



PARTS CATALOG

500-600 FORKLIFTS & BUCKMASTER

LITHO U.S.A.

FORM 1012401
Reprinted 11-75
(Replaces Form TP-103)

NOTICE

**THE PART NUMBERS IN THIS PARTS BOOK ARE LISTED
BY SERIAL NUMBER FOR THE FOLLOWING UNITS.**

600 Series Unit

Tractor No. 600-1001 FL and up
Base Group Serial No. 501 and up

500 Series Unit

Tractor Serial No. 600-1001 FL and up
Base Group Serial No. 501 and up

630 Series Unit

Tractor Serial No. 600-5968 and up
Base Group Serial No. 3050 and up

Buckmaster

Tractor Serial No. 600-1001 FL and up
Base Group Serial No. 501 and up

600 Series

610

612

614

621

Buckmaster

500 Series

510

512

514

521

630 Series

FOREWORD

The parts in this catalog are listed in alphabetical order and are located at the front of this catalog.

Except for some common hardware all parts are identified with an item number. Common hardware not identified such as bolts, nuts, cotter pins and lubrication fittings, are listed in the text under the part which they attach or fit into. Note particularly that the quantity of hardware listed is always the quantity required for one part.

Common attaching hardware listed under a part is not included in the assembly or included with the part unless specified. Example: (Incl. Bolt, Lock-washer and Nut).

"Assembly or Packaged Parts" indicates if an individual part is one of many in a large assembly or one of several kinds in a package.

All numbers are listed in the second last section of this catalog showing the quantity and description of the various parts that make up the assembly or package.

The last section of this catalog contains a part number index to indicate on which page or pages a part number appears.

All illustrations will be found to follow the text of each group or section of which it is a part.

For any additional copies of this catalog there will be a supplementing service charge of three dollars. Refer any requests to your Branch House or office under which you operate.

HOW TO ORDER PARTS

Order all parts for this machine from your local ALLIS-CHALMERS Dealer.

When ordering parts for this unit, supply the following information:

1. The tractor and engine serial numbers.
2. The model or name of the unit and its serial number.
3. State the common name of the part you wish to order, or a description of the part and its location on the unit, or bring in old part.

4. Always print your name and post office address, where parts are to be shipped; also specify whether material is to be shipped by freight, express or parcel post.

5. When ordering parts always determine right hand and left hand from a position in the operators seat facing the direction of forward travel. On Backhoe Units Right and Left is determined by facing the Backhoe from the operator seat.

IMPORTANT

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 Manufacturing 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.

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CYLINDER BLOCK
Gasoline

ITEM	NUMBER	QTY	DESCRIPTION
1	0227572-5	1	SEAL, crankshaft, rear
2	0227571-7	1	RETAINER, crankshaft rear seal
		6	0903771-4 Capscrew, 5/8 UNC x 7/8
		6	0913651-6 Washer, lock 5/8
3	0233205-4	1	GASKET, crankshaft rear seal retainer
4	-----	2	BUSHING, camshaft, front & rear (See Camshaft Group)
5	0918849-1	1	COCK, drain 1/4
6	-----	1	TRANSFER, instruction, water drain
7	0240035-6	1	BLOCK ASSY., cylinder (Incl. Items 4, 10 thru 17)
8	0231188-4	1	ROD ASSY., oil level gauge (Incl. Seal)
9	0230331-1	1	BUSHING, oil level gauge rod
10	-----	1	BUSHING, governor gear (See Governor Group)
11	-----	1	BUSHING, camshaft, center (See Camshaft Group)
12	0206782-5	2	WASHER, copper
13	0234354-9	1	COVER, fuel pump
		2	0921332-3 Capscrew, 5/16 UNC x 3/4
14	0234145-1	1	GASKET, cover
15	0234276-4	2	CAP, main bearing, front & center
16	0234277-2	1	CAP, main bearing, rear
17	0234939-7	6	CAPSCREW, main bearing cap
-	-----	1	TRANSFER, engine designation (Not shown)
18	0233207-0	1	GASKET, oil pump opening cover
19	0227574-1	1	COVER, oil pump opening
		1	0917151-3 Capscrew, 3/8 UNF x 3-1/4 (Top, short)
		1	0916795-8 Capscrew, 3/8 UNF x 3-1/2 (Bottom, long)
		2	0916965-7 Washer, lock 3/8
		2	0916602-6 Nut, 3/8 UNF
-	0291445-5	1	ENGINE ASSY., (160 cu. in. displacement)

