



- **SECTION 7 APPLICATION OF SEALANT DURING ENGINE ASSEMBLY**
- Table 2-6 Application of sealant during assembly of WD615 series engines



Training Document

HOWO ZZ4257S3241V

Type of sealant	Parts with sealant applied
Loctite 242 Action: anti-loosing	Timing gear housing bolt Tachometer coupling bolt Camshaft thrust shim bolt Intermediate gear shaft sleeve bolt Water pump impeller Water pump roller bearing seat Tensioning wheel bolt Filter seat bolt Oil cooler bolt Injection pump coupling bolt Intake pipe screw plug Air compressor bolt and nut Air compressor drive gear nut Intermediate gear shaft bolt
Loctite 262 (red) anti-loosing	Cylinder head studbolt





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Type of sealant	Parts with sealant applied
Loctite 271 (red) anti-loosing	Main oil passage pressure-limiting valve and oil cooler bypass valve Oil pump pressure-limiting valve
Loctite 609 (green) fastening	Oil-gas separator elbow Warm air water inlet/outlet pipe unions Bearing, oil pump drive shaft, intermediate gear Supercharger oil return pipe union
Loctite 680 (green) fastening	Cylinder head injection nozzle copper sleeve
Type of sealant	Parts with sealant applied
Loctite 569 (white) sealing	Supercharger lubricating pipe coupling bolt Oil pump lubricating pipe
Loctite 510 (red) sealing	Cylinder block and crankcase mating surface Engine body end surface Air compressor and timing gear housing mating surface
504 (orange) synthetic rubber sealant/silicon resin sealant	Safety valve Filter seat and crankcase mating surface Air compressor rear oil seal Supercharger oil inlet flange
Anti-Size	Exhaust pipe bolt, supercharger bolt
Molybdenium disulfide lubrication	Cylinder sleeve and engine block Valve guide and cylinder head Valve stem and guide