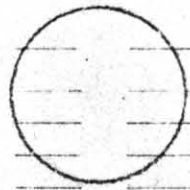


Date Issued: 11-27-42
 Retyped: 9-24-46

ASSEMBLY NO. Q-36-F
 SHEET NO. 2

ENGINE MODEL Q
 2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. 1 _____
 8 CYL. 1 _____



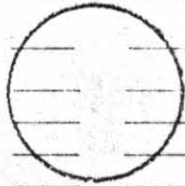
ASSY NAME: Fuel Transfer Pump
 FIRST USED ON: 42003-22
 ASSY DWGS: 91866

It.	Part No.	Part Name	Matl	Qty	Remarks
1		Nut		2	5/16-18
2	91920-3	Cover, Pump Body	CI	1	Use Patt. 91920-1
3		Plug, Pipe		1	3/8" Male
4	93406-1 91920-2	Gasket		1	1/32 Vel.
5		Capscrew		4	5/16-18 x 7/8
6	91921-3	Cage, Outlet	CI	1	Use Patt. 91921-1
7	91921-2	Gasket		1	1/16 Vel. Pre-Assy.
8		Capscrew		2	3/8-16 x 1 92900 (Cont.)
9	91922-3	Cage, Inlet	CI	1	Use Patt. 91922-1
10	93405-1 91922-2	Gasket		1	1/16 Vel.
11		Capscrew		2	3/8 - 16 x 1
12	91923-1	Valve	CBr	2	
13	91924-2	Gland	CBrz	1	
14		Packing		1	#117Gar. 3/16 x 3/16 x 1 39
15					
16					
17	91916-2	Gasket		1	1/16 Vel.
18	106-2	Dowel		2	
19		Capscrew		5	1/2 - 13 x 1 1/4
20		Capscrew, Allen Hd.		1	1/2-13 x 2 1/2
21	75512	Capscrew		4	
22		Wire		1	1/16 x 12
		Plug Snifter Connection Blk.		1	1/2"

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

ENGINE MODEL Q

- 2 CYL. _____
- 3 CYL. _____
- 4 CYL. _____
- 5 CYL. _____
- 6 CYL. 1
- 8 CYL. 1



ASSY NAME: Fuel Transfer Pump
 CI Plunger Type, Camshaft Driven
 Disp: 55 Strokes = 1 Gal. R.H.
 Reversible Eng.
 FIRST USED ON: 42003-22

ASSY DWGS: 91866

It.	Part No.	Part Name	Matl	Qty	Remarks
1		*FOR COMPLETE REPLACEMENT CAN USE Q-36-W			
2	92633	Pre-Assy. Fuel Transfer Pump		1	Consisting of:
3		Capscrews		2	1/2-13 x 4
4	75508	Bushing	Pre-Assy Brz 93456	2	
5	91916-1	Bracket	CI	1	Use Patt. 91177-1
6	91917-1	Cover, Trans. Pump	CI	1	
7	B-3887	Oil Cup		1	Gits #303
8	93420-1	Gasket	Vel	1	1/16 Vel
9		Capscrew		3	3/8-16 x 1
10	91180	Stub Shaft, Splined	CRS	1	
11	91182	Eccentric	CRS	1	
12	B-3915	Locknut		1	N-07
13	B-3916	Lockwasher		1	W-07
14	75513	Shim		11	.003 Brass
15	75514	Thrust Ring	CRS	1	
16	91918-1	Plunger		1	Ground Steel Shafting
17	75516	Pin		1	Drill Rod
18	75517	Connecting Rod	CI	1	
19	B-6499	Bushing	Pre-Assy. 78720	1/2	KR-219 Pre-Assy. 92900
20	B-6500	Bushing		1	KR-483
21	91919-2	Pump Body	CI	1	Use Patt. 91919-1
22	253	Stud		2	SAE 1120

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

CONTINUED
 NEXT PAGE

Date Issued: 10-26-49

ASSEMBLY NO. Q-34-CC

SHEET NO. 2

ENGINE MODEL Q

ASSY NAME: Water Pump

2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. 1 _____
 8 CYL. 1 _____

FIRST USED ON: 49041

ASSY DWGS: _____

It.	Part No.	Part Name	Matl	Qty	Remarks
1	75327	Packing Flange	CBr	1	
2		Packing	Flax	1	$\frac{1}{4} \times \frac{1}{4} \times 31\frac{1}{2}$, #31 Gar.
3	75328	Lantern Ring	Br	1	
4	75330	Washer	CRS	1	
5		Nut	Br	2	3/8-16
6	308	Stud, Packing Flange	Br	2	
7	104-1	Dowel		1	
8					
9					
10	79041-1	Gasket-Pump to Bracket	Vel	1	
11		Nuts, Pump to Bracket		8	1/2-13 x 1-1/2
12		Bolts, Pump to Bracket		8	1/2-13
13	95791	Bracket - Pump to Gear Case	Weld St	1	
14	95902	Gasket Bracket to Gear Case	Vel	1	
15		Capscrew, Bracket to Gear Case		8	1/2-13 x 1-1/2
16					
17					
18					
19					
20		* "Attach Tag #12618 to each Pump Assembly going to Service Parts."			
21					
22					

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

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

ENGINE MODEL Q
 2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. 1
 8 CYL. 1

ASSY NAME: Water Pump
 (Centrifugal) (Direct Reversing) Crank-
 shaft Drive, Manifold Side Pressure Lu-
 bricated, RH Engine (5.93 x Eng.RPM)

FIRST USED ON: 49041

ASSY DWGS: _____

It.	Part No.	Part Name	Matl	Qty	Remarks
1					
2	95910	* Assy. Water Pump & Bracket		1	See Assy.Dwg.G-2217 Consisting of:
3	75318-1	Casing	CI	1	
4		Pipe Plug	Br	4	1/4" Male Sq.Hd. Blk
5	B-3189	Pet Cock	Br	1	1/4" Male
6	75320-1	Cover	CI	1	
7	78342-1	Gasket, Cover-Casing	Rub	1	1/16
8		Capscrew		8	1/2-13 x 1-1/2
9	G-2216-1	Bracket	NSS CI	1	Pre-Assy.94398
10	75325	Bushing	Brz	2	
11		Capscrew		8	1/2-13 x 1-1/2
12	75322-1	Impeller		1	SAE 40 Red Brass
13	G-2563-1	Shaft	See Dwg.	1	
14	103-2	Pin, Dowel		1	
15	75321-2	Key	CRS	1	5/16 x 5/16 x 1-5/8
16		Nut, Castle		1	7/8-14
17		Cotter Pin	St	1	1/8 x 1-1/2
18		Taper Pin	St	3	#5 x 1-1/2
19	95901	Gear	St	1	
20	75324	Shim	St	24	
21	G-2055-1	Thrust Collar		1	SAE 1020
22	B-5633	Oil Seal		1	Natl.50519-S

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

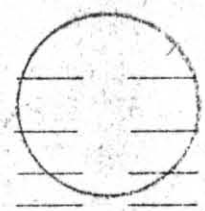
CRS = Cold Rolled Steel
 CBr = Cast Brass
 CBrz = Cast Bronze

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Date Issued: 10-24-46
 Retyped: 10-11-48

ASSEMBLY NO: G-34-DD
 SHEET NO. 2

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



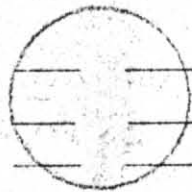
ASSY NAME: Water Pump
 FIRST USED ON: _____
 ASSY DWGS: _____

It.	Part No.	Part Name	Matl	Qty	Remarks
1	75327	Packing Flange	CBr	1	
2		Packing	Flax	1	1/4 x 1/4 x 31-1/2, #31 Gar
3	75328	Lantern Ring	Br	1	
4	75330	Washer	CRS	1	
5	308	Stud, Packing Flange		2	
6		Nut	Br	2	3/8-16
7	104-1	Dowel		1	
8					
9					
10	79041-1	Gasket, Bracket to Case	Vel	1	1/32"
11		Capscrew		8	1/2-13 x 1-1/2"
12					
13					
14		* "Attach Tag #12618 to each pump assembly going to service parts."			
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 DQ

- 2 CYL. _____
- 3 CYL. _____
- 4 CYL. _____
- 5 CYL. _____
- 6 CYL. 6 _____
- 8 CYL. 8 _____



ASSY NAME: Rocker & Push Rod
For Wide Roller Intake & Exhaust
Tappet (Reversible)

FIRST USED ON: 44172

ASSY DWGS: _____

It.	Part No.	Part Name	Matl	Qty	Remarks	
1						
2	92420	Pre-Assy. Rocker Arms & Shaft		1	Consisting of:	
3	9924-1	Shaft, Rocker		1	Pre-Assy. 92421	
4	93866-1	Rocker Arm, Intake NSS		1		
5	93868-1	Bushing, Rocker Arm		1		
6	93867-1	Pipe Plug, Slotted, 1/8 Bushing, Rocker Arm		1		
7	91613-1	Rocker Arm, Exhaust NSS		1		
8	93868-1	Bushing, Rocker Arm		1		Pre-Assy. 92422
9	93867-1	Pipe Plug, Slotted, 1/8 Bushing, Rocker Arm		1		
10		Pipe Plug		1	1/8" Male	
11	9923-1	Rocker, Air Pre-Assy. NSS		1	Pre-Assy. 92423	
12	10640-92	Bushing 93459		2		
13	9-65 12	Screw, Adjusting, Air Rocker		1		SAE 4140
14	9928	Nut, Adjusting Screw	CRS	1		
15		Pipe Plug, Slotted	Br	2	3/8 Square Socket Head Brass	
16	96954	Roller Pre-Assy. 95386		3	See Dwg.	
17	96955-8	Pin		3	See Dwg.	
18	B-3093	Zero-Lash Unit		2	Wilcox-Rich T-3547-A	
19	91612-1	Body, Zero Lash Lifter		2	See Dwg.	
20	91611-1	Lock, Lifter Body		2	Spring Wire	
21	9925	Screw, Adjusting, Int.&Exh.		2	See Dwg.	
22	9926	Nut, Adj. Screw, Int.&Exh.	CRS	2		

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

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

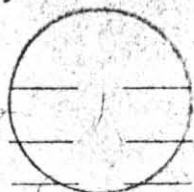
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Date Issued: 3/29/41

REPLACED BY G-15-F
SEE NOTE *

ASSEMBLY NO. Q-15-B
SHEET NO. _____

ENGINE MODEL	Q	G
2 CYL.	_____	_____
3 CYL.	_____	_____
4 CYL.	_____	_____
5 CYL.	_____	_____
6 CYL.	6	6
8 CYL.	8	8



ASSY NAME: Safety Valve

FIRST USED ON: 41010-17

ASSY DWGS: _____

It.	Part No.	Part Name	Matl	Qty	Remarks
1					
2	92003	Pre-Assy, safety valve		1	See Assy. 93080 Consisting of:
3	91281-1	Body		1	Ni.Cr.CI
4	6256-B	Valve	CRS	1	
5	6256-C	Cap	CRS	1	
6	6256-D	Lock nut	CRS	1	
7	6256-G	Handwheel	CRS	1	
8	6256-H	Collar, valve stem	CRS	1	
9	60359-1	Spring		1	Spring wire
10		Pin, cotter, stem collar		1	1/16 x 1
11		Plug, pipe	Blk	1	1/2"
12					
13	93351-1	Gasket, Valve body		1	3/64 Johns - Man. #60
14		Nut		2	5/8-11
15					
16					
17		* Replaced by G-15-F:			
18		For Q-Engines when replaced in sets			
19		For G-Engines w/new type Cyl.Heads only (w/Sub-cover)			
20		(old G Heads have different mounting holes)			
21					
22					

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

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

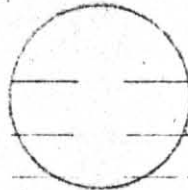
Date Issued: 11-12-42
Retyped: 9-17-46

ASSEMBLY NO. Q-14-C
SHEET NO. 2

ENGINE MODEL DQ

ASSY NAME: Valve

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		Cotter Pin		1	1/8 Dia. x 1"
2	B-3061	Ring, Str. Cut		2	1 1/2 x 1/8 A.H.
3	B-3062	Ring, Str. Cut		3	2 1/2 x 1/8 A.H.
4	93400-1	Washer	Stl	1	
5					
6					
7	9583	Retainer Cage	CS	1	
8	9169	Ring Cage	Rub.	1	
9	9341-2	Gasket, Cage	Cop.	1	.028 to .032
10	133	Nut, Cage		2	3/4-16 Hymo CD
11					
12					
13					
14					
15					
16					
17					
18					
19					
20					
21					
22					

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

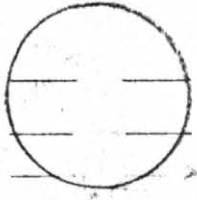
CRS = Cold Rolled Steel
CBr = Cast Brass
CBrz = Cast Bronze

Date Issued: 11-12-42
 Retyped: 9-17-46

SEE Q-13-H & J
 (Q-13 & 14 COMBINED)

ASSEMBLY NO. Q-14-C
 SHEET NO. 1

ENGINE MODEL DQ
 2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. 6
 8 CYL. 8



ASSY NAME: Valve
 FIRST USED ON: _____
 ASSY DWGS: _____

It.	Part No.	Part Name	Matl	Qty	Remarks
1	9863-1 96626	Valve, intake		1	See Assy. Dwg. 93090
2	9863-2 96627	Valve, exhaust		1	
3	B-3136	Thrust Bearing		2	
4	9886	Spring, Inner <i>HEAVY SPRING # 97614</i>		2	Spring Steel
5	9885	Spring, Outer		2	Spring Steel
6	9889	Spring Seat, (lower)	CRS	2	Diesel
7	9891	Retainer, Oil	Felt	2	
8	9890-1	Retainer, Spring	CRS	2	
9	9890-2	Wedge	CRS	4	Halves
10	<i>9867</i>	<i>Valve seat insert Exhaust</i>			
11	92683	Pre-Assy. Air Starting Valve		1	See Assy. Dwg. 9067 Consisting of:
12	9582	Cage	CI	1	<i>COPPER-9341-2</i>
13	9160-2	Valve		1	SAE 3140
14	9587	Retainer, Spring	CRS	1	<i>9169 O-Ring</i>
15	9588	Spacer	Brz	1	
16	9589	Washer	CRS	1	
17	9586-1	Piston, Auxiliary		1	Brass Bar Stock
18	9585-1	Piston	CBr	1	
19	93365-1	Cap, Air Valve	CRS	1	Pre-Assy. 9903
20	79007-1	Plug		1	
21	9592	Spring		1	
22	96644	Nut,		1	

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

NEXT PAGE CONTINUED

Date Issued: 9-11-46

ASSEMBLY NO. Q-13-F
SHEET NO. 2

ENGINE MODEL Q _____
 2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. 6 _____
 8 CYL. 8 _____

ASSY NAME: Cylinder Head

FIRST USED ON: 46133

ASSY DWGS: _____

It.	Part No.	Part Name	Matl	Qty	Remarks
1	94322-1 94367-1 94366-1	Packing Ring, Small Washer, Large # 95 781 Washer, Small # 95 782		4 6 4	Neophrene Dur. 55-60 Bonded to Ferrule 94323-1
2			Brz	4	
3	9124	Stud, Cylinder Head		8	SAE 4140 H.T.
4	129	Nut, Cylinder Head		8	1-3/4-8 Union CD Hymo
5	91006	Washer, Cylinder Head	CRS	8	
6					
7	94560 93857	Pre-Assy., Cyl. Head Cover (Polished) Pre-Assy., Cyl. Head Cover		1	Assy. Dwg. 93857 Consisting of:
8	92700-2 92700-1	Cover, Cylinder Head	See Dwg	1	Polished (Stationary) Painted (Marine)
9	7755-1			2	See Dwg. For Material
10	79965-1	Ring, Lock - Cyl. Hd. Nut		2	
11					
12	92816-1	Gasket, Cover, Cyl. Head		1	3/16 Gar. #660
13					
14	NOTE:	Use Following for Ordering Completely Assembled Units:			
15	94368	Pre-Assy., Cyl. Head w/Guides & Studs,			Q-13-F
16	94370	Pre-Assy., Cyl. Head w/Guides & Studs, Intake & Exhaust Valve			Q-13-F, Q-14-C
17	94371	Pre-Assy., Cyl. Head w/Guides, Studs, Intake & Exhaust Valves			Q-13-F, Q-14-C, Q-15-B
18	94372	Pre-Assy., Cyl. Head w/Guides, Studs, Intake & Exhaust Valve,			Q-13-F, Q-14-C
19					
20	94373	Group of Gaskets for Head Replacements			
21	96272	* For Replacement use Assy 96292 Gasket, Cyl. Head		1	Consisting of: Detroit 1001
22	95785	Gasket, Cyl. Head <i>insert</i>		1	Cork-Neoprene

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

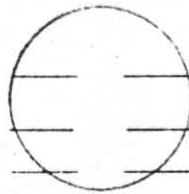
Date Issued: 9-11-46
Retyped: 2-28-51ENGINE MODEL Q2 CYL. _____
3 CYL. _____
4 CYL. _____
5 CYL. _____
6 CYL. 6
8 CYL. 8ASSY NAME: Cylinder Head
Air Starting, Head Gasket With Rubber RingsFIRST USED ON: 46133

ASSY DWGS: _____

It.	Part No.	Part Name	Matl	Qty	Remarks
1					
2	94368	Assy., Cylinder Head		1	Consisting of:
3	94328-1	Head, Cylinder	See Dwg.	1	
4	9123	Sleeve, Relief Valve	CRS	1	} (Cast in) Tubing Assy. 96453
5	X-3069	Plug, Sleeve		2	
6	9883	Sleeve, Nozzle	St.St.	1	
7	9908	Gasket, Nozzle Sleeve	Cop	1	.028-.032
8	9901	Stud, Nozzle Holder		2	SAE 4140
9	9902	Stud, Air.Cage		2	SAE 4140
10	706	Stud, Rocker Shaft		2	SAE 1120
11	515	Stud, Relief Valve		2	SAE 1120
12	313	Stud, Cyl. Head Cover		2	SAE 1120
13	9916-1	Cover	CI	1	Use Patt.9915
14		Allen Capscrew		3	5/16 x 3/4
15	93366-1	Gasket		1	Gar.660
16	9987-1	Cover, Water Inspection	CI	1	
17	93357-1	Gasket	Rub	1	
18		Capscrew		2	1/2-13 x 1-1/4
19	9866-1	Guide	CI	2	Ni.Cr.
20					
21	* 94324-1	Gasket, Cylinder Head		1	Detroit #1001
22	95788 94320-1	Packing Ring, Large		6	Neoprene Dur.55-60 Bonded to Ferrule 94321-1

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

ENGINE MODEL Q _____
 2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. 1 _____
 8 CYL. 1 _____



ASSY NAME: Con Rod & Bearings
For Cast Iron Oil Cooled Piston -
Flanged Shells

FIRST USED ON: 44259

ASSY DWGS: 94220

It.	Part No.	Part Name	Matl	Qty	Remarks
1	95040	Assembly Connecting Rod		1	Consisting of:
2	94247	Connecting Rod		1	Forge Dwg. 93378 Rough Mach. Dwg. 92703
3	91660-1	Bushing *		1	
4		*For Field Replacement of Bushing use			Part 92010-1
5					
6	92612	Assembly, Bearing		1	Consisting of:
7	91097-1	Box, Upper		1	
8	91097-2	Box, Lower		1	
9	93009-1	Bolt, Clamping		2	3/8-24 x 2-1/4
10		Nut Castle		2	3/8-24
11		Cotter		2	3/32 x 1
12					
13	96807	Assembly, Bearing Shell		1	Consisting of:
14	96806	Bearing		2	
15	91097-5	Shim		2	
16	91097-6	Shim		4	
17					
18	9107-1	Bolt, Con Rod Bearing		4	
19	126	Nut		4	
20		Cotter		4	3/16 x 2-1/2
21	9109-1	Shim Compression		9	(2) 1/32 (2) 1/64 (5) 1/16
22	75999-1	Washer		4	Supercharged Only

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

Date Issued:

ASSEMBLY NO. Q-11-M
SHEET NO. _____

ENGINE MODEL Q _____

2 CYL. _____
3 CYL. _____
4 CYL. _____
5 CYL. _____
6 CYL. 6 _____
8 CYL. 8 _____



ASSY NAME: Piston & Pin
Cast Iron, Oil Cooled

FIRST USED ON: _____

ASSY DWGS: _____

It.	Part No.	Part Name	Matl	Qty	Remarks
1					
2	96839	Assembly Piston & Pin		1	Consisting of:
3	94246	Piston		1	Assem. 96841
4	G-4352	Dowel		2	
5	91661-1	Plug, Piston		2	
6	94249-1	Insert, Oil Cooled Piston		1	
7		Capscrew		6	3/8-16x1
8	180-2	Locking Clip		6	
9	91662-1	Pin, Piston		1	Assem. 94525
10		Pipe Plug		2	
11					
12					
13		Rings to be arranged in order shown (First ring to be at top of piston)			
14					
15	94312	Assembly, Rings		1	Consisting of:
16	B-4199	Ring, Chrome Plated		2	16 x 3/8
17	B-4201	Ring, Taper Face		4	16 x 3/8
18	B-3089	Ring, LHA Oil Cutter		2	16 x 1/2
19	B-4202	Ring, Wide Channeled		1	16 x 1/2
20					
21					
22					

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

Date Issued: 1-23-39

Retyped 5-28-53

ASSEMBLY NO. Q-10-B

SHEET NO. _____

ENGINE MODEL Q _____

ASSY NAME: Cylinder Liner
16"

2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. 6 _____
 8 CYL. 8 _____

FIRST USED ON: 40001

Group 93442
~~ASSY~~ DWGS: _____

It.	Part No.	Part Name	Matl	Qty	Remarks
1	9840	Liner, cylinder	See Dwg.	1	Use Pattern 9103
2	9131	Ring, sleeve seal	Neo	2	
3					
4	93855-1	<i>Packing for hub of tube in liner</i>			<i>2 EA</i>
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: 11-27-42
Retyped: 5-11-49

ASSEMBLY NO. Q-38-D
SHEET NO. 2

ENGINE MODEL Q _____
2 CYL. _____
3 CYL. _____
4 CYL. _____
5 CYL. _____
6 CYL. _____
8 CYL. 1 _____

ASSY NAME: Force Feed Oiler

FIRST USED ON: 41002, 03, 04

ASSY DWGS: 93108

It.	Part No.	Part Name	Matl	Qty	Remarks
1	93416-1	Gasket	Vel	1	1/32
2		Capscrew		2	3/4-10 x 2
3	9865-1	Spacer	St	1	
4	9865-2	Spacer	St	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

Edition 2
 Date Issued: 11/27/42
 Revised 3-31-54

ASSEMBLY NO. Q-38-D
 SHEET NO. 1

ENGINE MODEL Q
 2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. _____
 8 CYL. 1 _____

ASSY NAME: Force Feed Oiler
 16 Feed Tappet drive
 8 Cyl., ~~Non-Reversible~~
 RH

FIRST USED ON: 41002,03,04

ASSY DWGS: 93108

It.	Part No.	Part Name	Matl	Qty	Remarks
1	B-3880	Oiler, Model 25W 16 Feed		1	Manzel
2		Horizontal outlet, right hand ratchet drive			(Omit all drive linkage & external check valves)
3		Capscrew		4	3/8-16x 2
4	92625	Pre-Assy Oiler tappet drive		1	See Assy. 93108 Consisting of:
5	9857-1	Guide Tappet	CI	1	
6	B-3879	National Oil Seal		1	50141
7	9858	Tappet		1	Ground shafting
8	9859	Spring		1	Spring Wire
9	75276	Roller		1	X1315
10	G-3952 4616-2	Pin		1	X1315
11	9861-1	Lever	CS	1	
12		Capscrew		1	3/8-16x1
13	9862-2	Link	CI	1	
14	113-2	Pin		2	SAE X-1315
15		Washer	St	4	3/8 SAE
16		Cotter Pin	St	4	3/32 X 5/8
17					
18					
19		Capscrew		3	3/8-16 x 1 1/2
20		Capscrew		1	3/8-16x 2
21	92441-1	Guard, manzel oiler	CI	1	
22		Capscrew		2	1/2-13 x 3/4

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

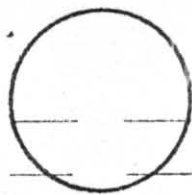
3-2

Date Issued: 6-24-42
 Retyped: 11-30-48

ASSEMBLY NO. Q-20-J
 SHEET NO. 1

ENGINE MODEL Q

2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. _____
 8 CYL. 1 _____



ASSY NAME: Water Manifold
 (Supercharged 8 Cyl. Air-Cooled
 Exh. Manif.)

