

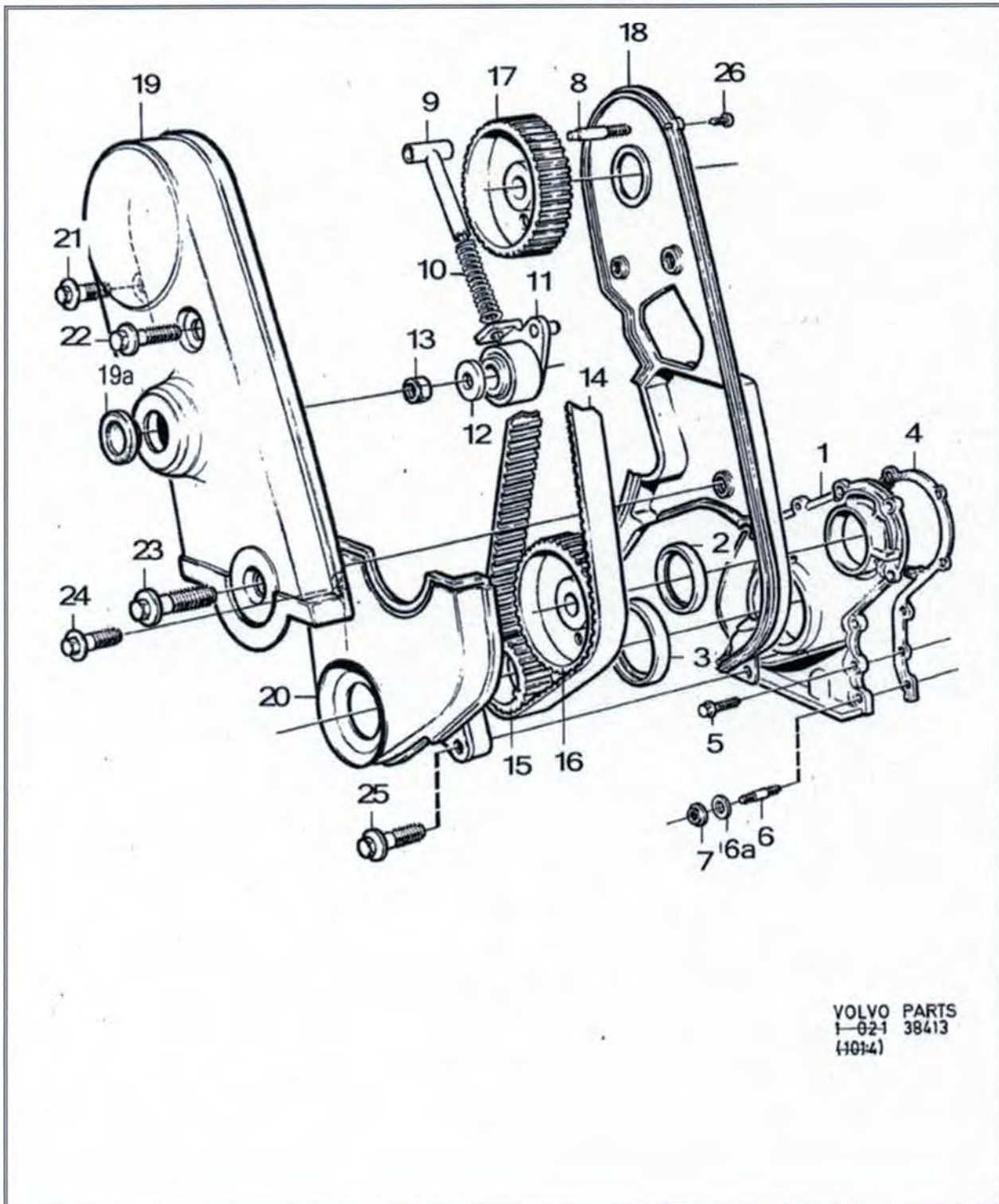
21 : Belt transmission B200, B230, B200F

240, 1992, B200F, M47, L.H.D, YV1245273N1918729, 918729

28/7/2015









PRINT



VOLVO PARTS
1-02-1 38413
(1014)

Fig.	Description	Qty.	PS	Part number
1	Sealing flange	1.00		1336761
2	Sealing ring	1.00	IK	6842273

