

IO-540-K1H5 Series Illustrated Parts Catalog

November 1983

Engine model IO-540-K1K5, previously covered in this parts catalog, has been superseded by PC-615-K1K5.

PC-615-2

LYCOMING

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652 Oliver Street
Williamsport, PA 17701

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TECHNICAL PUBLICATION SUPPLEMENT

REVISION No.	PUBLICATION	PUBLICATION No.	PUBLICATION DATE
PC-615-2C K1H5 Supplement	IO-540-K1K5 Engines	PC-615-2	NOVEMBER 1983
The page(s) furnished herewith are intended to be used in conjunction with the existing page(s) of the publication indicated above.			
Previous revisions to this publication		This supplement consists of: -	
<u>JUNE, 1985</u> PC-615-2A (IO-540-K1K5 Revision) Pages 1-7, 2-3, 2-4, 2-6, 3-1, 3-2, 3-6, 3-7, 3-8, 4-1, 4-2, 8-1, 8-2, 8-3, 8-4 <u>FEBRUARY, 2003</u> PC-615-2B (IO-540-K1K5 Revision) Parts Supersedures ... - Figure 1, Page 1-1 - Figure 2, Page 1-3 - Figure 3, Page 1-5 - Figure 4, Page 1-7 - Figure 5, Page 1-9 - Figure 8, Page 1-15 - Figure 10, Page 2-3 - Figure 12, Page 2-6 - Figure 14, Page 3-1 - Figure 15, Page 3-3 - Figure 16, Page 3-5 - Figure 17, Page 3-7 - Figure 19, Page 5-1 - Figure 21, Page 5-3 - Figure 22, Page 6-1 - Figure 23, Page 6-3		<u>FEBRUARY, 2003 (K1H5)</u> These Figures are to be used in conjunction with PC-615-2 Parts Catalog Illustrations: - Figure 1 – Crankcase Assembly - Figure 2 – Oil Level Gage & Engine Mtg. Brackets - Figure 3 – Crankcase Related Parts - Figure 4 – Crankshaft & Related Parts - Figure 5 – Camshaft & Related Parts - Figure 6 – Propeller Governor Drive Assembly - Figure 10 – Oil Pump Assembly & Accy. Attaching - Figure 12 – Oil Filter Assembly & Cooler Bypass Valve - Figure 14 – Connecting Rods, Pistons & Ring Assys. - Figure 15 – Cylinder Assembly - Figure 16 – Valve Assembly - Figure 17 – Cylinder Related Parts - Figure 19 – Alternator Assembly & Belt - Figure 21 – Alternator Mounting & Attaching - Figure 22 – Oil Sump & Induction Housing Assembly - Figure 23 – Intake Pipes & Air Inlet Housing These Figures have been added to show differences between the K1K5 and the K1H5 engine models: - Figure 7 – Crankshaft Idler Gears - Figure 8 – Crankcase Attaching Parts - Figure 9 – Accessory Housing Assembly - Figure 11 – Fuel Pump Assembly - Figure 13 – Vacuum Pump Drive & Cover, Oil Cooler & Breather Fittings - Figure 13A – Hydraulic Pump Drive & Covers - Figure 18 – Magnetos, Drives, Harnesses & Plugs - Figure 20 – Starter Assembly and Attaching - Figure 24 – Fuel Injector, Manifold & Injection Nozzles - Figure 24A – Fuel Injector, Manifold & Injection Nozzles	

INTRODUCTION

This illustrated parts catalog contains a complete parts listing for the Avco Lycoming IO-540-K1K5 wide cylinder flange model aircraft engines.

Major assembly and sub-assembly parts of the engines are listed in the Group Assembly sections in the general sequence of engine build up.

A Service Kits section and Oversize and Undersize Parts List are included to aid in ordering parts as necessary during overhaul.

The Numerical Index is provided for convenience in finding parts when only the part number is known.

Parts coverage of Vendor Accessories used on Avco Lycoming engines may be found in the appropriate Vendor's Parts Catalog. A list of these publications appear in the latest edition of Service Letter No. L114.

NOTE

The illustrations, pictures and drawings shown in this publication are typical of the subject matter they portray.

This catalog, when used in conjunction with the appropriate overhaul manual, shall be used for parts identification only. Under no circumstances shall this catalog be used as an assembly or installation document.

Any reference in this document to a suppliers/parts manufacturers' product, by name, trademark, part number or other description is solely for the purposes of identification and does not indicate or infer that Avco Lycoming accepts responsibility for quality control and/or airworthiness of parts which do not pass through the Avco Lycoming quality control system.

SERVICE BULLETINS, INSTRUCTIONS AND LETTERS

Although the information contained in this parts catalog is up-to-date at time of publication, users are urged to keep abreast of later information through all Avco Lycoming distributors or from the factory by subscription. Consult the latest edition of Service Letter No. L114 for subscription information.

HOW TO ORDER PARTS

In ordering parts for your engine, observe the following instructions which will expedite shipment of correct parts required without delay.

- a. Always specify the model and serial number of your engine.
- b. Always specify Part Number, Nomenclature and quantity required.

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Oversize and Undersize Parts Listing

PART NO.	DESCRIPTION	OVERSIZE							UNDERSIZE		
		P02	P05	P10	P15	P20	P30	P50	M03	M06	M10
		.002	.005	.010	.015	.020	.030	.050	.003	.006	.010
66670	BUSHING		X	X							
66713	GUIDE		X	X		X	X				
66796	INSERT			X							
69796	DOWEL		X								
71894	SEAT			X		X	X				
71903	BUSHING, Counterweight	SEE LATEST EDITION OF SERVICE INSTRUCTION NO. 1143 FOR APPLICATION.									
72155-S	BUSHING		X	X	X	X					
72897	GUIDE		X	X		X	X				
73810	BUSHING	SEE LATEST EDITION OF SERVICE INSTRUCTION NO. 1142 FOR APPLICATION.									
73857	RING			X		X					
74241	RING			X							
75656-S	BUSHING		X	X	X	X					
75657-S	BUSHING		X	X		X					
LW-12688	SEAT			X		X	X				
LW-13885	BEARING								X	X	X
LW-14830	BEARING								X	X	X
LW-15628	SEAL							X			
STD-1065	DOWEL	X	X	X	X						

Studs available in P03, P07 and P12.

NOTE

When ordering oversize and undersize parts, be sure to specify the required oversize and undersize dimension along with the proper part number. For example, to order bearing LW-13885 in .003 undersize, order part number LW-13885-M3. Oversize code letter is "P" while undersize code letter is "M". These letters are then followed by the number designating the size in thousandths of an inch.

**CRANKCASE, CRANKSHAFT AND CAMSHAFT GROUP
CRANKCASE ASSEMBLY**

FIG. REF. 1	PART NUMBER	DESCRIPTION	QUANTITY PER ASSEMBLY
1	11F24020-S1	CRANKCASE ASSEMBLY	1
2	31C-12	STUD, 5/16-18 x 1-1/2 long	2
3	31C-13	STUD, 5/16-18 x 1-5/8 long	1
4	38-13	STUD, 3/8-16 x 1-5/8 long	24
5	38-16	STUD, 3/8-16 x 2.00 long	8
6	38-22	STUD, 3/8-16 x 2-3/4 long	1
7	38D-17	STUD, 3/8-16 x 2-1/8 long, drilled	1
8	50-15	STUD, 1/2-20 x 1-7/8 long	12
9	LW-13794	STUD, 5/16-18 x 1.00 long, drilled	1
10	69796	DOWEL, Crankshaft bearing	2
11	STD-514	DOWEL, 5/16 dia. x 1/2 long	2
12	STD-557	DOWEL, 1/2 dia. x 11/16 long, hollow	2
13	STD-1339	PLUG, 1/16-27 NPT, Allen head	1
14	1102	PLUG, 1/8-27 NPT, Allen head	4
15	65007	-- DOES NOT APPLY TO THIS MODEL --	
16	72158	BUSHING, Governor drive idler shaft	1
17	31C-14 *	STUD, 5/16-18 x 1-3/4 long	4
	31C-16 **	STUD, 5/16-18 x 2.00 long	4
18	73772	NOZZLE ASSY., Piston cooling	6

* Used on IO-540-K1K5 engines.

** Used on IO-540-K1H5 engines.

- IMPORTANT -**Use in conjunction with PC-615-2: IO-540-K1K5 Series Parts Catalog, Figure 1 Illustration, Page 1-2.**

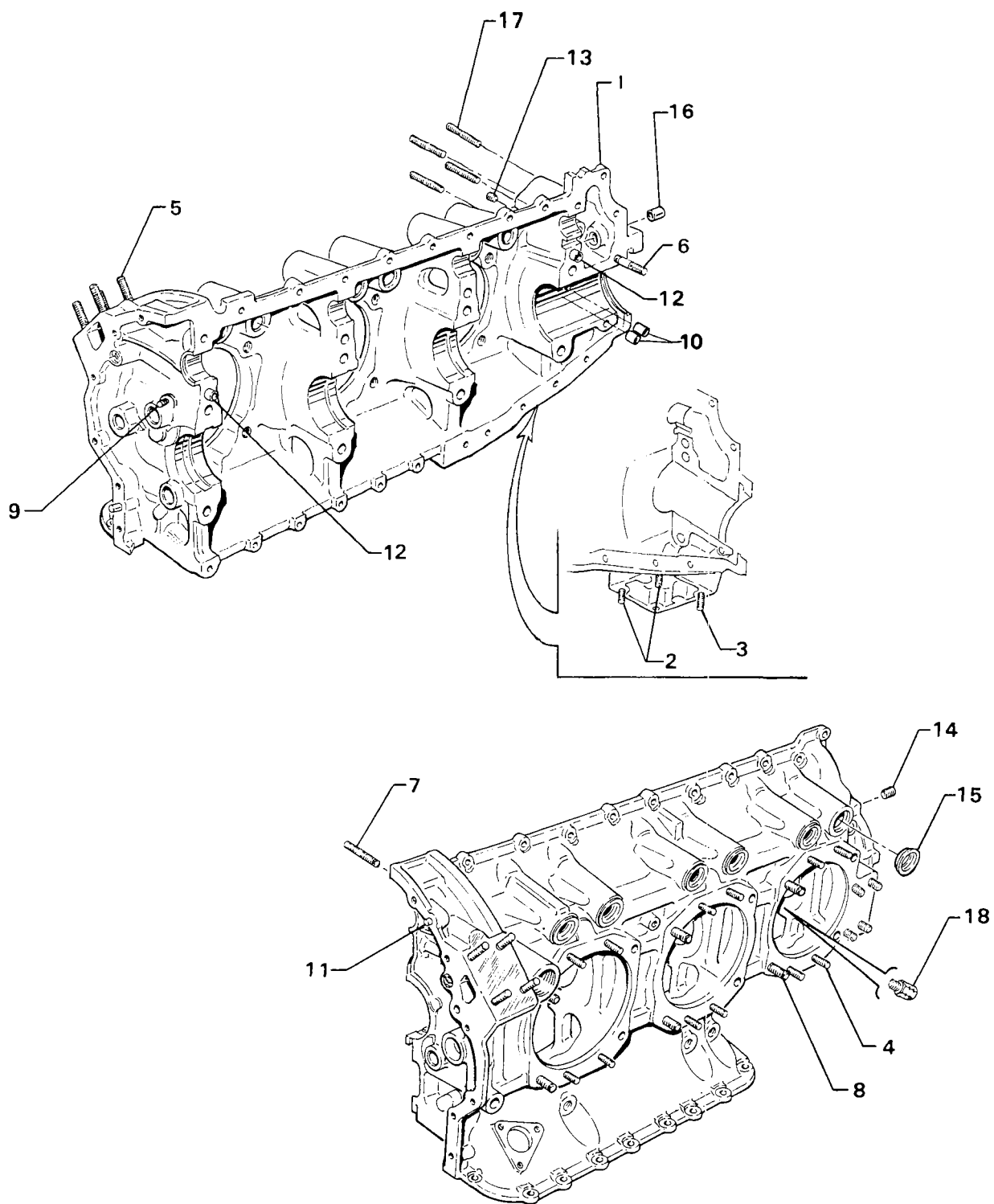


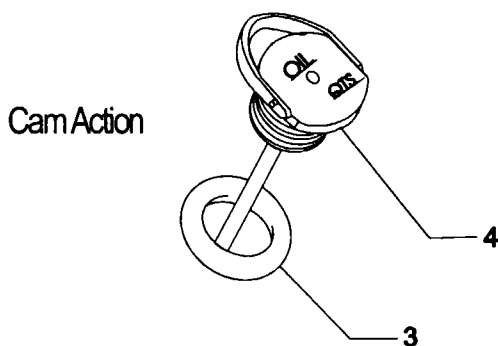
Figure 1. CRANKCASE ASSEMBLY

**CRANKCASE, CRANKSHAFT AND CAMSHAFT GROUP
OIL LEVEL GAGE AND ENGINE MOUNTING BRACKETS**

FIG. REF. 2	PART NUMBER	DESCRIPTION	QUANTITY PER ASSEMBLY
1	70457	GASKET, Oil filler extension	1
2	75675 *	EXTENSION, Oil filler (short)	1
	77527 **	EXTENSION, Oil filler (2-3/16 long)	1
3	74065 *	"O" RING, Oil level gage	1
	72312 **	"O" RING, Oil level gage	1
4	LW-14770 *	GAGE ASSY., Oil level	1
	LW-14729 **	GAGE ASSY., Oil level (cam action)	1
5	12A19770 **	BRACKET, Engine mounting (dynafocal)	4
	70456 **	BRACKET, Engine mounting (dynafocal)	4
6	STD-33	WASHER, 3/8 plain	16
7	STD-678	WASHER, 3/8 lock, internal teeth	16
8	STD-596	NUT, 3/8-24 plain	16

* Used on IO-540-K1K5 engines.

** Used on IO-540-K1H5 engines.

- IMPORTANT -**Use in conjunction with PC-615-2: IO-540-K1K5 Series Parts Catalog, Figure 2 Illustration, Page 1-4.**

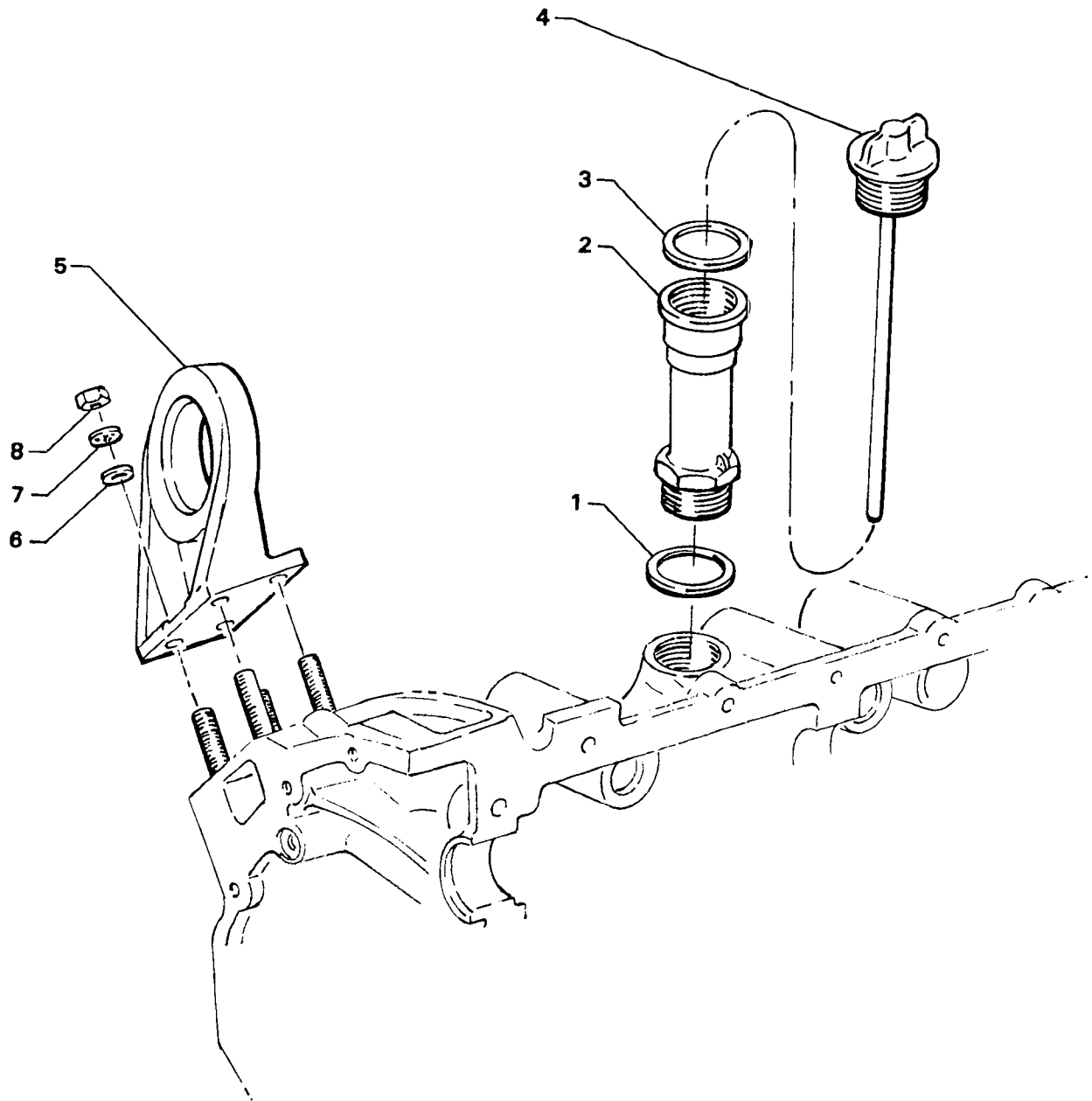


Figure 2. OIL LEVEL GAGE AND ENGINE MOUNTING BRACKETS

**CRANKCASE, CRANKSHAFT AND CAMSHAFT GROUP
CRANKCASE RELATED PARTS**

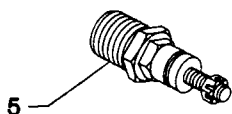
FIG. REF. 3	PART NUMBER	DESCRIPTION	QUANTITY PER ASSEMBLY
1	1028-B	BALL, 11/16 diameter	1
2	68668 *	SPRING, Oil pressure relief valve	1
	61084 *	SPRING, Oil pressure relief valve	1
	77467 *	SPRING, Oil pressure relief valve	1
	LW-11713 *	SPRING, Oil pressure relief valve	1
	LW-18085 *	SPRING, Oil pressure relief valve	1
3	STD-425	-- DOES NOT APPLY TO THIS MODEL --	
4	06E19769-1.25	GASKET, 1-1/4 I.D. x 1-1/2 O.D. x 3/32 annular	1
5	77808	VALVE ASSY., Oil pressure relief, adjustable	1
6	LW-14830	BEARING, Crankshaft	6
	18E22677	BEARING, Crankshaft (alternate)	6
7	LW-13885	BEARING, Crankshaft, front	2
	18A19399	BEARING, Crankshaft, front (alternate)	2
8	LW-15628 **	SEAL, Crankshaft oil, solid	1
	78443 **	SEAL, Crankshaft oil, split	1
9	72091	RING, Oil seal, 23/64 I.D. x 7/64 dia. section	2
10	72877	BODY, Hydraulic tappet	12

* Select spring to give a minimum of three threads exposed on adjusting screw to allow field adjustment. Reference latest edition of SSP-1776, Part 1 for spring identification.

** See latest edition of Lycoming Service Instruction No. 1324 for installation.

- IMPORTANT -

Use in conjunction with PC-615-2: IO-540-K1K5 Series Parts Catalog, Figure 3 Illustration, Page 1-6.



P/ N 77808 Valve Assy.