FIRST USED ON: 42003-22

ASSY DWGS: _____

It.	Part No.	Part Name	Matl	Qty	Remarks
1	92345-1	Water Manifold Manifold		1	5 ID x 5 1/2 OD x 18 3/4
2		Half-coupling, 1-1/2"		1	5 ID x 5 1/2 OD x 4
3	92345-2	Inlet Pipe		1	
4		1" Half coupling		1	
5	92346-1	Connector	CS	8	PRE
6		3/4" Half Coupling	St	3	WELDED ASSY 92818
7	91802-1	End Flange	CS	3	
8		Plug, Pipe, Male 1"		1	
9	93374-1	Gasket, block		8	1/16 Rubber
10		Capscrew		32	5/8-11 x 1-3/4
11	91829-1	Blind Flange	CS	1	
12	93375-1	Gasket, manifold		1	
13		Bolt		8	5/8-11 x 2
14		Nut, hex.		8	5/8-11
15		Pipe, Plug		2	3/8 Black
16	92128-1	Header	CI	4	
17	93117-1	Gasket		4	
18		Bolt		32	1/2-13 x 1-3/4
19		Nut, hex.		32	1/2-13
20	92163-1	Tube, water outlet	CI	8	
21	93377-1	Gasket to head		8	
22	93373-1	Gasket to header		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: 4-30-43
 Retyped: 1-9-47

ASSEMBLY NO. Q-19-E
 SHEET NO. 7

ENGINE MODEL _____
 2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. _____
 8 CYL. 1 _____

ASSY NAME: Exhaust Manifold

FIRST USED ON: 42003-22

ASSY DWGS: 92184, 92293, 92166

It.	Part No.	Part Name	Matl	Qty	Remarks
1	92276-1	Pad Body	ST	7	#16 Gauge
2	92276-2	Lug	ST	14	#13 Gauge
3	92276-3	Pipe	Blk	7	3/4 Std. x 3/4 Lg.
4		Capscrew		7	5/8-11 x 1-3/4
5		Washer		7	5/8 SAE
6	92277-1	Pad Body	ST	1	#16 Gauge
7	92276-2	Lug	ST	2	#13 Gauge
8		Capscrew		1	5/8-11 x 1-3/4
9		Washer		1	5/8 SAE
10					
11	91618-1	Gasket	Gar	8	1/16 #7508
12		Capscrew		32	1-8 x 2"
13		Washer	ST	24	1/2" SAE
14	76716-1	Washer	CRS	18	
15	76715-1	Connector		12	
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. Q-19-E
SHEET NO. 6

ENGINE MODEL _____
 2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. _____
 8 CYL. 1 _____

ASSY NAME: Exhaust Manifold
~~R.H. 8 Cyl. Supercharged, End Out-let with Hood Air Cooled~~

FIRST USED ON: 42003-22

ASSY DWGS: 92184, 92293, 92166

It.	Part No.	Part Name	Matl	Qty	Remarks
1	92197-6	Tube #16 Gauge, sheet st.	St	1	Pre-Assy. 93693 (cont.)
2	76706-1	Nut, special	CRS	3	
3	92198-1	Cover body #16 Gauge	St	1	sheet st. Pre-Assy. 93694 Cover, Rear, Lower Elb. 7 & 8
4	92198-2	Strip 1/8x2x63-1/2 lg.	St	1	
5	92198-3	Pipe 1" Std 2-5/16 lg.	Blk	7	
6	92198-4	Pipe 1" Std 2-15/16 lg.	Blk	3	
7	76706-1	Nut, special	CRS	4	
8		Capscrew 1/2-13 x 2		1	
9		Nut, hex, jam 1/2-13		1	
10	92199-1	Cover, end	St	1	
11		Capscrew		10	3/8-16 x 5/8 long
12	92164-1	Hood for 1,2,3,6,7,& 8 El ^{bow}	St	6	#16 Gauge
13	92164-2	Strip	St	6	1 1/2 x 1/8 x 32" lg. each
14	92164-3	Pipe	Blk	6	2" Std x 1-1/8" lg.
15		Capscrew		36	3/8-16 x 5/8" lg.
16	92165-1	Hood for 4 & 5 elbows	St	2	#16 Gauge
17	92165-2	Strip	St	2	1 1/2 x 1/8 x 44 lg. each
18	92165-3	Pipe	Blk	2	2" std x 1-1/8
19		Capscrew		16	3/8-16 x 5/8
20		Capscrew		25	1/2-13 x 3-1/2
21		Capscrew		17	1/2-13 x 1-1/2
22		Capscrew		70	3/8-16 x 5/8

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

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

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NEXT PAGE

ENGINE MODEL _____
 2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. _____
 8 CYL. 1 _____

ASSY NAME: Exhaust Manifold
~~R.H. 8 Cyl. Supercharged, End Out-~~
~~let with Hood Air Cooled~~

FIRST USED ON: 42003-22

ASSY DWGS: 92184, 92293, 92166

It.	Part No.	Part Name	Matl	Qty	Remarks
1	92195-3	Pipe 1" Std 2-5/16	Blk	6	Pre-Assy. 93690 Cover, Rear, Upper Elb. 4, 5 & 6 (cont.)
2	92195-4	Strip 3/8x1 1/2 x 110 lg	St	1	
3	76706-1	Nut, special	CRS	2	
4	92196-1	Cover Body # 16 Gauge	St	1	Sheet St.
5	92196-2	Strip 1/8x2x71-7/8 lg.	St	1	
6	92196-3	Pipe 1" Std 2-5/16 lg.	Blk	4	Pre-Assy. 93691 Cover, Rear, Lower Elb. 4, 5 & 6
7	92196-4	Pipe. 1" Std 2-15/16 lg.	Blk	5	
8	76706-1	Nut, special	CRS	2	
9		Capscrew 1/2-13 x 2		2	
10		Nut, hex, jam 1/2-13		2	
11	92192-1	Cover Body #16 Gauge	St	1	Sheet st.
12	92192-2	Strip 3/8x1 1/2x63-3/8 lg.	St	2	
13	92192-3	Pipe 1" Std 2-5/16 lg.	Blk	5	Pre-Assy. 93692 Cover, Front Elbows 7 & 8
14	92192-4	Pipe 1" Std 2-15/16 lg.	Blk	4	
15	76706-1	Nut, special	CRS	1	
16		Capscrew 1/2-13x2		1	
17		Nut, hex, jam 1/2-13		1	
18	92197-1	Cover, body #16 Gauge	St	1	sheet st.
19	92197-2	Strip 1/8x2x63-1/2 lg	St	1	
20	92197-3	Pipe 1" Std 2-5/16 lg.	Blk	5	Pre-Assy. 93693 Cover, Rear, Upper Elb. 7 & 8 (cont.)
21	92197-4	Flange 1/8 x 10 dia.	St	1	
22	92197-5	Strip 3/8x1 1/2 x 58 lg.	St	1	

CI = Cast Iron
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 FS = Forged Steel

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

CONTINUED
 NEXT PAGE

ENGINE MODEL _____
 2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. _____
 8 CYL. 1 _____

ASSY NAME: Exhaust Manifold
~~R.H. 8 Cyl. Supercharged, End Out~~
~~let with Hood Air Cooled~~

FIRST USED ON: 42003-22

ASSY DWGS: 92184, 92293, 92166

It.	Part No.	Part Name	Matl	Qty	Remarks
1	92193-4	Pipe 1" Std 2-5/16 lg.	Blk	3	
2	92193-5	Strip 3/8 x 1 1/2 x 87 lg.	St	1	Pre-Assy. 93687 Cover, Rear, Upper Elb. 1, 2 & 3 (cont.)
3	76706-1	Nut, special	CRS	2	
4		Nut, Hex. std 3/8-16		2	
5	92194-1	Cover body #16 Gauge	St	1	
6	92194-2	Strip 1/8 x 2 x 71	St	1	
7	92194-3	Pipe 1" Std 2 long	Blk	1	
8	92194-4	Pipe 1" Std 2-5/16 lg.	Blk	5	
9	92194-5	Pipe 1" Std 2-15/16 lg.	Blk	4	Pre-Assy. 93688 Cover, Rear, Lower Elb. 1, 2 & 3
10	76706-1	Nut, special	CRS	3	
11		Nut, hex. 3/8-16		3	
12		Capscrew 1/2-13 x 2		1	
13		Nut, hex. jam 1/2-13		1	
14	92191-1	Cover body #16 Gauge	St	1	Sheet st.
15	92191-2	Strip 3/8 x 1 1/2 x 71-3/4 lg.	St	2	
16	92191-3	Pipe 1" Std 2-5/16 lg.	Blk	4	
17	92191-4	Pipe 1" Std 2-15/16 lg.	Blk	5	Pre-Assy. 93689 Cover, Front, Elbows 4, 5 & 6
18	76706-1	Nut, special	CRS	2	
19		Capscrew 1/2-13 x 2		2	
20		Nut, hex. jam 1/2-13		2	
21	92195-1	Cover Body #16 Gauge sheet	st. St	1	Pre-Assy. 93690 (cont. next page)
22	92195-2	Strip 1/8 x 2 x 71-7/8 lg.	St	1	

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 FS = Forged Steel

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

CONTINUED
 NEXT PAGE

ENGINE MODEL _____
 2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. _____
 8 CYL. 1 _____

ASSY NAME: Exhaust Manifold
~~R.H. 8 Cyl. Supercharged, End Out~~
~~let with Hood Air Cooled~~

FIRST USED ON: 42003-22

ASSY DWGS: 92184, 92166

It.	Part No.	Part Name	Matl	Qty	Remarks	
1	76706-1	Nut	CRS	2	Elbow Complete #8 Cyl. (cont'd.)	
2		Tubing 5 ID 1/8 Wall 12-1/8 lg	St			
3		Tubing 5 ID 1/8 Wall 154-3/8 lg	St		Pre-Assy. 92137 Exhaust Pipe Cyl. 1 x 8	
4	76237-1	End Expans. Piece	CS	2		
5	92126-1	Elbow	CS	1		
6	76147-1	Pyrometer Connection	CRS	1		
7	B-3890	Ring, Expansion	CI	24	Hastings-Comp. Ring, Type 203 1/4 x 1/4 x 6 Dia.	
8						
9						
10	92820	Pre-Assy., Exhaust Manifold	R.H	1	Consisting of:	
11	92190	Cover, front, elbows 1, 2 & 3		1	Pre-Assy. 93686 Exhaust Manifold Hood	
12	92190-1	Cover, body #16 Gauge	St	1		sheet st.
13	92190-2	Strip, lower 3/8x1 1/2x70-7/8 lg	St	1		
14	92190-3	Strip, upper 3/8x1 1/2x72 lg	St	1		
15	92190-4	Pipe 1" Std. 2-5/16 lg	Blk	3		
16	92190-5	Pipe 1" Std. 2-15/16 lg	Blk	5		
17		Capscrew		1		1/2-13 x 2
18		Nut, Hex. jam		1		1/2-13
19		Nut, Hex. std.		5		3/8-16
20	92193-1	Cover body #16 Gauge	St	1		sheet st.
21	92193-2	Strip 1/8x2x72 long	St	1		Pre-Assy. 93687 (cont. next page)
22	92193-3	Pipe 1" Std 2 long	Blk	1		

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 FS = Forged Steel CBrz = Cast Bronze

CONTINUED
NEXT PAGE

ENGINE MODEL _____
 2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. _____
 8 CYL. 1 _____

ASSY NAME: Exhaust Manifold
~~R.H. 8 Cyl. Supercharged, End Out-~~
~~let with Hood Air Cooled~~

FIRST USED ON: 42003-22

ASSY DWGS: 92184, 92166

It.	Part No.	Part Name	Matl	Qty	Remarks
1	76714-2	Plate 2 x 6-3/4 x 3/32	St	2	Pre-Assy. 92284- Elbow, Complete #5 Cyl.
2	76706-1	Nut	CRS	3	
3		Tubing 5 I.D. 1/8 Wall x 10-3/8	St	1	Pre-Assy. 92140- Exhaust Pipe Cyl. 4 x 5
4		Tubing 5 I.D. 1/8 Wall x 8-1/8	St	1	
5	76237-1	End Expans. Pierce	CS	2	
6	92123-1	Elbow	CS	1	
7	76147-1	Pyrometer Connection	CRS	1	
8	76712-2	Plate 4 x 6-3/4 x 3/32	St	2	Pre-Assy. 92285- Elbow, Complete #6 Cyl.
9	76706-1	Nut	CRS	4	
10		Tubing 5 I.D. 1/8 Wall 58-3/8 lg	St	1	Pre-Assy. 92139- Exhaust Pipe Cyl. 3 x 6
11		Tubing 5 I.D. 1/8 Wall 60-1/8 lg	St	1	
12	76237-1	End Expans. Piece	CS	2	
13	92124-1	Elbow	CS	1	
14	76147-1	Pyrometer Connection	CRS	1	
15	76714-2	Plate 2 x 6-3/4 x 3/32	St	2	Pre-Assy. 92286- Elbow, Complete #7 Cyl.
16	76706-1	Nut	CRS	2	
17		Tubing 5 I.D. 1/8 Wall 36-1/8 lg	St		Pre-Assy. 92138- Exhaust Pipe Cyl. 2 & 7
18		Tubing 5 I.D. 1/8 Wall 106-3/8 lg	St		
19	76237-1	End Expans. Piece	CS	2	
20	92125-1	Elbow	CS	1	
21	76147-1	Pyrometer Connection	CRS	1	
22	76714-2	Plate 2 x 6-3/4 x 3/32	St	2	Pre-Assy. 92287- (cont. next page)

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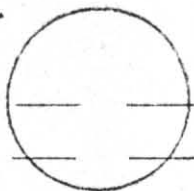
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Date Issued: 6-19-42
 Retyped: 2-24-49

ASSEMBLY NO. Q-19-E
 SHEET NO. 1

ENGINE MODEL _____

2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. _____
 8 CYL. 1 _____



ASSY NAME: Exhaust Manifold,
RH 8 Cyl. Supercharged, End Outlet
with Hood Air Cooled

FIRST USED ON: 42003-22

ASSY DWGS: 92184, 92166

It.	Part No.	Part Name	Matl	Qty	Remarks	
1						
2	92821	Pre-Assy., Exhaust Manifold		1	Consisting of:	
3	76707-2	Plate 2 x 6-3/8 x 3/32	St	2	Pre-Assy. 92280 Elbow Complete #1 Cyl.	
4	76706-1	Nut	CRS	2		
5	92119-1	Elbow	CS	1		
6	76147-1	Pyrometer Connect.	CRS	1		
7	76708-2	Plate 4 x 6 x 3/32	St	1		
8	76708-3	Plate 4 x 3-1/2 x 3/32	St	1		
9	76708-4	Plate 2 x 3-1/2 x 3/32	St	1		
10	76708-5	Plate 2 x 3-1/2 x 3/32	St	1		Pre-Assy. 92281 Elbow, Complete #2 Cyl.
11	76706-1	Nut	CRS	3		
12	92120-1	Elbow	CS	1		
13	76147-1	Pyrometer Connection	CRS	1		
14	76708-3	Plate 4 x 3-1/2 x 3/32	St	2		
15	76708-5	Plate 2 x 3-1/2 x 3/32	St	2		
16	76706-1	Nut	CRS	4		Pre-Assy. 92282 Elbow, Complete #3 Cyl.
17	92121-1	Elbow	CS	1		
18	76147-1	Pyrometer Connection	CRS	1		
19	76707-2	Plate 2 x 6-3/8 x 3/32	St	2		
20	76706-1	Nut	CRS	2		Pre-Assy. 92283 Elbow, Complete #4 Cyl.
21	92122-1	Elbow	CS	1		
22	76147-1	Pyrometer Connection	CRS	1		

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 FS = Forged Steel

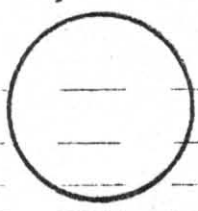
CRS = Cold Rolled Steel
 CBr = Cast Brass
 CBrz = Cast Bronze

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Date Issued: 3-18-43
 Retyped: 11-29-48

ASSEMBLY NO. Q-18-Q
 SHEET NO. _____

ENGINE MODEL Q
 2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. _____
 8 CYL. 1



ASSY NAME: Intake Manifold
8 Cyl. Supercharged, CI

FIRST USED ON: 42003-22

Group
 ASSY DWGS: 93442

It.	Part No.	Part Name	Matl	Qty	Remarks
1	92663-1	Cover, Intake Manifold	CI	2	
2	93393-1	Gasket		2	Gar. #660-3/32 thick
3		Capscrew		20	1/2-13 x 1-1/4
4					
5	9968-1	Cover, Intake Manifold	CI	5	
6	93394-1	Gasket		5	Gar. #660 - 3/32 thick
7		Capscrew		30	1/2-13 x 1-1/4
8					
9	9884-1	Ell, Manif-Head	CI	8	
10	93356-1	Gasket, Ell-Cyl-Block		8	Gar. #660 1/16 thick
11	93355-1	Gasket, Ell-Cyl-Head		8	Gar. #660 1/16 thick
12		Capscrew, Ells		64	5/8-11 x 1-3/4
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: 12-21-48

ASSEMBLY NO. Q-17-T
SHEET NO. 3

ENGINE MODEL Q

ASSY NAME: Tappet & Guide

2 CYL. _____
3 CYL. _____
4 CYL. _____
5 CYL. _____
6 CYL. 6 _____
8 CYL. 8 _____



FIRST USED ON: 42221

ASSY DWGS: _____

It.	Part No.	Part Name	Matl	Qty	Remarks
1	92648	Pre-Assy., Fuel Pump Base		1	Consisting of:
2	91647-1	Base, Fuel Pump -	CI	1	
3	91646-1	Insert	CI	1	
4	B-3063	Ring, Piston		2	AH 3 1/2 OD x 1/8 Wide
5	B-3064	Ring, Piston		2	AH 4 1/2 OD x 1/8 Wide
6	91648-1	Adapter -	CI	1	
7	93350-1	Gasket, Adapter-Base -		1	Vel
8		Oil Seal -		1	Natl. #50163, St Hsg.
9	612	Stud -	St	2	
10	91650-1	Ring, Fuel Tappet	CS	1	
11		Ell	Imp	2	49F 1/4T 1/8P
12		Nut	Imp	2	41FS 1/4T
13					
14					
15		Capscrew, Allen		4	5/8 - 11 x 5
16		Nut		2	3/4 - 10
17	93350-1	Gasket, Base-Block		1	Vel.
18					
19					
20					
21					
22					

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

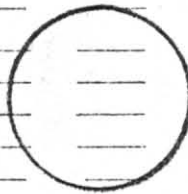
Date Issued: 12-21-48

ASSEMBLY NO. Q-17-T
SHEET NO. 2

ENGINE MODEL Q

ASSY NAME: Tappet & Guide

2 CYL. _____
3 CYL. _____
4 CYL. _____
5 CYL. _____
6 CYL. 6 _____
8 CYL. 8 _____



FIRST USED ON: 42221

ASSY DWGS: _____

It.	Part No.	Part Name	Matl	Qty	Remarks
1					
2		Capscrew		4	3/4 - 10 x 2
3		Lockwasher		4	3/4
4	107-2	Dowel		2	1/2 x 7/8
5					
6	94677 92647	Pre-Assy., Fuel Tappet		1	Consisting of:
7	91652-1	Guide	CI	1	Use Patt. 9835
8	91654-1	Plug, Adjusting		1	
9	91653-1	Tappet		1	
10	94713-1	Pin, Roller		1	
11	94712-1	Roller	Pre-Assy 94785	1	For replacement see Q-17-W
12	94700-1	Brg., Roller	Pre-Assy 94783*	1	
13	7797	Dowel	CRS	2	
14	91655-1	Locknut. -		1	
15					
16		* FOR REPL. USE PRE-ASSY. 95505			See Q-17-W
17					
18		Capscrew		4	3/4 - 10 x 1-3/4
19		Lockwasher		4	3/4
20	107-2	Dowel	CRS	2	
21					
22					

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

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

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Date Issued: 12-21-48

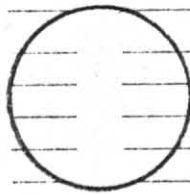
ASSEMBLY NO. Q-17-T
SHEET NO. 1

ENGINE MODEL Q
 2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. 6
 8 CYL. 8

ASSY NAME: Tappet & Guide
 Field Replacement for Eng 42221;
 Same as Q-17-G w/94407 Tappet Assy.

