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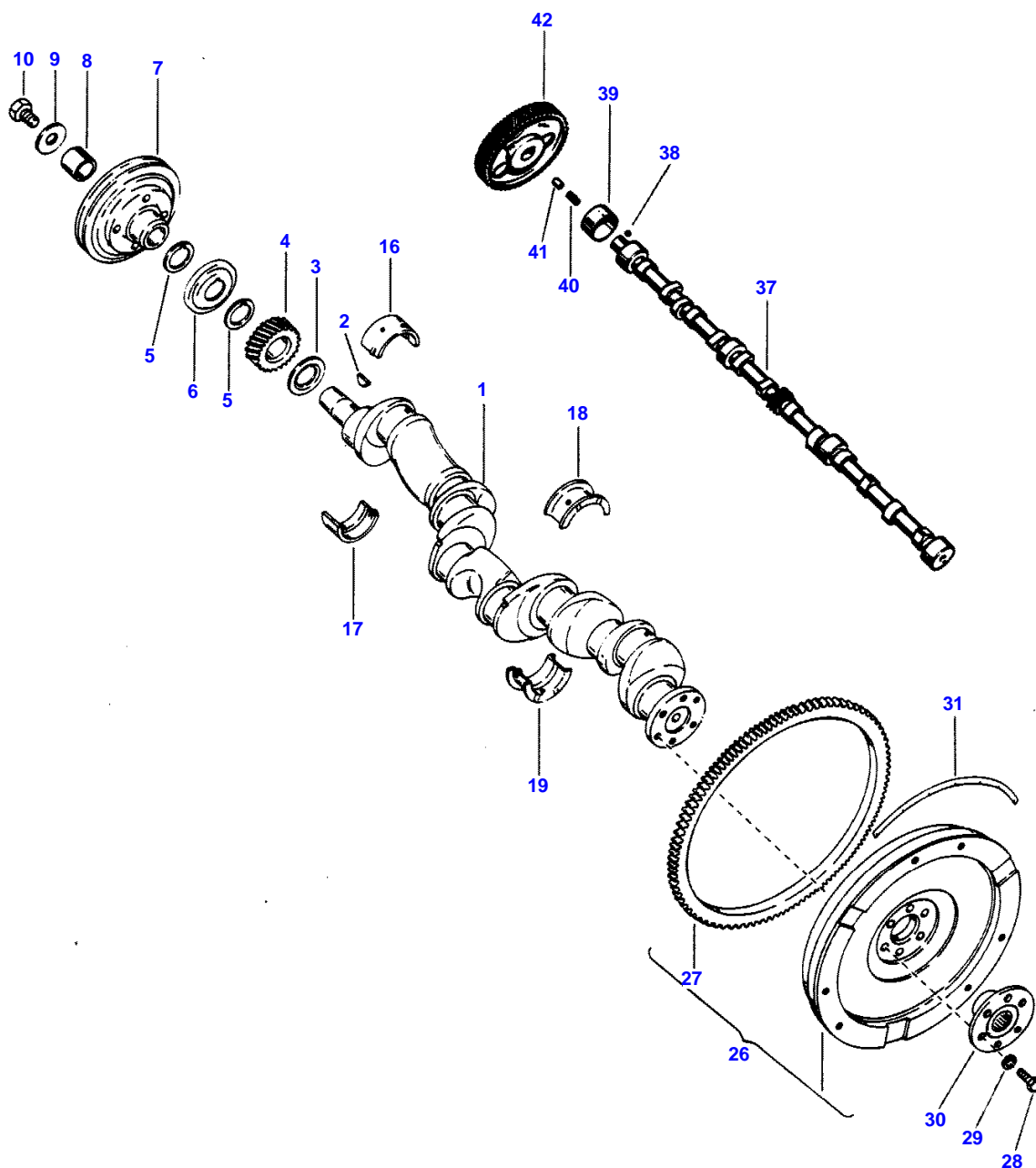
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CRANKSHAFT, FLYWHEEL AND MAIN BEARINGS (GAS)