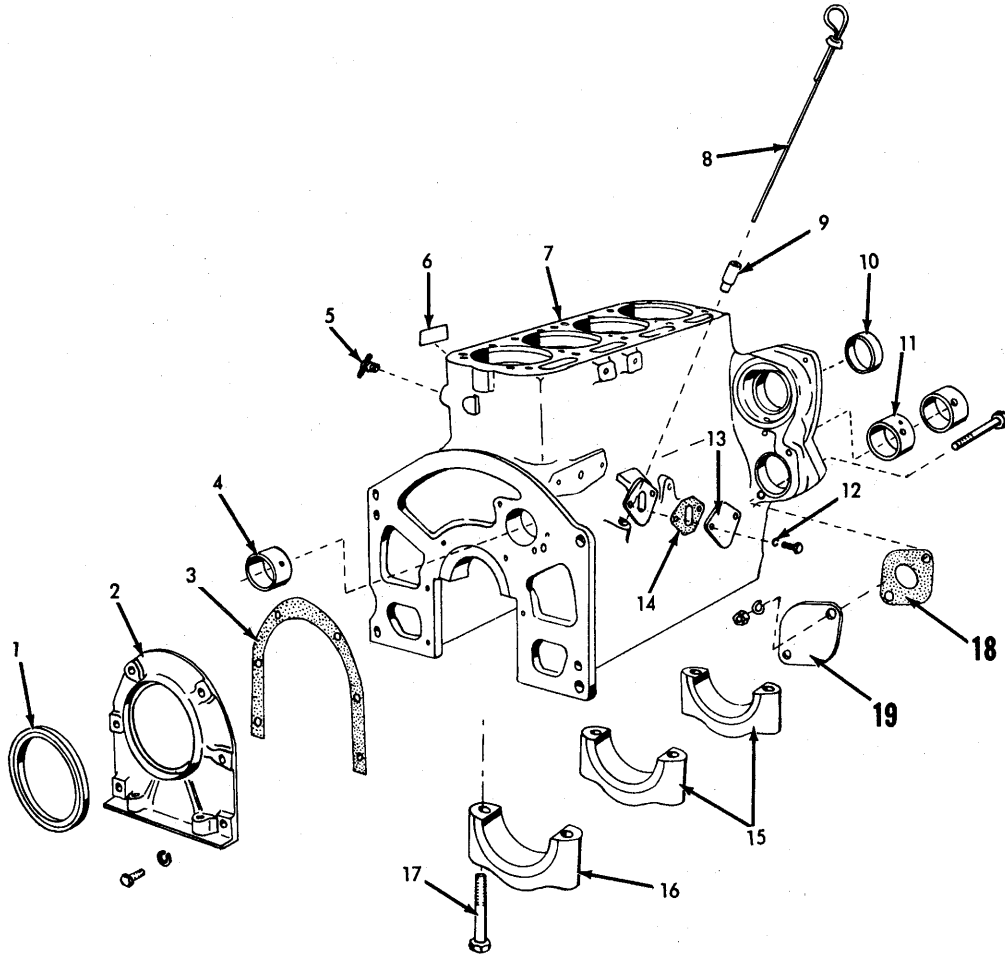
} Note: These parts not required when tractor is equipped w/ Fuel Pump.

Note: Replacement engines do not include fan, fan belt, flywheel, clutch, shaft bushing, carburetor, muffler, air cleaner, starting motor or generator.

- 0255324-6 - KIT, (Incl. Items 1 & 3)
- 0243968-5 - KIT, (Incl. Item 6 & Engine Transfer)

103-1

CYLINDER BLOCK
Gasoline



CRANKSHAFT & FLYWHEEL
 Gasoline

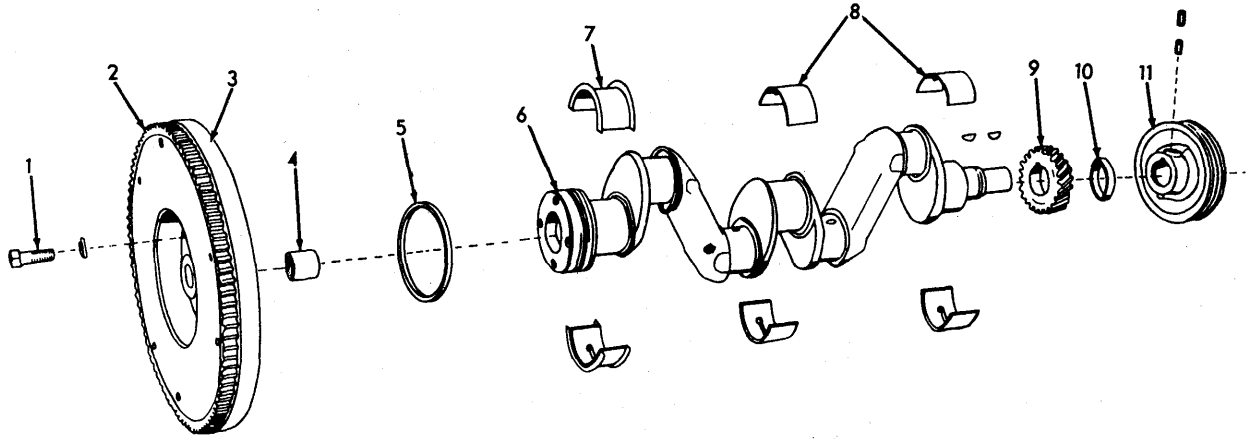
ITEM	PART NUMBER	QTY.	DESCRIPTION
1	210151	4	CAPSCREW, flywheel 1 904207 WASHER, lock, 7/16
2	233196	1	GEAR, ring, 116T
3	237065	1	FLYWHEEL ASSY., (Incl. Items 2 & 4)
4	228188	1	BUSHING, clutch shaft
5	227572	1	SEAL, crankshaft, rear
6	-----	1	CRANKSHAFT KIT, std
7	237831	1	BEARING, main, rear std. (2 halves)
	237827	1	BEARING, main, rear, .001" U/S(2 halves)
	237829	1	BEARING, main, rear, .0025" U/S (2 halves)
8	237830	1	BEARING, main, front & center std. (2 halves)
	237823	1	BEARING, main, front & center .001" (2 halves)
	237825	1	BEARING, main, front & center .0025" (2 halves)
9	227552	1	GEAR, crankshaft 1 910184 KEY, woodruff, 5/32 x 3/4
10	226620	1	SEAL, crankshaft, front
11	235043	1	PULLEY, crankshaft 1 919774 KEY, woodruff, 5/32 x 3/4 2 902870 SETSCREW, 3/8NC x 3/8
--	0255324-6	--	KIT (Incl. #5 & 10) (replaces 239958)
--	240921	--	KIT (Incl. No. 6 thru 9 & Key)