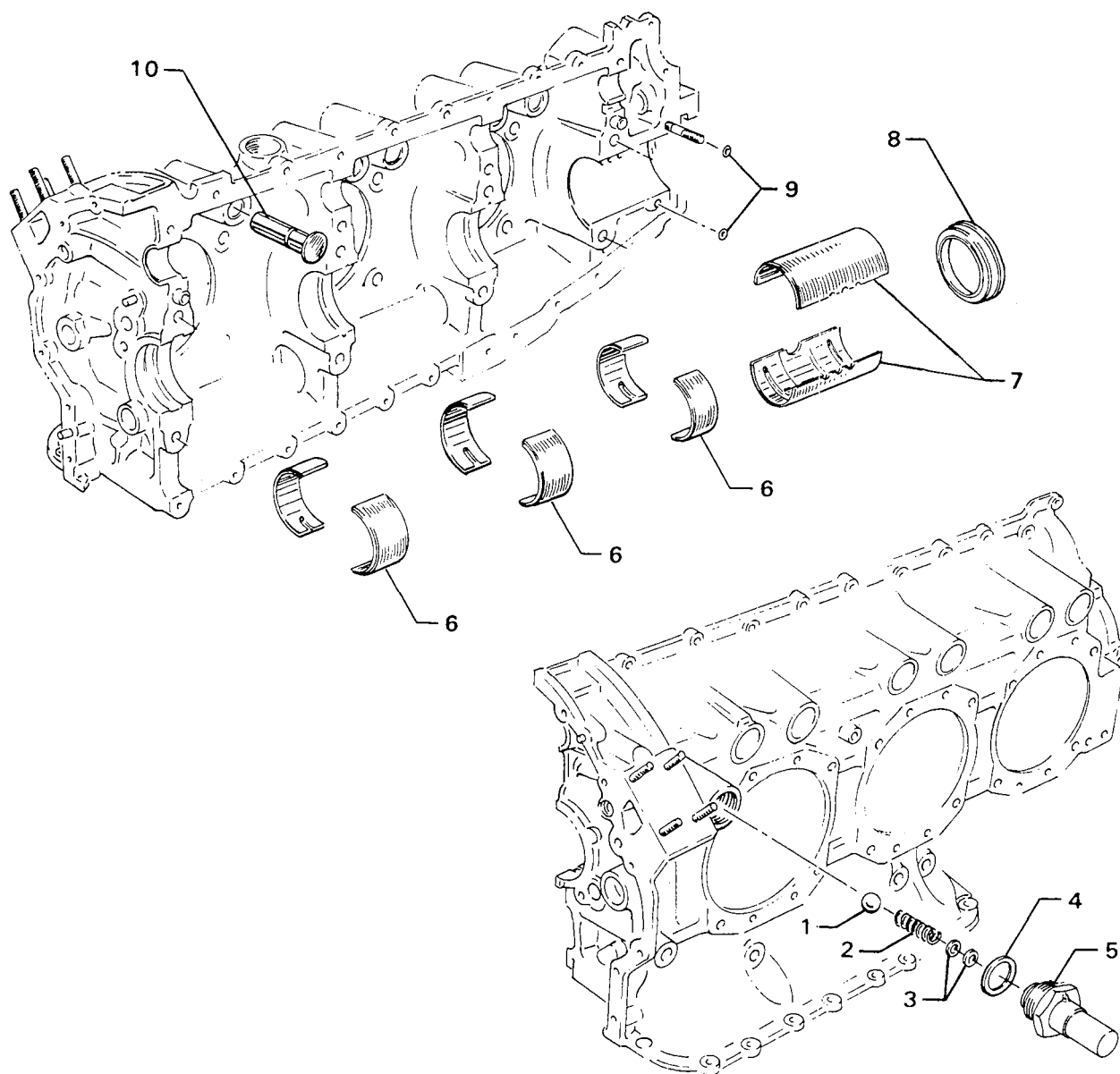


Figure 3. CRANKCASE RELATED PARTS

**CRANKCASE, CRANKSHAFT AND CAMSHAFT GROUP
CRANKSHAFT AND RELATED PARTS**

FIG. REF. 4	PART NUMBER	DESCRIPTION	QUANTITY PER ASSEMBLY
1	05K37777 *	KIT, CRANKSHAFT & COUNTERWEIGHT ASSY.	1
2	13F37727 *	CRANKSHAFT AND BUSHING ASSY.	1
3	STD-1211	PLUG, 2.00 dia. expansion	1
4	73810 **	BUSHING, Crankshaft dynamic counterweight	4
5	60945	PLUG, 1-1/4 diameter	1
6	75656-S	BUSHING, Propeller flange, long	4
7	72155-S	BUSHING, Propeller flange, short	1
8	75657-S	BUSHING, Propeller flange, indexing	1
9	STD-1065	DOWEL, Stepped, 5/16 & 1/4 dia. x 35/64 long	1
10	LW-19210 ■	COUNTERWEIGHT ASSY.	2
11	71903-A ●	BUSHING, Dynamic counterweight	8
12	73648 ■	ROLLER, Dynamic counterweight, 5.1 order	2
13	76788 ■	ROLLER, Dynamic counterweight, 6.3 order	2
14	LW-14820	RING, Internal retaining	8
15	71907	WASHER, Dynamic counterweight	8
16	13S19647 ♦	GEAR, Crankshaft	1
17	LW-18638	LOCKPLATE, Crankshaft gear	1
18	STD-2247 □	BOLT, 5/16-24 x 1-3/4 long, hex. head	1
19	LW-16471	SUPPORT ASSY., Starter ring gear, 12/14 pitch	1
20	72566	GEAR, Starter ring	1

- * P/N 05K27777 replaced by P/N 05K37777 **KIT, CRANKSHAFT & COUNTERWEIGHT ASSY.**
P/N 13F37727 CRKSHFT & BUSHING ASSY. supersedes P/N 13F27727 CRKSHFT & PLUG ASSY.
- ** See latest edition of Lycoming Service Instruction No. 1142 for application.
- See latest edition of Lycoming Service Instruction No. 1012 for application.
- See latest edition of Lycoming Service Instruction No. 1143 for application.
- ♦ See latest edition of Lycoming Service Bulletin No. 475 for application.
- P/N STD-2247 BOLT supersedes P/N STD-2209 BOLT.

- IMPORTANT -

Use in conjunction with PC-615-2: IO-540-K1K5 Series Parts Catalog, Figure 4 Illustration, Page 1-8.

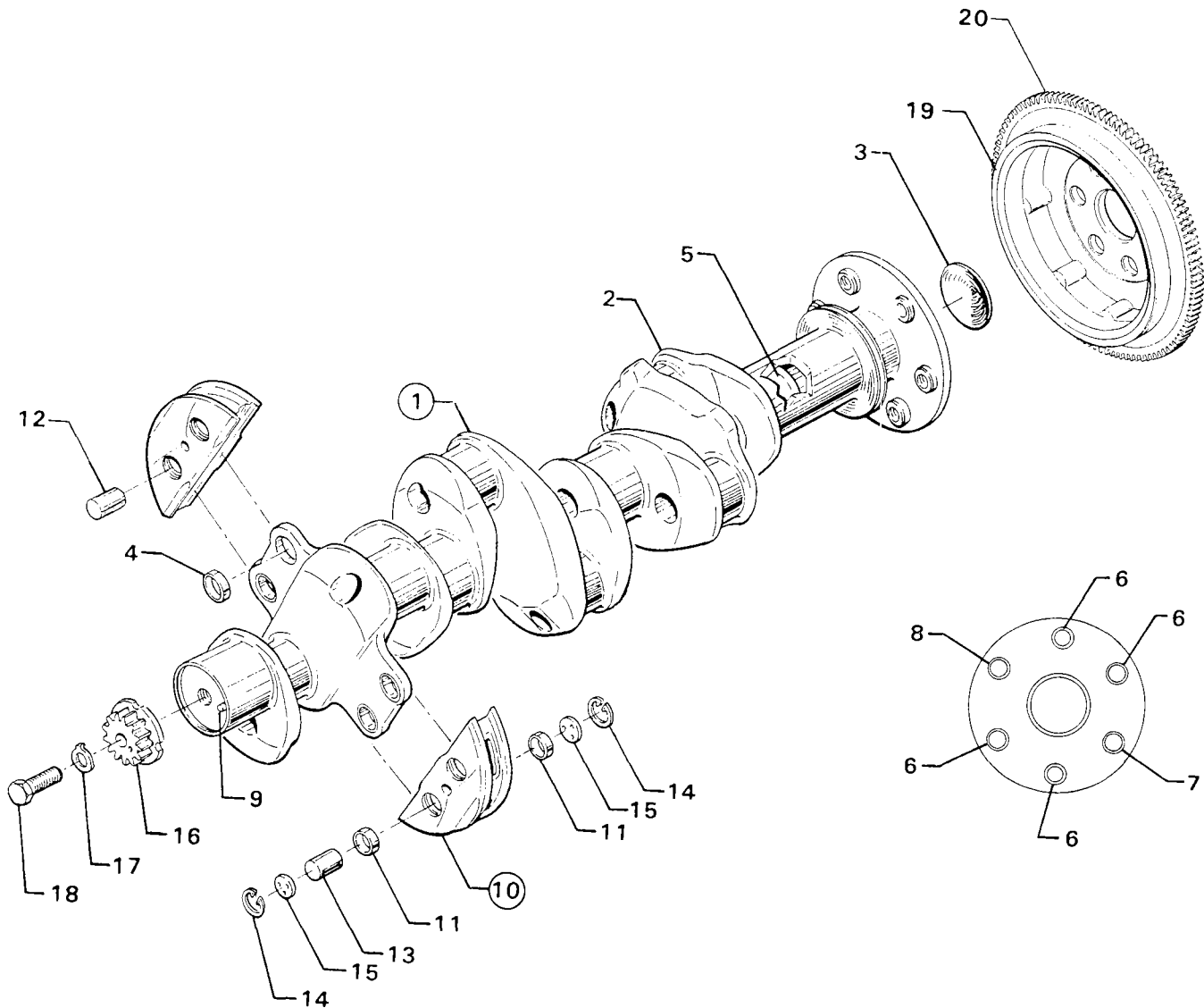


Figure 4. CRANKSHAFT AND RELATED PARTS

**CRANKCASE, CRANKSHAFT AND CAMSHAFT GROUP
CAMSHAFT AND RELATED PARTS**

FIG. REF. 5	PART NUMBER	DESCRIPTION	QUANTITY PER ASSEMBLY
1	LW-19340	CAMSHAFT ASSY.	1
2	76155	SHAFT ASSY., Tachometer	1
3	LW-18667	PIN, 3/16 x 2-21/64 long	1
4	76118	SPACER, Tachometer shaft centering	1
5	STD-2231	RING, Internal retaining	1

- IMPORTANT -

Use in conjunction with PC-615-2: IO-540-K1K5 Series Parts Catalog, Figure 5 Illustration, Page 1-10.

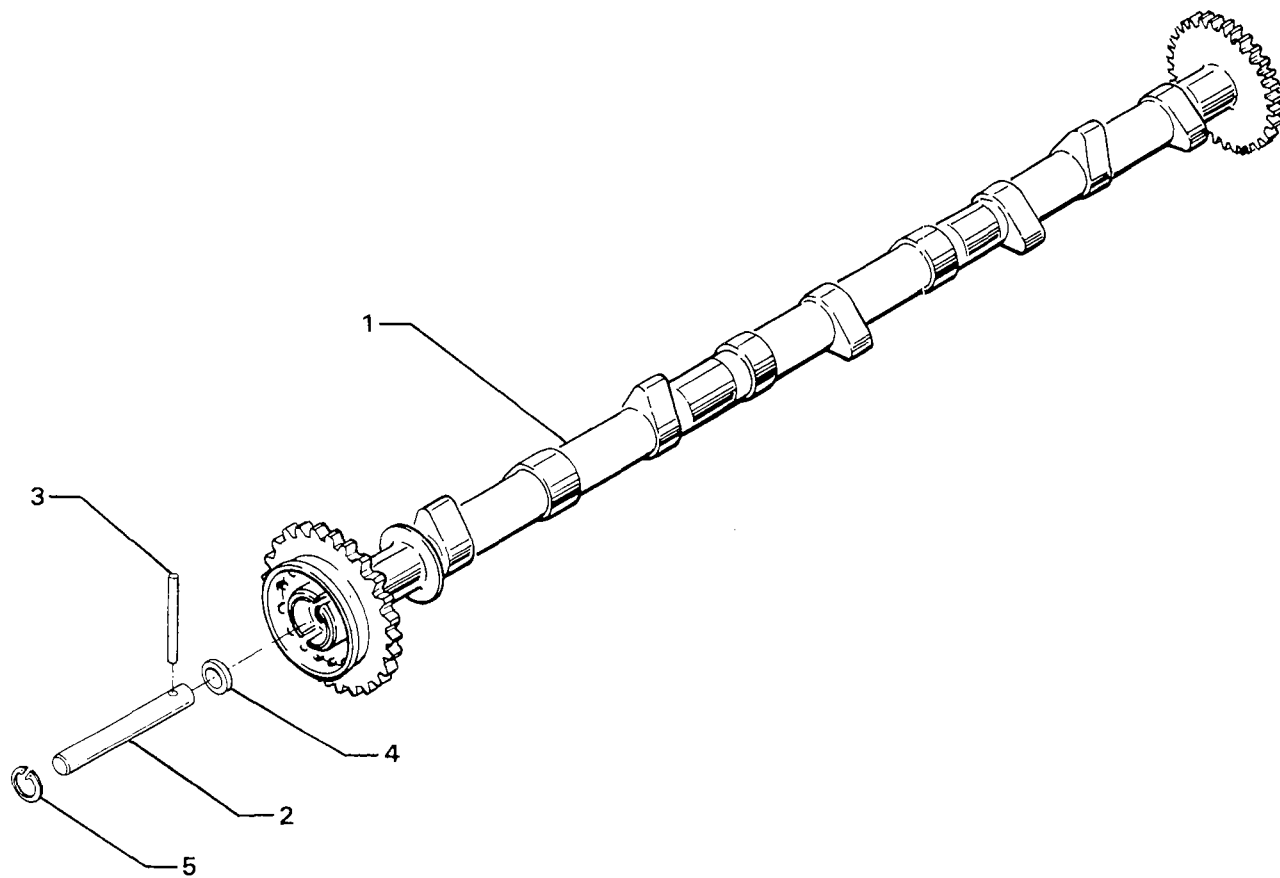


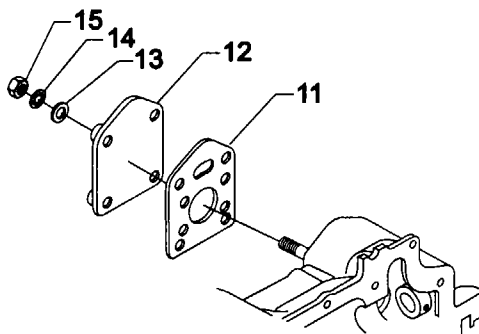
Figure 5. CAMSHAFT AND RELATED PARTS

**CRANKCASE, CRANKSHAFT AND CAMSHAFT GROUP
PROPELLER GOVERNOR DRIVE ASSEMBLY**

FIG. REF. 6	PART NUMBER	DESCRIPTION	QUANTITY PER ASSEMBLY
1	LW-10442	GEAR, Propeller governor driven	1
2	LW-14021	SHAFT, Propeller governor idler gear	1
3	LW-10541	GEAR ASSY., Propeller governor idler	1
4	77872	BUSHING, Propeller governor idler gear	2
5	STD-19	DOWEL, 3/32 dia. x 7/32 long	1
6	STD-798	DOWEL, 3/32 dia. x 9/32 long	1
7	73249	WASHER, Thrust (.0585 - .0595 thick)	AR
	73250	WASHER, Thrust (.062 - .063 thick)	AR
	73251	WASHER, Thrust (.0655 - .0665 thick)	AR
	73252	WASHER, Thrust (.069 - .070 thick)	AR
	01L21418	WASHER, Thrust (.055 - .056 thick)	AR
8	AN565B1032H5	SET SCREW, No. 10-32 x 5/16 long	1
9	70455	GASKET, 25/32 I.D. x 1-1/8 O.D. x 1/32 thick	1
10	LW-13896	PLUG, 3/4-16 hex head	1
11	72053	GASKET, Governor	1
12	72378	COVER, Governor drive	1
13	STD-35	WASHER, 5/16 plain	20
14	STD-475	WASHER, 5/16 lock, internal teeth	4
15	STD-1410	NUT, 5/16-18 plain	4

- IMPORTANT -

Use in conjunction with PC-615-2: IO-540-K1K5 Series Parts Catalog, Figure 6 Illustration, Page 1-12.



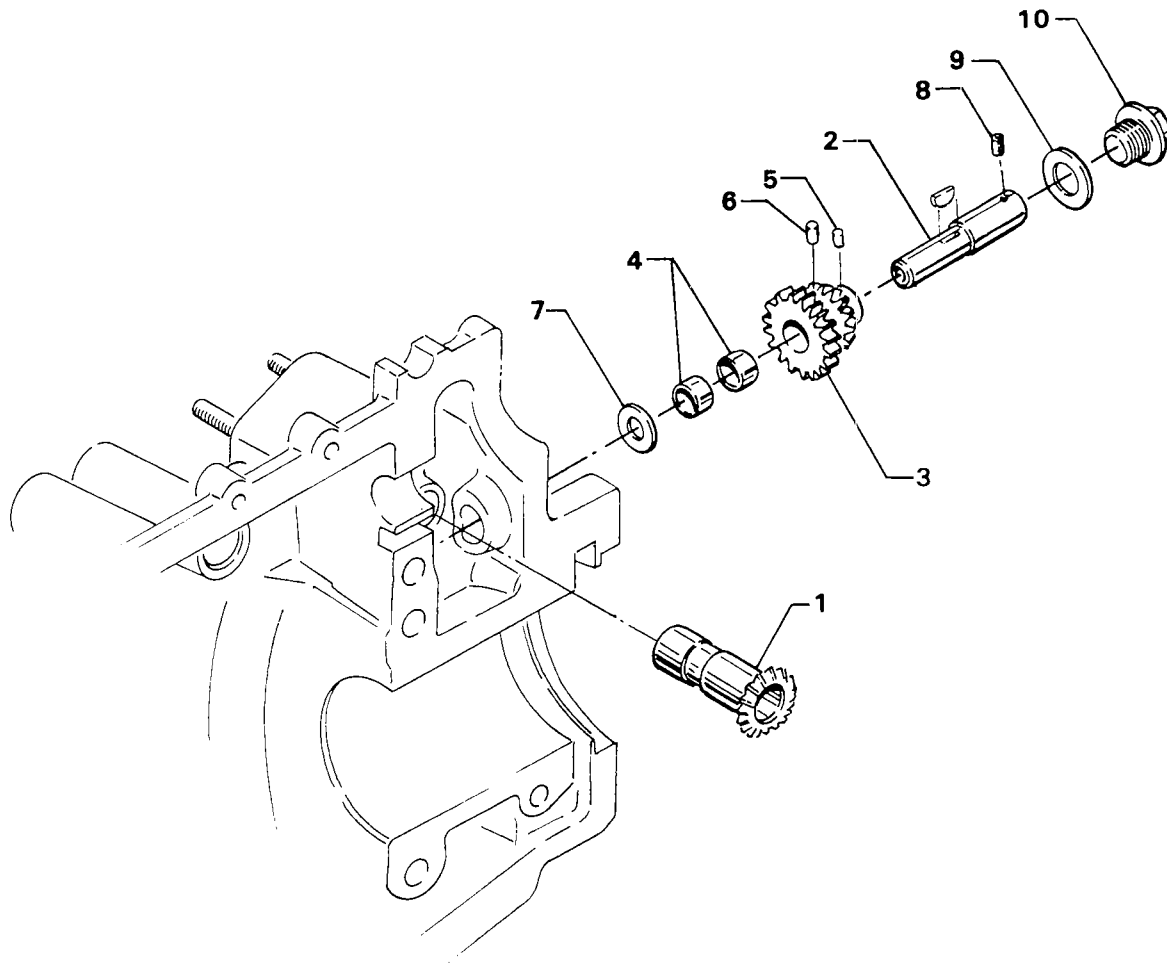


Figure 6. PROPELLER GOVERNOR DRIVE ASSEMBLY

**CRANKCASE, CRANKSHAFT AND CAMSHAFT GROUP
CRANKSHAFT IDLER GEARS**

FIG. REF. 7	PART NUMBER	DESCRIPTION	QUANTITY PER ASSEMBLY
1	61544	PLUNGER, Fuel pump, long	1
2	71652	GEAR ASSY., Crankshaft idler	1
3	67530	BUSHING, Crankshaft idler gear	1
4	71668	GEAR ASSY., Crankshaft idler, plain	1
5	67530	BUSHING, Crankshaft idler gear	1
6	LW-13795	SHAFT, Crankshaft idler gear	2
7	LW-31H0.88	BOLT, 5/16-18 x 7/8 long, hex. hd., dr.	3
8	STD-2168	NUT, 5/16-18 NC-3 slotted shear	1

