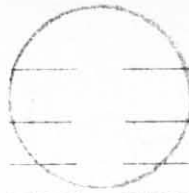


Date Issued: 6-12-47  
1-13-49

ASSEMBLY NO. 153-CC  
SHEET NO. \_\_\_\_\_

ENGINE MODEL \_\_\_\_\_

2 CYL. \_\_\_\_\_  
3 CYL. \_\_\_\_\_  
4 CYL. \_\_\_\_\_  
5 CYL. \_\_\_\_\_  
6 CYL. \_\_\_\_\_  
8 CYL. \_\_\_\_\_



ASSY NAME: Pyrometer Conduit Assy.  
RH. Rev. G6 Non-Supercharged (For  
6 Thermocouples Connections. Used  
W/Welded Ex. Man.  
FIRST USED ON: \_\_\_\_\_

ASSY DWGS: G-2605

It.	Part No.	Part Name	Matl	Qty	Remarks
1					
2	G-2604	Pre-Assy. Conduit		1	Consisting of:
3		Conduit, Flex.(Greenfield)		1	1" x 28"
4		Flex. Connector		2	1" x 90° or equivalent
5		Tee-Unilet (with cover)		6	Form 35 Appleton lxlx
6		Nipple Conduit		5	1" x 11-1/2"
7		Flex, 90° Ell. Connector		6	1/2
8		Flex. Straight Connector		6	1/2
9		Conduit, Flex.(Greenfield)		6	1/2 x 17"
10		Pipe Plug		1	1"
11	B-6257	Leadwire, rubber & weather proof braid compensated iron constantan		80'	3W2A3 <del>80' #0W2-14</del> (Brown)
12					
13		Wire Tag		6	Oakland, California #7505 L. L. Burror Co.
14					
15					
16		Clip, Parker		4	<del>#325 7/8T 1"</del>
17	<del>1772-2</del>	<del>Spacer, Clip</del>	<del>CRS</del>	<del>3</del>	
18		<del>Cap screw</del>		<del>4</del>	<del>3/8-16 x 1</del>
19					
20		Washer, Reducing			Use if needed. Appleton 1-1/4" to 1"
21					
22					

CI = Cast Iron                      CRS = Cold Rolled Steel  
CS = Cast Steel                    CBr = Cast Brass  
FS = Forged Steel                CBrz = Cast Bronze

ENGINE SPECIFICATIONS, SHEET 1

Installation Dwg: G-4141  
 Piping Diagrams  
 Jacket Water: 11713  
 Sea Water: 11714  
 Lube Oil: 12340  
 Fuel Oil: 12706  
 Air: 11708

ENGINE DMG-6 50018

HP 400 RPM 400

CUSTOMER Western Boatbuilding Co.

JOB NO. 550

INSPECTION Standard

DATE SHIPPED 6-19-50

No.	Parts List Name	Qty.	Remarks
G 1 R	Base	1	
G 2 H	Front Main Bearings	1	
G 4 H	Intermediate Main Bearings	5	
G 5 K	Rear Main Bearings	1	
G 6 V	Crankshaft	1	
G 7 N	Flywheel	1	
G 8 S	Cylinder Block	1	
G 9 LL	Cylinder Block Covers	1	
G 10 A	Cylinder Liners	6	
G 11 CC	Pistons and Pins	6	
G 12 L	Connecting Rods and Bearings	6	
G 13 U	Cylinder Heads	6	
<del>14</del>	<del>Valves</del>		
G 15 F	Safety Valves	6	
G 16 F	Rockers and Push Rods	6	
G 17 DD	Tappets and Guides	6	
G 18 S	Intake Manifold	1	
G 19 MM	Exhaust Manifold and Ells	1	
G 20 N	Water Manifold	1	
G 21 D	Starting Air Manifold	1	
G 22 B	Front Camshaft Bearing	1	
G 23 A	Intermediate Camshaft Bearings	6	
G 24 SS	Cams and Shaft	1	





## ENGINE SPECIFICATIONS, SHEET 4

CUSTOMER Western Boatbuilding Co.ENGINE DMG-650018

No.	Parts List Name	Qty.	Remarks
101 WW	Instruments	1	2R,6E,11A,16N(7),17A
<del>102</del>	<del>Auxiliary Air Compressor</del>		
<del>103</del>	<del>Air Receivers and Fittings</del>		
104 NN	Lube Oil Tanks and Fittings	1	
<del>105</del>	<del>Fuel Oil Tanks and Fittings</del>		
<del>106</del>	<del>Propeller and Shaft Equipment</del>		
108 LLL	Tool Set, Engine	1	
<del>108</del>	<del>Tool Set, Turbo Charger</del>		
<del>108</del>	<del>Injection Test Pump</del>		
<del>108</del>	<del>Valve Grinding Equipment</del>		
109 U	Operating & Maintenance Instruct.	1	
<del>110</del>	<del>Purse Seine Equipment</del>		
111 GG	Pyrometer	1	6 Thermocouples
112 -	Lube Oil Cooler and Fittings	1	B-5720
113 -	Spare Parts, Engine 50018	1	
<del>113</del>	<del>Spare Parts, Turbo Charger</del>		
<del>114</del>	<del>Muffler, Exhaust</del>		
<del>114</del>	<del>Muffler, Intake</del>		
115 V	Tachometer	1	500-0-500, Red 400-500, 1.3889 x Eng.Speed
<del>117</del>	<del>Pilot House Control</del>		
<del>118</del>	<del>Electrical Equipment</del>		
<del>119</del>	<del>Indicator Equipment</del>		
120	Miscellaneous		
<del>124</del>	<del>Sailing Clutch Remote Control</del>		
<del>124</del>	<del>Reverse Gear Remote Control</del>		
<del>128</del>	<del>Radiator</del>		
<del>129</del>	<del>Heat Exchanger</del>		
<del>130</del>	<del>Air Cleaner</del>		
<del>131</del>	<del>Bilge Pump</del>		
<del>132</del>	<del>Bilge Pump Lines and Fittings</del>		
138 Z	Flywheel Barring Device	1	





Date Issued: 11-1-43

ASSEMBLY NO. G-1-R  
SHEET NO. 1 of 2

ENGINE MODEL G \_\_\_\_\_  
 2 CYL. \_\_\_\_\_  
 3 CYL. \_\_\_\_\_  
 4 CYL. \_\_\_\_\_  
 5 CYL. \_\_\_\_\_  
 6 CYL. 1 \_\_\_\_\_  
 8 CYL. \_\_\_\_\_

ASSY NAME: BASE  
 CI, 6 Cylinder, Marine, Kingsbury or  
 Timken

FIRST USED ON: \_\_\_\_\_

ASSY DWGS: 79002 - Timken  
78138 - Kingsbury

It.	Part No.	Part Name	Matl	Qty	Remarks
1	78249-1	Base		1	
2	704	Stud, Base - Crankcase		28	
3	7695	Thru Bolt Base - Crankcase		14	
4	7697	Washer, Thru Bolt		14	
5	135	Nut, Hex. Thru Bolt		14	
6	136	Nut, Square, Thru Bolt		14	
7	X-2965	Collar, Set, Thru Bolt		14	
8	79150	Ring, Sealing Thru Bolt		14	
9	G-6270	Gasket, Inner, Base - Case		14	
10					
11	79629	Gasket Group		<span style="border: 1px solid black; padding: 2px;">1</span>	Consisting of:
12	78282-1	Gasket, Outer, Rear		2	
13	78282-2		Gasket, Outer, Center	2	
14	78282-3		Gasket, Outer, Front	2	
15					
16		Nut, Base - Crankcase Stud		28	7/8 - 9
17		Lockwasher, Crankcase Stud		28	7/8 Std.
18	78158	Stud, Main Bearing		28	
19	7690	Washer, Main Bearing		28	
20	126	Nut, Main Bearing		28	
21		Pin, Cotter, Main Bearing Stud		28	1/8 x 1-1/2
22	165	Nut, Square - Main Bearing		28	

CI = Cast Iron  
 CS = Cast Steel  
 FS = Forged Steel

CRS = Cold Rolled Steel  
 CBr = Cast Brass  
 CBrz = Cast Bronze

Date Issued: 11-1-43

ASSEMBLY NO. G-1-R  
SHEET NO. 2 of 2ENGINE MODEL G \_\_\_\_\_ASSY NAME: BASE Continued

2 CYL. \_\_\_\_\_

3 CYL. \_\_\_\_\_

4 CYL. \_\_\_\_\_

5 CYL. \_\_\_\_\_

6 CYL. \_\_\_\_\_

8 CYL. 1 \_\_\_\_\_

FIRST USED ON: \_\_\_\_\_

ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks
1	78160-1	Pin, Locking - Inter., Bearing		10	
2	78160-2	Pin, Locking - Front Bearing		2	
3	78160-3	Pin, Locking - Rear Bearing		2	
4		Cotter Pin		28	3/32 x 1
5		Wahser		28	3/8 SAE
6		Set Screw, Allen		14	1/4 - 20 x 1/4" Cup Point
7					
8					
9					
10		Combination Assembly			
11	G-1489	Assembly, Base, Studs & Erg. Caps			G5G or K CLR, G2E or H, G4D or H
12					
13					
14					
15					
16					
17					
18					
19					
20					
21					
22					

CI = Cast Iron  
CS = Cast Steel  
FS = Forged Steel

CRS = Cold Rolled Steel  
CBr = Cast Brass  
CBrz = Cast Bronze



Edition X 3

THIS ASSEMBLY REPLACES G-2-A,B,C,D,E,F, &amp; G

Date Issued: 10-10-45

ASSEMBLY NO. G-2-H

RETYPED: 6-23-49

SHEET NO. \_\_\_\_\_

RETYPED: 4-5-54

ENGINE MODEL G \_\_\_\_\_ASSY NAME: FRONT MAIN BEARINGTin Babbitt, Single Groove Shell

2 CYL. \_\_\_\_\_

3 CYL. \_\_\_\_\_

4 CYL. \_\_\_\_\_

5 CYL. \_\_\_\_\_

6 CYL. 1 \_\_\_\_\_8 CYL. 1 \_\_\_\_\_

FIRST USED ON: \_\_\_\_\_

ASSY DWGS: 76802

It.	Part No.	Part Name	Matl	Qty	Remarks
1	76813	Cap, Bearing		1	
2					
3	G-5231	Assem., Bearing		<input type="checkbox"/> 1	Consists of:
4	G-5172	{ Bearing, Upper & Lower		2	Not Sold Separately
5					
6	7682	Ring, Locking		2	
7		Capscrew		2	1/2-13 x 1/4 Allen
8	76789	Key, Base - Main Brg		4	
9		Capscrew		4	1/4-20 x 1/2 Allen
10					
11					
12		FOR .010 UNDERSIZE SHELLS USE:			
13	G-5514	Assem., Bearing		<input type="checkbox"/> 1	Consists of:
14	G-5223	{ Bearing, Upper & Lower		2	Not Sold Separately
15					
16		FOR .020 UNDERSIZE SHELLS USE:			
17	G-5779	Assem., Bearing		<input type="checkbox"/> 1	Consists of:
18	G-5648	{ Bearing, Upper & Lower		2	Not Sold Separately
19					
20		WHEN UNDERSIZE SHELLS SUPPLIED USE ALSO:			
21	11837	Nameplate, Undersize		1	
22		Screws, Fill. Head, PK		4	#6 Type Z

CI = Cast Iron  
 CS = Cast Steel  
 FS = Forged Steel

CRS = Cold Rolled Steel  
 CBr = Cast Brass  
 CBrz = Cast Bronze

ENGINE MODEL G \_\_\_\_\_  
 2 CYL. \_\_\_\_\_  
 3 CYL. \_\_\_\_\_  
 4 CYL. \_\_\_\_\_  
 5 CYL. \_\_\_\_\_  
 6 CYL. 6 \_\_\_\_\_  
 8 CYL. 8 \_\_\_\_\_

ASSY NAME: Intermediate Main Bearing  
Tin Babbitt Shells

FIRST USED ON: \_\_\_\_\_

ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks
1	76808-	Cap, Bearing		1	
2					
3	G-5232	Assy, Bearing Shell		<input type="checkbox"/> 1	Consisting of
4	G-5173	Bearing, Upper & Lower		2	Not Sold Separately
5					
6	7682-	Ring, Locking		2	
7		Capscrew		2	1/2 - 13 x 4 Allen
8	76789-	Key, Base-Bearing Cap		4	
9		Capscrew		4	1/4-20 x 1/2 Allen
10					
11	G-5515	For .010 Undersize Shells use Assem., Bearing		<input type="checkbox"/> 1	Consisting of
12	G-5222	Bearing, Upper & Lower		2	Not Sold Separately
13					
14	G-5780	For .020 Undersize Shells use Assem., Bearing		<input type="checkbox"/> 1	Consisting of
15	G-5649	Bearing, Upper & Lower		2	Not Sold Separately
16					
17	77718	For .250 Undersize shells use Assem., Bearing		<input type="checkbox"/> 1	Consisting of
18	77020-1	Bearing, Upper & Lower		2	Not Sold Separately
19					
20		When Undersize Shells Supplied use also			
21	11837	Nameplate, Undersize		1	
22		Screws, Fill Head, PK		4	No. 6, Type Z

CI = Cast Iron  
 CS = Cast Steel  
 FS = Forged Steel

CRS = Cold Rolled Steel  
 CBr = Cast Brass  
 CBrz = Cast Bronze

Date Issued: 3-6-43

SEE SERVICE INFORMATION MEMO # 3  
FOR REPLACEMENT USE G-5-PASSEMBLY NO. \_\_\_\_\_  
SHEET NO. \_\_\_\_\_G-5-K  
1 of 1

ENGINE MODEL G \_\_\_\_\_  
 2 CYL. \_\_\_\_\_  
 3 CYL. \_\_\_\_\_  
 4 CYL. \_\_\_\_\_  
 5 CYL. \_\_\_\_\_  
 6 CYL. 1 \_\_\_\_\_  
 8 CYL. 1 \_\_\_\_\_

ASSY NAME: REAR MAIN BEARING  
 (Does not take Thrust) Used on Marine  
 w/o sailing clutch

FIRST USED ON: \_\_\_\_\_

ASSY DWGS: 76802

It.	Part No.	Part Name	Matl	Qty	Remarks
1	76811	Cap, Bearing		1	
2					
3	77724	Assembly Shell, Bearing		1	Consisting of:
4	77413	(Shell, Bearing, Upper & Lower		2	NSS
5					
6	7682	Ring, Locking		2	
7		Capscrew, Allen		2	1/2 - 13 x 4
8	76789	Key, Base-Main Bearing		4	
9		Capscrew, Allen		4	1/4 - 20 x 1
10					
11					
12					
13		NOTE: REORDER PARTS FROM G-5-P			
14					
15					
16					
17					
18					
19					
20					
21					
22					

CI = Cast Iron  
 CS = Cast Steel  
 FS = Forged Steel

CRS = Cold Rolled Steel  
 CBr = Cast Brass  
 CBrz = Cast Bronze



ENGINE MODEL G \_\_\_\_\_  
 2 CYL. \_\_\_\_\_  
 3 CYL. \_\_\_\_\_  
 4 CYL. \_\_\_\_\_  
 5 CYL. \_\_\_\_\_  
 6 CYL. 1 \_\_\_\_\_  
 8 CYL. \_\_\_\_\_

ASSY NAME: CRANKSHAFT  
 FS, 8-1/2" Journals, 8" Pins, For Super-  
 charged Engines 80,000 PSI Min. Tensile  
 ABS Requirements. 6 Cylinder  
 FIRST USED ON: \_\_\_\_\_

ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks
1	G-2528	Crankshaft		1	For Forge Dwg. see 77018 For Rough Mach see 77397
2	G-2557	Key, Crankshaft		1	
3					
4					
5					
6					
7					
8					
9					
10					
11					
12					
13					
14					
15					
16					
17					
18					
19					
20					
21					
22					

CI = Cast Iron                      CRS = Cold Rolled Steel  
 CS = Cast Steel                    CBr = Cast Brass  
 FS = Forged Steel                CBrz = Cast Bronze

Date Issued: 10-22-43

SAME AS G-207-N

ASSEMBLY NO. G-7-N  
SHEET NO. 1 of 1

ENGINE MODEL G \_\_\_\_\_  
 2 CYL. \_\_\_\_\_  
 3 CYL. \_\_\_\_\_  
 4 CYL. \_\_\_\_\_  
 5 CYL. \_\_\_\_\_  
 6 CYL. 1 \_\_\_\_\_  
 8 CYL. 1 \_\_\_\_\_

ASSY NAME: FLYWHEEL  
 CI, 10-1/2 x 33", With Cast Slots,  
 Marine

FIRST USED ON: 43153-332ASSY DWGS: 78138

It.	Part No.	Part Name	Matl	Qty	Remarks
1	78143	Flywheel		1	
2	7643	Bolt, Flywheel		6	
3	126	Nut		6	
4		Cotter Pin, 3/16 x 2-1/4		6	
5	78146	Pointer, Flywheel		1	
6		Capscrew, Pointer - Block		2	1/2-13 x 1
7	104-2	Dowel, Pointer - Block		2	
8					
9					
10					
11					
12					
13					
14					
15					
16					
17					
18					
19					
20					
21					
22					

CI = Cast Iron  
 CS = Cast Steel  
 FS = Forged Steel

CRS = Cold Rolled Steel  
 CBr = Cast Brass  
 CBrz = Cast Bronze

For list of Special Drillings  
see Dwg. G-2299

Date Issued: 6-18-43

THESE PARTS ON G-208-S

ASSEMBLY NO. G-8-S  
SHEET NO. 1 of 1

ENGINE MODEL G \_\_\_\_\_  
 2 CYL. \_\_\_\_\_  
 3 CYL. \_\_\_\_\_  
 4 CYL. \_\_\_\_\_  
 5 CYL. \_\_\_\_\_  
 6 CYL. 1 \_\_\_\_\_  
 8 CYL. \_\_\_\_\_

ASSY NAME: Cylinder Block  
 RH-6 Cyl. Turbocharged or Non-Turbocharged

FIRST USED ON: \_\_\_\_\_

ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks
1	75383	Cylinder Block		1	
2		Plug, Drain		1	3/4 Male
3					
4					
5					
6					
7					
8					
9					
10					
11					
12					
13					
14					
15					
16					
17					
18					
19					
20					
21					
22					

CI = Cast Iron                      CRS = Cold Rolled Steel  
 CS = Cast Steel                    CBr = Cast Brass  
 FS = Forged Steel                CBrz = Cast Bronze



Date Issued: 9-22-49

See G-208 &amp; G-209

ASSEMBLY NO. G-9-LL  
SHEET NO. 1 of 3

ENGINE MODEL G \_\_\_\_\_  
 2 CYL. \_\_\_\_\_  
 3 CYL. \_\_\_\_\_  
 4 CYL. \_\_\_\_\_  
 5 CYL. \_\_\_\_\_  
 6 CYL. 1 \_\_\_\_\_  
 8 CYL. \_\_\_\_\_

ASSY NAME: CYLINDER BLOCK COVERS  
 RH-6 w/o Overspeed Trip, w/ Relief  
 Valves

FIRST USED ON: \_\_\_\_\_

ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks
1	78410	Assem. Rear Oil Seal		1	Consisting Of:
2	78377-1	Seal, Lower Rear End Oil		1	
3	78288-1	Gasket, Seal - Seal		2	
4	7644-1	Seal, Upper Rear End Oil		1	
5		Bolt		4	1/2-13 x 1-3/4
6		Nut		4	1/2-13
7	106-3	Dowel		2	
8					
9	7029-B	Cover, Side Door		10	
10	423	Stud, Relief Valve Cover		4	
11		Capscrew		92	1/2-13 x 1-1/2
12		Nut, Relief Valve Cover		4	1/2-13
13	78181-1	Gasket		12	
14	7844-1	Cover, Camshaft Left End		1	
15		Capscrew		9	1/2-13 x 1-1/4
16	7843-1	Cover, Camshaft Center		1	
17	78290-1	Gasket, Upper Seal to Block		1	
18		Capscrew		14	1/2-13 x 1-1/4
19		Bolt		4	1/2-13 x 1-1/2
20		Nut, Hex		4	1/2-13
21	7842-1	Cover, Camshaft Right End		1	
22		Capscrew, Cover - Block		11	1/2-13 x 1-1/4

CI = Cast Iron  
 CS = Cast Steel  
 FS = Forged Steel

CRS = Cold Rolled Steel  
 CBr = Cast Brass  
 CBrz = Cast Bronze

Date Issued: 9-22-49

ASSEMBLY NO. G-9-LL  
SHEET NO. 2 of 3

ENGINE MODEL G

ASSY NAME: CYLINDER BLOCK COVERS

2 CYL. \_\_\_\_\_  
 3 CYL. \_\_\_\_\_  
 4 CYL. \_\_\_\_\_  
 5 CYL. \_\_\_\_\_  
 6 CYL. 1 \_\_\_\_\_  
 8 CYL. \_\_\_\_\_

FIRST USED ON: \_\_\_\_\_

ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks
1		Bolt, Cover - Gear Cover		3	1/2-13 x 1-3/4
2		Nut, Hex.		3	1/2-13
3	108-1	Dowel		2	
4					
5	78286-1	Gasket, Left End Cover		1	Gasket Set 79631
6	78179-1	Gasket, Center to Block		2	
7	78189-2	Gasket, Center to Block		2	
8	78183-1	Gasket, End		2	
9	77928-1	Gasket, Right End - Lower Half		1	
10	77927-1	Gasket, Right End - Upper Half		1	
11	77926-1	Gasket to Gear Case		1	
12					
13	4833-1	Pipe, Breather		1	
14	B-3736	Breather, Crankcase		1	
15	533	Stud, Int. Exh. Tappet		32	
16		Nut, Hex.		32	5/8-18
17		Lockwasher		32	5/8 Shakeproof
18	538	Stud, Fuel Tappet		16	
19		Nut, Hex		16	5/8-11
20	532	Stud, Cam Bearing		18	
21		Nut		18	5/8-18
22		Lockwasher		18	5/8 Shakeproof

CI = Cast Iron  
 CS = Cast Steel  
 FS = Forged Steel

CRS = Cold Rolled Steel  
 CBr = Cast Brass  
 CBrz = Cast Bronze

Date Issued: 9-22-49

ASSEMBLY NO. G-9-LL  
SHEET NO. 3 of 3

ENGINE MODEL   G   \_\_\_\_\_  
 2 CYL. \_\_\_\_\_  
 3 CYL. \_\_\_\_\_  
 4 CYL. \_\_\_\_\_  
 5 CYL. \_\_\_\_\_  
 6 CYL.   1   \_\_\_\_\_  
 8 CYL. \_\_\_\_\_

ASSY NAME: CYLINDER BLOCK COVERS

FIRST USED ON: \_\_\_\_\_

ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks
1	607	Stud, Idler Stub		3	
2		Nut, Castle		3	3/4-10
3		Pin, Cotter		3	1/8 x 1-1/2
4					
5	77527-2	Name Plate		1	
6		Screw, Countersunk		22	P.K. No.6 x 1/2, Type Z
7	78366-1	Gasket, Lower Seal to Base		1	
8		Capscrew		15	1/2-13 x 1-1/2
9	79576-1	Flange, Blind		1	For Front Turbo. Eng. or Non-Turbo Eng. Only
10	79142-1	Gasket, Cover		1	
11		Capscrew		2	
12					
13	G-3646	Assem., Relief Valve		<span style="border: 1px solid black; padding: 2px;">2</span>	Assem. Dwg. G-3646 EACH Consisting of:
14	G-3633	Cover, Relief Valve		1	
15	G-3486-1	Stud		1	
16		Nut, Cap		1	1"-14
17		Nut, Jam		1	1"-14
18	G-3487-1	Ring, Sealing		1	
19	G-3488-1	Retainer, Spring		1	
20	G-3489-1	Spring		1	
21	G-3490-1	Valve, Relief Valve		1	
22					

