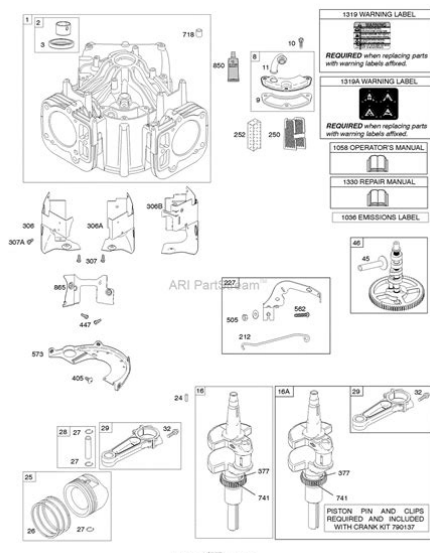


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If a part is worn larger inside dimension such as magneto bearing or smaller such as crankshaft journal surfaces than the given sizes, they should be rejected and replaced with new parts. Always use plug gauges wherever possible to eliminate doubt and possible mistakes. You will find plug gauges illustrated in Section 13. Special repair parts, valve guides, valve seat inserts, contact point plunger bushing, etc., are not listed in the regular Parts Lists and part numbers will be found only in this book. The term "Inspect," "Check," "Test" and "Replace" are used as follows INSPECT Visual inspection, look for signs of wear, scoring, cracks, stripped threads, etc. CHECK Measure by means of plug gauges, feeler gauges, micrometer, scale, etc. TEST Analyze with proper testing equipment. REPLACE This usually means to take off the old part and reassemble it or replace with a new one. Section 1 1 IGNITION. Section 2 2 CARBURETION. Section 3 3 GOVERNING CONTROL and. Section 4 CARBURETOR LINKAGE 4 GOVERNORS. Section 5 5 COMPRESSION. Section 6 6 STARTERS and CHARGING SYSTEMS. Section 7 7 LUBRICATION. Section 8 8 PISTONS, RINGS, RODS. Section 9 9 CRANKSHAFTS and CAM GEARS. Section 10 10 CYLINDERS and BEARINGS. Section 11 11 SYNCHROBALANCE. Section 12 12 TOOLS. Section 13 13 GENERAL THEORIES OF OPERATION. Dual Circuit Fuse Type. AC Only Circuit. DC Only Circuit. TriCircuit. 10 Amp Regulator. 10 Amp Fuse Type. Index. Test Equipment. Troubleshooting. Armature Air Gap. Timing. Automatic Choke. Auxiliary Drive. Battery Cable Size. Capacity. Maintenance. Bearings Ball Bearing. End Play. Plain Bearing. Breaker Box or Cover Removal and Installation. Breaker Bushing Check and Replace. Breaker Points Adjustment. Breaker Plunger Check and Replace. Breaker Shaft Remove and Install. Breather Checking and Installation. Camshaft Aluminum Cylinder. Cast Iron Cylinder. FloJet Two Piece Adjustment. Automatic Choke. Fuel Pump. Idling Control. Kerosene Conversion. Repairs.

Replacing Float Valve Seat. L.P Fuel. Pulsajet Adjustment. Automatic Choke. Repairs. VacuJet Adjustment. CheckUp Procedure. Clutch, Rewind Starter. Coils See Armature Compression Checking. Condenser Testing and Installation. Counter Balance Systems Installation and Timing. Crankcase Cover End Play. Crankshaft Aluminum Cylinder. Cast Iron Cylinder. End Play. Cylinder Head Assembly and Torque. Engine Model System. Extended Oil Fill. 7 1 8.40, 41.8.23 Flywheel Remove and Replace. Timing. Torque. Fuel Recommendation. Overhaul and TuneUp Procedure. 8 8 1.1 6.4.3 to 5 Pin, Piston. Piston Rings. 9 9.2, 3.2, 3 Rectifier, 120 Volt Electric Starter. Remote Controls. Regulator Generator. Resizing Cylinder Bore. 7 4 7 11.21, 27, 34.1 to 12.39 to 42.1, 2 Gear Reduction Lubrication. Gear, Ring. General Information. Generator, Starter. Governor Adjusting.

Governors Air Vane. Controls. Mechanical. Governed Speed Limits. Identification System Engine. Ignition Flywheel Type Internal Breaker. Flywheel Type External Breaker. MagnaMatic. Magneto See Armature VI INDEX Continued SECTION PAGE Rewind Starter. Electric, Gear Drive 12 Volt and 120 Volt. Electric StarterGenerator. Electric, Belt Drive 12 Volt and 120 Volt. Preface TuneUp and Overhaul Procedure. 1.3.4.1 to 8.II, III.II, III.3 to 5 Valves Check and Installing Guides. Clearance. Refacing Seats. Remove and Install. SECTION Camgear or Shaft Reject Sizes. Common Specifications. Connecting Rod Reject Sizes. Connecting Rod Screw Torque. Crankshaft Reject Size. Cylinder Bearing Reject Size. Cylinder Bore Standard Size. Cylinder Head Torque. Ignition Specifications. Main Bearing Tool Chart. Oil Capacity Chart. Piston Pin Reject Size. Ring Gap Reject Size. Stellite Valves and Rotators. Valve Seat Inserts. Valve Seat Counterbore Tools. As the name indicates, there are four strokes to one complete power cycle Fig. 1 The 4Stroke Cycle a.