FIRST USED ON: 42221

ASSY DWGS: _____



It.	Part No.	Part Name	Matl	Qty	Remarks
1					
2	95407	Pre-Assy., Int. & Exh. Tappet.		1	Consisting of:
3	9820	Guide Cluster Setscrew, Allen	CI	1	
4					
5	9821	Liner, Int. & Exh.	Brz	2	
6	7797	Dowel	CRS	2	
7					
8	94407	Pre-Assy., Tappet & Pin		(2)	EACH Consisting of:
9	93474-1	Tappet, Int. & Exh.		1	
10	93475-1 97793	Roller } Pre-Assy 93558	See Dwg	1	NSS
11	96563 10640-70				
12	93476-1	Pin	See Dwg	1	
13					
14	9323	Tappet, Air Start	St	1	
15	9828	Spring, Air St. Tappet	St	1	
16	9829	Spring Retainer	CRS	1	
17	9830	Snap Ring	St	1	
18	9896	Roller } Pre-Assy 94894	See Dwg	1	Assy. 94408
19	9897	Roller Pin	See Dwg	1	
20	9823	Tappet, Air Starting Plug, Pipe	St	1	4 Male, 1/8" Blk
21		Ell, 90°		1	69F 1/4T 1/8P
22					

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

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

CONTINUED
NEXT PAGE

ENGINE MODEL DQ

2 CYL. _____
3 CYL. _____
4 CYL. _____
5 CYL. _____
6 CYL. 6 _____
8 CYL. 8 _____



ASSY NAME: Rocker & Push Rod

FIRST USED ON: 44172

ASSY DWGS: _____

It.	Part No.	Part Name	Matl	Qty	Remarks
1		Nipples		1	1/8 x 3 Blk
2		Nut Ell, Street	Imp	1	Imp 41F 1/4T #50F 1/8P x 1/4T
3					
4					
5	93556	Pre-Assy. Int. & Exh. Push Rod		2	Assy. Dwg. 93556 EACH Consisting of:
6	97049	Top, Push Rod		1	SAE X-1315
7	97050	Bottom, Push Rod		1	See Dwg. } Weld Together
8	93475-1	Tube, Push Rod		1	See Dwg. } 45 5/8" O.A.
9					
10					
11	92644	Pre-Assy., Air Push Rod		1	Assy. Dwg. 92644 Consisting of:
12	97072	Tube, Push Rod		1	See Dwg. } Weld Together
13	97049	Top, Push Rod		1	SAE X-1315
14	9913	Bottom, Push Rod		1	See Dwg. }
15					
16					
17	164	Nut, Rocker Shaft	See Dwg.	2	
18		Lockwasher		2	7/8
19					
20					
21					
22					

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

Installation Dwg: 93024
 Piping Diagrams: 92004

INDEX SHEET 1
 ENGINEERING SPECIFICATIONS

ENGINE DMQ-38 43137

HP 1200 RPM 275

CUSTOMER Quartermaster Corps

CUSTOMER'S ORDER W-1311-gm-342

INSPECTION ABS

OUR ORDER 25-1

DATE SHIPPED _____

No.	Assembly Name	Qty.	Remarks
Q 1 G	Base	1	
Q 2 D	Front Main Bearings	1	
3	Center Main Bearings		
Q 4 D	Intermediate Main Bearings	7	
Q 5 H	Rear Main Bearings	1	
Q 6 H	Crankshaft	1	
Q 7 C	Flywheel	1	
Q 8 U	Cylinder Block & Special Covers	1	Special Drilling 92326
Q 9 Q	Standard Covers, Cylinder Block	1	
Q 10 B	Cylinder Liners	8	
Q 11 M	Pistons & Pin	8	average wt. 384.6 lbs.
Q 12 T	Connecting Rod & Bearings	8	
Q 13 F	Cylinder Head	8	
Q 14 C	Valve	8	
Q 15 B	Safety Valve	8	
Q 16 H	Rocker & Push Rods	8	
Q 17 T	Tappet & Guide	8	
Q 18 Q	Intake Manifold	1	
Q 19 E	Exhaust Manifold & Ells	1	
Q 20 J	Water Manifold	1	
Q 21 C	Starting Air Manifold	1	
Q 22 B	Front Camshaft Bearings	1	

Part of order 43136-43145

Part of order 43136-43145

No.	Assembly Name	Qty.	Remarks
48	Reverse Gear Control		
Q 49 D	Oiler Lines & Fittings	1	
Q 50 L	Fuel Oil Header & Fittings	1	
Q 51 H	Strainer & Fittings	1	
² Q 52 QQ ₁	External Lube Lines	1	See Assy. #93127
53	Ignition Equipment		
54	Fuel Pump & Oiler Drive		
G 55 V	Operating Control	1	Counterclockwise
56	Magneto Drive		
G 57 L 57	Exhaust Exhaust	1	
58	Lube Oil Tank, Attached		
Q 59 K	Circulating Water Fittings	1	
60	Eccentric Shaft		
61	Reverse Sector		
62	Camshaft Shifter		
63	Handwheel & Interlocking		
64	Air Control Valve		
65	Fuel Shutoff & Indicator		
66	Generator & Comp. Drive		
67	Generator & Mount		
68	Idling Control		
G 69 FFF	Lube Filter, Scav. Line	1	
G 69 DDD	Lube Filter, Pres. Line	1	
G 70 S	Fuel Filter	1	
Q 71 C	Revolution Counter	1	
Q 72 J	Supercharger	1	Serial 1164; B-3546 ✓
73	Jacket Water Outlet		
Q 74 A	Fuel Tank Bracket	1	
99	Shop Tests		Use Test Schedule _____

INDEX SHEET 2
ENGINEERING SPECIFICATIONS

ENGINE DMQ-38 43137

CUSTOMER Quartermaster Corps

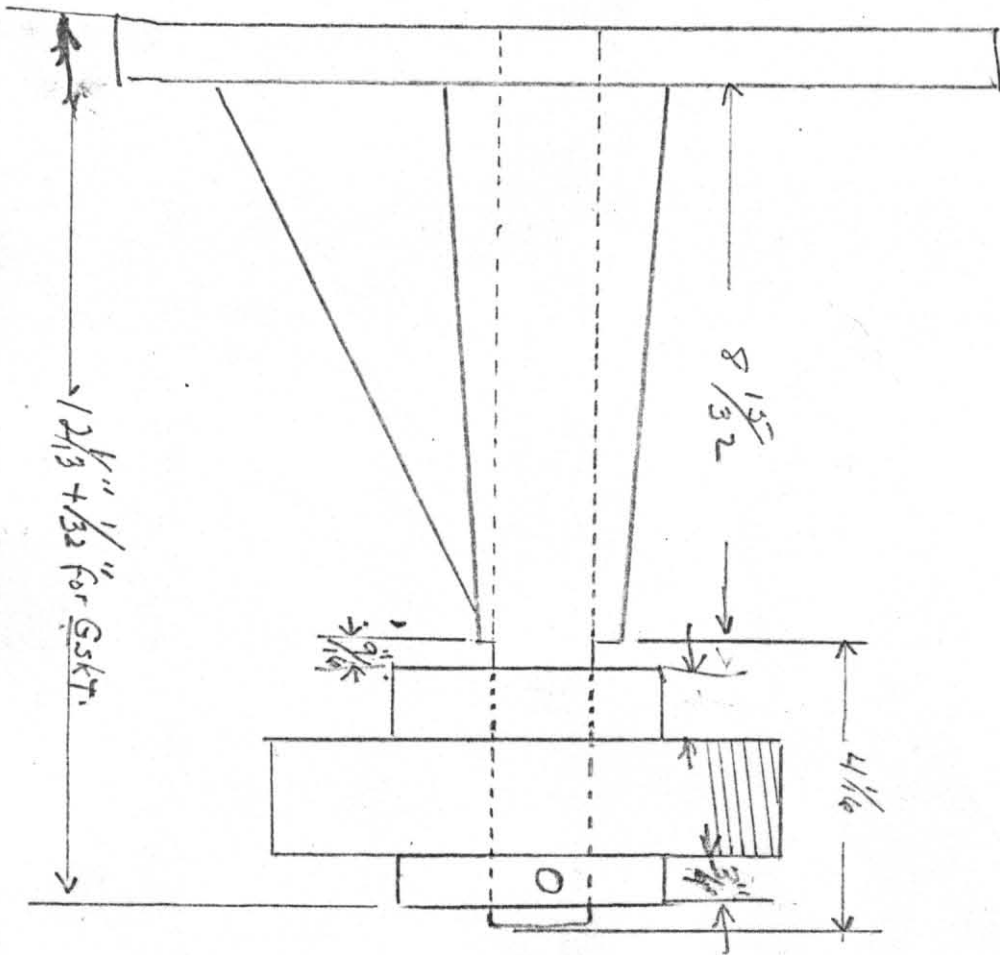
HP 1200

RPM 275

Part of order 43136-43145

No.	Assembly Name	Qty.	Remarks
Q 23B	Intermediate Camshaft Bearing	8	
Q 24J	Cams & Shaft	1	
Q 25L	Gear Case	1	
Q 26G	Gear Set	1	Use assy dwg 93076
Q 27 R	Governor & Tackometer Drive	1	
Q 28 M	Air Starter Linkage	1	
Q 29 M	Reverse Control	1	
Q230YY	Governor	1	
Q 31 BB	Governor Control	1	
Q 32 EEE	Fuel Pump Control	1	
Q 32 AL	Manual Fuel Control	1	
33	Main Air Compressor		
G34 DD	Water Pump, Fresh Water	1	Use pre-assy 76834-22
Q 34 CC	Water Pump, Sea Water	1	
35	Water Pump Valve		
Q 36 F	Fuel Transfer Pump	1	
Q 37 LL	Lube Oil Pump	1	W/95724 Adapter, 95726 Gasket
Q 38 D	Force Feed Oiler	1	
Q 39 L	Lubrication Fittings	1	
Q 40 G	Fuel Injection	8	
Q 41 D	Thrust Bearing	1	
42	Base Extension		
43	Reverse Gear		
44	Sailing Clutch		
45	Winch Clutch		
46	Cam Gear Cover		
Q 47 D	Thrust Shaft	1	

9" Enterprise Lube Pump
"Nose" Assy Dimen. old style.
Barbore loss only



1048
1230

ENTERPRISE

USE OF ENGINE PARTS MANUAL (Page 3)

HOW TO ORDER PARTS

BASIC REQUIRED INFORMATION

1. MODEL of Engine.
2. SERIAL NUMBER of Engine.
3. NAME of PURCHASER (or vessel name).
4. EXACT Shipping Instructions:
Parts will be shipped COD, or Sightdraft against bill of lading if by freight,
unless other terms have been previously established.
All shipments of parts are f.o.b. factory, San Francisco, California.
Transportation charges are extra.
5. EXACT QUANTITY of each part required.
6. PART NUMBER and PART NAME, as listed in manual.

CONFIRM ALL TELEPHONE OR TELEGRAPH ORDERS IN WRITING.

If there is any question as to a part needing replacement, send in defective part, prepaid.

INSTRUCTION MANUALS can be compiled and furnished for individual engines at \$5.50 per copy.

PARTS MANUALS are available at \$4.50 per copy.

It is not the policy of this company to furnish detailed drawings of engine component parts.

ENTERPRISE

USE OF ENGINE PARTS MANUAL (Page 2)

SECOND EXAMPLE

What and where is the *part number* of the link between the fuel control shaft and the injection pump.

1. Read the engine specification sheets thru until you come to the description that best suits the general group you want.
2. You find "Fuel Control Linkage".
3. On the parts list for Fuel Control Linkage you will find "Link, Fuel Pump."

THIRD EXAMPLE

The lube oil filter elements require replacement. What is the *part number* of the element.

1. The engine specification sheets list several lube oil filters and strainers as either "on" or "off engine." Choose the correct description.
2. The parts list code column on the specifications may list either a LETTER - NUMBER - LETTER code or a LETTER B - 4 digit number.
3. Turn to page in parts book bearing the referenced number. On this page you will find a description of the filter and the replacement element part number.

NOTES

1. The parts lists contained in the parts manual may be on one or more forms. In each case, use only the parts list of the proper code. Disregard all other lists which may appear on the same page.
2. Some parts lists are further coded at the top of the page or columns with O's and X's. These markings are significant only to the factory.
3. Certain parts lists contain groups of parts usually handled as complete assemblies, such as pumps, headers, rods and so forth. These assemblies are set apart on the parts lists by means of brackets which include the required parts. Wherever possible, order by assembly numbers.
4. Certain parts within assemblies are of such a nature that they must be sold as assemblies, such as gears, idler and drive; roller and bushing, etc. These parts are marked NSS (Not Sold Separately) and MUST be ordered as assemblies.
5. Filters, turbochargers and other auxiliary parts manufactured by others are given the letter B - 4 digit number. When ordering component parts for these items, give the identifying B - number and a full description of the material required. The instruction Manual contains descriptive literature in most cases.
6. Parts lists marked "For Complete Replacement Use ____" refer only to the entire unit. For individual parts replacement, continue to use the parts list noted in Engine Specifications.
7. When parts list is marked "Replaced by", note 6 also applies.

FOR FURTHER INFORMATION, CONSULT FACTORY

ENTERPRISE

USE OF ENGINE PARTS MANUAL

General:

A general catalog of all models and their parts is not published because of the Custom features of the ENTERPRISE line. Each engine, depending upon its application, has individual engine specifications and the parts manuals are compiled separately.

Engine Specification Sheets:

The engine specification sheets – the first three to five pages in the parts manual – are an index to the parts lists used in the engine assembly. The specifications contain the following information:

1. Engine type and model.
2. Engine serial number.
3. Names and numbers of the correct parts lists which in turn list the individual parts.

Parts Lists

The parts lists are made up of those parts which form a reasonable assembly group. Each list is numbered using a LETTER – NUMBER – LETTER coding. Each list is named with as comprehensive a description as is possible.

How to find a part number if only part name or description is known:

1. Check thru engine specification sheets until you find a description which covers the part you need, or check D-2204-A attached.
2. Using the parts list number (the Letter – Number – Letter code) which is listed in the specification, turn to the corresponding parts list in the part manual.
3. Check the part names on the parts list until you find the part you are looking for.

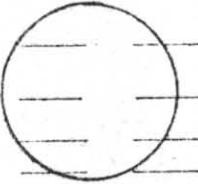
FIRST EXAMPLE

You want to find the *part number* of the sealing ring used with the cylinder liner:

1. As it is the ENTERPRISE rule to list attaching (or sealing) parts on the same list as the part attached (or sealed) look for cylinder liners in the engine specifications.
2. On the first page of the specifications you will find
"Cylinder Block and Liners" or
"Cylinder Liners"
3. The LETTER – NUMBER – LETTER code is in the column to the left of the description.
4. Turning to the parts list of the proper number you will find the sealing ring.
(For the model G engine number 7026; for the model Q engine 9131.)

ENGINE MODEL Q

2 CYL. _____
3 CYL. _____
4 CYL. _____
5 CYL. _____
6 CYL. 1 _____
8 CYL. _____



ASSY NAME: Gear Set
Marine & Stationary, Water Pump Speed-
up, (4.75 x Eng RPM) 325 Eng. RPM & Below
Crank Gear w/o Hub
FIRST USED ON: _____

ASSY DWGS: _____

It.	Part No.	Part Name	Matl	Qty	Remarks
1	9209	Gear Crankshaft		1	Forge 3145
2	93806-1*	Gear, Crank to Pump	St	1	
3	93809-1	Capscrew, Gear to Crank Case	St	8	
4		Wire, Capscrew, Safety	St	1	3/32 x 40" Long
5					
6	92628	Pre-Assy. Idler Gear		1	Consisting of:
7	9211	Gear, Idler Ring		1	Forge 1030 <i>E-29930 1207</i>
8	9210	Hub, Idler Gear	Pre-Assy. CI	1	
9	9212	Bushing, " "	92877	2	SAE Ph. Brz #64
10	9167	Bolt, Hub-Ring		6	SAE 1020
11		Nut, Slotted		6	5/8-11
12		Washer		6	5/8
13		Pin, Cotter		6	1/8 x 1-3/4
14					
15	**	For Replacement of 95574 Stub Use Group 96920			
16	95574**	Stub, Idler Gear	FS	1	Mtl. changed 6-22-49
17	95625	Washer, Thrust	CRS	1	
18	95624	Shim, Thrust Washer	Br	14	.003
19	9214	Lock		1	1/16 Sheet Steel
20	607	Stud, Stub-Block		5	SAE 1120
21		Nut, Castle		5	3/4-10
22		Pin, Cotter		5	1/8 x 1 1/2

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

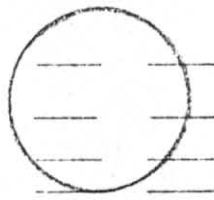
CRS = Cold Rolled Steel
CBr = Cast Brass
CBrz = Cast Bronze

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Date Issued: 6-24-42
 Retyped: 4-21-49

ASSEMBLY NO. Q-25-L
 SHEET NO. _____

ENGINE MODEL Q
 2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. 1
 8 CYL. 1



ASSY NAME: Gear Case
Reversible

FIRST USED ON: 42003-22

ASSY DWGS: 93106

It.	Part No.	Part Name	Matl	Qty	Remarks
1	*	Gear Case	CI	1	
2	93438-1	Gasket, Case-Block-Manif. ^{side}	Vel	1	} Gasket group 99794
3	93438-2	Gasket, Case-Block-Bottom	Vel	1	
4	93438-3	Gasket, Case-Block-Top	Vel	1	
5	93438-4	Gasket, Case-Block-Camsh. ^{side}	Vel	1	
6		Capscrews		21	5/8-11 x 1-1/2
7	91250-1	Cover, Inspection	CI	3	
8	93384-1	Gasket, Inspection Cover	Vel	3	1/32 Vel
9		Capscrews		18	1/2-13 x 1-1/4
10	91120-1	Cover, crankshaft	CI	1	
11	93382-1	Gasket, crankshaft cover	Vel	1	1/32
12		Capscrews		6	1/2-13 x 1-1/4
13	6294-A	Cover, crankshaft cap.	CI	1	
14	78996-1	Gasket	Vel	1	1/32
15		Capscrew		2	1/4-20 x 5/8
16		Lockwasher		2	1/4
17	107-1	Dowel		2	
18					
19					
20		*Revised to become a duplicate of 93535-1 Case,			
21		as on Q-25-M			
22					

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

Date Issued: 11-12-42
Retyped: 10-26-49ASSEMBLY NO. Q-24-J
SHEET NO. 2ENGINE MODEL Q
2 CYL. _____
3 CYL. _____
4 CYL. _____
5 CYL. _____
6 CYL. _____
8 CYL. 1 _____ASSY NAME: Cams & ShaftFIRST USED ON: 42003-22ASSY DWGS: 91150

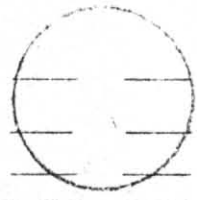
It.	Part No.	Part Name	Matl	Qty	Remarks
1	92503	Pre-Assy. Camshaft		1	Consisting of:
2	91119-1	Camshaft		1	Cumberland Grd. Shafting
3	93859-1	Key, Cam to Shaft	Drill Rod	8	
4	93860-1	Key, Hub to Shaft	Drill Rod	1	
5	97738 91622-1	Cam, Intake (M-91605-2)		8	SAE 2315 (Use Forg. 91604)
6	97737 91623-1	Cam, Exhaust (M-91605-1)		8	SAE 2315 (Use Forg. 91604)
7	91148-1*	Cam, Fuel (M-9837) (96204)		8	SAE 2315 (Use Forg. 92094)
8	91149-1	Cam, Air (M-9839)		8	SAE 2315
9	9860	Cam, Oiler Drive		1	X-1020
10	101-3	Setscrew, Cam to Shaft		41	
11		Key Woodruff		1	1-1/2 x 3/8
12		Setscrew, Cam to Shaft		24	1/2-13 x 3/8
13	9873	Washer	CRS	1	
14	151	Nut		1	Union C.D. Hymo
15		Cotter Pin	St	1	5/16 x 4-1/2
16					
17					
18		* For replacement of complete set of fuel cams, use 92466 hi-speed cam, for individual replacement use 91148 low-speed cam.			
19					
20					
21					
22					

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

Edition 3/4 FOR COMPLETE REPLACEMENT USE Q-24-PP
 Date Issued: 11-12-42 * For cam replacement see sh. 2.
 Retyped: 10-26-49

ASSEMBLY NO. Q-24-J
 SHEET NO. 1

ENGINE MODEL Q
 2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. _____
 8 CYL. 1



ASSY NAME: Cams & Shaft
 8 Cyl, Reversible Supercharged,
 Air Starting, 330 RPM or under

FIRST USED ON: 42003-22

ASSY DWGS: 91150

It.	Part No.	Part Name	Matl	Qty	Remarks
1		* For replacement use 95576-1	STEEL		
2	92624 **	FOR COMPLETE REPLACEMENT use 96904 Pre-Assy. Camshaft Gear		1	Consisting of:
3	91046-1.	Gear, Camshaft Ring		1	Brinell 190-210 Chr. Moly CI
4	9167-1	Bolt		4	
5		Nut, Castle Pre-Assy. 93314		4	5/8-11
6		Washer	CRS	4	5/8 SAE
7	91045	Hub, Camshaft Gear	CS	1	
8	91069	Spacer, Thrust Plate		1	Steel Plate
9		Capscrew, Spacer		3	1/4-20 x 1-1/4
10	91067	Shim, Thrust Ring	See Dwg.	1	
11	91048	Plate, Camshaft Thrust	CBrz	1	
12	91047	Rings, Camshaft Thrust	CS	1	
13		Capscrew		6	3/4-10 x 5-1/4
14	91078	Locking Clip, Thrust Ring		6	1/16 Steel
15	91079-2	Shim, Thrust Ring	See Dwg.	1	
16					
17					
18	9167-1	Bolt		2	SAE 1020
19		Nut		2	5/8-11
20		Cotter Pin		6	1/8 x 1-3/4
21		Washer		2	5/8 SAE
22					

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

CONTINUED
NEXT PAGE

Date Issued: 2/7/40

ASSEMBLY NO. Q-23-B
SHEET NO. _____

ENGINE MODEL Q _____
 2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. 6 _____
 8 CYL. 8 _____

ASSY NAME: Intermediate Cam Brg.
 4"
 FIRST USED ON: 40001
 ASSY DWGS: 9847

It.	Part No.	Part Name	Matl	Qty	Remarks
1	96866	Cap	CS	1	
2	96877	Shell (Lower)		1	Pre-Assy Group 93112 NSS
3	96868	Shell (Upper)			
4	75303-1	Ring, Locking	CRS	2	NSS
5		Flat head Machine screw		2	10-24 x 5/8
6	9854	Stud, Cam bearing		2	Stressproof No. 2
7		Washer		2	3/4 SAE
8		Nut - slotted		2	3/4 -16
9		Cotter Pin		2	1/8 Dia x 1 1/2
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: 8/1/40

ASSEMBLY NO. Q-22-B
SHEET NO.

ENGINE MODEL Q _____
 2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. _____
 8 CYL. 1 _____

ASSY NAME: Front Cam Bearing
 4" Reversible
 FIRST USED ON: 40022
 ASSY DWGS: 9847

It.	Part No.	Part Name	Matl	Qty	Remarks
1	96865	Cap	CS	1	
2	96887	Shell (lower)		1	Pre-Assy Group 93111 NSS
3	96888	Shell (Upper)		1	
4	75303-1	Ring, Locking	CRS	2	
5		Flat head Machine Screw		2	10-24 x 5/8
6	9854	Stud, cam bearing		4	Stressproof No. 2
7		Washer		4	3/4 SAE
8		Nut - slotted		4	3/4-16
9		Cotter Pin		4	1/8 dia x 1 1/2
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: 1-15-41
 Retyped: 3-14-49

ASSEMBLY NO. Q-21-C
 SHEET NO. _____

ENGINE MODEL Q
 2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. _____
 8 CYL. 1

ASSY NAME: Starting Air Manifold
CI 8 Cyl.
Non-Reversible Only

FIRST USED ON: 41002,3,4,

ASSY DWGS: _____

It.	Part No.	Part Name	Matl	Qty	Remarks
1	9991-1	Ell, inlet	CI	1	2" pipe tap
2	9171-1	Jumper, Head-head	CI	7	
3	91586-1	Flange, Blind	St	1	1/2" steel plate
4	91657-1	Gasket		16	3/64 Johns-Man. #60
5					
6					
7					
8		Capcrew, blind flange		3	1/2-13 x 1-3/8
9		Capcrew, jumper		14	1/2-13 x 2
10		Capcrew, jumper		28	1/2-13 x 2-3/4
11		Capcrew, inlet ell		3	1/2-13 x 3-3/4
12		Pipe plug, blind flange		1	3/8" Blk
13	B-3254	Globe Valve	Br	1	3/8 IP for 250 lbs.
14		Ell, Street		1	3/8 Blk
15		Nipple, hydraulic		1	3/8 x 2 Blk
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: 6-24-48

REtyped: 12-1-48

ASSEMBLY NO. Q-20-J

SHEET NO. 2

ENGINE MODEL Q

ASSY NAME: Water Manifold

2 CYL.

3 CYL.

4 CYL.

5 CYL.

6 CYL.

8 CYL. 1

FIRST USED ON: 42003-22

ASSY DWGS:

It.	Part No.	Part Name	Matl	Qty	Remarks
1		Capscrew		32	1/2-13 x 1-1/4
2	92129-1	Cover, water outlet header	CI	1	
3	93117-1	Gasket		1	
4		Bolt		8	1/2-13 x 1-3/4
5		Nut, hex.		8	1/2-13
6	92167-1	Adapter, water outlet	CI	1	
7	92650-1	Water Manifold Flange	CI	1	
8	93375-1	Gasket		1	
9		Bolt		8	5/8-11 x 2
10		Nut, hex		8	5/8-11
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: 1-18-43

ASSEMBLY NO. Q-9-Q
SHEET NO. 4

ENGINE MODEL Q

2 CYL. _____

3 CYL. _____

4 CYL. _____

5 CYL. _____

6 CYL. _____

8 CYL. 1 _____

ASSY NAME: Standard Covers
Cylinder Block

FIRST USED ON: 42003-22

Group _____
ASSY DWGS: 93442

It.	Part No.	Part Name	Matl	Qty	Remarks
1		Capscrew		4	1/2-13 x 7/8
2					
3	108-1	Dowel, block to base		2	
4					
5					
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: 1-18-43

ASSEMBLY NO. Q-9-Q
SHEET NO. 3

ENGINE MODEL Q _____
 2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. _____
 8 CYL. 1 _____

