

SECOND PRINTING (3-79)

Includes all information as published in First Printing. Also includes updated and/or revisional information which has not been previously published.

12G-B

crawler loader
and
Steel Mill Special
(Includes 11R Ripper)

parts catalog

S/N 96Y02001 - UP

S/N 55M02001 - UP

Form 73107140 English

(REPLACES 70680533)



WARNING

STUDY THE OPERATION AND MAINTENANCE
INSTRUCTION MANUAL THROUGH BEFORE STARTING,
OPERATING, MAINTAINING, FUELING OR SERVICING THIS
MACHINE.

PUBLICATIONS AVAILABLE
FOR
MODEL 12G-B
CRAWLER LOADER AND STEEL MILL SPECIAL
(See NOTE below)

<u>DESCRIPTION</u>	<u>SERIAL NO.</u>	<u>FORM NO.</u>			
		ENGLISH	ESPAÑOL (Spanish)	PORTUGUÊS (Portuguese)	FRANÇAIS (French)
PARTS CATALOGS					
Crawler Loader	All	73107140			
Injection Pump					
Robert Bosch	All	70698576			
Roosa Master	All	70685399			
OPERATORS MANUAL					
12G-B	All	70680534	70681714		70683858
SERVICE MANUALS					
Electrical System	All	70699657			70688844
Engine	All	70645121	70650410	70650411	70650412
Final Drives	All	70684604	70686636		
Injection Nozzles and Holders	All	70682797			
Injection Pump					
Robert Bosch	All	70681649			
Roosa Master	All	73111954			
Loader Linkage and Hydraulic System	All	70671114	70686638		70693062
Steering Clutches and Brakes	All	70659189	70686635		70693063
Engine Clutch Torque Converter, Transmission, Bevel Gear and Drive Shaft U-Joint	All	70683234	70683174		70693061
Turbocharger	All	70677064	70678570	70679482	70678727
Undercarriage	All	70686297	70686637		70693064

NOTICE

SEE CONSTRUCTION MACHINERY TECHNICAL PUBLICATIONS
INDEX (FORM 70658800) FOR ALL AVAILABLE PUBLICATIONS.

PUBLICATIONS INDEX (FORM 70658800) IS AVAILABLE FREE
FROM YOUR DEALER.

(Revised March 1979)

IMPORTANT

All parts listed herein, which have no specific usage indicated, are applicable to all models. Those parts which are used only on specific models are so indicated.

Attaching parts such as bolts, nuts, rivets, screws, washers, etc., are indented immediately following the parts which they attach.

Parts indicated with a square (□) are also available in packaged sets. Refer to section titled "PACKAGED PARTS".

The terms "right" and "left" used throughout this parts catalog are determined by facing the direction of forward travel.

INSTRUCTIONS FOR ORDERING PARTS

At the time this parts catalog was published, the listed part numbers were current. It is our policy to constantly improve our machines and therefore, part numbers and design may change. When ordering parts, verify part numbers through your dealer's Microfiche which is up to date with all latest part numbers.

Order parts from the dealer covering the local territory.

ALWAYS GIVE THE MODEL AND SERIAL NUMBER OF MACHINE. IF PARTS ARE FOR AN ASSEMBLY WHICH HAS A MODEL AND/OR SERIAL NUMBER (SUCH AS ENGINE ASSEMBLY, PUMP ASSEMBLY), ALSO INCLUDE THIS INFORMATION.

To obtain parts promptly, give part name and part number.

Give post office address, town, county and state where parts are to be shipped. Also specify whether material is to be shipped by freight, express or parcel post.

Confirm all telephone or telegraph orders in writing.

Parts for standard motor accessories such as generators and starting motors should be ordered from authorized Service Stations maintained by manufacturers of these units throughout the country.

No credit will be allowed on parts unless they are returned to the dealer from whom they were purchased; from there they will be returned, at the customer's expense, to the factory for inspection.

Unless claims for shortages or errors are made immediately upon receipt of goods, they will not be considered.

When broken goods are received, a full description of the damage should be made by the carrier agent on the freight bill. If this description is insisted upon, full damage can always be collected from the transportation company.

No responsibility is assumed for delay or damage to merchandise while in transit. Our responsibility ceases upon delivery of shipment to the transportation company from whom a receipt is received showing that shipment was in good condition when delivered to them; therefore, claims (if any) should be filed with the transportation company.

The right is reserved to change the construction or material of any parts where it seems desirable to do so without incurring the obligation of installing such changes on units already delivered.

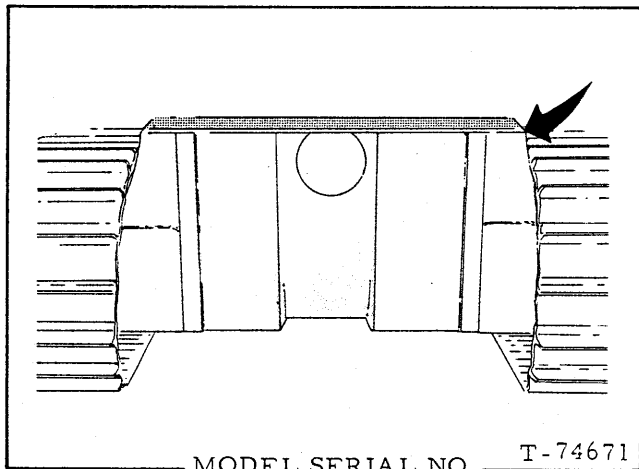
(Specifications and design subject to change without notice)

MODEL IDENTIFICATION

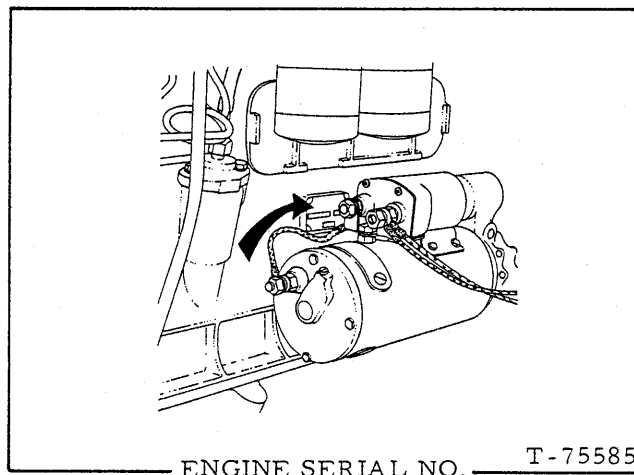
MODEL SYMBOL	ENGINE MODEL	DESCRIPTION
12G	11000 11000 MK II (S/N 11-25944 and up)	Diesel engine driven crawler loader with power-shift transmission, 42 link track
12GS	11000 11000 MK II (S/N 11-25944 and up)	Diesel engine driven crawler loader with power-shift transmission, 42 link track

RECORD YOUR SERIAL NUMBERS BELOW

MODEL SERIAL NUMBER _____ ENGINE SERIAL NUMBER _____



Also stamped on small plate attached to front of filter box.



