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TECHNICAL REPORT

Assembly of cylinder liner
gaskets set 60000300

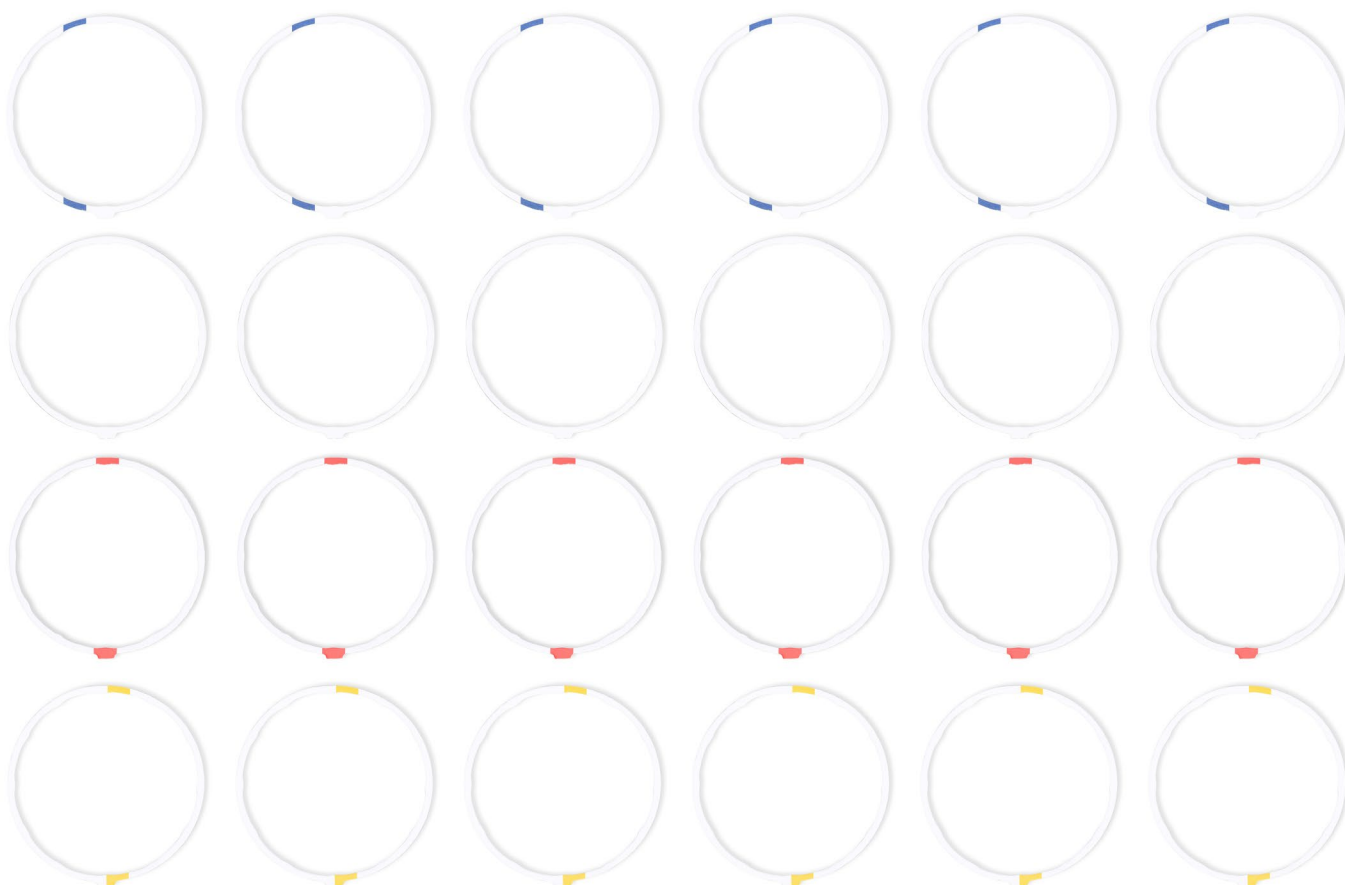




introduction

Assembly of cylinder liner gaskets 60000300 on CITROËN, PEUGEOT, RENAULT, VOLVO engines.

Brand	Model	Displacement (cc)	Power (hp)	Engine
Citroën	XM	2975 · 2963	167 - 200	SFZ · SKZ · UFZ
Peugeot	505 · 604 · 605	2849 · 2963	143 - 200	ZN3J / ZNJK SFZ · SKZ · UFZ
Renault	25 Laguna I-II-III Espace II-III Safrane I	2458 2849 2975	136 - 167	Z7U · Z7W · Z7X
Volvo	240 · 260 · 760 780 · 960	2849	129 - 155	B28

The sleeve gasket set 60000300 contains 24 gaskets separated into 4 groups of 6, by colours:



Set	Part number	Colour	Thickness (mm)	Picture
60000300	00221000	Blue	0.087	
	00221100	White	0.102	
	00221200	Red	0.122	
	00221300	Yellow	0.147	

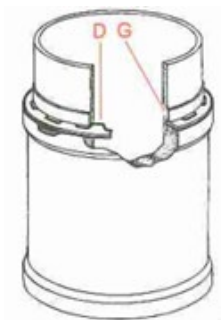
It will only be necessary to assemble one of these 4 groups of 6 gaskets, so for the assembly of the gaskets we will follow the following steps. The following steps are to be followed.

The correct overhang should be between **0.16-0.23 mm**, as close as possible to 0.23 mm.

If this is not the case, **repeat the process**, replacing the gaskets with those of the next thickness until the indicated overhang is achieved.

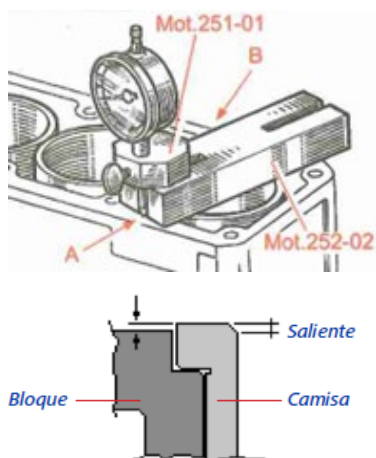
When the liners are new, it is not necessary to pay attention to the angular position. In addition, it will be possible to eliminate the differences in level between liners by rotating them in their cylinder.

01 | Choose the blue coloured gaskets, the thinner ones, placing the serrations (D) in the groove (G) of the liner.



03 | Position the liners in such a way that the coloured tabs of the seating gaskets are visible.

02 | Check the protrusion of each liner at (A) and (B) with the support plate Mot.252-01 and the bracket Mot.251-01 fitted with a dial gauge.



04 | Change gasket category if necessary to position the liners so that they are positioned in the same way:

- The difference in protrusion between two neighbouring cylinder liners is **0.04 mm** maximum (within tolerance).
- The protrusion is staggered from cylinder No. 1 to No. 3 (or No. 4 to No. 6).