CYLINDER HEAD
 Gasoline

ITEM	PART NUMBER	QTY.	DESCRIPTION
1	241591	1	HEAD ASSY., cylinder (Incl. Items 3, 5 & EXHAUST VALVE SEAT)
2	237833	7	CAPSCREW, cylinder head, long
	922477	1	CAPSCREW, 1/2NC x 4-1/2
	230318	3	PLUG, core hole
4	229754	1	WASHER, cylinder head capscrew
5	-----	8	GUIDE, valve (See VALVES & ROCKER ARMS Group)
6	922478	4	CAPSCREW, 1/2NC x 2-7/8
7	0237642-4	1	GASKET, cylinder head (replaces 254858)
NOT SHOWN	901839	1	BUSHING, reducer pipe
--	0255324-6	--	KIT (Incl. #7) (replaces 239958)
--	0255323-8	--	KIT (Incl. #7) (replaces 239959)

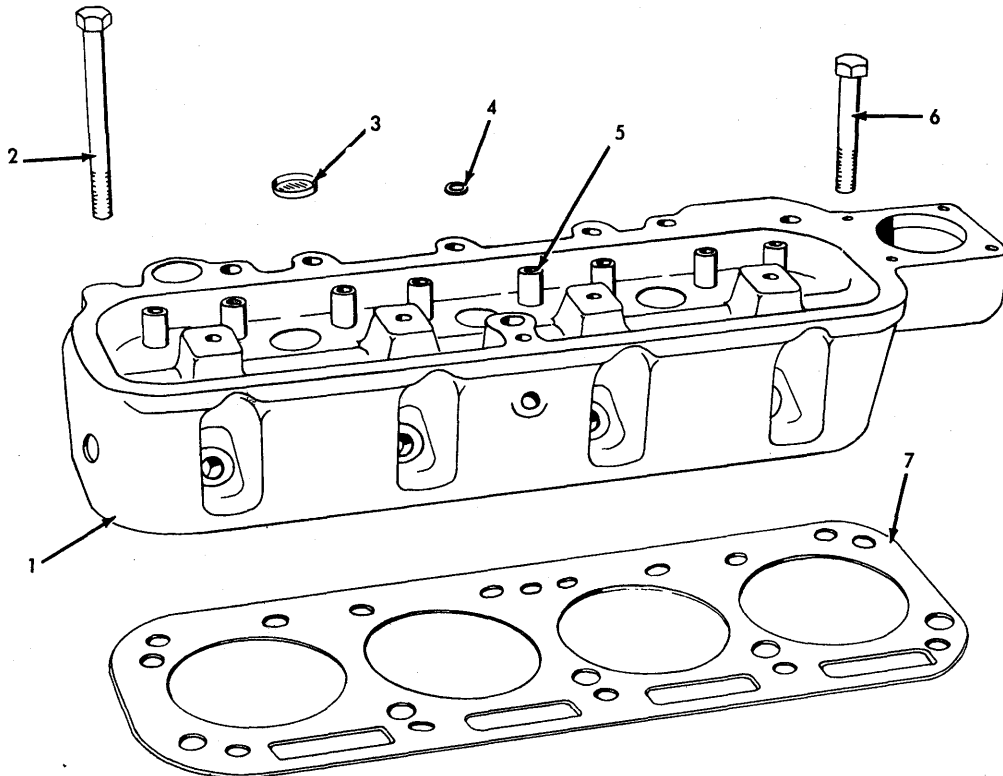
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CRANKSHAFT & FLYWHEEL
Gasoline



