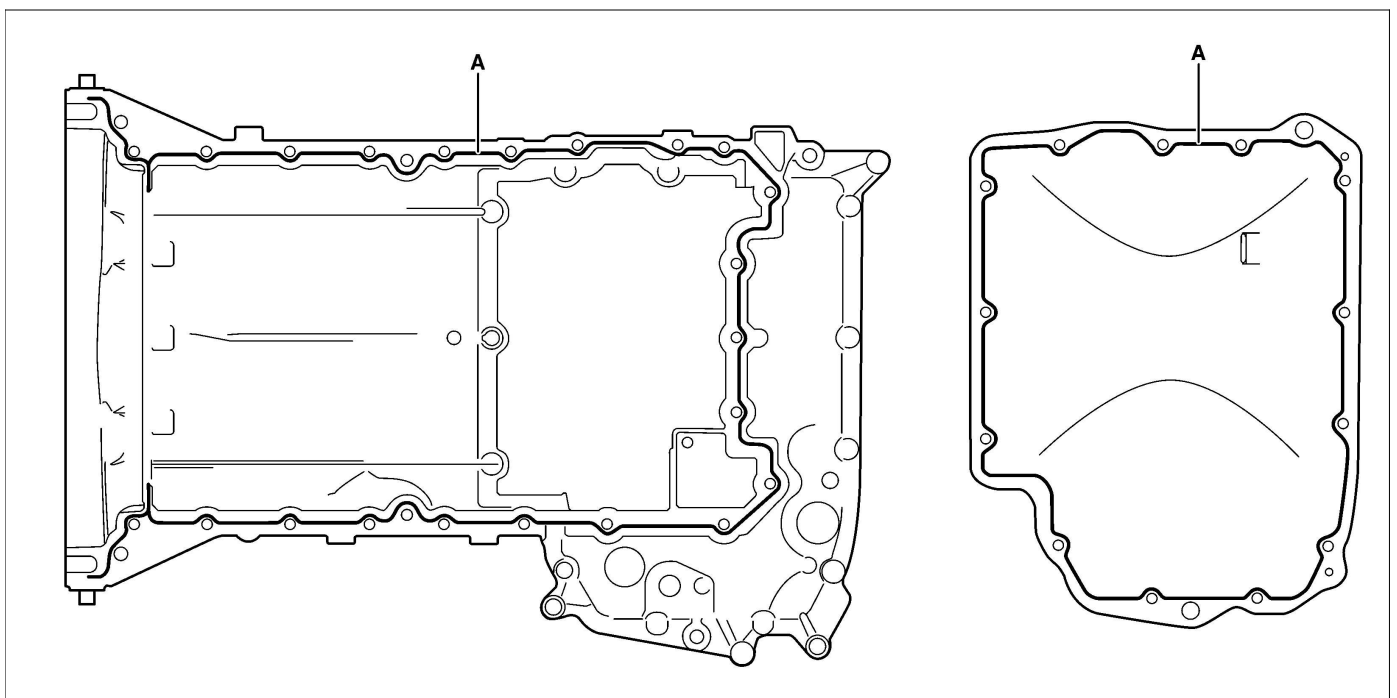


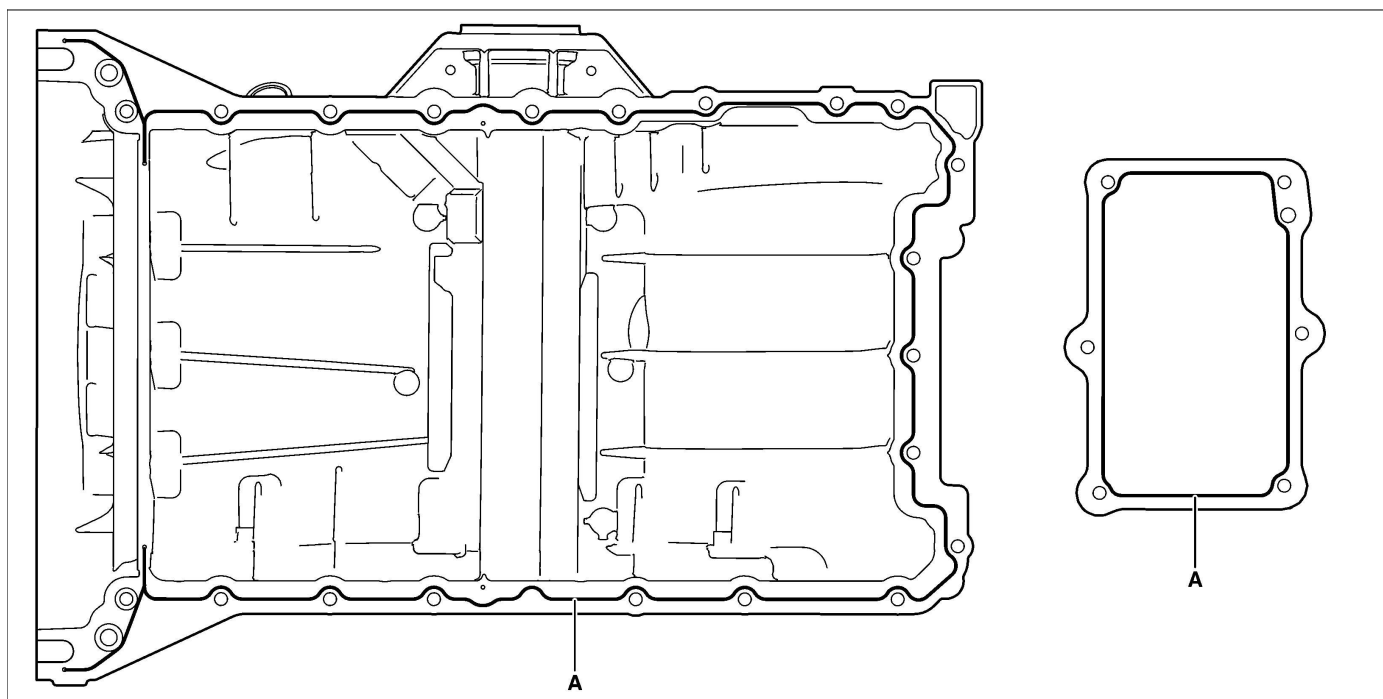
**Engine 642****General information on the sealing surface:**

- Free of anticorrosion agents
- Free of machining residue
- Oil and grease-free
- Dust-free
- Must be flat (replace bent components)
- Observe sealant path (A or F)
- Discontinuity of the sealant bead not permissible
- Do not spread sealing bead
- Component temperature: Min. +7 °C up to a max. of +25 °C
- Sealant temperature: Min. +7 °C up to a max. of +25 °C
- Maximum assembly time: 7 minutes
- Sealant bead diameter: 2 mm
- Nozzle diameter: 1.5 mm

