



Distribution: List Nos. 5, 8 & 9

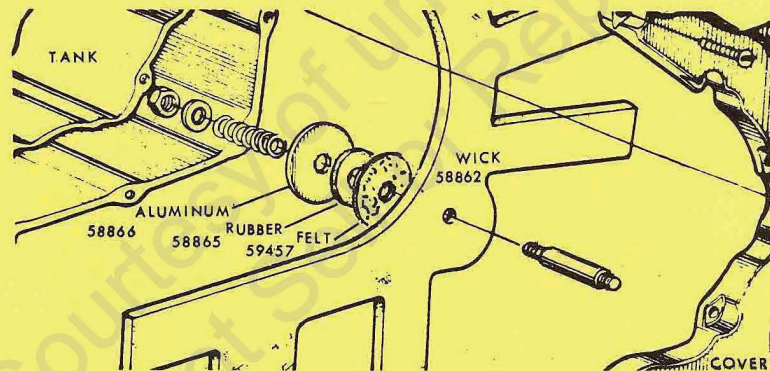
TO: Homelite Branches, Chain Saw Dealers and Construction Equipment Dealers

SUBJECT: Fuel Tank Assembly

DATE: 1/1/65

UNITS AFFECTED: XL Engines

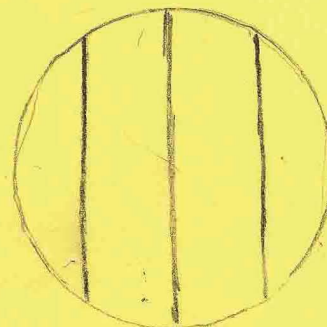
Please study the sketch below.

The felt washer, P/N 59457 is now used in all XL tanks.The rubber gasket, P/N 58865 should be installed between the round felt washer and the large aluminum washer as shown.

Please mark your parts books to show the correct sequence of assembly.

Walter N. Herold
Walter N. Herold
Service Manager

dm



Distribution: List Nos. 5, 8, 9,
11 & 14

TO: All Branches and Dealers

SUBJECT: Touch-Up Painting

DATE: 1/11/65

We have received several inquiries lately regarding touch-up painting of Homelite products.

The following printed instructions will help you provide excellent paint jobs only if they are followed to the letter. Any short cuts or deviations will result in a poor job which will have to be done over.

DIRECTIONS FOR SURFACE PREPARATION

1. Sand the damaged area thoroughly with No. 400 Wetordry abrasive paper using water or oil-free naphtha. Feather out the edges, blending with the surrounding area.

STRAIGHT OR LINE SCRATCHES: Sand lightly along the scratch with No. 400 paper with water or oil-free naphtha, until the finish at the edge is very thin, but do not make the area larger than necessary. Exercise care to avoid cutting through to bare metal. Finish sanding with a light rotary motion along the edge to smooth down to a feather edge.

ROUND SPOT: Sand as before, but use a rotary motion only.

EDGES AND CORNERS: A straight sanding motion should give a satisfactory feather edge. Care should be taken to sand very lightly on edges and corners, as the cutting is more rapid on smaller surfaces and there is danger of exposing bare metal.

2. Wipe thoroughly with lint-free cloth and naphtha.
3. If bare metal is exposed, spray on several light coats of Part No. 23129 Primer to cover the bare area. Read directions on the use of the tool first. Allow at least 30 minutes drying time (or less with an infra-red lamp). Wet sand with No. 400 Wetordry paper. The Primer over-spray should be completely removed by light sanding. Keep the sanding to a minimum, as all the sanded area must be painted with finish lacquer. Surfaces with a hard painted finish will require light sanding in order to obtain a good paint bond.

(Over)

4. Wipe the area thoroughly with lint-free cloth and oil-free naphtha. Do not use "Leveler" -- it will soften the Primer. The surface to be painted must be thoroughly cleaned.

LACQUER AVAILABLE IN AEROSOL FORM

For Touch Up On Outboards:	Part 23560	White
	Part 23318	Blue
On Chain Saws:	Part 23343	Green
	Part 23318	Blue
	Part 22771	Vermilion
	Part 22772	Black
	Part 23560	White
On Construction Equipment:	Part 23343	Green
	Part 22771	Vermilion
On Yard Tracs:	Part 23560	White
	Part 23318	Blue
When Required:	Part 23129	Primer
	Part 22773	Leveler

USE OF TOUCH UP TOOL

1. Shake well, allowing the internal metal agitator to thoroughly mix the contents.
2. Practice briefly on another surface. This is important.
3. ABSOLUTE MUST -- Hold the tool no closer than 10 to 12 inches from the surface. If held too close, paint will pile up and bubble because the propellant has not been allowed to escape.
4. Open and shut valve completely with the forefinger, keeping the fingertip back of the spray pattern. Otherwise droplets will form and be blown onto the surface. Partial depression of the valve will reduce the pressure and produce faulty atomization, droplets, etc.
5. Do not attempt to cover with one coat. Sags and runs will result. Use short, dusting strokes, allowing the paint to become tacky between light mist coats.
6. Whenever possible, position the work surface horizontally. This requires less skill and time.
7. Poor atomization usually results from the tool being too cold. Keep at room temperature. (See Care and Storage on next page.)

