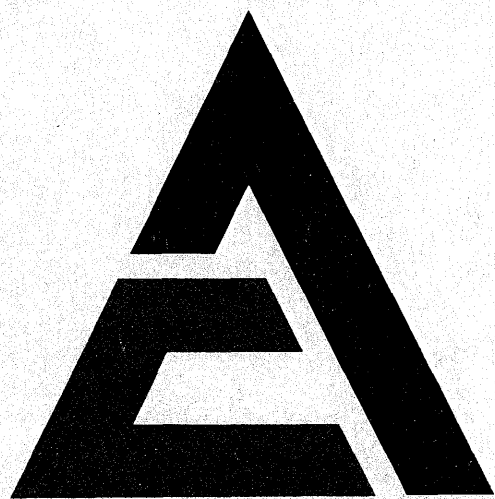


**Parts
Catalog**

**12G
CRAWLER
LOADER**

**(S/N 101 - UP)
(S/N 43C01001 - UP)**

(Includes 11R RIPPER)



ALLIS-CHALMERS

NOTICE

Allis-Chalmers Corporation and FIAT S.p.A. entered into a joint venture agreement to combine their manufacture, sale and service of construction machinery products throughout the world after January 1, 1974.

In view of the new enterprise, wherever in this publication reference is made to Allis-Chalmers or your Allis-Chalmers dealer, such reference is intended to identify FIAT-ALLIS Construction Machinery Inc. or your FIAT-ALLIS dealer.

**CONSTRUCTION MACHINERY DIVISION
SPRINGFIELD, ILLINOIS 62708 U. S. A.**

**FORM 0683934 - 4
REPLACES 0667913 - 8**

AVOID ACCIDENTS

Most accidents, whether they occur in industry, on the farm, at home or on the highway, are caused by the failure of some individual to follow simple and fundamental safety rules or precautions. For this reason **MOST ACCIDENTS CAN BE PREVENTED** by recognizing the real cause and doing something about it before the accident occurs.

Regardless of the care used in the design and construction of any type of equipment there are many conditions that cannot be completely safeguarded against without interfering with reasonable accessibility and efficient operation.

A careful operator is the best insurance against an accident.
The complete observance of one simple rule would prevent many thousand serious injuries each year.
That rule is:

Never attempt to clean, oil or adjust a machine while it is in motion.

NATIONAL SAFETY COUNCIL

WARNING

On machines having hydraulically, mechanically, and/or cable controlled equipment (such as shovels, loaders, dozers, scrapers, etc.) be certain the equipment is lowered to the ground before servicing, adjusting and/or repairing. If it is necessary to have the hydraulically, mechanically, and/or cable controlled equipment partially or fully raised to gain access to certain items, be sure the equipment is suitably supported by means other than the hydraulic lift cylinders, cable and/or mechanical devices used for controlling the equipment.

PUBLICATIONS AVAILABLE
FOR
MODEL 12G CRAWLER LOADER

<u>DESCRIPTION</u>	<u>SERIAL NO.</u>	<u>FORM NO.</u>		
		ENGLISH	ESPAÑOL (Spanish)	PORTUGUÊS (Portuguese)
<u>Parts Catalogs</u>				
Crawler Loader All	0683934-4			
Injection Pump (Roosa Master). All	0645323-7			
<u>Operator Manuals</u>				
12G (Loaders prior to s/n 1000)	0656801-8	0665289-5		
12G (Loader s/n 43C01001 and up)	0671726-8			
<u>Service Manuals</u>				
Engine (10000 & 11000) . . . All	0645121-5	0650410-4	0650411-2	0650412-0
Turbocharger All	0677064-8	0678570-3	0679482-0	0678727-9
Fuel Injection Pump (Roosa Master). All	0656820-8			
Fuel Injection Nozzles . . . All	0682797-6			
Engine Clutch, Torque Con- verter, Transmission, Bevel Gear and Drive Shaft U-Joint. All	0656803-4			
Steering Clutches and Brakes All	0659189-5			
Final Drives All	0659393-3			
Undercarriage. All	0659188-7			
Loader Linkage and Hydrau- lic System All	0671114-7			
Electrical System. All	0680006-4			

NOTICE

CONSULT ALLIS-CHALMERS CONSTRUCTION MACHINERY
DEALER FOR PUBLICATIONS.

SEE CONSTRUCTION MACHINERY TECHNICAL PUBLICATIONS
INDEX (FORM 0658800-8) FOR ALL AVAILABLE PUBLICATIONS.

PUBLICATIONS INDEX (FORM 0658800-8) IS AVAILABLE FREE
FROM YOUR DEALER.

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

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 and not with Allis-Chalmers.

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.

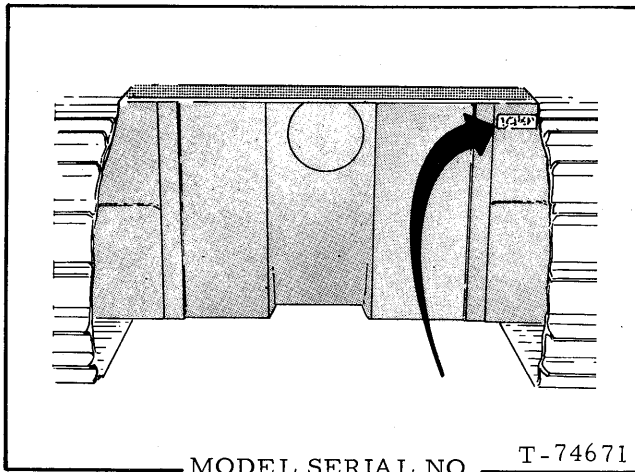
The information contained herein is general in nature and is not intended for specific application purposes. Allis-Chalmers reserves the right to make changes in specifications shown herein or add improvements at any time without notice or obligation.