Also stamped on small plate attached to front of filter box.

MODEL SERIAL NUMBER

Models are identified by an 8-character combination of letters and numerals.

***SERIAL NUMBER**, consisting of all 8 characters must always be submitted for positive identification of your machine. This Point Cannot Be Over-emphasized.

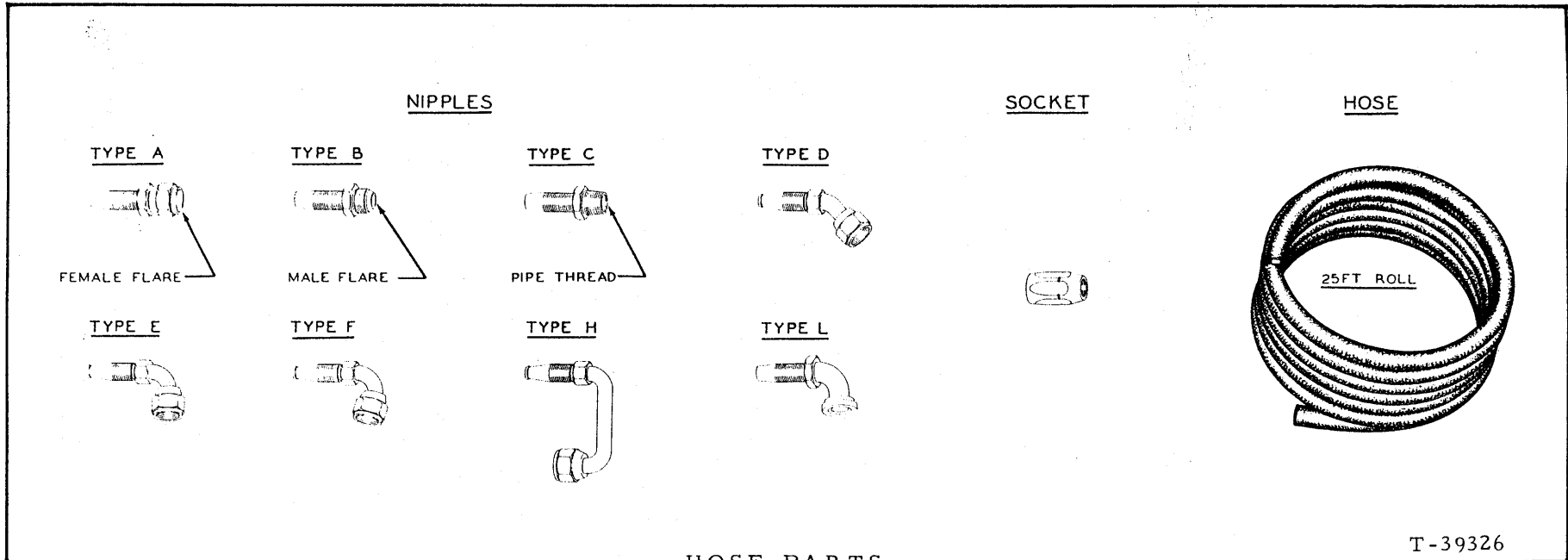
CRAWLER MODEL	*SERIAL NO.	
	PRODUCT CODE	UNIT NO.
12G	9 6 Y	0 2 0 0 1
12GS	5 5 M	0 2 0 0 1

ALPHABETICAL INDEX

Air Cleaner Mounting	68	Engine Shut-off Control	67
Air Restriction Indicator	68	Engine Hood	197
Alternator	222	Engine and Mounting	11
Automatic Bucket Controls	287,290	Exhaust Pipe	73,197
Batteries and Cables	220	Fans	98
Belt, Drive	98,222	Fan Belt	98
Bevel Gear and Shaft	145	Fan Drive	96
Boom Piping	296	Filter Box	198
Brake Control	172	Filters	
Brake Drum	150	Coolant	91,92
Brakes	168	Engine Oil	39,40
Bucket	244,247	Fuel	45
Bucket Control Valve	263	Steering	166
Bucket Controls	284	Transmission	135
Bucket Hydraulic Pump Lines	251,255	Water Separator (fuel oil)	49
Bucket Hydraulics	298	Final Drive	
Bucket Level Indicator	295	Housing	146
Bucket Linkage	248	Intermediate Shaft	148
Bucket Position Indicator	301	Pinion Shaft	150
Cab	242	Onboard Bearing and Seal	149
Camshaft	24	Sprocket, Shaft and Gear	155
Camshaft Bearings	12	Floor	201
Connecting Rod	16	Flywheel	20
Counterweight	238	Flywheel Housing	20
Crankcase Guard	175	Fuel Lines	42
Crankshaft	18	Fuel Tank	42
Cylinder Block	12	Fuel Tank Guard	44
Cylinder Head	22	Gauges	
Cylinder Sleeve	12	Air Restriction Indicator	68
Cylinders		Ammeter	228
Clam	298	Bevel Gear Compartment	
Dump	278	Oil Level	146
Lift	276	Engine Oil Level	28
Ripper	310	Engine Oil Pressure	232
Drawbar	200	Engine Temperature	228
Dump Cylinder Piping	280	Fuel Level	42
Elements		Fuel Pressure	233
Air Cleaner	70	Hour Meter	234
Bucket Hydraulic Tank	263	Hydraulic Tank Oil Level	263
Coolant Filter	91,92	Transmission Oil Level	146
Engine Oil	39,40	Transmission Pressure	231
Fuel Filter	45	Head Lights	224
Steering Oil Filter	166	Heat Exchangers	100
Steering Oil Strainer	167	Hood	197
Transmission Breather	123	Hood Side Plates	197
Transmission Filter	135	Hose Parts	6
Engine Breather	15	Hour Meter	234,235
Engine Clutch	112	Hydraulic Tank	263
Engine Clutch Control	106	Hydraulic Track Adjuster	181
		Injection Fuel Return Lines	59,61
		Injection Nozzles and Lines	55,57
		Injection Pump	51,52
		Instruments	228

