

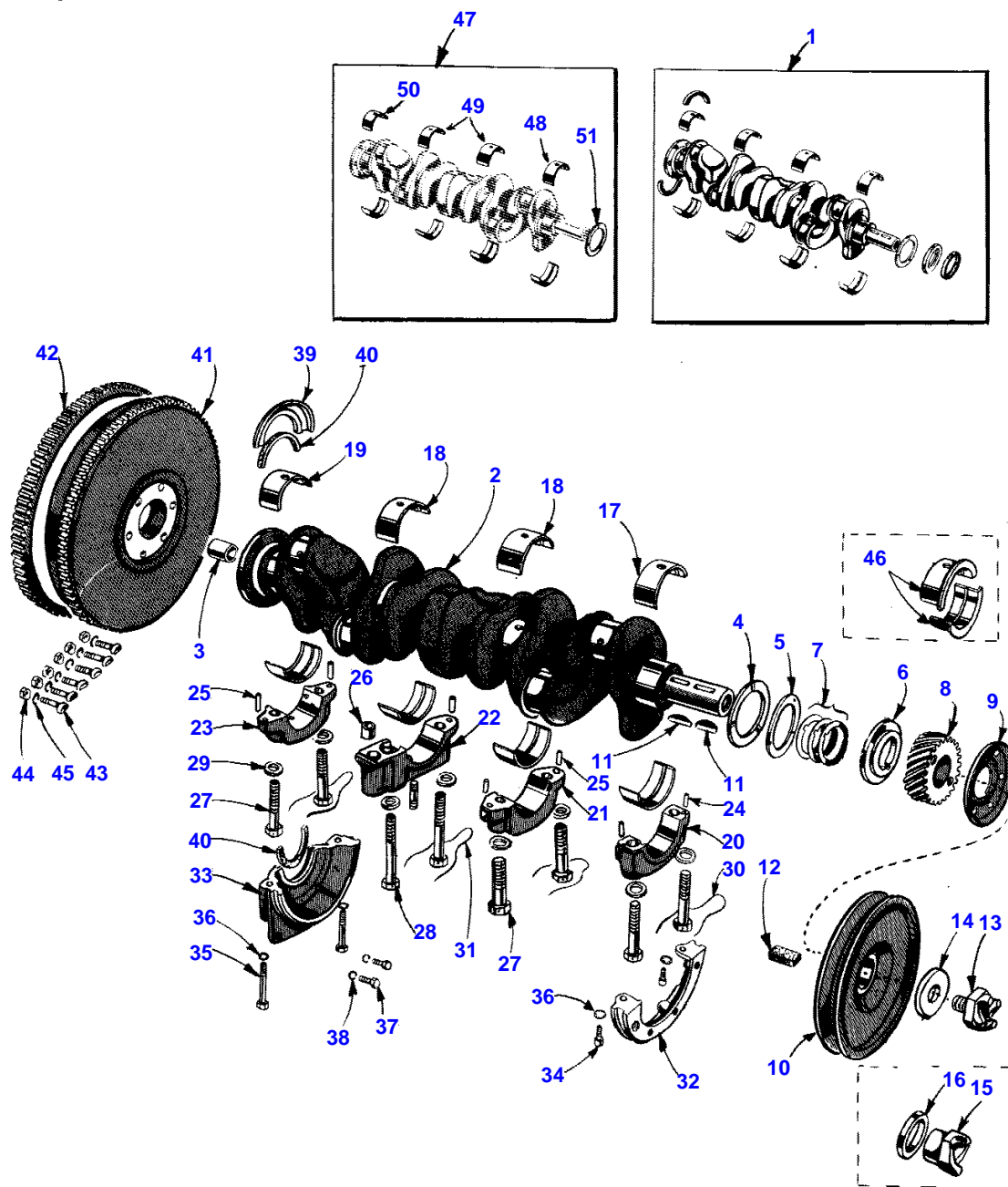
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## CRANKSHAFT, MAIN BEARINGS, CAPS, FILLER BLOCKS AND FLYWHEEL

