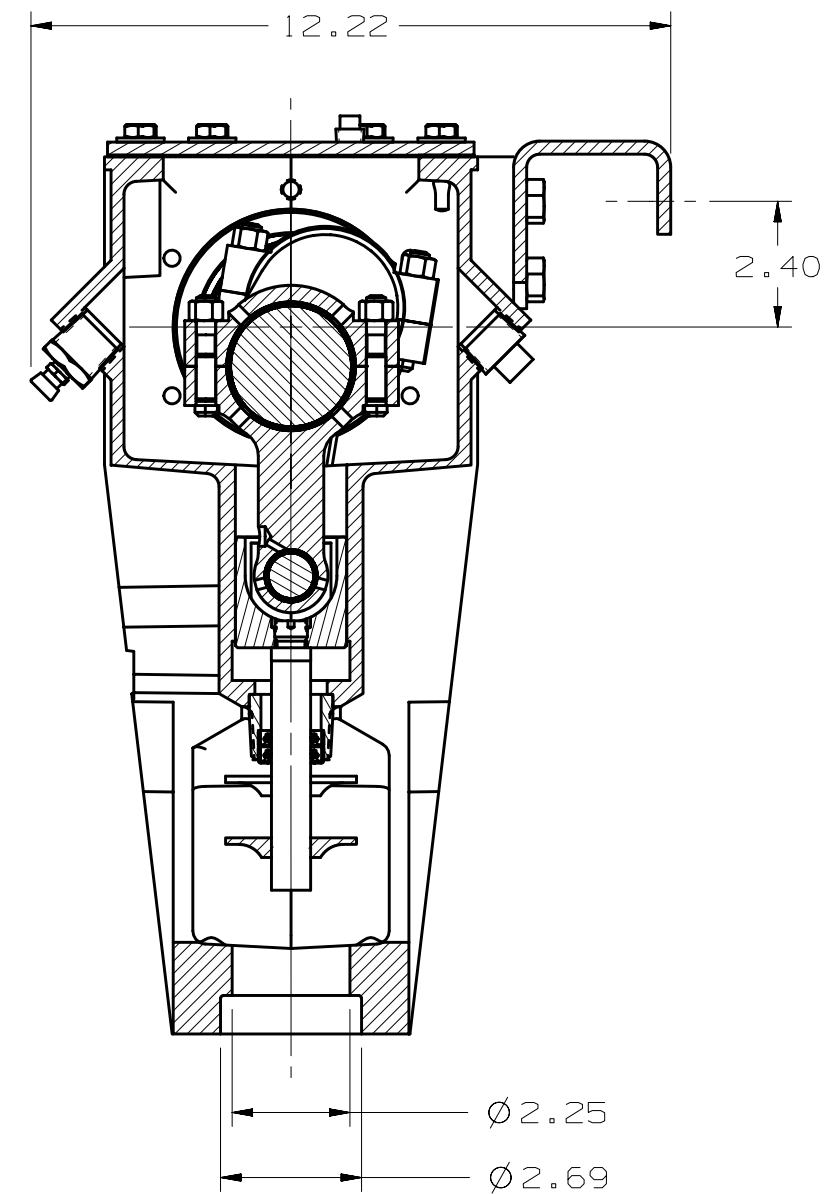
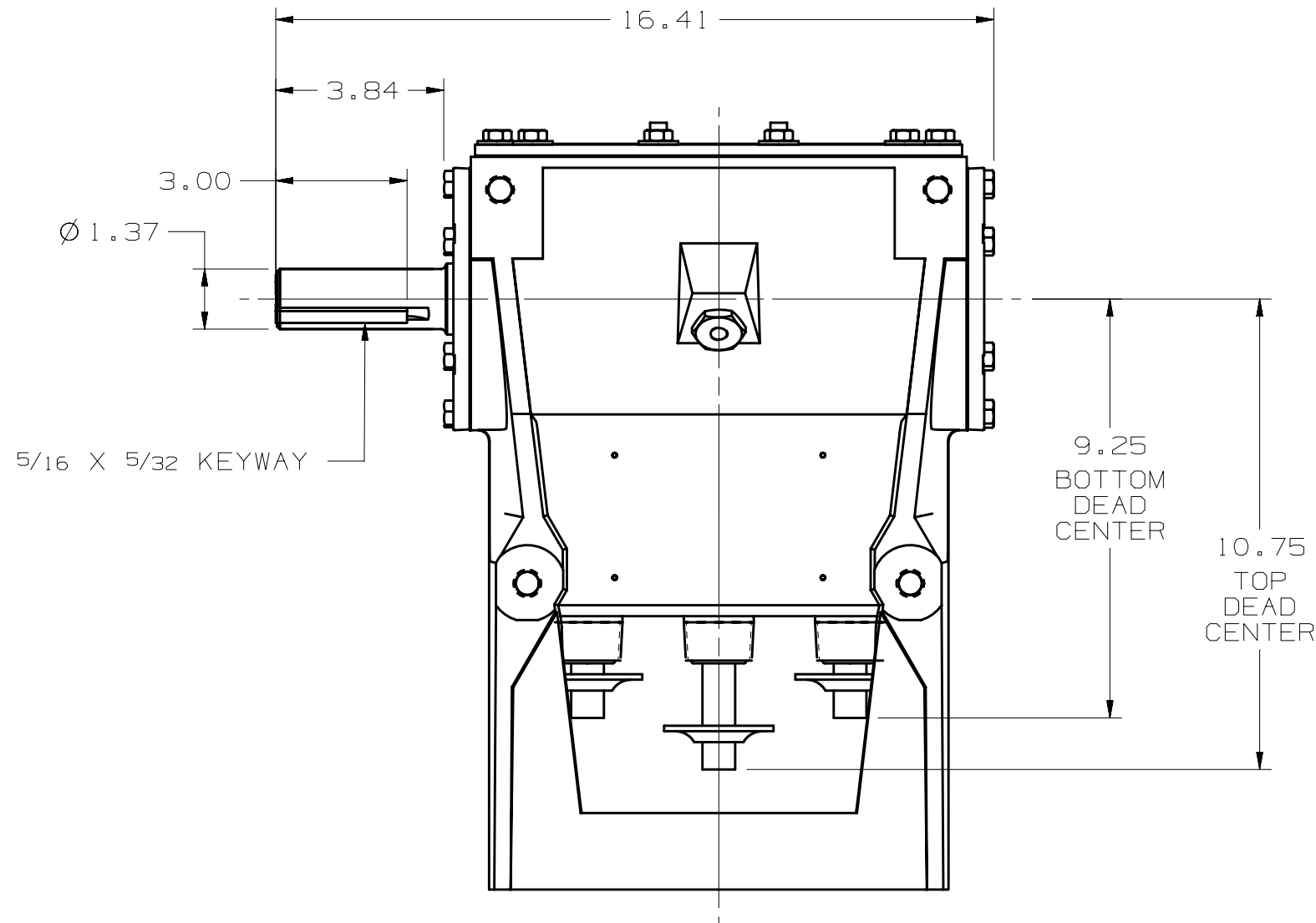