CI = Cast Iron  
 CS = Cast Steel  
 FS = Forged Steel

CRS = Cold Rolled Steel  
 CBr = Cast Brass  
 CBrz = Cast Bronze



Date Issued: 1-26-39

ASSEMBLY NO. G-10-A  
 SHEET NO. 1 of 1

ENGINE MODEL G

ASSY NAME: Cylinder Liner

2 CYL. \_\_\_\_\_  
 3 CYL. \_\_\_\_\_  
 4 CYL. \_\_\_\_\_  
 5 CYL. \_\_\_\_\_  
 6 CYL. 1 \_\_\_\_\_  
 8 CYL. 1 \_\_\_\_\_

FIRST USED ON: 9001 - 9010

ASSY DWGS: Group Dwg. 78435

It.	Part No.	Part Name	Matl	Qty	Remarks
1	7657	Cylinder Liner		1	
2	7026	Ring, Sleeve Seal		2	
3					
4					
5					
6					
7					
8					
9					
10					
11					
12					
13					
14					
15					
16					
17					
18					
19					
20					
21					
22					

CI = Cast Iron                      CRS = Cold Rolled Steel  
 CS = Cast Steel                    CBr = Cast Brass  
 FS = Forged Steel                CBrz = Cast Bronze

Edition 2  
Date Issued: 10-25-49

ASSEMBLY NO. G-11-CC  
SHEET NO. 1 of 1

ENGINE MODEL G  
  
2 CYL. \_\_\_\_\_  
3 CYL. \_\_\_\_\_  
4 CYL. \_\_\_\_\_  
5 CYL. \_\_\_\_\_  
6 CYL. 6  
8 CYL. 8

ASSY NAME: PISTON AND PIN  
CI, Oil Cooled, 450 RPM and Below  
Supercharged & Non-Supercharged, w/oil  
Retainer, Narrow Rings  
FIRST USED ON: 49050

ASSY DWGS: G-3766

It.	Part No.	Part Name	Matl	Qty	Remarks
1	G-3767	Assembly, Piston and Pin		1	Consisting of:
2	C-3769	Assembly, Piston and Plug		1	Consisting of:
3	C-3768	Piston		1	
4	79352	Assembly, Plug		2	EACH Consisting of:
5	78779	Screw		1	
6	7273	Plug		1	
7	G-3972	Assembly, Pin, Piston		1	Consisting of:
8	G-1290	Pin		1	
9		Plug, Pipe 1/4 Sock, Hd.		2	
10	G-3772	Assembly, Retainer		1	Consisting of:
11	G-3770	Retainer, Lube Oil		1	
12	G-3771	Plate, Oil Retainer		1	
13		Capscrew, 3/8 - 16 x 1		4	
14	180-2	Locking Clip		4	
15					
16	G-1439	Assembly, Ring Group		1	Consisting of:
17	B-3847 *	Ring, Chrome Plated		2	Top
18	B-3605**	Ring, Comp. Taper Face, Str. Cut		3	Center
19	B-3088	Ring, LHA Oil Cutter		2	Bottom
20					
21		FOR .005 OVERSIZE REPLACEMENT OF PIN G-1290 USE: G-4172 FOR .010 OVERSIZE REPLACEMENT OF PIN G-1290 USE: G-4171			
22		*Use E-6336 for 1/4" Oversize Replacement **Use E-6337 Ring " " "			

CI = Cast Iron                      CRS = Cold Rolled Steel  
CS = Cast Steel                    CBr = Cast Brass  
FS = Forged Steel                CBrz = Cast Bronze

Edition B V 5

Date Issued: 3-12-46  
Retyped: 1-10-49

SEE G-211  
REPLACED IN ENTIRETY BY G-12-S

ASSEMBLY NO. (G-12-L)  
SHEET NO.

ENGINE MODEL G  
2 CYL. \_\_\_\_\_  
3 CYL. \_\_\_\_\_ **All Others** \_\_\_\_\_  
4 CYL. \_\_\_\_\_  
5 CYL. \_\_\_\_\_  
6 CYL. 6 \_\_\_\_\_  
8 CYL. 8 \_\_\_\_\_

ASSY NAME: Con. Rod & Bearing  
ABS (80,000 psi) CI and  
Alum. Oil Cooled Pistons & Non-Oil  
Cooled Pistons  
FIRST USED ON: \_\_\_\_\_

ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks
1					
2	G-1669	Pre-Assy., Con.Rod & Brg.		1	Consisting of:
3	G-1206- <del>1</del>	Connecting Rod NSS } Pre-Assy.		1	Steel Forging } Pre-Assy
4	G-1293-1	*Bushing Con.Rod } G-2735	Brz	1	} G-1672
5		Plug - 1/8 Slotted		1	Forg.Dwg.79250
6	78513- <del>1</del>	Box, Con. Rod Brg. Upper	CS	1	<del>SAE 1030</del> } Pre-Assy 79350
7	<del>78513-2</del>	<del>Box, Con. Rod Brg. Lower</del>	<del>CS</del>	<del>1</del>	<del>SAE 1030</del>
8	G-1337-1	Shell, Con. Rod **		2	Satco } Pre-Assy G-1344
9	78508-1	Ring, Locking	CRS	2	
10		Capscrew, Allen		2	5/16-18 x 1
11	76957-1	Bolt, Con. Rod		4	SAE 4140
12	76984-1	Nut, Con. Rod Bolt		4	Union Cold Drawn Hymo
13		Cotter Pin		4	3/16 x 2"
14	76970-1	Shim, Compression	ST	2	1/64 thick shim stock
15	76970-2	Shim, Compression	ST	1	1/32 thick
16	76970-3	Shim, Compression	ST	1	1/16 thick
17		REORDER PARTS FROM G-12-S			
18		** For Field Replacement use G-4728 pre-assembly (Consisting of Two G-4368)			
19					
20		*(Note: For Replacement use G-1476-1 Bushing instead			
21		of item 4-2 above.)			
22					

CI = Cast Iron                      CRS = Cold Rolled Steel  
CS = Cast Steel                    CBr = Cast Brass  
FS = Forged Steel                  CBrz = Cast Bronze

Edition: 7 3/4 5

SEE G-213-U

Date Issued: 10-7-49

Retyped: 4-19-51

ASSEMBLY NO. G-13-U

SHEET NO. 1

ENGINE MODEL G

- 2 CYL. \_\_\_\_\_
- 3 CYL. \_\_\_\_\_
- 4 CYL. \_\_\_\_\_
- 5 CYL. \_\_\_\_\_
- 6 CYL. 6
- 8 CYL. 8

Marine  
(Painted)

ASSY NAME: Cylinder Head & Valves  
Air Starting Marine; with Sub-Cover;  
Heavy Valve Springs, Diesel

FIRST USED ON: \_\_\_\_\_

ASSY DWGS: G-3961

It.	Part No.	Part Name	Matl	Qty	Remarks	
1						
2	G-3717	Assy. Cylinder Head Complete		1	Consisting of:	
3	G-3689	Cylinder Head	CI	1	} Assy. G-3718	
4	G-4096	Cover, Blind		1		
5	G-4599 7726	Plug, Tube } Tube } Assy. G-4003		2 1		Cast in Head G-3689
6		Capscrew		2		3/8-16 x 1/2
		Pipe Plug		2		1 1/2" Flush
		Pipe Plug		1		1 1/2" Flush
7	G-3612	Nozzle Sleeve	St.St	1		Assy. G-2720
8	X-3043	71906-1 Gasket, Nozzle Sleeve	Cop	1		
9	G-3687	Guide, Valve	CI	2		
10	77845	Stud, Nozzle Holder	St	2		
11	546	Stud, Rocker Shaft	St	2		
12	515	Stud, Relief Valve	St	2		
13	75115	Stud, Air Starting Valve	St	2		
14	G-4981 <del>7668-1</del>	Valve, Intake	St	1		
15	G-4982 <del>7668-2</del>	Valve, Exhaust	See Dwg.	1		
16	7700	Spring, Inner	St	2		
17	G-5625	Spring, Outer	St	2		
18	75294	Retainer	CRS	2		
19	7669-2	Wedge	CRS	4		Halves
20	75112	Air Inlet Cage	CI	1		
21	75113	Valve, Air Inlet	St	1	Pre-Assy*7671 Dwg. 75105	
22	96669	Nut, <del>Castle</del>		1	1/2-20	

CI = Cast Iron                      CRS = Cold Rolled Steel  
 CS = Cast Steel                    CBr = Cast Brass  
 FS = Forged Steel                CBrz = Cast Bronze



Date Issued: 10-7-49

ASSEMBLY NO. G-13-U  
SHEET NO. 2ENGINE MODEL GASSY NAME: Cylinder Head & Valves

2 CYL. \_\_\_\_\_

3 CYL. \_\_\_\_\_

4 CYL. \_\_\_\_\_

5 CYL. \_\_\_\_\_

6 CYL. 68 CYL. 8

FIRST USED ON: \_\_\_\_\_

ASSY DWGS: G-3961 627

It.	Part No.	Part Name	Matl	Qty	Remarks
1		Cotter Pin		1	3/32 x 1
2	7901	Retainer, Spring	CRS	1	
3	7903	Spring	St	1	
4	75114	Spacer	Br	1	
5	7904	Washer	CRS	1	
6	7900	Piston, Auxiliary	Br	1	Pre-Assy. * 76751
7	B-3054	Rings, <del>Str. Cut</del>		2	1 1/2 x 1-1/8 Dwg. 75105 (Contd.)
8	7897	Piston	Cbrz	1	
9	B-3055	Rings, <del>Step Seal</del>		2	2 x 1/8
10	79006	Cap } Pre-Assy. 7898	St	1	
11	79007	Plug }	St	1	
12	79108	Washer	Ann. Cop.	1	
13	7116	Gasket	Cop	1	
14	7907	Ring, Sealing	Rub	1	
15	7905	Retainer, Air Valve Cage	CS	1	SAE 1030
16		Nut, Air Starting Valve	St	2	5/8-18
17					
18					
19	G-3709	Sub-Cover, Cylinder Head	CI	1	
20	312	Stud, Cylinder Head Cover	St	2	
21	7922-1	Cover, Blind	CI	1	
22	79099	Gasket, Cover		1	Gar. 660

CI = Cast Iron  
CS = Cast Steel  
FS = Forged SteelCRS = Cold Rolled Steel  
CBr = Cast Brass  
CBrz = Cast BronzeCONTINUED  
NEXT PAGE

Date Issued: 10-7-49

ASSEMBLY NO. G-13-U

SHEET NO. 3

ENGINE MODEL G

2 CYL. \_\_\_\_\_

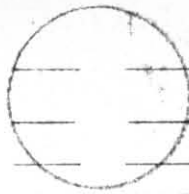
3 CYL. \_\_\_\_\_

4 CYL. \_\_\_\_\_

5 CYL. \_\_\_\_\_

6 CYL. 6 \_\_\_\_\_

8 CYL. 8 \_\_\_\_\_



ASSY NAME: Cylinder Head &amp; Valves

FIRST USED ON: \_\_\_\_\_

ASSY DWGS: G-3961

It.	Part No.	Part Name	Matl	Qty	Remarks
1		Capscrew, Cover		3	5/16-18 x 3/4 Sock. Head
2	G-3710	Gasket, Sub-Cover		1	
3		Capscrew		6	1/2-13 x 1-1/4
4	7694	Stud, Cylinder Head	St	7	
5	142	Nut, Cylinder Head	St	7	
6	7690	Washer, Cylinder Head		7	
7	78304	Gasket, Cylinder Head Cover		1	Gar #000
8	G-3690	Gasket, Cylinder Head	Set #	1	
9	G-3691	Gasket, Cylinder Head	G-4084	1	3/32 Cork & Neoprene Comp.
10					
11	7754	Pre-Assy., Cylinder Head Cover		1	Assy. Dwg. 7754 Consisting of:
12	76986-1	Cover, Cylinder Head	St	1	
13	G-4356	Knob Pin, Knob	Assem. & Dwg. 7755 (2) Each	1 1	
14	79965	Ring, Lock		2	
15					
16	* Use G-5104	in place of 76751 for complete replacement of Air Start Valve Assembly			
17	G-3698	Group of Gaskets for Head Replacement			
18					
19	G-3719	Cyl. Head Assy. Complete with Safety Valve			
20		Consisting of: G-3717 plus all parts on G-15-F			
21					
22					

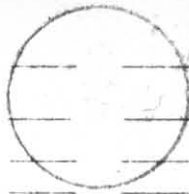
CI = Cast Iron  
 CS = Cast Steel  
 FS = Forged Steel

CRS = Cold Rolled Steel  
 CBr = Cast Brass  
 CBrz = Cast Bronze

Date Issued: 1-6-50

ASSEMBLY NO. G-15-F  
SHEET NO. \_\_\_\_\_

ENGINE MODEL	<u>G</u>	<u>Q</u>	
2 CYL.	_____	_____	
3 CYL.	_____	_____	
4 CYL.	_____	_____	
5 CYL.	_____	_____	
6 CYL.	<u>6</u>	<u>6</u>	
8 CYL.	<u>8</u>	<u>8</u>	


 ASSY NAME: Relief Valve  
 Used on Cyl.Heads w/Sub Cover
FIRST USED ON: 49051

ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks
1					
2	G-3932	Assy. Relief Valve		1	Assy.Dwg.G-3932 Consisting of:
3	G-3933	Valve Body	CI	1	
4	G-3934	Stem	CRS	1	
5	G-3935	Spring	St	1	
6	G-3936	Washer, Spring	St	1	
7	G-3937	Adjusting Screw	Br	1	
8	G-3938	Nut	Er	1	
9		Pipe Plug		1	1/2" Male Blk
10					
11					
12	93351-1	Gasket		1	3/64 JM #60
13		Nut		2	5/8-11
14					
15					
16					
17					
18					
19					
20					
21					
22					

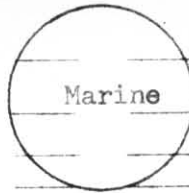
CI = Cast Iron	CRS = Cold Rolled Steel
CS = Cast Steel	CBr = Cast Brass
FS = Forged Steel	CBrz = Cast Bronze

Date Issued: 3-8-46  
Retyped: 8-19-52

ASSEMBLY NO. G-16-F  
SHEET NO. 1

ENGINE MODEL G

2 CYL. \_\_\_\_\_  
3 CYL. \_\_\_\_\_  
4 CYL. \_\_\_\_\_  
5 CYL. \_\_\_\_\_  
6 CYL. 6  
8 CYL. 8



ASSY NAME: Rocker & Push Rod  
(Air Starting)Wide  
Roller Tappets

FIRST USED ON: \_\_\_\_\_

ASSY DWGS: 75776

It.	Part No.	Part Name	Matl	Qty	Remarks	
1						
2	76757	Pre-Assem. Rocker Arms & Shaft		1	See Assem. Dwg. 76517 Consisting of:	
3	G-3685	Rocker Arm L.H.	CS	1	} Pre-Assem. 76761	
4	G-4772	Bushing		1		Made from Half of H-342
5	G-4771	Bushing		1		Made from Half of H-342
6		Pipe Plug, Slotted 1/8		1		
7	G-3686	Rocker Arm, R.H.	CS	1	} Pre-Assem. 76815	
8	G-4772	Bushing		1		Made from Half of H-342
9	G-4771	Bushing		1		Made from Half of H-342
10		Pipe Plug, Slotted 1/8	1	1		
11	75111-1	Rocker Arm, Air	CS	1	} Pre-Assem. 76755	
12	12503-5	Bushing	Brz	2		
13	75116-1	Screw, Adjusting, Air		1	SAE 4140	
14		Nut, Jam		1	3/4-16	
15	7725-1	Shaft, Rocker		1	SAE X-1315	
16		Pipe Plug, Slotted	BR	1	1/4	
17	75778	Body, Hydraulic Lifter		2	SAE 1020 Hardened	
18	75779	Screw, Adjusting	CRS	2		
	75780	Locknut, Adj. Screw	CRS	2		
19	75781	Lock, Lifter Body		2	Spring Steel	
20	B-3092	Zero Lash Unit		2		
21		Elbow 90° Street Nipple	Imp Blk	1 1	50F 1/4T 1/8P 1/8 x 2	
22		Union Nut	Imp	1	41F 1/4T	

CI = Cast Iron  
CS = Cast Steel  
FS = Forged Steel

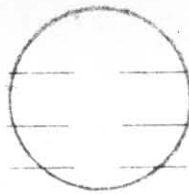
CRS = Cold Rolled Steel  
CBr = Cast Brass  
CBrz = Cast Bronze



Edition 7 3  
 Date Issued: 3-8-43  
 Retyped: 1-10-49

ASSEMBLY NO. G-16-F  
 SHEET NO. 2

ENGINE MODEL G  
 2 CYL. \_\_\_\_\_  
 3 CYL. \_\_\_\_\_  
 4 CYL. \_\_\_\_\_  
 5 CYL. \_\_\_\_\_  
 6 CYL. 6  
 8 CYL. 8



ASSY NAME: Rocker & Push Rod

FIRST USED ON: \_\_\_\_\_

ASSY DWGS: 75776

It.	Part No.	Part Name	Matl	Qty	Remarks	
1						
2	76816	Pre-Assy. Roller & Pin		<b>[3]</b>	EACH Consisting of:	
3	G-5624	Roller	CRS	1	<div style="border-left: 1px solid black; border-right: 1px solid black; border-bottom: 1px solid black; padding: 2px;">           Remachine 7756-1            Seamless Steel Weld-                                              ed         </div>	
4	G-5623	Pin		1		
5						
6						
7	G-3940 <del>78139</del>	Pre-Assy. Push Rod		<b>[2]</b>	Assy. Dwg. <del>78139</del> G-3940 EACH Consisting of:	
8	G-3941 <del>77335-1</del>	<div style="border-left: 1px solid black; border-right: 1px solid black; border-bottom: 1px solid black; padding: 2px;">           Tube, Push Rod, Int.&amp;Exh.         </div>		1	<div style="border-left: 1px solid black; border-right: 1px solid black; border-bottom: 1px solid black; padding: 2px;">           Remachine 7756-1            Seamless Steel Weld-                                              ed         </div>	
9	G-3902 <del>7756-2</del>		Top, Push Rod, Int. & Exh.	CRS		1
10	G-3901 <del>7756-3</del>		Bottom, Push Rod, Int. & Exh.	CRS		1
11						
12						
13	77671	Pre-Assy. Push Rod		1	Assy. Dwg. 77671 Consisting of:	
14	75290-1	<div style="border-left: 1px solid black; border-right: 1px solid black; border-bottom: 1px solid black; padding: 2px;">           Push Rod, Air         </div>	CRS	1	<div style="border-left: 1px solid black; border-right: 1px solid black; border-bottom: 1px solid black; padding: 2px;">           Welded         </div>	
15	75290-2		Top, Push Rod, Air	CRS		1
16						
17						
18	148	Nut, Rocker Shaft		2	Hymo CD	
19						
20						
21						
22						

CI = Cast Iron                      CRS = Cold Rolled Steel  
 CS = Cast Steel                    CBr = Cast Brass  
 FS = Forged Steel                CBrz = Cast Bronze

Date Issued: 12-1-44  
Retyped: 1-10-49ASSEMBLY NO. G-17-DD  
SHEET NO. 1ENGINE MODEL GASSY NAME: Tappet & Guide

2 CYL. \_\_\_\_\_

3 CYL. \_\_\_\_\_

4 CYL. \_\_\_\_\_

5 CYL. \_\_\_\_\_

6 CYL. 68 CYL. 8RH. Rev. ~~Wide Int. & Exh. Rollers~~, Air Starting;

Marine

Brz. Bushed Int., Exh., & Fuel; Fuel  
Guide without insert Without Liners, RH  
FIRST USED ON: All Speeds

ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks
1					
2	78153	Pre-Assy. Fuel Tappet & Guide		1	Assy. Dwg. #77968 Consisting of:
3	76882-1	Tappet SAE 1040		1	
4	76741-1	Roller SAE X-1315		1	Pre-Assy. NSS
5	79959-1	Bushing 79256	Brz	1	Pre-Assy. 77072 NSS
6	76886-1	Pin		1	NSS
7	77853-1	Guide & Fuel Pump Base	CI	1	
8	76884-1	Umbrella Locknut		1	Stressproof
9	6202-A	Plug, Adjusting		1	SAE 1020
10	76885-1	Shaft, Priming		1	SAE 4140
11	7744-1	Locking Screw		1	
12		Lockwasher		1	1/4
13	7745-1	Spring, Locking		1	Spring Wire
14		Plug, Pipe	Br	1	1/8 Slotted
15	B-5307	Ball	St	1	5/16 Dia.
16		Connector		1	Imp. 68F 1/4T 1/8P.T.
17					
18					
19		Capscrew, Allen		2	3/8-16 x 3-1/4
20	77967-1	Gasket		1	1/32 Vel.
21					
22					

CI = Cast Iron

CS = Cast Steel

FS = Forged Steel

CRS = Cold Rolled Steel

CBr = Cast Brass

CBrz = Cast Bronze

CONTINUED

NEXT PAGE

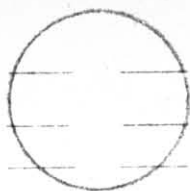
Date Issued: 12-1-44  
 Retyped: 1-10-49

ASSEMBLY NO. G-17-DD  
 SHEET NO. 2

ENGINE MODEL G

ASSY NAME: Tappet & Guide

2 CYL. \_\_\_\_\_  
 3 CYL. \_\_\_\_\_  
 4 CYL. \_\_\_\_\_  
 5 CYL. \_\_\_\_\_  
 6 CYL. 6 \_\_\_\_\_  
 8 CYL. 8 \_\_\_\_\_



FIRST USED ON: \_\_\_\_\_

ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks
1					
2	79653	& Guide Pre-Assy.Int.& Exh.Air Tappet		1	Assy. Dwg. 79728 Consisting of:
3	79640-1	Guide	CI	1	
4					
5	77433	Pre-Assy. Tappet, Int.&Exh.		2	EACH consisting of:
6	77392-1	Tappet, Int. & Exh.		1	SAE 4140
7	77390-1	Roller, Int.&Exh. Pre-Assy		1	See Dwg. NSS
8	G-4791 <del>10640-1</del>	Bushing, Int.&Exh. 79255	Brz	1	Pre-Assy 78120 NSS
9	77389-1	Pin, Int. & Exh.		1	SAE X-1315 NSS
10					
11	75281	Tappet, Air (Gr.Shafting)		1	
12	75276	Roller, Air Pre-Assy		1	SAE X-1315 77434 NSS
13	G-3952 <del>4616-2</del>	Pin, Air 78119		1	SAE X-1315 NSS
14	7797	Dowel	CRS	2	
15		Plug, Pipe	Blk	2	Male 1/8
16	77391-1	Spring, Air Tappet		1	Spring Steel
17	79982-1	Retainer, Spring	St	1	
18	79983-1	Snap Ring		1	Spring Steel
19		Elbow 90°	Imp	1	69F 1/4T 1/8P
20		Connector	Imp	1	68F 1/4T 1/8P
21					
22	106-6	Dowel	CRS	1	