FINAL APPEARANCE

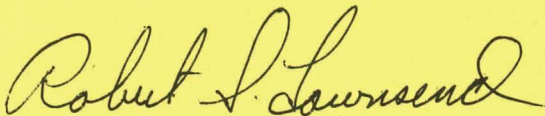
1. The touched up area should be oversprayed with clear "Leveler" to blend in the dry overspray ring around the touch up area. Apply sparingly after the lacquer has had time to set up. If properly applied, the need for rubbing should be largely eliminated.
2. Allow to dry 30 minutes (or less with an infra-red lamp).
3. Use Rubbing Compound to remove the lacquer dust on the areas surrounding the touch up. Use it also to finish off the actual touch up, if necessary. Too much rubbing will remove the porcelain like effect of the lacquer touch up, leaving a too-smooth surface.
4. Use Polishing Wax to get a uniform lustre on the entire area.

CARE AND STORAGE

1. Like all fine hand tools, your Sprayon Touch Up Tool requires reasonable care. Do not store in sunlight through glass, or expose to temperatures above 120° F. Particular care should be taken to avoid store windows, automobile back seats, etc. If chilled, or below 70° F., submerge tool in hot tap water (maximum 140°) for five minutes.
2. After each use of any tool but "Leveler," turn the can upside down and spray a jet of clear gas.
3. CLEANING: When necessary the plastic spray head can be removed for cleaning - replace by holding a finger over the orifice to prevent accidental spraying. Important - the metal orifice in the spray head must be open and free from all residue to prevent irregular spray and clogging. To clear, scrape off the face of the orifice with fingernail or other soft object and then twist the spray head 1/2 turn. The tip can also be sprayed with "Leveler" to soften the residue.

SAFETY PRECAUTIONS

1. The solvents in spray lacquer are inflammable. Do not use the tools near fire or open flame. Extinguish the flame and pilot lights of gas-fired appliances when painting. Do not puncture or incinerate container.



Robert S. Townsend
Ass't. Service Manager



BRANCH SERVICE MEMO NO. 528-O

DEALER SERVICE MEMO NO. 251

Distribution: List Nos. 5, 8 & 9

TO: All Branches, Chain Saw and Construction Equipment Dealers

SUBJECT: New Seal for Front-Half Crankcase

DATE: 1/12/65


UNITS AFFECTED: Model 20 and 35 Engine Production
Models 20, 35, 26, 5-30, 7-29 and 8-29 Service

After existing seals Part No. 71110 are used up, new seal Part No. 62750 will be used in the front half crankcases of the units listed above.

The new seal is rubber coated on its outside diameter. The rubber coating provides a "cushion" to prevent damage to the crankcase during installation.

Please mark your parts records as follows:

Seal 71110 - after stock is depleted use 62750


Walter N. Herold
Service Manager

dm

DEALER SERVICE MEMO NO. 252

Distribution: List Nos. 5, 8 & 9

TO: All Branches and Dealers

SUBJECT: XL Magnetos (Wico*), Felt Seal Added

DATE: 1/11/65

XL Engines with Wico Magnetos are now built with a new Stator Plate (Point Box) which includes a shelf to retain a new Felt Seal P/N 59760.

Point life is much improved with the felt in place, since it prevents oil vapors from entering the box.

Please mark your parts records for all XL engines (with Wico Magnetos) as follows:

	<u>New</u>	<u>Old</u>
Stator Plate and Core	58875-A	supersedes 58875
use with Felt Seal	59760	

* XL engines with Phelon Magnetos contain Seal P/N 59760 as original equipment.

Walter N. Herold
Service Manager

dm

**HOMELITE**

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DEALER SERVICE MEMO NO. 253

Distribution: List Nos. 5, 8 & 9

TO: Homelite Branches, Chain Saw and Construction Equipment Dealers

SUBJECT: Reed Alignment

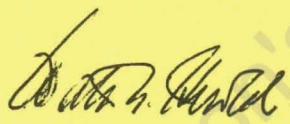
DATE: 1/13/65

Some of our reeds are riveted to their adapter. The Pyramid Reeds and the flat reed in XL engines are held in place with screws.

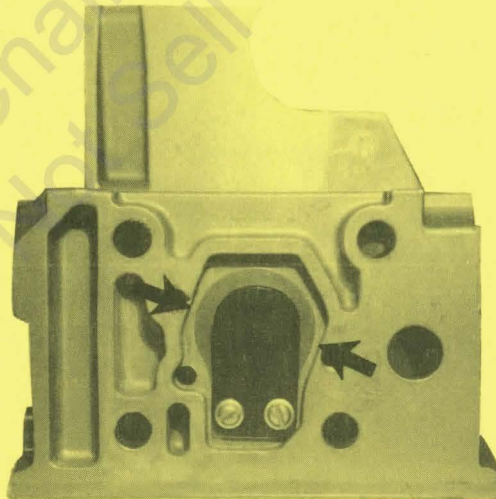
When you replace any of the reeds which are secured with screws, great care should be taken to get the reed centered over the opening.

On the pyramid reeds you can see quite well if the reed is centered -- on the XL's you have to look a little more closely!