ASSY NAME: Standard Covers
Cylinder Block

FIRST USED ON: 42003-22

Group
ASSY DWGS: 93442

It.	Part No.	Part Name	Matl	Qty	Remarks
1					
2	91134-1	Cover, cam front corner	CI	1	
3	93359-1	Gasket	Gar	1	1/16 #660
4		Capscrew		6	1/2-13 x 1-1/2
5		Capscrew		5	1/2-13 x 1-3/4
6		Nut		5	1/2-13
7					
8	92203-1	Cover, camshaft side, front	CI	1	
9		Capscrew		4	1/2-13 x 1-1/2
10					
11	93336-1	Gasket, cover block L.H.		6	1/16 #660
12	93336-2	Gasket, cover block R.H.		6	1/16 #660
13	93337-1	Gasket, cover to cover		4	1/16 #660
14	93339-1	Gasket, cover-block (End)		1	1/16 #660
15	93339-2	Gasket, cover-block L.H. (Side)		2	1/16 #660
16	93339-3	Gasket, cover-block R.H. (Side)		2	1/16 #660
17	93344-1	Gasket, block-lower half		1	1/16 #660
18	93344-2	Gasket, block-upper half		1	1/16 #660
19	93345-1	Gasket, gear case, cover		1	1/16 #660
20					
21	91965-1	Cover, cyl. block blind	CI	2	
22	93343-1	Gasket - to block		2	1/32 Vel

Gasket Set
93666

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

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

CONTINUED
NEXT PAGE

ENGINE MODEL Q
 2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. _____
 8 CYL. 1 _____

ASSY NAME: Standard Covers
Cyl. Block

FIRST USED ON: 42003-22

Group _____
ASSY DWGS: 93442

It.	Part No.	Part Name	Matl	Qty	Remarks
1	4833-3	Pipe - Breather		2	9"
2	B-3736	Breather Cap		2	Vortex 2205
3					
4	9344-1	Cover End Thru Bolt	CI	1	
5	93327-1	Gasket, thru bolt cover		1	1/16 Gar.660
6					
7	9940-1	Cover, Camshaft side, center	CI	3	
8		Capscrew		32	1/2-13 x 1
9		Bolt		16	1/2-13 x 1-3/4
10		Nut, hex.		16	1/2-13
11					
12	9942-1	Cover, camshaft side, rear	CI	1	
13		Capscrew		16	1/2-13 x 1-1/2
14					
15	93326-1	Gasket, breather cover	Gar	2	1/16 #660
16		Capscrew		8	1/2-13 x 1-1/4
17					
18	77527-2	Name Plate	See Dwg.	1	
19		Screw fil.hd.p.K.	Stainless Steel	22	No.6 type 2
20	92728-1	Cover, Air Intake Opening	CI	1	Non Turbocharged Engines only
21	93325-1	Gasket, Cover block		1	1/16 Vel.
22		Capscrew, Cover block		10	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

CONTINUED
NEXT PAGE

Date Issued: 6-25-42

ASSEMBLY NO. Q-9-Q
SHEET NO. 1

ENGINE MODEL Q
 2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. _____
 8 CYL. 1

ASSY NAME: Standard Covers
Cyl. Block, Plastic Cover

FIRST USED ON: 42003-22

Group
 ASSY DWGS: 93442

It.	Part No.	Part Name	Matl	Qty	Remarks
1					
2	93126	Pre-Assy., Cyl. Block Side Cover		16	Each Consisting of:
3	92672-1	Cover, side	Wood	1	
4		Parker Kalon Screw Nail	Blk	16	#13 x 3/4"
5	92672-2	Washer	St	8	
6					
7	94575-1	Gasket -		16	#660 Gar. 3/32
8		Capscrew		128	1/2-13 x 1-1/2
9					
10	92506	Pre-Assy. Rear Oil Seal		1	Consisting of:
11	9831-1	Oil Seal (Upper)	CI	1	
12	9832-1	Oil Seal (Lower)	CI	1	
13	93334-1	Gasket (Upper-Lower)	Vel	2	1/16
14	106-8	Dowel	CRS	2	
15		Bolt, upper-lower		4	1/2-13 x 2-1/8
16		Nut		4	1/2-13
17					
18					
19	93333-1	Gasket (Upper) cyl. block	Vel	1	1/32
20		Capscrew		17	5/8-11 x 1-3/4
21	93335-1	Gasket (Lower) cyl. block	Vel	1	1/32
22	9316-1	Cover, breather front	CI	2	

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

CONTINUED
NEXT PAGE

Date Issued: 6-25-42

ASSEMBLY NO. Q-8-U

Retyped 7-15-53

SHEET NO. _____

ENGINE MODEL Q _____

ASSY NAME: Cylinder Block
RH-8

2 CYL. _____
3 CYL. _____
4 CYL. _____
5 CYL. _____
6 CYL. _____
8 CYL. 1 _____

FIRST USED ON: 42003-22

ASSY DWGS: _____

It.	Part No.	Part Name	Matl	Qty	Remarks
1	92288-1	Cylinder Block	CI	1	
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

Date Issued: 3/13/41

ASSEMBLY NO. Q-7-C
SHEET NO.

ENGINE MODEL Q

ASSY NAME: Flywheel
WR 12690
48 x 15, Wt 5,300 lbs.

2 CYL. _____
3 CYL. _____
4 CYL. _____
5 CYL. _____
6 CYL. 1 _____
8 CYL. _____

FIRST USED ON: _____

ASSY DWGS: 91247

It.	Part No.	Part Name	Matl	Qty	Remarks
1	91243	Flywheel	CI	1	
2	91245-1	Bolt		6	SAE 4140
3	130	Nut, slotted		6	
4		Cotter Pin	St	6	1/4 x 4 1/2
5					
6	92504	Pre-Assy.		1	Consisting of:
7	9570-1	Bracket, flywheel pointer	CI	1	
8	9570-2	Pointer, flywheel	CRS	1	
9		Capscrew, pointer-bkt		3	3/8 - 16 x 1
10					
11		Capscrew, bkt-case		2	3/8 - 16 x 3/4
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: 3/27/42

ASSEMBLY NO. C-6-H
SHEET NO.

ENGINE MODEL C

ASSY NAME: Crankshaft
8 Cyl. CI 24" OD Flange

2 CYL. _____
3 CYL. _____
4 CYL. _____
5 CYL. _____
6 CYL. _____
8 CYL. 1



FIRST USED ON: 42003-22

ASSY DWGS: _____

It.	Part No.	Part Name	Matl	Qty	Remarks
1	91545-1	Crankshaft For rough mach. see DWG 93022	CI	1	Campbell, Wyant & Cannon Fdry Co.
2	91090-2 95622	Key, crankshaft gear		1	1 x 1 1/2 x 6 x 23-3/8 lg.
3	91545-3	Tubing	St	8	5/8 OD .065 wall
4	92034 -1	Plug, crankshaft	C.S.	1	
5		Setscrew, Allen		2	3/4-16x1
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: 3-6-43
 Retyped: 10-10-46

ASSEMBLY NO. Q-5-H
 SHEET NO.

ENGINE MODEL Q

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.
 Tin Babbitt
 FIRST USED ON:

Group
 ASSY DWGS: 93081

It.	Part No.	Part Name	Matl	Qty	Remarks
1	91117-1	Cap, Bearing	CS	1	
2	96724	Shell, Brg. Upper, Lower		2	Pre-Assy. Group 96742 Satee NSS
3	91113-1	Ring, Locking	CRS	2	
4		Capscrew		2	Or Dwg. 91476 1/2-13 x 5 Allen
5		Setscrew		2	7/16-14 x 1/2 Allen
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: 4-15-42

Retyped 7-15-53

ASSEMBLY NO. Q-4-D

SHEET NO. _____

ENGINE MODEL Q _____

ASSY NAME: Intermediate Main Brg.
Tin Ebbitt

2 CYL. _____
3 CYL. _____
4 CYL. _____
5 CYL. _____
6 CYL. 5 _____
8 CYL. 7 _____

FIRST USED ON: _____

Group Dwgs: 93081
ASSY DWGS: 91284

It.	Part No.	Part Name	Matl	Qty	Remarks
1	91116-1	Cap, bearing	CS	1	
2	96705	Shell, bearing, upper, lower NSS		2	Assembly 96739
3	91113		Ring, locking		
4		Capscrew		2	911476 1/2-13 x 5 Allen Or dwg. ^
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: 4/15/42

ASSEMBLY NO. Q-2-D
SHEET NO. _____

ENGINE MODEL Q
 2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. 1
 8 CYL. 1



ASSY NAME: Front Main Bearing
 FIRST USED ON: _____
 Group Dwgs: 93081
 ASSY DWGS: 91284

It.	Part No.	Part Name	Matl	Qty	Remarks
1	91115-1	Cap, bearing	CS	1	
2	96821	NSS Shell, bearing, lower, upper		2	Pre-Assy Group 96892 Satco
3	91113	Ring, locking	CRS	2	
4		Capscrew		2	Or Dwg. 91476 1/2-13 x 5 Allen
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 3 4
 Date Issued: 6-17-47
 Retyped: 8-17-48

ASSEMBLY NO. Q-1-G
 SHEET NO. 2

ENGINE MODEL Q
 2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. _____
 8 CYL. _____

ASSY NAME: Base
~~8 Cyl. with thrust brg., Mounting on shelf, 21" Kingsbury (Std. 8 Cyl.)~~
 FIRST USED ON: 41115-24
 93801 - Kingsbury
 ASSY DWGS: 91284

It.	Part No.	Part Name	Matl	Qty	Remarks
1		Cotter Pin		383	3/32 dia. x 7/8
2		Washer, plain		36	1/2 SAE
3					
4		Combination Pre-Assy.			
5	94128	Pre-Assy. Base with Brg. Caps Studs & Nuts (Bearing Shells not included)			Q-1G, Q-2C, D or E, Q-4D, Q-5F or H
6					
7					
8					
9		INSTALLATION EQUIPMENT-----NOT ENGINE MOUNTED			
10	11728	Screw, Jacking		12	
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 3
 Date Issued: 10-8-41
 Retyped: 8-17-49

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

ENGINE MODEL Q
 2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. _____
 8 CYL. 1 _____

ASSY NAME: Base
 8 Cyl. With Thrust Bearing, Mounting
 on Shelf, 21" Kingsbury

FIRST USED ON: 41115-24

Group Dwgs: 93081 - Kingsbury
 ASSY DWGS: 91284

It.	Part No.	Part Name	Matl	Qty	Remarks
1	91534-1	Base	CI	1	
2	93441-1	Gasket, Inner	Vel	18	
3	93349-1	Gasket, Outer - Front	Vel	2	Gasket Set 93715
4	93349-2	Gasket, Outer - Center	Vel	4	
5	93349-3	Gasket, Outer - Rear	Vel	2	
6	804	Stud, Base, Cylinder Block	St	36	
7	91111	Stud, Main Bearing	St	38	
8	9121-1	Thru Bolt, Base, Cyl. Block	St	18	
9	9122	Washer, Thru Bolt	CRS	18	
10	131	Nut, Hex. Thru Bolt	St	18	
11	132	Nut, Square, Thru Bolt	St	18	
12	159	Nut, Hex. Main Bearing	St	38	
13	158	Nut, Square, Main Bearing	St	38	
14	91112	Washer, Main Bearing		38	
15		Nut, Base, Cylinder Block		36	1"-8
16		Lockwasher, Base, Cyl. Block		36	1"
17		Pin, Cotter, Main Bearing		38	3/16 x 3-1/2
18	91885-1	Set Collar, Thru Bolt	CRS	19	
19		Setscrew, Allen	St	19	5/16-18 x 3/8
20	91884-1	Washer, Felt		19	
21	92006-1	Locking Pin, Inter. Main	CRS	14	
22	92006-3	Locking Pin, Front Main	CRS	2	
	92006-2	Locking Pin, Rear Main	CRS	2	

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

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

CONTINUED
 NEXT PAGE

INDEX SHEET 5
ENGINEERING SPECIFICATIONS

ENGINE DMQ-38 43137

CUSTOMER Quartermaster Corps

HP 1200

RPM 275

Part of order 43136-43145

No.	Assembly Name	Qty.	Remarks
128	Radiator		
129 Y	Heat Exchanger	1	
130	Air Cleaner		
131	Bilge Pump		
132	Bilge Pump Lines & Fittings		
133	Underwater Fittings - Engine		
134	Underwater Fittings Purse Seine		
135	Water Discharge Fittings		
136	Spring Bearing		
137	Bulkhead Stuffing Box		
138 L	Flywheel Barring Device	1	78870 - Bar, pry
139	Lube Hand Pump		7841-1,2
140	Fuel Oil Hand Pump		
141	Aux Engine Unit		
142	Fire Pump		
143	Sanitary Pump		
144	Lube Oil Purifier		
145	Lube Oil Transfer Pump		
146 F	Fuel Oil Transfer Pump	1	
147	Winch Drive		
148 T4	Safety Alarm	1	
149 U	Auxiliary Pump	1	
150	Battery		
151	Pump Priming		
152 C	Water Surge Tank	1	
153 F	Pyrometer Conduit	1	

INDEX SHEET 4
ENGINEERING SPECIFICATIONS

ENGINE DMQ-38 43137

CUSTOMER Quartermaster Corps

HP 1200

RPM 275

Part of order 43136-43145

No.	Assembly Name	Qty.	Remarks
10LWW	Instruments	1	Sh. 3F,7D,13C,16J,17G
102GG 102FF	Auxiliary Air Compressor Auxiliary Air Compressor	1 1	
103LL 103MM	Air Receivers & Fittings Air Receivers & Fittings	3 3	
104 L	Lube Oil Tanks & Fittings	1	
105	Fuel Oil Tanks & Fittings		
106	Propeller Equipment		
107	Circulating Water Fittings		
108EE 108CC	Tool Set Tool Set	1 1	See also Assy. 120
109 K	Operating & Maintenance Instruct.	1	
110	Purse Seine Equipment		
111JJ	Pyrometer	1	13 Thermocouples
112 V	Lube Oil Cooler & Fittings	1	
113EEE	Spare Parts	1	
114 TT	Muffler		
115 V	Tachometer	1	Range 350-0-350, Red 275 to 350, Ratio 4:1
116	Stack, Exhaust		
117	Pilot House Control		
118	Electrical Equipment		
119	Indicator Equipment		
120-	Miscellaneous	1	See 43136
121	Underwater Fittings		
122	Governer Remote Control		
123	Reversing Remote Control		
124	Sailing Clutch Remote Control		
124	Reverse Gear Remote Control		
125	Air Starting Remote Control		
126	Beat Tanks		
127	Valve Cage Puller		

Date Issued: 4-1-54

ASSEMBLY NO. Q-32-A4
SHEET NO. _____

ENGINE MODEL Q _____
 2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. _____
 8 CYL. 1 _____

ASSY NAME: Manual Fuel Control (special
 SI Governor, Piston Type
 Reverse Mechanism

FIRST USED ON: 43137

ASSY DWGS: _____

It.	Part No.	Part Name	Matl	Qty	Remarks
1	G-3785	Control Handle Assembly		1	
2	93204	Lever		1	
3	93205	Clamp		1	
4		Capscrew		1	3/8-16 x 1-1/2
5		Lockwasher		1	3/8
6	93206	Set Collar		1	
7	G-4918	Rod		1	
8	B-5047	Heim Joint		2	
9		Nut		4	3/8-24
10		Capscrew		2	3/8-24 x 1-1/2
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

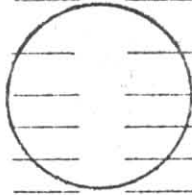
Date Issued: 9-30-49

ASSEMBLY NO. Q-32-EEE
SHEET NO. 5

ENGINE MODEL Q

ASSY NAME: Fuel Control, R.H.

2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. _____
 8 CYL. 1 _____



FIRST USED ON: 49048

ASSY DWGS: _____

It.	Part No.	Part Name	Matl	Qty	Remarks
1		Screw, Machine		3	#8-32 x 1/2 Rd.Hd.
2		Elbow, Street	Br	1	Imp #116-B 1/4"
3		Nipple, Close		1	Imp #112-B 1/4"
4		Half Union		1	Imp #48-F 3/8T x 1/4P
5		Union Nut		2	Imp #41-F 3/8T
6					
7					
8					
9					
10					
11					
12					
13					
14					
15					
16					
17					
18					
19					
20					
21					
22		SEE ASSY. 31 FOR COMBINATION PRE-ASSY. NUMBER			

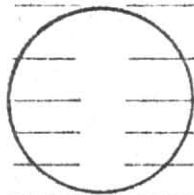
CI = Cast Iron
 CS = Cast Steel
 FS = Forged Steel

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

Date Issued: 9-30-49
Revised: 10-14-49ASSEMBLY NO. Q-32-EEE
SHEET NO. 4

ENGINE MODEL Q

ASSY NAME: Fuel Control, R.H.

2 CYL. _____
3 CYL. _____
4 CYL. _____
5 CYL. _____
6 CYL. _____
8 CYL. 1 _____

FIRST USED ON: 49048

ASSY DWGS: _____

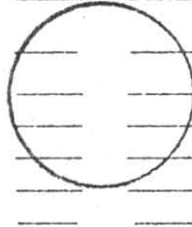
It.	Part No.	Part Name	Matl	Qty	Remarks
1	411	Stud, Bracket		16	
2		Nut, Hex.		16	1/2-13
3		Capscrew, Stub Shaft Brg.		2	5/16-18 x 1-1/4
4		Lockwasher		2	5/16 Std.
5		Groove Pin, Coll.Rod Pin		1	1/16 x 3/4 Style 1
6		Groove Pin, Coupling		1	1/4 x 1-1/2 Style 1
7		Taper Pin, Clamp		1	#4 x 2 on No.1 Cyl.Only
8		Taper Pin		2	#4 x 1-3/4
9	G-1899-1	Shim, Bearing Bkt.		5	} Use as required
10	G-1899-2	Shim, Bearing Bkt.		5	
11	94497-1	Shim, Bearing-Case		5	
12	94497-2	Shim, Bearing-Case		4	
13		Capscrew		2	1/2-13 x 1
14	104-2	Dowel	CRS	2	
15	B-5493	Air Cylinder		1	W.A.B #12751E
16		Capscrew		2	3/8-16 x 1
17		Taper Pin		1	#4 x 1-3/4
18	B-5716 95668	Ball Check Connector Valve		1	Parker #404-GG 1/4" Imp.#63-F-3/8T x 1/4P
19		Tee		1	#53-F Imp.#76-F 3/8T x 1/4P
20	B-5717	Drain-Cock Air Vent Valve		1	Norgren #NV-3 Imp.#38-E 1/4" Pipe Thd.
21		Tubing	Cop	1	3/8 OD x 60" Long
22		Clamps, Tubing		3	#6 for 3/8 OD Tube

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

Date Issued: 9-30-49
Revised: 10-14-49ASSEMBLY NO. Q-32-EEE
SHEET NO. 3

ENGINE MODEL Q

ASSY NAME: Fuel Control, R.H.

2 CYL. _____
3 CYL. _____
4 CYL. _____
5 CYL. _____
6 CYL. _____
8 CYL. 1 _____

FIRST USED ON: 49048

ASSY DWGS: _____

It.	Part No.	Part Name	Matl	Qty	Remarks
1	115-2	Pin	CRS	1	
2		Cotter Pin		2	3/32 x 1"
3	94355-1	Pin, Collapsible Rod	CRS	1	
4	94509-1	Lever, Collapsible Rod	St	1	Pre-Assy. 94354 Assy. Dwg. 94354
5	94353-1	Shaft, Stub	CRS	1	
6	94351-1	Bearing, Stub Shaft	CBr	1	
7	94350-1	Sprocket & Coupling	St	1	
8	B-4696	Snap Ring		1	
9		Setscrew, Hex. Sock Cup Pt.		1	5/16-18 x 1/4
10	95572	Lever, Fuel Limiting	St	1	
11		Capscrew		2	3/8-16 x 1-3/4
12	95738	Bell-Crank, Governor RH	CBr	1	
13	X-2457-1	Shaft	CRS	1	
14		Pin, Taper		1	#4 x 1-3/4
15	X-2635-1	Bracket		1	Pre-Assy. X-2642 Dwg. X-2635
16	10640-53	Bushing		2	
17	94961-1	Link, Gov.-Lever	CRS	1	
18	113-1	Pin	CRS	2	
19		Pin, Cotter		2	3/32 x 3/4
20		Collar, Set		1	7/8 ID x 1-7/16 OD x 9/16
21					
22					

CI = Cast Iron
CS = Cast Steel
FS = Forged SteelCRS = Cold Rolled Steel
CBr = Cast Brass
CBrz = Cast BronzeCONTINUED
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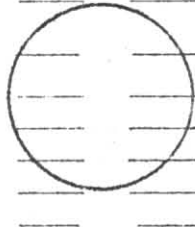
Date Issued: 9-30-49

ASSEMBLY NO. Q-32-EEE
SHEET NO. 2

ENGINE MODEL Q

ASSY NAME: Fuel Control, R.H.