CI = Cast Iron  
 CS = Cast Steel  
 FS = Forged Steel

CRS = Cold Rolled Steel  
 CBr = Cast Brass  
 CBrz = Cast Bronze

Date Issued: 12-2-47  
Retyped: 11-8-48

ASSEMBLY NO. G-18-S  
SHEET NO. \_\_\_\_\_

ENGINE MODEL G

2 CYL. \_\_\_\_\_

3 CYL. \_\_\_\_\_

4 CYL. \_\_\_\_\_

5 CYL. \_\_\_\_\_

6 CYL. 1 \_\_\_\_\_

8 CYL. \_\_\_\_\_

ASSY NAME: Intake Manifold  
Non-superchd., 6 Cyl., Wire Mesh  
Intake Filter Panels

FIRST USED ON: 47103

ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks
1	B-5023	Panel, Filter		3	
2					
3	<del>G-3908</del> <del>75537-1</del>	Ell, Air Inlet	CI	6	
4	78310-1	Gasket, Ell - Crankcase		6	Gar. 660
5	78309-1	Gasket, Ell - Head		6	Gar. 660
6		Capscrew, Ell - Crankcase		24	1/2 - 13 x 1-1/4
7	78308-1	Gasket, Intake Manifold		3	Gar. 660
8		Capscrew, Cover- Crankcase		36	1/2 - 13 x 1
9					
10	G-2002-1	Cover, Rear Man. Opening	St Pl	1	
11	G-2003-1	Gasket, Cover - Block	Vel	1	
12		Capscrew		6	3/4 - 10 x 1-1/4
13					
14	G-2459-1	Cover, Front Man. Opening	St Pl	1	
15	<del>G-2254</del> <del>G-2099-1</del>	Gasket, Cover	Vel	1	
16		Capscrew, Cover - Block		8	3/4 - 10 x 1-1/4
17					
18					
19					
20					
21					
22					

CI = Cast Iron  
CS = Cast Steel  
FS = Forged Steel

CRS = Cold Rolled Steel  
CBr = Cast Brass  
CBrz = Cast Bronze



Date Issued: 11-29-49

SEE G-219

ASSEMBLY NO. G-19-MM  
SHEET NO. \_\_\_\_\_ENGINE MODEL G2 CYL. \_\_\_\_\_  
3 CYL. \_\_\_\_\_  
4 CYL. \_\_\_\_\_  
5 CYL. \_\_\_\_\_  
6 CYL. 1  
8 CYL. \_\_\_\_\_ASSY NAME: Exhaust Manifold  
6 Cyl., R or LH., Unsupchd., Welded  
(Used w/Cyl.Hd.w/Sub-Cover) 3" Water  
Inlet  
FIRST USED ON: \_\_\_\_\_

ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks
1	G-3798	Manifold, Exhaust	See Dwg	1	
2	G-4160 94900	Flange, Exh Man - Cyl Hd Pyrometer Connection	HRS	6 6	Included in G-3798
3	G-4162 B-3990	Flange Flange, Slip-on		2 2	
4		Capscrew, Cyl. Head		24	5/8 - 11 x 1-1/2
5	78800-1	Gasket, Cyl. Head		6	Gar 7508
6		Pipe Plug		8	1/2" Blk
7		Pipe Plug		4	3/4" Blk
8	7280-1	Cover, Blind	CI	1	
9	78801-1	Gasket, Blind Cover		1	Gar 7508
10		Nut		4	3/4 - 10
11		Bolt		4	3/4 - 10 x 2-1/2
12	B-3873	Flange, Blind		1	
13	77728-1	Gasket	Rub	1	
14		Bolt, Flange,	St	8	5/8 - 11 x 2-3/4
15		Nut, Hex.		8	5/8 - 11
16					
17					
18					
19					
20					
21					
22					

CI = Cast Iron  
CS = Cast Steel  
FS = Forged SteelCRS = Cold Rolled Steel  
CBr = Cast Brass  
CBrz = Cast Bronze

Date Issued: 11-30-49

SEE G-220-N

ASSEMBLY NO. G-20-N

SHEET NO.

ENGINE MODEL G

2 CYL.

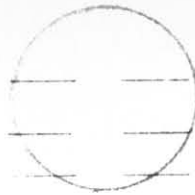
3 CYL.

4 CYL.

5 CYL.

6 CYL. 1

8 CYL.



ASSY NAME: Water Manifold  
6 Cyl., w/Water-cooled Exh. Manifold  
3" Water Outlet Ell; (Used w/Cyl.Hd.  
w/Sub-Cover)

FIRST USED ON:

ASSY DWGS:

It.	Part No.	Part Name	Matl	Qty	Remarks
1	79248-1	Cover, Water Manifold	St	3	
2	78836-1	Gasket, Cover - Crankcase	R Br	3	
3		Capscrew, Cover - Crankcase		60	1/2 - 13 x 1
4	7811	Screen	Monel	6	1/4 Mesh
5		Capscrew, Screen	"	24	1/2 - 13 x 3/4
6	G-3706	Ell, Head - Manifold	CI	6	
7	G-3708	Gasket, Ell - Head	Rub	6	
8	G-3697	Gasket, Ell - Manifold	Rub	6	
9		Capscrew, Ell		42	3/8 - 16 x 1
10					
11					
12					
13					
14					
15					
16					
17					
18					
19					
20					
21					
22					

CI = Cast Iron  
CS = Cast Steel  
FS = Forged Steel

CRS = Cold Rolled Steel  
CBr = Cast Brass  
CBrz = Cast Bronze

Date Issued: 2-8-45  
 Retyped: 4-14-49

SEE G-221-K&L

ASSEMBLY NO. G-21-D  
 SHEET NO. \_\_\_\_\_

ENGINE MODEL G  
 2 CYL. \_\_\_\_\_  
 3 CYL. (Reversible Eng. Only) \_\_\_\_\_  
 4 CYL. \_\_\_\_\_  
 5 CYL. \_\_\_\_\_  
 6 CYL. 1 \_\_\_\_\_  
 8 CYL. \_\_\_\_\_

ASSY NAME: Starting Air Manifold  
 CI. 6 cyl. with piston type rev. mech.  
**Marine**

FIRST USED ON: \_\_\_\_\_

Group \_\_\_\_\_  
 ASSY DWGS: 79766

It.	Part No.	Part Name	Matl	Qty	Remarks
1	75093-1	Jumper, Air	CI	5	
2	78844-1	Gasket, Jumper to Cyl. Hd.		5	3/64 Johns-Man.#60
3		Capscrew, Jumper to Cyl.Hd.		10	1/2-13 x 2-1/4
4		Capscrew, Jumper to Cyl.Hd.		20	1/2-13 x 3-1/4
5	75733-1	Flange, Blind	St	1	1/2" St.Plate
6	78838-1	Gasket, Flange to Cyl.Hd.		1	3/64 Johns.Man.#60
7		Capscrew, Flange to Cyl.Hd.		3	1/2-13 x 1-1/4
8		Ell, Street		1	3/8" Blk
9		Nipple, Hydraulic		1	3/8" x short Blk
10	B-3254	Valve, 250# Globe	Brz	1	3/8"
11					
12					
13					
14					
15					
16					
17					
18					
19					
20					
21					
22					

CI == Cast Iron                      CRS == Cold Rolled Steel  
 CS == Cast Steel                    CBr == Cast Brass  
 FS == Forged Steel                CBrz == Cast Bronze

Date Issued: 6-1-53

ASSEMBLY NO. G-22-B  
SHEET NO. 1 of 1

ENGINE MODEL F G \_\_\_\_\_  
 2 CYL. \_\_\_\_\_  
 3 CYL. \_\_\_\_\_  
 4 CYL. \_\_\_\_\_  
 5 CYL. \_\_\_\_\_  
 6 CYL. 1 1 \_\_\_\_\_  
 8 CYL. 1 1 \_\_\_\_\_

ASSY NAME: FRONT CAMSHAFT BEARING  
Reversible, Marine

FIRST USED ON: 9020 - 9022

ASSY DWGS: 75270

It.	Part No.	Part Name	Matl	Qty	Remarks
1	C-5787	Cap, Bearing		1	
2					
3	78383	Assem. Cam Shells		1	Consisting Of:
4	C-5783	Shell (Lower)		1	NSS
5	C-5785	Shell (Upper)		1	NSS
6					
7					
8	75303-1	Ring, Bearing Locking		2	
9		Machine Screw, Flat Head		2	10-24 x 3/4
10					
11					
12					
13					
14					
15					
16					
17					
18					
19					
20					
21					
22					

CI = Cast Iron  
 CS = Cast Steel  
 FS = Forged Steel

CRS = Cold Rolled Steel  
 CBr = Cast Brass  
 CBrz = Cast Bronze



Date Issued: 8-9-46  
Retyped 6-1-53

ASSEMBLY NO. G-23-A  
SHEET NO. \_\_\_\_\_

ENGINE MODEL F G

2 CYL. \_\_\_\_\_  
3 CYL. \_\_\_\_\_  
4 CYL. \_\_\_\_\_  
5 CYL. \_\_\_\_\_  
6 CYL. 6 6 \_\_\_\_\_  
8 CYL. 8 8 \_\_\_\_\_



ASSY NAME: Intermediate Cam Bearing

FIRST USED ON: 9020-9022

ASSY DWGS: 75270

It.	Part No.	Part Name	Matl	Qty	Remarks
1	75302-1	Cap Bearing	CS	1	
2					
3	78385	Assembly Shell		1	Consisting of:
4	G-5747	Shell (Lower) NSS		1	
5	G-5748		Shell (Upper) NSS	1	
6					
7					
8	75303-1	Ring, Bearing locking	CRS	2	
9		Flat head machine screw		2	10-24 x 3/4
10					
11					
12					
13					
14					
15					
16					
17					
18					
19					
20					
21					
22					

CI = Cast Iron                      CRS = Cold Rolled Steel  
CS = Cast Steel                    CBr = Cast Brass  
FS = Forged Steel                CBrz = Cast Bronze

Edition: 34  
 Date Issued: 6-14-54

ASSEMBLY NO. G-24-W  
 SHEET NO. \_\_\_\_\_

ENGINE MODEL \_\_\_\_\_  
 2 CYL. \_\_\_\_\_  
 3 CYL. \_\_\_\_\_  
 4 CYL. \_\_\_\_\_  
 5 CYL. \_\_\_\_\_  
 6 CYL. \_\_\_\_\_  
 8 CYL. \_\_\_\_\_

ASSY NAME: CAMSHAFT  
MG-6 RH      PISTON REVERSE  
 FIRST USED ON: \_\_\_\_\_  
 ASSY DWGS: 79790

It.	Part No.	Part Name	Matl	Qty	Remarks
1	77521	Assembly Gear		1	See Dwg. 77521
2	G-4142 *	Assembly Camshaft		1	See Dwg. G-4142
3					
4	7593	Bolt, Cam Ring Gear		2	
5		Nut, Slotted		2	9/16-18
6		Washer		2	9/16 SAE
7		Cotter		6	1/8 x 1-1/4
8					
9					
10					
11					
12					
13					
14					
15	*	FOR COMPLETE CAMSHAFT REPLACEMENT			
16		SEE REPLACEMENT SELECTION TABLES	G-24-1 thru	G-24-7.	
17					
18					
19					
20					
21					
22					

CI = Cast Iron      CRS = Cold Rolled Steel  
 CS = Cast Steel    CBr = Cast Brass  
 FS = Forged Steel   CBrz = Cast Bronze

Date Issued: 9-12-47  
 Revised: 10-20-48

SEE G-225-W

ASSEMBLY NO. G-25-W  
 SHEET NO. \_\_\_\_\_

ENGINE MODEL G  
 2 CYL. \_\_\_\_\_  
 3 CYL. \_\_\_\_\_  
 4 CYL. \_\_\_\_\_  
 5 CYL. \_\_\_\_\_  
 6 CYL. 1  
 8 CYL. 1



ASSY NAME: Gear Case  
 Reversible R.H., Small Crankshaft Cap,  
 1 or 2 Cent. Water Pumps, Large Capacity  
 Lube Pump

FIRST USED ON: 47021-24 46161

ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks
1	G-1782-1	Gear Case	CI	1	
2	78852-1	Gasket, Gear Case -Cyl. Block	Vel	1	1/32"
3	78852-2	Gasket, Gear Case -Cyl. Block	Vel	1	1/32" } Gasket Group 79795
4	78852-3	Gasket, Gear Case - Cyl. Block	Vel	1	1/32"
5	78852-4	Gasket, Gear Case -Cyl. Block	Vel	1	1/32"
6		Capscrew		25	1/2-13 x 1-1/4
7	75357-1	Cover, Idler Gear	CI	1	
8	78863-1	Gasket, Cover-Case		1	
9		Capscrew		4	1/2-13 x 1-1/2
10	G-3217-1	Cap, Crankshaft		1	
11	6294-A	Cover, Crankshaft Cap	CI	1	
12	78996-1	Gasket, Crankshaft Cap Cover	Vel	1	
13		Capscrew, Crankshaft Cap Cover		2	1/4-20 x 5/8
14	78897-1	Gasket, Crank Cap		1	1/32 Vel.
15		Capscrew, Crank Cap		4	3/8-16 x 1-1/4
16	7918-1	Cover, Gear Case Side	CI	3	
17	78997-1	Gasket		3	
18		Capscrew		18	1/2-13 x 1-1/4
19	7780-1	Cover, Camshaft Gear	CI	1	
20	78998-1	Gasket		1	
21		Capscrew		7	1/2-13 x 1-1/4
22					

CI = Cast Iron                      CRS = Cold Rolled Steel  
 CS = Cast Steel                    CBr = Cast Brass  
 FS = Forged Steel                CBrz = Cast Bronze

Date Issued: 5-6-47  
 Retyped: 5-11-49

ASSEMBLY NO. G-26-G  
 SHEET NO. \_\_\_\_\_

ENGINE MODEL G \_\_\_\_\_

- 2 CYL. \_\_\_\_\_
- 3 CYL. \_\_\_\_\_
- 4 CYL. \_\_\_\_\_
- 5 CYL. \_\_\_\_\_
- 6 CYL. \_\_\_\_\_
- 8 CYL. \_\_\_\_\_



ASSY NAME: Gear Set  
 Water Pump Speed up Drive  
 300-400 Eng. RPM.  
 Reversible Engines & Non-Reversing Eng  
 FIRST USED ON: \_\_\_\_\_

ASSY DWGS: 77793

It.	Part No.	Part Name	Matl	Qty	Remarks
1	79890-1	Forging Gear, Crankshaft (Dwg. 79149)		1	Brinell 245-260 Forge SAE 3145
2	7758	Shaft, Idler Gear Stub	CS	1	
3					
4	77672	Pre-Assy., Idler Gear & Bush		1	Consisting of:
5	7757	Gear, Idler NSS		1	Cast Steel 1040 Brinell 210-230
6	7759	Bushing, Idler Gear	Brz	2	
7					
8					
9	7760	Washer, Idler Gear Thrust	CRS	1	
10	7761	Shim, Thrust Washer	Br	14	.003" thick
11	7768	Capscrew, Thrust Washer Wire, Capscrew	CRS	2 1	5/8 - 11 x 1-1/2 3/32 dia. x 7/8
12	109-1	Dowel, stub shaft		2	
13	* G-2550-1	Gear, drive	CS	1	SAE 1030
14		Capscrew, gear		6	1/2-13 x 2
15	G-2043-1	Locking Clip		3	
16					
17		* Replaced by G-4167 Gear		(1)	
18		G-4342 Spacer		(1)	
19		Capscrew (6)			1/2-13 x 3
20					
21					
22					

CI = Cast Iron                      CRS = Cold Rolled Steel  
 CS = Cast Steel                    CBr = Cast Brass  
 FS = Forged Steel                CBrz = Cast Bronze



ENGINE MODEL G F

2 CYL. \_\_\_\_\_  
 3 CYL. \_\_\_\_\_  
 4 CYL. \_\_\_\_\_  
 5 CYL. \_\_\_\_\_  
 6 CYL. 1 1 \_\_\_\_\_  
 8 CYL. \_\_\_\_\_

ASSY NAME: Governor & Tach. Drive  
Rev. Eng., Ent. Gov.; w/o Rev.Cntr.  
Drive

FIRST USED ON: \_\_\_\_\_

G-3969

ASSY DWGS: ~~7915~~, 75350

It.	Part No.	Part Name	Matl	Qty	Remarks
1					
2	G-3659	Assy., Gov. & Tach. Drive		1	Consisting of:
3	G-3634 <del>6402-J</del>	Stub Shaft, Gov. Drive	CS	1	} Assy. 78809
4	G-3551	Gear, Tach. Drive	St	1	
5	7913	Gear, Governor Drive	St	1	
6	G-3640 <del>6403-G</del>	Flange, Tach. Drive Stub	CI	1	
7	<del>G-3641</del> G-4121	Bolt, Gear Sleeve	CRS	4	
8	G-3642 <del>6404-G</del>	Shaft, Tach. Drive	CRS	1	
9	G-3639 <del>6403-D</del>	Bushing, Sleeve - Lge	Brz	1	
10	G-3638 <del>6403-E</del>	Bushing, Sleeve - Sm.	Brz	1	
11	G-3635 <del>6403-A</del>	Sleeve, Drive Gear	CS	1	
12	G-3636 <del>6402-B</del>	Washer, Stub Shaft	CRS	1	
13	103-3	Dowel, Washer - Stub Shaft		1	
14	<del>G-3637</del> <del>6403-B</del>	<del>Flange, Tach. Drive Gear</del>	<del>CRS</del>	<del>1</del>	
15		Pipe Plug, Stub Shaft End	Br	1	1/8 Slotted
16		Taper Pin, Tach.		1	#1 x 1
17		Cotter Pin		4	3/32 x 7/8
18		Washer Nut, High Castle		4 4	SAE 3/8 3/8 - 24
19		Capscrew, Sleeve - Shaft		1	1/2 - 20 x 1
20		Lockwasher, External		1	1/2
21		Connector		1	Imp 68F 1/4T 1/8P
22	91233-2	Shim Thrust Washer	St	14	.003" Thick

CI = Cast Iron      CRS = Cold Rolled Steel  
 CS = Cast Steel    CBr = Cast Brass  
 FS = Forged Steel    CBrz = Cast Bronze

**CONTINUED  
 NEXT PAGE**

Date Issued: 9-16-49

ASSEMBLY NO. G-27-P  
SHEET NO. 2

ENGINE MODEL G F

ASSY NAME: Gov. & Tach. Drive

2 CYL. \_\_\_\_\_  
3 CYL. \_\_\_\_\_  
4 CYL. \_\_\_\_\_  
5 CYL. \_\_\_\_\_  
6 CYL. 1 1 \_\_\_\_\_  
8 CYL. \_\_\_\_\_



FIRST USED ON: \_\_\_\_\_

ASSY DWGS: G-3969  
7915, 75350

It.	Part No.	Part Name	Matl	Qty	Remarks
1	75349-1	Flange, Tach. Conn.	CI	1	
2	106-2	Dowel, Stub Shaft, Case		2	
3	79004-1	Gasket, Tach. Drive Flange	Vel	1	
4	455	Stud, Stub Shaft - Case		4	
5	6613-A	Cap, Tach. Flange		1	Omit if Tach. is used
6	79003-1	Gasket, Tach. Flange	Cop Asb	1	Victor 2067 Omit if Tach is used
7	B-5646 <del>B-3730</del>	Oil Seal		1	Natl. 50119-S
8		Capscrew, Tach. Drive Flg.		4	3/8 - 16 x 1
9		Nut, Slotted		4	1/2 - 13
10		Cotter Pin		4	3/32 x 1-1/8
11					
12					
13					
14					
15					
16					
17					
18					
19					
20					
21					
22					

CI = Cast Iron                      CRS = Cold Rolled Steel  
CS = Cast Steel                    CBr = Cast Brass  
FS = Forged Steel                CBrz = Cast Bronze

Date Issued: 7-9-46  
 Retyped: 10-2-46

SEE G-221-J&L

ASSEMBLY NO. G-28-S  
 SHEET NO. \_\_\_\_\_

ENGINE MODEL G  
 2 CYL. \_\_\_\_\_  
 3 CYL. \_\_\_\_\_  
 4 CYL. \_\_\_\_\_  
 5 CYL. \_\_\_\_\_  
 6 CYL. 1 \_\_\_\_\_  
 8 CYL. 1 \_\_\_\_\_



ASSY NAME: Air Starting Lines  
Reversible R.H. Eng. w/Piston Type  
Rev. Mech. 600# Strainer

FIRST USED ON: \_\_\_\_\_

Group \_\_\_\_\_  
 ASSY DWGS: 79766

It.	Part No.	Part Name	Matl	Qty	Remarks
1		Line from Air Tank to Operating Control Hsg.			
2	B-3161	Valve, 250# Globe	Brz	1	1 1/2"
3		Nipple	ST	1	1 1/2" x close
4		Bushing	ST	1	3/4 x 1/2
5	B-4288	Strainer, Y	ST	1	1 1/2" 600# (Screwed)
6	B-3189	Pet Cock	Brz	1	1/2"
7	G-2915-1 <del>77082-5</del>	Pipe, Bent Air Starting	ST	1	
8	79768-1	Flange	CS	1	
9	79771-1	Gasket, Flange to Control Hsg.		1	3/64 Johns-Man. #60
10		Capscrew, Flange to Control Hsg.		4	5/8-11 x <del>3-3/4</del> 4
11					
12		Line from Operating Control to Air Manifold			
13	79771-1	Gasket, Flange to Cont. Hsg.		1	3/64 Johns-Man. #60
14		Capscrew, Flange to Cont. Hsg.		4	5/8-11 x <del>3-3/4</del> 4
15	79768-1	Flange	CS	1	
16	79796-1	Pipe Bent	ST	1	
17		Ell, 90° Welding	ST	1	1 1/2"
18	79767-1	Ell	CS	1	
19					
20					
21					
22					

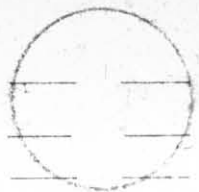
CI == Cast Iron                      CRS == Cold Rolled Steel  
 CS == Cast Steel                    CBr == Cast Brass  
 FS == Forged Steel                CBrz == Cast Bronze



Date Issued: 12-21-44  
 Retyped: 9-4-46

ASSEMBLY NO. G-29-Q  
 SHEET NO. 1

ENGINE MODEL G  
 2 CYL. \_\_\_\_\_  
 3 CYL. \_\_\_\_\_  
 4 CYL. \_\_\_\_\_  
 5 CYL. \_\_\_\_\_  
 6 CYL. 1  
 8 CYL. 1



ASSY NAME: Reverse Mechanism  
 R.H. Piston Type

FIRST USED ON: 45057

ASSY DWGS: 79679

It.	Part No.	Part Name	Matl	Qty	Remarks
1					
2	<del>79722</del>	Pre-Assy., Reverse Mechanism		1	<del>Assy. Dwg. 79722</del> <del>Consisting of:</del>
3	79688-1	Housing, Cylinder	CBrz	1	Pre-Assy. 79701 Assy. Dwg. 79701 Ni. Plate #6-32 x 3/8
4	G-1105-1	Caution Plate	Bake	1	
5	79675-1	Pin, Thrust	St	4	
6		Screw, Round HD. Mach. Screw		4	
7	101-3	Setscrew, Thrust Pin	St	4	
8					
9	B-3712	Seal, Piston Shaft		1	
10	79678-1	Piston	CBrz	1	
11	79681-1	Key, Woodruff Shaft, Piston	St	1	#5 (1/8 x 5/8)
12	79677-1	Nut, Piston Shaft	Br	2	Pre-Assy. & Dwg. 79722
13	79683-1	Clip, Piston Nut Locking	St	2	
14	B-3710	Ring, Piston	Brz	1	R.H. angle cut
15	B-3711	Ring, Piston	Brz	1	L.H. angle cut
16	79680-1	Hub, Thrust	CBr	1	
17	7815-1	Ring, Thrust	CS	1	
18	77520-1	Spacer, Thrust		1	Steel plate
19	7814-1	Shim, Thrust Ring		1	1/16 Lam. Steel
20		Capscrew	St	2	1/8-13 x 2 1/2
21	180-3	Clip, Locking	St	2	
22		Key, Woodruff	St	1	3/16 x 1"