(1306333)					
<input type="checkbox"/>	3	Sealing ring (1276424)	1.00	IK	1276425
<input type="checkbox"/>	4	Gasket	1.00	IK	1378493
<input type="checkbox"/>	5	Flange screw	6.00		982757
<input type="checkbox"/>	6	Stud	2.00		924055
<input type="checkbox"/>	6a	Washer	2.00		986478
<input type="checkbox"/>	7	Flange nut	2.00		985919
<input type="checkbox"/>	8	Stud	1.00		
		Cylinder head B200E, B200F, B200K, Not included in complete cylinder block.			
<input type="checkbox"/>		Stud	1.00		
		Cylinder head B230E, B230F, B230FX, Not included in complete cylinder block.			
<input type="checkbox"/>		Stud	1.00		
		Cylinder head B230K, Not included in complete cylinder block.			
<input type="checkbox"/>		Stud	1.00		
		Cylinder head B230FD, Not included in complete cylinder block.			
<input type="checkbox"/>	9	Spring guide Not included in complete cylinder block.	1.00		463386
<input type="checkbox"/>	10	Spring Not included in complete cylinder block.	1.00		463389
<input type="checkbox"/>	11	Tension pulley Not included in complete cylinder block.	1.00		463633
<input type="checkbox"/>	12	Washer Not included in complete cylinder block.	1.00		463580
<input type="checkbox"/>	13	Hexagon nut (955783), Not included in complete cylinder block.	1.00		985878
<input type="checkbox"/>	14	Tooth belt, kit -1992, Not included in complete cylinder block.	1.00		271713
<input type="checkbox"/>		Tooth belt, kit 1993-	1.00		271747
<input type="checkbox"/>	15	Pulley Crank mechanism B200, Not included in complete cylinder block.	1.00		
<input type="checkbox"/>		Pulley Crank mechanism B230E, B230F, B230FD, Not included in complete cylinder block.	1.00		
<input type="checkbox"/>		Pulley Crank mechanism B230K, Not included in complete cylinder block.	1.00		
<input type="checkbox"/>	16	Pulley Engine with fittings B200, Not included in complete cylinder block.	1.00		
<input type="checkbox"/>		Pulley Engine with fittings B230, Not included in complete cylinder block.	1.00		
<input type="checkbox"/>	17	Pulley Cylinder head B200E, B200F, B200K, Not included in complete cylinder block.	1.00		
<input type="checkbox"/>		Pulley Cylinder head B230E, B230F, B230FX, Not included in complete cylinder block.	1.00		
<input type="checkbox"/>		Pulley Cylinder head B230K, Not included in complete cylinder block.	1.00		
<input type="checkbox"/>		Pulley Cylinder head B230FD, Not included in complete cylinder block.	1.00		
<input type="checkbox"/>	18	Belt protector, rear Not included in complete cylinder block.	1.00		1336756
<input type="checkbox"/>	19	Belt protector, upper Not included in complete cylinder block.	1.00		1336757
<input type="checkbox"/>	19a	* Plug	1.00		961970
<input type="checkbox"/>	20	Belt protector, lower Not included in complete cylinder block.	1.00		1378611
<input type="checkbox"/>	21	Flange screw M6x30, Not included in complete cylinder block.	1.00		985183

	22	Flange screw M6x45, Not included in complete cylinder block.	1.00	982763
	23	Flange screw M8x55, Not included in complete cylinder block.	1.00	982801
	24	Flange screw M6x30, Not included in complete cylinder block.	1.00	985183
	25	Flange screw M8x30, Not included in complete cylinder block.	1.00	985188
	26	Six point socket screw -1989 (955143)	1.00	986118
		Six point socket screw 1990-, , REPL 1PCS 986064	1.00	972575