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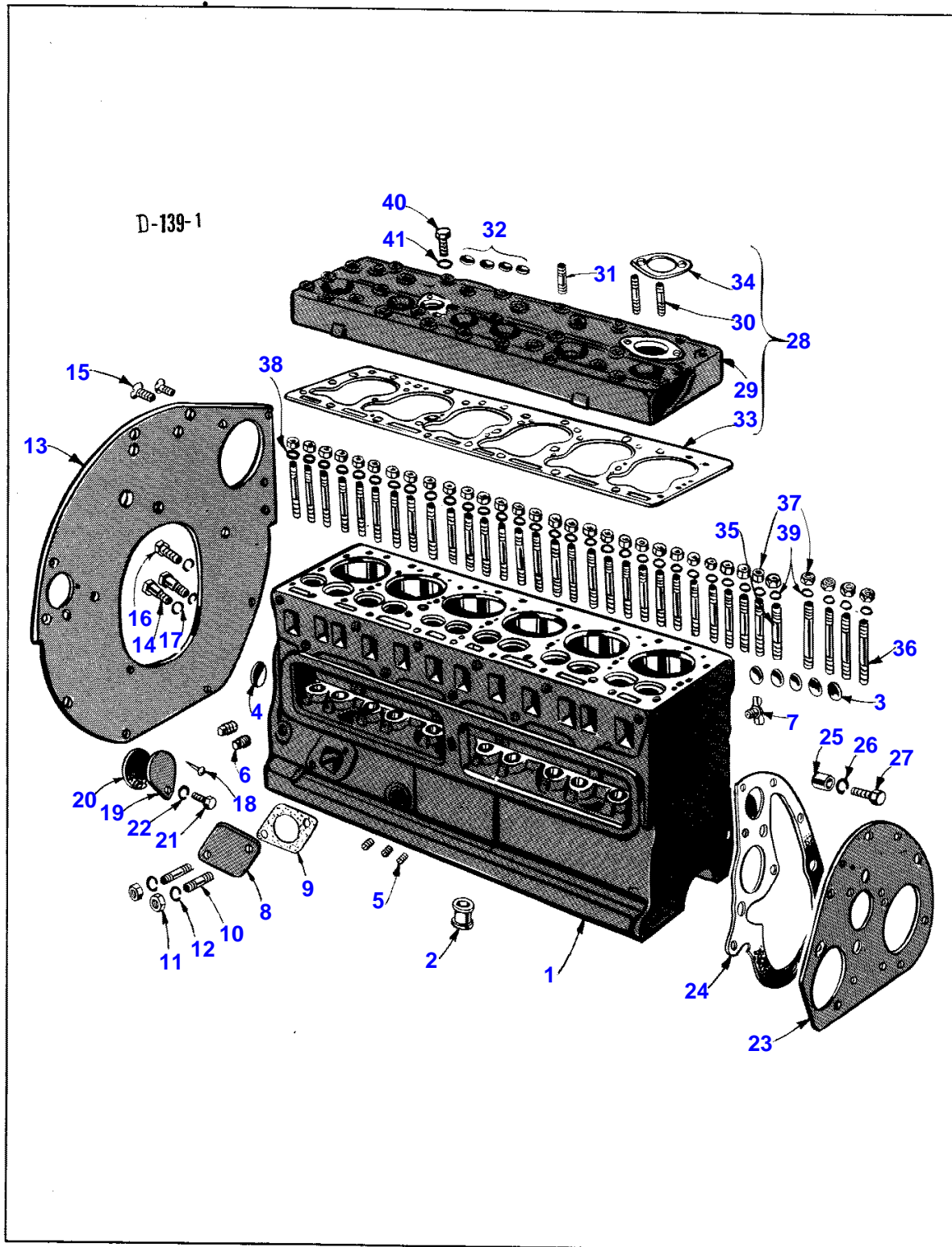
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## CRANKSHAFT, MAIN BEARINGS, CAPS, FILLER BLOCKS AND FLYWHEEL