MODEL IDENTIFICATION

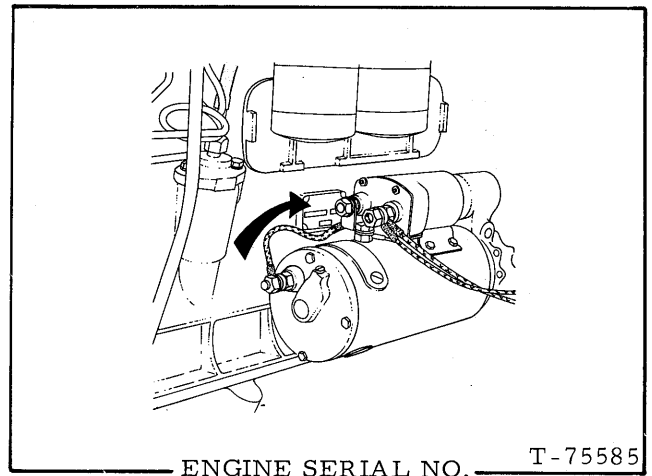
MODEL SYMBOL	ENGINE MODEL	DESCRIPTION
12G	11000	Diesel engine driven crawler loader with power-shift transmission, 42 link track

RECORD YOUR SERIAL NUMBERS BELOW

MODEL SERIAL NUMBER _____ ENGINE SERIAL NUMBER _____



Also stamped vertically along rear edge on right side of main housing and on small plate attached to front of filter box.



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

MODEL SERIAL NUMBER

NOTE: Effective in 1969, the model serial numbering system was changed. Under the prior system, models were numbered consecutively in numerals only. Thereafter, 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 overemphasized.

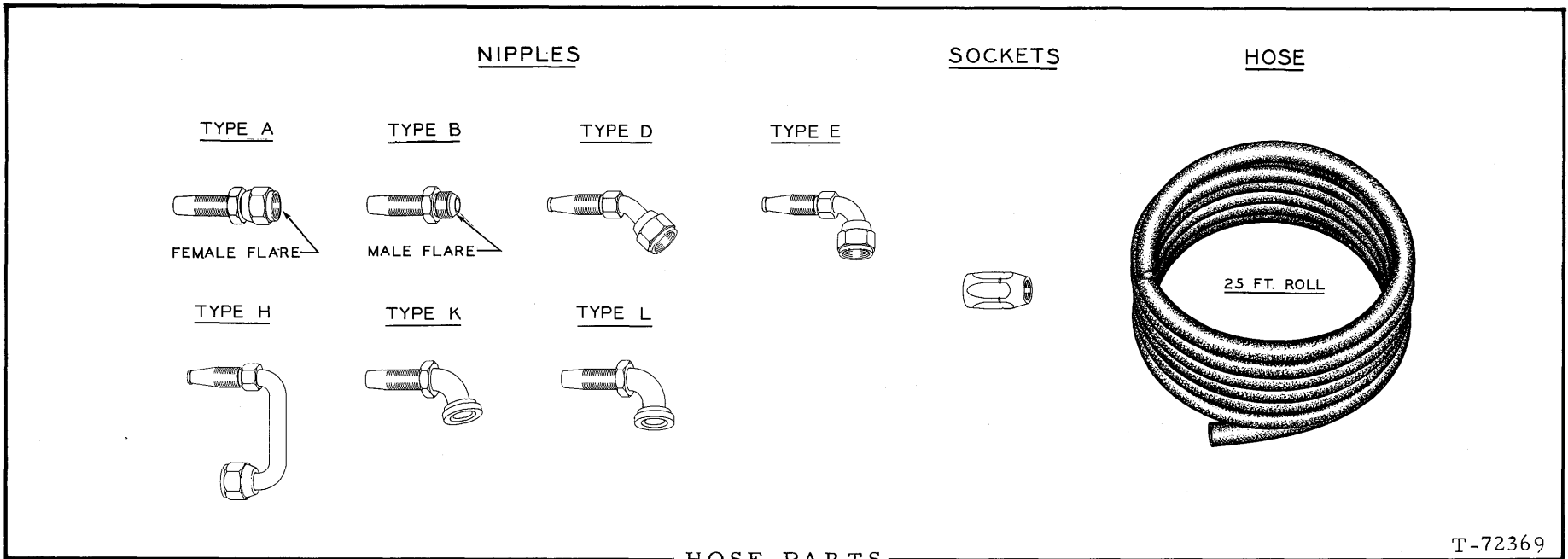
CRAWLER MODEL	*SERIAL NO.	
	PRODUCT CODE	UNIT NO.
12G	4 3 C	0 1 0 0 1

ALPHABETICAL INDEX

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Bucket Position Indicator	293	Sprocket, Shaft and Gear	145
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Cylinder Head	25	Air Restriction Indicator	58
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Speed Control Piping	133	Vandalism Prevention Parts	229
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Steering Clutch & Final Drive Housing	135		