ALPHABETICAL INDEX

Lift Cylinder Piping	274	Starter	223
Lights		Steering Clutch & Final Drive Housing .	146
Dash	228	Steering Clutches	152
Head	224	Steering Control	171
Rear Flood	226, 227	Steering Pump and Filter Lines	163
Main Bearings	18	Steering Valve Lines	161
Main Frame	175	Switch	
Main Housing	146	Light	228
Main Wiring	213 thru 219	Master	220
Manifolds		Safety	143
Exhaust	72	Starter	228
Intake	71	Thermostat	102
Radiator Inlet and Outlet	88	Throttle Control	65
Water Outlet	102	Timing Gear Housing	27
Master Switch	220	Timing Gears	18 thru 52
Numerical Index	311	Tool Bar and Linkage	305
Oil Cooler	100	Torque Converter Lines	116
Oil Filler Tube	31	Track	188
Oil Pan	28	Track Carrier Roller	193
Oil Pump	33	Track Frame	176
Packaged Parts	8	Track Frame Guards	178
Painting and Marking	208	Track Idler	195
Piston	16	Track Release	181, 185
Primer (Engine starting)	78, 79	Track Rollers	191
Primer (Injection Pump)	48	Transmission	
Pull Hook	248	Assembly	121
Pumps		Case and Covers	123
Bucket	253 thru 258	Clutch Shafts	125
Engine Oil	33	Input Shaft	124
Fuel Injection	51, 52	Pinion	128
Primer (Engine starting)	78, 79	Transmission Guards	175
Primer (Injection Pump)	48	Transmission Oil Pump and Filter	
Steering	165	Lines	130
Transmission	133	Turbocharger	75
Water	94	Universal Joint	119
Radiator Mounting	84	Valve Operating Mechanism	24
Radiator Expansion Tank	93	Valves	
Radiator Guard	82	Bucket Control	263
Radiator Screen	82	Bucket Relief	263
Radiator Piping	88	Clutch Modulating	141
Raincap	197	Decelerator	104
Rear Fenders	198	Engine Clutch Control	106
Rear Flood Lights	226, 227	Engine Oil Pressure Regulating	12
Rear Guard	239	Engine Oil Pump Relief	33
Regulator	213	Exhaust	22
Rigid Beam	187	Front-Mounted Equipment Control	296
Ripper Cylinder Piping	308	Intake	22
Ripper Mounting Frame	303	Lift Control	272
Ripper Valve and Controls	306	Main Relief	265, 268
Roll Over Protection Frame	241	Ripper Control	306
Seat	203	Speed Control	136
Side Dump Piping	260	Steering Control	157, 158
Speed Control Linkage	143	Transmission Pressure Relief	134
Speed Control Piping	139	Vandalism Prevention Parts	237
Speed Control Valves	136	Water Outlet Manifold	102
		Water Pump	94
		Water Separator	49



NOTE: Refer to right hand column for identity of interchangeable crimped-type hose (fittings not re-usable). Assembly number shown in left hand column indicates available replacement hose assembly with re-usable components; where no assembly number is listed, hose assembly is not available from factory but may be constructed in the field from data indicated.

HOSE ASSEMBLY NO. (See NOTE)	BULK HOSE (25' roll)	HOSE LENGTH (inches)	NIPPLE (#1 end)			NIPPLE (#2 end)			SOCKET (both ends)	NIPPLE FLANGE		CRIMPED-TYPE HOSE (See NOTE)
			Including SOCKET	NIPPLE only	Type	Including SOCKET	NIPPLE only	Type		Part No.	X Dim	
	70919218	6-3/4	70920850	70920303	A	70920880	70919254	D	70919076			70641125
	70919217	63-1/4	70920849	70920302	A	70920864	70919082	E	70919075			70642485
	70919196	56-3/4	70920847	70920301	A	70920847	70920301	A	70919143			70646198
	70919155	52-3/4	70920849	70920302	A	70920864	70919082	E	70919075			70650862
	70920794	7	70921020	70922830	A		70923279	E	70920972			70654779
	70919156	8-1/2	70920858	70919080	B	70920865	70919081	E	70919076			70655072
	70919196	28	70920855	70919144	B	70920862	70919194	E	70919143			70655390
	70919196	35	70920855	70919144	B	70920862	70919194	E	70919143			70655404
	70919156	7-3/4	70920850	70920303	A	70920858	70919080	B	70919076			70655778

70920221	7-1/4	70920860	70919279	B	70920860	70919279	B	70919281	70656237
70919155	7-1/4	70920857	70919079	B	70920864	70919082	E	70919075	70656239
70920222	8-1/2	70922808	70923011	B	70922808	70923011	B	70919282	70656246
70919474	6-3/4	70920859	70923867	B	70920859	70923867	B	70919469	70656283
70920795	25-7/8	70920945	70922831	A	70920945	70922831	A	70920973	70656296
70919156	9	70920858	70919080	B	70920858	70919080	B	70919076	70656403
70919155	9-1/4	70920857	70919079	B	70920857	70919079	B	70919075	70656542
70920794	24	70920944	70920978	A	70920944	70920978	A	70920972	70663459
70920222	30	70921033	70921034	A	70920868	70920144	E	70919282	70668167
70920222	25-3/4	70921033	70921034	A	70920798	70921495	D	70919282	70668169
70919156	13	70920850	70920303	A	70920880	70919254	D	70919076	70670283
70919156	15	70920850	70920303	A	70920865	70919081	E	70919076	70670284
70920221	12-1/2	70920867	70919277	E short	70920874	70921042	E long	70919281	70670309
70919196	38	70920847	70920301	A	70920847	70920301	A	70919143	70675452
70920795	30	70920945	70922831	A	70921855	70923263	L	70920973	70676574
70920794	17	70920934	70922833	B		70923279	E	70920972	70676798
70920793	48-1/4	70920942	70921562	A	70920926	70920968	B	70920971	70683556
70920793	52-1/4	70920942	70921562	A	70920926	70920968	B	70920971	70684690
70919156	15-1/2	70920850	70920303	A	70920880	70919254	D	70919076	70692438
70919218	31-3/4	70920838	70919074	C	70920865	70919081	E	70919076	70696505
70919196	56-1/8	70920847	70920301	A	70920847	70920301	A	70919143	77553507
70920794	43-1/8	70921020	70920830	A	70921020	70922830	A	70920972	70680379
70920794	36-3/4	70921020	70920830	A	70921020	70922830	A	70920972	70680380

PACKAGED PARTS

PACKAGE NO.	DESCRIPTION
74321984	GASKET KIT, cylinder head
4	70923574 O-RING, water by-pass tube
4	70923813 O-RING, water manifold tube
1	74300145 GASKET, water outlet elbow
1	74321437 GASKET ASSY., front cylinder head
1	74321438 GASKET ASSY., rear cylinder head
2	74321981 GASKET, rocker cover
4	74336182 GASKET, water manifold
1	74336263 GASKET, thermostat housing
1	74336266 GASKET, water elbow (Discard)
2	74337764 GASKET, valve lifter cover
2	74348133 GASKET, breather tube (Discard)
6	74376749 WASHER, sealing, rocker cover nut
12	74359741 GASKET, intake and exhaust manifold
6	74378031 GASKET, injection nozzle
74358696	GASKET KIT, intermediate, cylinder block
2	70923376 O-RING, flywheel housing dowel
4	70923574 O-RING, heat exchange tubes
2	70923813 O-RING, heat exchanger elbows
1	70923816 O-RING, flywheel to crankshaft
1	70923820 O-RING, injection pump drive cover
1	70924139 O-RING, injection pump mounting cover
1	74335056 GASKET, water pump volute
1	74336676 GASKET, timing hole cover
1	74336897 RING, sealing, flywheel housing to crankcase
1	74339118 GASKET, oil filter outlet flange
1	74339123 GASKET, filter interconnection
1	74339128 GASKET, filter head
1	74339150 GASKET, filter head to block
1	74339151 GASKET, oil line elbow
1	74346169 GASKET, oil pipe
1	74346456 GASKET, water inlet pipe
1	74346744 GASKET, water pump
1	74347031 GASKET, water by-pass flange
1	74348136 GASKET, timing gear housing
1	74348184 GASKET, filter head to block
1	74348185 GASKET, heat exchanger front cover
1	74348218 GASKET, oil pipe
1	74354163 GASKET, timing gear cover