| Item | Part Number | Qty | Description  |
|------|-------------|-----|--|
| 1    | 840706M91   | 1   | Crankshaft And Bearing Kit (Incl. 1 - 761461M91 Crankshaft, 1 - 761463M1 Starting Jaw, 1 - 761462M1 Washer, 1 - 840697M91 Main Brg. Kit, 1 - 840701M91 Conn. Rod Brg. Kit, 2 - 1001408M1 Oil Seal, 1 - 15287A Oil Seal And 1 - 14288A Dust Seal) |
| 2    | 761461M91   | 1   | Crankshaft Assembly (Order 840706M91)  |
| 3    | 15280A      | 1   | Bushing, Crankshaft Pilot  |
| 4    | 21257A      | 1   | Washer, Thrust, Inner (2-13/32 x 3-3/8 x 3/32" Bronz)  |
| 5    | 1000269M1   | 1   | (A) Washer, Thrust, Outer (2-13/32 x 3-3/8 x 1/8" Bronz) (See Note)  |
| 6    | 21156A      | 1   | Plate, Thrust  |
| 7    | 15283A      | AR  | Shim Thrust Plate (.002")  |
|      | 15284A      | AR  | Shim, Thrust Plate (.008")   |
| 8    | 32656A      | 1   | Gear, Crankshaft Timing  |
| 9    | 15286A      | 1   | Washer, Oil Throw-Off  |
| 10   | 35202A      | 1   | Pulley, Water Pump Drive   |
| 11   | 12501X      | 2   | Key, Timing Gear And Pulley (#15 Woodruff)   |
| 12   | 15291A      | 1   | Plug, Keyway (Cork)  |
| 13   | 761463M1    | 1   | (B) Jaw, Crankshaft Starting (See Note)  |
| 14   | 761462M1    | 1   | (B) Washer, Crankshaft Starting Jaw (See Note)   |
| 15   | 18693A      | 1   | (C) Jaw, Crankshaft Starting (See Note)  |
| 16   | 15290A      | 1   | (C) Washer, Crankshaft Starting Jaw (See Note)   |
| 17   | 1002528M91  | 1   | (D) Bearing Assembly, Front Main, Std. (See 840697M91)   |
| 18   | 1002530M91  | 2   | Bearing Assembly, Intermediate Main, Std. (See 840697M91)  |
| 19   | 1002532M91  | 1   | Bearing Assembly, Rear Main, Std. (See 840697M91)  |
| 20   | 1000295M1   | 1   | Cap, Main Bearing, Front   |
| 21   | 35229A      | 1   | Cap, Main Bearing, Front Intermediate  |
| 22   | 35228A      | 1   | Cap, Main Bearing, Rear Intermediate   |
| 23   | 35230A      | 1   | Cap, Main Bearing, Rear  |
| 24   | 1000270M1   | 2   | (E) Pin, Dowel, Front Bearing Cap (11/64 x 11/16")   |
| 25   | 1000357M1   | 5   | Pin, Dowel, Intermediate And Rear Bearing Cap (5/16 x 23/32")  |
| 26   | 21181A      | 1   | Ring, Dowel, Rear Intermediate Bearing Cap   |
| 27   | 21215A      | 6   | Bolt, Front, Front Intermediate And Rear Main Bearing Cap (1/2 x 2-1/2" NC, Hex. Drilled Hd.)  |
| 28   | 15235A      | 2   | Bolt, Rear Intermediate Bearing Cap (1/2 x 3-1/4" NC, Hex. Drilled Hd.)  |
| 29   | 15233A      | 8   | Washer (1/2" Flat)   |
| 30   | 15234A      | 3   | Wire, Lock (#19 - 10"0)  |
| 31   | 15236A      | 1   | Wire, Lock (#19 - 12")   |
| 32   | 32674A      | 1   | Filler Block, Front  |
| 33   | 6226A       | 1   | Filler Block, Rear   |
| 34   | 22110X      | 2   | Bolt (5/16 x 7/8" NC, Socket Hd.)  |
| 35   | 22115X      | 2   | Bolt (5/16 x 2-5/8" NC, Socket Hd.)  |
| 36   | 15492X      | 4   | Washer (5/16" Internal Shakeproof)   |
| 37   | 11077X      | 2   | Bolt (1/4 x 2" NC, Hex.)   |
| 38   | 2760X       | 2   | Washer (1/4" Lock)   |
| 39   | 32862A      | 1   | Guard, Oil   |
| 40   | 1001408M1   | 2   | Seal, Oil  |
| 41   | 33865A      | 1   | Flywheel Assembly  |
| 42   | 33565A      | 1   | Gear, Flywheel   |
| 43   | 15279A      | 6   | Bolt, Flywheel To Crankshaft (3/8 x 1-3/16" NF, Special)   |
| 44   | 12177X      | 6   | Nut, (3/8" NF, Hex.)   |
| 45   | 15200A      | 6   | Washer (3/8" Internal Shakeproof)  |
| 46   | 760451M91   | 1   | (F) Bearing Assembly, Front Main (Flanged Type) (Order 1 - 1002528M91 And 1 - 1000269M1) (See Note)  |
| 47   | 840697M91   | 1   | (G) Bearing Set, Main Std.   |
| 48   | 1002528M91  | 1   | Bearing Assembly, Front Main, Std.   |
| 49   | 1002530M91  | 2   | Bearing Assembly, Intermediate Main, Std.  |
| 50   | 1002532M91  | 1   | Bearing Assembly, Rear Main, Std.  |
| 51   | 1000269M1   | 1   | Washer, Thrust, Outer (2-13/32 x 3-3/8 x 1/8")   |
| 47   | 840698M91   | 1   | (G) Bearing Set, Main, - .002"   |
| 48   | 1002534M91  | 1   | Bearing Assembly, Front Main, - .002"  |
| 49   | 1002536M91  | 2   | Bearing Assembly, Intermediate Main, - .002"   |
| 50   | 1002538M91  | 1   | Bearing Assembly, Rear Main, - .002"   |
| 51   | 1000269M1   | 1   | Washer, Thrust, Outer (2-13/32 x 3-3/8 x 1/8")   |
| 47   | 840699M91   | 1   | (G) Bearing Set, Main, - .020"   |
| 48   | 1002540M91  | 1   | Bearing Assembly, Front Main - .020"   |
| 49   | 1002542M91  | 2   | Bearing Assembly, Intermediate - .020"   |
| 50   | 1002544M91  | 1   | Bearing Assembly, Rear Main - .020"  |
| 51   | 100269M1    | 1   | Washer, Thrust (2-13/32 x 3-3/8 x 1/8")  |
| 47   | 840700M91   | 1   | (G) Bearing Set, Main - .040"  |
| 48   | 1002546M91  | 1   | Bearing Assembly, Front Main - .040"   |