HOSE PARTS

T-72369

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) Part No.
			Including SOCKET	NIPPLE only	Type	Including SOCKET	NIPPLE only	Type		Part No.	X Dim	
4357430-0	0920388-6	12-3/4		0920806-7	A		0920806-7	A				
	0919218-8	6-3/4	0920850-5	0920303-5	A	0920880-2	0919254-3	D	0919076-0			0641125-0
	0919217-0	63-1/4	0920849-7	0920302-7	A	0920864-6	0919082-8	E	0919075-2			0642485-7
	0919196-6	56-3/4	0920847-1	0920301-9	A	0920847-1	0920301-9	A	0919143-8			0646198-2
	0919155-2	52-3/4	0920849-7	0920302-7	A	0920864-6	0919082-8	E	0919075-2			0650862-6
	0920794-5	21-1/4	0921020-4	0922830-5	A	0921020-4	0922830-5	A	0920972-7			0654778-0
	0920794-5	7	0921020-4	0922830-5	A		0923279-4	E	0920972-7			0654779-8
	0919156-0	7	0920858-8	0919080-2	B	0920865-3	0919081-0	E	0919076-0			0655072-7
	0920794-5	28		0923279-4	E		0923279-4	E	0920972-7			0655316-9

PACKAGED PARTS

PACKAGE
NUMBER

DESCRIPTION

0676107-6 CONVERSION KIT, dump and lift cylinders (See pages 263 and 277)

0676107-6 CONVERTER KIT, torque (For updating torque converter on loaders
 #101 thru #509)

1	0655619-5	SEAL, oil, fan drive
2	0656701-0	PLATE, thrust, guide wheel
3	0656717-6	GASKET, pump adapting plate
1	0656726-7	GASKET, bearing retainer
1	0657964-3	EXPANDER, piston outer ring
1	0657965-0	EXPANDER, piston inner ring
1	0657973-4	RING, piston, outer (teflon, split)
1	0657974-2	RING, piston, inner (teflon)
1	0658953-5	PIN, spacing plate
1	0663526-2	RING, piston, outer (teflon, not split)
2	0668279-3	WASHER, carrier retaining
1	0668281-9	CARRIER, sealing ring
1	0668282-7	HUB, turbine wheel
1	0668283-5	RACE, thrust bearing
1	0669677-7	VALVE ASSY., check
1	0669678-5	SEAL, oil, transmission pump drive
4	0669705-6	RING, back-up
1	0670385-4	HUB ASSY.
2	0670386-2	WASHER, hub
1	0670410-0	PLATE, spacing, accessory drive gear
2	0670411-8	BEARING, roller, idler gear
1	0672955-2	BEARING, thrust
2	0675282-8	CAP ASSY.
1	0681083-2	FLANGE ASSY., driving
3	0681070-9	RING, sealing
3	0924140-7	O-RING
2	0926059-7	O-RING
2	0926860-8	O-RING
1	3034958-3	SEAL
2	3037629-7	RING
1	-----	PRINT of X-217937-B ("Twin-Disc")

0676108-4 CONVERTER KIT, torque (For updating torque converter on loaders
 #510 thru #659)

1	0655619-5	SEAL, oil, fan drive
2	0656701-0	PLATE, thrust, guide wheel
1	0656726-7	GASKET, bearing retainer
1	0657964-3	EXPANDER, piston outer ring
1	0657965-0	EXPANDER, piston inner ring
1	0657973-4	RING, piston, outer (teflon, split)
1	0657974-2	RING, piston, inner (teflon)
1	0658953-5	PIN, spacing plate
1	0663526-2	RING, piston, outer (teflon, not split)
2	0668279-3	WASHER, carrier retaining
1	0668281-9	CARRIER, sealing ring
1	0668282-7	HUB, turbine wheel
1	0668283-5	RACE, thrust bearing
1	0669677-7	VALVE ASSY., check
1	0669678-5	SEAL, oil, transmission pump drive
4	0669705-6	RING, back-up
1	0670385-4	HUB ASSY.
2	0670386-2	WASHER, hub
1	0670410-0	PLATE, spacing, accessory drive gear
2	0670411-8	BEARING, roller, idler gear
1	0672955-2	BEARING, thrust
2	0675282-8	CAP ASSY.

(Continued)

PACKAGED PARTS (Continued)

PACKAGE
NUMBER

DESCRIPTION

0676108-8

CONVERTER KIT, torque (For updating torque converter on loaders
#510 thru #659) (Continued)

3	0681070-9	RING, sealing
3	0924140-7	O-RING
2	0926059-7	O-RING
2	0926860-8	O-RING
1	3034958-3	SEAL
2	3037629-7	RING
1	-----	PRINT of X-217937-B ("Twin-Disc")

4354291-9

GASKET KIT, cylinder head

4	0923813-0	O-RING, water manifold tube
4	4254294-2	O-RING, water by-pass tube (Discard. Not used)
1	4300145-2	GASKET, water outlet elbow
2	4336148-4	GASKET, rocker cover
4	4336182-3	GASKET, water manifold
1	4336263-1	GASKET, thermostat housing
1	4336266-4	GASKET, water elbow (Discard. Not used)
2	4337764-7	GASKET, valve lifter cover
2	4348133-4	GASKET, breather tube
1	4354294-1	GASKET ASSY., front cylinder head
1	4354295-0	GASKET ASSY., rear cylinder head
6	4359571-9	GASKET, intake and exhaust manifold
6	4378031-1	GASKET, injection nozzle