103-3

CYLINDER HEAD
Gasoline

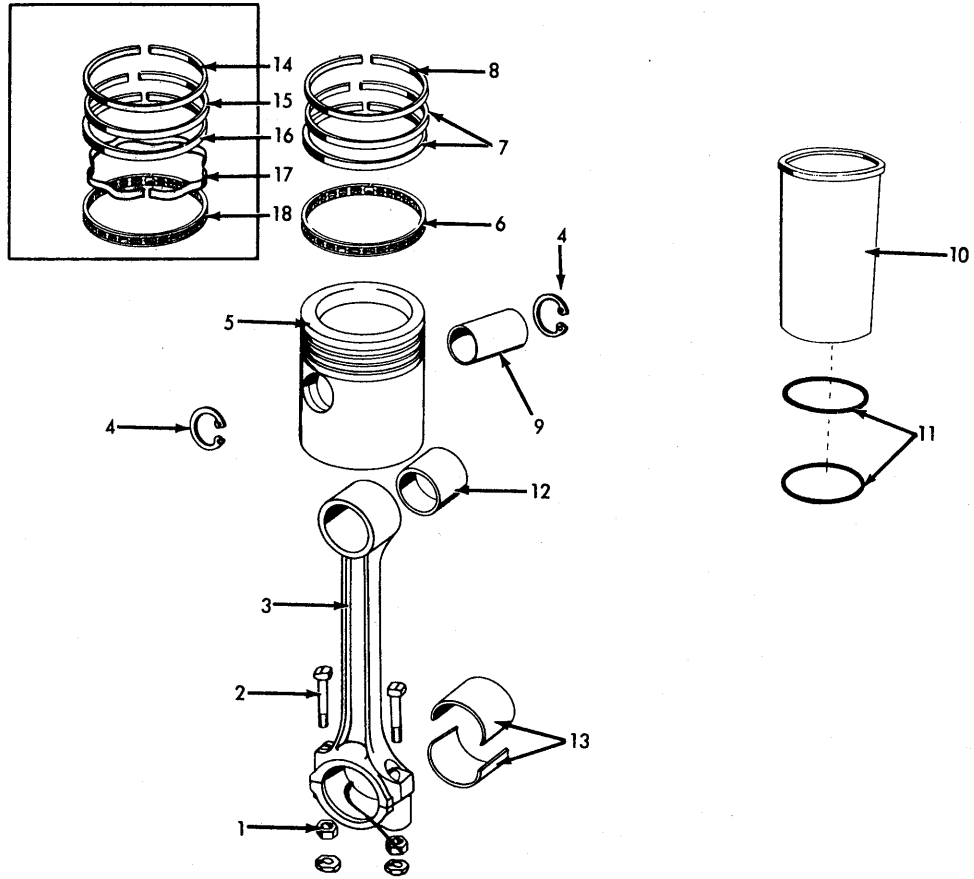


PISTON & CONNECTING ROD
Gasoline

ITEM	PART NUMBER	QTY.	DESCRIPTION
1	225672	8	NUT, bearing cap bolt 1 914393 NUT, lock, pltd., 3/8
2	235787	8	BOLT, bearing cap
3	237631	4	ROD ASSY., connecting (Incl. Items 1, 2 & 12)
4	4514586	8	LOCK, piston pin.
5	237644	4	PISTON ASSY., 8:1 ratio, gasoline (Incl. Item 9)
6	237650	4	RING, channel oil, piston
7	237649	8	RING, compression, second & third
8	237648	4	RING, compression, top
9	237645	4	PIN, piston
10	237646	4	LINER, cylinder
11	237647	8	RING, packing, cylinder liner
12	4507127	4	BUSHING, piston pin
	237802	4	BEARING, conn. rod, std. (2 halves)
13	237814	4	BEARING, conn. rod, .001" U/S (2 halves)
	237815	4	BEARING, conn. rod, .0025" U/S (2 halves)
14	237648	4	RING, top compression
15	237649	4	RING, 2nd compression
16	248435	4	RING, 3rd compression
17	248436	4	EXPANDER, 3rd Comp
18	237650	4	RING, oil control
--	285335	-	KIT (Incl. #4 thru 8, 10 & 11)
--	240921	-	KIT (Incl. #13)
--	248293	-	KIT (Incl. #14 thru 18)

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PISTON & CONNECTING ROD
Gasoline