| Item | Part Number | Qty | Description  |
|------|-------------|-----|--|
| 49   | 1002548M91  | 2   | Bearing Assembly, Intermediate Main - .040"  |
| 50   | 1002550M91  | 1   | Bearing Assembly, Rear Main - .040"  |
| 51   | 1000269M1   | 1   | Washer, Thrust (2-13/32 x 3-3/8 x 1/8")  |
|      |             |     | *****  |
|      |             |     | (A) - 1000269M1 Thrust Washer, Outer, Is Not Used With Flange Type Front Main Bearing Used In Production Prior To Engine Serial Number 40373. When Plain Type Front Main Bearing Is Installed, Be Sure To Install This Washer. |
|      |             |     | (B) - 761463M1 Starting Jaw And 761462M1 Washer First Used Engine Serial Number 30310. Check Old Parts And Engine Serial Number Before Ordering.   |
|      |             |     | (C) - 18693A Starting Jaw And 15290A Washer Used Prior To Engine Serial Number 30310. check Old Parts And Engine Serial Number Before Ordering.  |
|      |             |     | (D) - 1002528M91 Front Main Bearing "Plain Type" First Used Engine Serial Number 40373 Must Have 1000269M1 Outer Thrust Washer.  |
|      |             |     | (E) - 1000270M1 Dowel Pin First Used Engine Serial Number 40373.   |
|      |             |     | (F) - 760451M91 Front Main Bearing "Flange Type" Used Prior To Engine Serial Number 40373. For Repairs, Use 1 - 1002528M91 "Plain Type" Bearing W/ 1000269M1 Outer Thrust Washer.  |
|      |             |     | (G) - 840697M91, 840699M91 And 840700M91 Main Bearing Sets Contain Plain Type Front Main Bearings And Outer Thrust Washer. These Bearing Sets Can Be Used To Repalce Any Type Bearing Ever Used In This Engine.                |

CYLINDER BLOCK, CYLINDER HEAD AND END PLATES



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## CYLINDER BLOCK, CYLINDER HEAD AND END PLATES (SEE NOTE)