BE 922-1



1st Print

651 203 M97 (Issue 1) 2/73

Item	Part Number	Qty	Description
1	1034393M1	1	(A) Crankshaft
	1032581M1	1	(B) Crankshaft (Order 1034393M1 And 1034394M1)
2	22134X	1	Key (#708 Hi-Pro)
3	1032588M1	1	Spacer, Crankshaft Gear
4	1032587M1	1	Gear, Crankshaft
5	1032603M1	2	Gasket, Oil Thrower
6	1032590M1	1	Thrower, Oil
7	1032557M91	1	Pulley Assembly
8	1032589M1	1	Taper, Crankshaft Pulley
9	1032658M1	1	Washer, Pulley (11/16 x 2 x 3/16")
10	353607X1	1	Bolt (5/8 x 1" NF, Hex.)
	836033M91	1	Insert Kit (Std.)
16	1032598M1	3	Insert (Top) (Front, 1st Intermediate, Rear)
17	1032597M1	3	Insert (Lower) (Front, 1st Inter., Rear)
18	1032599M1	1	Insert (Top) (2nd Intermediate)
19	1032600M1	1	Insert (Lower) (2nd Intermediate)
	836034M91	1	Insert Kit (-.020")
16	1032614M1	3	Insert (Top) (Front, 1st, Intermediate, Rear)
17	1032612M1	3	Insert (Lower) (Front, 1st Intermediate, Rear)
18	1032616M1	1	Insert (Top) (2nd Intermediate)
19	1032618M1	1	Insert (Lower) (2nd Intermediate)
	836035M91	1	Insert Kit (-.040")
16	1032615M1	3	Insert (Top) (Front, 1st Intermediate, Rear)
17	1032613M1	3	Insert (Lower) (Front, 1st Intermediate, Rear)
18	1032617M1	1	Insert (Top) (2nd Intermediate)
19	1032619M1	1	Insert (lower) (2nd Intermediate)
26	1032767M91	1	(C) Flywheel Assembly (Incl. Item 27)
	1034081M91	1	(D) Flywheel Assembly (Incl. Item 27)
	1032591M91	1	(E) Flywheel Assembly (Incl. Item 27)
27	1032592M1	1	Gear, Flywheel Ring
28	1032648M1	6	Bolt (7/16 x 1-1/4" NF, Hex., Special)
29	359404X1	6	Washer (7/16" Int. Tooth Lock)
30	1034394M1	1	(A) Adapter, Flywheel
	1032594M1	1	(B) Adapter, Flywheel (Order 1034394M1)
31	1032593M1	1	Strip, Flywheel Timing

CAMSHAFT

37	1032523M1	1	Camshaft
38	13611X	1	Key (#13 Woodruff)
39	1032602M1	1	Bushing, Camshaft, Front
40	1032637M1	1	Spring, Camshaft Thrust Button
41	1032524M1	1	Button, Camshaft Thrust
42	1032525M1	1	Gear, Camshaft

(A) - Used Engine Serial Number 125771, 125787, 127197, 127212, 127228 And 130327 And Up.

(B) - Used Prior To Engine Serial Number 130327 Except For 125771, 125787, 127197, 127212 And 127228.

(C) - Used Engine Serial Number 120027 And Up.