CI = Cast Iron      CRS = Cold Rolled Steel  
 CS = Cast Steel    CBr = Cast Brass  
 FS = Forged Steel   CBrz = Cast Bronze

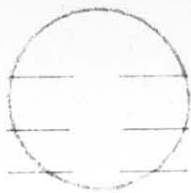
CONTINUED  
 NEXT PAGE



Date Issued: 12-21-44  
 Retyped: 9-4-46

ASSEMBLY NO. G-29-Q  
 SHEET NO. 2

ENGINE MODEL G  
 2 CYL. \_\_\_\_\_  
 3 CYL. \_\_\_\_\_  
 4 CYL. \_\_\_\_\_  
 5 CYL. \_\_\_\_\_  
 6 CYL. 1 \_\_\_\_\_  
 8 CYL. 1 \_\_\_\_\_



ASSY NAME: Reverse Mechanism

FIRST USED ON: 45057

ASSY DWGS: 79679

It.	Part No.	Part Name	Matl	Qty	Remarks
1	79676-1	Pin, Interlock lower	St	2	
2	79696-1	Pin, Interlock middle	St	2	
3	79685-1	Pin, Interlock upper	St	2	
4		Nut, Regular Jam	St	2	1/2-20
5	79697-1	Cover, Cylinder	CBrz	1	
6	B-3713	Seal, Piston Shaft		1	Pre-Assy.
7	79698-1	Gasket, Cover	Vel.	1	& Dwg. 79722
8		Capscrew, Socket Head	St	8	5/8-11x1 1/2 Allen or equal
9		Capscrew, Socket Head	St	2	5/8-11x2 1/2 Allen or equal
		Capscrew, Socket Head	St	2	5/8-11x2 1/2 Allen or equal
10	79684-1	Cap, Cylinder Cover	CBrz	1	
11	B-3188	Cock, Drain	Br	2	
12					
13					
14	<del>79140-1</del>	<del>Ring, Locking</del>		<del>1</del>	See 108 Assy.
15	<del>78492-1</del>	<del>Nut, Manual Reverse</del>		<del>1</del>	
16	G-2527-1	Capscrew, Thrust Ring	St	6	
		Nut, Hex, Slotted	St	6	1/2-13
17	<del>100-5</del>	<del>Clip, Locking Shaft Nut</del>	St	6	
18	X-1847	Shim, Thrust Ring		1	5/32 Lam. Br.
19		Capscrew, Cylinder to case	St	10	1/2-13 x 1 1/2
20	79682-1	Gasket, Cylinder to case	Vel	1	
21		Washer	St	6	1/2 SAE
22		Cotter Pin	St	6	1/8 x 1-1/4

CI = Cast Iron      CRS = Cold Rolled Steel  
 CS = Cast Steel    CBr = Cast Brass  
 FS = Forged Steel   CBrz = Cast Bronze

CONTINUED  
 NEXT PAGE

Date Issued: 12-21-44  
 Retyped: 10-19-49

ASSEMBLY NO. G-29-Q  
 SHEET NO. 3

ENGINE MODEL G  
 2 CYL. \_\_\_\_\_  
 3 CYL. \_\_\_\_\_  
 4 CYL. \_\_\_\_\_  
 5 CYL. \_\_\_\_\_  
 6 CYL. 1 \_\_\_\_\_  
 8 CYL. 1 \_\_\_\_\_



ASSY NAME: Reverse Mechanism  
 FIRST USED ON: 45057  
 ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks
1					
2		USE THE FOLLOWING PRE-ASSY. NUMBER WHEN ORDERING COMBINATIONS			
3					
4	<del>G-1151</del>	<del>Pre-Assy., Reverse &amp; Operating Control</del>			<del>(G-29-Q &amp; G-55-V)</del>
5	79723	Pre-Assy., Reverse & Operating Control			(G-29-Q & G-55-Q) (Assy. Dwg. 79679)
6	<del>79870</del>	<del>Pre-Assy., Reverse &amp; Operating Control</del>			<del>(G-29-Q &amp; G-55-S)</del>
7	79994	Pre-Assy., Reverse & Operating Control			(G-29-Q & G-55-T) (Group Dwg. 79995)
8	G-2372	Pre-Assy., Reverse & Operating Control			(G-29-Q & G-55-Y)
9	G-2880	Pre-Assy., Reverse & Operating Control			(G-29-Q & G-55-CC) (Assy. Dwg. G-2881)
10	G-2881	Pre-Assy., Reverse & Operating Control			(G-29-Q & G-55-EE)
11	G-4441	Assy. Comb. Reverse & Operating Control			(G-29-Q & 55 Exp.2)
12					
13					
14					
15					
16					
17					
18		For complete replacement of Air Motor type Rev. Mech.			G-29-Q, G-28-S, G-31-GG G-32-DDD or EEE, G-55-EE
19		with Ram Type use Pre-Assy. Group No. G-3016			
20					
21					
22					

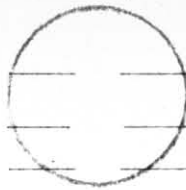
CI = Cast Iron                      CRS = Cold Rolled Steel  
 CS = Cast Steel                    CBr = Cast Brass  
 FS = Forged Steel                CBrz = Cast Bronze

FOR COMPLETE REPLACEMENT USE G-230-W5

Date Issued: 11-8-46

ASSEMBLY NO. G-30-KKK  
SHEET NO. 1

ENGINE MODEL G X  
2 CYL. \_\_\_\_\_  
3 CYL. \_\_\_\_\_  
4 CYL. \_\_\_\_\_  
5 CYL. \_\_\_\_\_  
6 CYL. \_\_\_\_\_  
8 CYL. \_\_\_\_\_



ASSY NAME: Governor  
Enterprise, (Rev.), Floating Bell  
Crank (One Piece), Eng.RPM 351 - 450  
with load limit: Gov.RPM 600 - 772.  
FIRST USED ON: \_\_\_\_\_

ASSY DWGS: G-2228

It.	Part No.	Part Name	Matl	Qty	Remarks
1					
2	G-2236	Pre-Assy., Governor		1	Consisting of:
3	6399-A	Housing, Governor	CI	1	Pre-Assy. 78726
4	106-2	Dowel		1	
5	79372-1	Cover, Gov.Hsg.	CI	1	
6	10640-89	Bushing	Brz	1	
7	79373-1	Yoke, Bell Crank	CI	1	
8		Capscrew		2	3/8-16 x 1
9		Lockwasher		2	3/8 Std.
10	79024-1	Gasket	Vel	1	1/32
11	79389-1	Dowel		1	
12		Capscrew		5	1/2-13 x 1
13		Screw, Flat Head		1	1/2-13 x 1
14	6440-A	Governor Drive Hub	CS	1	SAE 1030 NSS
15	10640-91	Bushing		1	Pre-Assy. 78671
16	B-3280	Ball Bearing		1	
** 17	B-3281	Ball Bearing		1	
18		Woodruff Key		1	1-1/4 x 1/4
19	6440-B	Washer	CRS	1	
20		Castle Nut		1	7/8-14
21		Cotter Pin		1	1/8 x 1-5/8
22					

CI = Cast Iron  
CS = Cast Steel  
FS = Forged Steel

CRS = Cold Rolled Steel  
CBr = Cast Brass  
CBrz = Cast Bronze

CONTINUED  
NEXT PAGE





Date Issued: 11-8-46

ASSEMBLY NO. G-30-KKK  
SHEET NO. 3

ENGINE MODEL G X

ASSY NAME: Governor

2 CYL. \_\_\_\_\_  
3 CYL. \_\_\_\_\_  
4 CYL. \_\_\_\_\_  
5 CYL. \_\_\_\_\_  
6 CYL. \_\_\_\_\_  
8 CYL. \_\_\_\_\_

FIRST USED ON: \_\_\_\_\_

ASSY DWGS: G-2228

It.	Part No.	Part Name	Matl	Qty	Remarks
1	75887	Roller	CRS	1	
2	113-4	Pin		2	
3		Washer		4	3/8 SAE
4		Cotter Pin		4	3/32 x 1
5		Taper Pin		2	#4 x 1-1/4
6	G-2196-1	Shaft, Governor Spring	CRS	1	
7		Nut, Hex, Jam		2	5/8-11
8	75885	Governor, Adj. Screw	CRS	1	
9	6434-D	Locknut, Sleeve	CRS	1	
10	75884	Pin, Floating Bell Crank		1	5/8 Drill Rod
11		Washer		2	5/8 SAE
12		Cotter Pin		2	1/8 x 1-1/4
13	75883	Pin, Bell Crank		1	1/2 Drill Rod
14		Washer		2	1/2 SAE
15		Cotter Pin		2	1/8 x 1-1/4
16	113-2	Pin, Fuel Control Yoke		1	
17		Washer		2	3/8 SAE
18		Cotter Pin		2	3/32 x 1
19	G-1005-1	Pin, Weight	CRS	2	X-1315
20	B-3862	Snap Ring		4	Truarc #62 External
21	6444-A	Locknut, Lowest Bearing	CRS	1	
22	6444-B	Lock Ring Brg. Locknut		1	Spring Steel

CI = Cast Iron  
CS = Cast Steel  
FS = Forged Steel

CRS = Cold Rolled Steel  
CBr = Cast Brass  
CBrz = Cast Bronze

CONTINUED  
NEXT PAGE

Date Issued: 11-8-46

ASSEMBLY NO. G-30-KKK  
SHEET NO. 4

ENGINE MODEL G X  
2 CYL.  
3 CYL.  
4 CYL.  
5 CYL.  
6 CYL.  
8 CYL.

ASSY NAME: Governor

FIRST USED ON:

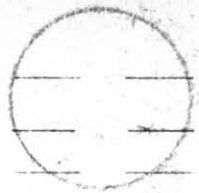
ASSY DWGS: G-2228

It.	Part No.	Part Name	Matl	Qty	Remarks
1	76532-5	Spring, Governor		1	
2	75879-1	Spring, Governor Idling		1	Steel Wire
3	6783-1	Retainer, Felt	CRS	1	
4	6783-2	Felt Bearing Seal	Felt	1	
5	6784	Spacer, Bearing	CRS	1	
6	6565-C	Pin	CRS	1	
7	45064-2	Fitting, Restricted Oil	Imp	1	Pre-Assy. NSS 79203
8	45064-3	Plug	Br	1	
9	75868-1	Yoke, Gov. Fuel Control	CBr	1	
10	<del>94357-1</del> <del>76347-2</del>	*Lever	CBr	1	
11		Capscrew		1	3/8-16 x 1-1/4
12					
13					
14	79025-1	Gasket to gear case	Vel	1	1/32
15		Capscrew		4	1/2-13 x 1-1/4
16					
17	**	FOR FIELD REPLACEMENT USE B-5910			
18		Instruct customer to remove Retainer 6783-1, Seal, Felt 6783-2, Spacer 6784-1 and insert			
19		new bearing with felt seal on top.			
20					
21					
22		*Use 76347-2 on "G" engs until exhausted			

CI = Cast Iron                      CRS = Cold Rolled Steel  
CS = Cast Steel                      CBr = Cast Brass  
FS = Forged Steel                      CBrz = Cast Bronze

Date Issued: 4-25-47. THESE PARTS ON G-252-J4 & K4 ASSEMBLY NO. G-31-GG  
SHEET NO. 1

ENGINE MODEL G  
 2 CYL. \_\_\_\_\_  
 3 CYL. \_\_\_\_\_  
 4 CYL. \_\_\_\_\_  
 5 CYL. \_\_\_\_\_  
 6 CYL. 1 \_\_\_\_\_  
 8 CYL. 1 \_\_\_\_\_



ASSY NAME: Governor Control R.H.  
 For Piston Type Rev. Mech. Ratchet  
 Type Handle With Lockout Screw

FIRST USED ON: 47006

ASSY DWGS: G-2532

It.	Part No.	Part Name	Matl	Qty	Remarks
1		For Complete Pre-Assy. number see last page			
2		Pre-Assy. Comb. Gov. & Fuel Control	RH ^	1	Consisting of:
3	91954-1	Rack	St	1	
4		Capscrew, Allen		2	1/4-20 x 1/2
5	94334-1	Handle	CBR	1	Chr. Plate & Polish
6	94335-1	Handlever R.H.	Pre-Assy. CBR	1	Chr. Plate & Polish
7	G-1918-1	Pin, Handle	94333 Assy. DWG. CRS	1	
8		Setscrew, Allen Cone Pt.	94333	1	1/4-20 x 3/8
9	94336-1	Spring		1	Spring Wire
10	94510-1	Screw, Locking		1	
11	G-2045-1	Spring, Handle		1	Spring Wire
12	G-1939-1	Segment, Lever	St	1	
13		Capscrew, Allen		3	3/8-16 x 3/4
14	G-1901-1	Lever, Gov. Control	CBR	1	Chr. Plate & Polish
15		Capscrew, Lever - Handlever		3	3/8-16 x 3/4 Allen
16		Setscrew, Allen Oval Pt.		2	3/8-16 x 1-1/2
17		Nut		2	3/8-16
18	79937-1	Link, Man. Gov. Control	CRS	1	
19		Yoke		2	3/8 SAE Clevis
20		Nut, Jam		2	3/8-24
21	113-1	Pin		2	
22		Cotter Pin		4	3/32 x 3/4

CI = Cast Iron                      CRS = Cold Rolled Steel  
 CS = Cast Steel                    CBR = Cast Brass  
 FS = Forged Steel                CBrz = Cast Bronze

CONTINUED  
 NEXT PAGE

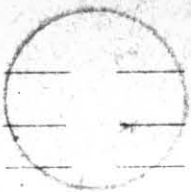
Date Issued: 4-25-47

ASSEMBLY NO. G-31-GG  
SHEET NO. 2

ENGINE MODEL G

ASSY NAME: Governor Control R.H.

2 CYL. \_\_\_\_\_  
3 CYL. \_\_\_\_\_  
4 CYL. \_\_\_\_\_  
5 CYL. \_\_\_\_\_  
6 CYL. 1 \_\_\_\_\_  
8 CYL. 1 \_\_\_\_\_



FIRST USED ON: 47006

ASSY DWGS: G-2532

It.	Part No.	Part Name	Matl	Qty	Remarks
1		Setscrew, Allen Oval Point		1	3/8-16 x 2
2	G-1926-1	Bracket, Fuel Shaft Brg.RH	CI	1	
3		Nut, Jam		1	3/8-16
4	79939-1	Guard, Chain	CI	1	
5		Capscrew, Flat Hd.		2	1/4-20 x 1-3/4
6					
7					
8	79933-1	Shim. Brkt.- Gear Case	St	3	} Use as required
9	79933-3	Shim, Brkt.- Gear Case	St	2	
10	79933-2	Shim, Brkt.- Gear Case	St	2	
11		Capscrew, Brkt.- Gear Case		3	3/8-16 x 3/4 Skt.Hd.
12					
13					
14					
15					
16		Use the following Pre-Assy. numbers when ordering assembled			
17		Parts. Check Engine specifications for right combination			
18		of assemblies.			
19	G-2534	Pre-Assy., Gov. & Fuel Control			G-31GG and G-32-DDD
20	G-2535	Pre-Assy., Gov. & Fuel Control			G-31-GG and G-32-BEE
21	G-3570	Pre-Assy., Gov. & Fuel Control			G-31-GG and G-32-VVV
22	G-3571	Pre-Assy., Gov. & Fuel Control			G-31GG and G-32-XXX

CI = Cast Iron                      CRS = Cold Rolled Steel  
CS = Cast Steel                    CBr = Cast Brass  
FS = Forged Steel                CBrz = Cast Bronze



REPLACES G-32-XXX

Date Issued: 5-24-46

THESE PARTS ON G-232-G4 & J4

ASSEMBLY NO. G-32-DDD

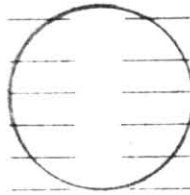
Retyped 6-8-53

SHEET NO. 1

ENGINE MODEL G

ASSY NAME: Fuel Control

- 2 CYL. \_\_\_\_\_
- 3 CYL. \_\_\_\_\_
- 4 CYL. \_\_\_\_\_
- 5 CYL. \_\_\_\_\_
- 6 CYL. 1 \_\_\_\_\_
- 8 CYL. \_\_\_\_\_



For Piston Type Rev. Mech. RH or LH  
Used with Ratchet Type Gov. Control

Ent. 6 Cyl.

FIRST USED ON: 46017-122

ASSY DWGS: G-2029

It.	Part No.	Part Name	Matl	Qty	Remarks
1					
2	79053-2	Shaft, Fuel Control		1	Ground Shafting
3					
4	G-1333-2	Bracket, Fuel Control Shaft	CBrz	6	
5		Set Collar		2	1" ID x 1-5/8 OD x 5/8 wide
6	78987	Lever, Fuel Pump	See Dwg.	6	
7	78963-1	Clamp, Fuel Pump Lever	See Dwg.	6	
8		Capscrew, Clamping		6	3/8-16 x 1-1/2
9	79051-1	Spring		6	Spring Wire
10	78986	Set Collar	See Dwg.	6	
11		Setscrew-Socket Hd., Cup Pt.		6	5/16 - 18 x 1/2
12	7736	Link Inj. Pump Lever	CRS	12	
13	111-1	Pin		12	
14		Cotter Pin		24	1/16 x 1/2
15	79948-1	Stop, Fuel Control Shaft	CBr	1	
16		Setscrew, Allen Cup Point		2	5/16-18 x 3/8
17		Capscrew, Adj.		1	3/8-16 x 1-1/4
18		Nut, Jam		1	3/8-16
19	G-1904-1	Bearing, Fuel Control Shaft	CBr	1	
20	G-1952-1	Lever, Fuel Control	CBr	1	L.H. Eng.
	G-1875-1	Lever, Fuel Control	CBr	1	R.H. Eng.
21	G-1880-1	Lever, Gov.-Fuel Control	CBr	1	
22		Setscrew, Allen Cup Pt.		1	3/8-16 x 3/8

CI = Cast Iron  
CS = Cast Steel  
FS = Forged Steel

CRS = Cold Rolled Steel  
CBr = Cast Brass  
CBrz = Cast Bronze

CONTINUED  
NEXT PAGE

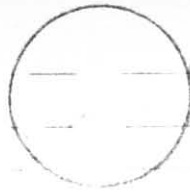
Date Issued: 5-24-46  
 Retyped 1-5-48

ASSEMBLY NO. G-32-DDD  
 SHEET NO. 2

ENGINE MODEL G

ASSY NAME: Fuel Control

2 CYL. \_\_\_\_\_  
 3 CYL. \_\_\_\_\_  
 4 CYL. \_\_\_\_\_  
 5 CYL. \_\_\_\_\_  
 6 CYL. 1 \_\_\_\_\_  
 8 CYL. \_\_\_\_\_



FIRST USED ON: 46017-122

ASSY DWGS: G-2029

It.	Part No.	Part Name	Matl	Qty	Remarks
1	76738-1	Link, Gov. Fuel Control	CRS	1	
2		Nut, Jam		1	3/8-16
3		Yoke		1	3/8 SAE
4		Nut, Jam		1	3/8-24
5	113-1	Pin, Lever	ST.	1	
6		Cotter Pin		2	3/32 x 3/4
7					
8	G-1932	Pre-Assy., Collapsible Rod		1	Use Assy. Dwg. G-1932 Consisting of:
9	G-1907-1	Barrel	St Tube	1	Pre-Assy. G-1921 Use Assy. Dwg. G-1921
10	G-1911-1	Plug	CRS	1	
11	G-1909-1	Rod	CRS	1	Pre-Assy G-1910 Use Assy. Dwg. G-1910
12		Nut, Jam		1	
13	G-1075-1	Spring		1	St. Sp. Wire
14	G-1908-1	Retainer	Br	2	
15	79742-1	Stop	CRS	1	
16	79743-1	Rod End		1	
17		Wire		1	1/16 x 11/16 lg.
18					
19	115-2	Pin, Collapsible Rod	St	1	
20		Cotter Pin		2	3/32 x 3/4
21	113-7	Pin, Collapsible Rod	St	1	
22		Cotter Pin		2	3/32 x 3/4

CI = Cast Iron  
 CS = Cast Steel  
 FS = Forged Steel

CRS = Cold Rolled Steel  
 CBr = Cast Brass  
 CBrz = Cast Bronze

CONTINUED  
 NEXT PAGE

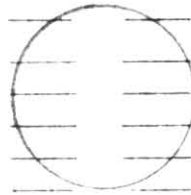
Date Issued: 5-24-46  
 Retyped 6-2-53

ASSEMBLY NO. G-32-DDD  
 SHEET NO. 3

ENGINE MODEL G

ASSY NAME: Fuel Control

2 CYL. \_\_\_\_\_  
 3 CYL. \_\_\_\_\_  
 4 CYL. \_\_\_\_\_  
 5 CYL. \_\_\_\_\_  
 6 CYL. 1 \_\_\_\_\_  
 8 CYL. \_\_\_\_\_



FIRST USED ON: 46017-122

ASSY DWGS: G-2029

It.	Part No.	Part Name	Matl	Qty	Remarks
1	G-1866-1	Lever, Collapsible Rod	CBr	1	
2		Setscrew, Allen Cup Point		1	3/8-16 x 3/8
3		Groov-Pin, Coupling		1	1/4 x 1-1/2 Style # 1
4	G-1265-1	Jaw, Coupling	CBr	1	
5	G-1927-1	Shaft, Collapsible Rod Lever	CRS	1	
6		Key, Woodruff		1	1/8 x 5/8
7	G-1855-1	Eccentric, Micro Switch	CRS	1	
8		Setscrew, Allen Cup Point		1	5/16-18 x 1/4
9	79942-1	Sprocket, Remote Control		1	SAE 1040 H.R.
10		Setscrew, Allen Cup Pt.		1	5/16-18 x 1/4
11					
12		Taper Pin, Fuel Shaft		3	# 4 x 1-3/4
13	301	Stud, Fuel Shaft Bkt.		12	
14		Lockwasher		12	3/8
15		Nut, Hex.		12	3/8-16
16		Capscrew Brg.-Bkt.		4	3/8-16 x 2-1/2
17	G-1899-1	Shim, Brg.-Bkt.	St.	3	Use as Required
18	G-1899-2	Shim, Brg.-Bkt.	St.	2	
19		Groove Pin, Collap. Rod Lever		1	1/4 x 1-3/4 Style 1
20					
21		See Assem. 31 for combination Assem. Number			
22					

CI = Cast Iron                      CRS = Cold Rolled Steel  
 CS = Cast Steel                    CBr = Cast Brass  
 FS = Forged Steel                  CBrz = Cast Bronze

Date Issued: 9-26-49

ASSEMBLY NO. G-34-JJ

SHEET NO. 1

ENGINE MODEL G

2 CYL. \_\_\_\_\_

3 CYL. \_\_\_\_\_

4 CYL. \_\_\_\_\_

5 CYL. \_\_\_\_\_

6 CYL. 1 \_\_\_\_\_

8 CYL. \_\_\_\_\_



ASSY NAME: Water Pump - R.H.