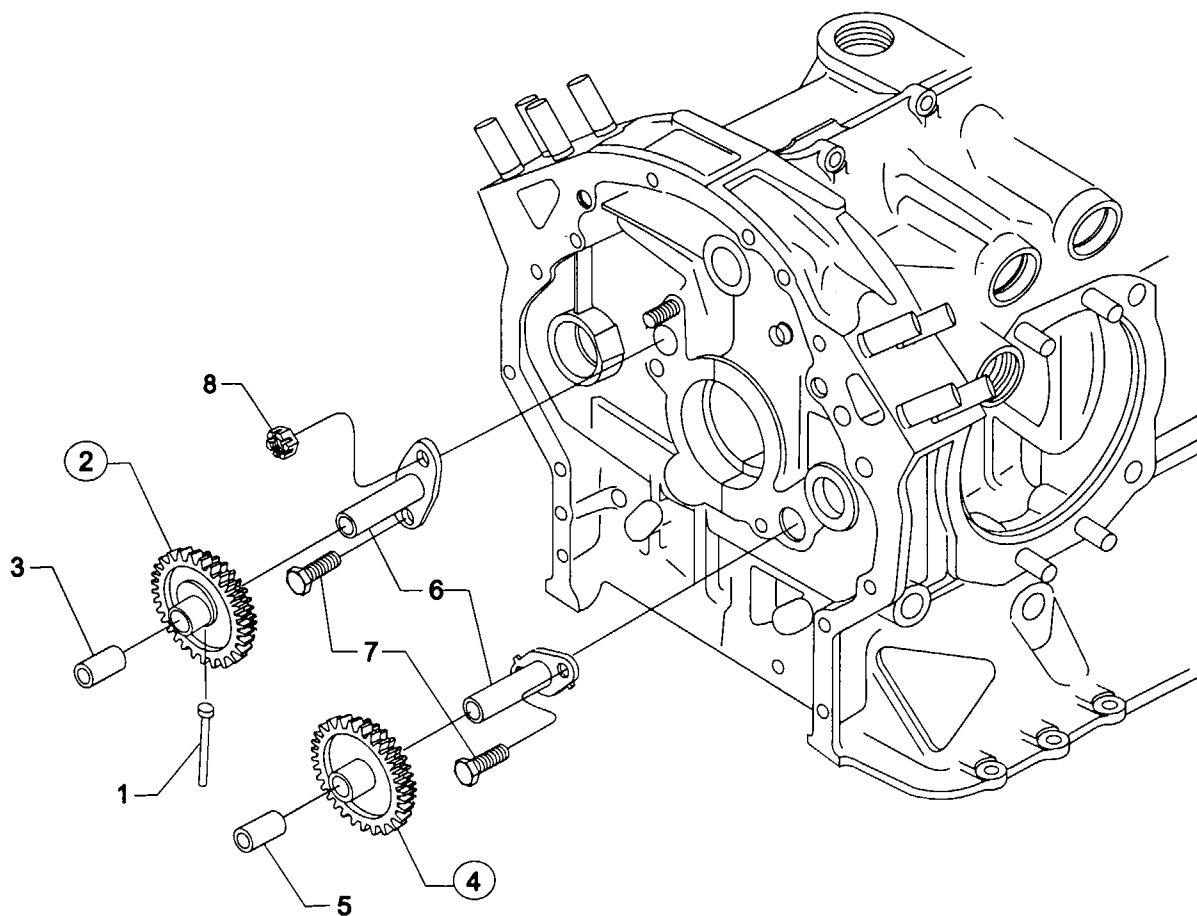
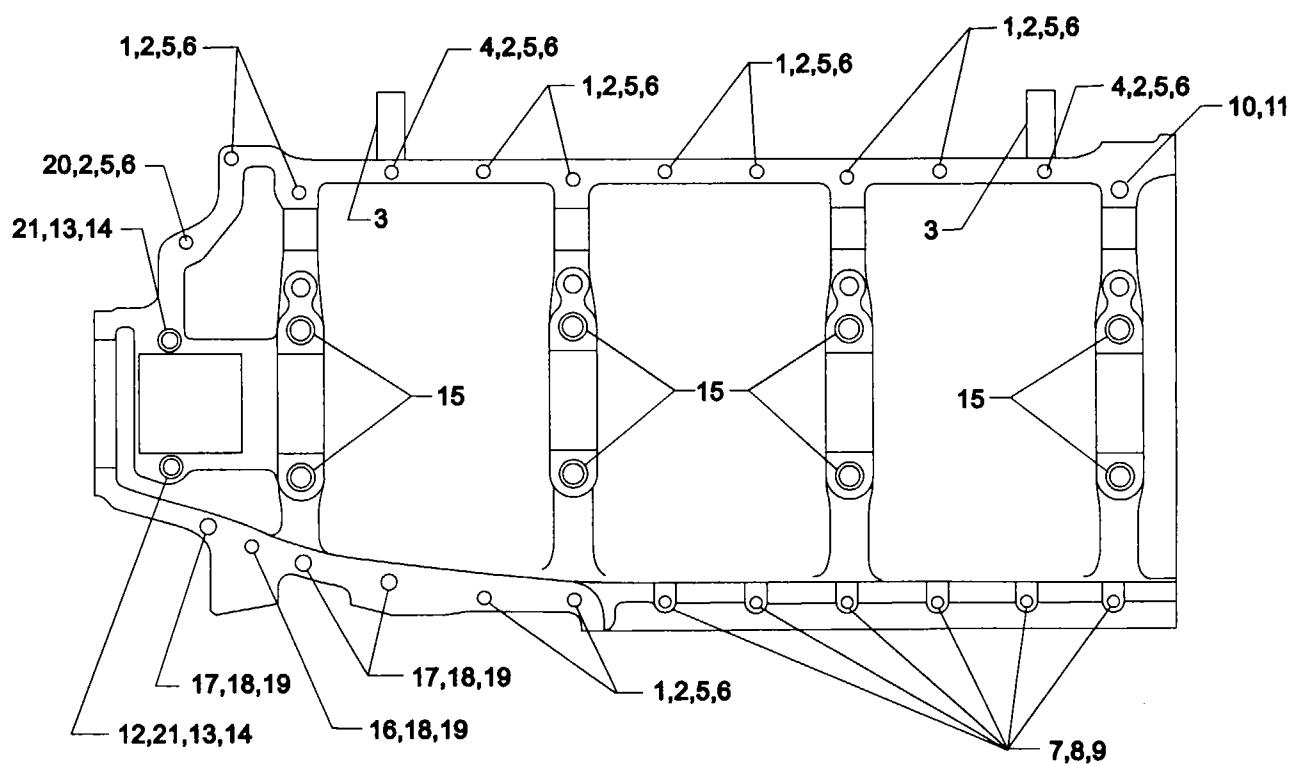


Figure 7. CRANKSHAFT IDLER GEARS

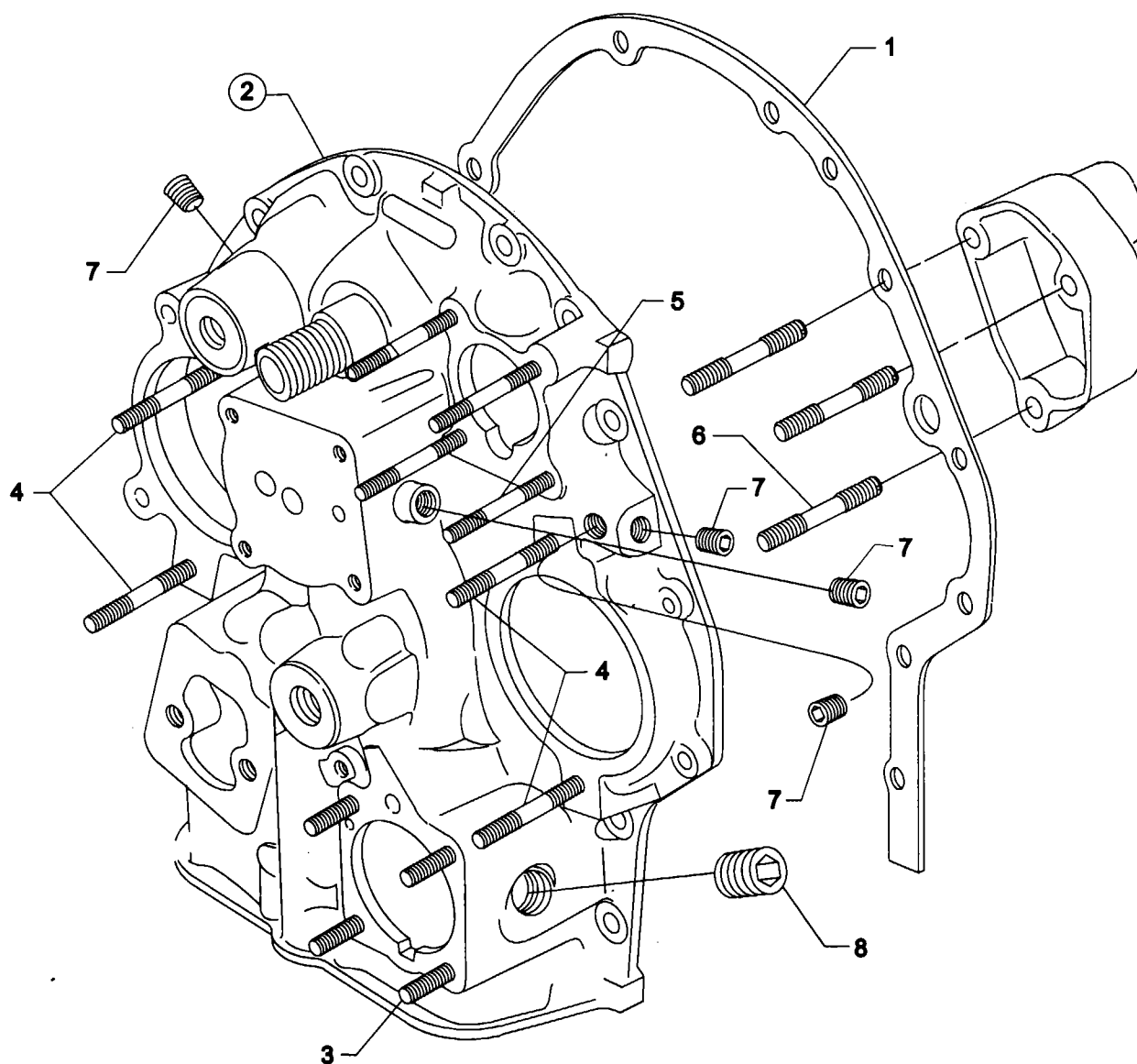
**CRANKCASE, CRANKSHAFT AND CAMSHAFT GROUP
CRANKCASE ATTACHING PARTS**

FIG. REF. 8	PART NUMBER	DESCRIPTION	QUANTITY PER ASSEMBLY
1	LW-25-1.50	BOLT, 1/4-20 x 1-1/2 long, hex. hd.	11
2	STD-8	WASHER, 1/4 plain	24
3	60803	STRAP, Lifting	2
4	LW-25-1.75	BOLT, 1/4-20 x 1-3/4 long, hex. hd.	2
5	STD-160	WASHER, 1/4 lock, internal teeth	13
6	STD-1411	NUT, 1/4-20 plain	12
7	LW-25S1.50	BOLT, 1/4-20 x 1-1/2 long, dr. end	6
8	STD-8	WASHER, 1/4 plain	18
9	STD-2249	NUT, 1/4-20 slotted shear	6
10	STD-33	WASHER, 3/8 plain	1
11	STD-872	NUT, 3/8-24 slotted	1
12	AN6-34A	BOLT, 3/8-24 x 3-37/64 long, hex. hd.	1
13	STD-678	WASHER, 3/8 lock, internal teeth	2
14	STD-596	NUT, 3/8-24 plain	2
15	76220	STUD, 1/2-20 x 10-45/64 long	8
16	LW-31-2.75	BOLT, 5/16-18 x 2-3/4 long, hex. hd.	1
17	LW-31-1.16	BOLT, 5/16-18 x 1-5/32 long, hex. hd.	3
18	STD-35	WASHER, 5/16 plain	4
19	STD-475	WASHER, 5/16 lock, internal teeth	4
20	LW-25-1.13	BOLT, 1/4-20 x 1-1/8 long, hex. hd.	1
21	STD-33	WASHER, 3/8 plain	3

**Figure 8. CRANKCASE ATTACHING PARTS**

**ACCESSORY HOUSING AND RELATED PARTS
ACCESSORY HOUSING ASSEMBLY**

FIG. REF. 9	PART NUMBER	DESCRIPTION	QUANTITY PER ASSEMBLY
1	73818	GASKET, Accessory housing	1
2	21C21539-02	HOUSING ASSY., Accessory	1
3	31C-12	STUD, 5/16-18 x 1-1/2 long	4
4	31C-21	STUD, 5/16-18 x 2-5/8 long	4
5	25C-21	STUD, 1/4-20 x 2-5/8 long	4
6	31CD-17	STUD, 5/16-18 x 2-1/8 long, drilled	3
7	1102	PLUG, 1/8-27 NPT, Allen hd.	4
8	STD-784	PLUG, 3/8-18 NPT, Allen hd.	1

**Figure 9. ACCESSORY HOUSING ASSEMBLY**

ACCESSORY HOUSING AND RELATED PARTS
OIL PUMP ASSEMBLY AND ACCESSORY HOUSING ATTACHING PARTS

FIG. REF. 10	PART NUMBER	DESCRIPTION	QUANTITY PER ASSEMBLY
1	78531	BODY ASSY., Oil pump	1
2	LW-18110 *	IMPELLER ASSY., Oil pump driven	1
3	74641	SHAFT, Oil pump drive	1
4	LW-18109 *	IMPELLER, Oil pump driving	1
5	STD-35	WASHER, 5/16 plain	3
6	STD-1420	NUT, 5/16-18 slotted	3
7	LW-14260	SEAL, Tachometer drive, oil	1
8	STD-8	WASHER, 1/4 plain	12
9	STD-160	WASHER, 1/4 lock	12
10	LW-25-0.94	BOLT, 1/4-20 x 15/16 long, hex. head	9
11	LW-25-1.13	BOLT, 1/4-20 x 1-1/8 long, hex. head	1
12	LW-25-1.44	BOLT, 1/4-20 x 1-7/16 long, hex. head	2

* To insure impellers are replaced together, oil pump impellers available in kit form only (P/N 05K19423-S) .

- IMPORTANT -

Use in conjunction with PC-615-2: IO-540-K1K5 Series Parts Catalog, Figure 10 Illustration, Page 2-4.

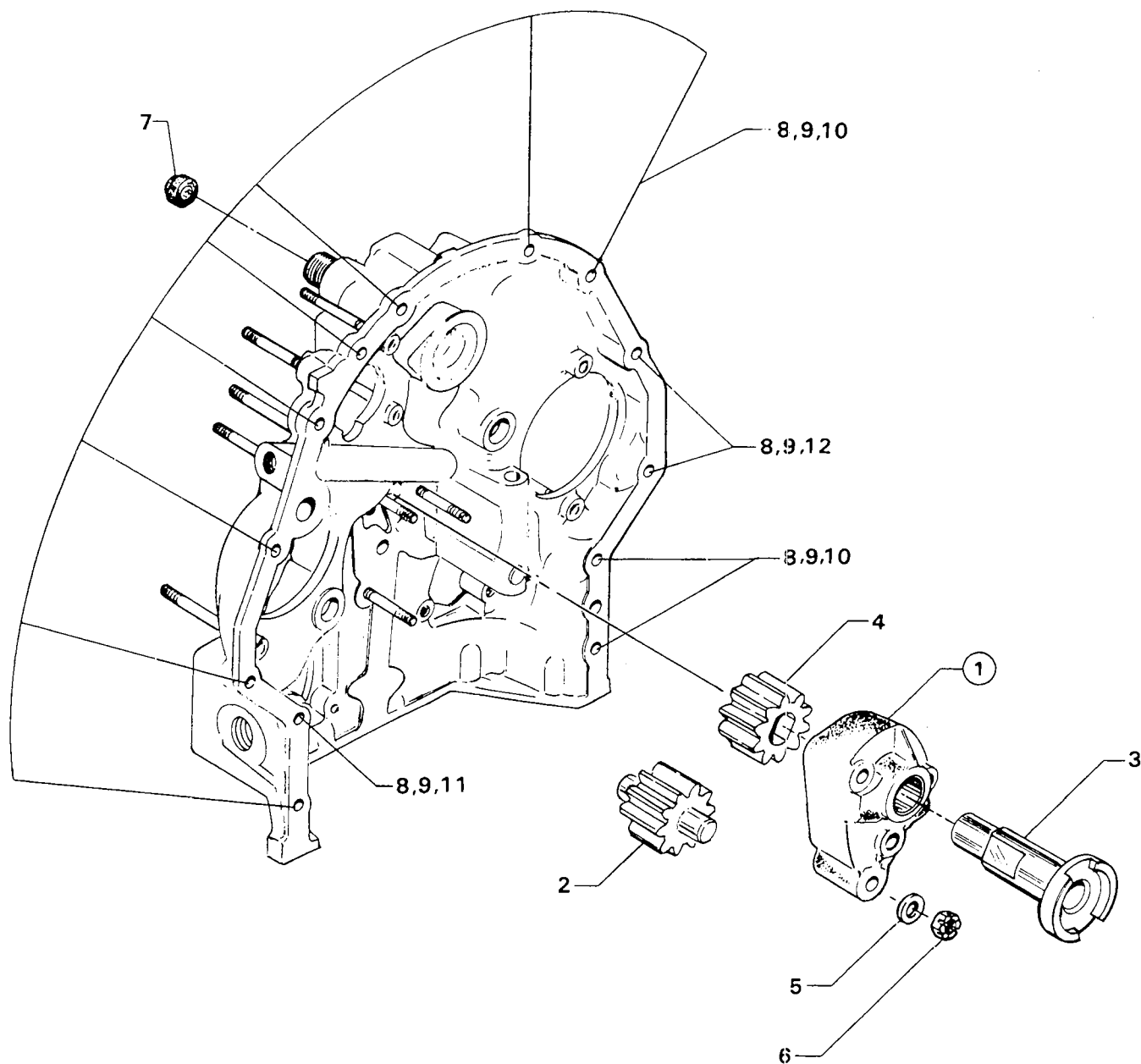
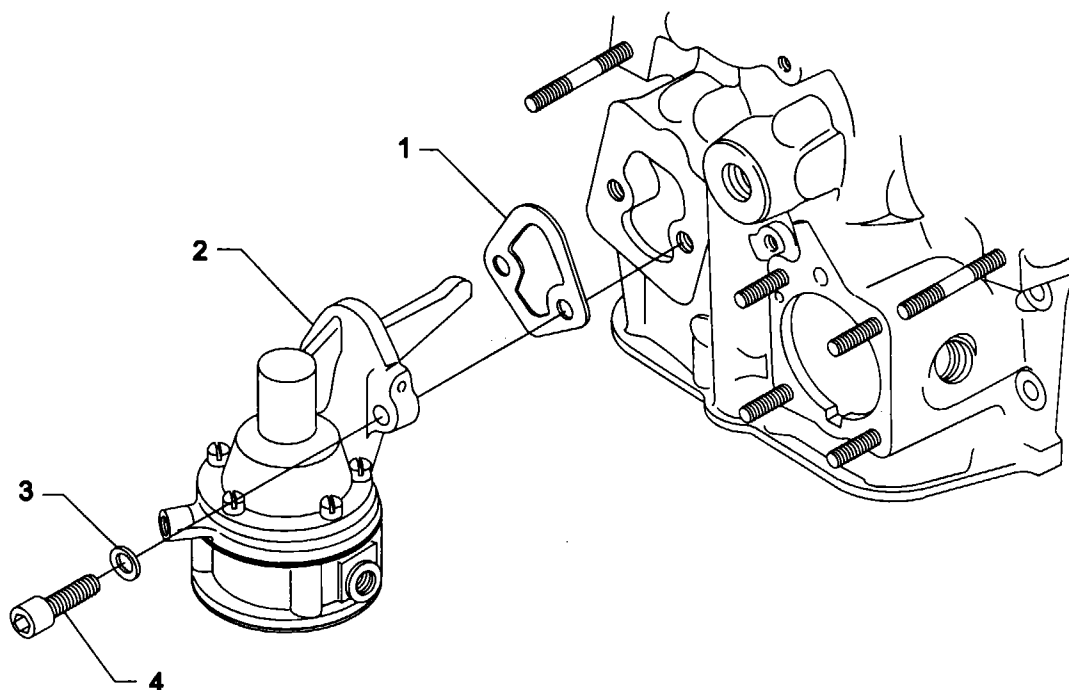


Figure 10. OIL PUMP ASSEMBLY AND ACCESSORY HOUSING ATTACHING PARTS

**ACCESSORY HOUSING AND RELATED PARTS
FUEL PUMP ASSEMBLY**

FIG. REF. 11	PART NUMBER	DESCRIPTION	QUANTITY PER ASSEMBLY
1	60096	GASKET, Fuel pump	1
2	LW-15473	FUEL PUMP, Dual diaphragm (6441234)	1
3	STD-33	WASHER, 3/8 plain	2
4	STD-1882	SCREW, 3/8-16 x 1-9/32 long, socket dr.	2

**Figure 11. FUEL PUMP ASSEMBLY**

INTENTIONALLY

LEFT

BLANK

**ACCESSORY HOUSING AND RELATED PARTS
OIL FILTER ASSEMBLY AND OIL COOLER BYPASS VALVE**

FIG. REF. 12	PART NUMBER	DESCRIPTION	QUANTITY PER ASSEMBLY
1	LW-12795 *	GASKET, Oil filter adapter	2
2	LW-13215 *	OIL FILTER, Short (spin-on type)	2
3	77852	BASE ASSY., Oil filter	1
4	STD-8	WASHER, 1/4 plain	4
5	STD-160	WASHER, 1/4 lock, internal teeth	4
6	STD-1411	NUT, 1/4-20 plain	1
7	LW-25-1.00	BOLT, 1/4-20 x 1.00 long, hex. head	3
8	53E22144	VALVE ASSY., Temp. control, oil cooler bypass	1
9	76510	GASKET, Valve assembly	1
10	25C-10	STUD, 1/4-20 x 1-1/4 long	1

* Extra gasket and oil filter shipped loose with engine.

