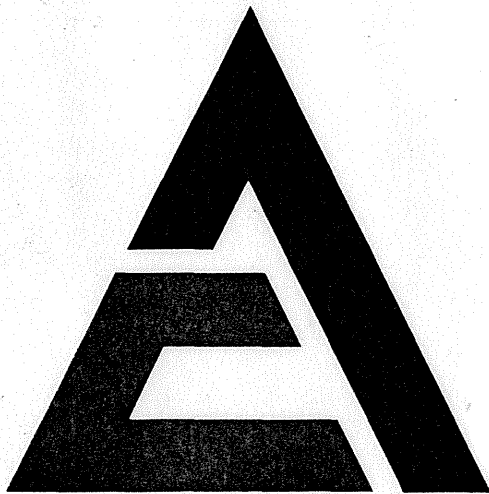


Parts
Catalog
for
645
WHEEL
LOADER

(PRIOR TO S/N 2032)



ALLIS-CHALMERS

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

FORM 3057428-9

REPLACES 3043910-3

ADDITIONAL PUBLICATIONS AVAILABLE
FOR
MODEL 645 WHEEL LOADER (S/N Prior to 2032)

ORDER FROM LOCAL ALLIS-CHALMERS DEALER

(Available in Foreign Language as Indicated)

<u>DESCRIPTION</u>	<u>SERIAL NO.</u>	<u>FORM NO.</u>			
		ENGLISH	ESPAÑOL (Spanish)	PORTUGUÊS (Portuguese)	FRANÇAIS (French)
<u>Parts Catalog</u>					
Cab Glass ----- All		0626019-4	-----	-----	-----
Injection Pump (Roosa Master)		0659480-3	-----	-----	-----
<u>Operating Instructions and Field Maintenance Manual</u>					
645 Wheel Loader (Prior to serial no. 1501)		3043911-1	3046910-0	3046912-6	3046911-8
645 Wheel Loader (Effective with serial no. 1501 & up)		3047531-3	-----	-----	-----
<u>Service Manuals</u>					
Axles ----- All		3053547-0	3051865-8	3051866-6	-----
Brakes ----- All		3047530-5	3052634-7	3052635-4	-----
Bucket and Chassis ----- All		3055458-8	3054309-4	3054308-6	-----
Electrical System ----- All		3051888-0	3053922-5	3054307-8	-----
Engine ----- All		0650824-6	0665234-1	0663050-3	0668379-1
Loader Hydraulic Systems ----- All		3055078-4	3051870-8	3052636-2	-----
Power Steering ----- All		3055077-6	3052606-5	3052639-6	-----
Service Tools ----- All		0650850-1	-----	-----	-----
Transmission, Torque Converter, Charging Pump ----- All		3044122-4	3052630-5	3052631-3	-----
Turbocharger ----- All		0649088-2	0668380-9	0668381-7	0668382-5

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.

The engine is mounted unconventionally with the flywheel toward the front of the machine, but all engine parts are designated in respect to the engine as it would be installed in a conventional machine with the flywheel to the rear.

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

The symbol listed below is stamped in front of the model serial number on each unit.

MODEL SYMBOL	ENGINE MODEL	DESCRIPTION
645	3500	Turbocharged Diesel powered engine, articulated four wheel drive loader unit of "modular" design, equipped with: power shift transmission, torque converter, planetary axles, power steering and power brakes.

RECORD YOUR SERIAL NUMBERS BELOW

WHEEL LOADER SERIAL NO. _____

ENGINE SERIAL NO. _____

TRANSMISSION SERIAL NO. _____

AXLE SERIAL NO. _____

SERIAL NUMBER LOCATION

LOADER SERIAL NO: On plate attached to the transmission control lever pedestal to the left of the operators seat.

ENGINE SERIAL NO: On plate attached to the right hand side of the engine block above starting motor.

TRANSMISSION SERIAL NO: On plate attached to the right side of the transmission housing.

AXLE SERIAL NO: On plate attached to the axle housing.

NOTICE

To better serve our Customers we have added a "check digit" to validate all part numbers in our numerical index. We have also added zeros to the left of any number which consisted of less than 7 digits in order to conform to the 8 digit system used at our Parts Central Depot. Because this is only a revision to our present Parts Catalog, check digits and zeros have only been added to part numbers on new or revised pages.

EXAMPLE

0's added to conform to 8 digit system. Check Digit

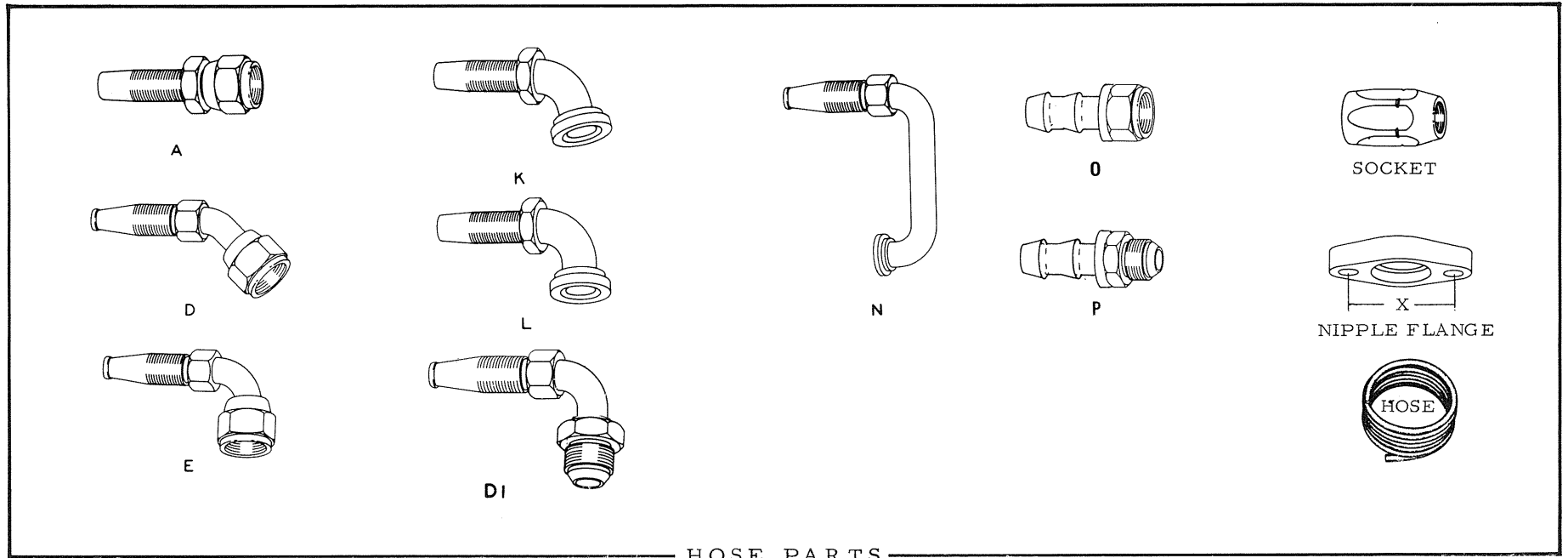
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ALPHABETICAL INDEX