INTAKE STROKE The piston goes down, creating a vacuum in the cylinder which draws gas through open intake valve into the space above piston. b. COMPRESSION STROKE The piston comes up with both valves closed, highly compressing the gas into the space left between the top of the piston and cylinder head. c. POWER STROKE At this point the magneto sends high tension current to the spark plug, firing or exploding the compressed gas and driving the piston down. d. EXHAUST STROKE Exhaust valve opens and the upward stroke of the piston forces out all of the burnt gases, thus completing the power cycle. CAUTION Exhaust gases contain carbon monoxide which is odorless and a deadly poison. Proper care must be taken to provide efficient ventilation when running an engine indoors. Fill the crankcase and air cleaner with proper oil before starting engine. See that oil level is maintained. Do not fill the gasoline tank while the engine is running. Avoid spilling gasoline on a hot engine This may cause an explosion and serious injury. However, the use of leadfree, or low lead, gasolines will result in reduced combustion deposits and normally will improve engine life. Therefore, leadfree, or low lead, gasoline may be used, where available. We also recommend that gasoline be purchased in small quantities, not more than a 30day supply. FRESH gasoline minimizes gum deposits, and also insures a fuel with volatility tailored for the season. Detergent oils keep the engine cleaner and retard the formation of gum and varnish deposits. No special additives should be used. OIL SHOULD BE CHANGED AFTER EACH 25 HOURS OF ENGINE OPERATION. More often under dirty operating conditions. In normal running of any engine, small particles of metal from the cylinder walls, pistons and bearings will gradually work into the oil. Dust particles from the air also get into the oil.

If the oil is not changed regularly, these foreign particles cause increased friction and a grinding action which shorten the life of the engine. Fresh oil also assists in cooling, for old oil gradually becomes thick and loses its cooling effect as well as its lubricating qualities. The air cleaner should be serviced every 25 hours of engine operation. Dirty operating conditions require more frequent servicing. CLEAN COOLING SYSTEM Grass particles, chaff or dirt may clog the air cooling system, especially after prolonged service in cutting dry grasses. Continued operation with a clogged cooling system may cause severe overheating and possible engine damage. The figures below show the blower housing removed and area to be cleaned. This should be a regular maintenance Operation. Vertical Crankshaft Horizontal Crankshaft 2 GENERAL INFORMATION TuneUp Procedure TUNEUP PROCEDURE A "TuneUp", see the steps listed below, would normally be performed on relatively new engines brought in for minor difficulties. By performing these steps you will either be sure that the engine is functioning properly or will know what major repairs should be made. The steps are also covered in the Overhaul Procedure and will normally be performed as a part of the complete overhaul. STEP NO. 1. 2. 3. 4. 5. 6. 7. 8. 9. STEP NO. 10. Remove air cleaner, check for proper servicing. Check oil level and drain. Clean fuel tank and lines if separate from carburetor. Remove blower housing, inspect rope and rewind assembly and starter clutch. Clean cooling fins and entire engine. Rock flywheel to check compression. Remove carburetor, disassemble and inspect for wear or damage. Wash in solvent, replace parts as necessary and assemble. Set initial adjustment. Inspect

crossover tube or intake elbow for damaged gaskets. Check governor blade, linkage and spring for damage or wear, if mechanical also check adjustment. Remove flywheel, check for seal leakage, both flywheel and PTO sides. Check flywheel key.

Remove breaker cover and check for proper sealing. 11. 12. 13. 14. 15. 16. 17. 18. 19. 3 Inspect breaker points and condenser. Replace or clean and adjust. Check plunger. Check coil, inspect all wires for breaks, damaged insulation. Be sure lead wires do not touch flywheel. Check stop switch and lead. Replace breaker cover, use sealer where wires enter. Install flywheel, time engine if necessary. Remove cylinder head, check gasket, remove spark plug, and clean carbon, inspect valves for seating. Replace cylinder head, torque to specified torque, set spark plug gap or replace plug if necessary. Replace oil and fuel, check muffler for restrictions or damage. Adjust remote control linkage and cable if used, for correct operation. Service air cleaner, check gaskets and element for damage. Naturally these steps could be rearranged in different order but efficiency is obtained when the repair operations are performed in the same sequence every time.

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