Align XL reeds so that the spaces between the edge of the reed and the two screw holes are identical (see arrows in sketch). Failure to align reeds invites breakage! Also, use Loctite on the reed screws to keep them from working loose.


Walter N. Herold
Service Manager

dm



DEALER SERVICE MEMO NO. 254

Distribution: List Nos. 5 & 8

TO: Homelite Branches and Chain Saw Dealers

SUBJECT: New, Strengthened Connecting Rod
A-59483 Supersedes AA-55195, A & B

DATE: 1/19/65

The "27 needle" connecting rods are now machined 1/16" wider. The wider rods are identified by P/N A-59483.

After you use up your stock of AA-55195, -A and -B, use A-59483.

A-59483 also includes a new wrist pin bearing P/N 59351, which may be used in either the old or the new rods.

Wrist pin bearing assembly tool #A-23809 is now supplied with a spacer to permit "centering" the new bearing in either the old or the new rods.

Walter N. Herold
Service Manager

dm



HOMELITE

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BRANCH SERVICE MEMO NO. 533-CS

DEALER SERVICE MEMO NO. 255

Distribution: List Nos. 5, 8 & 9

TO: All Branches and Dealers

SUBJECT: Carburetors for XL Engines

DATE: 1/26/65

- I Inlet Needle and Inlet Control Lever
- II New Body

I Carburetors for XL engines are now equipped with new Inlet Needles and Control Levers.

The Inlet Needle is changed

From This



58983

To This



59717

NEW

The Control Lever is changed

From This



58976

To This



59716

NEW

Spare parts will supply only the new parts shown on the right. Needles and Levers must be used together as a set.

(OVER)

The new design makes for positive opening of the Inlet Needle whenever the engine calls for fuel.

- II A new carburetor sheet for XL engines is attached. This new parts list, #23766-B, supersedes 23766 and 23766-A. Use the new parts list for ordering carburetor parts.

You will note that the carburetor part number is now A-58767-B (Tillotson #HS-4C). This change reflects a change in the internal drilling of the carburetor body (a decrease in size of the hole which forms the seat for the Inlet Needle).


Walter N. Herold
Service Manager

dm

Leon's Chainsaw Parts & Repair
Do Not Sell or Reproduce



Distribution: List Nos. 5, 8, 9,
11 & 14

TO: All Branches and Dealers

SUBJECT: Heli-Coil Part Numbers

DATE: 1/22/65

The Heli-Coil Corporation, Danbury, Connecticut has changed their part numbers for the Thread Repair Kits.

They now call them Heli-Coil Master Thread Repair Packs. They are available with standard inserts; or with screw-lock inserts; or with one-half standard and one-half locking inserts.

Here are the Part Numbers:

<u>Size</u>	<u>No. of Inserts</u>	<u>Standard Pack*</u>	<u>All Locking</u>	<u>50/50</u>	<u>Homelite No. for the Standard Pack*</u>
8-32	30	4951-2	4951-2SL	4951-2C	A-23072
10-24	30	4951-3	4951-3SL	4951-3C	A-23073
10-32	30	4952-3	4952-3SL	4952-3C	A-23519
12-24	30	4951-1	4951-1SL	4951-1C	A-23723
1/4-20	30	4951-4	4951-4SL	4951-4C	A-22922
5/16-18	24	4951-5	4951-5SL	4951-5C	A-22923
3/8-16	18	4951-6	4951-6SL	4951-6C	A-22924

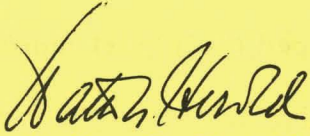
All inserts, unless ordered special, are one and one-half thread diameters long, the length of the 1/4-20 inserts, for example, is 3/8". Each Pack contains the correct Heli-Coil Tap, Installation Tool and Inserts.

Replacement Inserts are available. They are packaged by Heli-Coil under the numbers and in the quantities shown here:

<u>Size</u>	<u>Qty.</u>	<u>Standard</u>	<u>Locking</u>	<u>Standard Length</u>
8-32	15	1185-2CN	3585-2CN	1/4"
10-24	15	1185-3CN	3585-3CN	9/32"
10-32	15	1191-3CN	3591-3CN	9/32"
12-24	15	1185-1CN	3585-1CN	5/16"
1/4-20	15	1185-4CN	3585-4CN	3/8"
5/16-18	12	1185-5CN	3585-5CN	15/32"
3/8-16	9	1185-6CN	3585-6CN	9/16"

(OVER)

* We will continue to carry these Repair Kits under the Homelite Part Numbers shown. Because of the low volume of other sizes and of inserts only, we recommend that you contact your local distributor or Heli-Coil in Danbury, Connecticut for any requirements other than the kits listed.



Walter N. Herold
Service Manager

dm

Leon's Chainsaw Parts & Repair
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Distribution: List Nos. 5 & 8

TO: Branches and Chain Saw Dealers

SUBJECT: XL Brushcutters

DATE: 2/18/65

We have added a #10 lockwasher (Homelite Part No. 83046) under the #10-32 x 1/2" long round head screw which goes through the upper head and into the clutch drum bearing collar.

In addition to the lockwasher we recommend the use of Loc-tite to prevent this screw from backing out.