4358696-5

GASKET KIT, intermediate, cylinder block

2	0923376-8	O-RING, flywheel housing dowel
4	0923574-8	O-RING, heat exchanger tubes
2	0923813-0	O-RING, heat exchanger elbows
1	0923816-3	O-RING, flywheel to crankshaft
1	0923820-5	O-RING, injection pump drive cover
1	0924139-9	O-RING, injection pump mounting cover
1	4335056-0	GASKET, water pump volute
1	4336676-4	GASKET, timing hole cover
1	4336897-6	RING, sealing, flywheel housing to crankcase
1	4339118-4	GASKET, oil filter outlet flange
1	4339123-4	GASKET, filter interconnection
1	4339128-3	GASKET, filter head
1	4339150-7	GASKET, filter head to block
1	4339151-5	GASKET, oil line elbow
1	4346169-8	GASKET, oil pipe
1	4346456-9	GASKET, water inlet pipe
1	4346744-8	GASKET, water pump
1	4347031-9	GASKET, water by-pass flange
1	4348136-5	GASKET, timing gear housing
1	4348184-5	GASKET, filter head to block
1	4348185-2	GASKET, heat exchanger front cover
1	4348218-1	GASKET, oil pipe
1	4354163-0	GASKET, timing gear cover

GASKET KIT, turbocharger mounting (See TURBOCHARGER)

4358753-4

PISTON AND SLEEVE KIT (Used prior to engine #11-18404)

2	4255465-9	RETAINER, piston pin
2	4337972-6	O-RING, cylinder sleeve
1	4354720-7	SLEEVE, cylinder
1	4354778-5	PIN, piston
1	4357677-6	RING SET, piston
1	4358745-0	PISTON

PACKAGED PARTS (Continued)

PACKAGE
NUMBER

DESCRIPTION

4359603-0

PISTON AND SLEEVE KIT (Engine #11-18404 and up)
 2 4255465-9 RETAINER, piston pin
 2 4337972-6 O-RING, cylinder sleeve (1st and 2nd groove)
 1 4354778-5 PIN, piston
 1 4357677-6 RING SET, piston
 1 4358745-0 PISTON
 1 4359583-6 SLEEVE, cylinder
 1 4359586-7 O-RING, cylinder sleeve (3rd groove)

----- REPAIR KITS, dump and lift cylinders (See pages 265, 267, 269, 279, 281)

----- RING KIT, transmission (See page 116)

----- RING SET, piston (See PISTON AND CONNECTING ROD)

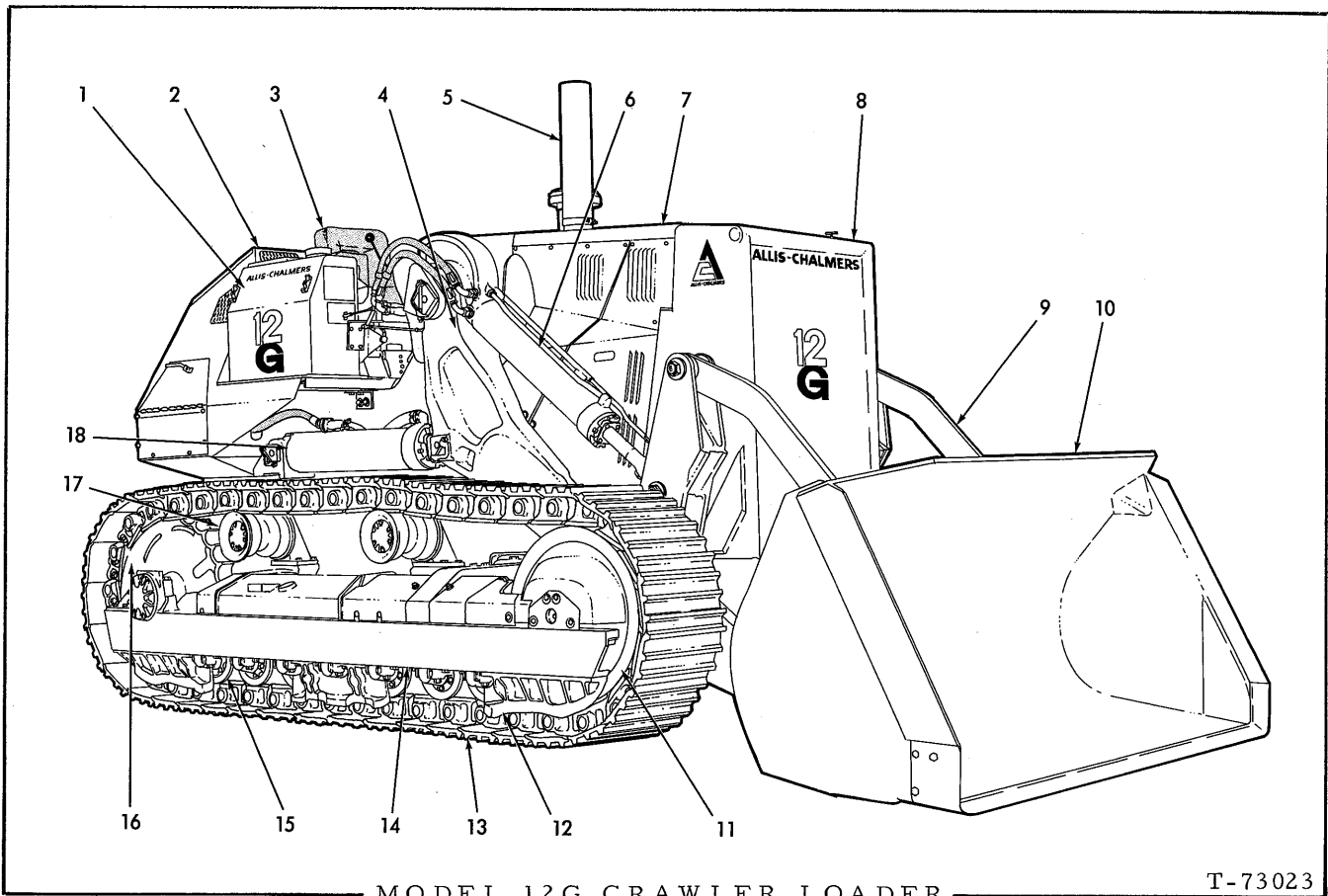
----- SEAL KITS, final drive (See pages 143 and 145)