PACKAGED PARTS

PACKAGE NO.	DESCRIPTION
-----	REPAIR KITS, dump and lift cylinders (See pages 276 and 278)
-----	RING KIT, transmission (See page 127)
-----	RING SET, piston (See page 16)
-----	SEAL KITS, final drive (See page 149 and 155)
-----	SEAL KIT, bucket hydraulic pump (See page 258)
-----	CONVERSION KIT, track release (Used to up-date track release on loaders prior to unit #02303)(See page 181)
70696702	GASKET KIT, transmission
	1 70623971 SEAL
	1 70624706 GASKET
	1 70628941 SEAL
	2 70629223 GASKET
	1 70638336 SEAL
	1 70642788 GASKET
	1 70643080 GASKET
	1 70643810 GASKET
	2 70648027 RING KIT
	1 70654294 GASKET
	1 70654798 GASKET
	1 70662882 GASKET
	1 70666907 GASKET
	1 70667252 GASKET
	2 70921887 O-RING
	1 70923587 O-RING
	1 70923879 O-RING
70696703	GASKET KIT, torque converter
	1 70630030 GASKET
	1 70655619 SEAL
	1 70656726 GASKET
	2 70669678 SEAL
	2 70921206 O-RING
	2 70921214 O-RING
	1 70921349 O-RING
	1 70921885 O-RING
	2 70923664 O-RING
	3 70924140 O-RING
	2 70926059 O-RING
	2 70926860 O-RING
	1 73034958 SEAL

PACKAGED PARTS

PACKAGE NO.

DESCRIPTION

74321189

ENGINE OIL PUMP KIT (Adapts integral scavenging and oil pressure pump to engines prior to serial No.11-24134)

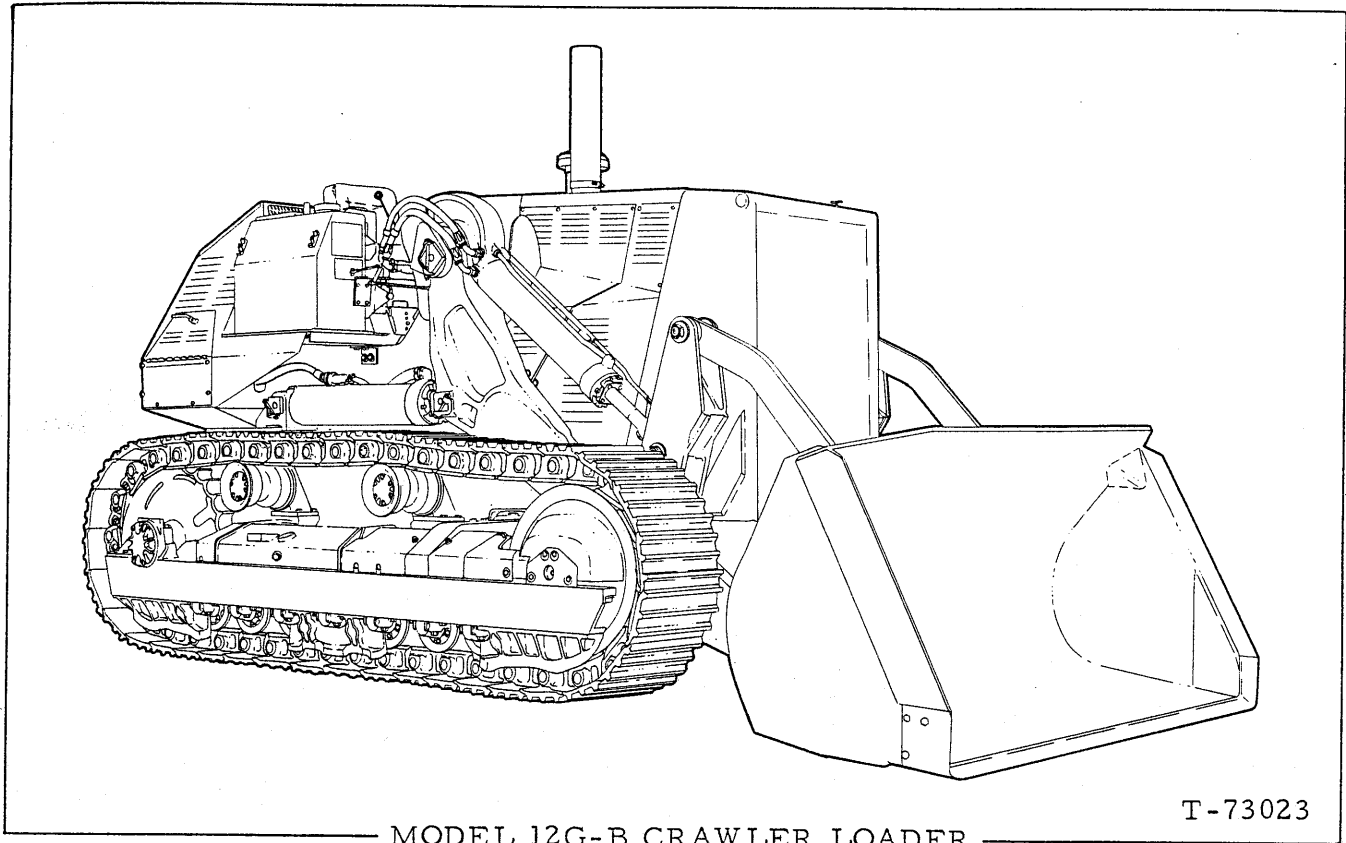
- 1 70035250 PLUG
- 1 70667252 GASKET
- 2 70904206 LOCKWASHER, 3/8"
- 2 70907863 LOCKWASHER, 7/16"
- 4 70910287 LOCKWASHER, 3/8"
- 5 70912369 WASHER
- 29 70913544 WASHER
- 22 70914847 CAPSCREW, 3/8" NC x 1-1/2"
- 4 70916271 CAPSCREW, 3/8" NC x 1"
- 4 70916279 CAPSCREW, 5/16" NC x 1-1/2"
- 8 70916543 LOCKWASHER, internal tooth, 3/8"
- 2 70916871 NUT, elastic stop, 5/8" NC
- 1 70919784 CAPSCREW, 5/16" NC x 4"
- 4 70921076 CAPSCREW, 3/8" NC x 1-1/4"
- 1 70921204 PLUG, 1-1/16" straight-thd.
(Includes O-RING)
- 2 70921565 CAPSCREW, 3/8" NC x 1-1/2"
- 8 70923193 CAPSCREW, 3/8" NF x 1-1/4"
- 2 70928212 NUT, 7/16" NC
- 1 70930924 O-RING
- 5 74255916 CAPSCREW, Nylon strip, 3/8" NC x 1"
- 1 74320597 VALVE ASSY., pressure relief
- 1 74320838 ELBOW
- 1 74320839 TUBE
- 1 74320885 TUBE
- 1 74320887 TUBE
- 1 74320916 GASKET
- 1 74321052 ELBOW
- 1 74321053 U-BOLT
- 1 74321671 BRACKET
- 1 74321954 PAN, oil
- 1 74321399 OIL PUMP ASSY., w/GEAR
- 1 74337740 GASKET
- 1 74337741 PLATE
- 4 74393359 GASKET
- 2 74395024 DOWEL
- 1 74321893 GASKET
- 1 OA-8673 DRAWING