2 CYL. _____
3 CYL. _____
4 CYL. _____
5 CYL. _____
6 CYL. _____
8 CYL. 1 _____



FIRST USED ON: 49048

ASSY DWGS: _____

It.	Part No.	Part Name	Matl	Qty	Remarks
1	94944-1	Barrel, Coll. Rod	Pre-Assy. St	1	} Pre-Assy. #94942 Dwg. #94942
2	94967-1	End, Barrel	#94940 Dwg. #94940 CRS	1	
3	94941-1	Plunger, Coll. Rod	CRS	1	
4	4722-6	Collar, Coll. Rod	CRS	1	
5		Pin, Taper		1	
6	4722-4	Nut	CRS	1	
7	94973-1	Spring	St	1	
8		Yoke, Adjustable		2	
9		Nut		2	
10	113-1	Pin	CRS	2	
11		Cotter Pin		4	3/32 x 3/4
12	G-1907-1	Barrel	NSS St	1	} Pre-Assy. #94349 Assy. Dwg. #94349
13	94348-1	Plug, Coll. Rod	CRS	1	
14	G-1909-1	Rod	NSS CRS	1	
15		Nut, Jam 5/16-18	NSS	1	
16	G-1075-1	Spring	Pre-Assy. & Dwg. #94347	1	
17	G-1908-1	Retainer	CRS	2	
18	79743-1	Rod End	St	1	
19	79742-1	Stop	CRS	1	
20		Wire		1	1/16 x 11/16 Long
21		Nut, Jam		1	3/8-24
22		Yoke, Adjustable		1	3/8 - SAE

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

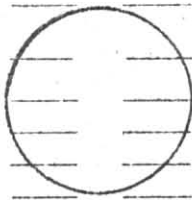
CRS = Cold Rolled Steel
CBr = Cast Brass
CBrz = Cast Bronze

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Date Issued: 9-30-49

Parts List made inactive;
replaced by Q-32-W3 on new
construction.ASSEMBLY NO. Q-32-EEE
SHEET NO. 1

ENGINE MODEL Q

2 CYL. _____
3 CYL. _____
4 CYL. _____
5 CYL. _____
6 CYL. _____
8 CYL. 1 _____ASSY NAME: Fuel Control, R.H. Eng.
For Piston Type. Rev.Mech.8-Cyl.with
Woodward SI Gov., High Fuel Header,
Idler Gear Driven.
FIRST USED ON: 49048

ASSY DWGS: 95740

It.	Part No.	Part Name	Matl	Qty	Remarks
1	94038-2	Shaft, Fuel Control	St	1	
2	95201-1	Bracket, Fuel Control Shaft	CBr	8	
3	93204-1	Lever, Fuel Pump	CBr	8	
4	93205-1	Clamp, Fuel Pump Lever	CBr	8	
5		Capscrew, Clamping		8	3/8-16 x 1-1/2
6		Lockwasher		8	3/8 - SAE
7	93383-1	Spring	St	8	
8	93206-1	Set Collar, Spring	CRS	8	
9	9947-1	Link, Inj.Pump Lever	CRS	16	
10	113-2	Pin, Lever Fuel Pump	St	16	
11		Washer		32	3/8 - SAE
12		Cotter Pin		32	3/32 x 1
13	94343-1	Stop, Fuel Control Shaft	CBr	1	
14		Setscrew,Hex.Sock Cup Pt		1	5/16 - 18 x 5/16
15		Setscrew,Hex.Sock Oval Pt		2	3/8-16 x 1-1/4
16		Nut, Jam		2	3/8-16
17	94342-1	Bearing, Fuel Shaft	CBr	1	Use Pat. G-1904
18		Capscrew, Brg. Bkt.		4	3/8-16 x 2-1/2
19	94925-1	Lever, Gov.Fuel Control RH	CBr	1	
20		Setscrew,Hex.Sock Cup Pt		1	5/16 - 18 x 5/16
21	94344-1	Lever, Collapsible Rod RH	CBr	1	Use Pat. 94468
22		Set Collar		3	1-1/8ID x 1-3/4OD x 5/8

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

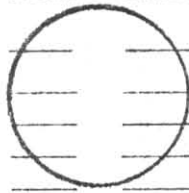
Date Issued: 9-30-49

ASSEMBLY NO. Q-31-BB
SHEET NO. 2

ENGINE MODEL Q

ASSY NAME: Governor Control RH

2 CYL. _____
3 CYL. _____
4 CYL. _____
5 CYL. _____
6 CYL. 1 _____
8 CYL. 1 _____



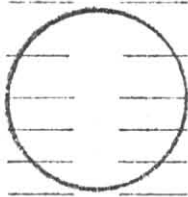
FIRST USED ON: 49048

ASSY DWGS: _____

It.	Part No.	Part Name	Matl	Qty	Remarks
1		Setscrew, Hex. Sock. Oval ^{Pt.}		1	3/8-16 x 1-3/4
2		Nut Jam		1	3/8-16
3	G-1939-1	Segment, Lever	St	1	
4		Capscrew, Sock. Hd.		3	3/8-16 x 3/4
5					
6	94341-1	Bracket, Gov. & Fuel Cont. RH	CI	1	
7		Capscrew, Brkt. Gear Case		3	3/8-16 x 1
8	95737	Lever, Governor	CBr	1	
9		Capscrew		1	3/8-16 x 1-1/4
10					
11		Use the following Pre-Assy Numbers when ordering			
12		assembled parts, check engine specifications for			
13		right combinations of assemblies:			
14	95751	Assy. Gov. & Fuel Control, RH, Dwg. #95740			- Q-31-BB & Q-32-BBE
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 Q
 2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. 1
 8 CYL. 1



ASSY NAME: Governor Control, RH Eng For Piston Type Rev. Mech. and Woodward SI Governor, Idler Gear Driven.
 FIRST USED ON: #49048

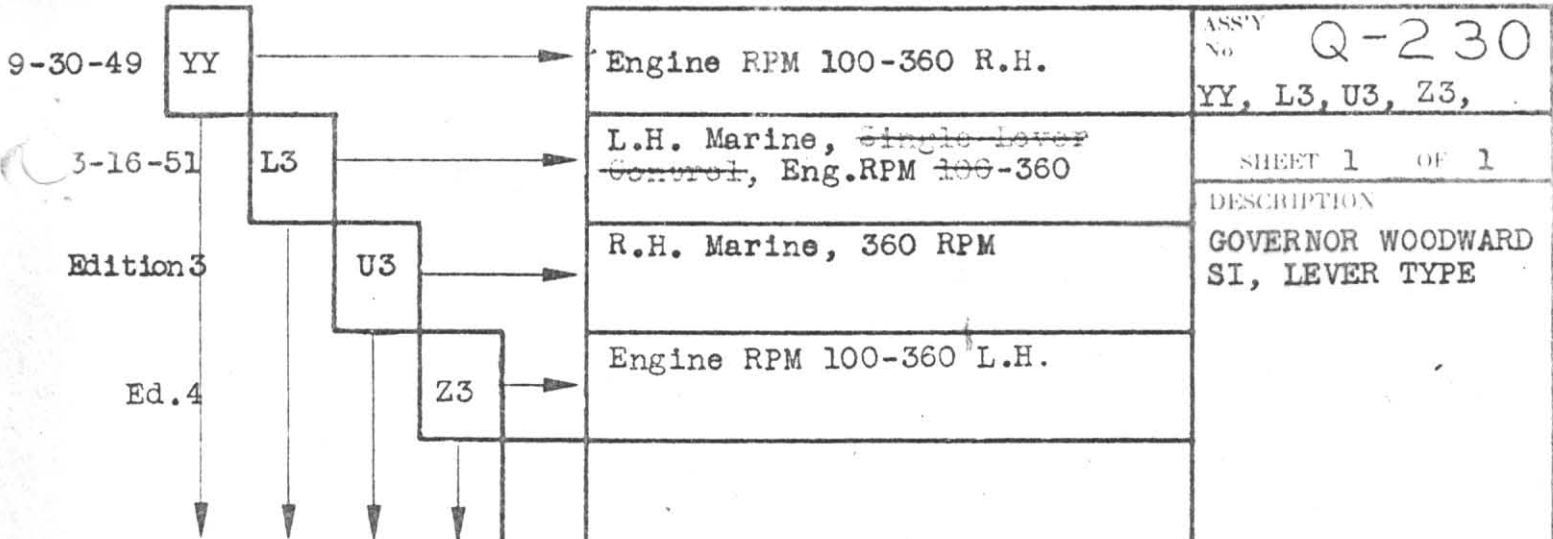
ASSY DWGS: 95740

It.	Part No.	Part Name	Matl	Qty	Remarks	
1		*See End of List for Pre-Assy. Number				
2		*Pre-Assy. Gov. & Fuel Control		1	Consisting of:	
3	91954-1	Rack	St	1	} Pre-Assy. #94333 Assy. Dwg. #94333	
4		Capscrew, Allen		2		1/4-20 x 1/2
5	94334-1	Handle, Gov. Contr. Lever ^{RH}	CBr	1		
6	94335-1	Hand Lever, Gov. Contr. RH	CBr	1		
7	G-1918-1	Pin, Handle	St	1		
8		Setscrew, Allen Cone Pt.		1		1/4-20 x 3/8
9	G-2045-1	Spring	St	1		
10	94510-1	Screw, Locking	CRS	1		
11	94336-1	Spring, Locking	St	1		
12	94339-1	Lever, Gov. Control RH	CBr	1		
13		Capscrew, Sock, Head		3		3/8-16 x 1
14		Setscrew, Hex Sock, Oval ^{Pt.}		2		3/8-16 x 1-1/2
15		Nut, Jam		2	3/8-16	
16	95736	Link, Manual Gov. Contr.	CRS	1		
17		Yoke, Adj.		2	3/8 SAE	
18		Nut		2	3/8-24	
19	113-1	Pin	St	2		
20	113-7	Pin	CRS	1		
21		Cotter Pin		4	3/32 x 3/4	
22	94341-1	Bracket, R.H.	CI	1		

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

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

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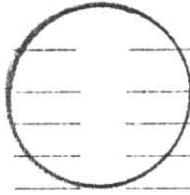


IT	QUANTITIES / Engine				PART No	PART NAME
1	1				95720	Assem. Dwg. 95713 Governor Assy., Consisting of:
2		1			96475	Assem. Dwg. 95716 Governor Assy., Consisting of:
3			1		96616	Assem. Dwg. 95713 Governor Assy., Consisting of:
4				1	96953	Assem. Dwg. 95716 Governor Assy., Consisting of:
5						
6	1			1	B-4978	Rework Shaft to Governor Drawing 95741
7	1		1		95717	Plate, Adapter
8		1		1	96476	Plate, Adapter
9	1	1	1	1	95698	Coupling, Male
10	1	1	1	1	79025	Gasket, Gov.
11	4	4	4	4		Capscrew, 1/2-13 x 1-1/4
12		1	1		B-6324	Rework Shaft to Governor Drawing 95741
13						
14						
15						
16						
17						
18	2	2	2	2	106-1	Dowel
19	1	1	1	1	95719	Gasket, Adapter
20	4	4	4	4		Capscrew, 1/2-13 x 2
21						

Date Issued: 2-25-46
 Retyped: 3-14-49

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

ENGINE MODEL Q _____
 2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. 1 _____
 8 CYL. 1 _____



ASSY NAME: Reverse Mechanism

FIRST USED ON: _____

ASSY DWGS: 93982, 93983, 93984, 94468

It.	Part No.	Part Name	Matl	Qty	Remarks
1					
2	94196	Pre-Assy. Comb. Rev. Mech. & Operating Controls C.C.W. Rotation			Q-29-M, G-55-V
3					
4	94454	Pre-Assy. Parts necessary for field changeover for operat- ing controls, reverse mehhanism etc. Eng. 42003			
5					
6					
7	94986	Pre-Assy. Comb. Rev. Mech & Operating Controls C.C.W. Rotation			Q-29-M, G-55-EE
8					
9	96378	Assy. Comb., Rev. Mech. & Oper- ating Controls C.C.W. Rot.			Q-29-M & Q-55-S
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: 8/22/45

ASSEMBLY NO. Q-29-M

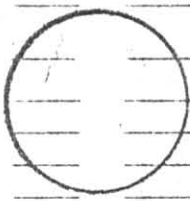
SHEET NO. 2

ENGINE MODEL Q

ASSY NAME: Reverse Mechanism

~~R.H. Piston Type~~

2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. I _____
 8 CYL. I _____



FIRST USED ON: _____

ASSY DWGS: 93982, 93983, 93984, 94468

3-9

It.	Part No.	Part Name	Matl	Qty	Remarks
1	79685-1	Pin, Interlock Upper	CRS	2	SAE 1020
2	96457	Interlock Pin Nut, Regular Jam	ST	2	1/2-20
3	79697-1	Cover, Cylinder	CBRZ	1	
4	B-3713	Seal, Piston Shaft		1	(Small) CR-22355 National 150358
5	79698-1	Gasket, Cover	Vel	1	1/32
6		Capscrew, Socket Head	ST	8	equal 5/8-11 x 1 1/2 Allen or/
7		Capscrew, Socket Head	ST	2	equal 5/8-11 x 2 1/2 Allen or/
8		Capscrew, Socket Head	ST	2	or equal 5/8-11 x 2 3/4 Allen/
9	93979-1	Cap, Cylinder Cover	CBRZ	1	
10	B-3188	Cock, Drain	Br.	2	1/8 Pipe Thread
11					
12					
13	79140-1	Ring, Locking	ST	1	See 108 Assy.
14	78492-1	Nut, Manual Reverse	ST	1	
15	95637	Capscrew, Thrust Ring	ST	6	3/4-10 x 5 1/4
16	91078	Nut, Hex. Slotted- Locking Clip, Thrust Ring	ST	6 6	3/4-10
17	91067	Shim, Thrust Ring		1	5/32 Lam. Br. & ST.
18		Capscrew, Cyl-Gear Case	ST	2	5/8-11 x 3 1/4
19		Capscrew, Cyl-Gear Case	ST	2	5/8-11 x 2 3/4
20		Capscrew, Cyl-Gear Case	ST	10	5/8-11 x 1 3/4
21	93985-1	Gasket, Cyl-Gear Case	Vel	1	1/32
22		Washer Cotter Pin		6 6	3/4 SAE 1/8 x 1 1/2

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

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

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Date Issued: 11-25-49

REPLACES Q-37-T
AS A COMPLETE UNIT

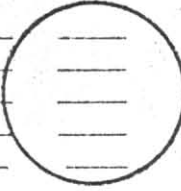
ASSEMBLY NO. Q-37-LL
SHEET NO. 1

ENGINE MODEL Q
 2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. 1
 8 CYL. 1

ASSY NAME: Lube Oil Pump
RH, Dbl.Rev., Pressure Lubricated
Pump Speed 3.4 x Eng.Speed

FIRST USED ON: _____

ASSY DWGS: _____



It.	Part No.	Part Name	Matl	Qty	Remarks
1					
2	94433	Assy., Lube Oil Pump		1	Assy Dwg 94433 Consisting of:
3	G-2052-1	Housing	CI	1	Assy 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	Assy 94434
7	94430-1	Shaft, Drive	CRS	1	
8	G-2048-1	Gear, Main - Scav.	CRS	1	
9		Groov-Pin	St	1	1/4 x 2-5/8, Style 1
10	G-1174-1	Gear, Idler - Press.	CRS	1	Assy G-2209
11	G-2171-1	Gear, Main - Press.	CRS	1	
12	G-2170-1	Key	St	1	
13		Pipe Plug, Hex.Sock.	St	1	3/8
14	94263-1	Gear, Drive	St	1	17 TOOTH ^{2 1/2" Face Width} of teeth
15		Taper Pin	St	1	#5 x 2-1/2
16	G-1178-1	Spring, Scav. Relief	St	1	
17	G-1312-1	Spring, Press. Relief Valve	St	1	
18					
19	G-1288	Assy., Relief Valve & Rod		(2)	Assy Dwg G-1288 EACH Consisting of:
20	G-2032-1	Rod, Valve	CRS	1	
21	G-1171-1	Valve, Relief	C Br	1	
22					

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

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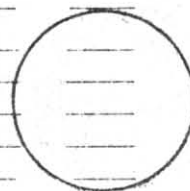
Date Issued: 11-25-49

ASSEMBLY NO. Q-37-LL
SHEET NO. 2

ENGINE MODEL Q

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	C Br	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, Outside Cover		1	
5		Capscrew, Covers	St	12	3/8 - 16 x 1
6		Capscrew, Inside Cover	St	1	3/8 - 16 x 2-1/4
7	180-2	Locking Clip, Inside Cov.	St	7	
8	105-2	Dowel, Inside Cover	St	2	
9	95783	Gasket, Inside Cover	Vel	1	
10		Pipe Plug		4	1/2 Blk
11	95946	Cover, Inside	CI	1	NSS
12	95758	Bushing	Brz	2	
13	G-1163-1	Valve, Cage, Upper	CI	1	
14	G-1168-1	Gasket, Upper Cage to Hsg	Vel	1	
15		Capscrew	St	1	3/8 - 16 x 3-3/4
16		Capscrew	St	7	3/8 - 16 x 4
17		Capscrew		8	3/8 - 16 x 4-1/4
18		Capscrew	St	2	3/8 - 16 x 4-3/4
19		Capscrew	St	3	3/8 - 16 x 2-1/4
20		Capscrew	St	3	3/8 - 16 x 3/4
21	G-1169-1	Gasket, Lower Cage to Hsg	Vel	1	
22	G-2256-1	Cage, Lower Valve	CI	1	Hsg Patt. G-1164

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

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

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NEXT PAGE

Date Issued: 11-25-49

ASSEMBLY NO. Q-37-LL
SHEET NO. 3

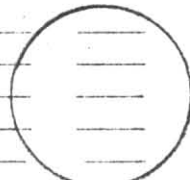
ENGINE MODEL Q

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	104-3	Dowel		2	
2	G-2257-1	Valve, Suction	C Brz	4	
3	G-1245-1	Valve, Discharge	C Br	4	
4		Elbow		2	Imp.69F, 1/4T 1/8PT
5		Tubing	Cop	1	1/4 OD x 9 long
6					
7					
8	G-1289-1	Gasket, Housing - Spacer	Vel	1	
9		Capscrew, Housing - G.C.		4	5/8 - 11 x 2
10	78458-1	Dowel	CRS	2	
11		Nut, Hex.		2	3/8 - 16
12	94262-1	Spacer	StPl	1	
13	94266-1	Gasket, Spacer - Gear Case	Vel	1	
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

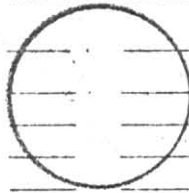
Date Issued: 8/22/45

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

ENGINE MODEL Q

ASSY NAME: Reverse Mechanism
R.H. Piston Type
w/Tapped Cam Gear Hub

- 2 CYL. _____
- 3 CYL. _____
- 4 CYL. _____
- 5 CYL. _____
- 6 CYL. I _____
- 8 CYL. I _____



FIRST USED ON: _____

ASSY DWGS: 93982, 93983, 93984, 94468

It.	Part No.	Part Name	Matl	Qty	Remarks
1					
2	93982	Pre-Assy. Reverse Mechanism		1	Use Assy. 93982 Consisting of:
3	93975-1	Housing, Cylinder	CBRS	1	SAE-620
4	93981-1	Pin, Hub	CRS	4	Pre-Assy. 93983
5	101-3	Setscrew	ST	4	Assy. Dwg. 93983
6	G-1105-1	Caution Plate	Bake	1	
7		Screw, Ctsk. oval, Parker ^{Kalon}	ST	4	#6 x 3/8 Nickel Plate
8	B-3712	Seal, Piston Shaft		1	National (L-92) 370520 (CHICAGO RAW) 116081
9	79678-1	Piston	CBRZ	1	B147-41T Alloy 8B
10	93980-1	Shaft, Piston	ST	1	SAE-1019
11	79677-1	Key, Woodruff Nut, Piston Shaft	Br.	1 2	#5 (1/8 x 5/8)
12	79683-1	Clip, Piston Nut Locking	ST	2	
13	B-3710	Ring, Piston	Brz	1	R.H. Angle Cut
14	B-3711	Ring, Piston	Brz	1	L.H. Angle Cut
15	93978-1	Hub, Thrust	CBRz	1	SAE 620
16	91047-1	Ring, Thrust	CS	1	SAE 1030
17	91069-1	Spacer, Thrust	ST	1	Steel Plate
18	91079	Shim, Thrust Ring	Br.	1	1/16 Laminated
19		Capscrew	ST	3	1/4-20 x 1 1/4
20		Key, Woodruff		1	3/16 x 1
21	79676-1	Pin, Interlock Lower	CRS	2	SAE 1020
22	79696-1	Pin, Interlock Middle	CRS	2	SAE 1020

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

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

**CONTINUED
NEXT PAGE**

ENGINE MODEL Q

- 2 CYL. _____
- 3 CYL. _____
- 4 CYL. _____
- 5 CYL. _____
- 6 CYL. 1
- 8 CYL. 1

ASSY NAME: Air Starting Lines
R.H. Marine Eng. with Piston Type
Rev.Mech.

FIRST USED ON: 45105

Group
ASSY DWGS: 94111

It.	Part No.	Part Name	Matl	Qty	Remarks
1		Line from Air Tank to Operating Control Housing			
2	B-3170	Valve, 300# Globe	Brz	1	2" Crane
3		Nipple	Steel	1	2" Crane
4	B-4312	Strainer, Y	C.St.	1	2" - 600# Crane
5	94108-1	Pipe Bend	St	1	
6	94107-1	Ell	CS	1	
7	79771-1	Gasket, Ell - Contr.Hsg.		1	3/64 Johns-Man. #60
8		Capscrew, Ell - Contr.Hsg.		4	5/8-11 x 1-1/4
9					
10		Line from Operating Control to Manifold			
11	79771-1	Gasket, Ell-Control Hsg.		1	3/64 Johns-Man,#60
12		Capscrew, Ell- Contr.Hsg.		4	5/8-11 x 1-1/4
13	94107-1	Ell	CS	1	
14	94110-1	Pipe Bend	St	1	
15	94109-1	Ell	CS	1	
16		Capscrew, Ell-Cyl.Hd.		1	1/2-13 x 2
17		Capscrew, Ell-Cyl.Hd.		2	1/2-13 x 3-1/4
18	91657-1	Gasket		1	3/64 Johns-Man.#60
19					
20					
21					
22					

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

						DESCRIPTION	ASSY No	
R	S	T	U	V	GOVERNOR AND TACHOMETER DRIVE		Q-27 R, S, T, U, V	
ITEM	QUANTITIES / Engine					PART No	PART NAME	SHEET 2 OF 2
1	1	1	1	1	1		Key Woodruff #13, 3/16 x 1	
2	2	2	2	2	2		Groov Pin Type 1, 1/4 x 2-1/4	
3			1				Groov Pin Type 1, 1/4 x 2-1/2	
4	1	1		1	1	95699	Coupling Female	
5			1			95774	Coupling Gov Drive	
6			1			95773	Shaft Gov Drive	
7	1	1	1	1	1	B-5393	Coupling	
8	2	2	2	2	2	95363	Key	
9	1	1	1	1		95706	Shaft Tach Drive	
10	1	1	1	1	1		Tee, Imp. 71F 1/8 PT - 1/4 T	
11	1	1	1	1	1		Connector, Imp 68F 1/8 PT - 1/4 T	
12	1	1	1	1			Groov Pin Type 1, 1/8 x 1-1/2	
13								
14	4	4	4	4	4		Capscrew 1/2-13 x 1-1/4	
15	4	4	4	4	4	180-10	Lock Clip	
16	2	2	2	2	2	109-1	Dowel	
17	1	1	1	1		95705	Cap Tach.	
18	1	1	1	1		95707	Gasket	
19	3	3	3	3			Capscrew 3/8-16 x 1-1/4	
20	1	1	1	1		B-5646	Oil Seal	
21								
22								
23								
24								
25								
26								
27								
28								

9-29-49

R

RH - Gov RPM 2.94 Eng. RPM SI GOV.
Tach Ratio: 2 x Eng. RPM

ASSY No Q-27

R,S,T,U,V

9-49

S

LH - Gov RPM 2.94 Eng. RPM SI Gov.
Tach Ratio: 2x Eng. RPM

SHEET 1 OF 2

10-3-49

T

RH - Gov RPM 3.6 x Eng. RPM
UG-8 or SG-8 Gov.
Tach. Ratio: 2 x Eng. RPM

DESCRIPTION

GOVERNOR OF TACHOMETER DRIVE

12-20-49

U

RH - Gov RPM 2.94 Eng RPM
UG-32 Gov.
Tach Ratio: 2 x Eng. RPM

5-4-50

V

RH - Gov RPM 3.6 x Eng. RPM
UG-32 Gov.
No Tach Drive Possible

LT	QUANTITIES / Engine					PART No	PART NAME
1	1					95713	Dwg. 95713 Assem. Gov. & Tach. Drive Consisting of:
2		1				95716	Dwg. 95716
3			1			95764	Dwg. 95764
4				1		96132	Dwg. 96146
5					1	96225	Dwg. 96062
6	1	1	1	1	1	95700	Bracket RH
7	2	2	2	2	2	95710	Bushing
8	2	2	2	2	2	95711	Bushing
9		1				95712	Bracket LH
10	1	1	1	1		95708	Shaft Tach Drive Gear
11					1	96054	Shaft Tach Drive Gear
12	1	1	1	1	1	95704	Gear Tach. Drive
13	1	1		1		95702	Gear Gov Drive
14			1		1	95770	Gear Gov Drive
15	2	2	2	2	2		Key Woodruff #21, 1/4 x 1-1/4
16	2	2	2	2	2		Groov Pin Type 1-1/4 x 2-1/4 long
17	1	1				95709	Shaft, Gov Drive
18			1	1	1	95761	Shaft, Gov Drive
19	1	1		1		95703	Gear, Gov. Driven
20			1		1	95771	Gear, Gov Driven
21	1	1	1	1	1	95701	Collar Gov Drive Shaft

Assem. 95714 (RH)
Dwg. 95700

Assem. 94715 (LH)
Dwg. 95712

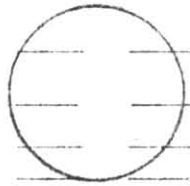
Date Issued: 8-11-47

ASSEMBLY NO. Q-26-G
SHEET NO. 2

ENGINE MODEL Q

ASSY NAME: Gear Set

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



FIRST USED ON: _____

ASSY DWGS: _____

3-15

It.	Part No.	Part Name	Matl	Qty	Remarks
1	109-2 109-2	Dowel, Stub-Block		2	Drill Rod
2	106-8	Dowel, Stub-Washer		1	Drill Rod
3		Capscrew		1	1-1/8-7 x 2 1/4
4					
5					
6					
7					
8					
9					
10		* For Field Replacement use the following:			
11	96233	Gear, Crank to Pump	St	1	
12	96236	Spacer Ring	St	1	
13					
14					
15					
16					
17					
18					
19					
20					
21					
22					