----- SEAL KIT, track roller (See page 173)

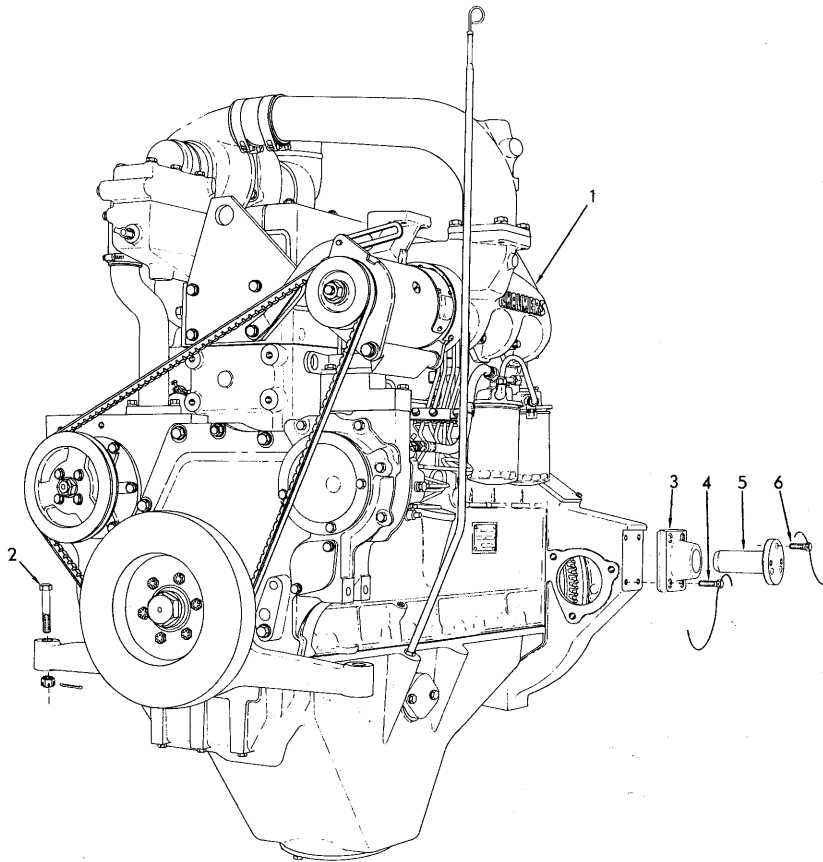
----- SEAL KIT, track idler (See pages 177 and 179)

----- SEAL KIT, track carrier roller (See page 183)