PISTON AND SLEEVE KIT

74062316

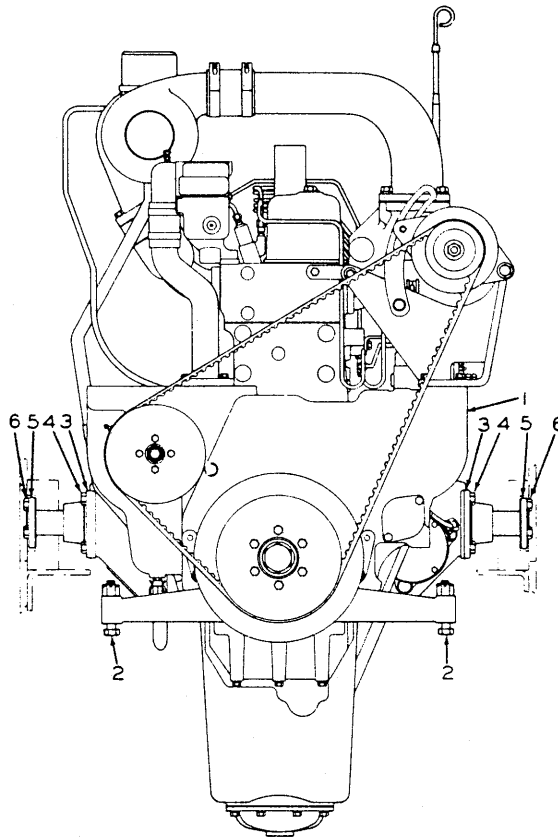
- 1 74061746 SLEEVE
- 1 74062313 PISTON

(Revised March 1979)



MODEL 12G-B CRAWLER LOADER

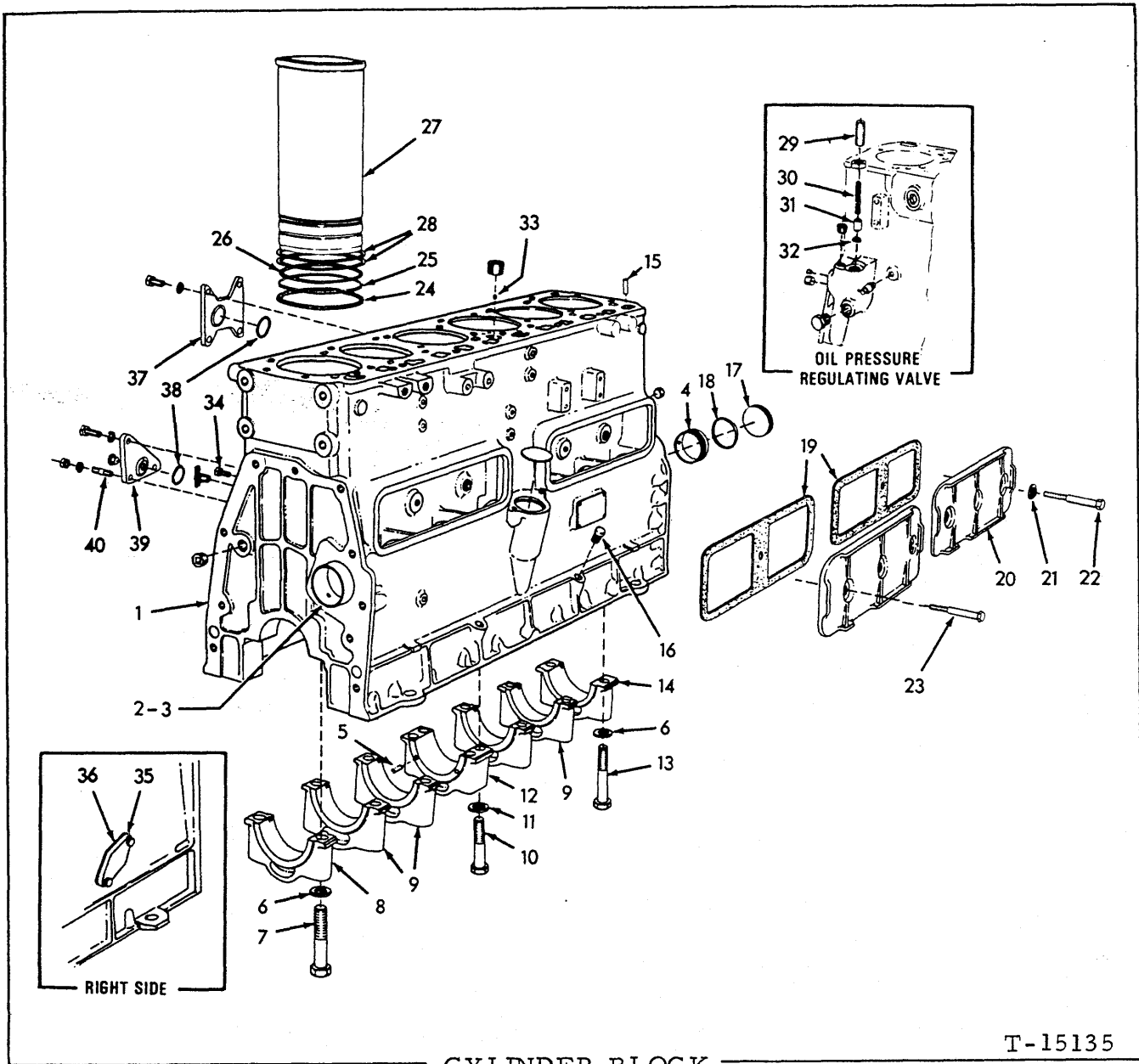
T-73023



T-76462

ENGINE AND MOUNTING

ITEM	PART NO.	QTY.	DESCRIPTION
1	74359724	1	ENGINE ASSY. ("Bosch" Injection Pump)(Effective Loader serial No. 55M02001 and 96Y02001. Engines prior to #11-24059)
	70696717	1	ENGINE ASSY. ("Roosa Master" Injection Pump) (Effective Loader serial No. 55M03212 thru 55M03395 and 96Y03212 thru 96Y03395. Engine #11-24059 thru #11-25943)
	70699807	1	ENGINE ASSY. (Effective Loader serial No. 55M03396 and 96Y03396. Engine #11-25944 and up)
NOTE: Each engine listed above includes oil and fuel filters, turbocharger, but does not include air cleaner or starter.			
2	70928685	2	CAPSCREW, front mounting (5/8"NF x 3-1/2")
	70913280	2	NUT, high, slotted, 5/8"NF
	70900806	2	PIN, cotter, 1/8" x 1"
3	70656193	2	TRUNNION, rear mounting
4	70927475	8	CAPSCREW, drilled-hd., 1/2"NC x 1-1/2"
	70023633	2	WIRE, locking, 1/16" x 12"
5	70655552	2	PIN, rear trunnion
6	70928684	6	CAPSCREW, drilled-hd., 1/2"NC x 1-3/8"
	70023633	2	WIRE, locking, 1/16" x 12"