ITEM	DESCRIPTION	QTY
1	POWER FRAME:	1
2	CRANKSHAFT:	1
3	CONNECTING ROD:	3
4	ROD BEARING: HALF SHELL	6
5	WRIST PIN:	3
6	CROSSHEAD ASSEMBLY:	3
7	SEAL HOLDER: PONY ROD SEAL	3
8	SEAL: PONY ROD	6
9	BEARING HOUSING: DRIVE SIDE	1
10	BEARING HOUSING: BLIND	1
11	GASKET: BEARING HOUSING	2
12	SHIM: BEARING HOUSING	6
13	BACK COVER:	1
14	GASKET: BACK COVER	1
15	OIL SEAL:	1
16	BEARING CONE:	2
17	BEARING CUP:	2
18	BARRIER WASHER:	3
19	KEY: 5/16 SQ X 3.00 LG	1
20	REAR FOOT:	1
21	SET SCREW: 1/4-20UNC-2A X .50 LG	3
22	HEX HEAD CAPSCREW: 3/8-16UNC X 1.2	12
23	HEX HEAD CAPSCREW: 3/8-16UNC X .75	12
24	HEX HEAD CAPSCREW: 1/2-13UNC-2A X	6
25	WASHER: BELLEVILLE, 3/8	12
26	BUSHING: HEX HEAD, 3/4 X 1/8	1
27	LUBE VENT: 1/8-27 PTF	1
28	PIPE PLUG: SQ HEAD, 1/8 NPT (N.S)	1
29	PIPE PLUG: 1/4 NPT	1
30	PIPE PLUG: 1/4 NPT	1
31	PIPE PLUG: SQ HEAD, 3/4 NPT	1

- NOTES:
- CONNECTING ROD SPLASH HOLE MUST BE FACING UPWARD.
 - WRIST PIN LOCK HOLE MUST ALIGN WITH SET SCREW. APPLY LOCTITE 271 TO SET SCREWS BEFORE ASSEMBLY.
 - LUBRICATE CRANKSHAFT OIL SEALS WITH LIGHT OIL ONLY.
 - ALL MOVING PARTS IN THE POWER END SHOULD BE LUBRICATED WITH SAE 30 WT OIL AT ASSEMBLY.
 - ASSEMBLE CRANKSHAFT IN POWER FRAME WITH TAPERED BEARINGS END PLAY OF .003 TIGHT TO THE CRANKCASE.
 - INSTALL ROD SEALS WITH BOTH LIPS TURNED TOWARD THE CRANKCASE.
 - APPLY SILICON SEALER TO SEAL HOLDER (ITEM #7) BEFORE PRESSING INTO POWER FRAME.
 - ITEMS 28 AND 29 TO BE INSTALLED AFTER TESTING, AND BEFORE CLEANING AND PAINTING.

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ENGINEERING
 DIMENSIONAL
 OUTLINE

DESCRIPTION
 POWER END ASSEMBLY; M06
 LH, W/TOP MOTOR MOUNT
 HOLES

DRAWN BY:	KUNISHIGE, SCOTT	DATE:	13-OCT-2006
DRAFTING CHECK:	KUNISHIGE, SCOTT	DATE:	13-OCT-2006
DESIGN REVIEW:	GOODELL, GENE	DATE:	21-DEC-2006
MANUFACTURING APPROVAL:	CRUZ, GEORGE	DATE:	15-DEC-2006
APPROVED BY:	SINGLETERRY, RONALD	DATE:	15-JAN-2007



LATEST ECN NO.	5016483	REV.	C
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