3-15

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

Date Issued: 6-24-43

ASSEMBLY NO. Q-59-K
SHEET NO. 5

ENGINE MODEL Q
2 CYL. _____
3 CYL. _____
4 CYL. _____
5 CYL. _____
6 CYL. _____
8 CYL. 1 _____

ASSY NAME: Circulating Water Fittings

FIRST USED ON: 42003-22

ASSY DWGS: 92682

It.	Part No.	Part Name	Matl	Qty	Remarks
1		Elbow, 90°	Brass	1	1/2
2		Pipe	Brass	1	1/2 x 154 1/8
3		Union	Brass	1	1/2
4		Pipe	Brass	1	1/2 x 12 ft.
5		Elbow, 90°	Brass	1	1/2
6		Nipple	Brass	1	1/2 x 7
7		Elbow, 90°	Brass	1	1/2
8		Nipple	Brass	1	1/2 x 14
9		Tee	Brass	1	1/2
10		Nipple	Brass	1	1/2 x short
11	B3202	Globe Valve	Brass	1	1/2
12		Nipple			1/2 x short
13					
14		Line Water Manifold to Inst. Board			
15		Bushing	Brass	1	3/4 x 1/4
16		Nipple	Brass	1	1/2 x short
17		Elbow, 90°	Brass	1	1/4
18		Nipple	Brass	1	1/4 x short
19	B3187	Globe Valve	Brass	1	1/2
20		Elbow, 90°	Imp	1	1/2 P.T x 1/2 T 69F
21		Nut	Imp	1	1/2 61F
22		Tubing - to Inst. Board	Cop	1	1/2 x 85

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

Date Issued: 5/28/43

ASSEMBLY NO. Q-59-K
SHEET NO. 4

ENGINE MODEL Q
 2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. _____
 8 CYL. 1 _____

ASSY NAME: Circulating Water Fitting

FIRST USED ON: 42003-22

ASSY DWGS: 92682

It.	Part No.	Part Name	Matl	Qty	Remarks
1	92704-1	Adapter, Cent. Water Pump	CI	1	
2	92704-2	Gasket		1	1/16 Rubber
3		Capcrew		8	1/2-13x1 1/2
4					
5		Line (S.W.) Tee to Inst. Board			
6		Bushing	Br	1	1/2 x 1/4
7		Nipple -	Br	1	1/4 x short
8		Elbow, 90° Street	Br	1	1/4
9	B3187	Globe Valve	Br	1	1/4
10		Connector	Br	1	1/4 P.T. x 1/4 T
11		Tubing	Cop	1	1/4 x 85
12					
13		Line Valve Cage to Thrust Bearing			
14		Bushing	Brass	1	1 x 1/2
15		Nipple	Brass	1	1/2 x short
16		Elbow, 90° Street	Brass	1	1/2
17	B3202	Globe Valve	Brass	1	1/2
18		Nipple	Brass	1	1/2 x close
19		Tee to Thrust Brg.	Brass	1	1/2
20		Nipple	Brass	1	1/2 x short
21		Union	Brass	1	1/2
22		Pipe	Brass	1	1/2 x 19 1/2

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

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

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NEXT PAGE**

Date Issued: 5-14-43

ASSEMBLY NO. Q-59-K
SHEET NO. 3

ENGINE MODEL Q _____
 2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. _____
 8 CYL. 1 _____

ASSY NAME: Circulating Water Fittings

FIRST USED ON: 42003-22

ASSY DWGS: 92682

It.	Part No.	Part Name	Matl	Qty	Remarks
1		Elbow 90°	Blk	1	1"
2		Pipe	Blk	1	1 x 21
3		Elbow 45°	Blk	1	1"
4		Pipe	Blk	1	1 x 18"
5		Elbow 90°	Blk	1	1"
6		Pipe	Blk	1	1" x 16"
7	92978-1	Clamp	St	1	
		Elbow 90°	Blk	1	1"
8		Nipple	Blk	1	1" x 6"
9		Elbow 45°	Blk	1	1"
10		Nipple	Blk	1	1" x 3"
11		Bushing	Blk	1	1 x 1½
12		Flange, Pump Adapter	CI	1	1½ x 6 reducing #557
13		Gasket		1	1/16 Rub. for 6" reducing flange
14		Clamps		4	Parker 1"
15		Capscrews, clamp		4	3/8 x 3/4"
16		Capscrews, flange		4	5/8 x 2
17		Nut		4	5/8 - 11
18					
19	75992-1	Tee, pump suction	CI	1	
20	77728-1 75992-2	Gasket		1	1/16-Rub
21		Capscrew		8	5/8 - 13 x 1½
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: 5-14-43

ASSEMBLY NO. Q-59-K
SHEET NO. 2

ENGINE MODEL Q
2 CYL. _____
3 CYL. _____
4 CYL. _____
5 CYL. _____
6 CYL. _____
8 CYL. 1 _____

ASSY NAME: Circulating Water Fittings

FIRST USED ON: .42003-22

ASSY DWGS: 92682

It.	Part No.	Part Name	Matl	Qty	Remarks
1		Supercharger inlet tee to oil cooler inlet			
2		Bushing	Blk	1	1 x 1/2
3		Coupling, Hays #540	Brass	1	1/2 I.D. Tubing x 1/8 P.T.
4		Tubing,	Cop.	1	5/8 O.D. x 30"
5		Ell, 90° Hays #520	Brass	1	1/2
6					
7		Supercharger outlet to fresh water pump inlet adapter			
8		Bushing	Blk	1	1 1/2 x 1
9		Nipple	Blk	1	1" x close
10		Tee	Blk	1	1"
11		Nipple	Blk	1	1" x close
12		Plug, pipe	Blk	2	1"
13		Tee	Blk	1	1"
14		Pipe	Blk	1	1" x 20"
15		Elbow 45°	Blk	1	1"
16		Nipple	Blk	1	1 x 5"
17		Union	Blk	1	1"
18		Pipe	Blk	1	1" x 26"
19		Elbow 90°	Blk	1	1"
20		Pipe	Blk	1	1" x 18 ft.
21		Union	Blk	1	1"
22		Pipe	Blk	1	1" 8 1/2"

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

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

**CONTINUED
NEXT PAGE**

Date Issued: 5-14-43

ASSEMBLY NO. Q-59-K
SHEET NO. 1

ENGINE MODEL Q

2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. _____
 8 CYL. 1

ASSY NAME: Circulating Water Fittings

FIRST USED ON: 42003-22

ASSY DWGS: 92682

It.	Part No.	Part Name	Matl	Qty	Remarks
1		Water Manifold to Water Circulator			
2		Nipple	Blk	1	1" x Short
3	B3230	Valve, Globe		1-	1"
4		Nipple	Blk	1	1 x 3
5		Ell, 90°	Blk	1	1"
6		Nipple	Blk	1	1 x Short
7		Ell, 90° Street	Blk	1	1"
8					
9		Water Circulator to Supercharger Inlet			
10		Ell, 90° St.	Blk	1	1"
11		Nipple	Blk	1	1 x 16"
12		Ell, 45°	Blk	1	1"
13		Nipple	Blk	1	1 x 26"
14		Ell, 90°	Blk	1	1"
15		Nipple	Blk	1	1 x 5"
16		Tee	Blk	1	1"
17		Nipple	Blk	1	1" x short
18		Union	Blk	1	1"
19		Nipple	Blk	1	1" x Short
20		Ell, 45°	Blk	1	1"
21		Nipple	Blk	1	1" x close
22					

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

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

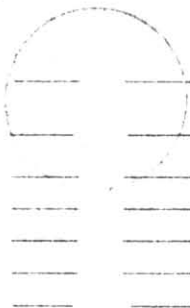
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Date Issued: 11-27-44
 Retyped: 1-13-49

ASSEMBLY NO. G-57-L
 SHEET NO. _____

ENGINE MODEL G Q

2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. _____
 8 CYL. _____



ASSY NAME: Exhaust Connection
BF-44-14" 150# Std. Flange

FIRST USED ON: _____

ASSY DWGS: _____

It.	Part No.	Part Name	Matl	Qty	Remarks
1	77142-1	Adanper, Exhaust	W.St	1	
2	79158	Gasket, turbocharger		1	1/16 Car. 7508
3	79157	Gasket, Exh. Adapter		1	
4		Capscrew, turbocharger		16	1/2-13" x 1-1/4"
5		Pipe Plug 1/2"		1	Male
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: 6-7-45
 Retyped: 12-22-47

ASSEMBLY NO. G-55-V
 SHEET NO. 3

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



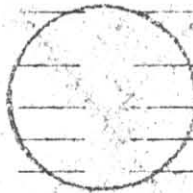
ASSY NAME: Operating Control
 FIRST USED ON: _____
 ASSY DWGS: _____

It.	Part No.	Part Name	Matl	Qty	Remarks
1		Capscrew, Control Housing	St	4	5/8-11 x 1 1/4 Allen
2	79721-1	Gasket, Control Housing	Vel	1	
3	104-2	Dowel	St.	2	1/2 x 7/8
4					
5					
6					
7					
8					
9					
10					
11					
12					
13					
14					
15					
16					
17					
18		SEE 29 ASSEMBLY FOR COMBINATIONS			
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: 6-7-45
Retyped: 12-22-47ASSEMBLY NO. G-55-V
SHEET NO. 2ENGINE MODEL GASSY NAME: Operating Control

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	79717-1	* Valve, Air Start	CBr	1	
2	G-2460-1	* "O" Ring Packing	Neo	1	
3		FOR REPLACEMENT ORDER NEW VALVE G-2836-1 & "O" RING	B-5001		12
4	.				
5	B-3775	Ring, Air Start Valve	Brz	1	1/8x2-3/4 AH Angle Cut
6	79718-1	Valve, Air Start Pilot	Br	1	2
7					
8	G-1068-1	Valve Screw	Br	1	
9	G-1070-1	Spring, Pilot Valve		1	PH.Brz. Spring Wire
10	G-1066-1	Spring, Air Start Valve		1	PH.Brz. Spring Wire
11	79700-1	Spring, Valve		2	PH.Brz. Spring Wire
12	G-1069-1	Hand Wheel	CBr	1	
13		Screw, Rd. Hd. Mach.		1	#10-32 x 3/8
14		Washer		1	3/16 Std. 1/2 O.D.
15	G-1184-1	Washer	Rub	1	12
16	79693-1	Pin, Air Start Cam	St	1	
17	79694-1	Valve, Shift	Br	2	
18	79692-1	Pin, Shift Valve Cam	St	2	
19	79695-1	Cover, Valve Chest	CBrz	1	
20	79720-1	Gasket, Cover	Vel	1	
21		Capscrew, Allen	St	4	5/8-11 x 1 1/2
22					

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

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

CONTINUED
NEXT PAGE

2-6-53

QQ

2 1/2" Suction Pipe, Bailey Strainer, One EGLF-3 & Suction Tee

ASSY

No

Q-252

QQ,

SHEET 1 OF 1

DESCRIPTION

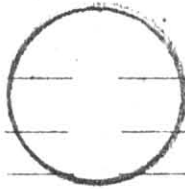
External Lube
Lines Duplex Non-
Reversible Lube
Pump

IT	QUANTITIES /Engine				PART No	PART NAME
1	1				94814-1	Connector, Lube Suction
2	1				93426-1	Gasket, 1/32
3	6					Capscrew, 3/8-16 x 1-1/2
4	1				B-3595	Flange, Blind, 2-1/2" x 150#
5	3				B-4283	Flange, Welding, 2-1/2 x 150#
6	1				94278-1	Flange, 2-1/2" Welded, Scav. Pump Suction
7	2				G-1286-1	Gasket
8	1				G-2022-1	Flange, Press. Pump Suction, 2 1/2" tapped
9	3				G-1942-1	Flange, Lube Pump Disch., 2" tapped
10	3				G-1191-1	Gasket
11	2				B-3582	Flange, Welding, 2" x 150#
12	2				79067-1	Gasket
13	1				B-3565	Flange, Header, 2" x 150#
14	1					Nipple, 2" x Close
15	1				14277-1	Screen Protective, Inlet
16	1				14281	Tag, Screen
17						
18						
19						
20						
21						

Date Issued: 2-2-42
 Retyped: 3-8-48

ASSEMBLY NO. Q-51-H
 SHEET NO. _____

ENGINE MODEL Q _____
 2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. _____
 8 CYL. 1 _____



ASSY NAME: Lube Oil Suction Line
8 Cyl. (Twin Suction Pipes)

FIRST USED ON: 41115-24

ASSY DWGS: 91958, 91985

It.	Part No.	Part Name	Matl	Qty	Remarks
1	91850-1	Connector	CS	1	
2	93426-1	Gasket	Vel	1	
3		Capscrew		6	3/8-16 x 1-1/2
4	91839-1	Pipe, Oil Sump	Blk	2	
5	9252-1	Clamp	St	8	
6		Capscrew		12	3/8-16 x 1-1/2
7		Nut		12	3/8-16
8		Pipe Cap	Blk	2	1-1/4
9		Flange, Blind	St	2	2" x 6
10		Gasket for 2" Std. Flange	Vel	2	1/32
11		Capscrew		8	5/8-11 x 2
12		Nuts		8	5/8-11
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: 10/27/43

ASSEMBLY NO. Q-50-L
SHEET NO. 5

ENGINE MODEL Q _____
 2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. _____
 8 CYL. 1 _____

ASSY NAME: Fuel Tank & Header
 CS Pres. Tank, Plunger Fuel Pump
 RH Q-8 Blk Pipe
 Single fuel oil drain header
 FIRST USED ON: _____

ASSY DWGS: ~~92400~~

It.	Part No.	Part Name	Matl	Qty	Remarks
1		Nut		8	5/16"-18
2		Nipple	Blk	1	3/4" x 4 1/2
3		Street Elbow 90°	Blk	1	3/4"
4	B-3353	Relief Valve with	Blk	1	
5		Enterprise special inner valve. Set at 25 lbs. 3/4"			
6					
7		Tubing or piping between			
8		pressure tank, strainers,			
9		filters and main header			
10		to suit each job. See			
11		miscel. Assy. 120 for list			
12		of matl.			
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: 10/27/43

ASSEMBLY NO. Q-50-L
SHEET NO. 4

ENGINE MODEL Q

2 CYL.	_____	_____	_____	_____
3 CYL.	_____	_____	_____	_____
4 CYL.	_____	_____	_____	_____
5 CYL.	_____	_____	_____	_____
6 CYL.	_____	_____	_____	_____
8 CYL.	1	_____	_____	_____

ASSY NAME: Fuel Tank & Header
CS Pres. Tank, Plunger Fuel Pump
RH Q-8 Blk Pipe
Single fuel oil drain header
FIRST USED ON: _____

ASSY DWGS: ~~92400~~

It.	Part No.	Part Name	Matl	Qty	Remarks
1		Tee	Blk	1	3/4"
2		Nipple-tee to relief valve	Blk	1	3/4" x close
3	B-3353	Relief Valve with	Br	1	
4		Enterprise special inner valve. Set at 25 lbs. 3/4"			
5					
6		Elbow 90° Street	Blk	1	3/4"
7		Nipple	Blk	1	3/4" x 4
8		Union	Blk	1	3/4"
9		Nipple	Blk	1	3/4 x 8
10		Street Ell, into tee	Blk	1	3/4" 90°
11		Plug	Blk	2	3/4"
12					
13	93216	Pre-Assy., Bypass Line RH		1	Consisting of:
14	92390-1	Flange Tubing	CRS	2	Welded at assembly
15	92545-1		St	1	
16		Pipe Clamp		4	1-hole, 1/2" Parker-Kalon
17		Machine screw, fil. head		4	5/16-18 x 3/4
18					
19	9937-1	Gasket	Cop	2	
20	92403-1	Flange	CRS	1	
21		Capscrew		4	5/16-18 x 1 1/2
22		Capscrew		4	5/16-18 x 1-3/4

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

Date Issued: 10/27/43

ASSEMBLY NO. Q-50-L
SHEET NO. 3

ENGINE MODEL Q

2 CYL. _____
3 CYL. _____
4 CYL. _____
5 CYL. _____
6 CYL. _____
8 CYL. 1 _____

ASSY NAME: Fuel Tank & Header
CS Pres. Tank, Plunger Fuel Pump
RH Q-8 Blk Pipe
Single fuel oil drain header
FIRST USED ON: _____

ASSY DWGS: ~~92400~~

It.	Part No.	Part Name	Matl	Qty	Remarks
1	93101	Pre-Assay Fuel Oil Drain		1	Consisting of:
2	93089-1	Header, fuel oil drain	Blk	1	1/2
3		Ell	Imp	16	49F 1/4T 1/8P
4		Union Nut	Imp	16	41F 1/4T
5		Plug - Male	Blk	1	3/8
6		El - Imp.	Imp	1	49F 1/2T 3/8P
7		Union nut	Imp	1	41F 1/2T
8					
9					
10		Tube head to drain header	Cop	8	1/4" x 32
11		Elbow to head	Imp	8	69F 1/4T 1/8P
12		Connection to head	Imp	8	68F 1/4T 1/8P
13		Tube to nozzle	Cop	8	1/4 x 28
14		Tube, tappet drain	Cop	8	1/4 x 5
15		Parker clamps 1/2"		4	
	91656-1	Strap, tappet drain	St	4	
16		Capscrew		8	1/4-20 x 3/4
17		Lockwasher		8	1/4
18					
19		Piping around fuel transfer pump			
20		Tee, suction connection	Blk	1	3/4"
21		Nipple-into pump	Blk	1	3/4" x close
22		Nipple-from pump	Blk	1	3/4" x close

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

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

CONTINUED
NEXT PAGE

Date Issued: 10/27/43

ASSEMBLY NO. Q-50-L
SHEET NO. 2

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

ASSY NAME: Fuel Tank & Header
CS Pres. Tank, Plunger Fuel Pump
RH Q-8 Blk Pipe
Single fuel oil drain header
FIRST USED ON: _____

ASSY DWGS: 92400

It.	Part No.	Part Name	Matl	Qty	Remarks
1	92397-1	Fitting, fuel header	CRS	1	Welded (cont.)
2	92402-2	Tube	St	1	
3	92391-1	Flange	CRS	1	
4					
5	9930-1	Bracket, fuel header	CBR	9	
6		Capscrew		9	1/2-13 x 3
7		Lockwasher		9	1/2
8		Set screw		9	1/2-13 x 3/4 Allen
9	9933	Adapter, fuel header	CRS	1	
10	94701-1	Washer, 1-1/8 x 1 1/4 x 1/8		1	Annealed Copper
11		Nipple		1	1/2 x 4
12	92524	Pre-Assy., Inlet Tube		8	Each consisting of:
13	9935-2	Tube, fuel connection		1	See Dwg.
14		Connector, fuel pump	St	1	Supplied with pump Bosch NRV 26/1X or Bendix 10-24173
15					
16	9936	Screw, fuel line	CRS	8	
17	9937	Gasket, fuel line		16	Soft annealed copper
18	9934	Plug	CRS	1	
19		Pipe Plug		1	1/8
20	94701-1	Washer, 1-1/8 x 1 1/4 x 1/8		1	Annealed Copper
21					
22					

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

CONTINUED
NEXT PAGE

Date Issued: 10/27/43

ASSEMBLY NO. Q-50-L
SHEET NO. 1

ENGINE MODEL Q
2 CYL.
3 CYL.
4 CYL.
5 CYL.
6 CYL.
8 CYL. 1

ASSY NAME: Fuel Tank & Header
CS Pres. Tank, Plunger Fuel Pump
RH Q-8 Blk Pipe, Single fuel oil
drain header
FIRST USED ON:

ASSY DWGS: 92400

It.	Part No.	Part Name	Matl	Qty	Remarks
1					
2	92574	Pre-Assy. Fuel Pressure Tank		1	Assy. Dwg. 92400 Consisting of:
3	92398-1	Tank, Accumulator	CSt	1	
4	93137-1	Plug Gasket	Vel	1	3/4 Pipe 1/16 thick
5	92399-1	Cover	CSt	1	
6		Capscrew, Cover		12	5/16-18 x 1
7		Plug		1	1/8 pipe
8	B-3204	Valve & Float assy. only		1	3/4
9	92415-1	Trunnion, Float	CRS	1	
10		Bushing	Blk	1	3/4" x 1/4"
11		Nipple	Blk	1	1/4" x 1 1/2"
12	B-3187	Valve, globe, drain	Br	1	1/4
13					
14		Air Bleed Line from Tank,			Consisting of:
15		Bushing from tank	Blk	1	1/2 x 1/8
16		Elbow	Imp	1	49F 1/4T x 1/8P
17		Union Nut	Imp	1	41F-1/4T
18		Tubing	Cop	1	1/4 x 24
19					
20	92412	Pre-Assy., Fuel Header		1	Consisting of:
21	92402-1	Fuel Header	St	1	Welded
22	92207-1	Fitting, fuel header	CRS	7	

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CBr = Cast Brass
CBrz = Cast Bronze

CONTINUED
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Date Issued: 7-24-44
 Retyped 7-15-53

ASSEMBLY NO. Q-49-D
 SHEET NO. _____
 and Fittings

ENGINE MODEL Q _____
 2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. _____
 8 CYL. 1 _____

ASSY NAME: Force Feed Oiler Lines
 Q-8

FIRST USED ON: 41002, 41003, 41004

Group _____
 ASSY DWGS: 93442

It.	Part No.	Part Name	Matl	Qty	Remarks
1	9274-1	Tube, cyl. Lubricator		8	Monel
2	7114	Tube, cyl. Lubricator		8	Monel
3	93085-1	Washer	Cop	32	
4	6269-B	Gland		16	Hex Steel
5	93855-1	Packing	Neop	16	
6	91127	Holder, oil lines	CI	1	Use Patt. 7145
7		Capscrew, Allen		4	3/8-16 x 1
8		Capscrew, holder		2	3/8-16 x 1-1/2
9					
10		Union	Imp	24	62F 1/4T
11		El1	Imp	16	69F 1/4T 1/8P
12		Tube	Cop	1/	1/4 x 147 ft.
13					
14		Clips, Tubing	Br	18	#8, 1/4"
15		Screw		36	1/4-20 x 1/2
16		Bolt		4	1/4-20 x 1/2
17		Nut		4	1/4-20
18					
19					
20					
21					
22					

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

Date Issued: 9/15/41

ASSEMBLY NO. Q-47-D
SHEET NO.