28/7/2015

PRINT

21 : Cylinder head B200E, B200F, B200K

240, 1992, B200F, M47, L.H.D, YV1245273N1918729, 918729

28/7/2015



PRINT

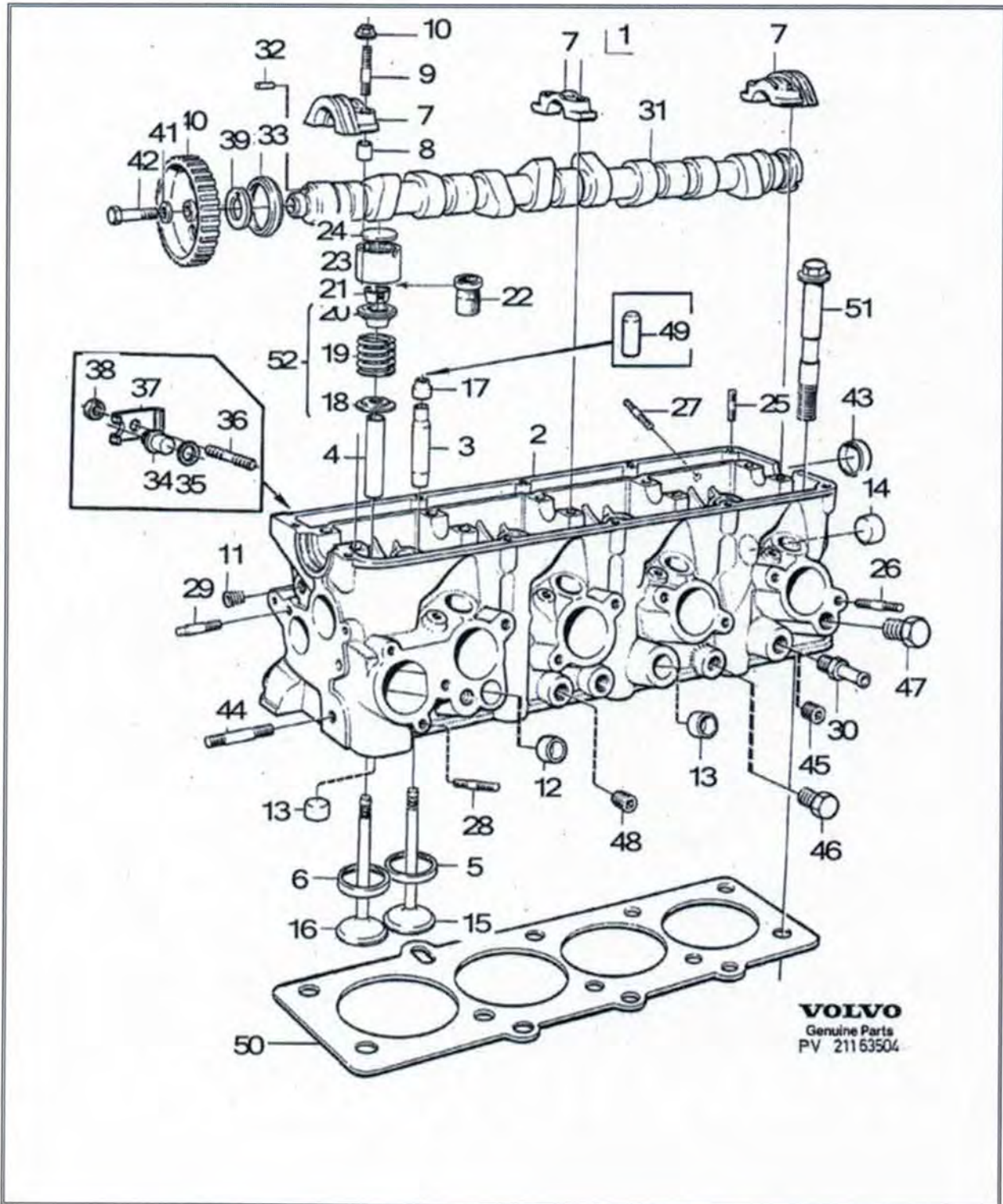


Fig.	Description	Qty.	PS	Part number
1	Cylinder head, exch B200K (1277718), , 1289214, 1289216, , 1289217	1.00	EU	5003553
	Cylinder head, exch	1.00	EU	5003551

B200K (1277677), , 1289218-1289221					
		Cylinder head, exch B200E (1277719), , REPL 1 PCS 1277721-5	1.00	EU	5003529
		Cylinder head B200F, , REPL 1PCS 5003546-8.	1.00		1277678
		Cylinder head, exch	1.00	EU	5003546
	2	• Cylinder head	1.00	NS	
	3	•• Valve guide, intake STD. O.DIA 13.5 mm	4.00		419652
		•• Valve guide, intake O.S 0.1 mm	4.00		1266193
		•• Valve guide, intake O.S 0.2 mm	4.00		1266195
		•• Valve guide, intake O.S 0.3 mm	4.00	OP	1266196
	4	•• Valve guide, exhaust STD. O.DIA 13.5 mm	4.00		3547603
		•• Valve guide, exhaust O.S 0.1 mm	4.00	OP	3547604
		•• Valve guide, exhaust O.S 0.2 mm	4.00		3547605
		•• Valve guide, exhaust O.S 0.3 mm	4.00	NS	
	5	•• Valve seat, intake STD. O.DIA 46 mm, , (1357651)	4.00		6842082
		•• Valve seat, intake O.S 0.25 mm, , (1266417)	4.00		9135345
		•• Valve seat, intake O.S 0.50 mm, , (1266418)	4.00		9135346
	6	•• Valve seat, exhaust STD. O.DIA 38 mm, , (1266419)	4.00		6842083
		•• Valve seat, exhaust O.S 0.25 mm, , (1266420)	4.00		6842381
		•• Valve seat, exhaust O.S 0.50 mm, , (1266421)	4.00		6842382
	7	•• Bearing cap kit	1.00	NS	
		••• Bearing cap	5.00	NS	
	8	•••• Guide sleeve	10.00		463690
	9	•• Stud	10.00		953049
	10	•• Flange nut	10.00		985921
	11	•• Plug	2.00		940375
	12	•• Cap plug STD. O.DIA 17.5 mm	x		946778
	13	•• Cap plug STD. O.DIA 21 mm	2.00		946779
		•• Cap plug O.S. O.DIA 25 mm	x		955086
	14	•• Cap plug STD. O.DIA 29 mm	4.00		946780
		•• Cap plug EXC B200/230F	x		955088
	15	• Inlet valve	4.00		463395
	16	• Exhaust valve	4.00		463526
	17	• Valve seal, intake	4.00	IK	1306630
	18	• Washer EXC B200/230F	8.00		463399