Air Brake System -----	157, 159	Door Assy. (Left) -----	282
Air Cleaner -----	57, 58	Door Assy. (Right) -----	281
Air Compressor -----	164	Drawbar -----	248
Alcohol Injector -----	161, 162	Drive Shaft Assy. -----	115, 116, 119
Alcohol Injector Assy. -----	163	Drive Shaft Group -----	114
Axle & Supports -----	120	Dump Cylinder Assy. -----	213
Axle Housing Assy. (Front Axle) -----	125	Electrical System -----	265
Axle Housing Assy. (Rear Axle) -----	133	Engine Air Heater -----	50
Batteries & Cables -----	261	Engine & Mounting -----	13
Battery Covers -----	262	Engine Controls -----	60
Brake Assy. (Front Axle) -----	140	Exhaust Manifold -----	38
Brake Assy. (Rear Axle) -----	142	Fenders -----	244
Bucket -----	252	Filter	
Bucket (Multi-Purpose) -----	254	Engine Oil -----	36
Bucket Hydraulics (Multi-Purpose) -----	256	Fuel -----	39
Bucket Indicator (Multi-Purpose) -----	257	Hydraulic Tank -----	223
Bucket Level Indicator -----	216	Transmission Oil -----	112, 113
Bucket Leveler -----	220	Flex Disk & Converter Drive -----	73
Boom Kick-Out -----	218	Flywheel Assy. -----	25
Cab -----	278, 286	Flywheel Housing -----	24
Clutch Cut-Off Valve -----	149	Forward Clutch & Planetary -----	84
Compressor Crankcase -----	168	Frame -----	243
Compressor Cylinder Block -----	166	Front Piping Group -----	211
Compressor Cylinder Head -----	169	Fuel Filter -----	39
Controls (3-Spool Valve) -----	236, 239	Fuel Tank & Lines -----	40
Control Valve Parts -----	229	Generator -----	276
Cowl, Floor Plate & Platform -----	241	Governor -----	170
Crankshaft -----	16	Heater & Defroster -----	297
Cylinder		High Range Clutch -----	90
Bucket (Multi-Purpose) -----	254	High Range Clutch & Trans. Drive Gear --	86
Dump -----	213	Hood -----	244
Lift -----	215	Hose Parts -----	6
Master -----	154	Hyd. & Power Steering Pump & Piping	182, 184
Power Steering -----	181	Hyd. Brake Lines (Front Section) -----	153
Wheel -----	144	Hyd. Brake Lines (Rear Section) ---	147, 150
Cylinder Block -----	14	Hydraulic Controls -----	235
Cylinder Head -----	20	Hydraulic Piping -----	187, 188
Cylinder Parts (Multi-Purpose) -----	258	Hydraulic Piping & Cylinders -----	207
Defroster -----	297	Hydraulic Pump Assy. -----	199
Demand Valve Assy. -----	201, 203	Hydraulic Tank & Controls -----	222
Differential Carrier Assy. (Front Axle) --	123	Hydraulic Tank & Covers -----	225
Differential Carrier Assy. (Rear Axle) --	131	Hydraulic Tank & Valve -----	227
Discharge Tube, Hydraulic Tank -----	224	Hydraulic Tank Filter -----	223
Door Assy. -----	289	Idler Gear Assy. -----	19

ALPHABETICAL INDEX

Injection Nozzles & Lines -----	48	Shaft & Hub (Front Axle) -----	127
Injection Pump -----	46	Shaft & Hub (Rear Axle) -----	135
Instrument Panel & Gauges -----	273, 275	Starter -----	277
Intake Manifold -----	37	Steering Gear Assy. -----	177
Ladder & Hand Rail -----	249	Steering Gear, Cylinder & Piping -----	172
Lift Cylinder Parts -----	215	Steering Pump, Demand Valve & Lines	191, 195
Light Assembly Parts -----	270	Strainer & Magnet -----	224
Lights & Wiring -----	269	Suction Fan Group -----	68
Linkage Group -----	251	Tail Light Assy. -----	267
Low Range Clutch & Transfer Drive Gear --	88	Tank, Fuel -----	40
Master Cylinder Assy. -----	154	Tank, Hydraulic -----	222, 225
Mechanical Fuel Shut-off -----	61	Thermostat & Housing -----	63
Multi-Purpose Bucket -----	254	Tie-Rod Assy. -----	175
Nozzle Holder Assy. -----	47	Timing Gear Housing -----	26
Oil Cooler -----	34	Tires -----	260
Oil Filter -----	36	Torque Converter -----	75
Oil Pan -----	28, 30	Torque Converter Housing -----	76
Oil Pump -----	31, 32	Transmission -----	70
Packaged Parts -----	8	Transmission Charging Oil Pump -----	98
Painting & Marking -----	295	Transmission Control Group -----	104
Parking Brake Assembly Parts -----	137	Transmission Control Valve -----	100
Parking Brake Control -----	138	Trans. Cooling Lines, Filter & Mounting -	111
Piston & Connecting Rod -----	18	Transmission Housing & Covers -----	80
Platform -----	241	Transmission Oil Filter -----	112, 113
Power Steering Cylinder -----	181	Transmission Rear Housing -----	96
Power Steering Pump Assy. -----	204, 205	Turbocharger -----	53
Power Takeoff -----	99	Turbocharger Assembly Parts -----	54
Primer Pump & Lines -----	42, 44	Turbine Driven Gears & Freewheel Unit ---	78
Pump		Universal Joint Cartridge & Support ----	117
Engine Oil -----	31, 32	Valve	
Fuel Injection -----	46	Clutch Cut-off -----	149
Hydraulic -----	199	Demand -----	201, 203
Power Steering -----	204, 205	Engine Oil Pressure -----	15
Primer -----	42, 44	Hydraulic Control -----	229
Transmission Charging Oil -----	98	Steering Gear -----	177
Water -----	66	Transmission Control -----	100
Radiator -----	69	Valve Operating Mechanism -----	22
Radiator Support, Hood & Fenders ----	244	Water Filter -----	64
Rear Axle Disconnect -----	94	Water Pump & Fan -----	66
Rear Axle Disconnect Controls -----	107, 109	Wheel Cylinder Assy. Parts -----	144
Rear Output Group -----	93	Wheel Group -----	259, 260
Relief Valve Assy. -----	197	Window Assy. (Rear) -----	284
Reverse Clutch & Planetary -----	83	Wiper Group -----	291
Seat & Mounting -----	247	Wiper Group (Rear) -----	294