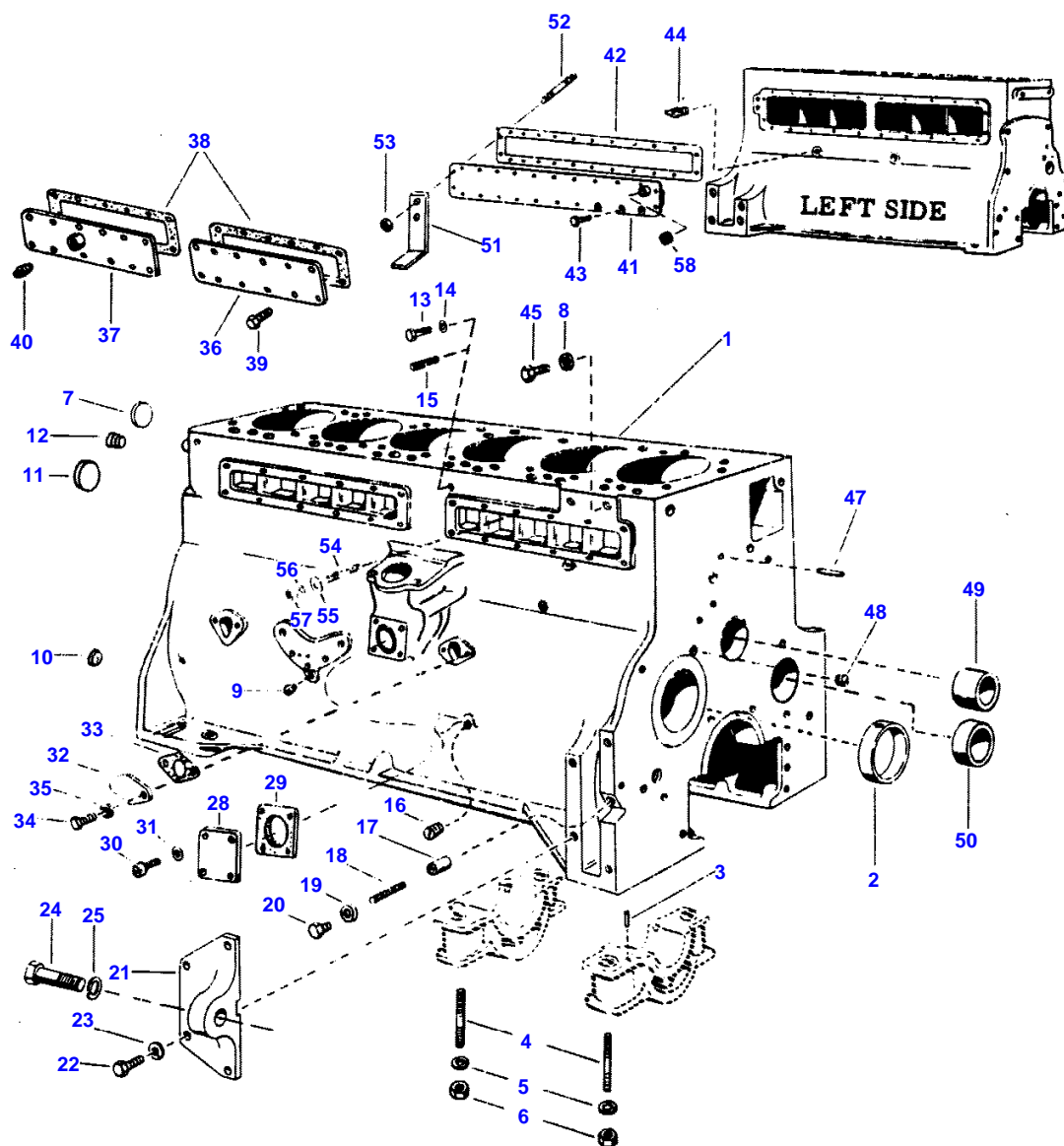
(D) - Used Engine Serial Number 115752 To 120027.

(E) - Used Prior To Engine Serial Number 115752. For Repairs Order 1034081M91, Flywheel; 1033648M1 Adapter, Plate And 1033649M1 Timing Hole Cover.