| Item | Part Number | Qty | Description  |
|------|-------------|-----|--|
| 1    | 1000764M91  | 1   | (A) Cylinder Block Assembly (Stripped)   |
|      | 1000765M91  | 1   | Cylinder Block Assembly (W/ Pistons, Rings Pins, Valves, Valve Springs And Tappets)  |
|      | 1000766M91  | 1   | Cylinder Block Assembly (W/ Pistons, Rings, Pins, Valves, Valve Springs, Tappets, Crankshaft, Conn. Rods, Camshaft And Timing Gears) |
| 2    | 15242A      | 1   | Bushing, Oil Pump Drive Shaft  |
| 3    | 1793X       | 6   | Plug, Cylinder Core Holes  |
| 4    | 13518X      | 1   | Plug, Rear Camshaft Bushing Hole   |
| 5    | 1000148M1   | 3   | Plug (1/4" P.T. Sckt. Hd.)   |
| 6    | 2409X       | 2   | Plug, Oil Passage (1/8" P.T. Sq. Hd.)  |
| 7    | 763716M1    | 2   | Drain, Cock  |
| 8    | 17166A      | 1   | Cover, Fuel Pump Hole  |
| 9    | 17165A      | 1   | Gasket, Fuel Pump Hole Cover   |
| 10   | 15244A      | 2   | Stud (5/16" NC x 1-1/4")   |
| 11   | 11922X      | 2   | Nut (5/16" NC, Hex.)   |
| 12   | 2761X       | 2   | Washer (5/16" Lock)  |
| 13   | 35196A      | 1   | Rear End Plate   |
| 14   | 15355A      | 2   | Dowel Screw  |
| 15   | 29785X      | 2   | Screw (7/16 x 7/8" NC, Ctsk. Hd.)  |
| 16   | 16264X      | 1   | Bolt (7/16 x 1-,1/8" NC, Hex.)   |
| 17   | 2763X       | 3   | Washer (7/16" Lock)  |
| 18   | 15353A      | 1   | Flywheel Pointer (#10 x 3/4" Drive Screw)  |
| 19   | 15354A      | 1   | Cover, Timing Hole   |
| 20   | 17058A      | 1   | Felt, Timing Hole Cover  |
| 21   | 12782X      | 1   | Bolt (3/8 x 5/8" NC, Hex.)   |
| 22   | 2762X       | 1   | Washer (3/8" Lock)   |
| 23   | 35206A      | 1   | Front End Plate  |
| 24   | 35216A      | 1   | Gasket, Front End Plate  |
| 25   | 15332A      | 1   | Ring Dowel, Front End Plate  |
| 26   | 1918X       | 1   | Bolt, Thru Ring Dowel (3/8 x 3/4" NC. Hex.)  |
| 27   | 2762X       | 1   | Washer (3/8" Lock)   |
| 28   | 840207M91   | 1   | Cylinder Head Kit (Regular)  |
| 29   | 760684M91   | 1   | Cylinder Head Assembly (Order 840207M91)   |
| 30   | 15265A      | 2   | Stud, Water Outlet Elbow (5/16" NC. x 1-7/8")  |
| 31   | 15245A      | 1   | Stud, Distributor Adapter (3/8" NC. x 1-3/8")  |
| 32   | 14012X      | 4   | Plug, Core Hole (7/8" Expansion)   |
| 33   | 1004045M1   | 1   | Gasket, Cylinder Head  |
| 34   | 18299A      | 1   | Gasket, Water Outlet Elbow   |
| 28   | 840451M91   | 1   | Cylinder Head Kit (Hi-Altitude)  |
| 29   | 761579M91   | 1   | Cylinder Head Assembly (Order 840451M91)   |
| 30   | 15265A      | 2   | Stud, Water Outlet Elbow (5/16" NC. x 1-7/8")  |
| 31   | 15245A      | 1   | Stud, Distributor Adapter (3/8" NC. x 1-3/8")  |
| 32   | 14012X      | 4   | Plug, Core Hole (7/8" Expansion)   |
| 33   | 1004045M1   | 1   | Gasket, Cylinder Head  |
| 34   | 18299A      | 1   | Gasket, Water Outlet Elbow   |
| 35   | 21208A      | 29  | Stud, Cylinder Head Attach. (3/8" NC-NF x 3-1/2")  |
| 36   | 761023M1    | 4   | Stud, Cylinder Head Attach. (3/8" NC-NF x 3-5/8")  |
| 37   | 761393M1    | 33  | Nut (3/8" NF, Hex., Special)   |
| 38   | 15233A      | 29  | Washer (1/2" Flat)   |
| 39   | 29856A      | 4   | Washer (21/32" Flat)   |
| 40   | 12782X      | 1   | Bolt (3/8 x 5/8" NC, Hex.)   |
| 41   | 17171A      | 1   | Washer (3/8" Copper)   |

\*\*\*\*\*

Note: All Cylinder Blocks Are Equipped  
W/ All Studs, Plugs, Camshaft Bearings,  
Main Bearings And Main Bearing Caps.  
(A) - Cylinder Block Assembly  
#1000764M91 Is Less Pistons And Is Not  
Considered Normal Repair Item. It Is  
Intended To Be Used Only When Replacing  
Block In New Engines That May Have Been  
Damaged By Freezing Or In Shipment.