Reversible, R.H. Eng., 5/1 Speed Up  
300 to 400 RPM (w/o Outboard Brg.)  
Pressure Lubricated

FIRST USED ON: Modified Pumps

# G 5641 installed May 27/59

ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks
1					
2	G-3711	* Assy. Water Pump		1	Use Assy. Dwg. G-3700 Consisting of:
3	G-3696	Bracket	CI	1	Use Pattern G-4362 Assy. G-3699 ** Assy. Dwg. G-3696
4	10649-33	Bushing	Brz	1	
5	12503-10	Bushing	Brz	1	
6	G-3703	Elbow, 90° Volute Housing R.H.	CI	1	Imp. 69F 1/8P 1/4T
7	X-2888-1	Gasket		6	Detroit Gasket Mtl. 1/64 thick
8		Capscrew	St	8	3/8-16 x 1-1/8 long
9		Lockwasher	St	8	3/8 Std. Kantlink
10	B-5632	Oil Seal		1	National #50070-S
11	X-2889-1	Retainer - Seal	Brz	1	
12	B-3979	Seal, Water Pump Shaft		1	Schwitzer Cummins #115049
13	G-3702	Impeller	Brz	1	
14		Nut, Jam	Br	1	7/8-14 Finished Jam
15	180-21	Lock Plate	St	1	Stainless
16		Pipe Plug	Brz	2	1/4 Brass - Sq. Hd. Female
17	B-3189 G-3704	Pet Cock Gear, Water Pump Shaft	Br St	1 1	
18	G-3701	Shaft, Water Pump	St	1	Stainless Steel
19		Key, Woodruff #13	St	2	1 Dia x 3/16
20		Groov - Pin		1	1/4 x 2-7/8 Long
21					
22					

CI = Cast Iron  
CS = Cast Steel  
FS = Forged Steel

CRS = Cold Rolled Steel  
CBR = Cast Brass  
CBZ = Cast Bronze

CONTINUED  
NEXT PAGE



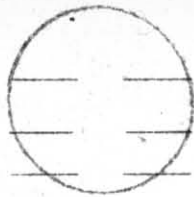
Date Issued: 9-26-49

ASSEMBLY NO. G-34-JJ  
SHEET NO. 2

ENGINE MODEL G

ASSY NAME: Water Pump

2 CYL. \_\_\_\_\_  
3 CYL. \_\_\_\_\_  
4 CYL. \_\_\_\_\_  
5 CYL. \_\_\_\_\_  
6 CYL. 1 \_\_\_\_\_  
8 CYL. \_\_\_\_\_



FIRST USED ON: \_\_\_\_\_

ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks
1	<del>79041-1</del> <del>78819-2</del>	Gasket - Brkt. to Gear Case	Vel	1	1/32
2		Capscrew - Pump to Gear Case		8	1/2-13 x 1-1/2
3	104-2	Dowel, Pump to Gear Case		2	
4					
5					
6					
7		* "Attach tag No. 12618 to each pump assembly going to service parts."			
8					
9		** To rework assem. G-3699 to include babbitt lined bushings and cartridge type water seal, see special machining drawing G-4761.			
10					
11		Parts required: G-4679 bushing			
12		G-4680 bushing			
13		12503-8 bushing			
14		B-5919 Water Seal			
15		B-5944 Oil Seal			
16					
17					
18					
19					
20					
21					
22					

CI = Cast Iron                      CRS = Cold Rolled Steel  
CS = Cast Steel                    CBr = Cast Brass  
FS = Forged Steel                  CBrz = Cast Bronze

Date Issued: 2-17-47  
Retyped: 6-1-53

THESE PARTS ON G-236-U

ASSEMBLY NO. G-36-U  
SHEET NO. 1ENGINE MODEL G2 CYL. \_\_\_\_\_  
3 CYL. \_\_\_\_\_  
4 CYL. \_\_\_\_\_  
5 CYL. \_\_\_\_\_  
6 CYL. \_\_\_\_\_  
8 CYL. \_\_\_\_\_ASSY NAME: Fuel Transfer Pump✓ Rev. Gear Type - Camshaft Driven ✓  
✓ R.H. Engine

FIRST USED ON: \_\_\_\_\_

ASSY DWGS: G-2418

It.	Part No.	Part Name	Matl	Qty	Remarks
1					
2	G-2423	Assem., Fuel Transfer Pump		1	Consisting of:
3	93745-1	Housing } Assem.	CI	1	Use Patt. 79083-1
4	32343	Shaft, Idler } 93746	St	1	
5	79092-1	Shaft, Drive } Assem.		1	
6		Key, Woodruff } 79558		1	#4-3/32 x 5/8
7	31408-1	Gear, Driver } NSS } Assem. 94459		1	
8	G-5377	Gear, Idler } NSS		1	
9	31376	Gland, Packing	BR	1	
10	31377	Gland, Screw	Br	1	
11		Packing	Gar	1	Gar. # 117 1/8 x 1/4
12	79084-1	Cover, Housing	CI	1	
13	79085-1	Gasket, Cover Housing	Paper	1	.002 - .003 thick
14	79085-2	Gasket, Cover Housing	Vel	1	.006 thick
15		Capscrew		8	5/16-18 x 3/4
16	104-4	Dowel		2	
17	75521-1	Valve	Br	4	
18	79086-1	Valve, Cage, Lower	CI	1	
19	79087-1	Gasket, V.C. to Housing		1	1/32 Vel.
20		Capscrew V.C. to Housing		4	5/16-18 x 3/4 Allen
21		Capscrew V.C. to Housing		2	5/16-18 x 1-3/4 Allen
22		Pipe Plug	Blk	2	1/2

CI = Cast Iron  
CS = Cast Steel  
FS = Forged SteelCRS = Cold Rolled Steel  
CBr = Cast Brass  
CBrz = Cast BronzeCONTINUED  
NEXT PAGE

Edition 3

Date Issued: 2-17-47  
Retyped: 10-19-49ASSEMBLY NO. G-36-U  
SHEET NO. 2ENGINE MODEL G  
2 CYL. \_\_\_\_\_  
3 CYL. \_\_\_\_\_  
4 CYL. \_\_\_\_\_  
5 CYL. \_\_\_\_\_  
6 CYL. \_\_\_\_\_  
8 CYL. \_\_\_\_\_

ASSY NAME: Fuel Transfer Pump

FIRST USED ON: \_\_\_\_\_

ASSY DWGS: G-2418

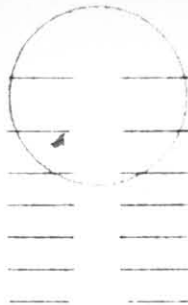
It.	Part No.	Part Name	Matl	Qty	Remarks
1	79088-2	Body, Relief Valve	Brz	1	
2	79078-1	Plunger, Relief Valve	CRS	1	
3	79282-1	Spring, Relief Valve	Sp.St	1	
4	79080-1	Screw, Adjusting Relief Valve	Br	1	Pre-Assy. 79103
5	79079-1	Locknut, Relief Valve	Br	1	Assy.Dwg. 79082
6	79076-1	Cap, Relief Valve	ST	1	Pre-Assy G-2385 Assy.Dwg. G-2385
7	79077-1	Gasket, Cap	Cop	1	Soft Annealed
8		Pipe Plug, Ctsk. Head		2	1/2 Blk
9	79089-1	Gasket, Valve to Housing		1	1/32 Vel
10		Capscrew, Valve to Housing		6	5/16-18x7/8
11	B-3728	Oil Seal - National		1	#50016 Nationalized Leather
12	79091-1	Coupling, Drive Shaft	CRS	1	
13		Setscrew		1	1/4 x 3/8 Cone Point
14		Key, Woodruff		1	#4-3/32 x 5/8
15	75510-1	Stub Shaft, Splined	CRS	1	
16		Capscrew, Pump Bracket		4	3/8-16 x 1-1/2
17	104-4	Dowel, Pump Bracket		2	
18	G-2419-1	Nut, Hex Bracket, Pump	CI	4	3/8-16
19	B-3736	Cap, Breather		1	
20	4833-1	Pipe		1	1-1/4 Blk
21					
22	75512	Capscrew, Stubshaft - Cam.		4	

CI = Cast Iron  
CS = Cast Steel  
FS = Forged SteelCRS = Cold Rolled Steel  
CBr = Cast Brass  
CBrz = Cast BronzeCONTINUED  
NEXT PAGE

Date Issued: 2-17-47  
 Retyped: 6-1-53

ASSEMBLY NO. G-36-U  
 SHEET NO. 3

ENGINE MODEL G  
 2 CYL. \_\_\_\_\_  
 3 CYL. \_\_\_\_\_  
 4 CYL. \_\_\_\_\_  
 5 CYL. \_\_\_\_\_  
 6 CYL. \_\_\_\_\_  
 8 CYL. \_\_\_\_\_



ASSY NAME: Fuel Transfer Pump  
 FIRST USED ON: G-2418  
 ASSY DWGS: \_\_\_\_\_

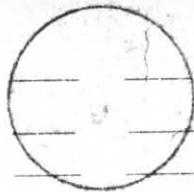
It.	Part No.	Part Name	Matl	Qty	Remarks
1		Wire, Capscrew		1	1/16 x 10 long
2	106-2	Dowel, Pump Bracket		2	
3		Capscrew, Bracket-Block		6	1/2-13 x 1-1/4
4	79063-1	Gasket, Bracket - Block		1	1/32 Vel.
5					
6					
7					
8					
9					
10					
11					
12					
13					
14					
15					
16					
17					
18					
19					
20					
21					
22					

CI = Cast Iron                      CRS = Cold Rolled Steel  
 CS = Cast Steel                    CBr = Cast Brass  
 FS = Forged Steel                CBrz = Cast Bronze



ENGINE MODEL G

- 2 CYL. \_\_\_\_\_
- 3 CYL. \_\_\_\_\_
- 4 CYL. \_\_\_\_\_
- 5 CYL. \_\_\_\_\_
- 6 CYL. 1 \_\_\_\_\_
- 8 CYL. 1 \_\_\_\_\_



ASSY NAME: Lube Oil Pump  
Large Scavenge Gears Double Rev.-R.H.  
Cone Point Check Valve for Oil Cooled  
Pistons  
FIRST USED ON: ✓

ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks
1					
2	G-2274	Pre-Assy. Double Rev. Lube Pump		1	Use Assy. Dwg. G-2274 Consisting of:
3	G-2052	Housing	Pre-Assy. CI	1	G-2053 Dwg. G-2052
4	10640-97 *	Bushing	Brz	2	
5	G-2050-1	Shaft, Idler	Brz	1	
6	G-2049-1	Gear, Idler, (Scav.)	CRS	1	NSS
7	G-2047-1	Shaft, Drive (Scavenge)	Pre-Assy. CRS	1	Pre-Assy. NSS G-2220
8	G-2048-1	Gear, Main	Assy. Dwg. CRS	1	
9		"Groov" Pin	G-2051 ST	1	1/2 x 2-5/8 Style 1
10	G-1174-1	Gear Idler, Pressure	CRS	1	Pre-Assy. NSS G-2209
11	G-2171-1	Gear, Main, (Pressure)	CRS	1	
12	G-2170-1	Key	ST	1	
13		Pipe Plug, Hex. Socket	ST	1	3/8
14	G-1166-1	Gear, Drive	CI	1	
15		Taper Pin	ST	1	#5 x 2 1/2
16		Cotter Pin	ST	1	1/8 x 2
17	<del>G-1178-1</del>	<del>Spring, Scavenge Relief</del>	<del>ST</del>	<del>1</del>	
18	G-1312-1	Spring Pressure Relief	ST	2	
19					
20	G-1288	Pre-Assy. Relief Valve & Rod		2	Use Dwg. G-1288 EACH Consisting of:
21	G-2032-1	Rod, Valve	CRS	1	
22	G-1171-1	Valve, Relief	CBr	1	

CI = Cast Iron      CRS = Cold Rolled Steel  
CS = Cast Steel      CBr = Cast Brass  
FS = Forged Steel      CBrz = Cast Bronze

\* FOR REPLACEMENT USE 97632 BUSHING

CONTINUED  
NEXT PAGE

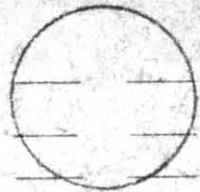
Edition 2  
 Date Issued: 12-6-46  
 Revised: 11-21-49

ASSEMBLY NO. G-37-CC  
 SHEET NO. 2

ENGINE MODEL G

ASSY NAME: Lube Oil Pump

2 CYL. \_\_\_\_\_  
 3 CYL. \_\_\_\_\_  
 4 CYL. \_\_\_\_\_  
 5 CYL. \_\_\_\_\_  
 6 CYL. 1 \_\_\_\_\_  
 8 CYL. 1 \_\_\_\_\_



FIRST USED ON: \_\_\_\_\_

ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks
1	G-1173-1	Retainer, Spring	CBr	2	
2	B-3919	Snap Ring	ST	2	Tru-Arc NAS-50-250
3	G-1167-1	Cover, Outside	CI	1	
4	G-1179-1	Gasket, Cover, Outside	Vel	1	
		Capscrew, Covers	ST	12	3/8 - 16 x 1
5		Capscrew, Inside Cover	St	1	3/8-16 x 2-1/4
	180-2	Locking Clip, Inside Cover	ST	7	
6	105-2	Dowel, Inside Cover	ST	2	
7	G-2166-1	Gasket, Inside Cover	Vel	1	
8		Pipe Plug, Housing	Blk	2	1/2" Male
9	G-1165-1	Cover, Inside	CI	1	} Pre-Assy. G-1181 Use Dwg. G-1165-1
10	10640-97 *	Bushing	Brz	2	
11	G-1163-1	Valve Cage, Upper	CI	1	
12		Pipe Plug		2	1/2 Male Blk
	G-1168-1	Gasket, Upper Cage to Hsg.	Vel	1	
13		Capscrew	ST	8	3/8 - 16 x 4
14		Capscrew		8	3/8 - 16 x 4 1/2
15		Capscrew	ST	2	3/8 - 16 x 4-3/4
16		Capscrew	ST	3	3/8 - 16 x 2 1/2
17		Capscrew	ST	3	3/8 - 16 x 3/4
18	G-1169-1	Gasket, Lower Cage to Hsg.	Vel	1	
19	G-2256-1	Cage, Lower Valve	CI	1	
	<del>G-2257-1</del>				
20	G-2257-1	Valve, Suction	See	4	
	<del>G-2256-1</del>		Dwg.	2	
21	104-3	Dowel		2	
	G-1245-1	Valve, Discharge	CBR	4	
22		Elbow	Imp	2	69F - 1/4T - 1/8PT
		Tubing	Cop	1	1/4 OD x 9" Long

CI = Cast Iron      CRS = Cold Rolled Steel  
 CS = Cast Steel    CBr = Cast Brass  
 FS = Forged Steel   CBrz = Cast Bronze

\* FOR REPLACEMENT USE 97632 BUSHING

CONTINUED  
 NEXT PAGE

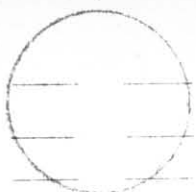
Date Issued: 12-6-46

ASSEMBLY NO. G-37-CC  
SHEET NO. 3

ENGINE MODEL G

ASSY NAME: Lube Oil Pump

2 CYL. \_\_\_\_\_  
3 CYL. \_\_\_\_\_  
4 CYL. \_\_\_\_\_  
5 CYL. \_\_\_\_\_  
6 CYL. 1 \_\_\_\_\_  
8 CYL. 1 \_\_\_\_\_



FIRST USED ON: \_\_\_\_\_

ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks
1					
2	G-1289-1	Gasket, Housing-Gear Case	Vel	1	
3		Capscrew, Hsg.-Gear Case		4	5/8 - 11 x 1 1/2
4	78458-1	Dowel	CRS	2	
5		Nut, Hex		2	3/8 - 16
6					
7					
8					
9					
10					
11					
12					
13					
14					
15					
16					
17					
18					
19					
20					
21					
22					

CI = Cast Iron                      CRS = Cold Rolled Steel  
CS = Cast Steel                    CBr = Cast Brass  
FS = Forged Steel                CBrz = Cast Bronze



Date Issued: 1-8-44 THESE PARTS ON G-239-H  
 Retyped: 10-19-49

ASSEMBLY NO. G-39-H  
 SHEET NO. 1

ENGINE MODEL G

2 CYL. \_\_\_\_\_  
 3 CYL. \_\_\_\_\_  
 4 CYL. \_\_\_\_\_  
 5 CYL. \_\_\_\_\_  
 6 CYL. 1 \_\_\_\_\_  
 8 CYL. \_\_\_\_\_



ASSY NAME: Lube Oil Fittings  
 G-6 Cyl. Rev. & Non Rev. Engine 2"  
 Suction Header

FIRST USED ON: 44001-44100

ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks
1		Header Assembly		1	Consisting of:
2	75455-1 7824-1	Header, Main Oil	St	1	Marine Engine Stationary Engine
3	78396-1	Flange, Header	St	2	
4	78580-1	Gasket, Flange		2	1/16 Gar. 660
5	B-3806	Seal		2	National #50095
6		Capscrew		4	1/2-13 x 1-3/8
7		Setscrew, Base-Head		4	Unbrako knurled on point 1/2-13 x 2
8		Pipe Plug		1	1-1/4 Blk
9					
10	78241	Pre-Assy., and Assy. Dwg. Line to Main Bearing		6	Each Consisting of:
11		Elbow, 90°		1	5/8T Hays 9060 1/2 Cop x 3/8 IP
12	76792	Tube		1	SAE 75, Lt. Annealed Cop 5/8 x 45
13		Adapter		1	5/8T Hays 9000 1/2 Cop x 1/2 IP
14					
15	78240	Pre-Assy. Line to Auxiliary Header		2	Each Consisting of:
16		Elbow, 90°	Imp	1	49F 1/2T 3/8P
17		Half Union Nut	Imp	2	48F 1/2T 3/8P 41F 1/2T
18	76791	Tube		1	SAE 75, Lt. Annealed Cop 1/2 x 58
19					
20	77068 77066	Pre-Assy. Lube Oil Header Pre-Assy. Lube Oil Header	LH RH		Consisting of:
21	76982-1 75434	Header, Auxiliary	St	1	LH RH
22		Plug		1	3/8 Blk

CI = Cast Iron  
 CS = Cast Steel  
 FS = Forged Steel

CRS = Cold Rolled Steel  
 CBr = Cast Brass  
 CBrz = Cast Bronze

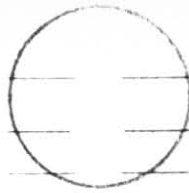
CONTINUED  
 NEXT PAGE



Date Issued: 1-6-44  
 Retyped 7-16-53

ASSEMBLY NO. G-39-H  
 SHEET NO. 2

ENGINE MODEL G  
 2 CYL. \_\_\_\_\_  
 3 CYL. \_\_\_\_\_  
 4 CYL. \_\_\_\_\_  
 5 CYL. \_\_\_\_\_  
 6 CYL. 1 \_\_\_\_\_  
 8 CYL. \_\_\_\_\_



ASSY NAME: Lube Oil Fittings

FIRST USED ON: 44001-44100

ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks
1		Bushing	Blk	1	3/8 x 1/4
2		ELL	Imp	6	68F 1/4P 1/4T
3		Connectors	Imp	7	68F 1/4P 1/4T
4		ELL	Imp	2	49F 3/8P 1/2T
5		Union Nut	Imp	2	41F 1/2 Tube
6		Nipple	Blk	2	3/8 x 2-1/2
7		Sleeve	Blk	2	3/8
8					
9		Line to Rear Cam Bearing		1	Consisting of:
10		Tube		1	Annealed Cop 1/4 x 12 SAE 75 Lt. ^
11		Tee	Imp	1	72-F 1/4T 1/4P
12					
13		Line to Intermediate Cam Bearing		5	EACH Consisting of:
14		Tube		1	Annealed Cop 1/4 x 12 SAE 75 Lt. ^
15		Tee	Imp	1	72-F 1/8P 1/4T 1/4T
16					
17		Fuel Pump Base Line, Cam Brg.-Tappet Cluster &		6	EACH Consisting of:
18		Tube		2	Annealed Cop 1/4 x 12 SAE 75 Lt. ^
19		Connector	Imp	1	68F 1/4T 1/8P
20					
21					
22					

CI = Cast Iron  
 CS = Cast Steel  
 FS = Forged Steel

CRS = Cold Rolled Steel  
 CBr = Cast Brass  
 CBrz = Cast Bronze

CONTINUED  
 NEXT PAGE

Date Issued: 1-6-44  
 Retyped: 10-8-46

ASSEMBLY NO. G-39-H  
 SHEET NO. 3

ENGINE MODEL G

ASSY NAME: Lube Oil Fittings

2 CYL. \_\_\_\_\_  
 3 CYL. \_\_\_\_\_  
 4 CYL. \_\_\_\_\_  
 5 CYL. \_\_\_\_\_  
 6 CYL. 1 \_\_\_\_\_  
 8 CYL. \_\_\_\_\_

FIRST USED ON: 44001-44100

ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks
1					
2		Line to front cam bearing			
3		Elbow, 90°	Imp	1	69-F 1/8P 1/4T
4		Tube	Cop	1	1/4 x 12
5		Elbow, 90°	Imp	1	69-F 1/8P 1/4T
6					
7					
8		Line to Rocker Arm		6	EACH Consisting of:
9		Tube	Cop	1	1/4 x 65
10		Union Nut	Imp	1	41-F 1/4T
11					
12		Line to Gear Case			
13		Half Union	Imp	1	48-F 3/8T 1/4P
14		Union Nut	Imp	1	41-F 3/8T
15		Tube	Cop	1	3/8 x 18
16		Union Nut	Imp	1	41-F 3/8T
17		Elbow, 90°	Imp	1	49-F 3/8T 1/4P
18		Nipple	Blk	1	1/4 x 1 1/2
19		Tee, Female	Blk	1	1/2P
20					
21					
22					

CI = Cast Iron  
 CS = Cast Steel  
 FS = Forged Steel

CRS = Cold Rolled Steel  
 CBr = Cast Brass  
 CBrz = Cast Bronze

CONTINUED  
 NEXT PAGE

Date Issued: 1-6-44  
 Retyped: 11-19-48

ASSEMBLY NO. G-39-H  
 SHEET NO. 4

ENGINE MODEL G

ASSY NAME: Lube Oil Fittings

2 CYL. \_\_\_\_\_  
 3 CYL. \_\_\_\_\_  
 4 CYL. \_\_\_\_\_  
 5 CYL. \_\_\_\_\_  
 6 CYL. 1 \_\_\_\_\_  
 8 CYL. \_\_\_\_\_

FIRST USED ON: 44001-44100

ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks
1					
2		Line to Idler Gear Stub			
3		Connector	Imp	1	68-F 1/4 T
4		Tube	Cop	1	1/4 x 36
5					
6					
7		Line to Cross			
8		Connector	Imp	1	68-F 1/4 T 1/4 P
9		Tube	Cop	1	1/4 x 12
10		Connector	Imp	1	68-F 1/4 T 1/4 P
11		Cross	Blk	1	1/4 P
12		Nipple	Blk	1	1/4 x 2
13		Elbow, 90°	Blk	1	1/4 P
14	10272	Plug, Drilled	St	1	1/4 P
15					
16					
17		Line, Cross-Main Header			
18		Nipple	Blk	1	1/4 x 2
19		Elbow, 90°	Blk	1	1/4 P
20		Half Union	Imp	1	48-F 3/8 T 1/4 P
21		Union Nut	Imp	1	41-F 3/8 T
22		Tube	Cop	1	3/8 x 40