CYLINDER BLOCK

T-15135

ITEM	PART NO.	QTY.	DESCRIPTION
1	74321963	1	BLOCK ASSY. (Includes items 2 thru 16, 32 thru 40 and hardware indented below (Engines prior to #11-24134)
	74321959	1	BLOCK ASSY. (Includes items 2 thru 16, 29 thru 33, 35, 36, 39 and hardware indented below)(Engines #11-24134 and up)(Requires piston-cooling type main bearings)
	70910017	1	PLUG, expansion, 2-3/8" diam.
	70919134	4	PLUG, pipe, hex-hd., 1/8"NPT
	70920333	1	PLUG, pipe, hex-hd., 3/8"NPT
	70918887	1	PLUG, pipe, hex-socket, 3/8"NPT
	70920416	1	PLUG, pipe, hex-hd., 1/2"NPT
	70904223	2	PLUG, pipe, hex-socket, 1/2"NPT
	70918888	1	PLUG, pipe, hex-socket, 1"NPT
	70912415	2	PLUG, pipe, hex-socket, 3/4"NPT

(Continued)

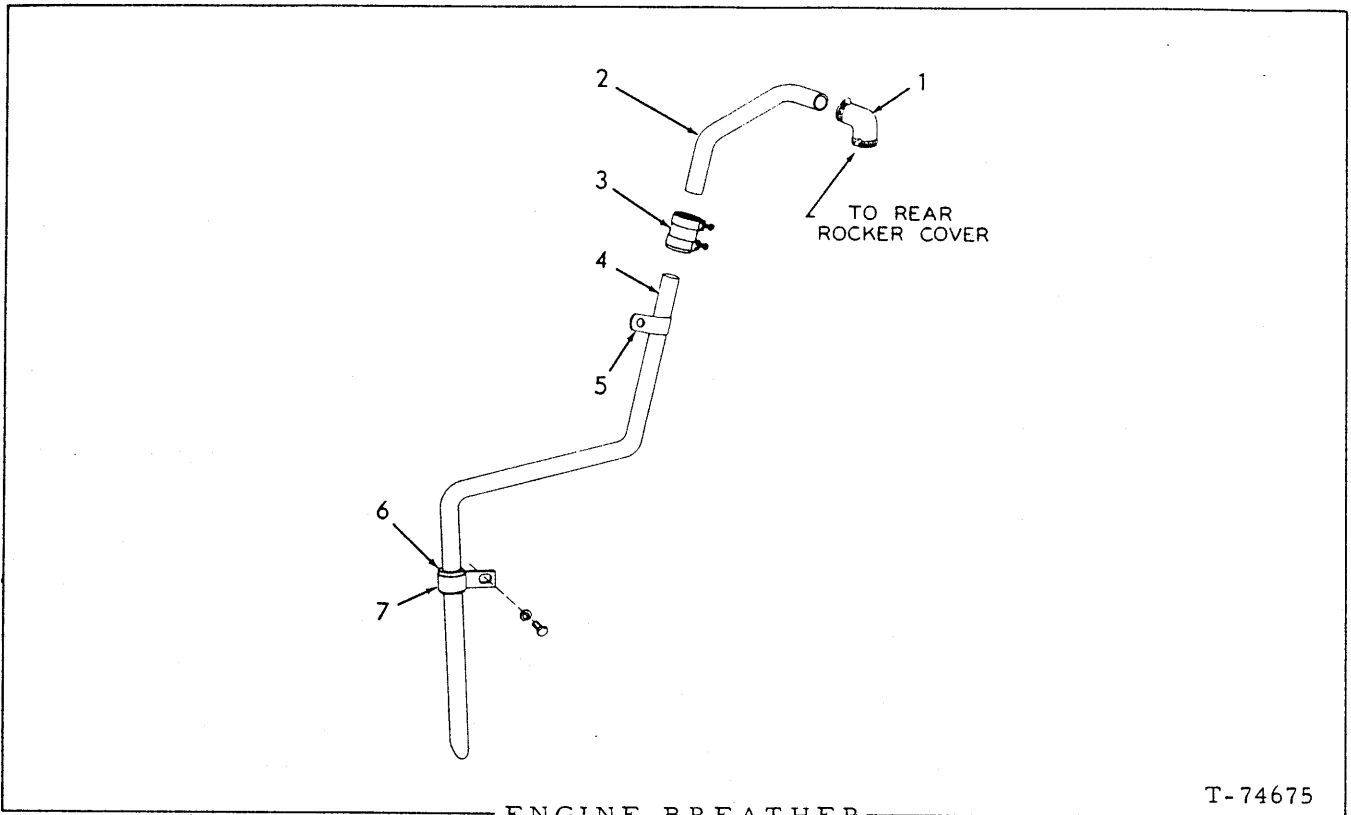
CYLINDER BLOCK (Continued)

ITEM	PART NO.	QTY.	DESCRIPTION	
2	{ 74346100	1	BEARING, camshaft, front (standard size)	
	{ 74347416	1	BEARING, camshaft, front (.010" undersize)	
3	{ 74320591	2	BEARING, camshaft, intermediate (standard size)	
	{ 74347419	2	BEARING, camshaft, intermediate (.010" undersize)	
4	{ 74320592	1	BEARING, camshaft, rear (standard size)	
	{ 74347413	1	BEARING, camshaft, rear (.010" undersize)	
5	-----	4	PIN, center main bearing cap (See page 18)	
6	74354175	12	WASHER, main bearing capscrew (Engines prior to #11-25944)	
7	74339037	2	CAPSCREW, front main bearing cap (3/4"NC x 3-15/16")	
8	74349630	1	CAP, front main bearing (See NOTE below)	
9	74349632	4	CAP, intermediate main bearing (See NOTE below)	
10	74035387	4	CAPSCREW, center main bearing cap (5/8" NC x 3-13/16")	
11	74391160	4	WASHER, center main bearing capscrew	
12	74349629	1	CAP, center main bearing (See NOTE below)	
13	74339036	10	CAPSCREW, rear and intermediate main bearing cap (3/4"NC x 4-5/16")	
14	74349631	1	CAP, rear main bearing (See NOTE below)	
15	74336432	4	PIN, dowel cylinder head	
16	74255063	1	PLUG, crankcase	
17	74335534	1	PLUG, camshaft hole	
18	70923815	1	<input type="checkbox"/> O-RING, camshaft hole plug	
19	74337764	2	<input type="checkbox"/> GASKET, valve lifter cover	
20	{ 74359668	1	COVER, valve lifter, front } First type (Cast)	
	{ 74354635	1		COVER, valve lifter, rear }
	{ 74320985	2		COVER, valve lifter, front or rear (Second type)(Stamped)
<u>NOTE:</u> Replacement bearing caps are semi-finished and must be line-bored after installing				
21	{ 74335456	3	WASHER, valve lifter cover bolt (Used with cast cover)	
	{ 74256008	6	WASHER, valve lifter cover capscrew (Used with stamped cover)	
22	{ 74335455	3	BOLT, valve lifter cover (rear)(Used with cast cover)	
	{ 70921160	3	CAPSCREW, 5/16"NC x 2-1/4" (rear)(Used with stamped cover)	
23	{ 74359683	3	BOLT, valve lifter cover (front)(Used with cast cover)	
	{ 70921160	3	CAPSCREW, 5/16"NC x 2-1/4" (front)(Used with stamped cover)	
24	74337972	6	O-RING, cylinder sleeve (bottom groove)(red)	
25	74359870	6	O-RING, cylinder sleeve (center groove)(black with blue markings)	