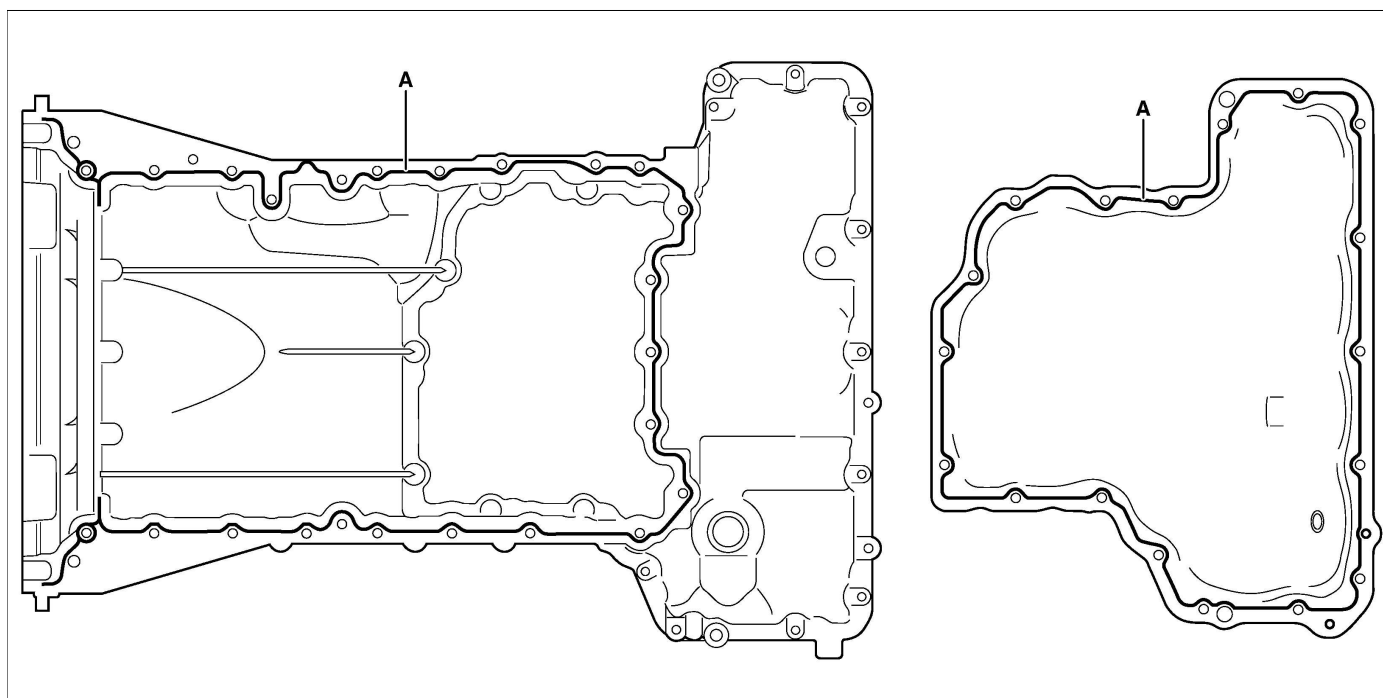


P01.45-2291-09

**Engine 642.852/910/920**

**Engine 642.862/930**

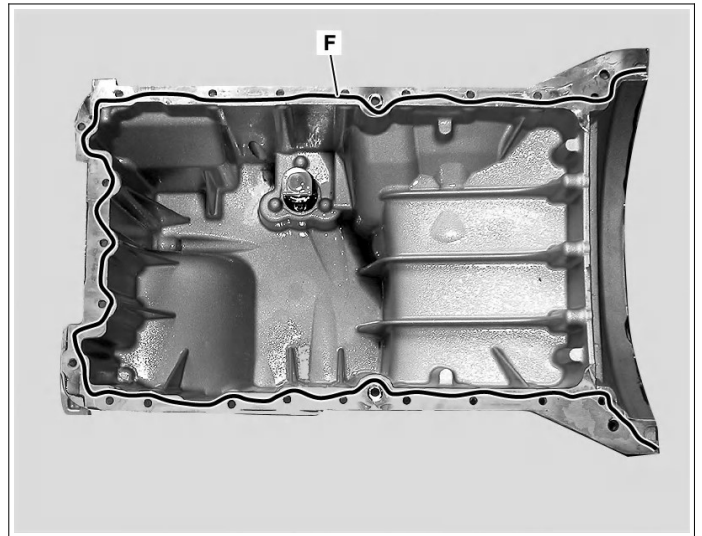
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**Engine 642.868/867/873/921/932/961**