CI = Cast Iron  
 CS = Cast Steel  
 FS = Forged Steel

CRS = Cold Rolled Steel  
 CBr = Cast Brass  
 CBrz = Cast Bronze

CONTINUED  
 NEXT PAGE

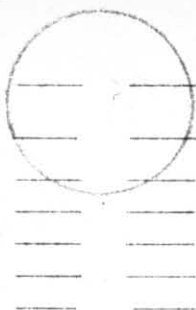
Date Issued: 1-6-44  
 Retyped: 11-19-48

ASSEMBLY NO. G-39-H  
 SHEET NO. 5

ENGINE MODEL G

ASSY NAME: Lube Oil Fittings

2 CYL. \_\_\_\_\_  
 3 CYL. \_\_\_\_\_  
 4 CYL. \_\_\_\_\_  
 5 CYL. \_\_\_\_\_  
 6 CYL. 1 \_\_\_\_\_  
 8 CYL. \_\_\_\_\_



FIRST USED ON: 44001-44100

ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks
1		Union Nut	Imp	1	41-F 3/8T
2		Elbow, 90°	Blk	1	1/2 P
3					
4					
5		Line, Cross-Governor Gear			
6		Connector	Imp	1	68-F 1/4 T 1/4 P
7		Tube	Cop	1	1/4 x 18
8					
9					
10		Line, Header-Governor			
11		Elbow, 90°	Imp	1	69-F 1/4 T 1/4 P
12		Tube	Cop	1	1/4 x 72
13		Elbow, 90°	Imp	1	69-F 1/4 T 1/4 P
14					
15					
16	79907	Pre-Assy. & Assy. Dwg. Line to Rear Main Bearing		1	Consisting of:
17		Elbow, 90° Tube Adapter		1	Hays 9060 1/2 Cop. x 3/8 IP
18	79874		Cop	1	5/8 x 45
19				1	Hays 9000 1/2 Cop. x 1/2 IP
20					
21					
22					

CI = Cast Iron                      CRS = Cold Rolled Steel  
 CS = Cast Steel                    CBr = Cast Brass  
 FS = Forged Steel                  CBrz = Cast Bronze



Date Issued: 12-2-40  
Retyped: 5-19-53

THESE PARTS ON G-240-K

ASSEMBLY NO. G-40-K  
SHEET NO. 1ENGINE MODEL G  
2 CYL. \_\_\_\_\_  
3 CYL. \_\_\_\_\_  
4 CYL. \_\_\_\_\_  
5 CYL. \_\_\_\_\_  
6 CYL. 6  
8 CYL. 8ASSY NAME: Fuel Injection  
Bendix Std. (1/8 ID Line)  
Non-supchd., 450 RPM & Below

FIRST USED ON: \_\_\_\_\_

ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks
1	B-3025	Pump, Bendix FC-15 #10-16405-4		1	Bendix
2		3/8 OD Injection Line, Steel Inlet Fitting			
3		10-23222 for 9/16 supply line, time for port closing			
4					
5		Connector, Return		1	Imperial 48F 1/8T 1/4T
6	B-3030	Dwg. #10-18630-5 Holder, Bendix HCV	Assem. G-2525	1	Bendix NSS
7		Nut, Return		1	Imperial 41F 1/4T
8	B-3032	Nozzle, Bendix 10-16714		1	Bendix
9	B-3036	Tip, Bendix 10-16730-20, 8 Hole .012" 130°		1	Bendix
10	G-4259	Clamp, Fuel Lines	CI	1	
11	79099-1	Gasket, Fuel Line Clamp		1	3/32 Garlock #660
12		Capscrew		5	5/16-18 x 3/4 Allen
13	1143	Gasket, Nozzle Holder	Cop	1	
14	75466	Washer, Tubing	St	2	(With Pump) NSS
15	75477	Nut, Tubing	Assem. 77836	2	(With Pump) NSS
16	G-5674	Tubing, Injection	St	1	Seq Spec. Dwg 266 Summerill 3/8 x 1/8 NSS
17					
18	77844-1	Retainer, Nozzle Holder	CS	1	
19	148	Nut, Nozzle Holder		2	Hymo CD
20	G-2461-1	Screw, Fuel Injection		1	See Dwg.
21					
22		(FOR LEFT HAND ENGINE use the following instead of Assembly 77836)			

CI = Cast Iron  
CS = Cast Steel  
FS = Forged SteelCRS = Cold Rolled Steel  
CBr = Cast Brass  
CBrz = Cast BronzeCONTINUED  
NEXT PAGE

Edition 3

Date Issued: 6-19-46

Retyped: 8-25-49

ASSEMBLY NO. G-40-K

SHEET NO. 2

ENGINE MODEL G

ASSY NAME: Fuel Injection

2 CYL. \_\_\_\_\_  
3 CYL. \_\_\_\_\_  
4 CYL. \_\_\_\_\_  
5 CYL. \_\_\_\_\_  
6 CYL. 6 \_\_\_\_\_  
8 CYL. 8 \_\_\_\_\_



FIRST USED ON: \_\_\_\_\_

ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks
1					
2	G-2000	Pre-Assy. LH Injection Line		1	Consisting of:
3	75466	Washer, Tubing	St	2	(With Pump) NSS
4	75477	Nut, Tubing	St	2	(With Pump) NSS
5	G-5672 <del>75895-3</del>	Tubing, Injection	St	1	See Spec. Dwg. 266 NSS
6					
7					
8					
9					
10					
11					
12					
13					
14					
15					
16					
17					
18					
19					
20					
21					
22					

CI = Cast Iron  
CS = Cast Steel  
FS = Forged Steel

CRS = Cold Rolled Steel  
CBr = Cast Brass  
CBrz = Cast Bronze

Date Issued: 4-8-43  
 Retyped: 1-25-54

ASSEMBLY NO. G-41-E  
 SHEET NO. 2

ENGINE MODEL   G    
 2 CYL. \_\_\_\_\_  
 3 CYL. \_\_\_\_\_  
 4 CYL. \_\_\_\_\_  
 5 CYL. \_\_\_\_\_  
 6 CYL.   1   \_\_\_\_\_  
 8 CYL. \_\_\_\_\_



ASSY NAME: Thrust Bearing

FIRST USED ON: 41049-58, 62

Group  
 ASSY DWGS: 79002

It.	Part No.	Part Name	Matl	Qty	Remarks
1	76195-1	Shims .003 thick		12	
2	76195-2	Shims .010 thick		12	
3	76179-1	Cover, Side		2	
4	79105-1	Gasket		2	
5		Plug, Pipe		2	1/2"
6		Capscrew		8	1/2-13 x 1-1/4
7	6845	Breather		1	
8		Bushing -	Blk	1	1 x 1/4
9		Nipple	Blk	1	1/4 x short
10		Plug, Pipe	Blk	1	1" Flush
11	B-4057	Eye Bolt		1	
12	B-3922	Oil Gage		1	
13		Plug, Pipe		1	3/8
14					
15					
16	78455	Bolt, Housing to Base		4	
17		Nut, Slotted		4	1-1/4 -7
18	75999	Washer		8	
19	60235-1	Dowel		2	
20		Nut		2	1"-14
21		Cotter Pin		4	3/16 x 2-1/2
22	76187	Shims, Housing to Base		2	Sets

Assem.  
 G-3668  
 (Contd)

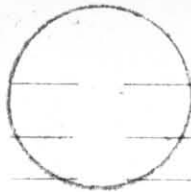
CI = Cast Iron                      CRS = Cold Rolled Steel  
 CS = Cast Steel                    CBr = Cast Brass  
 FS = Forged Steel                  CBrz = Cast Bronze

Date Issued: 4-8-43  
 Retyped: 9-3-46

ASSEMBLY NO. G-41-E  
 SHEET NO. 3

ENGINE MODEL G

2 CYL. \_\_\_\_\_  
 3 CYL. \_\_\_\_\_  
 4 CYL. \_\_\_\_\_  
 5 CYL. \_\_\_\_\_  
 6 CYL. 1 \_\_\_\_\_  
 8 CYL. \_\_\_\_\_



ASSY NAME: Thrust Bearing

FIRST USED ON: 41049-58, 62

Group  
 ASSY DWGS: 79002

It.	Part No.	Part Name	Matl	Qty	Remarks
1		USE FOLLOWING PRE-ASSEMBLY NUMBERS WHEN ORDERING			
2		ASSEMBLED PARTS; CHECKING YOUR ENGINE SPECIFICATIONS FOR			
		THE RIGHT COMBINATION OF ASSEMBLIES			
3	78060	Pre-Assy. Thrust Bearing			Use Assy. Dwg. 77567-X-2580 G-41-E, G-47-L, (G-44-D or X-44-F)
4		Shaft & Sailing Clutch (Twin Disc) with Compressor			
5					
6	78060	Pre-Assy. Thrust Bearing,			Use Assy. Dwg. 77567 G-41-E, G-47-L, G-44-C
7		Shaft & Sailing Clutch (Twin Disc) w/o Compressor			
8					
9	77550	Shaft Pre-Assy. Thrust Bearing & A			Use Assy. Dwg. 76176 G-41-E & G-47-H
10					
11	X-2339	Pre-Assy., Thrust Bearing &			Use Assy. Dwg. X-2328 G-41-E, X-47-B, X-44-B
12		Shaft & Sailing Clutch (Twin Disc E221)			
13					
14	X-2345	Pre-Assy., Comp. Drive & Brkt.			G-41-E, X-47-A, X-44-A
15		& Sailing Clutch Shifter Parts (Twin Disc CR221)			
16					
17	78737	Pre-Assy. Thrust Bearing,			Use Assy. Dwg. 78711 G-41-E, G-44-F, G-47-N
18		Shaft & Sailing Clutch (Dodge) w/o Compressor			
19					
20	78737	Pre-Assy. Thrust Bearing,			Use Assy. Dwg. 78711 G-41-E, G-44-G, G-47-N
21		Shaft & Sailing Clutch (Dodge) with Compressor			
22					

CI = Cast Iron      CRS = Cold Rolled Steel  
 CS = Cast Steel      CBr = Cast Brass  
 FS = Forged Steel    CBrz = Cast Bronze

**CONTINUED  
 NEXT PAGE**



MISCELLANEOUS TROUBLES - Continued

<u>Probable Cause</u>	<u>Suggested Remedy</u>
3. Excessive smoke from crankcase breathers due to -	
a. Stuck piston rings.	a. Clean rings, ring grooves and oil drains.
b. Rings or cylinder liners worn.	b. Replace rings. Use oversize rings if necessary. If liners are worn more than .040", replace liners.
c. Cracked piston.	c. Replace piston.

## ENGINE SPECIFICATIONS, SHEET 2

CUSTOMER Western Boatbuilding Co.

ENGINE DMG-6

50018

No.	Parts List Name	Qty.	Remarks
G 25 W	Gear Case	1	
G 26 G	Gear Set	1	Assy.Dwg.G-1113
G 27 P	Governor and Tachometer Drive	1	
G 28 S	Air Starter Linkage	1	
G 29 Q	Reversing Mechanism	1	
G 30 KKK 30 30	Governor, Normal Overspeed Governor or Trip Governor Opening Cover	1	
G 31 GG	Governor Control	1	
G 32 DDD	Fuel Pump Control	1	
<del>33</del>	<del>Main Air Compressor</del>		
G 34 JJ 34	Water Pump Water Pump	2	
<del>35</del>	<del>Water Pump Valve</del>		
G 36 U	Fuel Transfer Pump	1	
G 37 CC	Lube Oil Pump	1	
<del>38</del>	<del>Force Feed Oiler</del>		
G 39 H	Lubrication Fittings	1	
G 40 K	Fuel Injection	6	
G 41 E	Thrust Bearing	1	
<del>43</del>	<del>Reverse Gear</del>		
<del>44</del>	<del>Sailing Clutch</del>		
<del>45</del>	<del>Winch Clutch</del>		
G 47 H	Thrust Shaft	1	
<del>48</del>	<del>Reverse Gear Control</del>		
<del>49</del>	<del>Oiler Lines and Fittings</del>		
G 50 BBB	Fuel Oil Header and Fittings	1	
G 51 F	Strainer and Fittings	1	
G 52 GGG	External Lube Lines	1	

(Also Used on X Supercharged Eng.)

Date Issued: 2-7-46

Retyped: 9-3-46

ASSEMBLY NO. G-41-E

SHEET NO. 4

ENGINE MODEL G

ASSY NAME: Thrust Bearing

2 CYL.

3 CYL.

4 CYL.

5 CYL.

6 CYL. 1

8 CYL.

FIRST USED ON: 41049-58, 62

See Remarks Column  
opposite Pre-Assy's.

Group

ASSY DWGS: 79002

It.	Part No.	Part Name	Matl	Qty	Remarks
1	X-2412	Shaft Pre-Assy., Thrust Bearing & and Sailing Clutch (Dodge 50 B 140 x H)			Use Assy. Dwg. X-2408 G-41-E, X-47-E, (X-44-C or X-44-E)
2					
3					
4	79626	Pre-Assy., Thrust Bearing & Shaft and Sailing Clutch (Twin Disc E-2-24)			G-41-E, X-44-F, X-47-G
5					
6					
7	X-2792	Pre-Assy., Thrust Bearing & Shaft and Sailing Clutch EH-224			G-41-E, X-44-H, X-47-G
8					
9					
10	G-1324	Pre-Assy., Thrust Bearing & Shaft and Sailing Clutch (Twin Disc EH224)			G-41-E, X-44-K, X-47-G
11					
12					
13	G-1326	Pre-Assy., Thrust Bearing & Shaft & Sailing Clutch (Twin Disc E-224)			G-41-E, X-44-L, X-47-G
14					
15					
16	G-1445	Pre-Assy., Thrust Bearing, Shaft & Sailing Clutch			G-41-E, G-44-H, G-47-L or G-44-M
17					
18	G-3669	Assy. Combination, Thrust Bearing & Shaft			G-41-E & G-47-V
19					
20	G-3670	Assy. Combination, Thrust Bearing & Shaft & Sailing Clutch (Dodge 100B 140H)			G-41-E, G-44-F, G-47-X
21					
22					

CI = Cast Iron

CS = Cast Steel

FS = Forged Steel

CRS = Cold Rolled Steel

CBR = Cast Brass

CBRz = Cast Bronze

CONTINUED  
NEXT PAGE



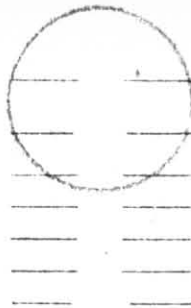
Date Issued: 8-15-49

ASSEMBLY NO. G-41-E  
SHEET NO. 5

ENGINE MODEL G

ASSY NAME: Thrust Bearing

2 CYL. \_\_\_\_\_  
3 CYL. \_\_\_\_\_  
4 CYL. \_\_\_\_\_  
5 CYL. \_\_\_\_\_  
6 CYL. 1 \_\_\_\_\_  
8 CYL. \_\_\_\_\_



FIRST USED ON: 41049-58, 62

Group  
ASSY DWGS: 79002

It.	Part No.	Part Name	Matl	Qty	Remarks
1	G-3671	Assy. Combination, Thrust Bearing & Shaft & Sailing Clutch (Twin Disc EH-224) w/o Compressor			G-41-E, G-44-M, G-47-W
2					
3					
4					
5	G-4094	Assy. Combination Thrust Bearing & Shaft - w/o Clutch & w/Compressor Drive Sheave on Thrust Shaft			G-41-E & G-47-AA
6					
7					
8					
9					
10					
11					
12					
13					
14					
15					
16					
17					
18					
19					
20					
21					
22					

CI = Cast Iron                      CRS = Cold Rolled Steel  
 CS = Cast Steel                    CBr = Cast Brass  
 FS = Forged Steel                CBrz = Cast Bronze



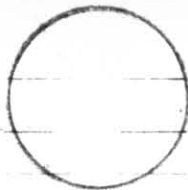
Items 1 to 8 part of pre-assembly 77550

Date Issued: 4-8-43  
Retyped: 12-17-48

ASSEMBLY NO. G-47-H  
SHEET NO.

ENGINE MODEL G

- 2 CYL. \_\_\_\_\_
- 3 CYL. \_\_\_\_\_
- 4 CYL. \_\_\_\_\_
- 5 CYL. \_\_\_\_\_
- 6 CYL. 1 \_\_\_\_\_
- 8 CYL. \_\_\_\_\_



ASSY NAME: Thrust Shaft  
For Timken Thrust Brg. 400 @ 400  
on engine

FIRST USED ON: 41048-58, 62

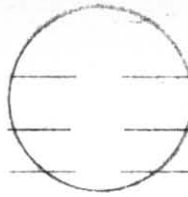
ASSY DWGS: 76178

It.	Part No.	Part Name	Matl	Qty	Remarks
1	76180- <del>2</del>	Thrust Shaft } Assy.	FS	1	
2	B-3920	Locknut } G-4132		1	N-36
	G-1829-1	Key, coupling	St	1	
3	76186	Coupling	CS	1	
4	76184-1	Washer, thrust shaft end	St	1	
5		Capscrew		3	1-14 x 2 1/2
6	76185	Lock Plate	St	1	
7					
8					
9					
10					
11					
12					
13					
14					
15					
16					
17					
18					
19					
20		SEE ASSEMBLY 41 FOR PRE*ASSEMBLY GROUP LIST			
21					
22					

CI = Cast Iron                      CRS = Cold Rolled Steel  
CS = Cast Steel                    CBr = Cast Brass  
FS = Forged Steel                  CBrz = Cast Bronze

ENGINE MODEL G

- 2 CYL. \_\_\_\_\_
- 3 CYL. \_\_\_\_\_
- 4 CYL. \_\_\_\_\_
- 5 CYL. \_\_\_\_\_
- 6 CYL. 1
- 8 CYL. 1



ASSY NAME: Fuel Headers  
Gear Fuel Pump, G-6-Stationary or Marine, Low Fuel Header & Return Line Connection  
FIRST USED ON: 49037-38

ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks
1					
2	76746	Pre-Assy., Fuel Header		1	<del>Assy. Dwg. 75948</del> Consisting of:
3	7746-2	Header, Fuel <del>Pre-Assy.</del> <sup>76746</sup>	St	1	} Welded on Engine See Assy. Dwg. 75948 NSS
4	76966	Fitting, Fuel Header	CRS	6	
5		Elbow, 90°	St	1	
6					
7	78699-	Adapter, Fuel Header	CRS	2	
8		Washer	Cop	2	15/16 x 3/4 x 1/16
9		Tee		1	1/2 PT
10		Bushing		1	1/2 x 1/8 PT
11	B-5479	Valve, Relief		1	1/2" Set at 15 PSI
12					
13	76747	Pre-Assy., Inlet Tube	NSS	<span style="border: 1px solid black; padding: 2px;">6</span>	EACH Consisting of:
14	7740-2	Tube, Fuel Connection	St	1	Welded
15	B-3025-15	Connector, Fuel Pump		1	Furnished with Pump Bosch NRV 22/3X or Bendix 10-23222
16					
17	7776	Screw, Fuel Line	CRS	6	Cadmium Plate
18	75454	Gasket	Cop	12	
19	B-3198	Valve, Relief		1	1/2" Set at 20 PSI For Stationary Eng. Only
20					
21	78352	Pre-Assy. Fuel Oil Drain Header		1	Consisting of:
22	78247	Header, Tappet Drain		1	3/8 Std. Pipe Blk

CI = Cast Iron                      CRS = Cold Rolled Steel  
CS = Cast Steel                    CBr = Cast Brass  
FS = Forged Steel                CBrz = Cast Bronze

CONTINUED  
NEXT PAGE

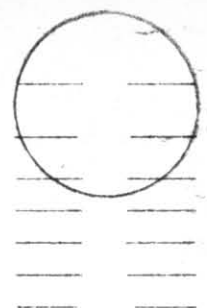
Date Issued: 6-1-49

ASSEMBLY NO. G-50-BBB  
SHEET NO. 2

ENGINE MODEL G

ASSY NAME: Fuel Headers

2 CYL. \_\_\_\_\_  
3 CYL. \_\_\_\_\_  
4 CYL. \_\_\_\_\_  
5 CYL. \_\_\_\_\_  
6 CYL. 1 \_\_\_\_\_  
8 CYL. \_\_\_\_\_



FIRST USED ON: 49037-38

ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks
1		Connection	Imp	12	1/4T 1/8P 68F
2		Coupling		1	3/8" Blk
3		Elbow	Imp	1	1/2 Tube 3/8 IPT 49F
4		Nut	Imp	1	1/2T 41F
5		Cap		1	3/8 Blk
6					
7					
8	78848-2	Tube, Drain Header - Head	Cop	6	
9		Ell, 90°, into Head	Imp	6	1/4T 1/8P 69F
10		Connection, from Head	Imp	6	1/4T 1/8P 68F
11	78848	Tube, Head - Nozzle	Cop	6	
12	76867	Bracket, Tappet Drain Header	CBrz	3	
13		Capscrew		3	3/8-16 x 1-3/4 Allen
14		Capscrew, Clamping		3	1/4-20 x 3/4
15		Lockwasher		3	1/4 Light
16		Setscrew, Allen		3	1/2-13 x 5/8
17	77891	Tubing	Cop	6	1/4 x 7 Lg. Approx.
18		Tubing, to Drain	Cop	1	1/2 x 15 Lg. Approx.
19					
20					
21					
22					

CI = Cast Iron                      CRS = Cold Rolled Steel  
CS = Cast Steel                    CBr = Cast Brass  
FS = Forged Steel                CBrz = Cast Bronze

Date Issued: 3-16-44

SEE G-201

ASSEMBLY NO. G-51-F  
SHEET NO. 1 of 1

ENGINE MODEL G

2 CYL. \_\_\_\_\_

3 CYL. \_\_\_\_\_

4 CYL. \_\_\_\_\_

5 CYL. \_\_\_\_\_

6 CYL. 1

8 CYL. 1

ASSY NAME: LUBE STRAINER

Left Hand and Right Hand, Marine, 2"  
Suction Pipe

FIRST USED ON: \_\_\_\_\_

ASSY DWGS: 78575 RH, 79917 LH

It.	Part No.	Part Name	Matl	Qty	Remarks
1	G-6283 78579	Assem., Lube Oil Suction, LH Assem., Lube Oil Suction, RH		<input type="checkbox"/> 1	Consisting of:
2	78553	Suction Head		1	
3	78704	Screen		1	
4	78833	Pipe		1	
5	78559	Flange		1	
6					
7					
8		Capscrew		2	1/2"-13 x 1-1/4
9		Capscrew		2	1/2"-13 x 1-1/2
10		Lockwasher		4	1/2" Reg.
11	78581-1	Gasket		1	
12	78557	Elbow		1	
13	78583-2 78583-1	Pipe, Header Pipe, Header		1	8 Cyl. Engine 6 Cyl Engine
14		Setscrew, Pt, Knurled		2	1/2"-13 x 2 Unbrako
15	78396	Flange, Header		1	
16	B-3936	Oil Seal		1	
17	78580-1	Gasket		1	
18		Capscrew		2	1/2"-13 x 1-1/2
19					
20					
21					
22					

CI = Cast Iron  
CS = Cast Steel  
FS = Forged Steel

CRS = Cold Rolled Steel  
CBr = Cast Brass  
CBrz = Cast Bronze



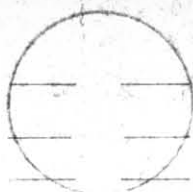
Date Issued: 5-13-46

THESE PARTS ON G-252-GGG

ASSEMBLY NO. G-52-GGG  
SHEET NO.