Please add between Index #31 and #32 on page 5 of the XL Brushcutter parts book (Parts Book #23811):

Lockwasher #10	Part No. 83046	1 required
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Walter N. Herold
Service Manager

dm



Distribution: Nos. 5 & 8

TO: All Branches and Chain Saw Dealers

SUBJECT: Carburetor Chamber

DATE: 2/17/65

UNITS AFFECTED: XL Automatic from Serial No. 1819169 to 1821699
Super XL from Serial No. 1820738 to 1821012

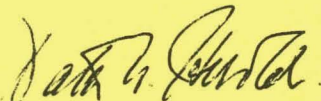
The saws in the serial number ranges listed above have been assembled with three P/N 59274 gaskets, each 1/32" thick.

Two of these 1/32" thick gaskets are used between the formica spacer and the reed adapter (see arrow in sketch), and one 1/32" thick gasket is used between the formica spacer and the carburetor chamber.

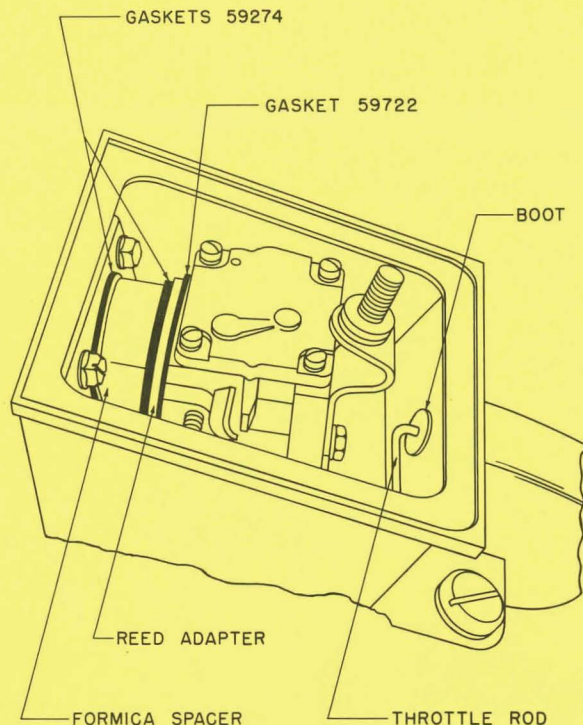
The gaskets we now use -- and all P/N 59274 gaskets from Service Parts Stock -- are 3/64" thick.

If you service one of the saws with three P/N 59274 gaskets, please discard all three gaskets and replace with two (one on each side of the formica spacer) P/N 59274 - 3/64" thick gaskets from stock.

Note also that the throttle rod Boot is installed with the accordion section facing back into the pistol grip. This is the correct way on all XL Automatics and the new Super XL.


Walter N. Herold
Service Manager

dm





Distribution: List Nos. 5 & 8

TO: All Branches and Chain Saw Dealers

SUBJECT: Reeds for Pyramid Reeds

DATE: 3/22/65

UNITS AFFECTED: XL Automatics, Super XL's

Please change Item #4 on page 4 of the Part No. 23840 parts book as follows:

<u>No.</u>	<u>Description</u>	<u>Part No.</u>	
4	Valve - reed	59678-A	*** 4

59678-A is .004" stainless steel while 59725-A was .005" carbon steel.

Only stainless will be supplied in the future. Any existing stock #59725-A may be used up.

Walter N. Herold
Service Manager

dm

**HOMELITE**

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DEALER SERVICE MEMO NO. 261

Distribution: List Nos. 5 & 8

TO: All Branches and Chain Saw Dealers

SUBJECT: Spark Plugs for XL Automatics and
Super XL Chain Saws

DATE: 3/23/65

Champion Spark Plug TJ-6-J (Homelite #59654-S) replaces the TJ-8-J (Homelite #58917-S) in the XL Automatics and the Super XL's.

But we'll continue to supply #58917-S (TJ-8-J) in the XL-12 and for service of the XL-12 and Super XL-12.

Please change Item 93 on page 3 of XL Parts Book #23840 (the green one) from 58917-S to 59654-S.

The platinum tipped 59558-S plug will work excellently in all XL saws.

A handwritten signature in cursive script, appearing to read "Walter N. Herold".

Walter N. Herold
Service Manager

dm



Distribution: 5, 8

TO: All Branches and Chain Saw Dealers

SUBJECT: Units Becoming Obsolete

DATE: 4/14/65

Units Affected: 26, 26LCS, 26LCSA Chain Saws

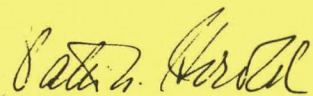
The following parts fit only the units listed above:

A-6035	Governor, Centrifugal
31733-2	Fitting, Straight Tube
71270	Bell, Drive
71298-A	Plate, Swivel Handle
71298-1A	Plate, Swivel Handle
71299-A	Spacer, Carburetor
71383	Pin, Indexing Lever
71403	Shim, Swivel Handle
71404	Spring, Throttle Button
71408-A	Gasket, Carburetor Swivel
A-71424-1	Lever, Throttle
71643	Pin, Groove
71768	Lock, Throttle
71793	Flange, Carburetor Swivel
71795-B	Guard, Carburetor
AA-71960	Sprocket & Drum, Belt
71973-A	Pin, Sprocket Hub
71974-A	Flange, Sprocket
71975-B	Nut, Sprocket
AA-71997	Rope, Starting (Steel)
72014-4	Crankshaft
72015-B	Shield
72016	Spacer, Bearing
72017	Spider, Clutch
72018	Shoe, Clutch
AA-72020	Clutch
72039	Ring, Piston
A-72116	Crankcase, Front Half
72121	Cylinder
AA-72127	Fitting, Tube Elbow
AA-72140	Bracket, Starting Rope
AA-72146	Carburetor
72151-A	Ring, Handle Indexing
72152	Bushing, Swivel Handle

(over)

72155	Cover, Air Filter
AA-72158	Handle, Swivel
AA-72158-1	Handle, Swivel
72160	Button, Throttle
AA-72162	Shaft, Throttle
72165-A	Lever, Throttle Shaft
AA-72168	Container, Fuel
AA-72168-1	Container, Fuel
72170	Decal
AA-72172	Fuel Filler Cap
AA-72177	Pump, Oil
72254-B	Sprocket
AA-72260	Brush, Filter Cleaning
72310-A	Line, Fuel
72404	Nozzle, Main
AA-72406	Piston
AA-72479	Element, Air Filter
72506	Gasket, Swivel Handle
72507	Gasket, Swivel Handle
AA-72686	Plug, Button
72733	Element, Muffler
AA-72736	Muffler
72789	Washer, Sprocket
72835	Sprocket, Cutting Chain
A-72850	Crankcase, Front
72853	Hub, Sprocket
AA-72854	Sprocket
73049	Decal
AA-73050	Sprocket
AA-73136	Line, Pressure Relief
73925	Sprocket

After existing stocks are used up, we will no longer attempt to supply any of these parts.



Walter N. Herold
Service Manager

mr



Distribution: 5, 8

TO: All Branches and Chain Saw Dealers

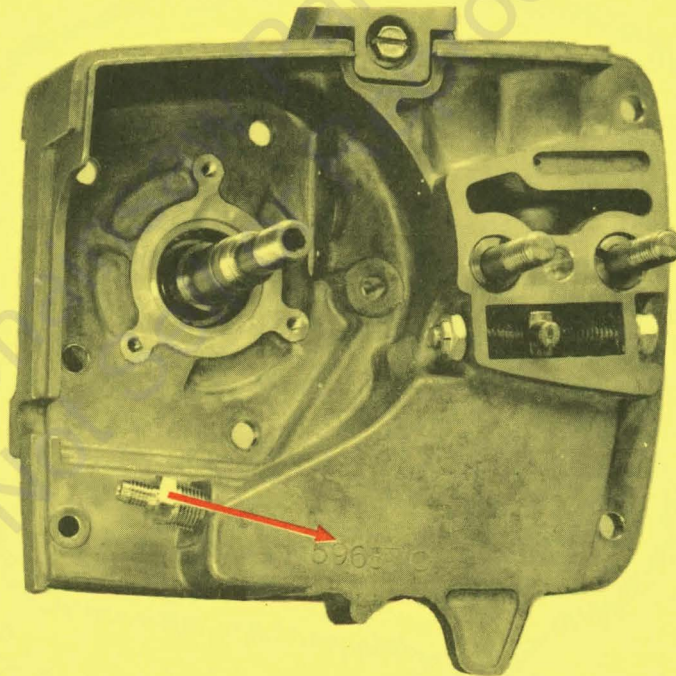
SUBJECT: XL Automatic and Super XL Service

DATE: 4/27/65

We snapped the picture below to show the angle at which the Oil-Pick-Up assembles into the drive case.

Some people have "cross threaded" these fittings by trying to install them parallel to the floor - which is not correct.

This picture should help you to remember to "angle" the part slightly so that it goes in properly and seals tightly.



Walter N. Herold
Service Manager

mr



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DEALER SERVICE MEMO NO. 264

Distribution: 5, 8

TO: All Branches and Chain Saw Dealers

SUBJECT: New Handle Clamp for Brushcutters

DATE: 5/4/65

Handle Clamp #55398-C supersedes #55398-B.

The new clamp is made of malleable iron; the -B clamp was aluminum.

While we made this change we also adjusted the thickness of the clamping bosses so that all three clamping screws used are now the same size (5/16 - 18 x 1" long). The screw part number is 80308.

Please mark your records accordingly.

Walter N. Herold
Walter N. Herold
Service Manager

mr

Leon's Chainsaw Parts & Repair
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Distribution: 8

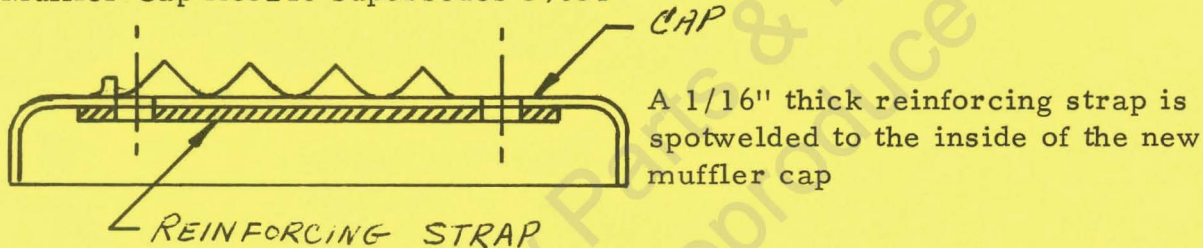
TO: All Branches and Chain Saw Dealers

SUBJECT: I Muffler Caps
II Muffler Studs

DATE: 5/14/65

Units Affected: All XL Chain Saws except those with "stack" muffler

I Muffler Cap A63246 supersedes 59051



II To compensate for the thickness of the strap, the muffler studs for the new cap were made 1/16" shorter.