HOSE PARTS

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	
3041394	920720	17-5/8	920805		O	920800		P				3042611
	920221					920852	920344	A	919281	920412	2-1/2	3043064
	920221	49	920852	920344	O	920867	919277	E	919281			3043152
	920388	26-1/4	920389		P	920806		O				3043323
	920388	24-3/8	920806		O	920806		O				3043344
	920720	38-1/2	920829		Comp	920805		O				3043347
	920793	40-3/8	920942	921562	A	920942	921562	A	920971			3043353
	920221	41-7/8	920852	920344	A	920867	919277	E	919281			3043426
	920720	47-1/2	920805		O	920805		O				3044096

	919156	10-3/4	920865		E	920805		E			3044141
	924031	21-1/4	924043		K	924041		A			3044142
	920794	32	923506	922894	L	923506	922894	L	920972		3044144
	920794	32	923506	922894	L	923506	922894	L	920972		3044145
	920795	22-1/4	920945	922831	A	920945	922831	A	920973		3044146
	920795	13-3/8	3011219		L	3011219		L			3044147
	920794	29-3/4	923506	922894	L	921020	922830	A	920972		3044149
	920795	17-1/4	925073		K	920945	922831	A	920973		3044150
	924031	74-3/4	924043		D1	924042	923660	E			3044151
	920794	32	923506	922894	L	923506	920894	L	920972		3044164
	920794	32	923506	922894	L	923506	922894	L	920972		3044165
	920793	77-1/4	920951	921563	E	920961	921302	D1	920971		3044172
	920795	9-3/8	925224		K	920945	922831	A	920973		3044173
	920221	68-1/4	920874	921042	E	920852	920344	A	919281		3044174
	920795	11	3011219		L	925075		K			3044196
	920795	11-3/8	925075		K	920945		A			3044242
	919156	25-1/2	920902	921226	A	920902	921226	A	919820		3044967
	924031	16-1/4	924041		A						3044978
	920795	58-3/4	920945	922831	A	920945	922831	A	920973		3045624
	920795	35-1/8	920945		A	920945		A			3045625
	920795	28	924239		K	3011219		L	920973		3045838
	920221	65-3/4	920874	921042	E	920874	921042	E	919281		3045845
	920795	33-3/16	923486			920958					3047084
	920795	20-1/2	3011219		L	920945		A			3047086
	920794		3050486		N	3050487		D			3050430
	920795	24-1/4	3050483		N	925267		L	920973		3050432
	920795	32-1/2	925267		L	923486		J	920973		3053413
	920794	13-1/4	920962	921564	D	923904		J	920972		3053427
	920795	10-1/2	925267		L			N			3053731
	922337	55-3/4	920867	919277	E	920874	921042	E			3055286
	922356	44-1/2	925267		L	927337		L			3055287
	922356	26			L			N			3055288

PACKAGED PARTS

PACKAGE NO.	DESCRIPTION
-----	REPAIR KIT, cylinder (See DUMP CYLINDER)
-----	REPAIR KIT, cylinder (See LIFT CYLINDER)
-----	REPAIR KIT, cylinder (See POWER STEERING CYLINDER)
-----	REPAIR KIT, master cylinder (See MASTER CYLINDER ASSY.)
-----	REPAIR KIT, wheel cylinder (See WHEEL CYLINDER ASSY.)
-----	LINING KIT (See BRAKE ASSY.)
-----	DECAL KIT (See PAINTING AND MARKING)
-----	RING SET, piston (See PISTON AND CONNECTING ROD)
-----	REPAIR KIT, pump (See WATER PUMP)
 3022040-4	 SPACER KIT, pinion bearing, front axle
	1 3022446-3 SPACER (.259" thick)
	1 3022447-1 SPACER (.260" thick)
	1 3022448-9 SPACER (.261" thick)
	1 3022449-7 SPACER (.262" thick)
	1 3022450-5 SPACER (.263" thick)
	1 3022451-3 SPACER (.264" thick)
 3022041-2	 SPACER KIT, pinion bearing, front axle
	1 3022452-1 SPACER (.270" thick)
	1 3022453-9 SPACER (.276" thick)
	1 3022454-7 SPACER (.282" thick)
	1 3022455-4 SPACER (.288" thick)
	1 3022456-2 SPACER (.294" thick)
 3024603-7	 SPACER KIT, pinion cage, rear axle
	1 3024605-2 SPACER (.219" thick)
	1 3024606-0 SPACER (.220" thick)
	1 3024607-8 SPACER (.221" thick)
	1 3024608-6 SPACER (.222" thick)
	1 3024609-4 SPACER (.223" thick)
	1 3024610-2 SPACER (.224" thick)
 3024611-0	 SPACER KIT, pinion cage, rear axle
	1 3024612-8 SPACER (.230" thick)
	1 3024613-6 SPACER (.236" thick)
	1 3024614-4 SPACER (.242" thick)
	1 3024615-1 SPACER (.248" thick)
	1 3024616-9 SPACER (.254" thick)
 3024625-0	 SHIM KIT, pinion bearing cage assy., rear axle
	1 3024624-3 SHIM (.003" thick)
	1 3024626-8 SHIM (.005" thick)
	1 3024627-6 SHIM (.010" thick)

PACKAGED PARTS

PACKAGE NO.	DESCRIPTION	
3046168-5	SEAL AND GASKET KIT, transmission (2-speed forward, 1-speed reverse)	
24	3021041-3	NUT
1	3021053-8	SEAL, oil, shifter shaft
2	3021056-1	GASKET, strainer and core cover
1	3021058-7	RING, seal
1	3027012-8	RING, seal, cover
1	3031847-1	CUP, cut-off plug
1	3035714-9	RING, seal, hi-clutch
2	3039422-5	SEAL, oil, valve
2	3042138-2	SEAL KIT (Includes expander)
2	3042146-5	SEAL KIT (Includes expander)
1	3042151-5	SEAL KIT (Includes expander)
6	3044377-4	STRIP, locking, pump retainer
1	3044382-4	RING, seal
1	3044386-5	GASKET, oil pump
1	3044390-7	GASKET, housing, transmission
1	3044400-4	RING, seal, suction tube nut
1	3044402-0	GASKET, cover, oil pump
1	3044409-5	SEAL, oil
1	3044411-1	RING, seal, rear cover
3	3044414-5	NUT
2	3044422-8	RING, seal, 2nd turbine
6	3044460-8	TAB, lock, piston housing
2	3044462-4	SEAL, oil, output shaft
2	3044474-9	GASKET
1	3044485-5	GASKET, trimmer valve
2	3044489-7	GASKET, cut-off plug
6	3046029-9	STRIP, locking
1	3048782-1	GASKET, control valve
1	3051197-6	DIAPHRAGM
1	3054475-3	GASKET, pump, torque converter
1	-----	SEAL, oil (Not used-discard)
1	-----	RING, seal (Not used-discard)
1	-----	INSTRUCTION SHEET