ENGINE MODEL G

2 CYL. \_\_\_\_\_  
3 CYL. \_\_\_\_\_  
4 CYL. \_\_\_\_\_  
5 CYL. \_\_\_\_\_  
6 CYL. 1  
8 CYL. 1



ASSY NAME: External Lube Lines  
(No 4 way valve) 2 1/2" Flanges  
(Used with C-37-R or AA)  
Reversible  
FIRST USED ON: 46126

ASSY DWGS: See Photos

It.	Part No.	Part Name	Matl	Qty	Remarks
1	B-3582	Flange	CS	7	Std. Flange #554 150# 2" or Purch
2	79067-1	Gasket, 2" Std. Flange	Vel	7	
3	G-2022-1	Flange, L.O. Suction-2" P.T.	St	1	
4	G-1285-1	Flange-L.O. Suction-2" Weld	St	1	
5	G-1191-1	Gasket, Disch. Flg.	Vel	3	
6	G-1286-1	Gasket, Suction Flg.	Vel	2	
7	G-1942-1	Flange-Discharge 2" P.T.	St	3	
8					
9					
10					
11					
12					
13					
14					
15					
16					
17					
18					
19					
20					
21					
22					

CI = Cast Iron                      CRS = Cold Rolled Steel  
CS = Cast Steel                    CBr = Cast Brass  
FS = Forged Steel                CBrz = Cast Bronze

ENGINE MODEL G

2 CYL. \_\_\_\_\_  
 3 CYL. \_\_\_\_\_  
 4 CYL. \_\_\_\_\_  
 5 CYL. \_\_\_\_\_  
 6 CYL. 1 \_\_\_\_\_  
 8 CYL. 1 \_\_\_\_\_



ASSY NAME: Operating Control  
 R.H. Piston Type (C-CW Rot.)  
 Internal Grommet in Air Valve

FIRST USED ON: \_\_\_\_\_

ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks	
1						
2	<del>G-2863</del>	<del>Pre-Assy., Operating Control</del>		1	<del>Use Assy. Dwg. G-2863</del> <del>Consisting of:</del>	
3	79704-1	Lever, Control	CBr	1	Pre-Assy. 79702 Assy. Dwg. 79702	
4	79707-1	Button, Lever Block	CBr	1		
5	79708-1	Pin, Lever Block	St	1		
6	79709-1	Button, Valve Block	CBr	1		
7	79710-1	Pin, Valve Block	St	1		
8		<del>Setscrew</del>	<del>St</del>	<del>2</del>		<del>Gene Pts.</del> <del>#10-24 x 1/4 Lg.</del>
9		Ball	St	2		1/4" Dia.
10	79711-1	Spring	St	2		
11		Plug	Br	1		Slotted Type 1/8 Pipe
12	79949-1	Housing, Control, R.H.	CBrz	1		Pre-Assy. & Dwg. G-2863
13	G-1067 79687-1	Valve, Guide Dowel, Lever Block	Br St	1 2	Assembly & Dwg. 79989	
14	G-2825-1	Plug, Metering	St	2		
15	79712-1	Strip, Indicator, R.H.	CBr	1		
16		Screw, Chrome Plate	Br	3	1/4-20 x 1/2 Flat Hd.	
17		Ball, Indicator	St	1	5/8 Steel Ball	
18	79716-1 G-1011-1	Spring, Indicator Ball Shaft, Operating, R.H.	St St	1 1		
19		"Groov" Pin		1	3/8 x 2	
20	79950-1	Plate, Thrust	CRS	1		
21		Setscrew, Allen Cup Point		2	5/16-18 x 1/2	
22	G-2836-1	Valve, Air Start.	CBr	1		

CI = Cast Iron                      CRS = Cold Rolled Steel  
 CS = Cast Steel                    CBr = Cast Brass  
 FS = Forged Steel                CBrz = Cast Bronze

CONTINUED  
 NEXT PAGE

ENGINE MODEL G

ASSY NAME: Operating Control

2 CYL. \_\_\_\_\_  
3 CYL. \_\_\_\_\_  
4 CYL. \_\_\_\_\_  
5 CYL. \_\_\_\_\_  
6 CYL. 1  
8 CYL. 1

FIRST USED ON: \_\_\_\_\_

ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks
1	B-5001	"O" Ring Packing	Neo.	1	
2	B-3775	Ring, Air Start Valve	Brz	1	
3	79718-1	Valve, Air Start. Pilot	Br	1	
4					
5	G-1068-1	Valve Screw	Br	1	
6	G-1070-1	Spring, Pilot Valve		1	
7	G-1066-1	Spring, Air Start. Valve		1	
8	79700-1	Spring, Valve		2	Pre-Assy. & Dwg. G-2863 (contd.)
9	G-1069-1	Hand Wheel	CBr	1	
10		Screw, Rd. Hd. Mach.		1	#10-32 x 3/8
11		Washer		1	#10 SAE <del>3/16 Std. 1/2 O.D.</del>
12	G-1184-1	Washer	Rub	1	
13	79693-1	Pin, Air Start. Cam	St	1	
14	79694-1	Valve, Shift	Br	2	
15	79692-1	Pin, Shift Valve Cam	St	2	
16	79695-1	Cover, Valve Chest	CBrz	1	
17	79720-1	Gasket, Cover	Vel	1	
18		Capscrew, Allen	St	4	5/8-11 x 1-1/2
19					
20					
21		Capscrew, Control Housing	St	4	5/8- 11 x 1-1/4 Allen
22	79721-1	Gasket, Control Housing	Vel	1	
	104-2	Dowel	St	2	

CI = Cast Iron                      CRS = Cold Rolled Steel  
CS = Cast Steel                    CBr = Cast Brass  
FS = Forged Steel                CBrz = Cast Bronze



Date Issued: 1-27-41 THESE PARTS ON G-257-F  
 Retyped: 6-29-49

ASSEMBLY NO. G-57-F  
 SHEET NO. \_\_\_\_\_

ENGINE MODEL G  
 2 CYL. \_\_\_\_\_  
 3 CYL. \_\_\_\_\_  
 4 CYL. \_\_\_\_\_  
 5 CYL. \_\_\_\_\_  
 6 CYL. 1  
 8 CYL. 1



ASSY NAME: Exhaust  
 (For Welding 8" Pipe) G-6 450 RPM  
~~and over, All G-8.~~ (Non-Supercharged)

FIRST USED ON: \_\_\_\_\_

ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks
1	76037-1	Adapter	CS	1	
2	79120-1	Gasket	Gar.	1	1/16
3		Bolt		4	3/4-10 x 2-1/2
4		Nut		4	3/4-10
5		Plug		2	1/2" Blk
6					
7					
8					
9					
10					
11					
12					
13					
14					
15					
16					
17					
18					
19					
20					
21					
22					

CI = Cast Iron                      CRS = Cold Rolled Steel  
 CS = Cast Steel                    CBr = Cast Brass  
 FS = Forged Steel                CBrz = Cast Bronze



Date Issued: 4-8-46.

THESE PARTS ON G-259-D3

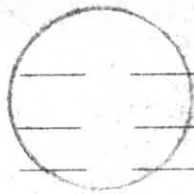
ASSEMBLY NO. G-59- DDD  
SHEET NO. \_\_\_\_\_ENGINE MODEL G

2 CYL. \_\_\_\_\_

3 CYL. \_\_\_\_\_

4 CYL. \_\_\_\_\_

5 CYL. \_\_\_\_\_

6 CYL. 18 CYL. 1ASSY NAME: Circulating Water Fittings  
300 to 400 RPM Rev. 2 Cent. (Small  
Pump) HE & LOC off Engine, w/o Thrust  
Brg. Line

FIRST USED ON: 46011

ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks
1		Jacket Water Line from Pump			
2	79896-1	Tee, Pump-Block	CI	1	RH Eng.
	79914-1	Tee, Pump-Block	CI	1	LH Eng.
3	77686-1	Gasket, Pump-Tee	Rub	1	1/16
4	79132-1	Gasket, Tee-Block	Rub	1	1/16
5		Capscrew, Tee-Pump		8	1/2-13 x 1-1/2
6		Capscrew, Tee-Block		6	5/8-11 x 1-1/2
7		Plug, Pipe	Blk	1	1/4
8	B-3568	Flange	CI	1	3" 125# Crane #553
9	77686-1	Gasket	Rub	1	1/16
10		Bolt, Hex		4	5/8-11 x 2
11		Nut, Hex		4	5/8-11
12		Plug, Pipe	Blk	1	3"
13					
14		Line to Gage Board			
15		Ell, 90° str.	Br	1	1/4
16		Nipple	Br	1	1/4 x short
17	B-3187	Valve, Globe	Br	1	1/4
18		Connection	Imp	1	68F 1/4P 1/4T
19		Tube	Cop	1	1/4 x 48
20		Connection	Imp	1	68F 1/4T 1/8P
21	B-3130	Stop Cock	Br	1	1/2
22	B-3227	Vertical Check Valve	Br	1	1/2

CI = Cast Iron  
CS = Cast Steel  
FS = Forged SteelCRS = Cold Rolled Steel  
CBr = Cast Brass  
CBrz = Cast Bronze

Date Issued: 4-20-50

ASSEMBLY NO. G-69-A6  
SHEET NO. 1 of 1

ENGINE MODEL Q

2 CYL. \_\_\_\_\_  
 3 CYL. \_\_\_\_\_  
 4 CYL. \_\_\_\_\_  
 5 CYL. \_\_\_\_\_  
 6 CYL. 1 \_\_\_\_\_  
 8 CYL. 1 \_\_\_\_\_

ASSY NAME: LUBE FILTER  
 CS Strainer, 2" Weld Pipe, 20 Mesh  
 Scav. Line

FIRST USED ON: \_\_\_\_\_

ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks
1	33891	Assem., 2" Scav. Strainer		<input checked="" type="checkbox"/> 1	Consisting of:
2	31052	Body, Strainer		1	Use Pattern 31053
3	32773	Basket, Strainer		1	
4	32633	Clamp, Strainer		1	
5	32630	Cover, Strainer		1	
6	B-1175	"O" Ring		1	
7	32631	Spring, Strainer		1	
8	31617	Assem., Handle		<input checked="" type="checkbox"/> 1	Dwg. 31617 Consisting of:
9	32632	Clamp Screw		1	
10	32628	Handle		1	
11		Pipe Plug		1	1"
12					
13					
14					
15					
16					
17					
18					
19					
20					
21					
22					

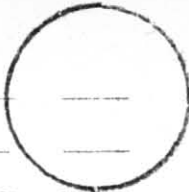
CI = Cast Iron  
 CS = Cast Steel  
 FS = Forged Steel

CRS = Cold Rolled Steel  
 CBr = Cast Brass  
 CBrz = Cast Bronze

Date Issued: 5-13-46  
 Retyped: 1-13-49

ASSEMBLY NO. G-69-B4  
 SHEET NO. \_\_\_\_\_

ENGINE MODEL \_\_\_\_\_  
 2 CYL. \_\_\_\_\_  
 3 CYL. \_\_\_\_\_  
 4 CYL. \_\_\_\_\_  
 5 CYL. \_\_\_\_\_  
 6 CYL. \_\_\_\_\_  
 8 CYL. \_\_\_\_\_



ASSY NAME: Lube Strainer  
 Cuno - Commercial, metal edge-  
 Simplex & Cleanable - Model EGF-2  
 2 - 6" Cart. 45 GPM  
 FIRST USED ON: 46017-122  
 ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks
1	B-4250	Cuno strainer		1	Cuno EGF-2
2		.003" spacing scraper type metal edge, CI head			
3		w/2" standard commercial flange connections, 6"			
4		long cartridge, 45 GPM pressure drop of 7#/sq."			
5		w/ built in relief valve set at 15 psi #10910.			
6					
7					
8					
9					
10					
11					
12					
13					
14					
15					
16					
17		Replacement Information			
18	B-4244	Element			
19					
20					
21					
22					

CI = Cast Iron                      CRS = Cold Rolled Steel  
 CS = Cast Steel                    CBr = Cast Brass  
 FS = Forged Steel                CBrz = Cast Bronze

Date Issued: 2-21-49

ASSEMBLY NO. G-70-PPF  
SHEET NO. \_\_\_\_\_

ENGINE MODEL G  
2 CYL. \_\_\_\_\_  
3 CYL. \_\_\_\_\_  
4 CYL. \_\_\_\_\_  
5 CYL. \_\_\_\_\_  
6 CYL. 1  
8 CYL. \_\_\_\_\_



ASSY NAME: Fuel Oil Filter  
Duplex, Absorbent Type

FIRST USED ON: 48086-89

ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks
1	B-5100	Filter, Fuel Oil Duplex,		1	Winslow
2		2 Element absorbent Type;			Model #600-BF-4
3		Commercial Construction			
		with Cast Aluminum Head			
4					
5					
6					
7					
8					
9					
10					
11					
12					
13					
14					
15		Replacement Information			
16	B-3113	Filter Element			
17					
18					
19					
20					
21					
22					

CI = Cast Iron                      CRS = Cold Rolled Steel  
CS = Cast Steel                    CBr = Cast Brass  
FS = Forged Steel                  CBrz = Cast Bronze



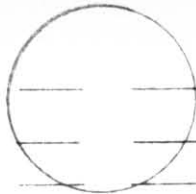
Date Issued: 1-3-44

ASSEMBLY NO. G-70-00

Retyped 9-23-53

SHEET NO. \_\_\_\_\_

ENGINE MODEL X G



ASSY NAME: Fuel Filter

metal-edge, .003 spacing comm.  
construction, duplex, cleanable

2 CYL. \_\_\_\_\_  
3 CYL. \_\_\_\_\_  
4 CYL. \_\_\_\_\_  
5 CYL. \_\_\_\_\_  
6 CYL. \_\_\_\_\_  
8 CYL. \_\_\_\_\_

FIRST USED ON: 42269

ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks
1	B-3437	Filter, Model D-113-JJ-10		1	Purolator Products
2					
3					
4					
5					
6					
7					
8					
9					
10					
11					
12					
13					
14					
15		Replacement Information			
16	B-3396	Filter Element			
17					
18					
19					
20					
21					
22					

CI = Cast Iron  
CS = Cast Steel  
FS = Forged Steel

CRS = Cold Rolled Steel  
CBr = Cast Brass  
CBrz = Cast Bronze

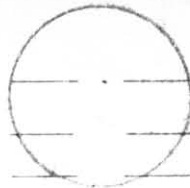
Date Issued: 7-18-46  
Retyped: 1-13-49

THESE PARTS ON G-274-J

ASSEMBLY NO. G-74-J  
SHEET NO. \_\_\_\_\_

ENGINE MODEL \_\_\_\_\_

2 CYL. \_\_\_\_\_  
3 CYL. \_\_\_\_\_  
4 CYL. \_\_\_\_\_  
5 CYL. \_\_\_\_\_  
6 CYL. 1 \_\_\_\_\_  
8 CYL. 1 \_\_\_\_\_



ASSY NAME: Filter Bracket & Drip Pan  
602 & 802 BF-4 Winslow Filter, All  
Non-Turbocharged Engines, 6 Cyl.  
Front End Mtd. Turbochg. Engines  
FIRST USED ON: 47006-7

ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks
1	G-2035-1	Plate, Filter	ST	1	
2		Capscrew, Plate to Block	ST	2	1/2-13 x 1-1/2
3		Capscrew, Plate to Filter	ST	4	3/8-16 x 1
4					
5	76008-1	Drip Pan	CI	1	
6		Pipe Plug		1	1/2 Standard
7		Capscrew		4	3/8-16 x 1-1/2
8	76011-1	Screen - Drip Pan		1	20 Mesh (Welded)
9					
10					
11					
12					
13					
14					
15					
16					
17					
18					
19					
20					
21					
22					

CI = Cast Iron                      CRS = Cold Rolled Steel  
CS = Cast Steel                    CBr = Cast Brass  
FS = Forged Steel                  CBrz = Cast Bronze

(See individual Eng. Specs. for which pages to use. Also 103 Assem. for additional gauges.)

Date Issued: 1-2-45

Retyped 6-2-53

ASSEMBLY NO. 101-WW  
SHEET NO. 2-R Sh. 1

ENGINE MODEL \_\_\_\_\_  
2 CYL. \_\_\_\_\_  
3 CYL. \_\_\_\_\_  
4 CYL. \_\_\_\_\_  
5 CYL. \_\_\_\_\_  
6 CYL. \_\_\_\_\_  
8 CYL. \_\_\_\_\_

ASSY NAME: Instrument Board & Gauges  
(Back Conn.)

FIRST USED ON: 111299

ASSY DWGS: 75905

It.	Part No.	Part Name	Matl	Qty	Remarks
1		MEDIUM SIZE PANEL 3-1/2" W/O FUEL, W/SEA WATER, W/STD. ROUND ALNOR PYROMETER.			
2					
3		(See end of list for Combination Assembly number.)			
4					
5	75909-1	Panel, Gauge Board on Engine		1	Bakelite
6		Drilled for the following Gauges:			
7		Tachometer		1	See 115 Assem.
8		Pyrometer		1	See 111 Assem.
9	B-3340	Starting Air Pressure		1	0-600
10	B-4237	Lube Oil Pressure		1	0-100
11	B-3715	Circulating Water Pressure		1	0-60
12	B-3654	Sea Water Pressure		1	0-60 (or 0-30, B-3342 if ^ Cent. Pump)
13					
14		Line Inside Gauge Board.			
15		Union	Imp	4	62F 1/4T
16		Tube	Cop	1	1/4 x 12'
17		El1	Imp	4	69F 1/4T 1/4P
18		Screw, Roundhead Gauge		12	8-32 x 3/4 Long
19		Nut, Hex		12	8-32
20		Lockwasher		12	3/16 Regular
21		Screw, Rd. Hd. Pyrometer		3	1/4-20 x 1 Long
22		Lockwasher		3	1/4 Regular

CI = Cast Iron  
CS = Cast Steel  
FS = Forged Steel

CRS = Cold Rolled Steel  
CBr = Cast Brass  
CBrz = Cast Bronze

CONTINUED  
NEXT PAGE

Date Issued: 1-2-45  
 Retyped 6-2-53

ASSEMBLY NO. 101-WW  
 SHEET NO. 2-R Sh. 2

ENGINE MODEL \_\_\_\_\_  
 \_\_\_\_\_  
 \_\_\_\_\_  
 2 CYL. \_\_\_\_\_  
 3 CYL. \_\_\_\_\_  
 4 CYL. \_\_\_\_\_  
 5 CYL. \_\_\_\_\_  
 6 CYL. \_\_\_\_\_  
 8 CYL. \_\_\_\_\_

ASSY NAME: Instrument Board & Gauges  
 FIRST USED ON: 44299  
 ASSY DWGS: 75905

It.	Part No.	Part Name	Matl	Qty	Remarks
1		Nut, Hex		3	1/4-20
2					
3					
4					
5	12438	Assem., Combination Panel and			2-R & 6-E
6		Frame			
7					
8					
9					
10					
11					
12					
13					
14					
15					
16					
17					
18					
19					
20					
21					
22					

CI = Cast Iron                      CRS = Cold Rolled Steel  
 CS = Cast Steel                    CBr = Cast Brass  
 FS = Forged Steel                CBrz = Cast Bronze



Date Issued: 1-28-43

Retyped: 1-16-51

ASSEMBLY NO. 101-WW

SHEET NO. 6E

ENGINE MODEL \_\_\_\_\_

ASSY NAME: Instrument Board &amp; Gauges

2 CYL. \_\_\_\_\_

3 CYL. \_\_\_\_\_

4 CYL. \_\_\_\_\_

5 CYL. \_\_\_\_\_

6 CYL. \_\_\_\_\_

8 CYL. \_\_\_\_\_

FIRST USED ON: \_\_\_\_\_

ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks
1		MEDIUM SIZE RUBBER MOUNTED FRAME			
2		(See Panel Parts List for Comb. Assy. No.)			
3	75906-1	Frame, Gauge Board		1	Welded Steel
4	75906-3	Back Cover, Slotted	Br	1	Sheet St. 18 Gauge
5		Screw, Knurled		10	10 x 24 x 1/2
6	G-5394	Support, Frame		2	Steel Channel
7	B-3957	Pad, Mounting, Shear Type	Rub	4	Lord Series 150 PD10
8		Capscrew, Hex		4	1/4-20 x 1-1/2
9		Nut, Acorn	Br	4	1/4-20
10	G-5400	<del>Washer</del> Spacer	St	4	<del>1/4</del>
11		Lockwasher		4	1/4
12		Screw, Rd. Hd. Mach.	St	8	8-32 x 5/16 Assy. 77319
13		Nut, Hex.		8	<del>1/4-20</del> 8-32
14	G-5399	Lockwasher Bracket, Rubber Mounting	St	2	No. 8
15	B-3998	Pad, Mounting Cylindrical	Rub	4	U.S. Royal #300
16		Nut, Hex.		8	1/4-20
17		Lockwasher Screw, Oval Hd. Mach.	St	10	1/4 #8-32 x 1/2
18		Washer, Finish, Cntrs nk.		10	1/2 O.D.
19		Lockwasher		10	1/4
20		Nut, Hex.		10	1/4-20
21	75972-1	Plate Conduit Support	St	1	
22	76482	Plate Conduit Support	St	1	

CI = Cast Iron

CS = Cast Steel

FS = Forged Steel

CRS = Cold Rolled Steel

CBr = Cast Brass

CBrz = Cast Bronze

(See individual engine specs for which pages to use)

Date Issued: 5-5-42  
Retyped: 1-6-49

ASSEMBLY NO. 101-WW  
SHEET NO. 11A

ENGINE MODEL \_\_\_\_\_  
2 CYL. \_\_\_\_\_  
3 CYL. \_\_\_\_\_  
4 CYL. \_\_\_\_\_  
5 CYL. \_\_\_\_\_  
6 CYL. \_\_\_\_\_  
8 CYL. \_\_\_\_\_

ASSY NAME: Instrument Board & Gauge

FIRST USED ON: \_\_\_\_\_

ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks
1					
2		BRACKET, G REVERSIBLE ENGINE RH MEDIUM BOARD			
3	76025-1	Bracket, instrument board		1	Welded steel
4		Capscrew, bkt-cyl.block		4	1/2-13 x 1
5		Bolt, board-bracket		4	1/2-13 x 1-3/4
6		Nut, hex		4	1/2-13
7		Lockwasher		4	1/2 Std.
8					
9					
10					
11					
12					
13					
14					
15					
16					
17					
18					
19					
20					
21					
22					

CI = Cast Iron                      CRS = Cold Rolled Steel  
 CS = Cast Steel                    CBr = Cast Brass  
 FS = Forged Steel                CBrz = Cast Bronze

Date Issued: 2-3-47

Retyped 9-23-53

ASSEMBLY NO. 101-WW  
SHEET NO. 16-N

ENGINE MODEL \_\_\_\_\_

ASSY NAME: INSTRUMENT BOARD & GAUGE  
Marine & Stat.