<u>Short (new)</u>	<u>Long (old)</u>	<u>Used On</u>
59065-A	59065	Super XL-12
59891-A	59891	XLAO, Super XL, Super XL-15

Old studs may be reworked by machining 1/16" off the hex end.

If a new cap is used to replace an old cap, be sure to change the studs to the shorter ones so that the baffle inside the muffler will be clamped firmly.

Walter N. Herold
Walter N. Herold
Service Manager

mr



BRANCH SERVICE MEMO NO. 551

DEALER SERVICE MEMO NO. 266

Distribution: 5, 8

TO: All Branches and Chain Saw Dealers

SUBJECT: XL Units with Wico Ignition

DATE: 5/19/65

Condenser #63250 supersedes #58817

After present stock is used up, Wico will supply condenser #63250 in place of #58817. Please mark your parts lists accordingly.

No. 63250 has a shorter lead than #58817. This shorter lead should be wrapped around the coil primary lead only once. (The long lead of 58817 went around three times.)

This change was made to avoid breaking the connection from the lead to the inside of the condenser.

Walter N. Herold
Service Manager

mr



BRANCH SERVICE MEMO NO. 552-CS

DEALER SERVICE MEMO NO. 267


Distribution: 5, 8

TO: Branches and Chain Saw Dealers

SUBJECT: Special Reed Adapter Assembly for C-91 Chain Saws DATE: 5/21/65

Part No. A63239 is a brand new flat reed assembly, designed especially for the C-91 chain saws. It incorporates a special "High-lift" reed stop. It's standard equipment on all C-91's from Serial No. 1854403 on.

It may be installed in earlier C-91's and it could be used on C-9's also. In a C-9, however, use of this high performance reed calls for the air filter cover from the C-91 series to get the proper match between the height of the cover and the angle of the cover stud which is installed in the elbow.


Walter N. Herold
Service Manager

mr



BRANCH SERVICE MEMO NO. 553-CS

DEALER SERVICE MEMO NO. 268

Distribution: 5, 8, 9

TO: All Branches, Chain Saw and Construction Equipment Dealers

SUBJECT: Rotor Screen Alignment in XL Units

DATE: 5/26/65

New, Shouldered "Centering" Stud


P/N 58757-A Stud Replaces P/N 58757 in All XL Units

There have been some instances where a misaligned screen interfered with the free return of the recoil starter.

The Part No. 58757-A stud has a shoulder to align the screen most accurately and to eliminate the chance of interference between the center hole of the screen and the starter cup.

Old studs (Part No. 58757) may be used up, but care should be taken to align the screen when you tighten it down.

Service Parts will ship new studs (Part No. 58757-A) only, and these new studs will do the job automatically.


Walter N. Herold
Service Manager

mr



Distribution: 5, 8, 9

TO: Homelite Branches, Chain Saw and Construction Equipment Dealers

SUBJECT: Service Tools Listing

DATE: 5/26/65

Attached is your copy of Service Tool Listing #23903. It supersedes List #23737 under orange Section 10 of your Service Manual. Place this up-to-date listing where you can find it when you need it. All recently released units are covered.

Vincent F. Regan, Supervisor
Marketing Communications

mr

Leon's Chainsaw Parts & Repair
Do Not Sell or Reproduce

PRICE .10

HOMELITE SERVICE TOOLS

For: CHAIN SAWS, CIRCULAR SAWS, BRUSHCUTTERS, KART ENGINES

(THROUGH APRIL, 1965 PRODUCTION)

Tool Description	Part No.	Saw/Engine Model																									Notes
		EZ, E2-6	Bolt Drive Saws	A-20, E-20, E-20L	AT-20, E-20L	WIZ, E-20	A-200	17 1/2"	7-19, 7000	7-21, 7000	7-21, 7000	7-21, 7000	7-21, 7000	7-21, 7000	7-21, 7000	7-21, 7000	7-21, 7000	7-21, 7000	7-21, 7000	7-21, 7000	7-21, 7000	7-21, 7000	7-21, 7000	7-21, 7000			
PLUG - Seal Assembly, Continued	a) 23233 b) 23176 b) 23233-1 b) 23384 e) 23391-2 c) 23671 c) 23845 c) 23725-A 23781	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*		
PULLER - Bearing	A-23778																										
PULLER - Clutch Spider	A-23863 A-23131	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*		
PULLER - Magneto Rotor	A-22560 A-22810 A-23761-A	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*		
ROD - Locking	22963																										
SLEEVE - Crankshaft, Main Brng., & Seal Assembly	a) 23557 a) 23136 a) 23666 a) 23884 b) 22720 b) 22764 c) 22721 e) 22819 e) 23232 e) 23422 e) 23750 d) 23776 e) 23693 e) 23800 e) 23843 e) 23844 f) 23390	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*		
SPACER - Crankshaft Assembly	23382																										
WRENCH - Box	23786																										
WRENCH - Combination	22808	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*		
WRENCH - Socket Head Screw	22061 22221 22865 23605 23785 a) 22220 a) 23328 a) 22126	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*		
WRENCH - Spanner	23710 A-23696																										
WRENCH - Square Section	22964																										
WRENCH - Stud Insert	A-23841																										