	•	Valve spring washer	8.00		9135132
		B200/230F			
19	•	Valve spring	8.00		463739
		EXC B200/230F			
	•	Valve spring	8.00		9135130
		B200/230F			
20	•	Valve spring washer	8.00		1266797
		EXC B200/230F			
	•	Valve spring washer	8.00		9135131
		B200/230F			
21	•	Valve cotter	16.00		419643
22	•	Absorber	8.00		3514432
		(1219648)			
23	•	Valve tappet	8.00		463075
24	•	Adjusting washer	x		463546
		THK 3.30 mm			
	•	Adjusting washer	x		463547
		THK 3.35 mm			
	•	Adjusting washer	x		463548
		THK 3.40 mm			
	•	Adjusting washer	x		463549
		THK 3.45 mm			
	•	Adjusting washer	x	IK	463550
		THK 3.50 mm			
	•	Adjusting washer	x	IK	463551
		THK 3.55 mm			
	•	Adjusting washer	x	IK	463552
		THK 3.60 mm			
	•	Adjusting washer	x	IK	463553
		THK 3.65 mm			
	•	Adjusting washer	x	IK	463554
		THK 3.70 mm			
	•	Adjusting washer	x	IK	463555
		THK 3.75 mm			
	•	Adjusting washer	x	IK	463556
		THK 3.80 mm			
	•	Adjusting washer	x	IK	463557
		THK 3.85 mm			
	•	Adjusting washer	x	IK	463558
		THK 3.90 mm			
	•	Adjusting washer	x	IK	463559
		THK 3.95 mm			
	•	Adjusting washer	x	IK	463560
		THK 4 mm			
	•	Adjusting washer	x	IK	463561
		THK 4.05 mm			
	•	Adjusting washer	x	IK	463562
		THK 4.10 mm			
	•	Adjusting washer	x	IK	463563
		THK 4.15 mm			
	•	Adjusting washer	x		463564
		THK 4.20 mm			
	•	Adjusting washer	x		463565
		THK 4.25 mm			
	•	Adjusting washer	x		463566
		THK 4.30 mm			
	•	Adjusting washer	x		463567
		THK 4.35 mm			

	•	Adjusting washer THK 4.40 mm	x		463568
	•	Adjusting washer THK 4.45 mm	x		463569
	•	Adjusting washer THK 4.50 mm	x		463570
	•	Adjusting washer kit THK 3.50-4.15 mm	1.00	OP	273699
25	•	Stud	10.00		953035
26	•	Valve cover EXC B200K Stud	7.00		953046
	•	Inlet manifold LG 42 mm EXC B200K Stud	1.00		953047
	•	Inlet manifold LG 45 mm B200K Stud	6.00		953046
27	•	Inlet manifold Stud	8.00		953047
28	•	Exhaust pipe Stud	2.00		948606
29	•	Stud	1.00		463390
30	•	Spring guide (961656) Nipple	1.00		986842
31	•	Heater unit Camshaft MARKED Y, , B200K 1289218-1289221	1.00		1346438
	•	Camshaft MARKED L, , B200K 1289216,1289217	1.00		1336777
	•	Camshaft MARKED A, , B200E	1.00		1336767
	•	Camshaft MARKED M, , B200F	1.00		1336779
32	••	Spring pin	1.00		949433
33	•	Sealing ring (1306333)	1.00	IK	6842273
34	•	Plug Spare part version.	4.00		1277457
35	•	Gasket kit (1378487), Spare part version.	4.00		271776
36	•	Stud Spare part version.	4.00		953032
37	•	Clamp Spare part version.	4.00		1266663
38	•	Hexagon nut Spare part version.	4.00		985876
39		Washer B200K 1289214 ENG -1275. B200K 1289216 ENG -1701. B200K 1289217 ENG -562. B200K 1289218 ENG -920. B200K 1289219 ENG -515. B200K 1289220 ENG -500. B200K 1289221 ENG -500., , B200E 1289224 ENG -5414. B200E 1289225 ENG -2599., , B230F 1289186 ENG -21458. B230F 1289187 ENG -30799. B230F 1289188 ENG -848. B230F 1289189 ENG -2570., , B230K 1289120 ENG -7583. B230K 1289121 ENG -1438. B230K 1289174 ENG -692. B230K 1289175 ENG -584. B230K 1289332 ENG -500. B230K	1.00		1357572

1289333 ENG -500., , B230E 1289226 ENG -1679. B230E 1289227 ENG -742. B230E 1289228 ENG -1997. B230E 1289229 ENG -1178. B230E 1289304 ENG -542. B230E 1289305 ENG -518.