2 CYL. \_\_\_\_\_

3 CYL. \_\_\_\_\_

4 CYL. \_\_\_\_\_

5 CYL. \_\_\_\_\_

6 CYL. \_\_\_\_\_

8 CYL. \_\_\_\_\_

FIRST USED ON: 46207

ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks
1					
2		Thermometers			
3	B-3956	Thermometers			
4		Oil to Engine		1	
5		Oil from Engine		1	
6		Water from Engine		1	
7		Water to Engine		1	
8					
9		If used with separate L.O.			
10		Cooler & Heat Exchanger, add		3	
11		If combination L.O. Cooler			
12		& Heat. Exchanger, add		2	
13		If supercharged add for			
14		water discharge		1	
15		If used with Radiator,			
16		evaporative Cooler etc & separate L.O. Cooler, add		1	
17		If used with Radiator with			
18		Oil Cooling Section, add		0	
19					
20					
21					
22					

CI = Cast Iron  
CS = Cast Steel  
FS = Forged SteelCRS = Cold Rolled Steel  
CBr = Cast Brass  
CBrz = Cast Bronze

(See Individual Engine Specs For Which Pages To Use)

Date Issued: 5-6-42  
Retyped: 6-2-53

ASSEMBLY NO. 101-WW  
SHEET NO. 17-A

ENGINE MODEL \_\_\_\_\_  
2 CYL. \_\_\_\_\_  
3 CYL. \_\_\_\_\_  
4 CYL. \_\_\_\_\_  
5 CYL. \_\_\_\_\_  
6 CYL. \_\_\_\_\_  
8 CYL. \_\_\_\_\_

ASSY NAME: Instrument Board & Gauge  
(Fuel Gage on Side of Cylinder  
Block)

FIRST USED ON: \_\_\_\_\_

ASSY DWGS: 76191

It.	Part No.	Part Name	Matl	Qty	Remarks
1					
2	77609	Assem., Fuel Gage Bracket		1	Consisting of:
3	B-3365	Gauge, Fuel Oil Pressure 3 1/2"		1	Bottom Conn. 0-60 lbs.
4		Screw, Rd.Hd.		3	8-32 x 1/2
5	76193	Bracket	St	1	Welded
6	76192	Housing	CI	1	
7	B-3957	Mounting Pad	Rub	3	Lord 150-PD2
8		Screw, Rd.Hd.		6	6-32 x 5/16
9		Lockwasher		6	SAE #6
10		Nut, Hex		6	6-32
11		Bolt		3	1/4-20 x 1-1/2
12		Washer		3	1/4" SAE
13		Nut, Hex.		3	1/4-20
14					
15		Elbow	Blk	1	1/4" 90°
16					
17	B-3958	Hose, 1/4" ID x 10" Long B.C.		As Reqd	Resisto-Flex Type SCN
18		On solid male; one swivel male, 1/4" ID Couplings			
19		Attached			
20	B-3232	Shut-Off Cock		1	1/4"
21		Bushing	Blk	1	
22					

CI = Cast Iron                      CRS = Cold Rolled Steel  
CS = Cast Steel                    CBr = Cast Brass  
FS = Forged Steel                CBrz = Cast Bronze



ENGINE MODEL X G \_\_\_\_\_  
 2 CYL. \_\_\_\_\_  
 3 CYL. \_\_\_\_\_  
 4 CYL. \_\_\_\_\_  
 5 CYL. \_\_\_\_\_  
 6 CYL. 1 1 \_\_\_\_\_  
 8 CYL. \_\_\_\_\_

ASSY NAME: LUBE OIL TANK  
 100 Gal. Rectangular, Sight Glass Gauge  
 and Outlet Connections on Side  
 FIRST USED ON: 48078-84  
 ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks
1					
2	12977	Pre-Assy., Lube Oil Tank		1	Consisting of:
3	12903	Tank, Lube Oil		1	Consisting of:
4	93012	Flange, Gauge		2	
5	G-3117	Flange		1	
6	G-3116	Flange		1	
7	G-3119	Flange		1	
8	94685	Flange		1	
9	G-2537	Cover, Cleanout		1	
10	G-2538	Gasket, Cover		1	
11		Capscrew		16	3/8-16 x 3/4
12	13573	Flange, Blind-Gauge Opening		2	
13	94694	Gasket, Flange		2	
14		Capscrew		8	5/16-24 x 5/8
15	G-3493	Gasket, Cover		1	
16	G-3123	Cover		1	
17		Capscrew		8	3/4-10 x 1-1/2
18	B-3971	Flange, Blind		1	
19	94696	Gasket		1	
20		Capscrew		4	5/8-11 x 1-3/4
21		Pipe Plug		1	3/4 Sq. Hd.
22		Pipe Plug		1	1-1/2 Sq. Hd.

CI = Cast Iron                      CRS = Cold Rolled Steel  
 CS = Cast Steel                    CBr = Cast Brass  
 FS = Forged Steel                CBrz = Cast Bronze

Date Issued: 10-18-55

ASSEMBLY NO. 104-NN

SHEET NO. 2 of 2

ENGINE MODEL X G

ASSY NAME: LUBE OIL TANK

2 CYL. \_\_\_\_\_

3 CYL. \_\_\_\_\_

4 CYL. \_\_\_\_\_

5 CYL. \_\_\_\_\_

6 CYL. 1 1 \_\_\_\_\_

8 CYL. \_\_\_\_\_

FIRST USED ON: \_\_\_\_\_

ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks
1		Pipe Plug		1	2-1/2 Sq. Hd.
2		Pipe Plug		1	3 Sq. Hd.
3					
4					
5	B-4826-3	Gauge, Sight Glass		1	
6					
7					
8					
9					
10					
11					
12					
13					
14					
15					
16					
17					
18					
19					
20					
21					
22					

CI = Cast Iron  
 CS = Cast Steel  
 FS = Forged Steel

CRS = Cold Rolled Steel  
 CBr = Cast Brass  
 CBrz = Cast Bronze

Date Issued: 11-13-48

ASSEMBLY NO. 108-LLL  
SHEET NO. 1 of 4ENGINE MODEL GASSY NAME: TOOLS AND FIXTURES  
"G" Engine, Standard Diesel

2 CYL.	_____	_____	_____
3 CYL.	_____	_____	_____
4 CYL.	_____	_____	_____
5 CYL.	_____	_____	_____
6 CYL.	<u>1</u>	_____	_____
8 CYL.	<u>1</u>	_____	_____

FIRST USED ON: \_\_\_\_\_

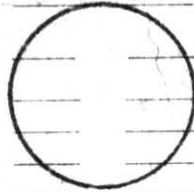
ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks
1	B-3666	Eyebolt, Piston Puller		1	For Alum. Pistons Only
				2	For Iron Pistons Only
2	B-4034	Wrench, Zero Lash Unit		1	
3	B-6068	Wrench, Fuel Pump Bleeder		1	
4	B-4044	Socket, Con Rod Nut		1	
5	B-4046	Adapter, 1 to 3/4 Drive		1	
6	B-4047	Handle		1	
7	B-4053	Drive Head, Male		1	
8	B-4056	Socket, Drag Link		1	
9	B-4057	Eyebolt, Liner Puller		1	
10	B-4045	Socket, Main Brg. Nut		1	
11	B-4213	Socket, Cylinder Head		1	
12	B-4219	Vise, Pin, Tip Cleaning		1	
13		Wire, Music, Tip Cleaning		1	See 40 Assembly Use .002 Undersize, 6" Long
14	B-4534	Wrench, Nozzle Nut		1	
15	B-5376	Pin Handle		1	} Assem., B-4055
16	B-5377	Socket		1	
17	B-5378	Extension, 10"		1	
18	1317-5	Fixture, Piston Ring		1	
19	G-6322	Plate, Liner Puller		2	
20	G-6323	Bolt, Liner Puller		1	
21		Nut, Liner Puller		1	1"-8, Hex
22	1794-1	Bar, Thru-Bolt		1	

CI = Cast Iron  
CS = Cast Steel  
FS = Forged Steel

CRS = Cold Rolled Steel  
CBr = Cast Brass  
CBrz = Cast Bronze

Date Issued: 11-18-48

ASSEMBLY NO. 108-LLL  
SHEET NO. 2ENGINE MODEL GASSY NAME: Tools & Fixtures  
"G"2 CYL. \_\_\_\_\_  
3 CYL. \_\_\_\_\_  
4 CYL. \_\_\_\_\_  
5 CYL. \_\_\_\_\_  
6 CYL. 1 \_\_\_\_\_  
8 CYL. 1 \_\_\_\_\_

FIRST USED ON: \_\_\_\_\_

ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks
1	11718-1	Wrench, "Zero-Lash" Unit	CRS	1	
2	11719-1	Tool, Brg. Shell Removing	St	1	
3	11724-1	Bar, Main Brg., Con-Rod & Cyl.Hd./ Sock.	CRS	1	
4	11732-1	Wrench, Relief Valve	See Dwg	1	
5	11845-1	Nut, Liner Puller	St	1	
6		Jackscrew, Air Valve Cage		2	Sq.Hd. Setscrew, 1/2-13x3
7	12562-1	Plate, Piston Holder	CRS	2	
8		Capscrew		2	1/2 - 13 x 2
9		Nut		2	1/2 - 13
10	12584-1	Socket, Thru-Bolt, Nut	St	1	
11					
12	X-3259	Pre-Assy., Tappet Wrench		1	Consisting of:
13	B-4375	Wrench, Tappet Plug		1	Plomb # 5661 Bonney # 4290
14	1576	Bar, Tappet Wrench	CRS	1	
15	12577-1	Wrench, #6 SAE Locknut		1	
16					
17					
18	12028	Pre-Assy., Valve Grinding Tool		1	Consisting of:
19	11731-1	Body	CRS	1	
20	11731-2	Pin	St	2	
21					
22					

CI = Cast Iron  
CS = Cast Steel  
FS = Forged SteelCRS = Cold Rolled Steel  
CBr = Cast Brass  
CBrz = Cast BronzeCONTINUED  
NEXT PAGE



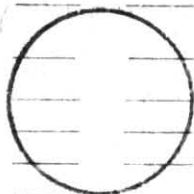
Date Issued: 11-18-48

ASSEMBLY NO. 108-LLL  
SHEET NO. 3

ENGINE MODEL G

ASSY NAME: Tools &amp; Fixtures

2 CYL. \_\_\_\_\_  
 3 CYL. \_\_\_\_\_  
 4 CYL. \_\_\_\_\_  
 5 CYL. \_\_\_\_\_  
 6 CYL. 1 \_\_\_\_\_  
 8 CYL. 1 \_\_\_\_\_



FIRST USED ON: \_\_\_\_\_

ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks
1	77242	Pre-Assy., Valve Spring Tool		1	Assy. Dwg. 77242 Consisting of:
2	11723-1	Body	CS	1	
3	12642-1	Screw, Comp	CRS	1	
4		Setscrew		2	3/8 - 16 x 2, Sq. Hd.
5	11722-1	Fork	CS	1	
6	12653-1	Handle	CRS	1	
7					
8					
9		<u>FOR STATIONARY ENGINES ONLY, ADD THE FOLLOWING:</u>			
10		(If Flange Mounting Base but no Sub-base):			
11	11717-1	Screw, Jacking	St	4* 6*	for 6 Cylinder Engine for 8 Cylinder Engine
12	12433-1	Plate, Jacking Screw		4* 6*	for 6 Cylinder Engine for 8 Cylinder Engine
13		(If Flush Mounting Base): Capscrew, Jacking 1 1/2 - 7 x 6		8* 10*	For 6 Cylinder Engine For 8 Cylinder Engine
14	12433-1	Plate, Jacking Screw		8* 10*	For 6 Cylinder Engine For 8 Cylinder Engine
15		<u>FOR MARINE ENGINES ONLY, ADD THE FOLLOWING:</u>			
16	79140-1	Ring, Locking - Manual Rev.	C Brz	1	
17	78492-1	Nut, Manual Reverse	C Brz	1	
18	11717-1	Screw, Jacking	St	6** 8**	For 6 Cylinder Engine For 8 Cylinder Engine
19	*	(For Jobs of more than one engine, only one set of Jacking Screws to be supplied)			
20	**	A Set of Jacking Screws to be supplied for each Marine Engine. (If Compressor or Sailing Clutch is used, add the following.)			
21	B-4377	Gun, Grease		1	Alemite C-600
22	B-4378	Hose, Grease Gun		1	Alemite A-1039

CI = Cast Iron  
 CS = Cast Steel  
 FS = Forged Steel

CRS = Cold Rolled Steel  
 CBr = Cast Brass  
 CBrz = Cast Bronze

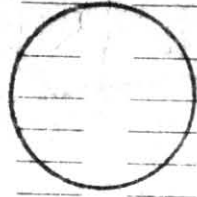
CONTINUED  
 NEXT PAGE

Date Issued: 11-18-48

ASSEMBLY NO. 108-LLL  
SHEET NO. 4

ENGINE MODEL G

- 2 CYL. \_\_\_\_\_
- 3 CYL. \_\_\_\_\_
- 4 CYL. \_\_\_\_\_
- 5 CYL. \_\_\_\_\_
- 6 CYL. 1 \_\_\_\_\_
- 8 CYL. 1 \_\_\_\_\_



ASSY NAME: Tools & Fixtures

FIRST USED ON: \_\_\_\_\_

ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks
1	If	Assy. 35 and/or 131is used,	add the following:)		
2	10677-1	Stud, W.P.Seat Pulling Tool	CRS	1	
3	10677-2	Strong Back	CRS	1	
4		Nut		1	5/8 - 11, High
5					
6					
7					
8					
9					
10					
11					
12					
13					
14					
15					
16					
17					
18					
19					
20					
21					
22					

CI = Cast Iron                      CRS = Cold Rolled Steel  
 CS = Cast Steel                    CBr = Cast Brass  
 FS = Forged Steel                CBrz = Cast Bronze

Date Issued: 1-24-49

ASSEMBLY NO. 109-U  
SHEET NO. 1 of 1

ENGINE MODEL Q X G \_\_\_\_\_  
 2 CYL. \_\_\_\_\_  
 3 CYL. \_\_\_\_\_  
 4 CYL. \_\_\_\_\_  
 5 CYL. \_\_\_\_\_  
 6 CYL. \_\_\_\_\_  
 8 CYL. \_\_\_\_\_

ASSY NAME: OPERATING AND MAINTENANCE  
INSTRUCTIONS, With Caution  
Plate

FIRST USED ON: \_\_\_\_\_

ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks
1	11927	Plate, Instruction		1	
2		Screw, Flat Head		4	#8-32 x 3/8, Nickel Pl.
3					
4	13003	Plate, Caution		1	
5		Screw, Flat Head		4	#8-32 x 3/8, Nickel Pl.
6					
7		Instruction Book		2	
8		Parts Book		1	
9					
10					
11					
12					
13					
14					
15					
16					
17					
18					
19					
20					
21					
22					

CI = Cast Iron                      CRS = Cold Rolled Steel  
 CS = Cast Steel                    CBr = Cast Brass  
 FS = Forged Steel                  CBrz = Cast Bronze

Date Issued: 4-30-43

ASSEMBLY NO. 111-00  
SHEET NO. 1 of 1

ENGINE MODEL G

2 CYL. \_\_\_\_\_

3 CYL. \_\_\_\_\_

4 CYL. \_\_\_\_\_

5 CYL. \_\_\_\_\_

6 CYL. \_\_\_\_\_

8 CYL. \_\_\_\_\_

ASSY NAME: PYROMETER

12 Point, 0-1200°F, Std., Commercial  
4" Thermocouples

FIRST USED ON: \_\_\_\_\_

ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks
1	B-3672	Pyrometer		1	
2	B-3675	Thermocouple			For Quantity, see engine specs for each job
3					
4					
5					
6					
7					
8					
9					
10					
11					
12					
13					
14					
15					
16					
17					
18					
19					
20					
21					
22					

CI = Cast Iron                      CRS = Cold Rolled Steel  
 CS = Cast Steel                    CBr = Cast Brass  
 FS = Forged Steel                CBrz = Cast Bronze





Date Issued: 5-18-50

ASSEMBLY NO. 113SHEET NO. 1ENGINE MODEL G \_\_\_\_\_ASSY NAME: Spare Parts - Standard

2 CYL. \_\_\_\_\_

3 CYL. \_\_\_\_\_

4 CYL. \_\_\_\_\_

5 CYL. \_\_\_\_\_

6 CYL. 1 \_\_\_\_\_

8 CYL. \_\_\_\_\_

FIRST USED ON: 50018

ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks
1		The entire equipment shall be packed in a manner suitable to			
2		protect it from dirt, moisture and mechanical injury during shipment			
3		and storage. Standard wooden boxes should be used. Spare parts			
3		should be packed separately from the Miscellaneous Engine Parts.			
4		All parts shall be clearly tagged with Part Numbers.			
5	B-3025	Pump, Bendix		1	Bendix FCX-15
6	G-2525	Assy. Nozzle Holder		1	Bendix
7	B-3032	Nozzle		1	Bendix
8	B-3036	Tip, 8 Hole, .012" 130°		1	Bendix
9	77837	Assy. Injection Line		1	
10	76747	Assy. Inlet Tube		1	
11	B-3354-13	Screw, Air Bleed		1	Bendix 10-22737
12	B-3354-12	Gasket, Bleeder Screw		1	Bendix 10-16466
13	1143	Gasket, Nozzle Holder	Cop	6	
14	75454	Gasket, Fuel Line Screw	Cop	6	
15	B-3113	Element, Absorbent		2	Winslow #600 BF-4
16	7700-1	Spring, Inner - Exh.	St	1	
17	7699-2	Spring, Outer - Exh.	St	1	
18	75294	Retainer	CRS	1	
19	7669-2	Wedge	CRS	2	Halves
20	G-3690	Gasket, Cylinder Head		2	
21	G-3691	Gasket, Cylinder Head		2	
22	7668-2	Valve, Exhaust		1	

CI = Cast Iron  
 CS = Cast Steel  
 FS = Forged Steel

CRS = Cold Rolled Steel  
 CBr = Cast Brass  
 CBrz = Cast Bronze

CONTINUED  
 NEXT PAGE

Date Issued: 5-18-50

ASSEMBLY NO. 113  
SHEET NO. 2

ENGINE MODEL G \_\_\_\_\_  
 2 CYL. \_\_\_\_\_  
 3 CYL. \_\_\_\_\_  
 4 CYL. \_\_\_\_\_  
 5 CYL. \_\_\_\_\_  
 6 CYL. 1 \_\_\_\_\_  
 8 CYL. \_\_\_\_\_

ASSY NAME: Spare Parts - Standard

FIRST USED ON: 50018

ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks
1	G-1070-1	Spring, Pilot Valve		1	
2	B-5001	Packing "O" Ring		2	
3	B-3712	Seal, Piston Shaft		1	
4	B-3713	Seal, Piston Shaft		1	
5					
6					
7					
8					
9					
10					
11					
12					
13					
14					
15					
16					
17					
18					
19					
20					
21					
22					

CI = Cast Iron                      CRS = Cold Rolled Steel  
 CS = Cast Steel                    CBr = Cast Brass  
 FS = Forged Steel                CBrz = Cast Bronze

Date Issued: 11-22-39

ASSEMBLY NO. 115-V

Retyped 5-29-53

SHEET NO. \_\_\_\_\_

ENGINE MODEL                        

2 CYL.                        

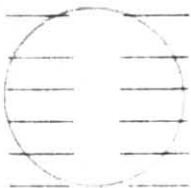
3 CYL.                        

4 CYL.                        

5 CYL.                        

6 CYL.   1     1                    

8 CYL.   1     1                    



ASSY NAME:   Tachometer    
 Weston 1-Station, Reversible (Solo Operation) Indicator in English

FIRST USED ON: \_\_\_\_\_

ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks
1	B-4012	Tachometer Generator Model 724		1	Weston
2		Type C2 equipped with 3/16 Diam. Drive, to fit Std. SAE Marine			
3		Engine Tachometer Shaft Connection			
4		Tachometer Indicator, Model 271,		1	Weston
5		Scale <u>  </u> -0- <u>  </u> RPM with Scale in red from <u>  </u> to <u>  </u> RPM. Gen. to run <u>  </u> x Eng. Speed. Stud 1-1/2" long. Left Side to be marked "Astern" Right Side to be marked "Ahead"			See Engine Specs for Data. Take-Off Ratio for: UW = 1.406 x Eng. RPM Old FG = 1.5625 x Eng. RPM X = 1.3333 x Eng. RPM For Q $\left\{ \begin{array}{l} 1x \text{ Eng. RPM} \\ \text{Camshaft Driven} \end{array} \right.$ For Q $\left\{ \begin{array}{l} 2x \text{ Eng. RPM} \\ \text{Idler Gear Driven} \end{array} \right.$ G = 1.3889 x Eng. RPM
10	B-3812	Cable, Automotive		8 ft.	
11					
12					
13					
14					
15					
16					
17					
18					
19					
20					
21					
22					

CI = Cast Iron                      CRS = Cold Rolled Steel  
 CS = Cast Steel                    CBr = Cast Brass  
 FS = Forged Steel                CBrz = Cast Bronze



Date Issued: 4-29-46  
 Retyped: 1-13-49

ASSEMBLY NO. 138-Z  
 SHEET NO. 1

ENGINE MODEL G \_\_\_\_\_  
 2 CYL. \_\_\_\_\_  
 3 CYL. \_\_\_\_\_  
 4 CYL. \_\_\_\_\_  
 5 CYL. \_\_\_\_\_  
 6 CYL. 1 \_\_\_\_\_  
 8 CYL. 1 \_\_\_\_\_

ASSY NAME: Flywheel Barring Device  
 Marine Flywheel-Cast Slots, Top &  
 Side Mount on base, Ratchet Type

FIRST USED ON: 46011

ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks
1					
2	G-1809	Pre-Assy., Barring Device		1	Assy. Dwg. G-1809 Consisting of:
3	G-1808-1	Bracket	CS	1	
4	G-1740-1	Pin, Bracket	CRS	2	
5		Cotter Pin		4	3/16 x 1-3/4 long
6	G-1710-1	Capstan	CS	1	
7	G-1706-1	Lever, Barring	CS	1	
8	G-1739-1	Pin, Barring Lever	CRS	1	
9		Washer, Plain		2	3/4 SAE
10		Cotter Pin		2	3/32 x 1-1/2 long
11	G-1738-1	Pin, Pawl	CRS	1	
12		Cotter Pin		2	3/32 x 1-1/2 long
13	G-1703-1	Pawl, Long	ST	1	
14	G-1705-1	Pawl, Short	ST	1	
15	G-2060-1	Pin, Locking	CRS	1	
16	76373-2	Nut	CRS	1	
17		Cotter Pin		2	1/8 x 1-1/4
18		Safety Chain	ST	1	#1-.028 gauge 9" long
19	G-2061-1	Plate, Spring	ST	1	
20		Wire, Music	ST		long #24 Gauge (.055) 1-7/8
21		Capscrew		2	1/4-20 x 1/2
22		Lockwasher		2	1/4 SAE

CI = Cast Iron                      CRS = Cold Rolled Steel  
 CS = Cast Steel                    CBr = Cast Brass  
 FS = Forged Steel                CBrz = Cast Bronze

CONTINUED  
 EXT. PAGE

Date Issued: 4-29-46  
Retyped: 6-2-53

ASSEMBLY NO. 138-Z  
SHEET NO. 2

ENGINE MODEL G \_\_\_\_\_  
2 CYL. \_\_\_\_\_  
3 CYL. \_\_\_\_\_  
4 CYL. \_\_\_\_\_  
5 CYL. \_\_\_\_\_  
6 CYL. 1 \_\_\_\_\_  
8 CYL. 1 \_\_\_\_\_

ASSY NAME: Flywheel Barring Device

FIRST USED ON: 46011

ASSY DWGS: \_\_\_\_\_

It.	Part No.	Part Name	Matl	Qty	Remarks
1	G-2064-1	Capscrew, Bracket - Base		3	
2					
3					
4					
5					
6					
7					
8					
9					
10					
11					
12					
13					
14					
15					
16					
17					
18					
19					
20					
21					
22					

CI = Cast Iron                      CRS = Cold Rolled Steel  
CS = Cast Steel                     CBr = Cast Brass  
FS = Forged Steel                  CBrz = Cast Bronze