LV654

HOMELITE A Textron DIVISION PORT CHESTER, NEW YORK PART NO. 23903

Tool Description	Part No.	WIZ Drive Series																				Notes
		EZ-6	WIZ-6	WIZ-7	WIZ-8	WIZ-9	WIZ-10	WIZ-11	WIZ-12	WIZ-13	WIZ-14	WIZ-15	WIZ-16	WIZ-17	WIZ-18	WIZ-19	WIZ-20	WIZ-21	WIZ-22	WIZ-23	WIZ-24	
ANVIL - Crankshaft Installation	23846																					† XL-AO & Super XL only
ANVIL - Sprocket Shaft Assembly	23267		*																			† WIZ-A only
COLLAR - Main Bearing Assembly	22678	*																				Use w/sleeve #22557 & jackscrew #A-23680 Use w/sleeve #23136 & jackscrew #A-23672 a) Use w/sleeve #23136 & jackscrew #A-23137 † WIZ only † Use w/sleeve #23666 & jackscrew #A-23667 for 775G & 770GS † EZ-6 w/7 digit S/N only
	a) 22820-2		*																			
	a) 22820-1	*																				
	a) 23138																					
	a) 23138-1																					
FIXTURE - Drive Case Assembling	A-23858																					† XL-AO & Super XL only
FIXTURE - Sprocket Holding	22750	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	† XL-15 only
	A-23713																					
	A-23792																					
GAUGE - Breaker Point	22486	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	.015" .020"
	22699																					
JACKSCREW - Main Bearing & Crankshaft Assembly	A-22680	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	Use w/sleeve #22557 & collar #22678 Use w/sleeve #23136 Use w/sleeve #23666 & collar #22820-1, use w/sleeve #23232 (crankshaft) Use w/sleeve #23136 & collar #22820-2
	A-23137																					
	A-23667																					
	A-23672																					
KEY - Torque Wrench	A-22224	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	Recoil starter
PLATE - Crankshaft Aligning	22812	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	
	22812-1																					
	23383																					
	23670																					
PLIERS - Retaining Ring	22726	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	Sprocket shaft bearing retaining ring Piston pin retaining ring † XL-15 only ‡ XL-100 only
	22828																					
	23665																					
	23785																					
	23795																					
	23796																					
PLUG - Bearing Assembly	a) 22892	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	a) Sprocket shaft bearings † WIZ only ‡ WIZ-A only Use w/sleeve #23290 (seal) b) Sprocket/Drum bearings XL-15 & XI-AO gear only Except XL-100 c) Connecting rod bearings d) Backplate bearings e) Crankcase bearings f) Crankcase & drivecase bearings g) Drivecase bearings XL-100 only h) Gear housing cover bearing i) Starter bearings † 995D, G only j) Planetary bearings XL-15 & XI-AO gear k) XL-100 drive gear bearing
	a) 22833		*																			
	a) 23228		*																			
	a) 23280																					
	b) 23129	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	
	b) 23420		*	*																		
	b) 23726-A																					
	b) 23779																					
	b) 23319																					
	c) 23372																					
	e) 23756																					
	e) 23874																					
	e) A-23809	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	
	e) 23294	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	
	d) 22831	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	
	d) 23391																					
	d) 23391-1																					
	e) 23174	*	*																			
	e) 23176	*	*																			
	f) 23757																					
f) 23758																						
g) 23391-2																						
g) 23780																						
g) 23876																						
h) 23663																						
h) 23664																						
i) 23678																						
i) A-23678																						
j) 23725-A																						
j) 23772																						
k) A-23810																						
PLUG - Seal Assembly	23726-A																					Planet carrier seal a) Backplate seals
	a) 22891																					
	a) 22830	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	
	a) 22830-A	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	



Distribution: 5,8,9

TO: Homelite Branches and Dealers

SUBJECT: Molded Fuel Line

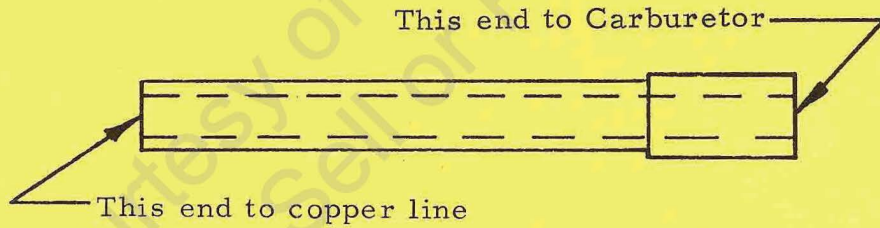
DATE: 6/4/65

Units Affected: All XL Chair Saws, Brushcutters, Circular Saws

A new, Molded Fuel Line, Part No. 58958, is now used in the units listed above.