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CYLINDER BLOCK (GAS)

BE 921-1



Item	Part Number	Qty	Description
	514522M92	1	Engine Assembly (Complete)
	1032757M91	1	Block Assembly, Short (Incl. Crankshaft And Brgs. Conn. Rod., Pistons & Camshaft)
1	1032578M91	1	Block Assembly (Stripped)
2	1032602M1	1	Bushing, Camshaft, Front
3	363838X1	8	Pin, Dowel, Main Bearing Cap
4	1032656M1	8	Stud (9/16" NC-NF x 4-1/16")
5	353447X1	8	Washer (9/16" Lock)
6	365673X1	8	Nut (9/16" NF., Hex.)
7	1032664M1	1	Plug (1" Expansion, Brass)
8	17186X	8	Washer (3/8" Flat)
9	356039X1	1	Plug (1/8 P.T. Hex. Sckt. Hd.)
10	1032647M1	1	Plug (21/32" Cup Type)
11	1032663M1	1	Plug (2" Expansion, Brass)
12	22728X	3	Plug (1/4" P.T. Sq. Sckt.)
13	353664X1	1	(A) Bolt (1/4 x 3/8" NC, Hex.)
14	1002044M1	1	(A) Washer (17/64 x 1/2 x 1/16")
15	834020M1	1	(B) Stud (1/4" NC-NF x 3/4")
16	195591M1	4	Plug (1/8" P.T. Sltd.)
17	1032604M1	1	Plunger, Oil Relief Vavle
18	1032636M1	1	Spring, Plunger
19	22239X	1	Gasket (9/16 x 13/16 x 3/32")
20	1032628M1	1	Screw, Relief Valve
21	1032559M1	2	Support, Engine Front
22	353724X1	8	Bolt (1/2 x 1-1/2" NC, Hex.)
23	353439X1	8	Washer (1/2" Lock)
24	354714X1	2	Bolt (3/4 x 2-1/2" NC, Hex.)
25	353440X1	2	Washer (3/4" Lock)
28	1032632M1	1	Cover
29	1032560M2	1	Gasket, Cover
30	357445X1	4	Screw (#10 - 24 x 5/8" Sltd. Hd.)
31	1032659M1	4	Washer (3/16 x 11/32 x 1/32" Copper)
32	1032627M1	1	Plate, Cover
33	1032518M2	1	Gasket, Cover Plate
34	353679X1	2	Bolt (5/16 x 1" NC, Hex.)
35	1032661M1	2	Washer (21/64 x 1/2 x 1/32" Copper)
36	1032606M1	1	Plate, Cover, Right Front
37	1032607M91	1	Plate Assembly, Cover, Right Rear
38	1032605M1	2	Gasket, Cover Plate
39	353665X1	22	Bolt (1/4 x 1/2" NC, Hex.)
40	375182X1	2	Plug (1/2" P.T. Sq. Hd.)
41	1032582M91	1	Cover Assembly, Left
42	1032519M1	1	Gasket, Cover
43	353665X1	22	Bolt (1/4 x 1/2" NC, Hex.)
44	763716M1	1	Drain, Cock
45	353896X1	3	Bolt (3/8 x 1/2" NC, Hex.)
47	1032596M1	1	Tube, Timing Gear Oil (1/4 x 1")
48	355554X1	2	Plug (1/4" P.T., Sltd.)
49	1032601M1	1	Bushing, Governor Gear
50	1032626M1	1	Plug, Idler Hole
51	1033595M1	1	Stop, Governor Lever
52	834114M1	2	Stud (1/4" NC-NF x 1-1/8")
53	353918X1	2	Nut (1/4" NF, Hex.)
54	731374M1	2	Stud
55	353754X1	2	Washer (9/32 x 5/8 x 1/16" Flat)
56	353441X1	2	Washer (1/4" Lock)
57	353918X1	2	Nut (1/4" NF, Hex.)
58	353543X1	1	Bolt (3/8 x 1-5/8" NF, Hex.)

 (A) - Used Late Production Engines.
 (B) - Used Early Production Engines.
 Order 353664X1 Bolt.