3046957-1	SEAL AND GASKET KIT, transmission (2-speed forward, 2-reverse)	
24	3021041-3	NUT, converter cover
1	3021053-8	SEAL, oil, shaft
3	3021056-1	GASKET, strainer assy.
1	3021058-7	RING, seal cut-off, valve plug
2	3021121-3	RING, seal, low piston
1	3026156-4	SEAL, oil, pump body
1	3027012-8	RING, seal, cover
1	3027016-9	RING, seal converter drive
1	3031847-1	CUP, plug
1	3039422-5	SEAL, range selector valve
1	3042138-2	SEAL KIT (Includes expander)
1	3042146-5	SEAL KIT (Includes expander)
1	3042147-3	SEAL KIT (Includes expander)
1	3044377-4	STRIP, locking, pump retainer
1	3044382-4	RING, seal, input gear
1	3044386-5	GASKET, oil pump
1	3044390-7	GASKET, transmission housing

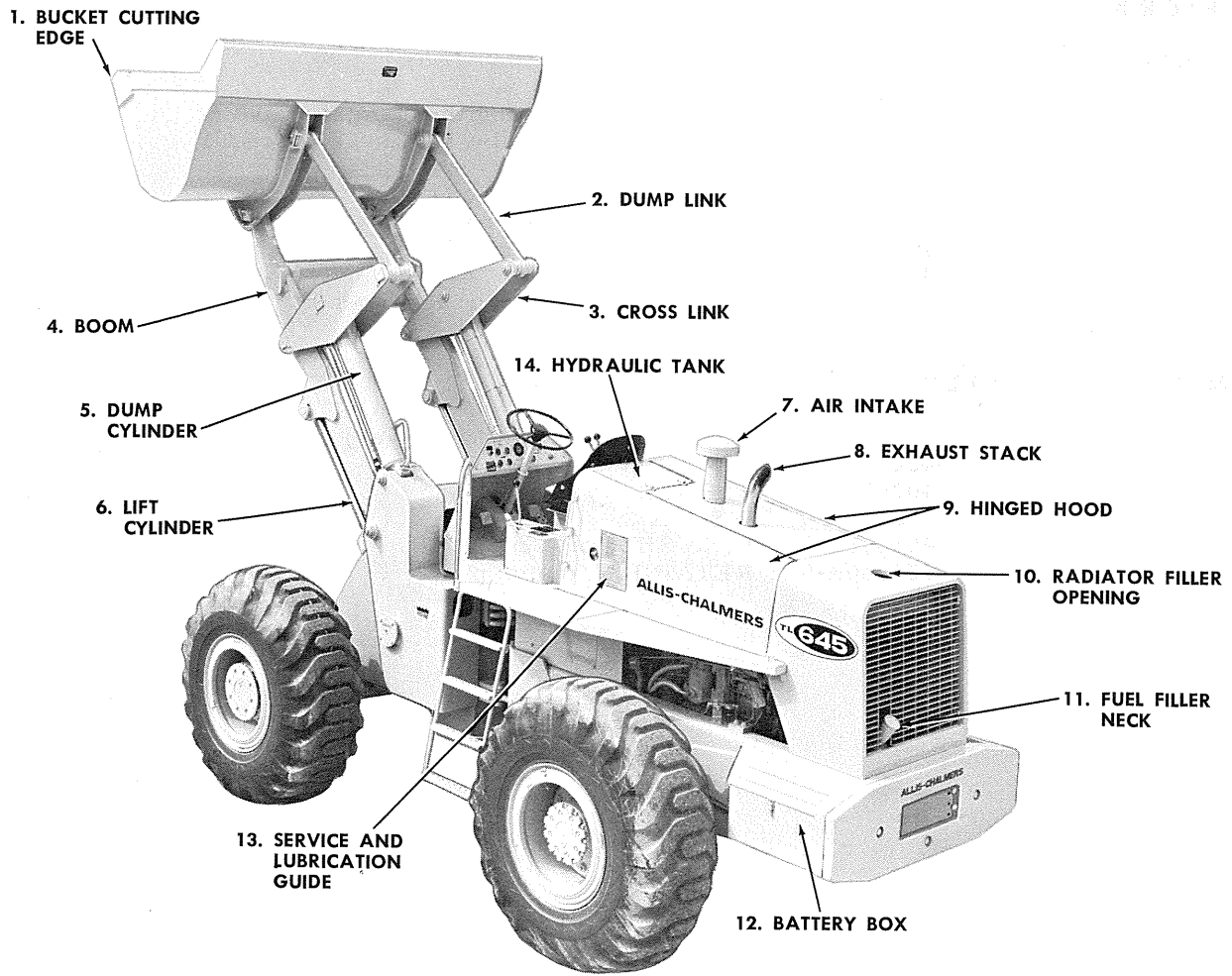
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PACKAGED PARTS

PACKAGE NO.	DESCRIPTION
3046957-1	SEAL AND GASKET KIT, transmission (2-speed forward, 2-reverse)(Cont.
1	3044400-4 RING, seal, nut, suction tube
1	3044402-0 GASKET
1	3044409-5 SEAL, accessory drive
1	3044411-1 RING, seal, rear housing
2	3044414-5 NUT, drive flange
2	3044422-8 RING, seal, ground sleeve
3	3044462-4 SEAL, oil
2	3044474-9 GASKET, plug
1	3044485-5 GASKET, trimmer valve
1	3044489-7 GASKET, cut-off, valve plug
1	3045285-8 GASKET, adapter, rear housing
2	3045289-0 RING, seal
1	3045313-8 SEAL KIT (Includes expander)
1	3045320-3 GASKET, rear housing
1	3045327-8 SEAL, oil
1	3048782-1 GASKET, control valve
1	3051197-6 DIAPHRAGM AND SEAL ASSY.
1	3054475-3 GASKET, pump
4027283-3	GASKET KIT, intermediate
1	0226012-3 GASKET, drain plug
1	0923376-8 O-RING, rear plate (Not used-discard)
2	0923649-8 O-RING, oil cooler
4	0923664-7 O-RING, oil cooler
1	0923684-5 O-RING, volute
1	0923814-8 O-RING, oil cooler
1	0923816-3 O-RING, adapter
1	0923817-1 O-RING, drive housing
1	0923822-1 O-RING, water pump
1	4020879-5 O-RING, rear plate
1	4025019-3 GASKET, cover plate
2	4025021-9 GASKET, cover plate
2	4025080-5 GASKET, cover plate
1	4025097-9 O-RING, rear plate
1	4025106-8 GASKET, inlet pipe
2	4025120-9 GASKET, oil filter
1	4025306-4 GASKET, cover plate (Not used-discard)
1	4025343-7 GASKET, cover
1	4025367-6 GASKET, oil cooler (Not used-discard)
1	4025622-4 GASKET, compressor bracket
2	4025632-3 GASKET, oil cooler
1	4026548-0 GASKET, inspection plate
1	4027751-9 GASKET, front cover
1	4027752-7 GASKET, front plate
1	4105456-0 GASKET, plug (Not used-discard)
1	4336676-4 GASKET, timing hole (Not used-discard)
1	4337740-7 GASKET, cover (Not used-discard)
1	4349984-7 GASKET, oil cooler (Not used-discard)
1	4371289-2 GASKET, cover plate (Not used-discard)