MEMO



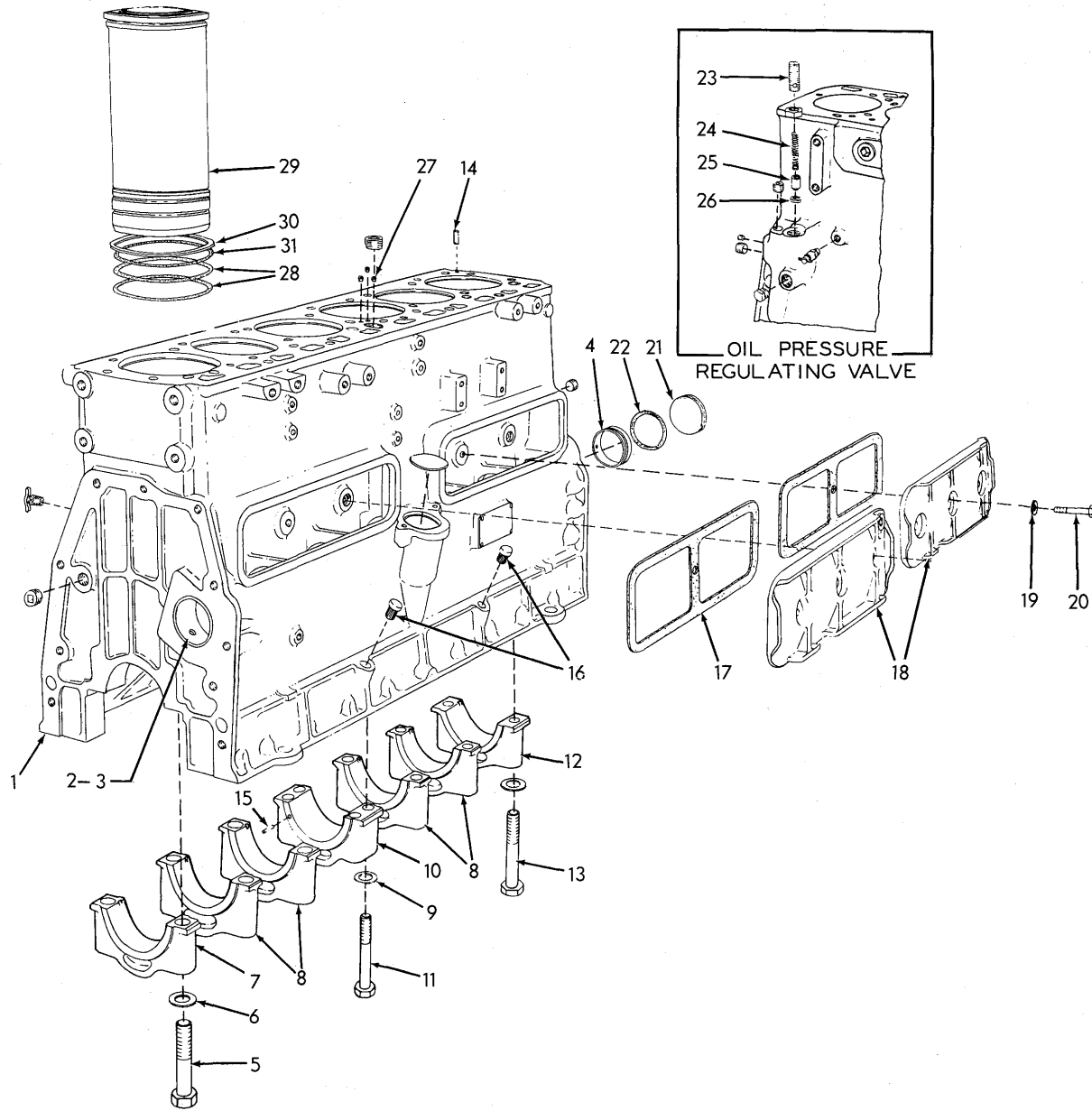
- | | |
|--------------------|--------------------------|
| 1. Hydraulic Tank | 10. Bucket |
| 2. Radiator Guard | 11. Track Idler |
| 3. Seat | 12. Track Roller Guards |
| 4. Bucket Boom | 13. Track |
| 5. Exhaust Pipe | 14. Track Frame |
| 6. Dump Cylinder | 15. Track Rollers |
| 7. Engine Hood | 16. Track Sprocket |
| 8. Fuel Tank Guard | 17. Track Carrier Roller |
| 9. Bucket Linkage | 18. Lift Cylinder |



T-74988

ENGINE AND MOUNTING

ITEM	PART NO.	QTY.	DESCRIPTION
1	4354538	1	ENGINE ASSY. (Engines prior to serial No. 11-17330 on loaders prior to #43C01001)
	4359570	1	ENGINE ASSY. (Engines serial No. 11-17330 and up, effective with loader #43C01001)
NOTE: Engines include generator, oil and fuel filters, turbo-charger, but do not include air cleaner or starter.			
2	642563	2	CAPSCREW, front mounting (5/8"NF x 3-1/2")
	913280	2	NUT, high, slotted, 5/8"NF
	900806	2	PIN, cotter, 1/8" x 1"
3	656193	2	TRUNNION, rear mounting
4	927475	8	CAPSCREW, drilled-hd., 1/2"NC x 1-1/2"
	023633	4	WIRE, locking, 1/16" x 12"
5	655552	2	PIN, rear trunnion
6	604963	6	CAPSCREW, drilled-hd., 1/2"NC x 1-3/8"
	023633	2	WIRE, locking, 1/16" x 12"