<input type="checkbox"/>	40	Pulley -1992. (1219322)	1.00		3514089
<input type="checkbox"/>		Pulley 1993-	1.00		6842032
<input type="checkbox"/>	41	Washer	1.00		463580
<input type="checkbox"/>	42	Hexagon screw (955322)	1.00		987002
<input type="checkbox"/>	43	Cover washer	1.00		1336763
<input type="checkbox"/>	44	Stud	1.00		953077
<input type="checkbox"/>		Tension pulley			
<input type="checkbox"/>	45	Plug ALTER. 3/8"	2.00		986811
<input type="checkbox"/>	46	Plug ALTER. M12	1.00		960629
<input type="checkbox"/>	47	Plug ALTER. M14	1.00		986815
<input type="checkbox"/>	48	Plug	1.00		986811
<input type="checkbox"/>	49	Sleeve, fitting of valve seals	1.00	IK	1332645
<input type="checkbox"/>	50	Gasket	1.00	IK	1378645
<input type="checkbox"/>	51	Screw	10.00		1306341
<input type="checkbox"/>	52	Service kit B200/230F, B230FD, Parts version with component parts as pos: 18, 19 and 20 show.	8.00	OP	271793

28/7/2015

PRINT

21 : Crank mechanism B200, B200F

240, 1992, B200F, M47, L.H.D, YV1245273N1918729, 918729

28/7/2015



PRINT

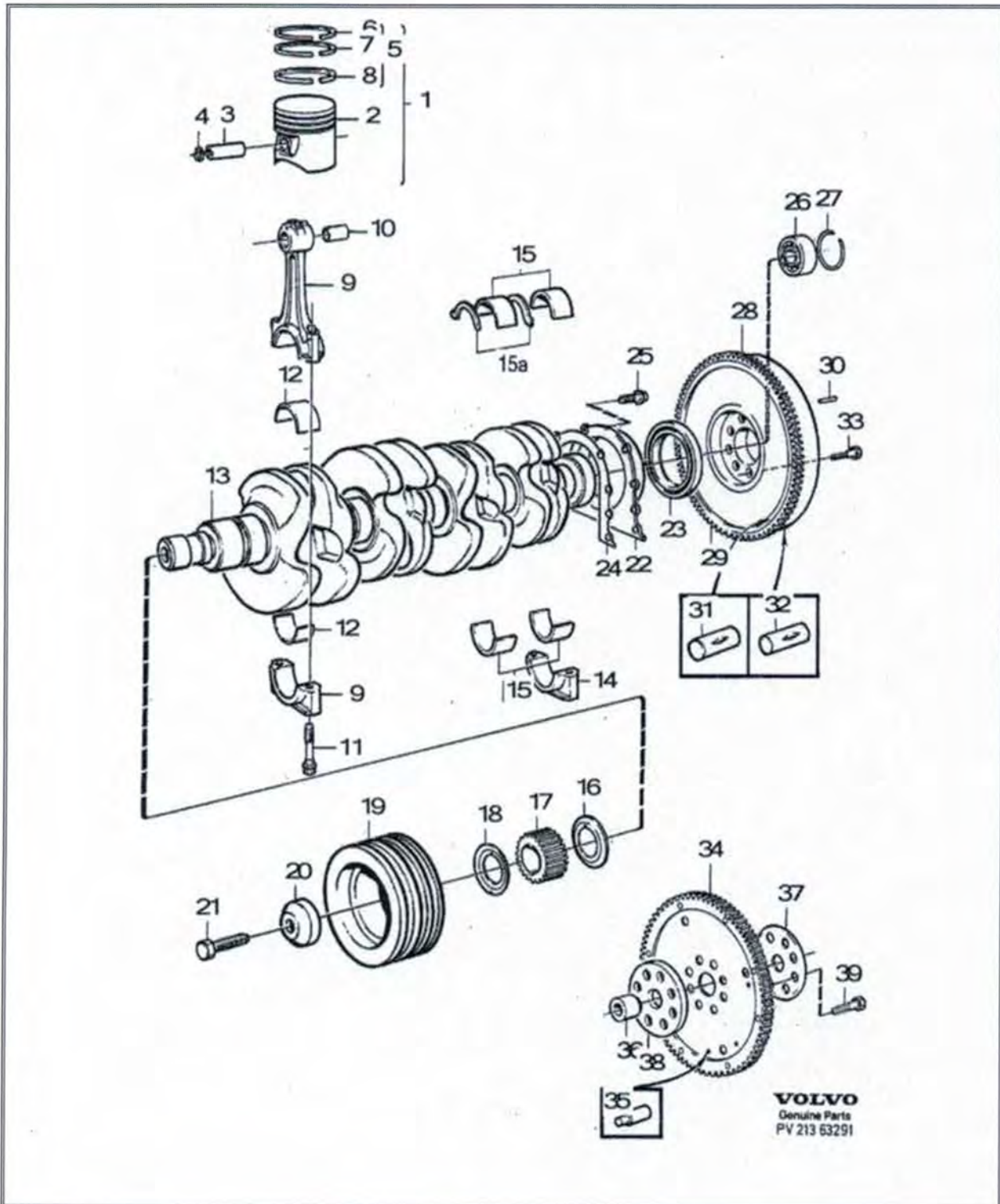


Fig.	Description	Qty.	PS	Part number
1	Piston kit, complete B200K 91/93 OCTANE, , B200K 1289218-1289221 • Piston kit	1.00	NS	

		STD MARKED D	4.00		272114
		• Piston kit	4.00		272115
		STD MARKED G, , O.S 0.03 mm			
		• Piston kit	4.00	OP	272116
		O.S 0.38 mm			
		• Piston kit	4.00		272117
		O.S 0.76 mm			
		Piston kit, complete B200K 97/98 OCTANE, , B200K 1289214-1289217	1.00	NS	
		• Piston kit	4.00		271592
		STD MARKED D, , (272106)			
		• Piston kit	4.00		272107
		STD MARKED G, , O.S 0.03 mm, , REPL 1PCS 271593-6.			
		Piston kit	4.00		271593
		• Piston kit	4.00		271594
		O.S 0.38 mm, , (272108)			
		• Piston kit	4.00		271595
		O.S 0.76 mm, , (272109)			
		Piston kit, complete B200E, B200F	1.00	NS	
		• Piston kit	4.00		271592
		STD MARKED D, , (272106)			
		• Piston kit	4.00		272107
		STD MARKED G, , O.S 0.03 mm, , REPL 1PCS 271593-6.			
		• Piston kit	4.00		271594
		O.S 0.38 mm, , (272108)			
		• Piston kit	4.00		271595
		O.S 0.76 mm, , (272109)			
	2	•• Piston	4.00	KN	
	3	•• Gudgeon pin	4.00	NS	
	4	•• Retaining ring	8.00	IK	1346593
	5	•• Piston ring kit B200, , STD	1.00	IK	275363
		•• Piston ring kit B200, , O.S 0.38 mm	1.00	IK	275364
		•• Piston ring kit B200, , O.S 0.76 mm	1.00	IK	275365
	6	••• Compression ring	4.00	KN	
	7	••• Compression ring	4.00	KN	
	8	••• Oil deflector ring	4.00	KN	
	9	Connecting rod kit	1.00		271451
		• Crankshaft (1346135)	4.00	NS	