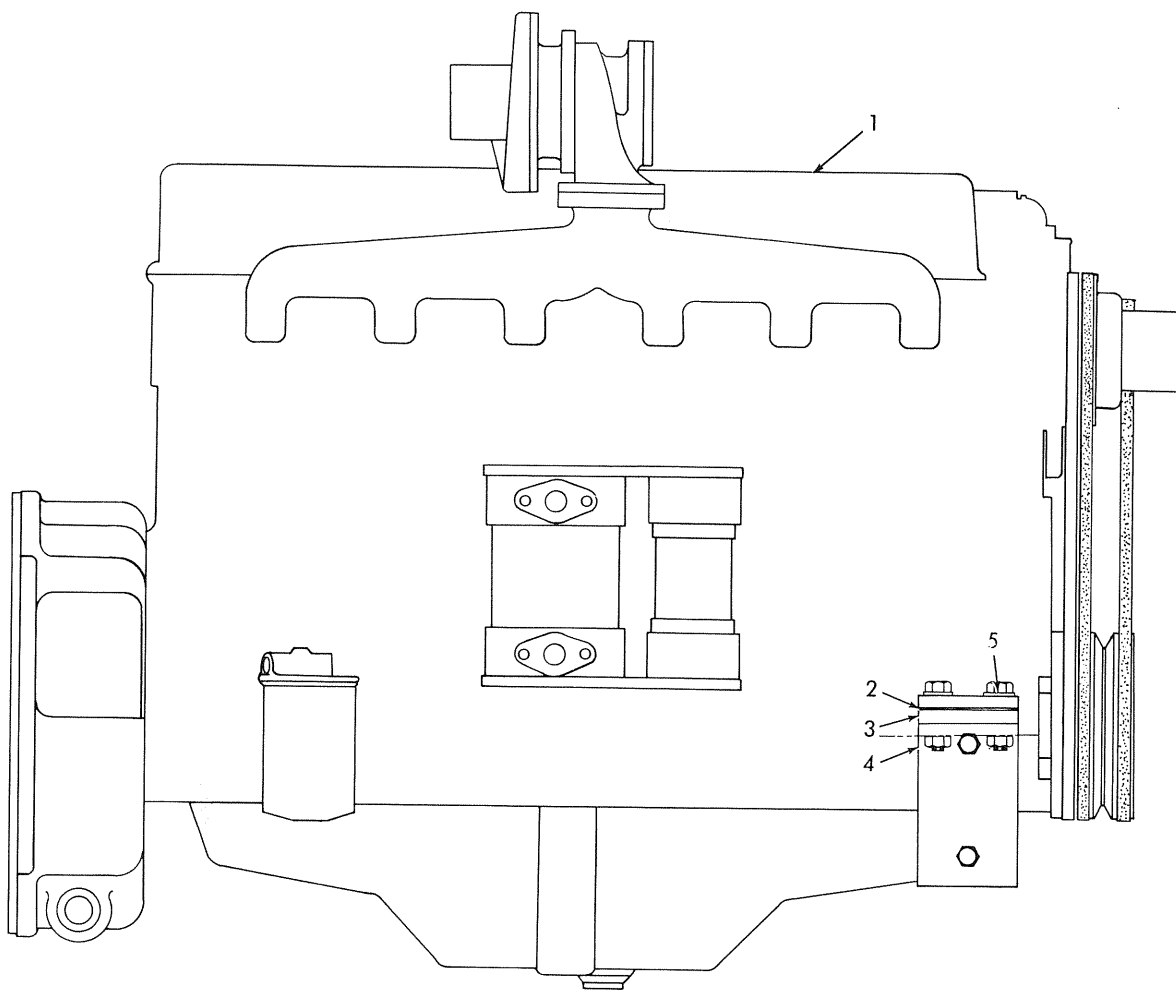
PACKAGED PARTS

PACKAGE NO.	DESCRIPTION	
4027785-7	GASKET KIT, cylinder head	
	2	4025101-9 GASKET, flange and thermostat housing
	1	4025106-8 GASKET, water inlet (Not used-discard)
	6	4025150-6 GASKET, injection nozzle
	1	4025472-4 GASKET, cylinder head cover
	6	4026573-8 GASKET, exhaust manifold
	1	4026579-5 GASKET, intake manifold
	6	4027013-4 RING, fire
	1	4027598-4 GASKET ASSY., cylinder head
4028090-1	SLEEVE KIT (Includes piston)	
	2	4025015-1 RING, cylinder sleeve (lower)
	1	4025036-7 PIN, piston
	1	4026578-7 SLEEVE, cylinder
	1	4026973-0 PISTON
	1	4026982-1 RING SET, piston
	2	4254608-5 RETAINER, piston pin