CYLINDER BLOCK

T-41944

CYLINDER BLOCK

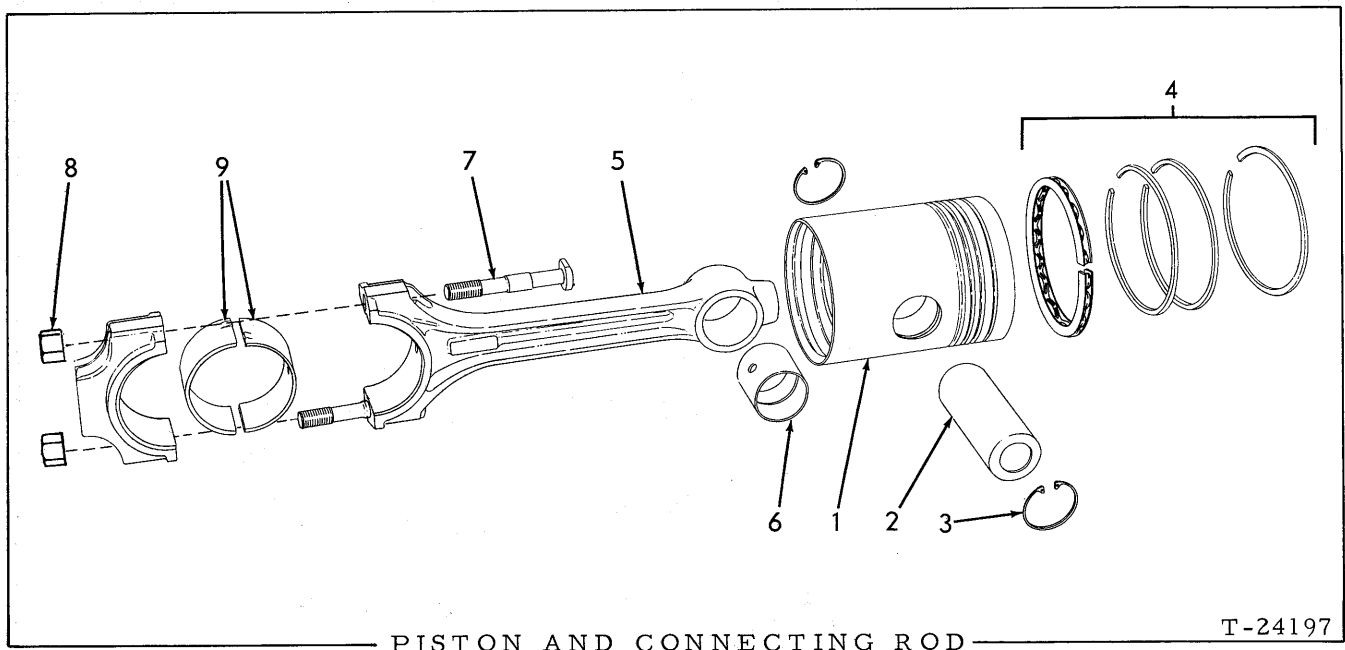
ITEM	PART NO.	QTY.	DESCRIPTION
1	4358582	1	BLOCK ASSEMBLY (Includes items 2 thru 13, 26 and 27)
	910017	1	PLUG, expansion, 2-3/8" diam. (Early units)
	919134	4	PLUG, pipe, hex-hd., 1/8"NPT
	920333	1	PLUG, pipe, hex-hd., 3/8"NPT
	918887	1	PLUG, pipe, hex-socket, 3/8"NPT
	917970	2	PLUG, pipe, hex-socket, 1/2"NPT
	920416	1	PLUG, pipe, hex-hd., 1/2"NPT
	918851	1	PLUG, pipe, hex-socket, 3/4"NPT
	918888	1	PLUG, pipe, hex-socket, 1"NPT
	912415	2	COCK, drain, 1/4"NPT
2	{ 4346100	1	BEARING, camshaft, front (standard size)
	{ 4347416	1	BEARING, camshaft, front (.010" undersize)
3	{ 4346099	2	BEARING, camshaft, intermediate (standard size)
	{ 4347419	2	BEARING, camshaft, intermediate (.010" undersize)
4	{ 4346108	1	BEARING, camshaft, rear (standard size)
	{ 4347413	1	BEARING, camshaft, rear (.010" undersize)
5	4339037	2	CAPSCREW, front main bearing cap (3/4"NC x 3-15/16")
6	4354175	12	WASHER, main bearing cap screw
7	4349630	1	*CAP, front main bearing
8	4349632	4	*CAP, intermediate main bearing
9	4391160	4	WASHER, center main bearing cap screw
10	4349629	1	*CAP, center main bearing
11	4339038	4	CAPSCREW, center main bearing cap (5/8"NC x 3-13/16")
12	4349631	1	*CAP, rear main bearing
13	4339036	10	CAPSCREW, rear and intermediate main bearing cap (3/4"NC x 4-5/16")
14	4336432	4	PIN, dowel, cylinder head
15	-----	4	PIN, dowel, crankshaft thrust flange (See CRANKSHAFT)
16	4362338	2	PLUG, crankcase
17	4337764	2	□GASKET, valve lifter cover
18	4354635	2	COVER, valve lifter
19	4335456	6	WASHER, valve lifter cover bolt
20	4335455	6	BOLT, valve lifter cover
21	4335534	1	PLUG, camshaft hole
22	923815	1	O-RING, camshaft hole plug
23	4389058	1	SCREW, oil pressure regulating valve
	910847	1	NUT, jam, 3/4"NF

*Replacement bearing caps are semi-finished and must be line-bored after installing

(Continued)