- IMPORTANT -

Use in conjunction with PC-615-2: IO-540-K1K5 Series Parts Catalog, Figure 12 Illustration, Page 2-6.

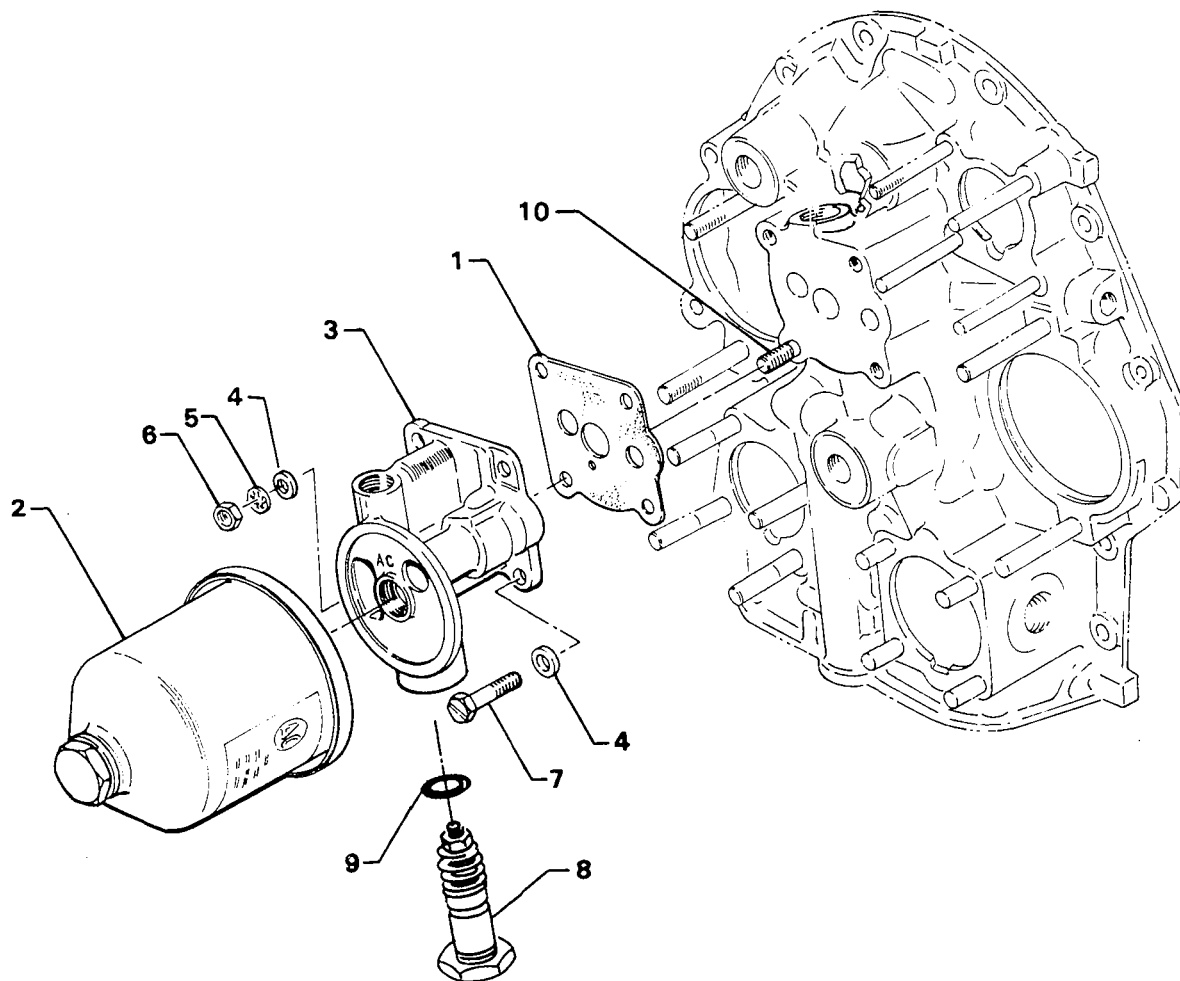


Figure 12. OIL FILTER-ASSEMBLY AND OIL COOLER BYPASS VALVE

ACCESSORY HOUSING AND RELATED PARTS
VACUUM PUMP DRIVE AND COVER, OIL COOLER AND BREATHER FITTINGS

FIG. REF. 13	PART NUMBER	DESCRIPTION	QUANTITY PER ASSEMBLY
1	61183	GASKET, Accessory adapter	1
2	67536	ADAPTER ASSY., Vacuum pump	1
3	06A19956	OIL SEAL, 7/8 I.D. x 1-1/2 O.D. x 5/16 wide	1
4	STD-1774	PIN, 1/8 dia. x 1/4 long	1
5	72974	GEAR ASSY., Vacuum pump driven	1
5A	72962	THRUST BUTTON, Vacuum pump gear	1
6	71596	WASHER, Accessory drive gear	1
7	8313	GASKET, Vacuum pump	1
8	60430	COVER, Vacuum pump	1
9	STD-8	WASHER, 1/4 plain	4
10	STD-160	WASHER, 1/4 lock, internal teeth	4
11	STD-1411	NUT, 1/4-20 plain	4
12	06E19769-0.63	GASKET, 7/8 O.D. x 5/8 I.D. x 3/32 annular	1
13	69675	CONNECTOR, Accy. hsg. oil cooler	1
14	STD-784	PLUG, 3/8-18 NPT, Allen head	2
15	71651	FITTING, Breather	1

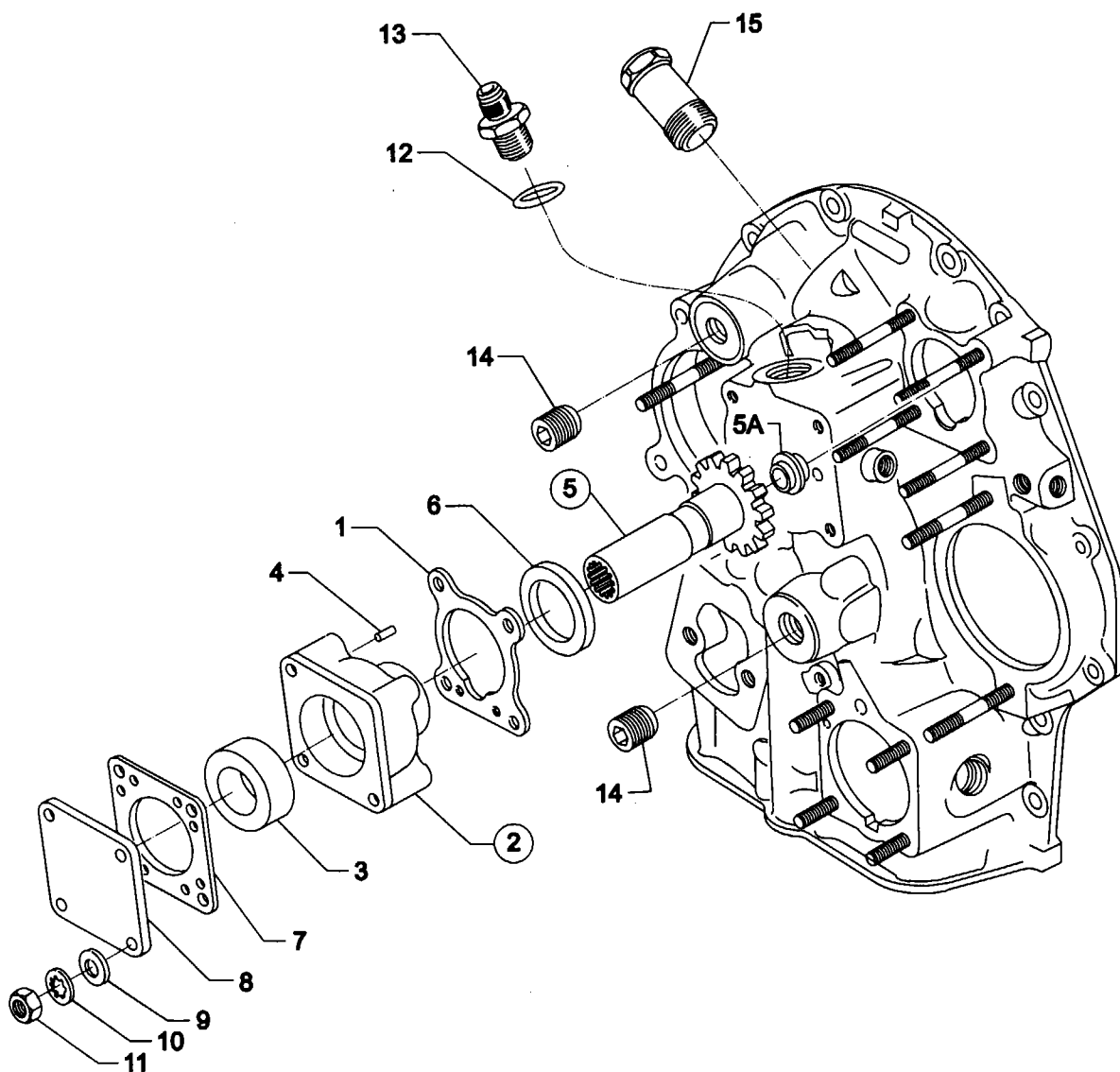


Figure 13. VACUUM PUMP DRIVE AND COVER, OIL COOLER AND BREATHER FITTINGS

**ACCESSORY HOUSING AND RELATED PARTS
HYDRAULIC PUMP DRIVE AND COVERS**

FIG. REF. 13A	PART NUMBER	DESCRIPTION	QUANTITY PER ASSEMBLY
1	72964	GEAR ASSY., Hydraulic pump driven	1
2	72962	THRUST BUTTON, Hydraulic pump gear	1
3	71596	WASHER, Accessory drive gear	1
4	68315	GASKET, Accessory drive adapter	1
5	71675	ADAPTER ASSY., Hydraulic pump	1
6	06A19956	OIL SEAL, 7/8 I.D. x 1-1/2 O.D. x 5/16 wide	1
7	25C-12	STUD, 1/4-20 x 1-1/2 long	4
8	STD-1774	PIN, 1/8 dia. x 1/4 long	1
9	STD-35	WASHER, 5/16 plain	4
10	STD-475	WASHER, 5/16 lock, internal teeth	4
11	STD-1410	NUT, 5/16-18 plain	4
12	8313	GASKET, Hydraulic pump	1
13	60430	COVER, Hydraulic pump	1
14	STD-8	WASHER, 1/4 plain	4
15	STD-160	WASHER, 1/4 lock, internal teeth	4
16	STD-1411	NUT, 1/4-20 plain	4
17	69551	GASKET, Hydraulic pump	1
18	69106	COVER, Hydraulic pump	1
19	STD-35	WASHER, 5/16 plain	4
20	STD-475	WASHER, 5/16 lock, internal teeth	4
21	STD-1410	NUT, 5/16-18 plain	4

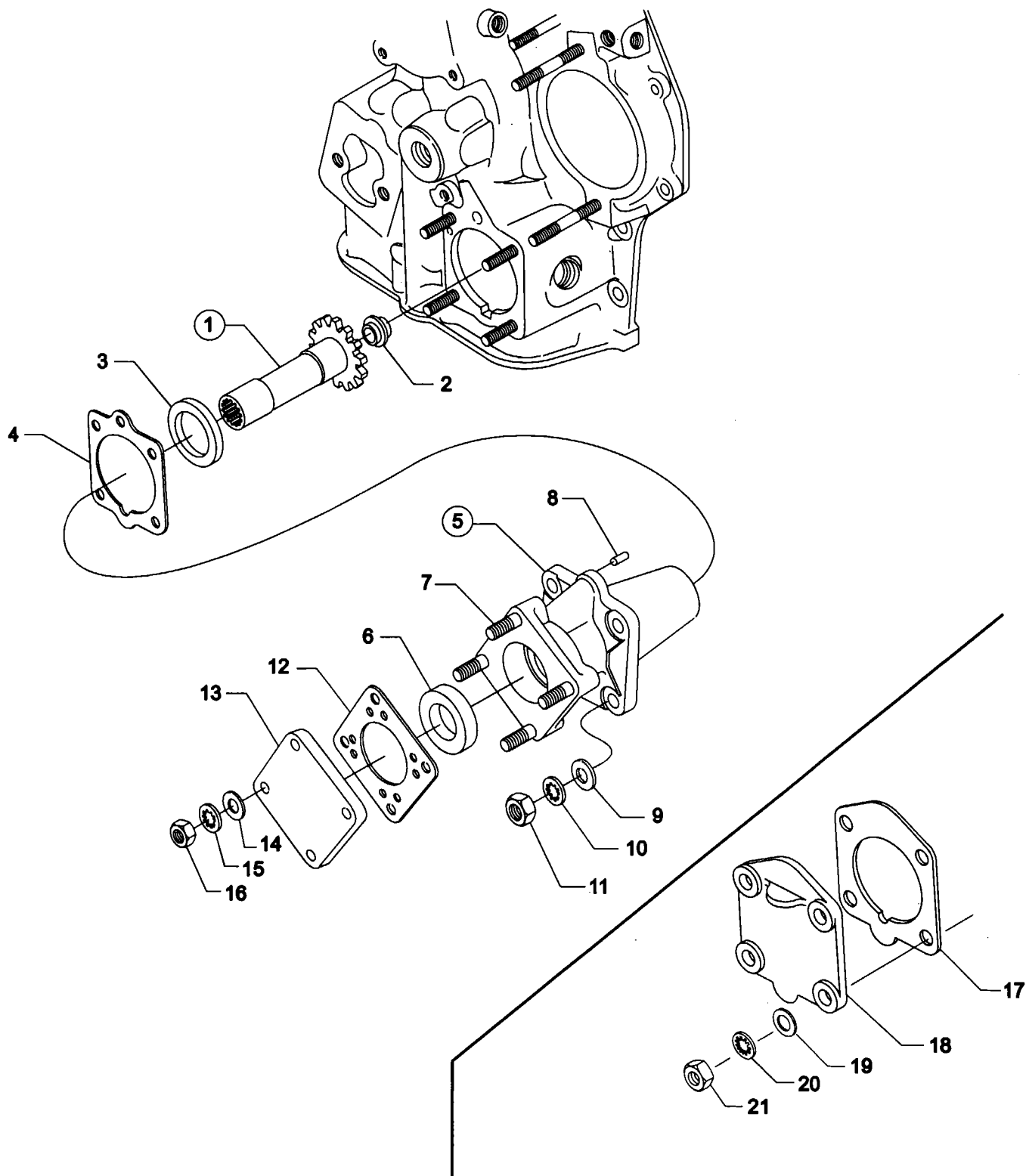


Figure 13A. HYDRAULIC PUMP DRIVE AND COVERS

**CYLINDER, PISTON AND VALVE TRAIN
CONNECTING RODS, PISTONS AND RING ASSEMBLIES**

FIG. REF. 14	PART NUMBER	DESCRIPTION	QUANTITY PER ASSEMBLY
1	LW-19332	CONNECTING ROD ASSEMBLY	6
2	LW-13923	BUSHING, Connecting rod	6
3	LW-12596	BOLT, Connecting rod	12
4	LW-12186	NUT, Connecting rod bolt	12
5	18N19391 *	BEARING, Connecting rod	12
6	LW-10207-S	PISTON, Compression ratio, 8.7:1	6
7	74241	RING, Piston compression	12
8	14H21950	RING, Piston, oil regulating (expander type)	6
9	LW-14078	PIN, Piston	6
10	72198	PLUG, Piston pin	12

* P/N 18N19391 BEARING supersedes P/N 74309 BEARING.

- IMPORTANT -

Use in conjunction with PC-615-2: IO-540-K1K5 Series Parts Catalog, Figure 14 Illustration, Page 3-2.

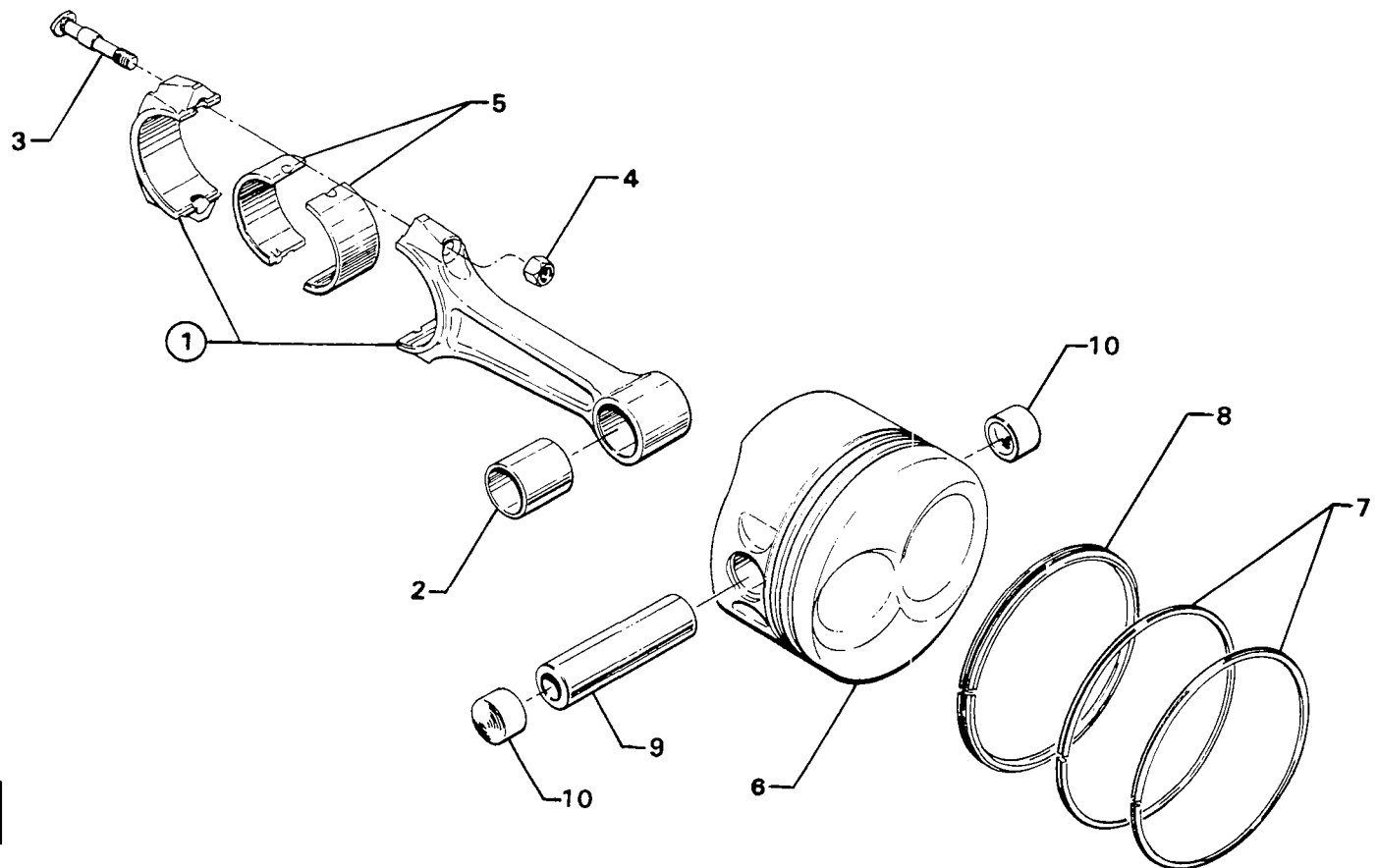


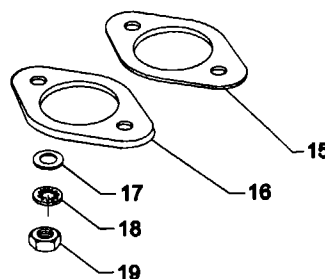
Figure 14. CONNECTING RODS, PISTONS AND RING ASSEMBLIES

**CYLINDER, PISTON AND VALVE TRAIN
CYLINDER ASSEMBLY**

FIG. REF. 15	PART NUMBER	DESCRIPTION	QUANTITY PER ASSEMBLY
1	LW-12993	CYLINDER AND HEAD ASSEMBLY	6
2	LW-12688	SEAT, Intake valve	6
3	16T19468	SEAT, Exhaust valve	6
4	66713	GUIDE, Valve intake	6
5	75838	GUIDE, Valve exhaust	6
6	66796	INSERT, Spark plug, 18 – 1.5 MM	12
7	STD-1872	-- DOES NOT APPLY TO THIS MODEL --	
8	31C-12	STUD, 5/16-18 x 1-1/2 long	12
9	25C-8	STUD, 1/4-20 x 1.00 long	24
10	66670	BUSHING, Rocker shaft, inner	24
11	MS20823-6D	ELBOW, 45° x 3/8 flared tube	6
12	72343	STABILIZER, Cylinder head fins, 15 teeth	6
13	72344	STABILIZER, Cylinder head fins, 26 teeth	6
14	1102	PLUG, 1/8-27 NPT, Allen hd.	6
15	75118	GASKET, Exhaust flange	12
16	67195	FLANGE, Exhaust	6
17	STD-35	WASHER, 5/16 plain	12
18	STD-475	WASHER, 5/16 lock, internal teeth	12
19	STD-1410	NUT, 5/16-18 plain	12

- IMPORTANT -

Use in conjunction with PC-615-2: IO-540-K1K5 Series Parts Catalog, Figure 15 Illustration, Page 3-4.