(Continued)

CYLINDER BLOCK (Continued)

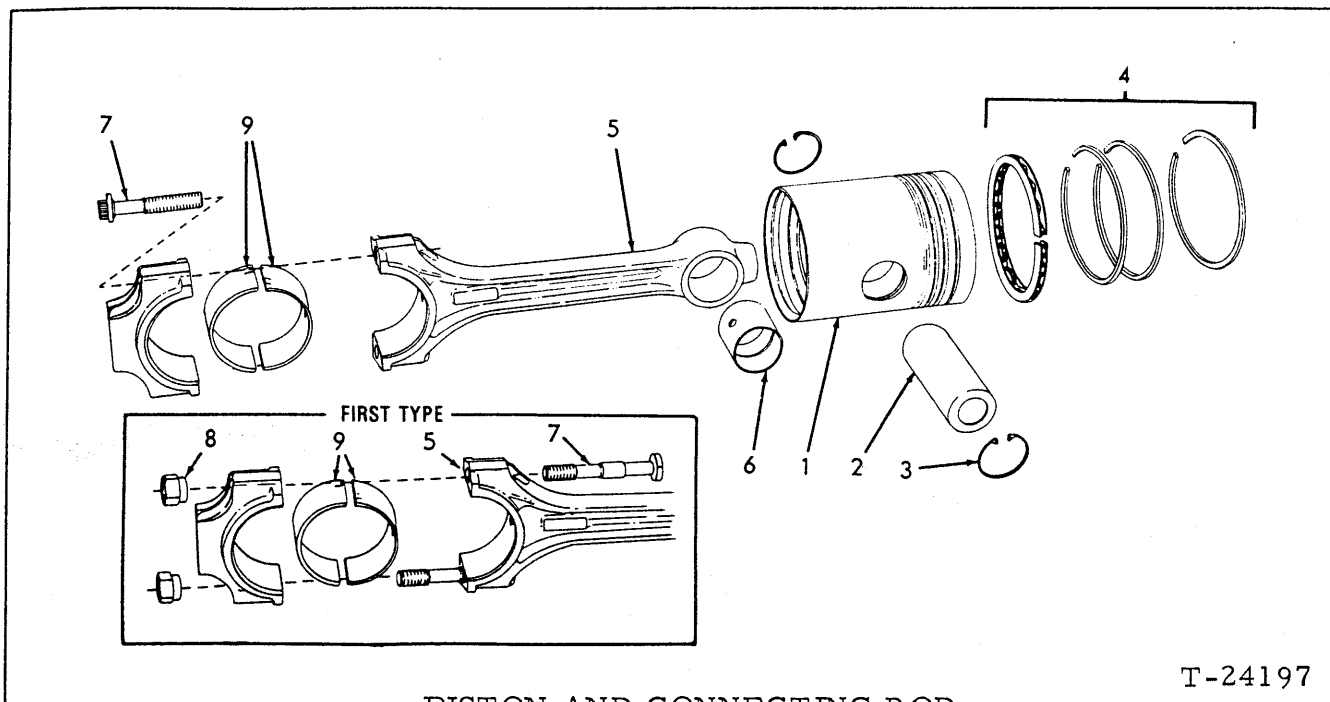
ITEM	PART NO.	QTY.	DESCRIPTION
26	74359869	6	O-RING, cylinder sleeve (top groove)(black with white markings)
27	74061746	6	□ SLEEVE ASSY. (Includes sleeve and items 24, 25 and 26)
28	74348857	-	SHIM, cylinder sleeve (.005" thick)
	74348856	-	SHIM, cylinder sleeve (.008" thick)
	74348859	-	SHIM, cylinder sleeve (.010" thick)
	74348858	-	SHIM, cylinder sleeve (.015" thick)
	74348900	-	SHIM, cylinder sleeve (.020" thick)
29	74389058	1	SCREW, oil pressure regulating valve (Engines prior to #11-25680)
	74022129	1	SCREW, oil pressure regulating valve (Engines #11-25680 and up)
	70910847	1	NUT, jam, 3/4"NF
30	74660358	1	SPRING, oil pressure regulating valve (Engines prior to #11-25680)
	74500231	1	SPRING, oil pressure regulating valve (Engines #11-25680 and up)
31	74500230	1	PISTON, oil pressure regulating valve (Engines prior to #11-25680)
	74507374	1	PISTON, oil pressure regulating valve (Engines #11-25680 and up)
32	74347465	1	INSERT, oil pressure regulating valve seat (Engines prior to #11-24251)
	74507673	1	INSERT, oil pressure regulating valve seat (Engines #11-24251 and up)
33	74347061	1	RESTRICTOR, oil passage (Engines prior to #11-24058)
34	74335777	2	CAPSCREW, crankcase pad (3/8"NC x 3/4", Nylok)
<p><u>NOTE:</u> Items 35, 36 and 39 listed below were furnished with some early service replacement cylinder blocks and are not original equipment.</p>			
35	74339604	1	PLATE, cover, turbocharger oil drain hole
	70918683	2	CAPSCREW, 1/2"NC x 1-1/8"
	70904208	2	LOCKWASHER, 1/2"
36	74336436	1	□ GASKET, cover plate
37	74335369	1	PLATE, cover, oil gallery hole, upper
	70916311	4	CAPSCREW, 1/2"NC x 1-1/4"
	70904208	4	LOCKWASHER, 1/2"
38	70923718	2	O-RING, oil gallery hole cover plates
39	74359104	1	PLATE, cover, oil gallery hole, lower
	70920333	1	PLUG, pipe, hex-hd., 3/8"NPT
	70919230	1	CAPSCREW, 1/2"NC x 1-3/8"
40	74305073	2	STUD
	70904208	3	LOCKWASHER, 1/2"
	70910195	2	NUT, 1/2"NF