	10	•• Bearing bushing	4.00		1346392
	11	•• Screw	8.00		1326296
	12	Big-end bearing kit STD	1.00		270136
		Big-end bearing kit U.S 0.25 mm	1.00		270137
		Big-end bearing kit U.S 0.50 mm	1.00		270138
		• Bearing shell, upper	4.00	KN	
		• Bearing shell, lower	4.00	KN	
	13	Crankshaft REPL 1PCS 270906-1, , 1PCS 6842784-8,, , 1PCS 1378980-5., For engines with main	1.00		1346013

	bearing diameter 55 mm., Replacement parts included part or whole in new design, referred to in another section of this catalogue.			
	replacement parts			
	6842784-8		XX	
	Engine block B200			
	Crankshaft	1.00		1378980
	For engines with 63 mm diameter main bearings.			
14	Bearing cap	5.00		
	Engine block B200			
	Bearing cap	5.00		
	Engine block B230			
15	Main bearing kit	1.00		271236
	STD, For engines with main bearing diameter 55 mm.			
	Main bearing kit	1.00		270906
	STD, For engines with 63 mm diameter main bearings.			
	Main bearing kit	1.00		271237
	U.S 0.25 mm, For engines with main bearing diameter 55 mm.			
	Main bearing kit	1.00		270907
	U.S 0.25 mm, For engines with 63 mm diameter main bearings.			
	Main bearing kit	1.00		271238
	U.S 0.50 mm, For engines with main bearing diameter 55 mm.			
	Main bearing kit	1.00	OP	270908
	U.S 0.50 mm, For engines with 63 mm diameter main bearings.			
	• Bearing shell, upper	5.00	KN	
	• Bearing shell, lower	5.00	KN	
15a	Thrust washer kit	1.00		270471
	STD, For engines with main bearing diameter 55 mm.			
	Thrust washer kit	1.00		270472
	O.S 0.1 mm, For engines with main bearing diameter 55 mm.			
	• Thrust washer, rear	1.00	KN	
	• Thrust washer, front	1.00	KN	
16	Locating plate, rear (1357620)	1.00		3531184
17	Pulley -1992	1.00		1336927
	Pulley 1993-	1.00		9135271
18	Locating plate, front	1.00		1357621
19	Oscillation damper (1336821), Not included in complete cylinder block.	1.00		9135194
20	Washer Not included in complete cylinder block.	1.00		1336822
21	Hexagon screw Not included in complete cylinder block.	1.00		963319
22	Sealing flange	1.00		8250102
23	Sealing ring (6842093)(3514312)	1.00		6842160
24	Gasket	1.00		1378492
25	Flange screw	6.00		982757
26	Ball bearing MAN.TRANS	1.00		181799
27	Retaining ring	1.00		191848
28	Flywheel, light MAN.TRANS, , B200K TRANS M45, Not included in complete cylinder block.	1.00		1336119
	Flywheel, heavy MAN.TRANS, , B200K TRANS M47., , B200E, B230E,, , B230F 1289186,1289188, Not included in complete cylinder block.	1.00	OP	1317359