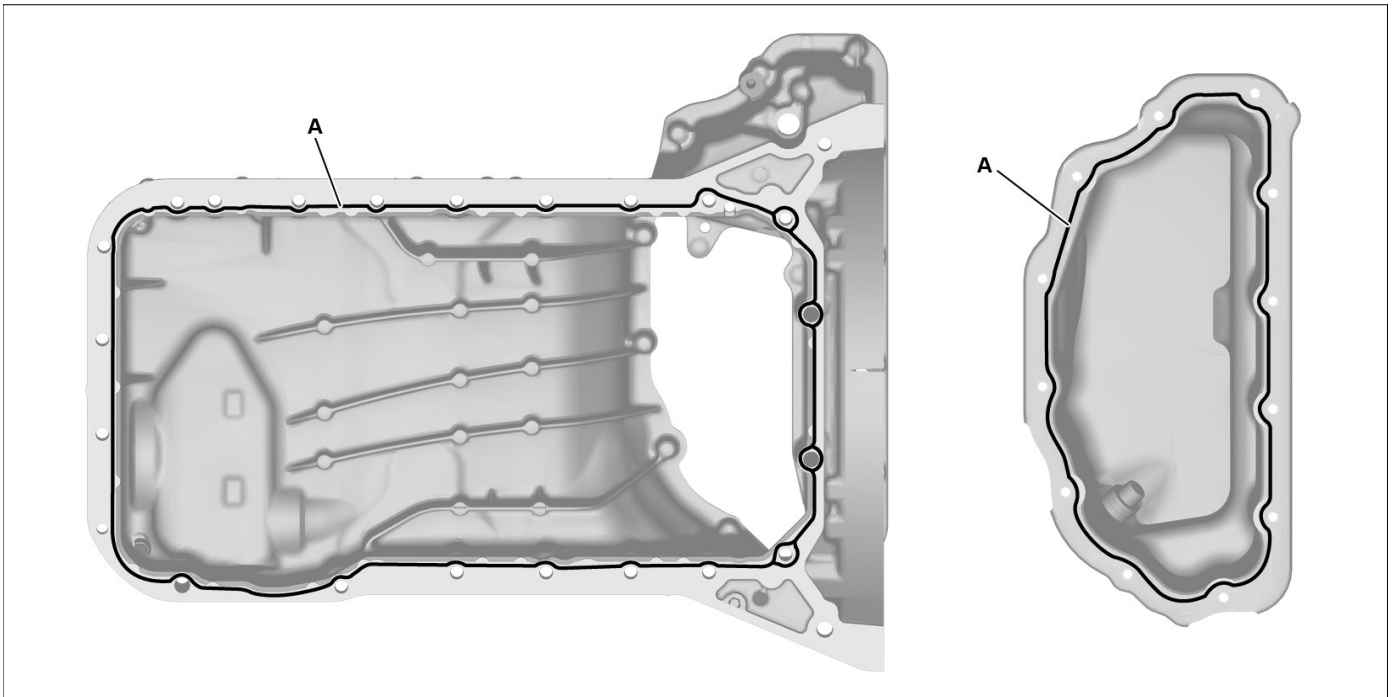
P01.45-2292-09

Engine 642.872/886/940/950/970

Engine 642.884/975



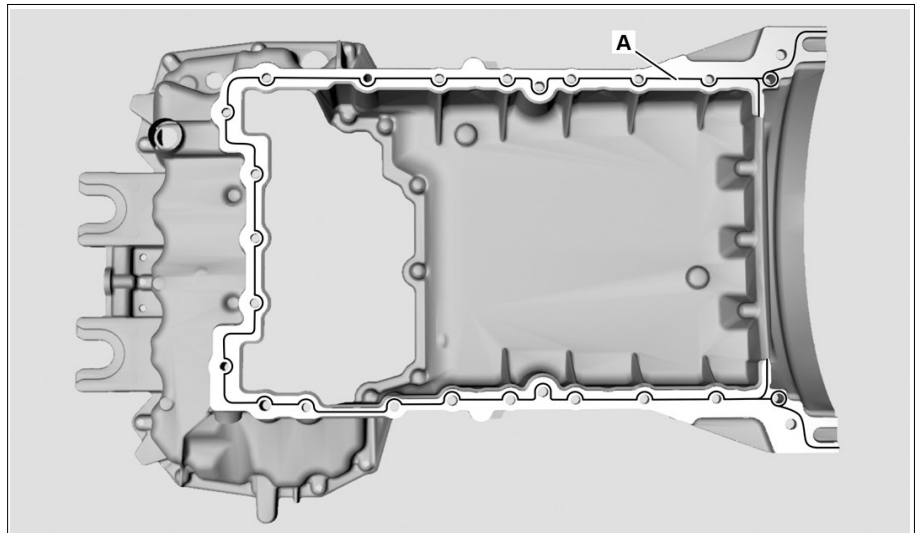
P01.45-2305-11



P01.45-2370-09

Engine 642.826

**Engine 642.855/861**



P01.45-2410-05