



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.



FIGURE 1



FIGURE 2

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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		2,3
7	39	67377	RING, SEALING	AR	(.124 THICK)	
7	39	78633	RING, SEALING	AR	(.139 THICK)	
8	31	93495	ROLLER BEARING	2	(1 PIECE)	
8	31	88903	ROLLER BEARING	2	(2 PIECE)	
8	31	67445	ROLLER BEARING	2	(2 PIECE)	
9	53	67444	RETAINING RING	2		
10	766	8666A 3	PISTON ASSEMBLY	3	(Starboard-Standard) SN# 661875	
10		NLA	No Longer Available, Piston Assembl	AR	(Starboard-.030 Oversize SN# 661	
10	766	8667A 3	PISTON ASSEMBLY	3	(Port-Standard) SN# 6618751 & U	
10		NLA	No Longer Available, Piston Assembl	AR	(Port-.030 Oversize) SN# 6618751	
10	765	7441A 3	PISTON	3	(Starboard-Standard) SN# 661875	
10	765	7443A 2	PISTON	AR	(Starboard-.015 Oversize SN# 661	
10	765	7445A 2	PISTON	AR	(Starboard-.030 Oversize) SN# 661	
10	765	7442A 3	PISTON	3	(Port-Standard) SN# 6618750 & B	
10	765	7444A 2	PISTON	AR	(Port-.015 Oversize) SN# 661875C	
10	765	7446A 2	PISTON	AR	(Port-.030 Oversize) SN# 661875C	
11	39	813011A12	PISTON RING	1	(Standard) SN# 6618751 & Up	
11	39	90264A 4	PISTON RING	3	(.030 Oversize) SN# 6618751 & U	
11	39	78807A12	PISTON RING	1	(Standard-Use with 2 Ring Piston)[	
11	39	67376A12	PISTON RING	2	(Standard-Use with 3 Ring Piston)[	
11	39	93481A12	PISTON RING	1	(Standard)[See Note #2 On Illustrate	
11	39	78918A 4	PISTON RING	1	(.015 Oversize) SN# 6618750 & B	
11	39	85636A 4	PISTON RING	1	(.030 Oversize) SN# 6618750 & B	
12	40	52035	RING, Lock	12		
13	636	8119A 5	CONNECTING ROD ASSEMBLY	6		
14	10	93886	SCREW, (.3125-28 X .875)	12		
14	10	76349	SCREW, (.3125-24 X 1.00)	12		
15	12	47247	WASHER	12		
16	31	17514A 1	BEARING KIT	6		
17	29	67483	NEEDLE BEARING	174		
-	27	11338A88	GASKET SET, Engine Overhaul	1	SN# 6618751 & Up	
-	27	79583A81	GASKET SET	1	SN# 5875204 THRU 6618750	
-		NLA	No Longer Available, Gasket Set	1	(Service Bulletin 81-8) SN# USA-5	