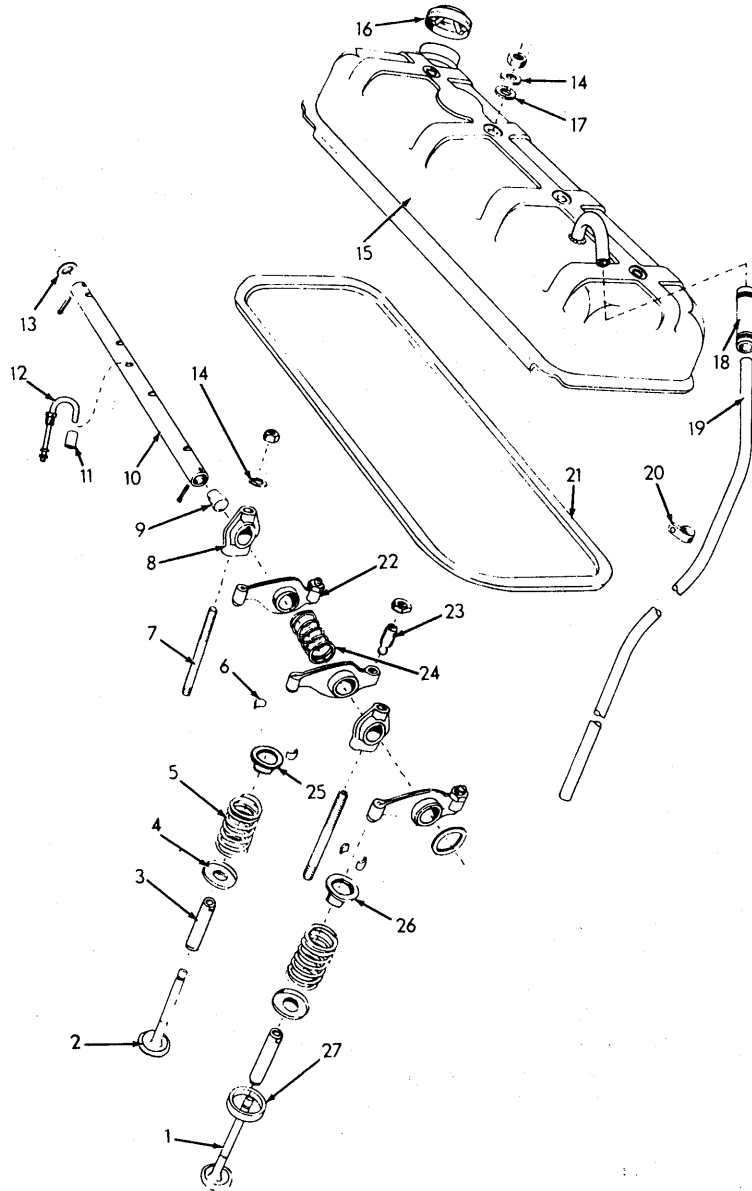


VALVES & ROCKER ARMS
 Gasoline

ITEM	PART NUMBER	QTY.	DESCRIPTION
1	228589	4	VALVE, exhaust
2	234829	4	VALVE, intake
3	234824	8	GUIDE, intake & exhaust valve
4	218124	8	SEAT, valve spring
5	233850	8	SPRING, valve
6	206880	16	LOCK, spring retainer (Half)
7	224733	4	STUD, rocker arm support
		1	910123 NUT, 3/8NF
		1	904206 Washer, lock, (Used w/Engine Hanger)
8	239791	4	SUPPORT, rocker arm shaft
9	212004	2	STOPPER, rocker arm shaft, cork
10	228536	1	SHAFT ASSY., rocker arm (Incl. Item 9 & C-PINS)
		2	900807 PIN, cotter, 1/8 x 1-1/4
11	237637	1	SLEEVE, rocker arm oil tube
12	227636	1	TUBE, oil, rocker arm shaft
		1	913526 NUT, 3/16
13	203009	2	WASHER, rocker arm shaft
14	911115	8	WASHER, support stud, 3/8
15	237643	1	COVER, rocker arm
16	240624	1	CAP, oil filler
17	226477	4	PACKING, cover stud
18	236745	1	HOSE, breather
		2	921911 CLAMP, hose, 11/16 - 2-1/4
19	237761	1	TUBE, breather
20	236800	1	CLAMP, breather tube to manifold stud
21	0255296-6	1	GASKET, rocker arm cover (replaces 232334)
22	234781	4	ARM ASSY., rocker, L. H. (Incl. Item 23 & NUT)
	234780	4	ARM ASSY., rocker, R. H. (Incl. Item 23 & NUT)
23	206888	8	SCREW, rocker arm adjusting
		1	912795 NUT, 7/16NF
24	203011	3	SPRING, rocker arm spacing
25	206881	4	RETAINER, valve spring, intake
26	224926	4	ROTO-CAP, exhaust valve
27	230510	4	SEAT, exhaust valve
--	0255324-6	--	KIT (Incl. #17 & 21) (replaces 239958)
--	0255323-8	--	KIT (Incl. #17 & 21) (replaces 239959)

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VALVES & ROCKER ARMS
Gasoline