MODEL TL645 (Diesel) TRACTOR LOADER

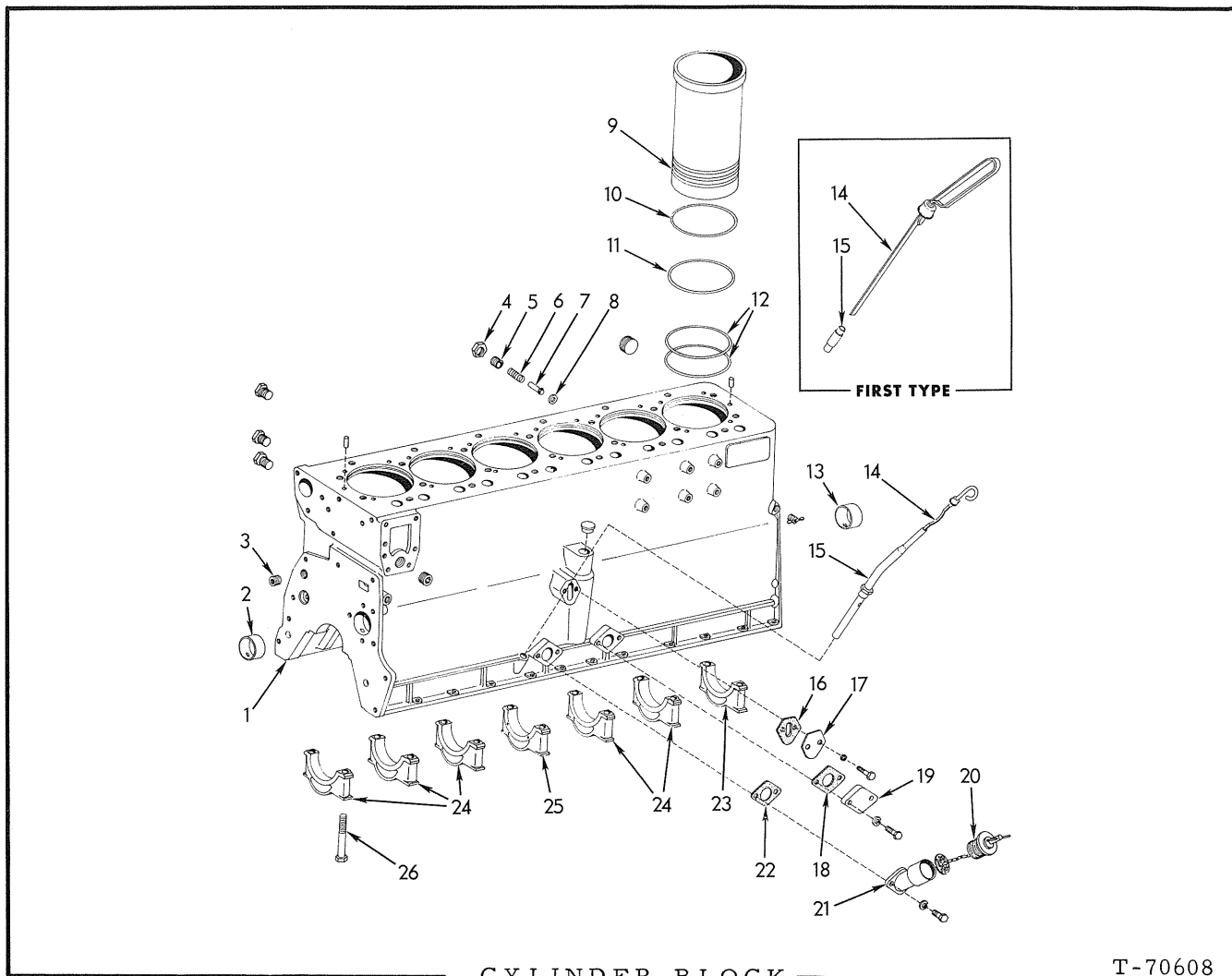
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ENGINE AND MOUNTING

T-70680

ITEM	PART NO.	QTY.	DESCRIPTION
1	4025605-9	1	ENGINE ASSY. (Less air cleaner, fan and starter) (Used prior to engine serial no. 3D-05351, excluding 3D-05195, 3D-05196, 3D-05217 thru 3D-05347)
	4026670-2	1	ENGINE ASSY. (Less air cleaner, fan and starter) (Effective with engine serial no. 3D-05351, including 3D-05195, 3D-05196, 3D-05217 thru 3D-05347)
	0913105-3	6	CAPSCREW, 1/2" NF x 1-1/2"
	0914487-4	6	NUT, safety, 1/2" NF
	0912415-7	2	COCK, drain, 1/4" NPT
2	3043879-0	2	SHIM, engine mounting (.0598" thick. Use as req'd)
3	3043878-2	2	BLOCK, engine mounting
4	3052961-4	1	BRACKET, engine mounting, left
	3052963-0	1	BRACKET, engine mounting, right
5	0915790-0	4	CAPSCREW, 5/8" NF x 3"
	3026289-3	4	WASHER, plain
	0916589-5	4	NUT, safety, 5/8" NF



CYLINDER BLOCK

T-70608

ITEM	PART NO.	QTY.	DESCRIPTION
1	402644 402880 4026943	1	BLOCK ASSEMBLY, cylinder (Includes PLUGS and items 2, 3, 13, & 23 thru 26)
	917542	2	PIN, dowel, 7/16" x 3/4"
	917970	1	PLUG, pipe, 1/2" NPT
	918888	1	PLUG, pipe, 1" NPT
	919134	1	PLUG, pipe, 1/8" NPT
	904223	2	PLUG, pipe, ctsk., 1/2" NPTF
	917536	2	PIN, dowel, 1/2" x 1-3/8"
	908944	2	PLUG, pipe, ctsk., 1/2" NPT
	4025323	1	PLUG, pipe, oil gallery
	4254452	1	PLUG, distributor hole
	4255490	1	PLUG, pipe, 1/8"
	4255491	1	PLUG, pipe, 1/4"
2	4025025	1	BEARING, camshaft, front (Std.)
	4025259	1	BEARING, camshaft, front (.010" undersize)
3	4025392	1	PLUG, pipe, restrictor
4	4510836	1	SCREW, oil pressure regulating valve
	910847	1	NUT, jam, 3/4" NF
5	4025471	1	SPACER, oil pressure regulating valve

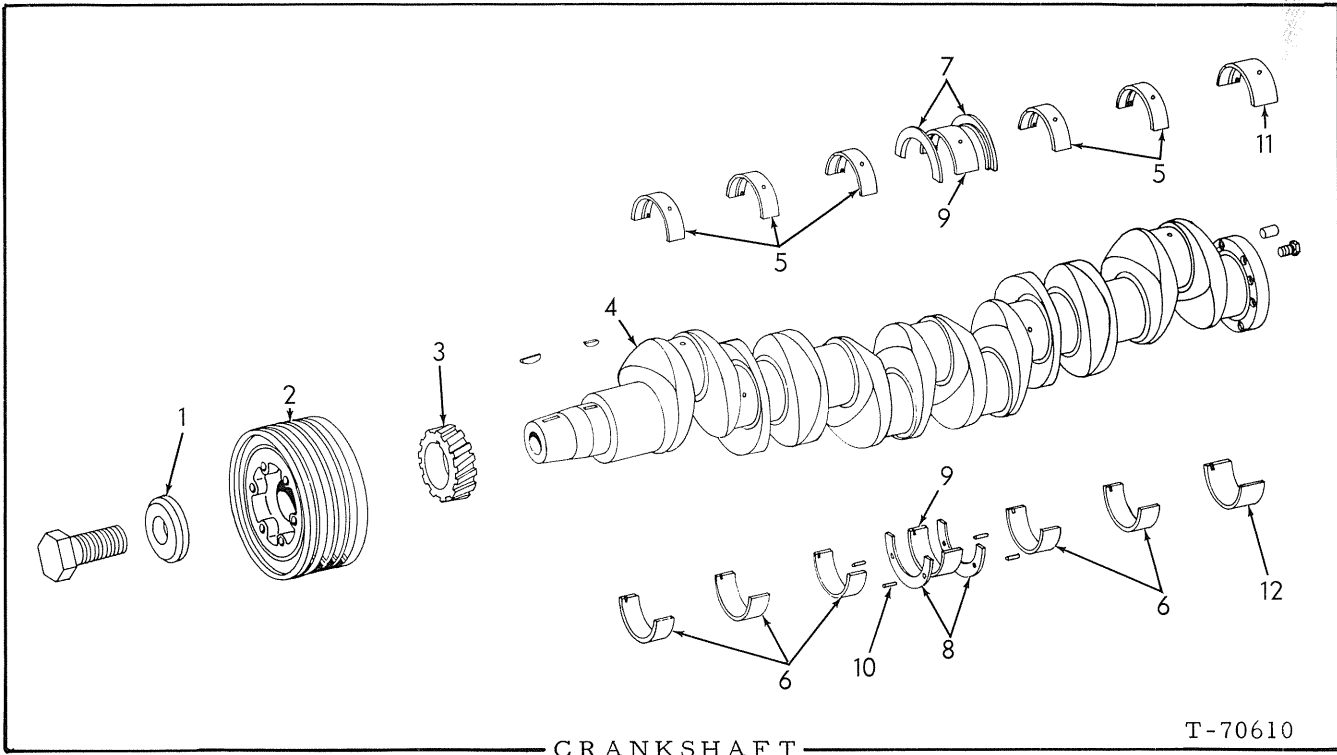
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CYLINDER BLOCK (Continued)