ENGINE MODEL Q
2 CYL.
3 CYL.
4 CYL.
5 CYL.
6 CYL.
8 CYL. 1

ASSY NAME: Thrust Shaft
Kingsbury GF-21,
22" OD 17 1/2 BC 10 1/4 Shaft

FIRST USED ON: 41115-120

ASSY DWGS: 91531

It.	Part No.	Part Name	Matl	Qty	Remarks
1.	91528	Thrust Shaft	FS	1	
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
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FS = Forged Steel CBrz = Cast Bronze

Date Issued: 10/27/41

ASSEMBLY NO. Q-41-D
SHEET NO. _____

ENGINE MODEL Q _____
 2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. _____
 8 CYL. 1 _____

ASSY NAME: THRUST BEARING
 Kingsbury Bearing 21 GFS
 10 $\frac{1}{2}$ Shaft
 Mounting Feet Below Shaft Centerline
 FIRST USED ON: 41115-24
 Group Dwgs: 93081-Kingsbury
 ASSY DWGS: 91531

It.	Part No.	Part Name	Matl	Qty	Remarks
1	B-3662	Thrust bearing for 10.250 Shaft as per Kingsbury		1	Kingsbury 21 GFS
2		Dwg. 262992 without shaft. with water cooling coil.			Assy. DWG. #262992
3					
4	91547-1	Bolt	CRS	8	
5	91052	Washer	St.	8	1-5/16 I.D. x 2-0 D. x 5/32
6		Cotter Pin	St.	8	3/16 x 2-1/2
7	126	Nut, slotted	St.	8	1-1/4-12
8	91546-1	Shims	St.	4	sets
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 3 4

Date Issued: 12-15-41
Retyped: 2-17-49ASSEMBLY NO. Q-40-G
SHEET NO. 2ENGINE MODEL Q
2 CYL. _____
3 CYL. _____
4 CYL. _____
5 CYL. _____
6 CYL. 6
8 CYL. 8ASSY NAME: Fuel Injection
(Supercharged, slow speed)

FIRST USED ON: 41065

ASSY DWGS: 93090

It.	Part No.	Part Name	Matl	Qty	Remarks
1					
2					
3	Note:	For L.H. engines, use the following in place of items 19-22sh 1			
4	94808	Pre-Assy., Injection Tube		1	Dwg. 96913 Consisting of:
5	94809-1	Collar, inj. tube		2	NSS
6	96913	Tubing, inj.	St	1	1/20D x 3/16 ID x 33 1/4 NSS
7	92920-1	Nut, tubing		2	With Pump NSS
8					
9					
10					
11					
12					
13					
14					
15					
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: 12-15-41
Retyped: 8-26-43ASSEMBLY NO. Q-40-G
SHEET NO. 1ENGINE MODEL Q
2 CYL. _____
3 CYL. _____
4 CYL. _____
5 CYL. _____
6 CYL. 6 _____
8 CYL. 8 _____ASSY NAME: Fuel Injection
(Supercharged, slow speed)

FIRST USED ON: 41065

ASSY DWGS: 93090

It.	Part No.	Part Name	Matl	Qty	Remarks
1	B-3028	Pump, Bendix FDR-24, Time		1	Bendix 10-19124-3
2		for port closing, steel			
3		inlet fitting 10-24173			
4		for 7/8 OD tubing; steel			
		outlet fitting for 1/2"			
		OD tubing			
6	B-3031	Nozzle Holder HDV-250		1	Bendix 10-19210-1
8	B-3033	Nozzle N.D.		1	Bendix 10-19761
10	B-3039	Tip, T.D. 8 Hole, .020 Dia.		1	Bendix 10-21328-4
		at 140°			
					changed to Bendix 84703-11
12	9904	Retainer, nozzle holder	CS	1	
13	9377	Gasket, nozzle holder		1	Copper with pump
14	9915-3	Clamp cover, inj. line	CI	1	
15	93366-1	Gasket		1	3/32 Gar 660
16		Capscrew		5	5/16-18 x 1 Allen
17	152	Nut, Nozzle Holder		2	
19	94809	Pre-Assy., Injection Tube		1	Dwg. 96912 Consisting of:
20	94807	Collar, Inj. Tube	St	2	SAE 4140 NSS
	91823				
21	96912	Tubing, Inj., 1/2 x 3/16	St	1	1/2 OD x 3/16 ID x 28 NSS
	91728-1				
22	92920-1	Nut, tubing	St	2	With Pump NSS

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

Date Issued: 11-23-49

ASSEMBLY NO. Q-39-L
SHEET NO. 4

ENGINE MODEL Q _____
 2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. _____
 8 CYL. 1 _____

ASSY NAME: Lube Oil Fittings

FIRST USED ON: 49041

ASSY DWGS: _____

It.	Part No.	Part Name	Matl	Qty	Remarks
1		Line to Cam Bearings		8	Consisting of:
2		Connector		1	Imp 68F, 1/4T 1/4P
3		Tube	Cop	1	1/4 x 9
4		Tee		1	Imp 72F, 1/4T 1/4P
5					
6		Line to Fuel Tappet from Tee		8	Consisting of:
7		Tube	Cop	1	1/4 x 10
8		Ell		1	Imp 69F, 1/4T 1/8P
9		Line, Header to Tappets		8	Consisting of:
10		Connector		1	Imp 68F, 1/4T 1/4P
11		Tube	Cop	1	1/4 x 18
12		Ell		1	Imp 69F, 1/4T 1/8P
13		Line, Header to Rocker Bkt.		8	Consisting of:
14		Connector		1	Imp 68F, 1/4T 1/4P
15		Tube	Cop	1	1/4 x 70
16		Ell, 90°		1	Imp 50F, 1/4T 1/8P
17		Union Nut		1	Imp 41F, 1/4T
18		Line, Header to Front Brg.		1	Consisting of:
19		Connector		1	Imp 68F, 1/4T 1/4P
20		Tube	Cop	1	1/4 x 11
21		Ell, 90°		1	Imp 69F, 1/4T 1/4P
22					

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Date Issued: 11-23-49

ASSEMBLY NO. Q-39-L
SHEET NO. 3

ENGINE MODEL Q
2 CYL. _____
3 CYL. _____
4 CYL. _____
5 CYL. _____
6 CYL. _____
8 CYL. 1 _____

ASSY NAME: Lube Oil Fittings

FIRST USED ON: 49041

ASSY DWGS: _____

It.	Part No.	Part Name	Matl	Qty	Remarks
1		Connection		1	Imp 68F, 1/4T 1/4P
2		Tube	Cop	1	1/4 x 36
3		Tee		1	Imp 72F, 1/4T 1/4P
4		Ell, 90° Str. into Cam Gear Stub		1	1/4 Blk
5		Tube	Cop	1	1/4 x 24
6		Connection		1	Imp 68F, 1/4T 1/4P
7		Tee		1	1/4 Blk
8		Nipple into Gear Case		1	1/4 x close Blk
9		Ell, 90° Str.		1	1/4 Blk
10	10272	Plug, to Acc. Gears		1	1/4 Drilled #50 Blk
11					
12	93057	Assy., Line to Upper Header		1	Consisting of:
13		Ell		1	Hays 9060, 1/2"
14	91716	Tube	Cop	1	5/8 x 44
15		Ell into Aux. Header		1	Hays 9060, 1/2"
16					
17	93025	Assy., Line to Upper Header		1	Consisting of:
18		Ell		1	Hays 9060, 1/2"
19	91715	Tube	Cop	1	5/8 x 50-1/2
20		Ell into Aux. Header		1	Hays 9060, 1/2"
21					
22	91126-1	Header, Auxiliary		1	

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CBr = Cast Brass
CBrz = Cast Bronze

CONTINUED
NEXT PAGE

Date Issued: 11-23-49

ASSEMBLY NO. Q-39-L
SHEET NO. 2

ENGINE MODEL Q
2 CYL. _____
3 CYL. _____
4 CYL. _____
5 CYL. _____
6 CYL. _____
8 CYL. 1 _____

ASSY NAME: Lube Oil Fittings
FIRST USED ON: 49041
ASSY DWGS: _____

It.	Part No.	Part Name	Matl	Qty	Remarks
1		Line to End Cam Bearing		1	Consisting of:
2		Connection		1	Imp 68F, 1/4T 1/4P
3		Tube	Cop	1	1/4 x 54
4		Ell into Bearing		1	Imp 69F, 1/4T 1/4P
5					
6		Line to Idler Gear		1	Consisting of:
7		Connection		1	Imp 68F, 1/4T 1/4P
8		Tube	Cop	1	1/4 x 40
9		Connection		1	68F, Imp 1/4T 1/4P
10		Sleeve		1	1/4 Blk
11		Nipple into Idler Gear		1	1/4 x close Blk
12					
13		Line to Gears		1	Consisting of:
14		Ell		1	Imp 49F, 3/8T 1/4P
15		Union Nut	Imp	1	41F, 3/8T
16		Tube	Cop	1	3/8 x 32
17		Connection		1	68F, Imp 1/4T 1/4P
18		Cross		1	1/4 Blk
19		Nipple		1	1/4 x close Blk
20		Ell, 90° Str. into G.C.		1	1/4 Blk
21		Connection		1	Imp 68F, 1/4T 1/4P
22		Tube, to Main Gears	Cop	1	1/4 x 5

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

CONTINUED
NEXT PAGE

Date Issued: 11-23-49

ASSEMBLY NO. Q-39-L
SHEET NO. 1

ENGINE MODEL Q
 2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. _____
 8 CYL. 1

ASSY NAME: Lube Oil Fittings
RH-8, (Inside Cyl. Block) w/large
Header

FIRST USED ON: 49041

ASSY DWGS: _____

It.	Part No.	Part Name	Matl	Qty	Remarks
1	95911	Header, Main	St	1	
2	95913	Flange	St	2	
3	93737-1	Gasket, Flange		2	
4	B-5659	Oil Seal		2	Natl. 55364
5		Capscrew, Flange		4	1/2 - 13 x 1-1/4
6	95914	Clamp, Eccentric	St	4	
7		Setscrew, Sock. Hd.		8	1/2 - 13 x 5/8
8		Setscrew, Sock. Hd.		4	1/2 - 13 x 1-3/4
9					
10	93058	Assy., Lines to Front Mn.Brg		1	Consisting of:
11		Coupling		1	Hays 9000, 1/2"
12	91717	Tube	Cop	1	5/8 x 33
13		Coupling		1	Hays 9000, 1/2"
14					
15	93059	Assy., Lines to Int.Mn.Brg.		⑦	EACH Consisting of:
16		Coupling		1	Hays 9000, 1/2"
17	91718	Tube	Cop	1	5/8 x 32-1/2
18		Coupling		1	Hays 9000, 1/2"
19					
20	93060	Assy., Lines to Rear Mn.Brg.		1	Consisting of:
21		Coupling		1	Hays 9000, 1/2"
22	91719	Tube	Cop	1	5/8 x 34-1/4
		Coupling		1	Hays 9000, 1/2"

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

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

CONTINUE
NEXT PAGE

Date Issued: 1-4-44
 Revised: 3-22-44
 Retyped: 4-15-49
 ENGINE MODEL Q

ASSEMBLY NO. 108-EE
 SHEET NO. 7



ASSY NAME: Tool List
 Q Engine

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	11124-6	Bracket		1	
2	11124-17	"		1	
3	11125-1	"		1	
4	11125-2	"		2	
5	11126-6	"		1	
6	11128-3	"		2	
7	11128-4	"		2	
8					
9	93199	Pre-Assy., Fixture Board		1	See Photo #11572 Consisting of:
10	1887	Tool Board		1	
11		Wood Screws		79	#12 x 3/4 long
12	11119-1	Bracket		2	
13	11122-1	"		1	
14	11126-1	"		2	
15	11126-2	"		2	
16	11126-3	"		2	
17	11126-4	"		2	
18	11126-5	"		4	
19	11126-12	"		2	
20	11126-22	"		2	
21	11126-25	"		2	
22	11128-1	"		2	

CI = Cast Iron
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 FS = Forged Steel

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

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Date Issued: 1-4-44
 Revised: 3-22-44
 Retyped: 4-15-49
 ENGINE MODEL Q

ASSEMBLY NO. 108-EE
 SHEET NO. 6

ASSY NAME: Tool List
 Q Engine

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	11117-14	Bracket		1	
2	11117-15	"		2	
3	11117-18	"		1	
4	11118-1	"		1	
5	11120-1	"		1	
6	11120-2	"		2	
7	11120-3	"		1	
8	11121-1	"		1	
9	11122-1	"		1	
10	11122-2	"		2	
11	11122-3	"		2	
12	11122-4	"		2	
13	11122-5	"		2	
14	11122-6	"		5	
15	11122-7	"		1	
16	11122-8	"		4	
17	11122-19	"		2	
18	11124-1	"		1	
19	11124-2	"		1	
20	11124-3	"		1	
21	11124-4	"		1	
22	11124-5	"		1	

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

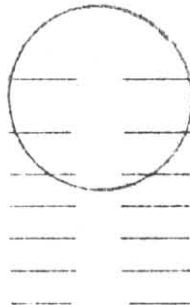
CRS = Cold Rolled Steel
 CBr = Cast Brass
 CBrz = Cast Bronze

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Date Issued: 1-4-44
 Retyped: 4-13-49

ASSEMBLY NO. 108-EE
 SHEET NO. 5

ENGINE MODEL Q
 2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. _____
 8 CYL. _____



ASSY NAME: Tool List
Q Engine

FIRST USED ON: _____

ASSY DWGS: _____

It.	Part No.	Part Name	Matl	Qty	Remarks
1	B-4377	Gun, grease		1	Alemite C-600
2	B-4378	Hose, Grease gun		1	Alemite A-1039
3	B-4379	Paint, enamel		1	Gallon.Std.shop color
4	B-4380	Pliers, Truarc #7			Supply only if Q-11-D is specified
5	93198	Pre-Assy., Tool Board		1	See Photo #11571 Consisting of:
6	1887	Tool Board		1	
7		Wood Screws		116	#12 x 3/4 long
8	11117-1	Bracket		1	
9	11117-2	"		1	
10	11117-3	"		1	
11	11117-4	"		1	
12	11117-5	"		2	
13	11117-6	"		1	
14	11117-7	"		1	
15	11117-8	"		1	
16	11117-9	"		1	
17	11117-10	"		1	
18	11117-11	"		1	
19	11117-12	"		1	
20	11117-13	"		2	
21					
22					

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

UNFINISHED
 PAGE

138-L bearing device

93188 ass., bracket

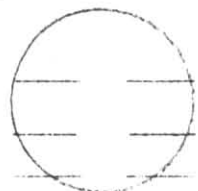
fly-wheel bearing

70

Date Issued: 1-4-44
 Retyped: 4-15-49

ASSEMBLY NO. 108-EE
 SHEET NO. 4

ENGINE MODEL Q
 2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. _____
 8 CYL. _____



ASSY NAME: Tool List
Q Engine

FIRST USED ON: _____

ASSY DWGS: _____

It.	Part No.	Part Name	Matl	Qty	Remarks	
1						
2	9399	Piston Pulling Tool	CSt	1		
3		Cap screws		2	3/4 10 x 3	
4						
5	93144-1	Lifting Plate, cyl. head	St	1	Pre-Assy 12864	
6		Washer		2		3/4 Std.
7		Cap screw		2		3/4 10 x 3-1/2
8	6817	Washer	CRS	1		
9		Eye bolt		1		1"-8
10		Nut		1	1"-8	
11						
12	B-4219	Pin Vise (fuel nozzle cleaning) Wire, Music (nozzle cleaning)		1	Starrett 162A	
13				1	See 40 Assy. Use .002 6" long undersize	
14						
15	11724-1	main bearing Bar, Capstan, con. rod,		1	1-1/8 x 36	
16						
17	1794-1	cyl. head Bar, flywheel bolt, thru bolt		1	1-1/4 x 48	
18	B-4215	Screw driver		1	M & S 4" K404	
19	B-4216	Pliers	Bonn	1	10" #B-10	
20	B-4217	Gauge feeler		1	Lufkin 109T	
21	B-4376	Oil Can (Zinc Oilers)	Perko	1	#3	
22						

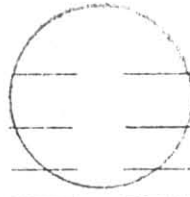
CI = Cast Iron CRS = Cold Rolled Steel
 CS = Cast Steel CBr = Cast Brass
 FS = Forged Steel CBrz = Cast Bronze

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Date Issued: 1-4-44
 Retyped: 4-15-49

ASSEMBLY NO. 108-EE
 SHEET NO. 3

ENGINE MODEL Q
 2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. _____
 8 CYL. _____



ASSY NAME: Tool List
 Q Engine

FIRST USED ON: _____

ASSY DWGS: _____

It.	Part No.	Part Name	Matl	Qty	Remarks
1					
2	92571	Pre-Assy., Valve Spring Tool		1	Consisting of:
3	11729-1	Body		1	Welded Steel
4	13009-1	Screw, Compressing		2	3/4-10 x 6-1/2
5		Nut		2	3/4-10
6		Capscrew		2	3/4-10 x 7"
7	11730	Fork, Valve Spring	CS	2	
8					
9	11829-1	Body, Valve Grinding Tool	CRS	1	Pre-Assy 12029
10	11731-2	Pin, Valve Grinding Tool		2	
11	B-4056	Drag Link Socket	Bonn	1	4002
12					
13	12561-1	Plate, piston Holder	St	1	Per cyl. 5/8-11 x 2-1/2
14		Capscrew		1	Per Cyl. 5/8-11 x 2-1/2
		Nut		1	Per cyl. 5/8-11
15					
16	1764-1	Plate, liner Puller	CI	2	
17	1764-2	Bolt, Liner Puller		1	1"-8 60" long
18		Nut, Liner Puller		1	1"-8
19	11845-1	Lifting Nut, Liner Puller		1	1"-8
20	B-4057	Eyebolt, Liner Puller		1	Vulcan #30-1"-8
21	1776	Fixture, Piston Ring	CI	1	
22					

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 FS = Forged Steel

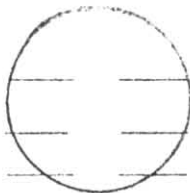
CRS = Cold Rolled Steel
 CBr = Cast Brass
 CBrz = Cast Bronze

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Date Issued: 1-4-44
 Retyped: 4-15-49

ASSEMBLY NO. 108-EE
 SHEET NO. 2

ENGINE MODEL Q
 2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. _____
 8 CYL. _____



ASSY NAME: Tool List
 Q Engine

FIRST USED ON: _____

ASSY DWGS: _____

It.	Part No.	Part Name	Matl	Qty	Remarks
1	93631-1	Socket, Cyl. Head		1	
2	93631-2	Socket, Con. Rod Brg.		1	
3	93631-4	Socket, Thru Bolt		1	
4	93631-3	Socket, Main Bearing & Fly-wheel Bolt		1	
5	B-4049	Socket, Side Door	Bonn	1	4024 3/4 Speed
6	B-4050	Handle, Socket, Side Door	Bonn	1	4085
7	B-4372	Socket, Exhaust Manif.	Bonn	1	HD-42 1-5/16
8	B-4373	Socket, Air Cage, Fuel Nozzle	Bonn	1	HD-40 1-1/4
9	B-4214	Socket, Safety Valve	Bonn	1	HD-34 1-1/16
10	B-4374	Handle, Socket, Exh. Manif. Air Cage, Safety Valve	Bonn	1	4287
11	B-5252	Wrench, Inj. Pump		1	Plomb, Slugging #USN 348 Furn. w/ FDRX Pump only
12	11719-1	Tool, Brg. Shell Removing	St	1	Forged Crankshaft
13	11720-1	Tool, Brg. Shell Removing	St	1	Cast Crankshaft
14					
15	10677-1	Stud, W.P. Seat Pull. Tool		1	SAE 4140
16	10677-2	Strongback	CRS	1	Furnish only
17		High Nut		1	5/8-11 Valve Cage is used
18					
19		Jackscrews, Air Valve Cage		2	Setscrews - cup point 5/8 - 11 x 6
20					
21	11728-1	Jacking Screws for Eng. Base		12 10	(8 cyl) (6 cyl) 1-3/4 5 x 12
22		Not supplied if sub-base is used			

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CRS = Cold Rolled Steel
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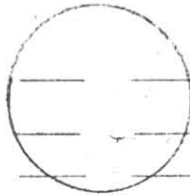
Date Issued: 1-4-44
 Retyped: 9-18-46

ASSEMBLY NO. 108-EE
 SHEET NO. 1

ENGINE MODEL Q

ASSY NAME: Tool List

2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. _____
 8 CYL. _____



Grease Gun Included, For Sailing
 Clutch, Compressor with Clutch or
 with Idler Sheave Drive.

FIRST USED ON: Q-Engine

ASSY DWGS: _____

It.	Part No.	Part Name	Matl	Qty	Remarks
1	B-4364	Wrench, zero lash retainer	Bonn	1	B072
2	13178	Bar, zero lash adjustment	CRS	1	1/2 x 1/2 x 12 (Sq. Stock)
3	B-4365	Engineers' wrench		1	Armstrong 2" #12
4	B-4366	Engineers' wrench		1	For nut 2" across flats Armstrong 2 1/4" #13-A
5	12154	Wrench, int. manif. Ell	Bonn	1	
6	B-4367	Wrench, fuel pump base	Bonn	1	HD 28 7/8"
7	B-6068	Wrench, fuel pump bleeder	Arm-	1	961J, 1/4" if Bendix
	B-4368	Wrench, fuel pump bleeder	strong	1	962H, 5/16" if Bosch
8	B-4375	Wrench, Tappet (Fuel tappet)		1	Bonney # 4290 or Plomb # 5661
9	12863-1	Wrench, locknut(Fuel tappet)	CRS	1	SAE 4140
10	11727-1	Bar, Fuel pump tappet wrench	CRS	1	
11	B-4037	Wrench, fuel contr. shaft	Bonn	1	1725-B 9/16-1/2
12	B-4369	Wrench, inj. line union nut	Bonn	1	1037 1 1/4 - 1-1/16
13	B-4370	Wrench, nozzle drain line nut	Bonn	1	1731-A 3/4 - 7/8
14	B-4038	Wrench, crescent		1	8"
15	B-4039	Wrench, crescent		1	12"
16	B-4371	Wrench, crescent		1	18"
17	B-4040	Wrench, Allen screw 5/16		1	Fits 3/8 & 7/16 Cap & 5/8 Set
18	B-4041	Wrench, Allen screw 3/16		1	Fits 1/4 Cap & 3/8 Set
19	B-4042	Wrench, Allen screw 1/2		1	Fits 5/8 Cap & 7/8 Set
20	B-4043	Wrench, Allen screw 3/8		1	Fits 1/2 Cap & 3/4 Set
21	B-4343	Wrench, Allen screw 1/8		1	Fits #8 Cap & 1/4 Set
22	B-4535	Wrench, Nozzle Nut	Bonn	1	#2813 1-7/16 & 1-5/8 Openings

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 CBr = Cast Brass
 CBrz = Cast Bronze

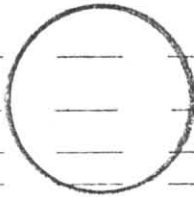
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Date Issued: 5-5-42
 Retyped: 7-7-48

ASSEMBLY NO. 104-L
 SHEET NO. _____

ENGINE MODEL Q _____

 2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. 1 _____
 8 CYL. 1 _____



ASSY NAME: Lube Tank
275 Cal.
Bayonet Gage

FIRST USED ON: 41115-24

ASSY DWGS: _____

It.	Part No.	Part Name	Matl	Qty	Remarks
1	92106-1	Tank		1	Welded Steel
2	6167-B	Cover	St	1	
3	9430-1	Screen		1	20 Mesh
4	92173-1	Tube	St	1	
5		Flanges	St	7	2" Weldolet
6	92107	Bayonet Gage Assembly		1	Consisting of:
7	92172-1	Head	CRS	1	} Welded together as 92172
8	92172-2	Rod	CRS	1	
9	92172-3	End	CRS	1	
10	75795-	Handle	CRS	1	
11	92107-1	Blade	CRS	1	
12					
13					
14					
15					
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18					
19					
20					
21					
22					

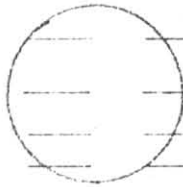
CI = Cast Iron CRS = Cold Rolled Steel
 CS = Cast Steel CBr = Cast Brass
 FS = Forged Steel CBrz = Cast Bronze

Date Issued: 9-11-42
 Retyped: 12-28-48

ASSEMBLY NO. 103-MM
 SHEET NO. _____

ENGINE MODEL _____

- 2 CYL. _____
- 3 CYL. _____
- 4 CYL. _____
- 5 CYL. _____
- 6 CYL. _____
- 8 CYL. _____



ASSY NAME: Air Tank

30x96 250 lb.

Bu. Mar. Insp. & Nav.

FIRST USED ON: 42003-22

ASSY DWGS: _____

It.	Part No.	Part Name	Matl	Qty	Remarks
1	10945-1	Tank, welded	St	1	30 x 96 250 lb.
2	B-3391	Safety Valve	BrZ	1	3/4"
3		set at 250 lb., ground special for air.			
4	B-3360	Gage, air pressure, 3 1/2" starting air pressure.		1	Bottom Connection 0-600
5					
6					
7		Bushing, safety valve	Blk	1	1-3/4
8		Nipple, safety valve		1	or extra heavy blk. 3/4 x short seamless stl
9		Plug	Blk	2	2"
10		Plug	Blk	1	1 1/2"
11		Plug	Blk	1	3/4"
12		Plug	Blk	1	1/2"
13		Plug	Blk	1	1/4"
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

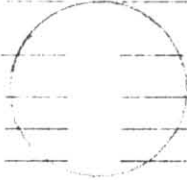
Date Issued: 9-11-42
 Retyped: 12-23-48

ASSEMBLY NO. 103-LL
 SHEET NO. _____

ENGINE MODEL _____

ASSY NAME: Air Tank
 30 x 96 250 lb.
 Bu.Mar. Insp & Nav.