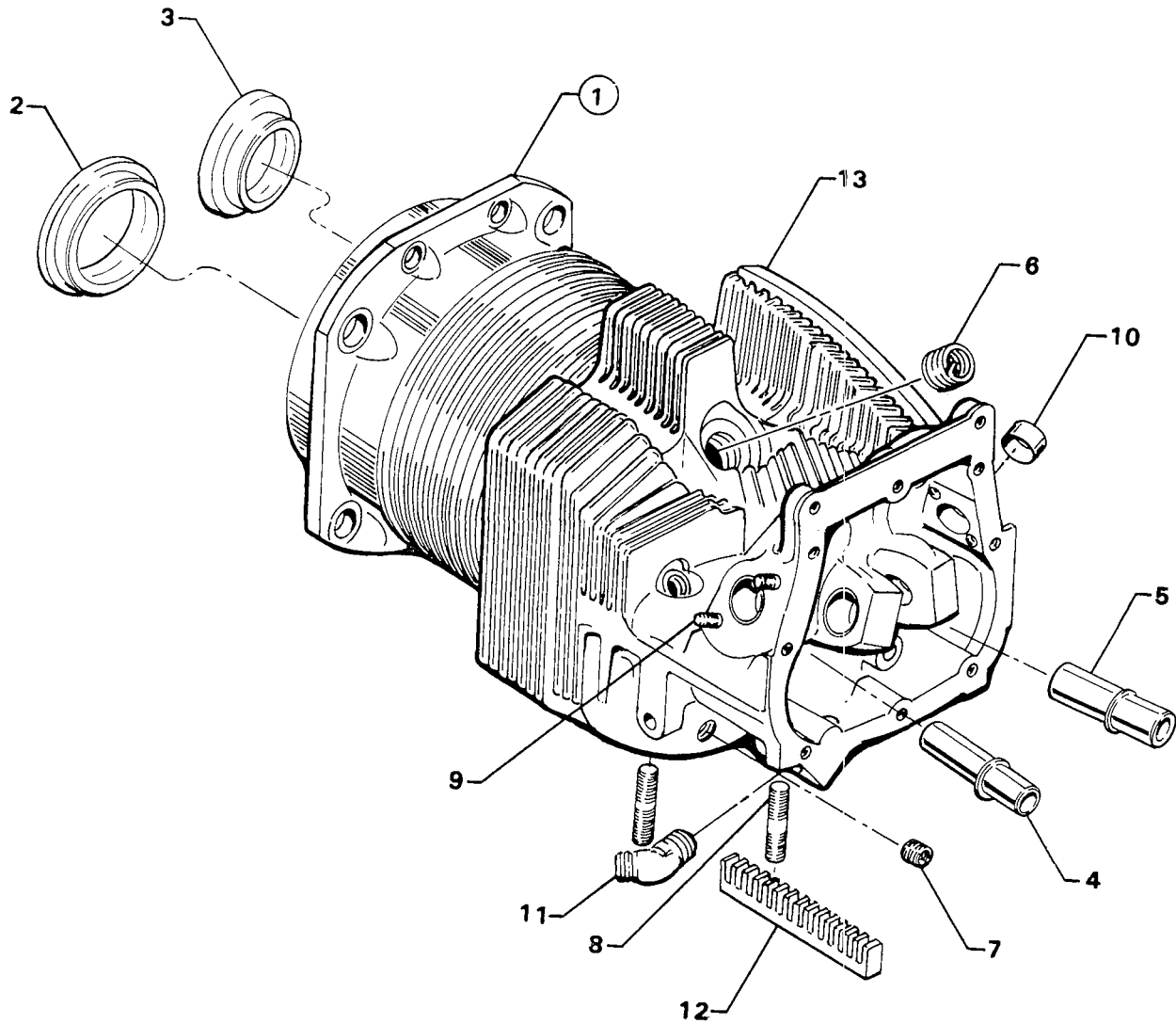


Figure 15. CYLINDER ASSEMBLY

**CYLINDER, PISTON AND VALVE TRAIN
VALVE ASSEMBLY**

FIG. REF. 16	PART NUMBER	DESCRIPTION	QUANTITY PER ASSEMBLY
1	LW-13622	VALVE, Intake	6
2	LW-16740	VALVE, Exhaust	6
3	LW-11797	SPRING, Valve, inner	12
4	LW-11796	SPRING, Valve, outer	12
5	LW-13321	SEAT, Valve spring, lower intake	6
6	LW-13322	SEAT, Valve spring, lower exhaust	6
7	69532	SEAT, Valve spring, upper intake (rotator)	6
8	LW-16475	SEAT, Valve spring, upper exhaust (rotator)	6
9	72050	KEY, Valve intake (rotator)	12
10	62388	CAP, Valve stem, intake (rotator)	6
11	17C21191	KEY, Valve exhaust (rotator)	12
12	17C19386	CAP, Valve stem, exhaust (rotator)	6
13	78290	PLUNGER ASSY., Hydraulic tappet	12
14	15B21319	SOCKET, Push rod, hydraulic tappet	12
15	72255	TUBE ASSY., Shroud, push rod	12
16	15H21201	SPRING, Shroud tube	24
17	66728	WASHER, 25/32 I.D. x 1-1/4 O.D. x 1/32 thick	24
18	61503	SLEEVE, Shroud tube seal	12
19	LW-18661	SEAL, Shroud tube (w/ 61503 sleeve)	24
20	62922	-- DOES NOT APPLY TO THIS MODEL --	
21	15F19957-55	ROD ASSY., Push (A total of 12 reqd.)	AR
	17F19957-56	ROD ASSY., Push (A total of 12 reqd.)	AR
	17F19957-57	ROD ASSY., Push (A total of 12 reqd.)	AR
	15F19957-58	ROD ASSY., Push (A total of 12 reqd.)	AR
Added	15F21362-21	ROD ASSY., Push (A total of 12 reqd.)	AR
Added	15F21362-22	ROD ASSY., Push (A total of 12 reqd.)	AR
Added	15F21362-23	ROD ASSY., Push (A total of 12 reqd.)	AR

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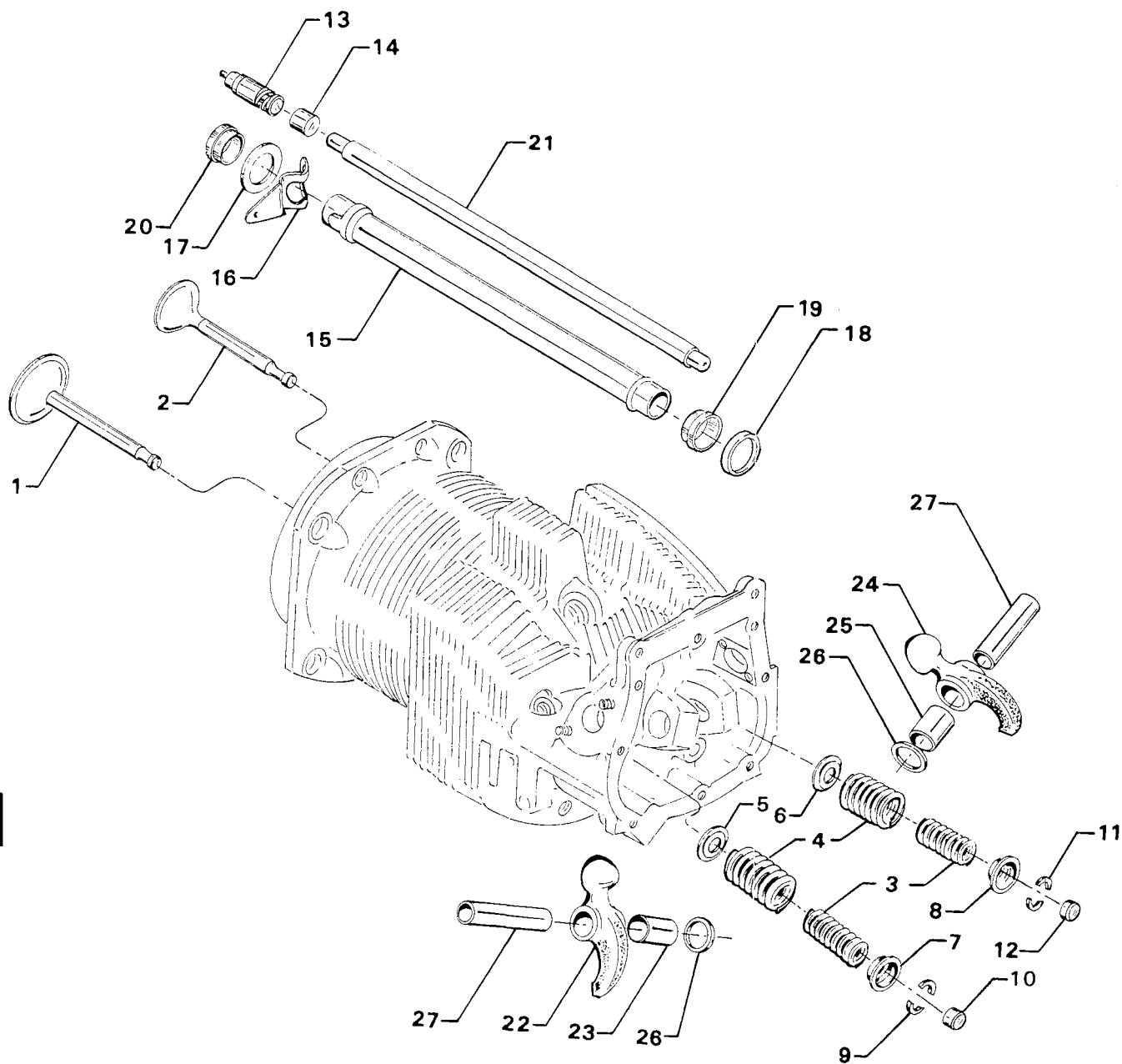


Figure 16. VALVE ASSEMBLY

**CYLINDER, PISTON AND VALVE TRAIN
CYLINDER RELATED PARTS**

FIG. REF. 17	PART NUMBER	DESCRIPTION	QUANTITY PER ASSEMBLY
1	66732	GASKET, Valve rocker shaft cover	12
2	72710	COVER, Valve rocker shaft	12
3	STD-160	WASHER, 1/4 lock, internal teeth	24
4	STD-1411	NUT, 1/4-20 plain	24
5	67193	GASKET, Rocker box cover	6
6	68795	COVER ASSY., Rocker box	6
7	STD-1925	SCREW, 1/4-20 X 5/8 long, pan. hd. self-locking	48
8	74494	PLATE, Spark plug caution	6
9	71481	RING, Oil seal, 3/32 dia. x 4-27/32 I.D.	6
10	77906	SPACER, 33/64 I.D. x 7/8 O.D. x 1/8 thick	2
11	74887	SPACER, 33/64 I.D. x 7/8 O.D. x 3/8 thick	2
12	383-B	NUT, 3/8-24 plain	24
13	STD-2090	NUT, 1/2-20 plain	28
14	STD-684	NIPPLE, Straight, 3/8 I.D. hose	6
15	STD-2180	HOSE, 3/8 I.D. x 1-13/16 long	6
16	LW-15592-5-05	CLAMP, Hose	12
17	72702	TUBE ASSY., Cyl. head oil drain, cyl. no. 1	1
18	72703	TUBE ASSY., Cyl. head oil drain, cyl. no. 2	1
19	73027	TUBE ASSY., Cyl. head oil drain, cyls. no. 3, 4, 5, 6	4
20	75338	BAFFLE ASSY., Intercylinder	4
21	71610	HOOK, Intercylinder baffle retainer	4
22	71611	RETAINER, Intercylinder baffle	4
23	72834	COVER, Baffle ignition cable hole	4
24	STD-692	SCREW, No. 10-32 x 1/2 long, round head	8
25	STD-670	NUT, No. 10-32 self-locking	8

- IMPORTANT -**Use in conjunction with PC-615-2: IO-540-K1K5 Series Parts Catalog, Figure 17 Illustration, Page 3-8.**

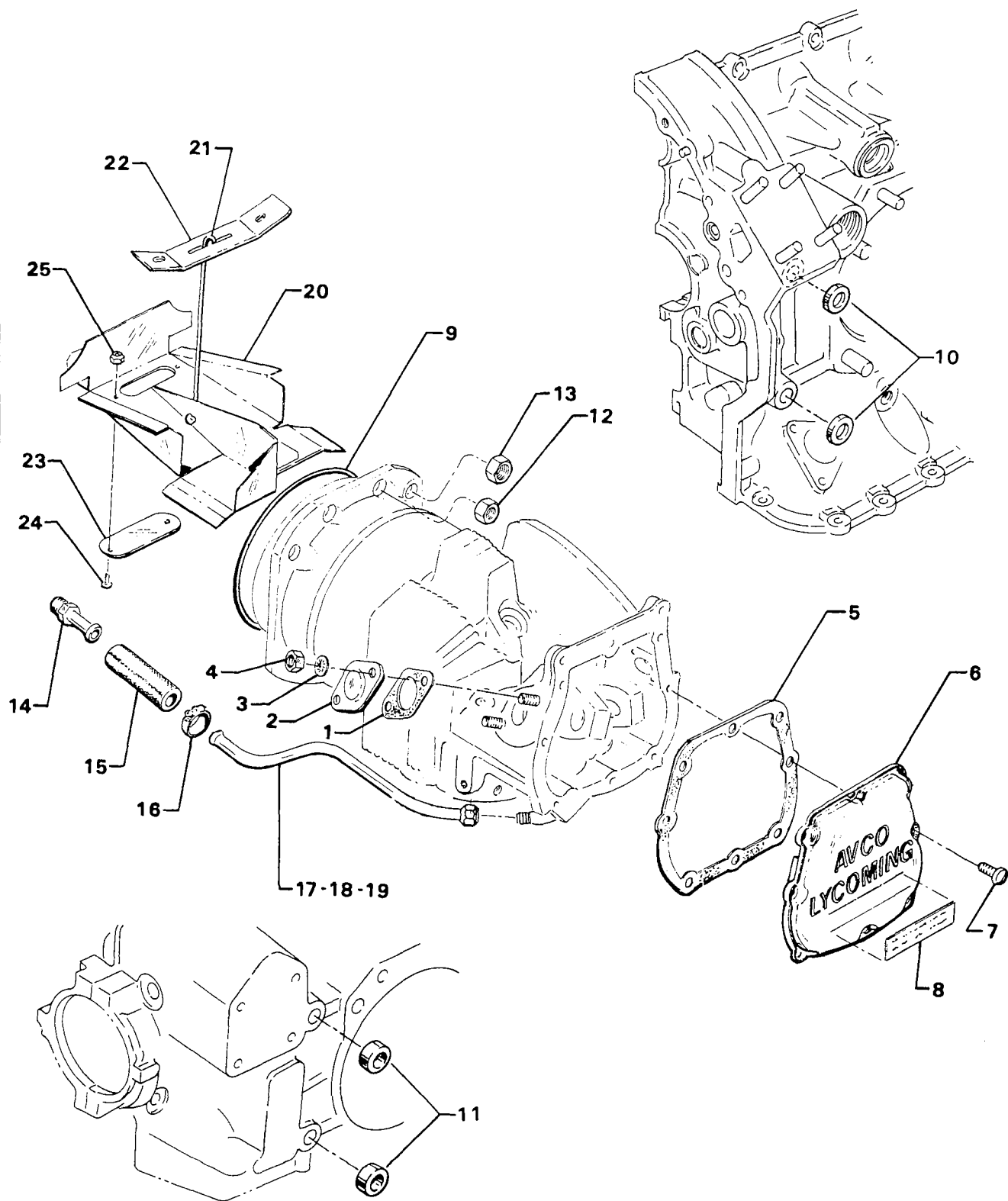


Figure 17. CYLINDER RELATED PARTS

IGNITION SYSTEM

SLICK MAGNETOS, MAGNETO DRIVES , HARNESS ASSYS. AND SPARK PLUGS

FIG. REF. 18	PART NUMBER	DESCRIPTION	QUANTITY PER ASSEMBLY
1	73000	COUPLING, Magneto drive	1
2	68H22624 *	CUSHION, Magneto drive	4
3	62224	GASKET, Magneto adapter	2
4	LW-12707	ADAPTER, Magneto	2
5	LW-12681	GASKET, Magneto	2
6	LW-19096	GEAR RETAINER ASSEMBLY	2
7	67542	BALL BEARING	2
8	66LP-OSCNN	MAGNETO, Plain, (Right), Model No. 6350	1
9	66LC35SDNN	MAGNETO, Impulse, (Left), Model No. 6351	1
10	67U20636	HARNESS, Right, Slick M-2960	1
11	67U20637	HARNESS, Left, Slick M-2959	1
12	66M21195	CLAMP, Magneto	4
13	STD-475	WASHER, 5/16 lock, internal teeth	4
14	STD-1410	NUT, 5/16-18 plain	4
15	STD-713	COTTER PIN, 3/32 dia. x 3/4 long	2
16	1182-E7 **	SPARK PLUG, Champion (REM 38E) or Auburn (SR 87)	12
•	01P19762-4-16	BAG, Magneto harness attaching	1

* P/N 68H22624 CUSHION supersedes P/N LW-13641 CUSHION.

** Item No. 16 spark plugs are used in current production only. Additional spark plugs are available for these engines. See latest edition of Lycoming Service Instruction No. 1042 for complete listing of all approved spark plugs.

- See Page 4-2 for breakdown of individual parts contained in magneto and harness attaching parts bag. These parts to be attached by customer per engine line drawing included in each bag.