ITEM	PART NO.	QTY.	DESCRIPTION
6	4500231-8	1	SPRING, oil pressure regulating valve
7	4507374-9	1	PISTON, oil pressure regulating valve
8	4507673-4	1	INSERT, oil pressure regulating valve
9	4025013-6	6	<input type="checkbox"/> SLEEVE, cylinder
10	4025298-3	-	SHIM, cylinder sleeve (.005" thick. Use as req'd)
	4025299-1	-	SHIM, cylinder sleeve (.010" thick. Use as req'd)
	4025300-7	-	SHIM, cylinder sleeve (.015" thick. Use as req'd)
	4025301-5	-	SHIM, cylinder sleeve (.020" thick. Use as req'd)
11	4025014-4	6	<input type="checkbox"/> O-RING, cylinder sleeve (Upper) (Used prior to engine serial no. 3D-03992)
12	4025015-1	12	<input type="checkbox"/> O-RING, cylinder sleeve (Lower)
13	4025238-9	5	BEARING, camshaft (Int. & rear) (Std.)
	4025258-7	5	BEARING, camshaft (Int. & rear) (.010" undersize)
14	4026457-4	1	GAUGE, oil level (Used prior to engine serial no. 3D-05351, excluding 3D-05195, 3D-05196, 3D-05217 thru 3D-05347)
	4026592-8	1	GAUGE, oil level (Effective with engine serial no. 3D-05351, including 3D-05195, 3D-05196, 3D-05217 thru 3D-05347)
15	4025314-8	1	ADAPTER, oil level gauge (Used prior to engine serial no. 3D-05351 excluding 3D-05195, 3D-05196, 3D-05217 thru 3D-05347)
	4026849-2	1	ADAPTER, oil level gauge (Effective with loader serial no. 3D-05351 including 3D-05195, 3D-05196, 3D-05217 thru 3D-05347)
16	4025019-3	1	<input type="checkbox"/> GASKET, vacuum line adapter
17	4026383-2	1	PLATE, fuel pump pad
	0915809-8	2	CAPSCREW, 5/16" NC x 3/4"
	0904205-2	2	LOCKWASHER, 5/16"
18	4025021-9	1	<input type="checkbox"/> GASKET, oil filler plate
19	4026382-4	1	PLATE, oil filler hole
	0916269-4	2	CAPSCREW, 3/8" NC x 7/8"
	0904206-0	2	LOCKWASHER, 3/8"
20	4354449-3	1	CLOSURE ASSY. (Serviced only as a unit)
21	4025717-2	1	ELBOW ASSY., oil filler (Includes item 20)
	0914847-9	2	CAPSCREW, 3/8" NC x 1-1/2"
	0904206-0	2	LOCKWASHER, 3/8"
22	4025021-9	1	<input type="checkbox"/> GASKET, elbow oil filler
23	4025247-0	1	CAP, rear main bearing (See Note)
24	4025245-4	5	CAP, intermediate & front main bearing (See Note)
25	4025246-2	1	CAP, center main bearing (See Note)
26	4025062-3	14	CAPSCREW, main bearing caps

NOTE: Replacement bearing caps are semi-finished and must be line-bored after installing.

(Also see PACKAGED PARTS)