2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. _____
 8 CYL. _____



FIRST USED ON: 42003-22

ASSY DWGS: _____

It.	Part No.	Part Name	Matl	Qty	Remarks
1	10958-1	Tank, welded	St	1	30x96 250 lb.
2	B-3391	Safety valve	Brz	1	3/4"
3		set at 250 lb., ground special for air.			
4	B-3360	Gage, air pressure, 3 1/2 starting air pressure.		1	Bottom Connection 0-600
5					
6		Bushing, safety valve	Blk	1	1-3/4
7		Nipple, safety valve		1	or extra heavy blk. 3/4 x short seamless stl.
8		Plug	Blk	2	2"
9		Plug	Blk	1	1 1/2"
10		Plug	Blk	1	3/4"
11		Plug	Blk	1	1/2"
12		Plug	Blk	1	1/4"
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: 8/13/43

ASSEMBLY NO. 102-FF
SHEET NO.

ENGINE MODEL Q
2 CYL. _____
3 CYL. _____
4 CYL. _____
5 CYL. _____
6 CYL. _____
8 CYL. 1

ASSY NAME: Aux.-Air Compressor
Ingersoll-Rand

FIRST USED ON: 42003

ASSY DWGS: _____

It.	Part No.	Part Name	Matl	Qty	Remarks
1	B-3997	Ingersoll Rand		1	
2		Model #242-4"x2 1/2"x2-3/4"			
3		Type 30 Air Compressor			
4		driven by a type B-254			
5		Frame 5 HP, 115-V,			
6		1750 RPM, stabilized			
7		shunt wound drip proof			
8		horizontal marine type			
9		motor, mounted on sub-			
10		base, including square			
11		D pressure switch, mag-			
12		netic starting controls,			
13		push button station and			
14		pressure unloader with			
15		ABS Spares.			
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: 8-13-43
 Retyped: 4-13-49

ASSEMBLY NO. 102-GG
 SHEET NO. _____

ENGINE MODEL Q _____
 2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. _____
 8 CYL. I _____

ASSY NAME: Aux. Air Compressor
Ingersoll-Rand

FIRST USED ON: 42003

ASSY DWGS: _____

It.	Part No.	Part Name	Matl	Qty	Remarks
1	B-4002	Ingersoll-Rand,		1	
2		5 1/2" x 2-3/4" x 5"			
3		type 20 2-stage air com-			
4		pressor driven by a 15HP			
5		type CDM-85 frame 115 V.			
6		compound wound drip-proof,			
7		vertical marine GE motor			
8		cow complete with magnetic starting			
9		controls, discharge unloader,			
10		magnetic unloader, push			
11		button station with ABS Spares.			
12					
13					
14					
15					
16					
17					
18					
19					
20					
21					
22					

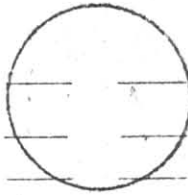
CI = Cast Iron CRS = Cold Rolled Steel
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(See individual engines spec for which pages to use)

Date Issued: 1/27/43
Retyped: 1-23-46

ASSEMBLY NO. 101-WW
SHEET NO. 17G

ENGINE MODEL Q
2 CYL. _____
3 CYL. _____
4 CYL. _____
5 CYL. _____
6 CYL. 1 _____
8 CYL. _____



ASSY NAME: Instrument Board & Gauge
(Fuel gage with pressure tank
off engine)

FIRST USED ON: 42277-96

ASSY DWGS: 92768

It.	Part No.	Part Name	Matl	Qty	Remarks
1	B-3365	Gauge, fuel oil pressure		1	3 1/2" Bott.Conn. O-60#
2	92906-1	Adaptor	CRS	1	
3		Capscrew		3	5/16 - 18 x 3/4
4		Connector	Imp	1	1/4P x 1/4T #68F
5		Tubing	Cop	1	1/4" x 17" long
6		Connector	Imp	1	1/4P x 1/4T #68F
7	B-3232	Cock Shut off	Blk	1	1/4"
8		Bushing	Blk	1	3/4" to 1/4"
9		Nipple, close	Blk	1	1/4" x close
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: 2-28-44
 Retyped: 1-6-49

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

ENGINE MODEL _____

 2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. _____
 8 CYL. _____

ASSY NAME: Instrument Board & Gauge
 Stationary - Special
 (when Cyl.Hd. Therms.Req'd.)

FIRST USED ON: _____

ASSY DWGS: _____

It.	Part No.	Part Name	Matl	Qty	Remarks
1					
2		J Halla Thermometers			
3	B-3956	Thermometers, nickel plated,			J. Halla
4		brass case, cylindrical,			
5		range 50-250° F. red spirit			
6		tube, graphite bath, brass			
7		chamber, 1/2" P.T. straight			
8		pattern Halla #S-33, for			
9		location as follows:			
10		Oil to Engine		1	
11		Oil from Engine		1	
12		Water from Engine		1	
13		Oil to Oil Cooler		1	
14		Water to Engine		1	
15		Water from each cyl.head		6	(or 8 for 8-cyl.eng.)
16					
17		If used with separate L.O.			
18		Cooler & Heat, Exhanger,		3	
19		add			
20		If combination L.O. Cooler		2	
21		& Heat, Exhanger, add			
22					
23		If supercharged add for		1	
24		water discharge			
25					
26		If used with Radiator,			
27		evaporative Cooler, etc.			
28		& separate L.O. Cooler, add		1	
29					
30		If used with Radiator with			
31		Oil Cooling Section, add		0	

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

Date Issued: 9-25-42

ASSEMBLY NO. 101WW
SHEET NO. 13C

ENGINE MODEL Q

ASSY NAME: Instrument Board

2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. _____
 8 CYL. 1 _____

FIRST USED ON: 42003-22

ASSY DWGS: 76628

It.	Part No.	Part Name	Matl	Qty	Remarks
1					
2		Bracket, Q Reversible Engine, RH			Supercharged Eng.-Large Board
3					
4	92509-1	Bracket, Gage Board	St	1	
5		Capscrew, Bkt-Blk		4	1/2-13 x 7/8
6		Capscrew, Bkt-Mtg.		4	1/2-13 x 5/8
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

See individual Eng.Specs. for which pages to use.

Date Issued: 1-28-43
Retyped: 11-12-48

ASSEMBLY NO. 101-WW
SHEET NO. 7-D

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		LARGE SIZE SOLID MOUNTED FRAME			
2	92550-1	Frame, Gauge Board		1	Welded Steel
3	92550-2	Cover, Gauge Board		1	Sheet St. 18 Gauge
4		Screw, Rd.Hd.Machine		10	10-24 x 1/2
5		Nut, Knurled	Br	10	10-24
6		Screw, Oval Hd. Machine	St	10	#8-32 x 3/8
7		Ctsk. Finish Washer		10	1/2 O.D.
8		Lockwasher		10	1/4
9		Nut. Hex		10	1/4-20
10					
11					
12	461	Stud, Board - Bracket		4	
13		Nut, Hex.Jam		12	1/2-13
14		Washer, Plain		8	1/2 Std.
15	95661	Washer, Rubber	Rub	8	
16					
17					
18					
19					
20		(See Panel Parts List for Combination Pre-Assy.Number)			
21					
22					

Pre-Assy. 77320

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

(See individual engine specs. for which pages to use)

Date Issued: 10/15/43

ASSEMBLY NO. 101-WW

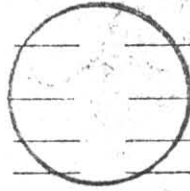
SHEET NO. 3F

(Continued)

ENGINE MODEL _____

ASSY NAME: Instrument Board & Gauge
(Bottom Conn. Gauges)

2 CYL. _____
3 CYL. _____
4 CYL. _____
5 CYL. _____
6 CYL. _____
8 CYL. _____



FIRST USED ON: 43344-55

ASSY DWGS: _____

It.	Part No.	Part Name	Matl	Qty	Remarks
1					
2		Ell intake manifold	Imp	1	49F 3/8T 1/4P
3		Union nut	Imp	1	41F 3/8T
4		Tube	Cop	1	3/8 x 15
5		Union nut	Imp	1	41F 3/8T
6		Union	Imp	1	42F 3/8T
7		Union nut	Imp	1	41F 3/8T
8		Tube	Cop	1	3/8 x 15
9		Union nut	Imp	1	41F 3/8T
10		Half Union	Imp	1	48F 3/8T 1/8P
11	B-3348	Cock, Gauge	Br	1	1/4
12		Nipple	Br	1	1/4 x close
13		Ell	Br	1	1/4
14		Nipple	Br	1	1/4 x close
15		Ell 90° into manometer	Br	1	1/4
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

(See individual engine specs. for which pages to use)

Date Issued: 10/15/43

ASSEMBLY NO. 101-WW
SHEET NO. 3F

ENGINE MODEL _____

ASSY NAME: Instrument Board & Gauge
(Bottom Conn. Gauges)

- 2 CYL. _____
- 3 CYL. _____
- 4 CYL. _____
- 5 CYL. _____
- 6 CYL. _____
- 8 CYL. _____



FIRST USED ON: 43344-58

ASSY DWGS: _____

It.	Part No.	Part Name	Matl	Qty	Remarks
		PANEL			
1		LARGE SIZE 3 1/2" W/O FUEL; W ALNOR PYROMETER; MANOMETER	SEA WATER		WITH STD ROUND
2	92912-1	PANEL, GAUGE BOARD, ON ENG.	Br	1	Bakelite 1 1/4 ga. (.064)
3		Containing the following: Tachometer		1	See Assy 115
4	B-3360	Pyrometer		1	See Assy 111
	B-3360	Starting air press 0-500		1	
	B-3361	Lube oil press 0-60		1	
	B-3362	Circ. water press 0-30		1	
	B-3364	Sea water press 0-60		1	(B-3370) Or 0-30 if cent. pump
6	B-3959	Manometer, Meriam 15" gland packed, U type as per Meriam Dwg. B1105		1	1 lb. of Mercury
8	B-3960	Mercury Above gauges to be 3 1/2"		1 Lb	Ashcroft Hanv
9		#1245-A, with bronze tube, bronze movement for air, oil and water pressure. Bottom connection 1/4" pipe thd., white figures on black dial. Service markings as indicated above. With brass restriction cock.			
10					
11					
12					
13					
14	10553-2	Plate, name		1	1/16 Blk Bakelite
15					
16		Lines inside board consisting of: Union	Imp	4	62F 1/4T
17		Ell	Imp	2	69F 1/4T 1/8P
18		Tube	Cop	1	1/4 x 12 ft.
19		Ell into cock	Imp	4	69F 1/4T 1/4P
20		Nipple from cock	Br	4	1/4 x 1
21		Ell, 90° into gage	Br	4	1/4
22		Air manif. pres line to gage board			

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

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

CONTINUED
NEXT PAGE

Date Issued: 7-28-43
 Retyped: 1-17-49

ASSEMBLY NO. Q-74-A
 SHEET NO. _____

ENGINE MODEL Q
 2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. 1
 8 CYL. 1



ASSY NAME: Fuel Tank Bracket
 (Turbocharged)
BF-44 Supercharger
 FIRST USED ON: _____
 ASSY DWGS: _____

It.	Part No.	Part Name	Matl	Qty	Remarks
1	92968-1	Bracket	St	1	
2		Capscrews		2	3/4-10 x 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

B-3546

Turbocharger

BF-44

CANCELLED

IDENTICAL TO B-3544

FIRST USED ON:

ENGINE NO.

PARTS LIST

ALTERATIONS

ITEM	PART NAME	QTY.	MATERIAL

ENTERPRISE ENGINE & FOUNDRY CO.
SAN FRANCISCO, CALIFORNIA

DWG. NAME Turbocharger BF-44

DRAWN 11-16-45 AF

CHECKED

APPROVED

B-3546

PART & DWG. NO.

Date Issued: 2-12-44

ASSEMBLY NO. Q-72-J
SHEET NO. 2

ENGINE MODEL Q

2 CYL. _____
3 CYL. _____
4 CYL. _____
5 CYL. _____
6 CYL. _____
8 CYL. 1



ASSY NAME: Supercharger Mounting
~~Elliott X-810684 DP44 R.H. Eng.~~
~~Air Cooled Ex. Man. 8 Cyl.~~

FIRST USED ON: 43137-150

~~CODE 44482-26~~

ASSY DWGS: 93444

It.	Part No.	Part Name	Matl	Qty	Remarks
1	11548-1	Name Plate, Bush	RBr	1	Furnished by Elliot Co.
2		Screw		4	3-32 x 5/8
3	CAT. No 002345	JENSON, PUMP OIL, (REPLACEMENT)		1	ELLIOTT CO. - H.R. BUSHLEY 418 VANCE BLDG.
4	92839	Pre-Assy., Exhaust Conn.		1	Consisting of:
5		Exhaust connector		1	} Pre-Assy., 79580 Welded Assy. Dwg. 76259-1
6	76259-2	Pipe "A" R.H.	CS	1	
7	76259-3	Pipe "A" L.H.	CS	1	
8	76259-4	Pipe "B" R.H.	CS	1	
9	76259-5	Pipe "B" L.H.	CS	1	
10	76259-7	Flange 1" thick	St	1	
11	76147-1	Pyrometer Connection	CRS	4	
12	77357-2	Brace	St	2	3/32 x 2 x 6-1/8
13	77238-2	Brace	St	4	3/32 x 2 x 5
14	76706-1	Nut	CRS	6	
15	79148-1 76259-6	Gasket		1	1/16 Garlock 7508
16	77247-1 77247-2	Cover, outside Cover, inside	W.St W.St	1 1	
17		Capscrew, cover to Conn.		6	1/2-13 x 3 1/2
18	76716-1	Washer	St	6	
19		Capscrew, Between halves		8	3/8-16 x 3/4
20					
21		Nut	Br	12	5/8-11
22	515	Stud, con. to superch.		12	

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

Date Issued: 2-12-44

ASSEMBLY NO. Q-72-J
SHEET NO. 1

ENGINE MODEL Q
 2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. _____
 8 CYL. 1

ASSY NAME: Supercharger Mounting
 Elliott X-810624-BF44-R.H. Eng.
 Air Cooled Ex. Man, 8 Cyl.

FIRST USED ON: 43137-150

CODE-BF-44-42826

ASSY DWGS: 93444

It.	Part No.	Part Name	Matl	Qty	Remarks
					B-5501 Oil Tank B-5501-2 Oil Piping
1	B-5408	Elliott Supercharger, BF-44		1	See individual Engine Specs for "B" number
2	77142-1	Adapter, Exhaust, Out	St	1	Welded (Moved to G-57-1)
3	77142-2	Gasket to Supercharger		1	3/16 thick asbestos
4	77142-3	Gasket to Exhaust		1	3/16 thick asbestos
5		Capscrew, adapter-supercharger		16	$\frac{1}{2}$ -13 x $1\frac{1}{4}$
6	76238-1	Adapter Superch'r.-Bracket	CI	1	
7		Capscrew		4	3/4-10 x 1-3/4
8	607	Studs Turbocharger		4	
9		Nuts		4	3/4-10
10		Lockwasher		4	3/4-Medium
11	76253-2	Shims, Sup'ch'r. Adapter	St	2	
12	93160-1	Bracket	CI	1	
13	79152-1 92114-2	Gasket, to supercharger		1	3/32 Gar. #660
14	93429-1 92115-2	Gasket to Cyl. Block Air Man.		1	3/32 Gar. 660
15	607	Studs, Cyl. Block		12	
16		Nuts		12	3/4-10
17		Lockwasher		12	3/4 Medium
18		Bolts, to supercharger		12	$\frac{1}{2}$ -13 x $2\frac{1}{2}$
19		Nuts		12	$\frac{1}{2}$ -13
20		Pipe Plug	Br	1	1" Male
21		Pipe Plug	Br	1	3/4 Male
22		Capscrews to Cyl. Block		10	1/2-13 x 1-3/4

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

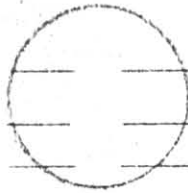
CRS = Cold Rolled Steel
 CBr = Cast Braes
 CBrz = Cast Bronze

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Date Issued: 12-2-42
Retyped: 1-13-49

ASSEMBLY NO. Q-71-C
SHEET NO. 3

ENGINE MODEL Q
2 CYL. _____
3 CYL. _____
4 CYL. _____
5 CYL. _____
6 CYL. _____
8 CYL. 1 _____



ASSY NAME: Revolution Counter

FIRST USED ON: 42003-22

ASSY DWGS: _____

It.	Part No.	Part Name	Matl	Qty	Remarks
1	93419-1	Gasket, brkt.gear case		1	1/32 vel.
2		Capscrews		4	1/2-13 x 1-1/4
3	106-5	Dowel		2	
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: 12/2/42

ASSEMBLY NO. Q-71-C
SHEET NO. 2

ENGINE MODEL Q
2 CYL. _____
3 CYL. _____
4 CYL. _____
5 CYL. _____
6 CYL. _____
8 CYL. 1



ASSY NAME: Revolution Counter

FIRST USED ON: 42003-22

ASSY DWGS: _____

It.	Part No.	Part Name	Matl	Qty	Remarks
1	76170-2 79880-1	Gasket, housing-housing		1	1/32
2	101-1	Setscrew	St	2	1/4-20 x 1/2 cone point
3		Capscrew		4	3/8-16 x 3/4
4	76207-1	Shaft rev. counter drive	St	1	
5		Nut Castle		1	1/2-13
6		Pin, cotter		1	1/16 x 1 1/2
7		Key, woodruff		1	1/8 x 1/2
8		Pin, cotter		1	3/32 x 1
9	B-3888	Lockwasher		1	N-H W-00
10	B-3889	Locknut		1	NH N-00
11		Washer	St	1	1/2 SAE
12	B-3275	Bearing ball, grease sealed		1	Norma Hoffman 77010
13	B-3274	Bearing ball, grease sealed		1	Norma Hoffman 9017-D
14	The following parts are supplied by Speedometer Service:				
15		Worm Gear, Boston D-1121	Brz	1	RH for RH Eng.
16		Worm Gear, Boston HDSH		1	RH for RH Eng.
17		Counter, Veeder Root		1	V 236
18	76239-1	Cover, rev. counter hsg.		1	White Bakelite
19		Screws, FH machine		6	5-40 x 1/4
20		Screw, RH machine		4	6-32 x 3/8
21		Lockwasher		4	#6
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: 12/2/42

ASSEMBLY NO. C-71-C
SHEET NO. 1

ENGINE MODEL Q

- 2 CYL. _____
- 3 CYL. _____
- 4 CYL. _____
- 5 CYL. _____
- 6 CYL. _____
- 8 CYL. 1 _____



ASSY NAME: Revolution Counter
CCW Rotation LH eng. for RH single engine installation.

FIRST USED ON: 42003-22

ASSY DWGS: 92258

It.	Part No.	Part Name	Matl	Qty	Remarks
1					
2	92642	Pre Assy Rev. Counter		1	See Assy. Dwg. 92258 Consisting of
3	91841-1	Bracket	CI	1	Pre-Assy 94134
4	10649-2	Bushing		1	
5	91843-1	Shaft	CRS	1	
6	91842-1	Gear tach. drive	CI	1	
7		Taper Pin		1	No. 1 x 1" lg.
8	92211-1	Gear, counter drive	St	1	Stressproof
9		Taper Pin		1	No. 1 x 15/16 lg.
10	92212-1	Gear, counter driven	St	1	Stressproof
11	92251-1	Bushing		1	Johnson KR 124
12	93432-1	Housing, gear	CI	1	Use Patt 76206
	92251-2	Gasket		1	1/32 Vel
13		Capscrew		4	3/8-16 x 1
14		Bushing		1	Johnson KR-124
15	B-5646 B-3730	Oil Seal		1	National #50119-S
16	6263-A	Connecting Flange	CI	1	
17	77958-1 6263-B	Gasket		1	1/32 Vel
18		Capscrew		3	3/8-16 x 1
19	76210-1	Cover	CI	1	
20	79879-1 76210-2	Gasket		1	1/32 Vel
21		Capscrew		4	1/4-20 x 5/8
22	76170-0	Housing, rev. counter	CI	1	

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

CRS = Cold Rolled Steel
CBR = Cast Bronze
CBRz = Cast Bronze

**CONTINUED
NEXT PAGE**

Date Issued: 11-28-41
 Retyped: 12-14-48

ASSEMBLY NO. G-70-S
 SHEET NO. _____

ENGINE MODEL Q
 2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. 1
 8 CYL. 1

ASSY NAME: Fuel Filter
Briggs 1000-1200 HP
 FIRST USED ON: 41115-24
 ASSY DWGS: _____

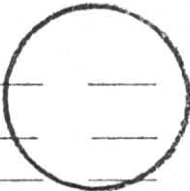
It.	Part No.	Part Name	Matl	Qty	Remarks
1	B-3484	Filter-strainer unit, fuel		1	Briggs per BP 1557
2		oil, consisting of duplex			Model DF-TI:S4-100A
3		full flow Turulator strainer			
4		and simplex 4-element absorb-			
5		ent type Briggs filter, complete			
6		unit in tank with necessary			
7		pipng and valves. 3-way			
8		valves marked to show direction of			
9		flow. Unit to be arranged for			
10		mounting to floor of engine room.			
11					
12					
13					
14					
15					
16		Replacement Information			
17	B-3723	Element (Absorbent)			
18	B-3746	" (Metal)			
19					
20					
21					
22					

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

Date Issued: 11-4-43
 Retyped: 10-8-46

ASSEMBLY NO. G-69-DDD
 SHEET NO. _____

ENGINE MODEL _____
 2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. _____
 8 CYL. _____



ASSY NAME: Lube Filter
 Pres. Line, Bailey, Duplex, CI,
 60 Mesh, 30 GPM
 FIRST USED ON: _____
 ASSY DWGS: _____

It.	Part No.	Part Name	Matl	Qty	Remarks
1	B-3426	Strainer, Duplex, CI		1	Bailey
2		body and cap, type CI			
3		size 2 $\frac{1}{2}$, number 200, 2 $\frac{1}{2}$ "			
4		std. flanged, clamped bon-			
5		net, 50 lb. working pres-			
6		sure, lube oil service,			
7		60 mesh monel baskets 2-			
8		way plug. Strainer to be			
9		tagged showing mesh size			
10					
11					
12					
13					
14					
15					
16					
17		Replacement information			
18	B-3602	Strainer Baskets			
19					
20					
21					
22					

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

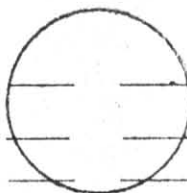
For Complete Replacement use G-69-Y5

Date Issued: 12-6-43
 Retyped: 11-20-46

ASSEMBLY NO. G-69-FFF
 SHEET NO. _____

ENGINE MODEL G _____

2 CYL. _____
 3 CYL. _____
 4 CYL. _____
 5 CYL. _____
 6 CYL. 1 _____
 8 CYL. 1 _____



ASSY NAME: Lube Filter
 C.S. Strainer
 2" Flanged 20 Mesh.

FIRST USED ON: 42003-22

ASSY DWGS: _____

It.	Part No.	Part Name	Matl	Qty	Remarks
1					
2	31041-1	Pre-Assy., 2" Strainer			Consisting of: 4
3	30958-1	Body, Strainer	C.S.	1	
4	31047-1	Basket, Strainer	CBr	1	Pre-Assy. 31070
5	31048-1	Wire Screen	Br	1	
6	32633 3155-3	Clamp, Strainer	C.S.	1	
7	32630 3155-4	Cover, Strainer	C.S.	1	Except Matl. CS
8	32629 3155-10	Gasket	Vel	1	1/32
9	32631 3155-5	Spring, Strainer		1	Spring Wire
10	32632 3155-6	Clamp Screw } Pre-Assy. & Dwg. #31617	CRS	1	3/4 Dia. x 2-3/4
11	32628 3155-7		Handle	CRS	
12		Pipe Plug		1	1/2"
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