		Flywheel MAN.TRANS, , B200F, B230FD,, , B230F 1289254, 1289256, , 1289368., Not included in complete cylinder block.	1.00		1378112
	29	• Gear ring (1326333)	1.00		6842185
	30	• Pin	3.00		950543
	31	• Pin	2.00		1332078
	32	• Pin FOR 1317359-6	1.00		1332078
	33	Hexagon screw Not included in complete cylinder block.	8.00		946379
	34	Flexplate AUTO.TRANS, , B200E, B230E,, , B230F 1289187,1289189, , REPL 1PCS 6842013-2., Not included in complete cylinder block.	1.00		1326336
	35	• Pin	2.00	NS	
	36	Guide bushing AUTO.TRANS, Not included in complete cylinder block.	1.00		1336913
	37	Support plate -1992. AUTO.TRANS, Not included in complete cylinder block.	1.00		463087
	38	Flange AUTO.TRANS, Not included in complete cylinder block.	1.00		463088
	39	Hexagon screw AUTO.TRANS, Not included in complete cylinder block.	8.00		946379

28/7/2015

PRINT

21 : Engine with fittings B200

240, 1992, B200F, M47, L.H.D, YV1245273N1918729, 918729

28/7/2015



PRINT

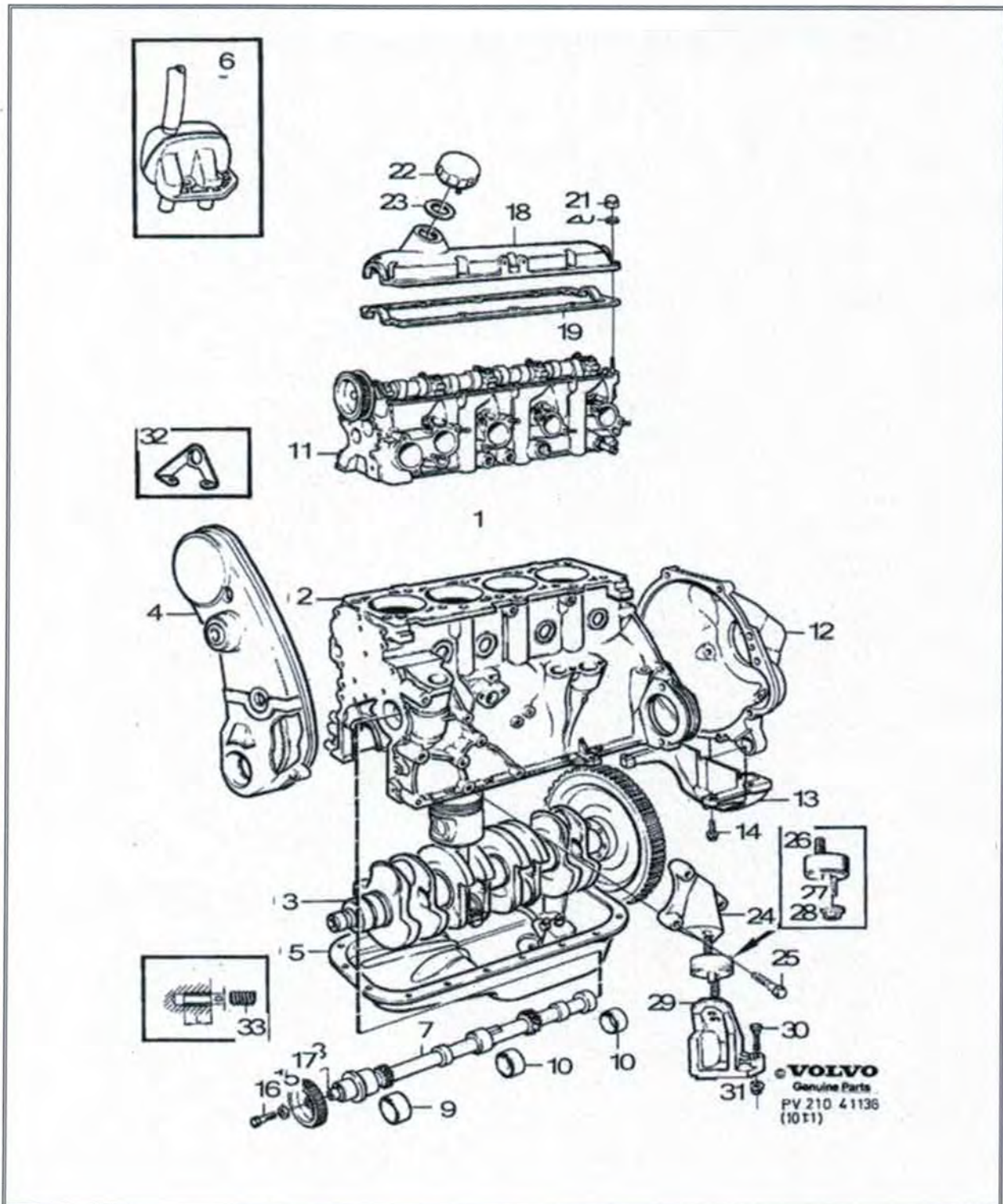


Fig.	Description	Qty.	PS	Part number
■ 1	Cylinder block, complete B200K	1.00	OP	1277669

		Cylinder block, complete B200E, B200F	1.00	OP	1277668
	2	• engine block Engine block B200	1.00		
		• engine block Engine block B230	1.00		
	3	• crank mechanism Crank mechanism B200	1.00		
		• crank mechanism Crank mechanism B230E, B230F, B230FD	1.00		
		• crank mechanism Crank mechanism B230K	1.00		
	4	• belt transmission Belt transmission B200, B230	1.00		
	5	• Lubricating system Lubricating system B200, B230	1.00		
	6	• crankcase ventilation Inlet system exhaust system	1.00		
	7	• Countershaft	1.00		463581
	8	•• Spring pin	1.00		949433
	9	• Bearing bushing Engine block B200	1.00		
		• Bearing bushing Engine block B230	1.00		
	10	• Bearing bushing Engine block B200	2.00		