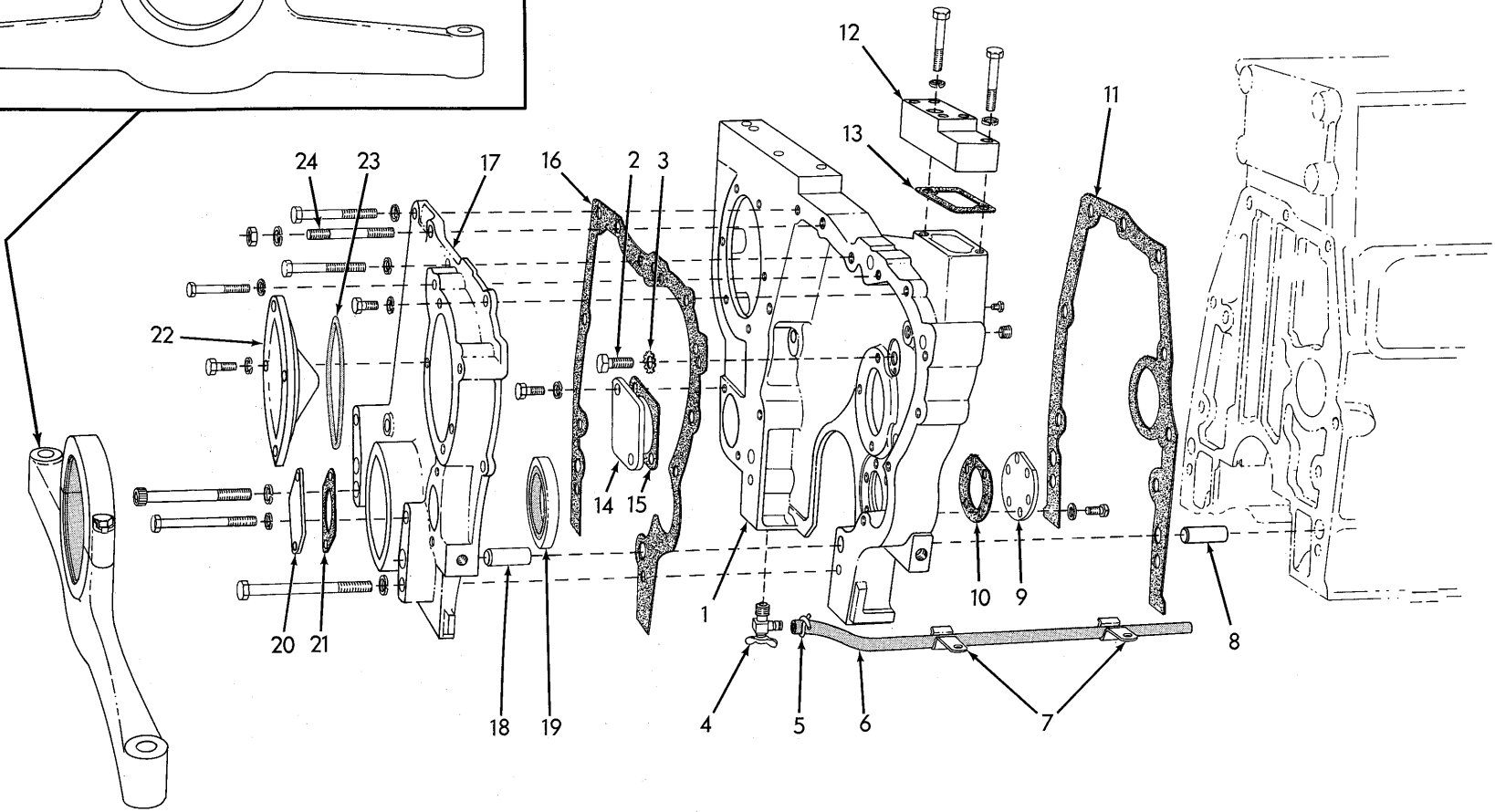
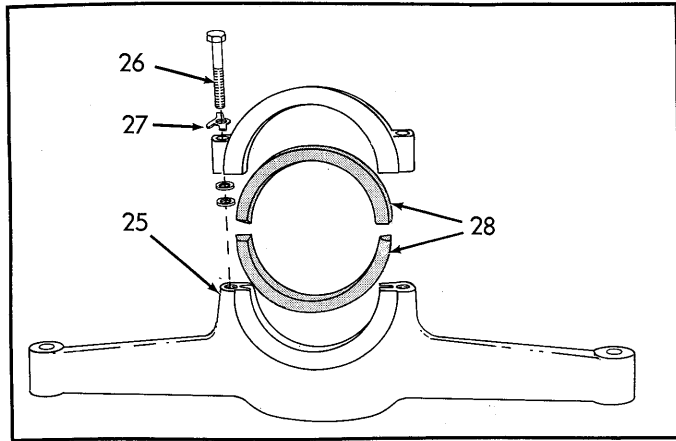
CYLINDER BLOCK (Continued)

ITEM	PART NO.	QTY.	DESCRIPTION
24	4660358-5	1	SPRING, oil pressure regulating valve
25	4500230-0	1	PISTON, oil pressure regulating valve
26	4347465-9	1	INSERT, oil pressure regulating valve seat
27	4347061-6	1	RESTRICTOR, oil passage
28	4337972-6	12	<input type="checkbox"/> O-RING, cylinder sleeve (1 and 2 groove)
29	-----	6	<input type="checkbox"/> SLEEVE, cylinder (Used prior to engine #11-16980. Order SLEEVE 4359583-4 and O-RING 4359586-7)
	4359583-4	6	
30	4348857-6	-	SHIM, cylinder sleeve (.005" thick) } Use as required when re-machining cylinder blocks
	4348856-8	-	
	4348859-2	-	
	4348858-4	-	
	4348900-4	-	
31	4359586-7	6	O-RING, cylinder sleeve (3rd groove)(Effective engine #11-16980 and up)



ITEM	PART NO.	QTY.	DESCRIPTION
1	4358745-0	6	□ PISTON (Engines prior to #11-18404)
	4359360-7	6	□ PISTON (Engine #11-18404 and up)
2	4354778-5	6	□ PIN, piston
3	4255465-9	12	□ RETAINER, piston pin
4	4359758-2	6	□ RING SET (Engines prior to #11-18404)
	4359757-4	6	□ RING SET (Engine #11-18404 and up)
5	4354788-4	6	ROD ASSY., connecting (Includes items 6 thru 8)
6	4339017-8	6	BUSHING, connecting rod
7	4354787-6	12	BOLT, connecting rod
8	4354748-8	12	NUT, connecting rod bolt
9	4337701-9	12	BEARING, connecting rod (standard size)
	4337702-7	12	BEARING, connecting rod (.010" undersize)
	4337703-5	12	BEARING, connecting rod (.020" undersize)
	4337704-3	12	BEARING, connecting rod (.030" undersize)
	4337705-0	12	BEARING, connecting rod (.040" undersize)

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TIMING GEAR HOUSING

T-73051