P/N 01P19762-4-16		
LW-16266-25-25	CLIP, One wire	4
LW-14060	CLIP, Two wire	4
STD-8	WASHER, 1/4 plain	12
STD-160	WASHER, 1/4 lock	8
STD-1874	SCREW, 1/4-20 x 13/16 long	6
76734	ZIP STRAP	12
LW-16266-10-75	CLAMP	2
LW-16266-25-44	CLAMP, 7/16 I.D. x 1/4 dia. screw	5
STD-696	WASHER, 1/4 plain (thin)	6
STD-1916	SCREW, 1/4-20 x 1-1/8 long	2
STD-1925	SCREW, 1/4-20 x 5/8 long	4
72815	BRACKET, Support clamp, 90°	4
STD-692	SCREW, No. 10-32 x 1/2 long	4
STD-425	WASHER, No. 10 plain	4
STD-670	LOCKNUT, No. 10-32	4
LW-M-2376	PLATE, Spark plug cable	2

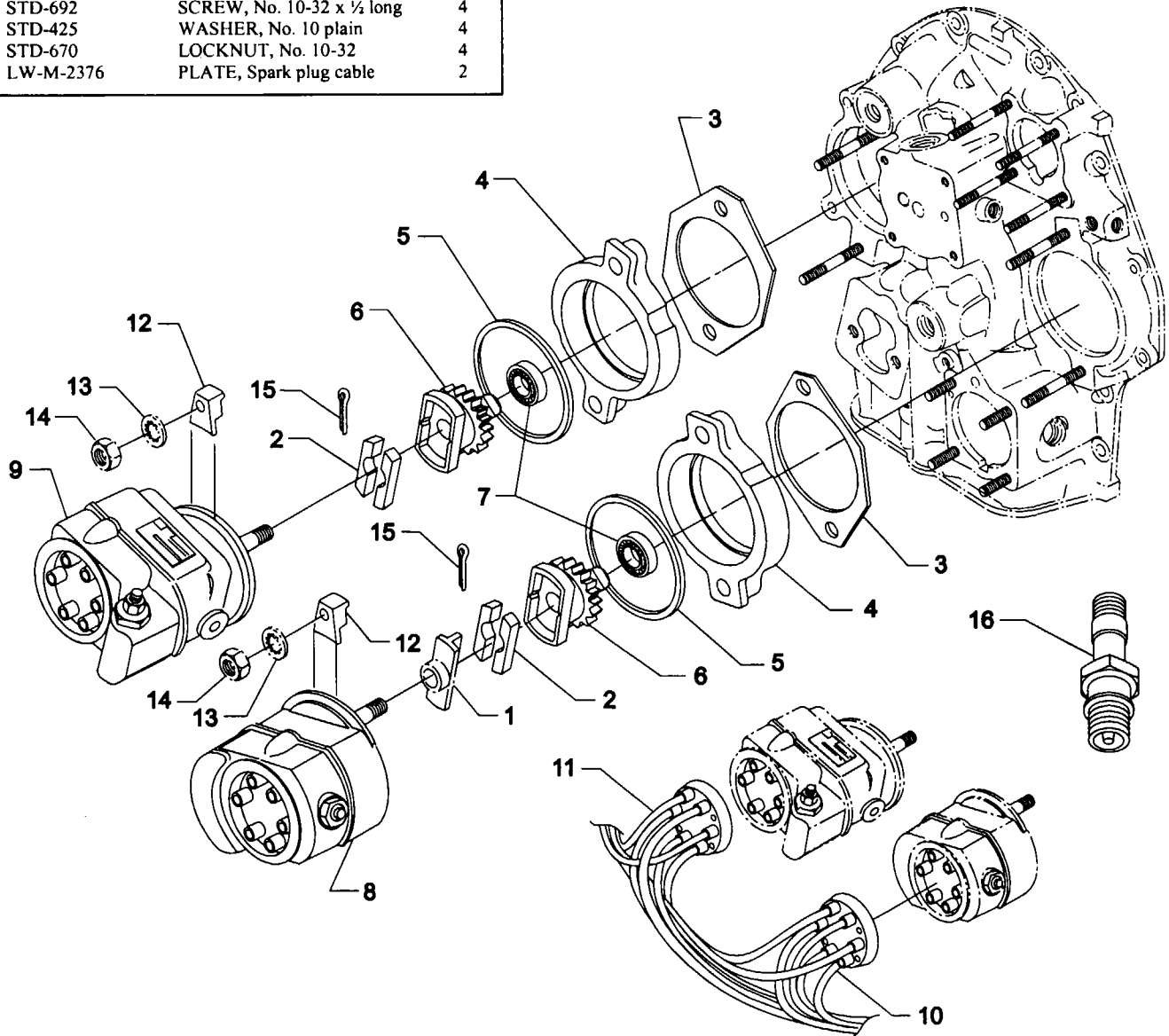


Figure 18. SLICK MAGNETOS, MAGNETO DRIVES, HARNESS ASSYS. AND SPARK PLUGS

**ELECTRICAL COMPONENTS
ALTERNATOR ASSEMBLY AND BELT**

FIG. REF. 19	PART NUMBER	DESCRIPTION	QUANTITY PER ASSEMBLY
1	LW-14324 *	ALTERNATOR, 24 Volt, 70 Amp.	1
	32B19549 **	ALTERNATOR ASSY., 12 Volt, 70 Amp.	1
	LW-14318 **	ALTERNATOR, (ALX-8521-LS)	1
	36B19484 **	PULLEY, Alternator	1
2	37A19773-376	BELT, Alternator drive, 3/8 wide	1

* Used on IO-540-K1K5 engines.

** Used on IO-540-K1H5 engines.

NOTE

See latest edition of Lycoming Service Instruction No. 1154 for complete listing of FAA approved starters, generators, alternators, regulators and relays.

- IMPORTANT -

Use in conjunction with PC-615-2: IO-540-K1K5 Series Parts Catalog, Figure 19 Illustration, Page 5-1.

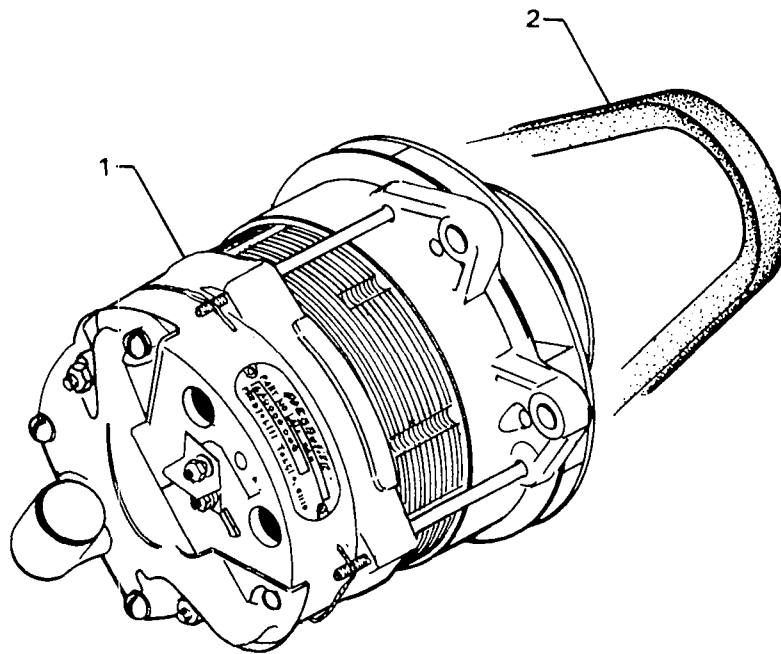


Figure 19. ALTERNATOR AND BELT

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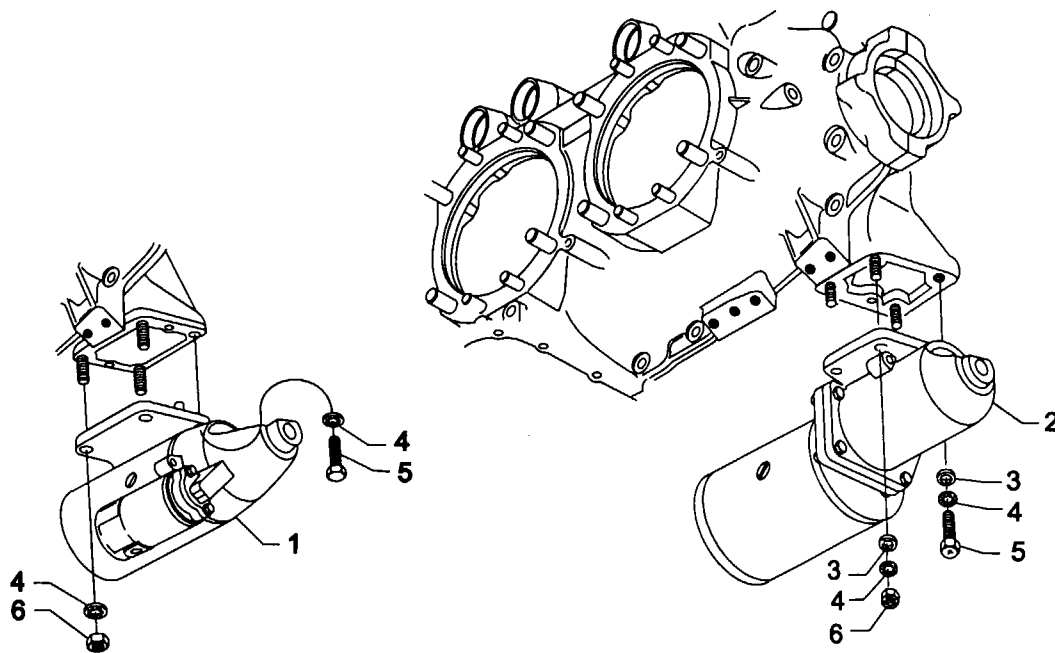
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ELECTRICAL COMPONENTS
STARTER ASSEMBLY (SKY TEC & ELECTROSYSTEMS) AND ATTACHING PARTS

FIG. REF. 20	PART NUMBER	DESCRIPTION	QUANTITY PER ASSEMBLY
1	31A22100	STARTER, Sky-Tec (149 – 12 PM)	1
	31A22104	STARTER, Sky-Tec (149 – 12 LS)	1
2	31A22470	STARTER, ElectroSystems (MZ-6222)	1
3	STD-35	WASHER, 5/16 plain	4
4	STD-475	WASHER, 5/16 lock, internal teeth	4
5	LW-31-1.16	BOLT, 5/16-18 x 1-5/32 long, hex. hd.	1
6	STD-1410	NUT, 5/16-18 plain	3

NOTE

See latest edition of Lycoming Service Instruction No. 1154 for complete listing of FAA approved starters, generators, alternators, regulators and relays.



**Figure 20. STARTER ASSEMBLY AND ATTACHING PARTS
(SKY TEC & ELECTROSYSTEMS)**

**ELECTRICAL COMPONENTS
ALTERNATOR MOUNTING AND ATTACHING PARTS**

FIG. REF. 21	PART NUMBER	DESCRIPTION	QUANTITY PER ASSEMBLY
1	07A19474	BRACKET, Alternator	1
2	73383	LOCKPLATE, 5/16 bolt x 1.00 spacing	1
3	LW-31-0.94	BOLT, 5/16-18 x 15/16 long, hex. hd.	2
4	75380	LINK, Alternator adjusting	1
5	STD-35	WASHER, 5/16 plain	1
6	LW-31H0.75	BOLT, 5/16-18 x 3/4 long, hex. hd., dr.	1
7	STD-1727	WASHER, Plain, 3/4 O.D. x 1 1/32 I.D. x 1/8 thick	1
8	LW-31H0.75	BOLT, 5/16-18 x 3/4 long, hex. hd., dr.	1
9	07F23268	STRUT, Alternator support	1
10	LW-31H0.75	BOLT, 5/16-18 x 3/4 long, hex. hd., dr.	1
11	STD-690	WASHER, 13/16 O.D. x 25/64 I.D. x 1/16 thick	1
12	AN6-14 *	BOLT, 3/8-24 x 1-37/64 long, hex. hd., dr. end	1
	AN6-17 **	BOLT, 3/8-24 x 1-61/64 long, hex. hd., dr. end	1
13	STD-690	WASHER, 13/16 O.D. x 25/64 I.D. x 1/16 thick	3
14	STD-872	NUT, 3/8-24 slotted	1
15	STD-713	PIN, Cotter, 3/32 dia. x 3/4 long	1
16	AN6-16	BOLT, 3/8-24 x 1-53/64 long, hex. hd, dr. end	1
17	76534	SHIM, 1-1/8 O.D. x 13/32 I.D. x .005 thick	5
18	STD-690	WASHER, 13/16 O.D. x 25/64 I.D. x 1/16 thick	3
19	STD-872	NUT, 3/8-24 slotted	1
20	STD-713	PIN, Cotter, 3/32 dia. x 3/4 long	1

* Used on IO-540-K1K5 engines.

** Used on IO-540-K1H5 engines.

- IMPORTANT -**Use in conjunction with PC-615-2: IO-540-K1K5 Series Parts Catalog, Figure 21 Illustration, Page 5-4.**

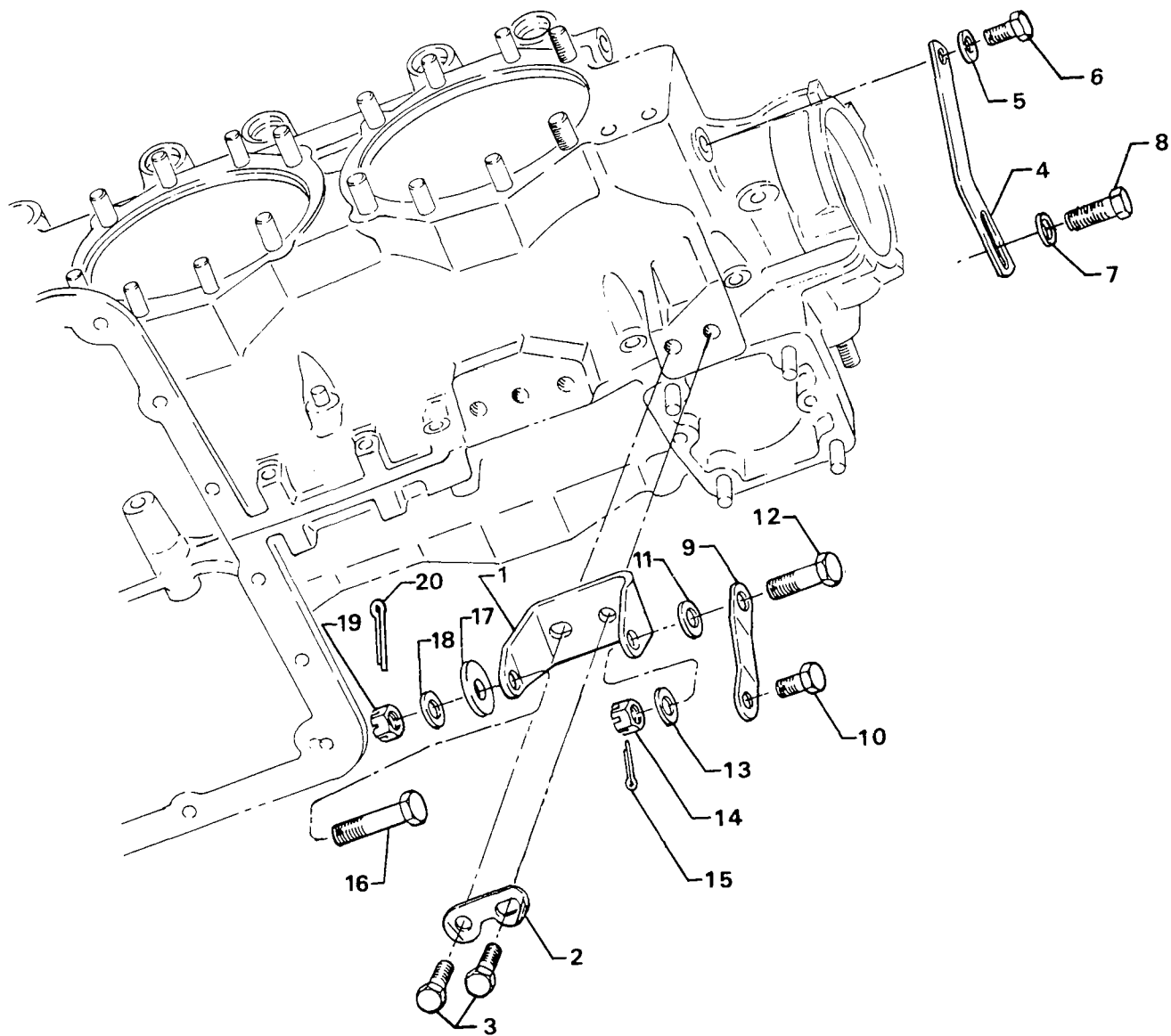


Figure 21. ALTERNATOR MOUNTING AND ATTACHING PARTS

**OIL SUMP AND INDUCTION SYSTEM
OIL SUMP AND INDUCTION HOUSING ASSEMBLY**

FIG. REF. 22	PART NUMBER	DESCRIPTION	QUANTITY PER ASSEMBLY
1	06B21326	GASKET, Oil sump	1
2	56A21692-03	HOUSING ASSY., Oil sump and induction	1
	56A21692-06	HOUSING ASSY., Oil sump and induction	1
3	LW-18065	INSERT, Helicoil, 1/2 NPT	1
4	LW-18291	COVER, Induction housing	1
5	STD-514	DOWEL, 5/16 dia. x 1/2 long	2
6	72179	STUD, Intake pipe extension	3
7	72167	PIPE, Extension, intake cylinders no. 1 & 2	2
8	72168	PIPE, Extension, intake cylinders no. 3 & 4	2
9	72169	PIPE, Extension, intake cylinders no. 5 & 6	2
10	LW-11273	CLAMP, Intake pipe extension	3
11	25C-9	STUD, 1/4-20 x 1-1/8 long	4
12	25C-11	STUD, 1/4-20 x 1-3/8 long	15
13	38-15	STUD, 3/8-16 x 1-7/8 long	8
14	72706	INSERT, Helicoil, 1/4-20 x 3/8 long, self-lock	14
15	STD-91	PLUG, 1/2-14 NPT, Allen hd.	1
16	1102	PLUG, 1/8 pipe, Allen hd.	5
17	STD-784	PLUG, 3/8-18 NPT, Allen hd.	1
18	STD-355	PLUG, 3/4-14 NPT, Allen hd.	2
19	STD-8	WASHER, 1/4 plain	29
20	STD-160	WASHER, 1/4 lock, internal teeth	23
21	LW-25-2.00	BOLT, 1/4-20 x 2.00 long, hex. hd.	2
22	LW-25-1.00	BOLT, 1/4-20 x 1.00 long, hex. hd.	10
23	STD-1411	NUT, 1/4-20 plain	13
24	06E19769-0.91	GASKET, Annular, 1-1/8 O.D. x 29/32 I.D. x 1/16	1
25	72958	-- DOES NOT APPLY TO THIS MODEL --	
26	72960	PLUG, 7/8-14 x 5/8 hex. hd.	1
27	LW-25-0.81	BOLT, 1/4-20 x 13/16 long, hex. hd.	4
28	STD-8	WASHER, 1/4 plain	37
29	STD-160	WASHER, 1/4 lock, internal teeth	23
30	LW-25-1.13	BOLT, 1/4-20 x 1-1/8 long, hex. hd.	6
31	LW-25-1.00	BOLT, 1/4-20 x 1.00 long, hex. hd.	8
32	STD-1411	NUT, 1/4-20 plain	25

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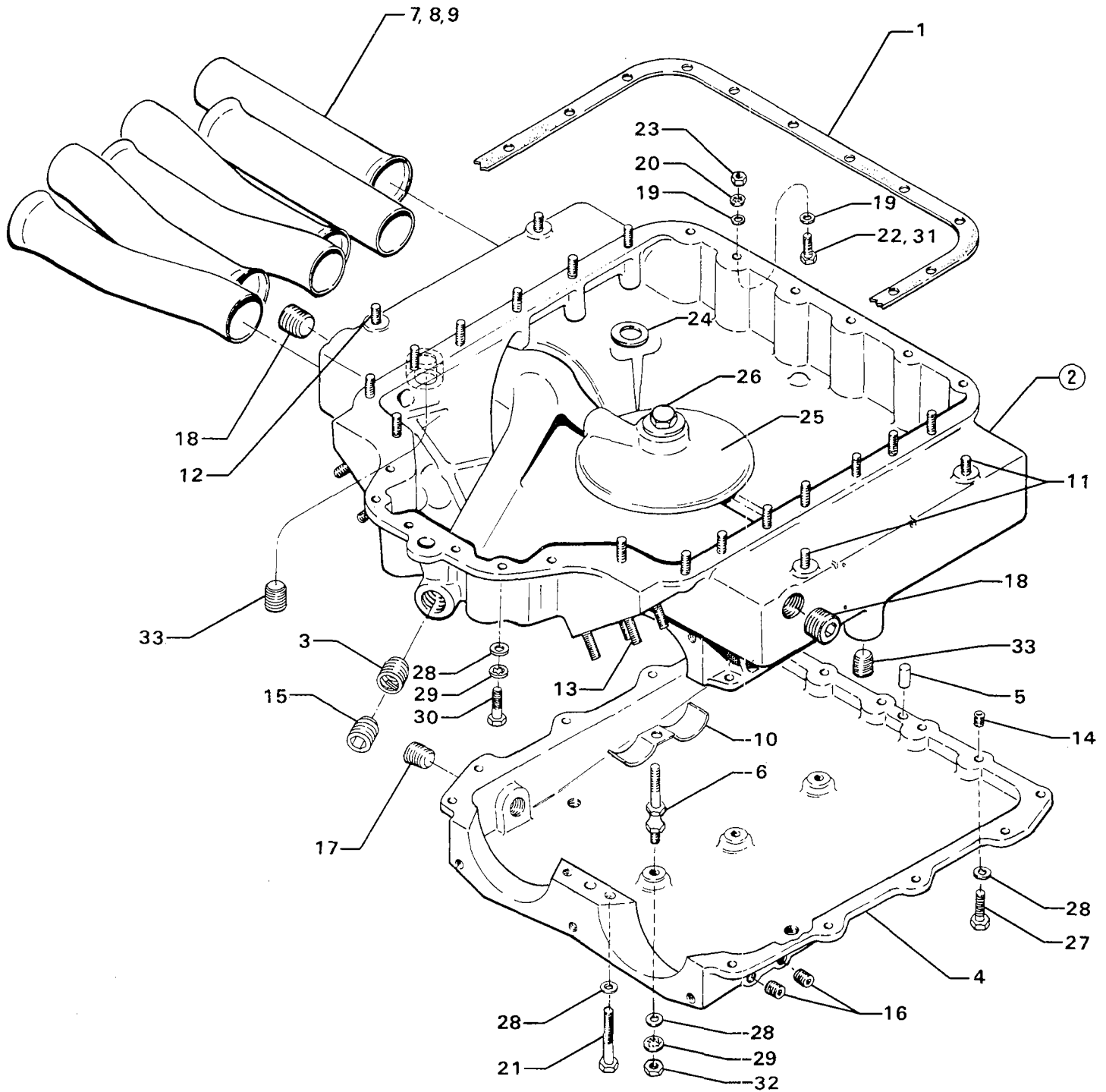