		• Bearing bushing Engine block B230	2.00		
	11	cylinder head Cylinder head B200E, B200F, B200K	1.00		
		cylinder head Cylinder head B230E, B230F, B230FX	1.00		
		cylinder head Cylinder head B230K	1.00		
		cylinder head Cylinder head B230FD	1.00		
	12	clutch housing Gearbox	1.00		
	13	Bracket (463830)	1.00		9146354
	14	Flange screw	4.00		982817
	15	Washer	1.00		463580
	16	Hexagon screw (955322)	1.00		987002
	17	Pulley -1992. (1219322)	1.00		3514089
		Pulley 1993-	1.00		3507751
	18	Valve cover (1336754)	1.00		3514361
	19	Gasket	1.00	IK	1378870
	20	Spring washer	8.00		986652
	21	Cap nut	10.00		948685
	22	Filler cap (1275403)(3547599)	1.00		8692888
	23	Gasket	1.00	IK	940096

24	Engine anchorage, L.H.	1.00		1205999
	Engine anchorage, R.H.	1.00		1206213
25	Flange screw LG 35 mm, L.H., , EXC B200K	2.00		982797
	Flange screw LG 30 mm, L.H., , EXC B200K	1.00		985188
	Flange screw LG 30 mm, L.H., , B200K	3.00		985188
	Flange screw LG 30 mm, R.H.	3.00		985188
26	Rubber cushion kit L.H.	1.00		274110
	Rubber cushion kit R.H.	1.00		274111
27	* Rubber cushion	2.00	KN	
28	* Flange lock nut (949279)	4.00		987891
29	Bracket, L.H.	1.00		1229173
	Bracket, R.H.	1.00		1229171
30	* Screw	6.00	NS	
31	Flange lock nut M10x13.4, , (971089), , (985869)(971098)	6.00		987891
32	Lifting eye, L.H., rear B200, B230E	1.00		463850
	Lifting eye, L.H., front	1.00		463849
	Lifting eye, R.H.	1.00	NS	
33	Thread insert M6x1x9	x		956014
	Thread insert M8x1.25x12	x		956018
	Thread insert M10x1.5x15	x		956022
	Thread insert M12x1.5x24	x		948095
	Thread insert M14x1.25x12	x		948756
	Thread insert M14x1.5x12	x		948758
	gasket kits Gasket kits B200E/F	1.00		
	gasket kits Gasket kits B200K	1.00		
	gasket kits Gasket kits B230E/F/FD/FX	1.00		
	gasket kits Gasket kits B230K	1.00		

28/7/2015

PRINT