TIMING GEAR COVER
Gasoline

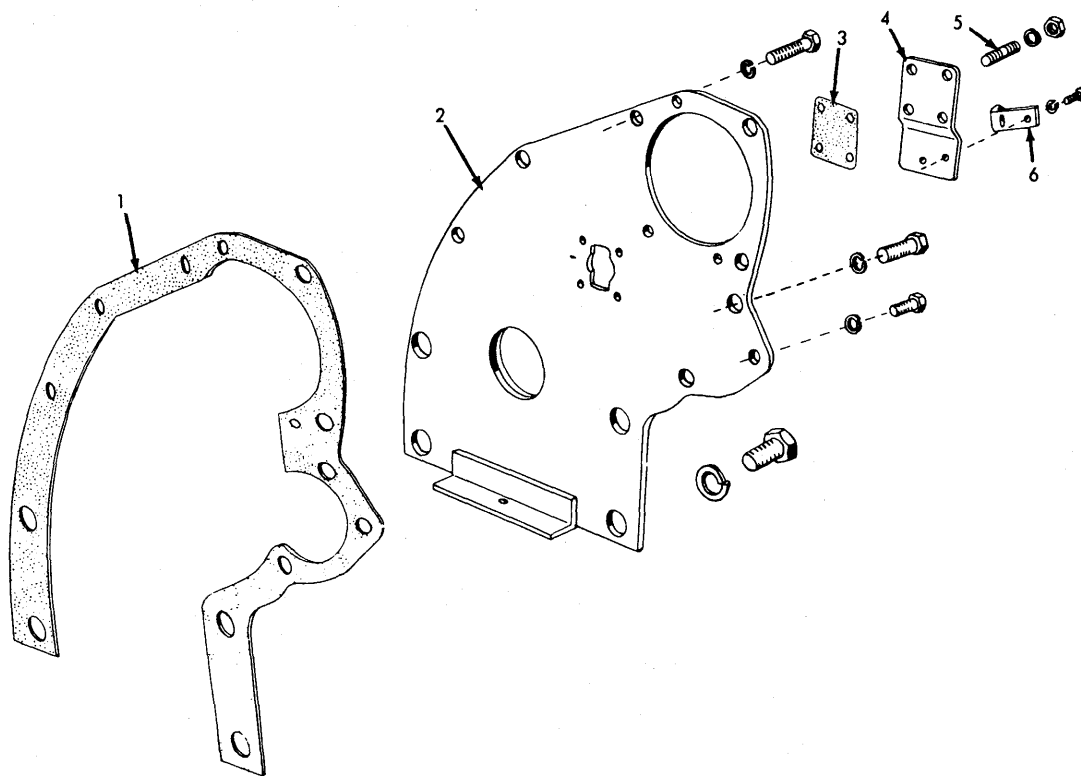
ITEM	PART NUMBER	QTY.	DESCRIPTION
1	233204	1	GASKET, timing gear cover
2	232322	1	COVER ASSY., timing gear
		4	913828 CAPSCREW (lower) 5/8NC x 1-1/2
		4	904209 WASHER, lock (lower) 5/8
		3	915809 CAPSCREW (center) 5/16NC x 3/4
		3	904205 WASHER, lock (center) 5/16
3	248969	1	GASKET, thrust cover
4	235044	1	COVER, thrust, camshaft
5	218288	4	STUD, thrust plate cover
		1	904204 WASHER, lock, 1/4
		1	911040 NUT, 1/4NF
6	235045	1	POINTER, timing
		2	912731 SCREW, machine, #8NF x 5/16
		2	912739 WASHER, lock, #8
-	0255324-6	--	KIT (Incl. #1 & 3) (replaces 239958)

CAMSHAFT
Gasoline

ITEM	PART NUMBER	QTY.	DESCRIPTION
1	209130	2	BUSHING, camshaft, front & rear, std.
	233528	1	BUSHING, camshaft, center, std.
2	233386	1	CAMSHAFT, engine
		1	910946 PIN, plain, 5/32 x 1-1/4
3	227633	8	ROD, push
4	206890	8	TAPPET, valve
5	231529	1	SPRING, oil relief valve
		1	905365 BALL, steel, 5/8
6	247366	1	PLATE, thrust
7	207422	1	GEAR, camshaft
		1	910184 KEY, woodruff, 5/32 x 3/4
8	242192	1	PLUNGER, thrust
9	248970	1	SPRING, thrust