Figure 22. OIL SUMP AND INDUCTION HOUSING ASSEMBLY

**OIL SUMP AND INDUCTION SYSTEM
INTAKE PIPES AND AIR INLET HOUSING**

FIG. REF. 23	PART NUMBER	DESCRIPTION	QUANTITY PER ASSEMBLY
1	72711	RING, Seal, intake pipes	6
2	LW-12191	PIPE, Intake, cylinder no. 1	1
3	LW-12192	PIPE, Intake, cylinder no. 2	1
4	LW-12193	PIPE, Intake, cylinder no. 3	1
5	LW-12194	PIPE, Intake, cylinders no. 4 & 5	2
6	LW-12195	PIPE, Intake, cylinder no. 6	1
7	71973	GASKET, 2 bolt flange, 1-7/8 I.D.	6
8	74360	FLANGE, Intake pipe, upper	6
9	STD-8	WASHER, 1/4 plain	12
10	STD-160	WASHER, 1/4 lock, internal teeth	12
11	STD-1215	BOLT, 1/4-20 x 1-1/4 long, hex. head	12
12	72210	GASKET, Air throttle housing	1
13	LW-16956	HOUSING ASSY., Air inlet	1
14	31C-14	STUD, 5/16-18 x 1-3/4 long	4
15	1102	PLUG, 1/8 pipe, Allen head	1
16	STD-1353	INSERT, 10-24 helicoil x 3/8 long	3
17	STD-8	WASHER, 1/4 plain	6
18	STD-1875	BOLT, 1/4-20 x 13/16 long, hex. head	6
19	60422	SCREEN, Oil suction	1
20	LW-14247	FITTING, Nipple, sump oil return	1
21	LW-13749	SEPARATOR, Oil	1
22	LW-13750	VALVE, Oil	1
23	LW-18127	ELBOW, Sump oil suction	1
24	LW-18128	NUT, 1.00-20 UNF-3 x 9/32 thick	1
25	AN900-16	GASKET, Copper asbestos	1

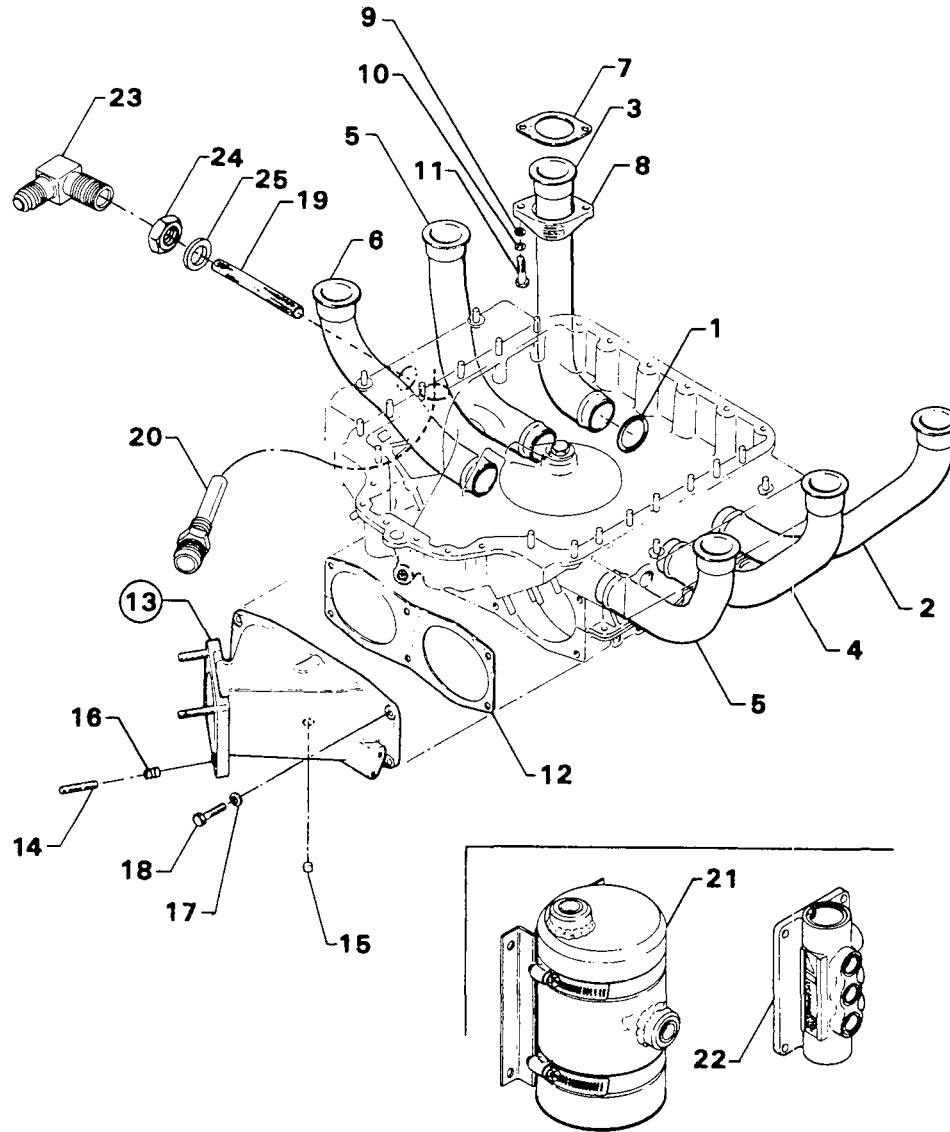


Figure 23. INTAKE PIPES AND AIR INLET HOUSING

**OIL SUMP AND INDUCTION SYSTEM
FUEL INJECTOR, FUEL MANIFOLD AND INJECTION NOZZLES**

FIG. REF. 24	PART NUMBER	DESCRIPTION	QUANTITY PER ASSEMBLY
1	73032 *	GASKET, Air inlet housing	2
2	77654	SPACER, Fuel injector	1
3	75567	FUEL INJECTOR (2524273-12)	1
4	76304 **	ELBOW, 45° (fuel injector outlet)	1
5	STD-35	WASHER, 5/16 plain	2
6	STD-1727	WASHER, Plain, 3/4 O.D. x 11/32 I.D. x 1/8 thick	2
7	STD-1410	NUT, 5/16-18 plain	4
8	STD-475	WASHER, 5/16 lock, internal teeth	4
9	LW-18265	NOZZLE, Injection (2524864)	6
10	75573	MANIFOLD ASSY., Fuel	1
11	AN816-4	NIPPLE, 1/8 NPT to 1/4 tube	1
12	AN791-2	ELBOW, Union, 45°, 1/8 tube	2
13	STD-148	NIPPLE, Union, 1/8 NPT	4
14	02G21446	NIPPLE, 1/8 NPT to 1/8 tube	1
15	75009	BRACKET, Fuel manifold	1
16	STD-251	WASHER, No. 10 internal lock	4
17	STD-82	SCREW, No. 10-24 x 1/2 long, fill. hd.	4
18	STD-160	WASHER, 1/4 lock, internal teeth	1
19	LW-25-0.50	BOLT, 1/4-20 x 1/2 long, hex. hd.	1
20	LW-12098-0-210	TUBE ASSY., Fuel injector line	3
21	LW-12098-0-280	TUBE ASSY., Fuel injector line	1
22	LW-12098-0-140	TUBE ASSY., Fuel injector line	2
23	LW-16266-10-75	CLAMP	8
24	LW-16266-10-13	CLAMP, 1/8 dia. for No. 10 screw	10
25	STD-860	SCREW, No. 10-32 x 5/8 long, fill.. hd.	13
26	STD-425	WASHER, No. 10 plain	2
27	STD-670	LOCKNUT, No. 10-32	13
28	LW-12798-4S340	HOSE ASSY., 1/4 hose straight	1
29	LW-16266-25-63	CLAMP, 5/8 I.D. x 1/4 dia. screw	1
30	LW-12799-6S110	HOSE ASSY., 3/8 hose straight	1
31	72377 ■	ELBOW., 3/8 flared tube, adj. (fuel pump outlet)	1
32	LW-16266-10-13	CLAMP, 1/8 dia. for No. 10 screw	2
33	73136	BRACKET, Extension, fuel injector line	4

* Extra gasket, shipped as loose part with engine.

** Requires P/N MS29512-08 O-ring.

■ Requires P/N MS29512-06 O-ring.

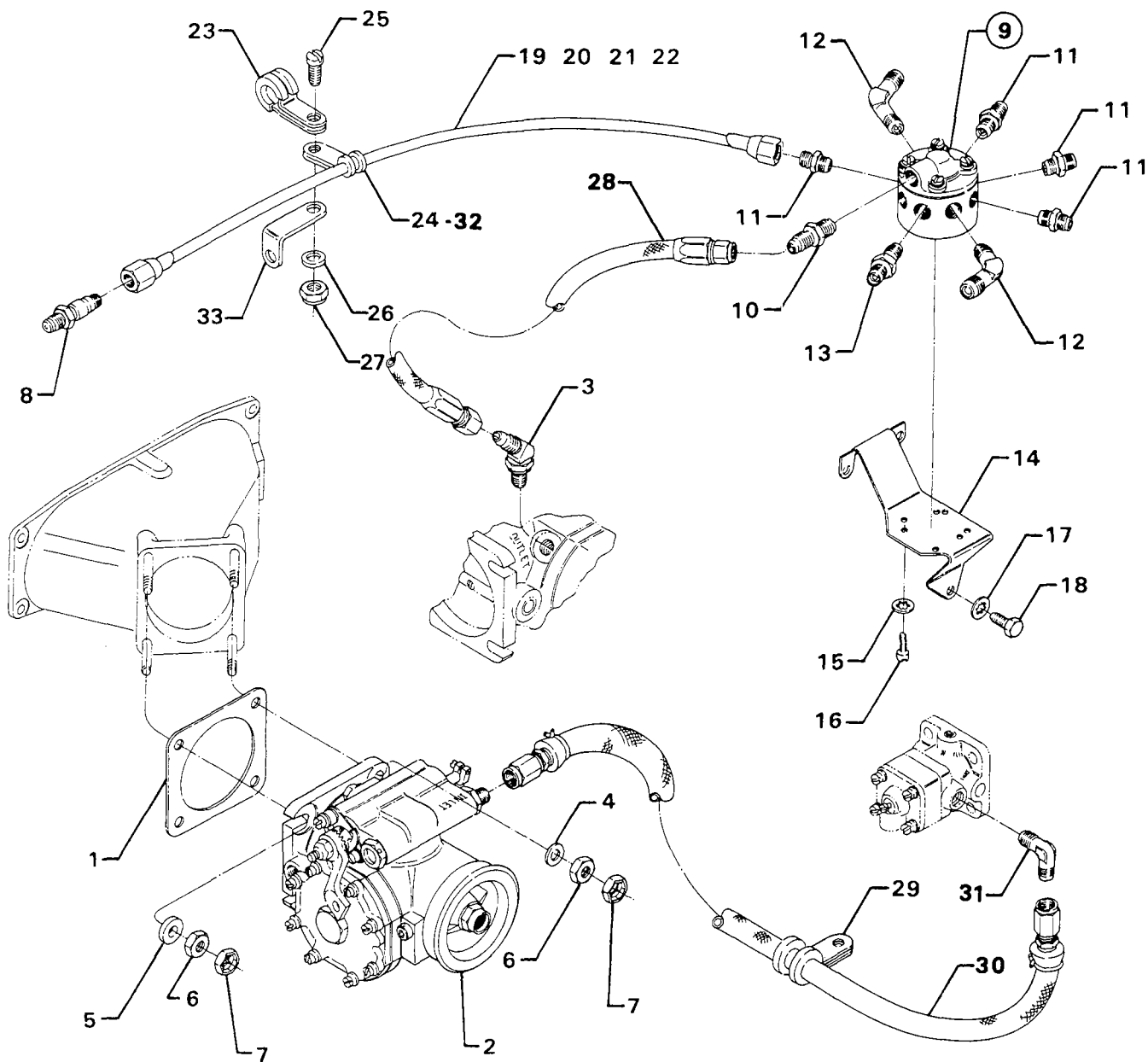


Figure 24. FUEL INJECTOR, FUEL MANIFOLD AND INJECTION NOZZLES

OIL SUMP AND INDUCTION SYSTEM
FUEL INJECTOR, FUEL MANIFOLD AND INJECTION NOZZLES

FIG. REF. 24A	PART NUMBER	DESCRIPTION	QUANTITY PER ASSEMBLY
1	73032 *	GASKET, Air inlet housing	2
2	77654	SPACER, Fuel injector	1
3	79034	FUEL INJECTOR (2524422-9)	1
4	MS29512-06	"O" RING, 15/32 I.D. x 5/64 section	1
5	AN919-6	REDUCER, Ext. 3/8 flared tube to 1/4 tube	1
6	STD-35	WASHER, 5/16 plain	4
7	STD-1410	NUT, 5/16-18 plain	4
8	STD-475	WASHER, 5/16 lock, internal teeth	4
9	75283	MANIFOLD ASSY., Fuel	1
10	MS20823-4	ELBOW, 1/8 NPT to 1/4 flared tube	1
11	STD-148	NIPPLE, Union, 1/8 NPT	6
12	02G21446	NIPPLE, 1/8 NPT to 1/8 tube	1
13	LW-18265	NOZZLE, Injection (2524864)	6
14	73966	SPACER, Fuel manifold bracket	2
15	73965	BRACKET, Fuel manifold	2
16	STD-251	WASHER, No. 10 internal lock	4
17	STD-82	SCREW, No. 10-24 x 1/2 long, fill. hd.	4
18	LW-12098-0-210	TUBE ASSY., Fuel injector line	4
19	LW-12098-0-170	TUBE ASSY., Fuel injector line	2
20	LW-16266-10-75	CLAMP	10
21	LW-16266-10-13	CLAMP, 1/8 dia. for No. 10 screw	12
22	STD-860	SCREW, No. 10-32 x 5/8 long, fill. hd.	14
23	STD-425	WASHER, No. 10 plain	2
24	STD-670	LOCKNUT, No. 10-32	14
25	73136	BRACKET, Extension, fuel injector line	4
26	LW-12876-4S334	HOSE ASSY., 1/4 hose, 90° elbow	1
27	73152	BRACKET, Support clamp	1
28	LW-16266-25-63	CLAMP, 5/8 I.D. x 1/4 dia. screw	2
29	STD-860	SCREW, No. 10-32 x 5/8 long, fill. hd.	1
30	STD-425	WASHER, No. 10 plain	1
31	STD-670	LOCKNUT, No. 10-32	1
32	LW-10446	ELBOW, 3/8 tubing, 90° swivel nut (fuel inj. inlet)	1
33	LW-12799-6S110	HOSE ASSY., 3/8 hose straight	1
34	72377	ELBOW, 3/8 flared tube, adj. (fuel pump inlet & outlet)	2
35	MS29512-06	O-RING	2

* Extra gasket, shipped as loose part with engine.

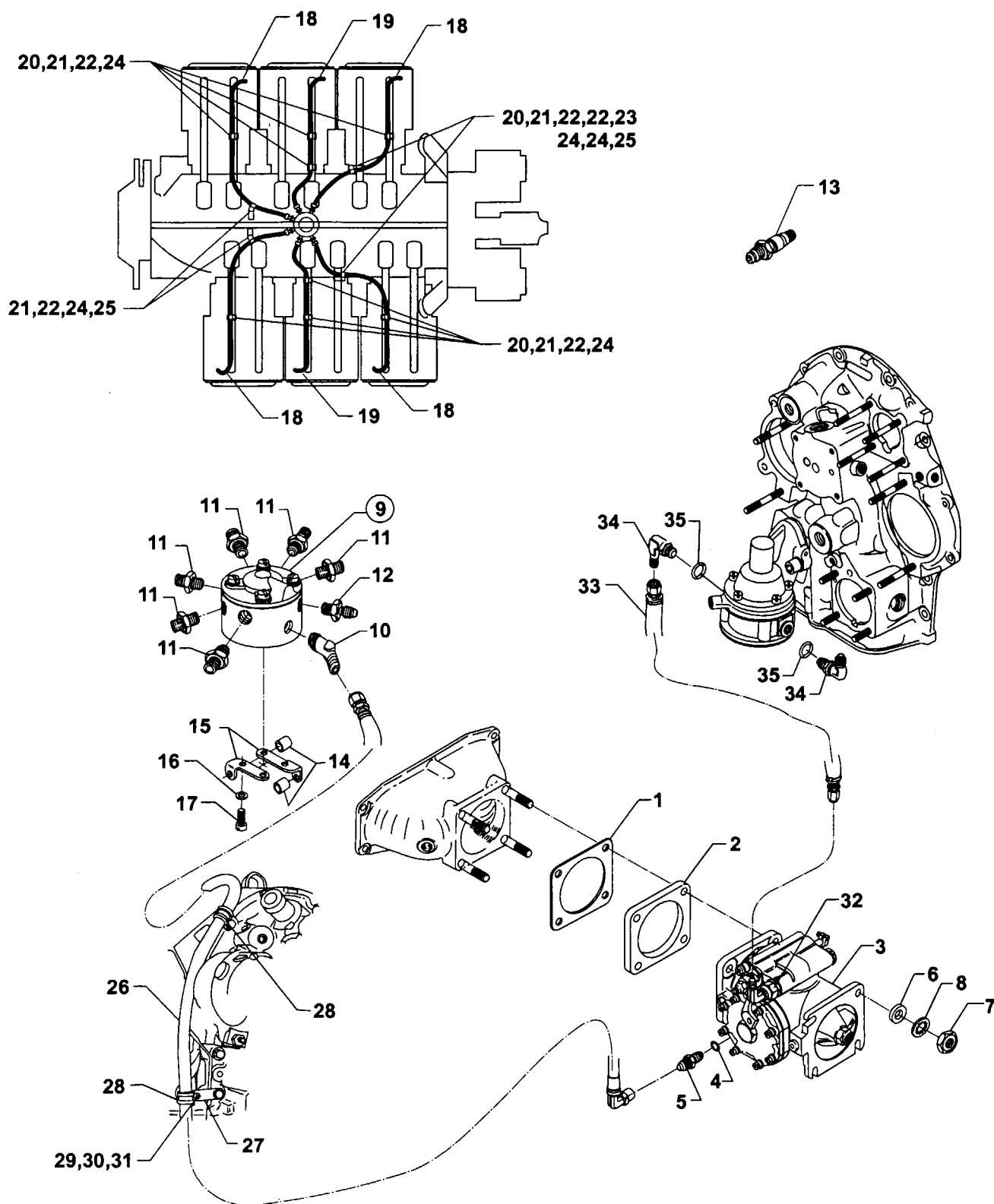


Figure 24A. FUEL INJECTOR, FUEL MANIFOLD AND INJECTION NOZZLES

SERVICE KIT SECTION

SEAL AND GASKET SET WIDE CYLINDER FLANGE MODELS

Part No.	Part Name	Qty.
73185-1	SEAL AND GASKET SET	1
LW-12681	GASKET, Magneto	2
LW-12795	GASKET	1
LW-13306	GASKET, Oil sump	1
LW-13792	SEAL, Crankshaft oil	1
LW-14260	SEAL, Tachometer	1
LW-15628	SEAL, Crankshaft	1
LW-18638	LOCKPLATE, Crankshaft gear	1
LW-18661	SEAL, Shroud tube	24
MS29512-6	SEAL	1
MS29512-8	SEAL, Oil	1
STD-111	GASKET, Annular	2
STD-213	SEAL, Oil (fuel pump drive)	1
STD-294	GASKET, Annular	2
STD-589	GASKET	1
STD-1045	GASKET, Annular	1
STD-1441	GASKET, Annular	6
STD-1737	RING	1
STD-2217	SEAL, Oil	1
1691-C	GASKET, Fuel pump pad	1
8313	GASKET, Vacuum pump	2
61173	GASKET, Oil pressure housing	1
61183	GASKET, Accessory adapter	1
62224	GASKET, Magneto	4
66732	GASKET, Valve rocker shaft cover	12
67193	GASKET, Rocker box cover	6
68315	GASKET, Accessory drive adapter	1
69164	GASKET, Fuel pump adapter	1
69551	GASKET, Accessory pad cover	1
70455	GASKET	1
70457	GASKET, Oil level gage	1
71193	BOX	1
71450	GASKET, Rocker box	6
71481	RING, Oil seal	6
71667	LOCKPLATE, Crankshaft idler gear	2
71973	GASKET, Intake flange	6
72053	GASKET, Governor drive pad	1
72075	SEAL, Oil	8
72078	LOCKPLATE, Cam gear	2
72091	RING, Oil seal	2
72210	GASKET, Air throttle housing	1
72312	RING, Oil seal	1
72711	RING, Oil seal intake pipe	6
73032	GASKET, Air inlet housing	1
73383	LOCKPLATE	2