T-74675

ENGINE BREATHER

ITEM	PART NO.	QTY.	DESCRIPTION
1	74357735	1	ELBOW (rubber)
	74253978	1	CLAMP, hose
	74253977	1	CLAMP, hose
2	74357733	1	TUBE, intermediate
3	74347924	1	HOSE, tube connecting
	74253453	2	CLAMP, hose
4	74338310	1	TUBE, lower
5	74254173	1	CLIP, tube supporting, upper
6	74371324	1	INSULATOR, lower tube (rubber)
7	74371323	1	CLIP, tube supporting, lower
	70915408	1	CAPSCREW, 3/8"NC x 3/4"
	70904206	1	LOCKWASHER, 3/8"



PISTON AND CONNECTING ROD

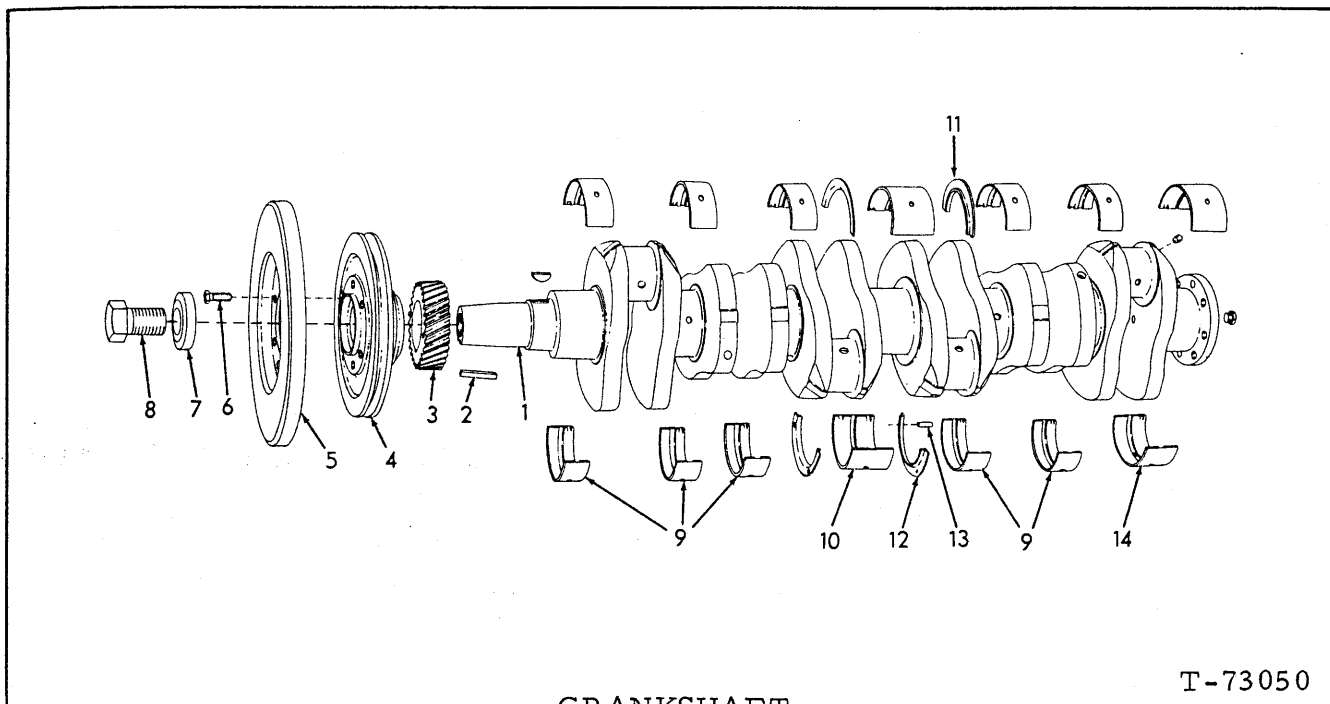
ITEM	PART NO.	QTY.	DESCRIPTION
1	74062313	6	PISTON ASSY. (Includes piston and items 2, 3, and 4)
2	74354778	6	PIN, piston
3	74255465	12	RETAINER, piston pin
4	74062311	6	RING SET
5	74354788	6	ROD ASSY., connecting (Includes items 6 thru 8) (Engines prior to #11-19497)
	74320801	6	ROD ASSY., connecting (Includes items 6 and 7) (Engines #11-19497 and up)
6	74339017	6	BUSHING, connecting rod
7	74354787	12	BOLT, connecting rod (Engines prior to #11-19497)
	74359222	12	CAPSCREW, connecting rod (Engines #11-19497 thru #11-25943)
	74321199	12	CAPSCREW, 12-pt., connecting rod (Engines #11-25944 and up)
8	74354748	12	NUT, connecting rod bolt (Engines prior to #11-19497)
9	74337701	12	BEARING, connecting rod (standard size)
	74337702	12	BEARING, connecting rod (.010" undersize)
	74337703	12	BEARING, connecting rod (.020" undersize)
	74337704	12	BEARING, connecting rod (.030" undersize)
	74337705	12	BEARING, connecting rod (.040" undersize)
	74321007	12	BEARING, connecting rod (standard size)
	74321033	12	BEARING, connecting rod (.010" undersize)
	74321034	12	BEARING, connecting rod (.020" undersize)
	74321035	12	BEARING, connecting rod (.030" undersize)
	74321036	12	BEARING, connecting rod (.040" undersize)

(Continued)

(Revised March 1979)

PISTON AND CONNECTING ROD (Continued)

ITEM	PART NO.	QTY.	DESCRIPTION	
10	74061766	1	BEARING KIT, connecting rod (Standard)	} Engines #11-25944 and up
	74061767	1	BEARING KIT, connecting rod (.010" undersize)	
	74061768	1	BEARING KIT, connecting rod (.020" undersize)	
	74061769	1	BEARING KIT, connecting rod (.030" undersize)	
	74061770	1	BEARING KIT, connecting rod (.040" undersize)	



CRANKSHAFT

T-73050

ITEM	PART NO.	QTY.	DESCRIPTION
1	74321965	1	CRANKSHAFT ASSY. (Includes plug below)
	70919840	1	PLUG, pipe, hex-hd., 1/4"NPT
2	74003490	1	KEY, crankshaft damper (Engines prior to #11-19386)
3	74359278	1	GEAR, crankshaft
	70905127	1	KEY, "B" woodruff, 5/16" x 1"
4	74354553	1	PULLEY, drive, water pump and generator
5	74354261	1	DAMPER, vibration
6	74255585	6	BOLT, attaching
7	74371503	1	WASHER, crankshaft damper
8	74393587	1	CAPSCREW, crankshaft damper
9	74337710	10	BEARING (Standard size)
	74337711	10	BEARING (.010" undersize)
	74337712	10	BEARING (.020" undersize)
	74337713	10	BEARING (.030" undersize)
	74337714	10	BEARING (.040" undersize)
	74321348	10	BEARING (Standard size)
	74321388	10	BEARING (.010" undersize)
	74321389	10	BEARING (.020" undersize)
	74321390	10	BEARING (.030" undersize)
	74321391	10	BEARING (.040" undersize)

Front and intermediate main. Engines prior to #11-25944

Front and intermediate main. Engines #11-25944 and up with piston cooling.

(Continued)