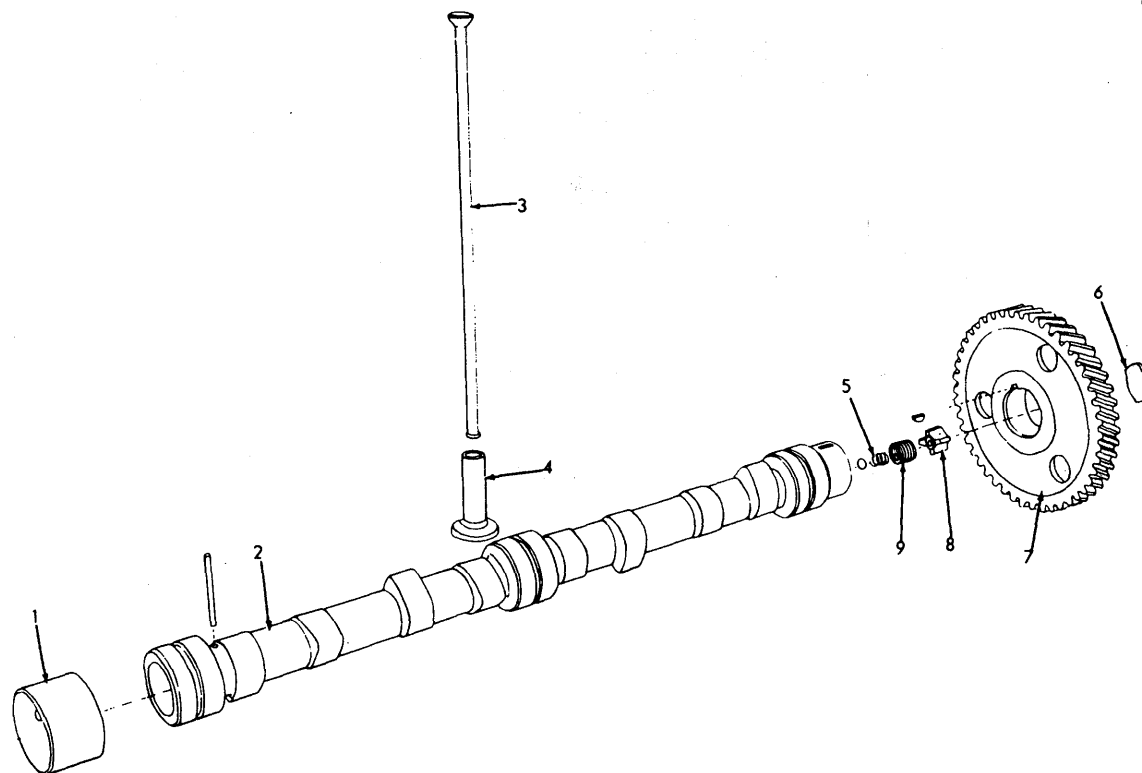
103-6

TIMING GEAR COVER
Gasoline



103-7

CAMSHAFT
Gasoline

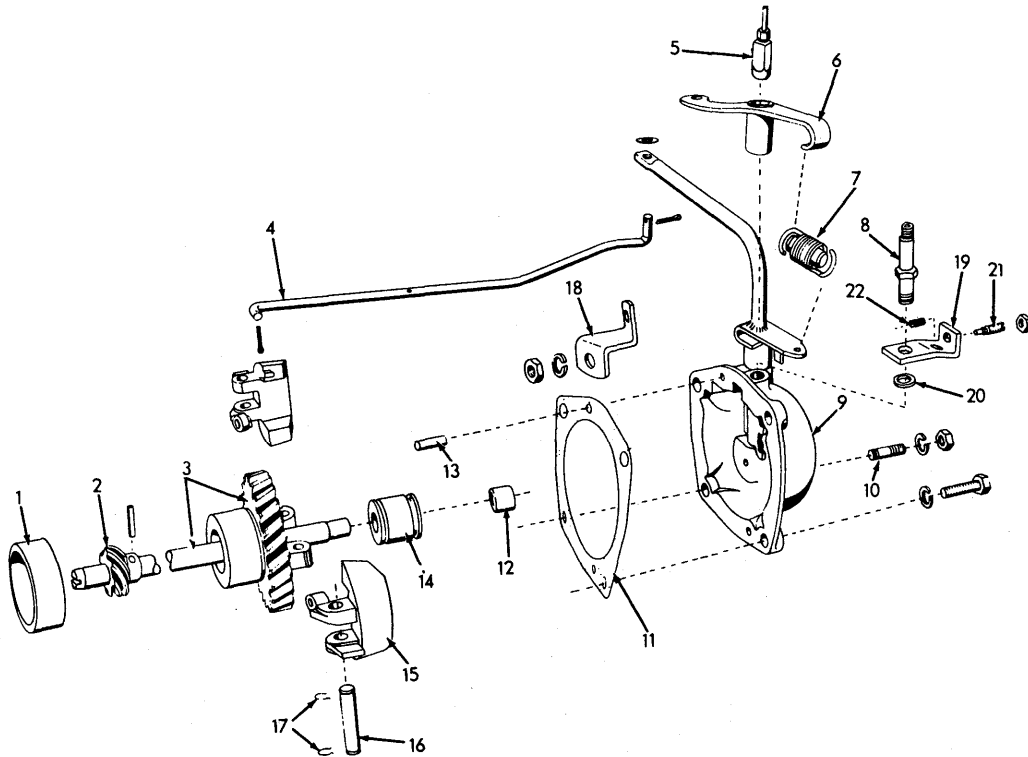


GOVERNOR
Battery Ignition
Gasoline

ITEM	PART NUMBER	QTY.	DESCRIPTION
1	210689	1	BUSHING, governor gear
2	225353	1	GEAR, drive, distributor, 6T
			1 915796 PIN, 3/16 x 3/4
3	228136	1	SHAFT ASSY., governor (Incl. GEAR)
4	248431	1	LINK, carburetor
			1 911114 WASHER, plain (front) 1/4
			2 900970 PIN, cotter, 1/16 x 1/2
5	228138	1	Tee, oil tube (Incl. 2 SLEEVES & NUTS)
			2 911841 SLEEVE, 1/8
			2 912589 NUT, 1/8
6	234113	1	LEVER ASSY. control rod (Incl. BUSHING)
7	223516	1	SPRING, governor (Incl. PLUNGER)
8	234109	1	PIN, pivot, control rod lever
9	234107	1	HOUSING ASSY., governor (Incl. SPRING LEVER, CROSS SHAFT COLLAR, CROSS SHAFT BUSHING, CROSS SHAFT, FORK & Item 12)
10	207402	1	STUD, housing
			1 904205 WASHER, lock, 5/16
			1 910323 NUT, 5/16NC
11	233213	1	GASKET, housing
12	207714	1	BUSHING, governor shaft, front
13	915796	2	PIN, dowel, housing, 3/16 x 3/4
14	208875	1	BEARING, ball, thrust
15	233928	2	WEIGHT ASSY., governor (incl. RISER PIN)
16	207718	2	PIN, pivot, weight
17	207719	4	CLIP, weight pivot pin
18	234114	1	BRACKET, governor adjustment
			1 903625 CAPSCREW, 1/4NC x 3/4
			1 910880 NUT, 1/4NC
			1 904206 WASHER, lock, 3/8
			1 910324 NUT, 3/8NC
19	234110	1	BRACKET, bumper spring
20	234111	1	WASHER, pivot pin
			1 920437 NUT, jam, pltd., 1/4NF
21	234112	1	SCREW, bumper spring
22	4614092	1	SPRING, bumper
-	0255324-6	--	KIT (Incl. #11) (replaces 239958)

103-8

GOVERNOR
Battery Ignition
Gasoline



IGNITION
Battery
Gasoline

ITEM	PART NUMBER	QTY.	DESCRIPTION
1	225606	1	CLAMP ASSY., coil (Incl. SCREW, which is not serviced separately) 2 905661 CAPSCREW, 5/16NC x 5/8 2 904205 WASHER, lock, 5/16 1 910335 WASHER, plain, 11/32 x 11/16 x 1/16