SERVICE KIT SECTION**SEAL AND GASKET SET (Continued)**
WIDE CYLINDER FLANGE MODELS

Part No.	Part Name	Qty.
73185-1	SEAL AND GASKET SET	1
73818	GASKET, Accessory housing	1
74065	"O" RING, Oil filler plug	1
74305	SEAL, Crankshaft oil	1
75118	GASKET, Exhaust flange	12
75233	"O" RING	24
76510	GASKET	1
76940	SEAL, Crankshaft oil	1

SERVICE KIT SECTION**CYLINDER, PISTON AND RING KIT
WIDE CYLINDER FLANGE MODELS**

Part No.	Part Name	Qty.
LW-15485	CYLINDER, PISTON AND RING KIT	1
STD-160	WASHER	4
STD-1215	BOLT	2
STD-1411	NUT	4
STD-1925	SCREW	8
MS13997-3	KEY, Exhaust (rotator type)	2
MS13998-3	CAP, Valve stem, exhaust	1
72050	KEY, Valve intake	2
60828	PLUG, Piston pin	2
LW-18661	SEAL, Shroud tube	4
66731	COVER, Valve rocker shaft	2
66732	GASKET, Valve rocker shaft cover	2
67193	GASKET, Rocker box cover	1
LW-13221	SEAT, Valve spring, lower, intake	1
68795	COVER ASSY., Rocker box	1
LW-14077	PIN, Piston	1
71195	BOX, Set up	1
71265	ROCKER ASSY., Exhaust valve	1
71266	ROCKER ASSY., Intake valve	1
71481	SEAL, Cylinder base	1
71549	WASHER, Valve rocker thrust	2
72626	SHAFT, Valve rocker	2
LW-16740	VALVE, Exhaust	1
LW-13322	SEAT, Valve spring, lower	1
LW-13622	VALVE, Intake (small head)	1
73857	RING, Piston, oil regulator (chrome)	1
74241	RING, Piston compression (chrome)	2
LW-16475	SEAT, Valve spring, upper exhaust	1
69532	SEAT, Valve spring, upper intake	1
LW-10207S	PISTON, 3 ring	1
LW-11796	SPRING, Valve, outer	2
LW-11797	SPRING, Valve, inner	2
LW-12993	CYLINDER ASSY., Nitrided	1
LW-11775	PLUG, Piston pin	2
SSP2272	TAG	1
62388	CAP	1

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PART NO.	PART NAME	PAGE NO.	PART NO.	PART NAME	PAGE NO.
AN565B1032H5	Set Screw	1-11	LW-13795	Shaft	1-13
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AN6-16	Bolt	5-3	LW-13896	Plug	1-11
AN6-34A	Bolt	1-15	LW-13923	Bushing	3-1
AN791-2	Elbow	6-5	LW-14021	Shaft	1-11
AN816-4	Nipple	6-5	LW-14057	Clip	4-1
AN900-16	Gasket	6-3	LW-14060	Clip	4-1
LW-M-2376	Plate	4-1	LW-14078	Pin	3-1
LW-M-2454	Harness Assy.	4-1	LW-14247	Fitting	6-3
LW-M-2455	Harness Assy.	4-1	LW-14260	Seal	2-3
LW-25-.50	Bolt	6-5	LW-14324	Alternator	5-1
LW-31H.75	Bolt	5-3	LW-14770	Gage Assy.	1-3
LW-10207S	Piston	3-1	LW-14820	Ring	1-7
LW-10442	Gear	1-11	LW-14830	Bearing	1-5
LW-10541	Gear Assy.	1-11	LW-14954	Bearing	3-1
LW-10646	Rod Assy.	3-1	LW-15572	Starter	5-2
LW-10799	Spacer	2-5	LW-15592-5-05	Clamp	3-7
LW-11273	Clamp	6-1	LW-15628	Seal	1-5
LW-11796	Spring	3-5	LW-16266-10-13	Clamp	6-5
LW-11797	Spring	3-5	LW-16266-10-75	Clamp	6-5
LW-11866	Spacer Nut	1-15	LW-16266-25-44	Clamp	4-1
LW-12098-0-134	Tube Assy.	6-5	LW-16266-25-50	Clamp	6-5
LW-12098-0-200	Tube Assy.	6-5	LW-16475	Seat	3-5
LW-12098-0-210	Tube Assy.	6-5	LW-16494	Gear Retainer	4-1
LW-12098-0-276	Tube Assy.	6-5	LW-16740	Valve	3-5
LW-12136	Cushion	4-1	LW-16878	Adapter	2-7
LW-12186	Nut	3-1	LW-16956	Housing Assy.	6-3
LW-12191	Pipe	6-3	LW-17752	Crankshaft	1-7
LW-12192	Pipe	6-3	LW-17777	Crankshaft	1-7
LW-12193	Pipe	6-3	LW-18058	Housing Assy.	6-1
LW-12194	Pipe	6-3	LW-18060	Housing Assy.	2-1
LW-12195	Pipe	6-3	LW-18064	Plug	6-1
LW-12681	Gasket	4-1	LW-18065	Insert	6-1
LW-12688	Seat	3-3	LW-18109	Impeller	2-3
LW-12707	Adapter	4-1	LW-18110	Impeller Assy.	2-3
LW-12795	Gasket	2-6	LW-18127	Elbow	6-3
LW-12879-6S120	Hose Assy.	6-5	LW-18128	Nut	6-3
LW-12993	Cyl. & Head Assy.	3-3	LW-18265	Nozzle	6-5
LW-13039	Bracket	5-3	LW-18346	Crankcase Assy.	1-1
LW-13077	Spring	3-5	LW-18378	Clamp	4-1
LW-13175-4-340	Hose Assy.	6-5	LW-18638	Lockplate	1-7
LW-13215	Oil Filter	2-6	LW-18661	Seal	3-5
LW-13306	Gasket	6-1	LW-349310-1	Magneto	4-1
LW-13321	Seat	3-5	LW-349370-4	Magneto	4-1
LW-13322	Seat	3-5	LW-620037-4	Clip	4-1
LW-13622	Valve	3-5	MS13997-3	Key	3-5
LW-13749	Separator	6-3	MS13998-3	Cap	3-5
LW-13750	Valve	6-3	MS16625-1081	Ring	1-9
			MS20822-6	Elbow	6-5
LW-13794	Stud	1-1	MS20823-6D	Elbow	3-3
			STD-8	Washer	1-15
			STD-8	Washer	2-3

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STD-8	Washer	4-1	STD-713	Pin	5-3
STD-8	Washer	6-1	STD-784	Plug	2-1
STD-8	Washer	6-3	STD-784	Plug	2-7
STD-19	Dowel	1-11	STD-784	Plug	6-1
STD-33	Washer	1-3	STD-798	Dowel	1-11
STD-33	Washer	1-15	STD-860	Screw	6-5
STD-35	Washer	2-3	STD-872	Nut	1-15
STD-35	Washer	2-5	STD-872	Nut	5-3
STD-35	Washer	2-7	STD-1045	Gasket	1-5
STD-35	Washer	5-2	STD-1065	Dowel	1-7
STD-35	Washer	5-3	STD-1204	Bolt	2-3
STD-35	Washer	6-5	STD-1211	Plug	1-7
STD-82	Screw	6-5	STD-1215	Bolt	6-3
STD-91	Plug	6-1	STD-1339	Plug	1-1
STD-148	Nipple	6-5			
STD-160	Washer	1-15	STD-1353	Insert	6-3
STD-160	Washer	2-3	STD-1409	Nut	1-15
STD-160	Washer	2-6	STD-1410	Nut	2-5
STD-160	Washer	2-7	STD-1410	Nut	2-7
STD-160	Washer	3-7	STD-1410	Nut	4-1
STD-160	Washer	4-1	STD-1410	Nut	5-2
STD-160	Washer	6-1	STD-1410	Nut	6-5
STD-160	Washer	6-3	STD-1411	Nut	1-15
STD-160	Washer	6-5	STD-1411	Nut	2-6
STD-213	Seal	1-13	STD-1411	Nut	2-7
STD-251	Washer	6-5	STD-1411	Nut	3-7
STD-294	Gasket	2-7	STD-1411	Nut	6-1
STD-355	Plug	6-1	STD-1414	Bolt	1-15
STD-425	Washer	1-5	STD-1416	Bolt	1-15
STD-425	Washer	6-5	STD-1419	Bolt	1-15
STD-475	Washer	2-5	STD-1419	Bolt	2-3
STD-475	Washer	2-7	STD-1419	Bolt	6-1
STD-475	Washer	4-1	STD-1420	Nut	2-3
STD-475	Washer	5-2	STD-1646	Bolt	6-1
STD-514	Dowel	1-1	STD-1688	Bolt	6-1
STD-514	Dowel	6-1	STD-1727	Washer	5-3
STD-551	Plug	6-1	STD-1727	Washer	6-5
STD-557	Dowel	1-1	STD-1737	Ring	1-13
STD-589	Gasket	6-1	STD-1763	Locknut	6-5
STD-596	Nut	1-3	STD-1774	Pin	1-13
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STD-670	Nut	6-5	STD-1856	Screw	2-6
STD-678	Washer	1-3	STD-1872	Insert	3-3
STD-684	Nipple	3-7	STD-1874	Screw	4-1
STD-690	Washer	5-3	STD-1875	Bolt	6-1
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PART NO.	PART NAME	PAGE NO.	PART NO.	PART NAME	PAGE NO.
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STD-2084	Bolt	1-15	66670	Bushing	3-3
STD-2090	Nut	3-7	66713	Guide	3-3
STD-2156	Bolt	5-2	66728	Washer	3-5
STD-2167	Screw	1-13	66731	Cover	3-7
STD-2168	Nut	1-13	66732	Gasket	3-7
STD-2180	Hose	3-7	66796	Insert	3-3
STD-2209	Bolt	1-7	67112	Rocker Assy.	3-5
STD-2217	Seal	2-7	67113	Rocker Assy.	3-5
25C-8	Stud	3-3	67114	Bushing	3-5
25C-9	Stud	6-1	67193	Gasket	3-7
25C-10	Stud	2-6	67514	Gear	1-7
25C-11	Stud	6-1	67530	Bushing	1-13
25C-12	Stud	2-1	67542	Bearing	4-1
25C-12	Stud	2-7	68315	Gasket	2-7
31C-12	Stud	1-1	68795	Cover Assy.	3-7
31C-12	Stud	2-1	69159	Adapter Assy.	1-13
31C-12	Stud	3-3	69164	Gasket	1-13
31C-13	Stud	1-1	69532	Seat	3-5
31C-14	Stud	1-1	69796	Dowel	1-1
31C-14	Stud	6-3	70455	Gasket	1-11
31C-19	Stud	2-1	70457	Gasket	1-3
31C-21	Stud	2-1	70474	Washer	1-13
31CD-17	Stud	2-1	71481	Ring	3-7
38-13	Stud	1-1	71549	Washer	3-5
38-15	Stud	6-1	71596	Washer	2-7
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38-22	Stud	1-1	71611	Retainer	3-7
38D-17	Stud	1-1	71664	Gear Assy.	1-13
50-15	Stud	1-1	71667	Lockplate	1-13
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1028-B	Ball	1-5	71675	Adapter Assy.	2-7
1102	Plug	1-1	71894	Seat	3-3
1102	Plug	2-1	71903	Bushing	1-7
1102	Plug	6-1	71907	Washer	1-7
1102	Plug	6-3	71973	Gasket	6-3
1182-J3	Spark Plug	4-1	72050	Key	3-5
8313	Gasket	2-7	72091	Ring	1-5
60422	Screen	6-3	72155	Bushing	1-7
60430	Cover	2-7	72158	Bushing	1-1
		2-3	72167	Pipe	6-1
60803	Strap	1-15	72168	Pipe	6-1
60828	Plug	3-1	72169	Pipe	6-1
60945	Plug	1-7	72179	Stud	6-1
61084	Spring	1-5	72210	Gasket	6-3
61503	Sleeve	3-5	72246	Shaft	1-13
62224	Gasket	4-1	72255	Tube Assy.	3-5
62388	Cap	3-5	72336	Cover	6-1
62417	Plug	2-7	72343	Stabilizer	3-3

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PART NO.	PART NAME	PAGE NO.	PART NO.	PART NAME	PAGE NO.
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72566	Gear	1-7	74887	Spacer	3-7
72626	Shaft	3-5	75009	Bracket	6-5
72702	Tube Assy.	3-7	75060	Bolt	3-1
72703	Tube Assy.	3-7	75338	Baffle Assy.	3-7
72706	Insert	6-1	75380	Link	5-3
72711	Ring	6-3	75447	Nipple	6-5
72815	Bracket	4-1	75567	Fuel Injector	6-5
72834	Cover	3-7	75656	Bushing	1-7
72877	Body	1-5	75657	Bushing	1-7
72958	Baffle	6-1	75675	Extension	1-3
72960	Plug	6-1	75838	Guide	3-3
72964	Gear Assy.	2-7	75944	Valve Assy.	2-6
72972	Shaft Gear Assy.	1-13	76026	Belt	5-1
73000	Coupling	4-1	76118	Spacer	1-9
73027	Tube Assy.	3-7	76148	Camshaft	1-9
73032	Gasket	6-5	76155	Shaft Assy.	1-9
73136	Bracket	6-5	76220	Stud	1-15
73249	Washer	1-11	76304	Elbow	6-5
73250	Washer	1-11	76486	Pump	2-5
73251	Washer	1-11	76510	Gasket	2-6
73252	Washer	1-11	76529	Plug	1-5
73383	Lockplate	5-3	76534	Shim	5-3
73455	Rod Assy.	3-5	76734	Zip Strap	4-1
73456	Rod Assy.	3-5	76787	Roller	1-7
73457	Rod Assy.	3-5	76788	Roller	1-7
73458	Rod Assy.	3-5	77289	Bracket	1-3
73644	Counterweight	1-7	77309	Bushing	1-13
73772	Nozzle Assy.	1-1	77579	Support Assy.	1-7
73810	Bushing	1-7	77852	Base Assy.	2-6
73818	Gasket	2-1	77872	Bushing	1-11
73857	Ring	3-1	77906	Spacer	3-7
74065	"O" Ring	1-3	78290	Plunger Assy.	3-5
74241	Ring	3-1	78368	Pin	1-9
74323	Strut	5-3	78524	Socket	3-5
74360	Flange	6-3	78531	Body Assy.	2-3
74494	Plate	3-7	78924	Manifold Assy.	6-5
			10-92873-302	Nut	4-1
			10-92879-43	Lockwasher	4-1

PARTS SUPERSEDURES FOR PC-615-2 .. IO-540-K1K5 PARTS CATALOG

FIGURE REFERENCE	OLD PART NUMBER		NEW PART NUMBER
Figure 1	LW-18346 CRANKCASE ASSY.	superseded by	11F24020-S1 CRANKCASE ASSY.
Figure 2	77289 MOUNTING BRACKET	superseded by	12A19770 MOUNTING BRACKET
Figure 3	STD-1045 GASKET	superseded by	06E19769-1.25 GASKET
Figure 3	76529 PLUG	superseded by	77808 VALVE ASSY.
Figure 4	LW-17777 CRK. & CWT. ASSY.	replaced by	05K37777 KIT
Figure 4	LW-17752 CRKSHFT & PLUG	superseded by	13F37727 CRKSHFT & BUSHING
Figure 4	73644 COUNTERWEIGHT ASSY.	superseded by	LW-19210 COUNTERWEIGHT ASSY.
Figure 4	76787 ROLLER	superseded by	73648 ROLLER
Figure 4	67514 CRANKSHAFT GEAR	superseded by	13S19647 CRANKSHAFT GEAR
Figure 4	77579 SUPPORT ASSY.	superseded by	LW-16471 SUPPORT ASSY.
Figure 5	76148 CAMSHAFT	superseded by	LW-19340 CAMSHAFT ASSY.
Figure 5	78368 PIN	superseded by	LW-18667 PIN
Figure 5	MS16625-1081 RING	superseded by	STD-2231 RING
Figure 8	STD-1409 NUT	superseded by	STD-2249 NUT
Figure 10	STD-1204 BOLT	superseded by	LW-25-0.94 BOLT
Figure 10	STD-1419 BOLT	superseded by	LW-25-1.13 BOLT
Figure 10	STD-1931 BOLT	superseded by	LW-25-1.88 BOLT
Figure 12	75944 VALVE ASSY.	superseded by	53E22144 VALVE ASSY.
Figure 14	LW-10646 CONN. ROD ASSY.	superseded by	LW-19332 CONN. ROD ASSY.
Figure 14	75060 BOLT	replaced by	LW-12596 BOLT
Figure 14	LW-14954 BEARING	superseded by	18N19391 BEARING
Figure 14	73857 RING	superseded by	14H21950 RING
Figure 14	60828 PISTON PLUG	superseded by	72198 PISTON PLUG
Figure 15	71894 SEAT	superseded by	16T19468 SEAT
Figure 16	MS13997-3 KEY	superseded by	17C21191 KEY

PARTS SUPERSEDURES FOR PC-615-2 .. IO-540-K1K5 PARTS CATALOG

FIGURE REFERENCE	OLD PART NUMBER		NEW PART NUMBER
Figure 16	MS13998-3 CAP	superseded by	17C19386 CAP
Figure 16	78524 SOCKET	superseded by	15B21319 SOCKET
Figure 16	LW-13077 SPRING	superseded by	15H21201 SPRING
Figure 16	62922 SEAL	superseded by	LW-18661 SEAL
Figure 16	73455 ROD ASSY.	superseded by	15F19957-55 ROD ASSY.
Figure 16	73456 ROD ASSY.	superseded by	15F19957-56 ROD ASSY.
Figure 16	73457 ROD ASSY.	superseded by	15F19957-57 ROD ASSY.
Figure 16	73458 ROD ASSY.	superseded by	15F19957-58 ROD ASSY.
Figure 16	67113 ROCKER ASSY.	superseded by	17F21186 ROCKER ASSY.
Figure 16	67114 BUSHING	superseded by	74389 BUSHING
Figure 16	67112 ROCKER ASSY.	superseded by	17F21185 ROCKER ASSY.
Figure 17	66731 COVER	superseded by	72710 COVER
Figure 19	76026 BELT	superseded by	37A19773-376 BELT
Figure 21	LW-13039 BRACKET	superseded by	07A19474 BRACKET
Figure 21	STD-1838 BOLT	superseded by	LW-31-0.94 BOLT
Figure 21	74323 STRUT	superseded by	07F23268 STRUT
Figure 22	LW-13306 GASKET	superseded by	06B21326 GASKET
Figure 22	LW-18058 HOUSING ASSY.	replaced by	56A21692-05 HOUSING ASSY.
Figure 22	72336 COVER	superseded by	LW-18291 COVER
Figure 22	STD-1646 BOLT	superseded by	LW-25-2.00 BOLT
Figure 22	STD-1688 BOLT	superseded by	LW-25-1.00 BOLT
Figure 22	STD-589 GASKET	superseded by	06E19769-0.91 GASKET
Figure 22	STD-1875 BOLT	superseded by	LW-25-0.81 BOLT
Figure 22	STD-1419 BOLT	superseded by	LW-25-1.13 BOLT
Figure 23	STD-1215 BOLT	superseded by	LW-25-1.25 BOLT

PARTS SUPERSEDURES FOR PC-615-2 .. IO-540-K1K5 PARTS CATALOG

FIGURE REFERENCE	OLD PART NUMBER		NEW PART NUMBER
Figure 23	STD-1875 BOLT	superseded by	LW-25-0.81 BOLT