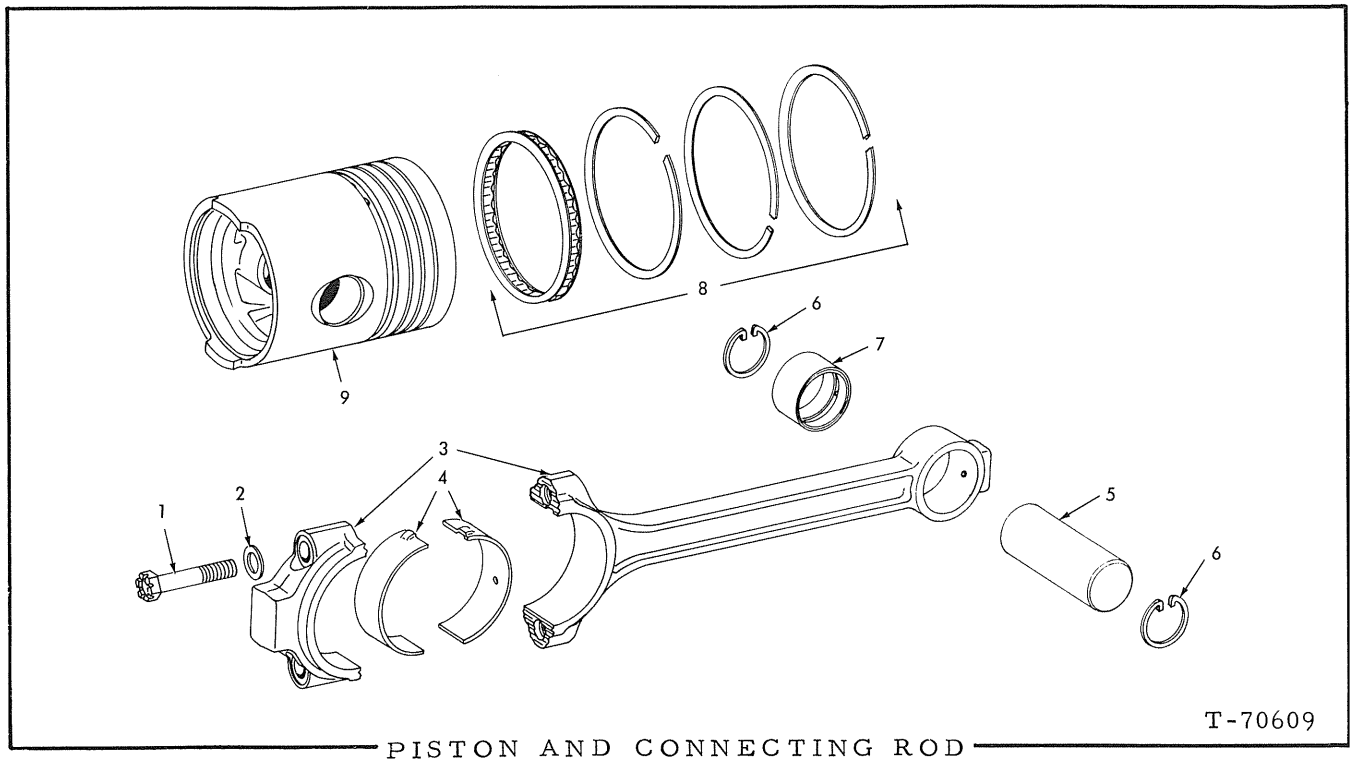


ITEM	PART NO.	QTY.	DESCRIPTION
1	4025115	1	WASHER, pulley
	918297	1	CAPSCREW, 1" NF x 2"
2	4025589	1	PULLEY, crankshaft
	905845	1	KEY, woodruff, 1/4" x 7/8"
3	4025041	1	GEAR, crankshaft
	905845	1	KEY, woodruff, 1/4" x 7/8"
4	4025478	1	CRANKSHAFT ASSEMBLY (Includes PLUG)
	919840	1	PLUG, pipe, 1/4" NPT (Used prior to engine serial no. 3D-07441)
5	4025006	5	BEARING, front & intermediate, upper (Std.)
	4025271	5	BEARING, front & intermediate, upper (.002")
	4025272	5	BEARING, front & intermediate, upper (.010")
	4025273	5	BEARING, front & intermediate, upper (.020")
	4025274	5	BEARING, front & intermediate, upper (.030")
6	4025275	5	BEARING, front & intermediate, upper (.040")
	4025007	5	BEARING, front & intermediate, lower (Std.)
	4025266	5	BEARING, front & intermediate, lower (.002")
	4025267	5	BEARING, front & intermediate, lower (.010")
	4025268	5	BEARING, front & intermediate, lower (.020")
	4025269	5	BEARING, front & intermediate, lower (.030")
	4025270	5	BEARING, front & intermediate, lower (.040")

(Continued)

C R A N K S H A F T (Continued)

ITEM	PART NO.	QTY.	DESCRIPTION
7	4025010	2	FLANGE, thrust, upper (Std.)
	4025263	2	FLANGE, thrust, upper (.005")
	4025264	2	FLANGE, thrust, upper (.010")
	4025265	2	FLANGE, thrust, upper (.015")
8	4025011	2	FLANGE, thrust, lower (Std.)
	4025260	2	FLANGE, thrust, lower (.005")
	4025261	2	FLANGE, thrust, lower (.010")
	4025262	2	FLANGE, thrust, lower (.015")
9	4025292	1	BEARING KIT, center (Std.)
	4025293	1	BEARING KIT, center (.002")
	4025294	1	BEARING KIT, center (.010")
	4025295	1	BEARING KIT, center (.020")
	4025296	1	BEARING KIT, center (.030")
	4025297	1	BEARING KIT, center (.040")
NOTE: Each bearing kit listed above includes upper and lower bearings, set of standard thrust flanges and groove pins.			
10	4251746	4	PIN, groove, thrust flange
11	4025008	1	BEARING, rear, upper (Std.)
	4025281	1	BEARING, rear, upper (.002")
	4025282	1	BEARING, rear, upper (.010")
	4025283	1	BEARING, rear, upper (.020")
	4025284	1	BEARING, rear, upper (.030")
	4025285	1	BEARING, rear, upper (.040")
12	4025009	1	BEARING, rear, lower (Std.)
	4025276	1	BEARING, rear, lower (.002")
	4025277	1	BEARING, rear, lower (.010")
	4025278	1	BEARING, rear, lower (.020")
	4025279	1	BEARING, rear, lower (.030")
	4025280	1	BEARING, rear, lower (.040")

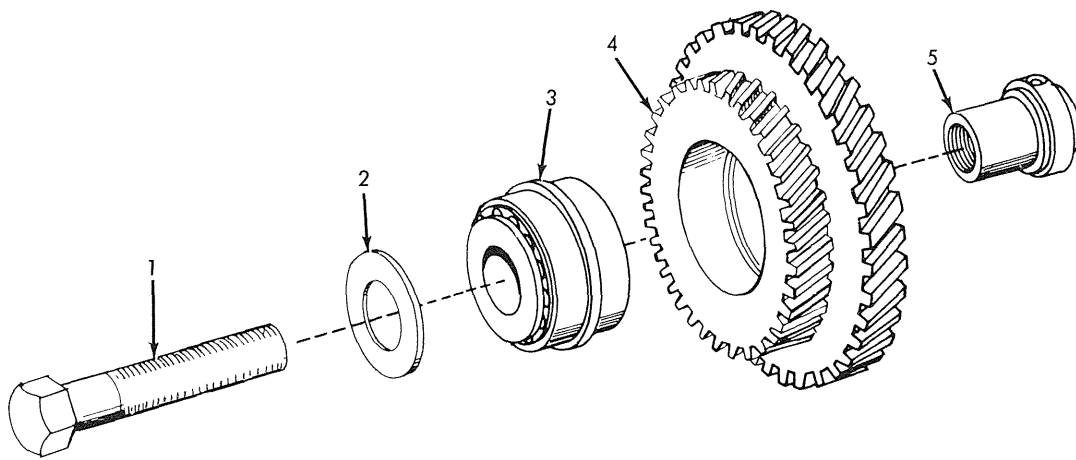


PISTON AND CONNECTING ROD

T-70609

ITEM	PART NO.	QTY.	DESCRIPTION
1	4027334	12	CAPSCREW, connecting rod
2	4025070	12	WASHER, flat, connecting rod
3	4027332	6	ROD ASSEMBLY, connecting (Includes items 1, 2 and 7)
4	4025030	12	BEARING, connecting rod (Std.)
	4025253	12	BEARING, connecting rod (.002")
	4025254	12	BEARING, connecting rod (.010")
	4025255	12	BEARING, connecting rod (.020")
	4025256	12	BEARING, connecting rod (.030")
	4025257	12	BEARING, connecting rod (.040")
5	4026505	6	□PIN, piston
6	4254608	12	□RETAINER, piston pin
7	4025031	6	BUSHING, connecting rod
8	4026982	6	□RING SET, piston
9	4026973	6	□PISTON

□(Also see PACKAGED PARTS)



T-70758

IDLER GEAR ASSEMBLY

ITEM	PART NO.	QTY.	DESCRIPTION
1	921539	1	CAPSCREW, retaining idler gear
2	4025461	1	WASHER, idler gear cap screw
3	4025082	1	BEARING ASSEMBLY, idler gear
4	4027769	1	GEAR, idler
	922546	4	CAPSCREW, 1/2" NF x 1" (Used prior to engine serial #3D-02980)
5	4020102	1	SHAFT, idler gear