2	228141	1	PLUG, distributor drive housing (Not used with operation meter)
3	4515665-0	1	COIL ASSY., ignition (Incl. Item 1)
4	912803	6	TERMINAL, cable (Coil & Distributor End) 75MM Brass
5	228131	1	CABLE, primary, distributor to coil
6	225073	1	NIPPLE, cable (f/coil)
7	-----	1	CABLE, secondary, coil to distributor
8	239677	4	PLUG, spark (auto-Lite) (f/Gasoline)
	224990	4	PLUG, spark (A-C) (f/Gasoline)
	239678	4	PLUG, spark (Champion) (f/Gasoline)
9	206460	4	TERMINAL, spark plug cable (plug end)
10	203203	1	RETAINER, cable
11	-----	2	CABLE, spark plug, No. 1 & 2 cylinder
	-----	1	CABLE, spark plug, No. 3 cylinder
	-----	1	CABLE, spark plug, No. 4 cylinder
12	225484	5	NIPPLE, cable (f/distributor)
13	-----	1	DISTRIBUTOR ASSY., (See DISTRIBUTOR Group)
14	226683	2	CAPSCREW, distributor clamp (Incl. WASHER, lock)
15	225344	2	CLAMP, distributor to drive housing
16	228138	1	TEE, oil tube (Incl. SLEEVE & NUTS) 2 911841 SLEEVE, 1/8 2 912589 NUT, 1/8
17	226007	1	TUBE, oil 1 910125 CONNECTOR, (Incl. SLEEVE & NUT) 1/8 x 1/8 2 911841 SLEEVE, 1/8 2 912589 NUT, 1/8
18	233211	1	GASKET, distributor base to drive housing
19	225348	1	BUSHING, governor shaft, rear
20	233212	1	GASKET, drive housing to cylinder block
21	232126	1	STUD, drive housing 1 904206 WASHER, lock, 3/8 1 910324 NUT, 3/8NC
22	228500	1	HOUSING ASSY., distributor drive (Incl. Item 19)
23	207430	1	CLIP, drive housing 1 912943 CAPSCREW, 3/8NC x 1-3/4 1 904206 WASHER, lock, 3/8
NOT SHOWN	-----	1	CABLE SET, spark plug
--	229867	--	KIT (Incl. No. 7, 11 & Cable Set)
--	0255324-6	--	KIT (Incl. #18 & 20) (replaces 239958)

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IGNITION
Battery
Gasoline

