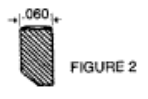
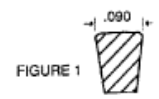


When ordering replacement piston ring assemblies, refer to Notes listed below:  
 NOTE #1 The enclosed assemblies contain 12 Keystone piston rings as shown in figure 1.  
 NOTE #2 The enclosed assemblies contain 6 Keystone piston rings (top) as shown in figure 1 and 6 Rectangular piston rings (bottom) as shown in figure 2.



Parts List								
Ref	Class	Part	Description	Qty	Comment	Footnote		
1	455	8745A 5	CRANKSHAFT ASSEMBLY	1				
2	30	67923	BEARING, Ball (LOWER)	1				
3	53	67446	RING	1				
4	43	99727A 1	DRIVE GEAR	1	(OIL INJECTION)			
5		54196A 6	CARRIER ASSEMBLY	1				
6		65800	PACKING	1		4,2		
7	39	67377	RING, SEALING	AR	(.124 THICK)			
7	39	78633	RING, SEALING	AR	(.139 THICK)			
8	31	88903	ROLLER BEARING	2				
9	53	67444	RETAINING RING	2				
10	31	67445	ROLLER BEARING	2				
11	765	7441A 3	PISTON	3	(STARBOARD-STANDARD)			
11	765	7443A 2	PISTON	AR	(STARBOARD - .015 O.S.)			
11	765	7445A 2	PISTON	AR	(STARBOARD -.030 O.S.)			
11	765	7442A 3	PISTON	3	(PORT-STANDARD)			
11	765	7444A 2	PISTON	AR	(PORT -.015 O.S.)			
11	765	7446A 2	PISTON	AR	(PORT -.030 O.S.)			
12	39	78807A12	PISTON RING	1	(SEE NOTE #1 ON ILLUSTRATIC			
12	39	93481A12	PISTON RING	1	(SEE NOTE #2 ON ILLUSTRATIC			
12	39	78918A 4	PISTON RING	1	(.015 O.S.)			
12	39	85636A 4	PISTON RING	1	(.030 O.S.)			
13	40	52035	RING, Lock	12				
14	636	8119A 5	CONNECTING ROD ASSEMBLY	6				
15	10	93886	SCREW, (.3125-28 X .875)	12				
15	10	76349	SCREW, (.3125-24 X 1.00)	12				
16	12	47247	WASHER	12				
17	31	17514A 1	BEARING KIT	6				
18	29	67483	NEEDLE BEARING	174				
-	27	90484A88	GASKET SET	1	SN# ME-6042946/MA-6038681 &			
-	27	79583A81	GASKET SET	1	SN# 5866777 THRU 6042945			
-		NLA	No Longer Available, Gasket Set	1	(Service Bulletin 81-8) SN# ME-5813			