Fuel Lines, Part Nos. 58997 and 59828, in your stock should be used up; but mark your records as follows:

58997	}	Use up; ask for Part No. 58958 next order.
59828		



Walter N. Herold

Walter N. Herold
Service Manager

mr



BRANCH SERVICE MEMO NO. 557-CS

DEALER SERVICE MEMO NO. 272

Distribution: 5, 8

TO: All Chain Saw Dealers

SUBJECT: XP-1000 with Wrap around Handle Bar

DATE: 6/3/65

Three handle bars are listed for the XP-1000:

A58650-2	Flush Cut
A58398	Standard Wrap Around
A59922	Special Wrap Around

This last handle bar, A59922 must not be used at this time. If any saw was equipped with this bar, remove it and use one of the other two instead.

In a short while, we will have available a new drive case cover and a new guard plate which will make it possible to use A59922 again.

The new drive case cover (which also shields the muffler) will carry Part No. A58683 and will be standard for all future XP-1000's. The guard plate will carry Part No. 63389 and will be required only with handle Part No. A59922. It must be used together with the long "west coast" spiked bumper Part No. 59975.

Please notify all concerned to make sure that Part No. A59922 Handle Bar will not be used until the guard plate is available.

Walter N. Herold
Service Manager

bn



BRANCH SERVICE MEMO NO. 559-CS

DEALER SERVICE MEMO NO. 273

Distribution: 5, 8

TO: Branches and Chain Saw Dealers

SUBJECT: Felt Washer Added

DATE: 7/9/65

UNITS AFFECTED: XL, C, XP Saws

A felt washer, Part No. 63290, has been added inside the carburetor chamber of the subject chain saws.

The felt washer is held by the cotter pin in the drain hole. Its function is to prevent the entry of fine saw dust at that point.

Please add Part No. 63290 Washer, felt to the XL, C and XP parts lists.

Walter N. Herold
Walter N. Herold
Service Manager

mr



BRANCH SERVICE MEMO NO. 560-CS

DEALER SERVICE MEMO NO. 274

Distribution: 5, 8

TO: All Branches and Chain Saw Dealers

SUBJECT: Drivecase Assemblies - XP and C Chain Saws

DATE: 7/22/65

After your existing stock of Drivecase Assemblies, Part No. A59493-1 is used up, Part No. A59493-A1 can be used as a replacement.

Part No. A59493-A1 is standard on the XP-1000. It contains Needle Bearing, Part No. 63043, (with greater load carrying capacity) and it is machined to accept the dowel pins which are part of the XP-1000 crankcase. To replace the Part No. 63043 Needle Bearing in this drivecase, use Tool, Part No. 23876, instead of Part No. 23391-2 which fits Bearing, Part No. 74251, in the old drivecase.

Starting with Serial No. 1935931, our Production Department is using A59493-A1 on "C" model chain saws as well as on the XP-1000.

Please mark your records as follows:

A59493-1 Drivecase

Do not reorder - use up on C's below S/N 1935931.

A59493-A1 Drivecase

replaces A59493-1, must be used on the XP-1000.

Walter N. Herold
Service Manager

bn



BRANCH SERVICE MEMO NO. 561-CS

DEALER SERVICE MEMO NO. 275

Distribution: 5, 8

TO: All Homelite Branches and Chain Saw Dealers

SUBJECT: Engine Operation in the Summertime

DATE: 7/22/65

A few reports of overheating and of boiling fuel in Chain Saws have reached us. These reports seem to be limited to days when the temperature is well above 90° and, even then, only saws which are worked hard and constantly are affected. The XL-500, perhaps because it is used with longer bars and for heavier cutting, has been mentioned somewhat more frequently than the other saws; but the following applies to the XLAO and Super XL also.

The overheating is primarily due to the clogging of the cooling passages with sawdust. To prevent it, the saw must be kept clean.

If you have a customer who complains about an engine which overheats, instruct him to remove the Starter-Fan Housing (four screws) and to clean the inside of the housing and all the cylinder fins. If these parts are clean, if there are no restrictions, the cooling air can carry away the heat and keep the engine temperature down.

One other point! Fuel tank caps are designed with a vent to let air in as fuel is used by the engine. They'll also let air, or fuel, out - but not unless some pressure is built up inside the tank. If a cap leaks under normal conditions, the fuel cap valve has to be replaced.


Walter N. Herold
Service Manager

mr



Distribution: 5, 8,

TO: All Branches and Chain Saw Dealers

SUBJECT: Washer, Felt Part No. 56292-A

DATE: 8/2/65

Units Affected: All C and XP Series Saws

Felt Washer, Part No. 56292-A, is added between the stator plate and the crankcase hub on all C-series and XP-series saws.

The purpose of the washer is to prevent foreign matter from entering the breaker box.

When saws come in for service, we recommend that you add the felt washer.

Also, add the felt washer to the parts lists for the C-series and the XP-1000.

Walter N. Herold

Walter N. Herold
Service Manager

mr

P.S. This is the same washer which is already in use on the 775, 995, Wiz and similar saws.



BRANCH SERVICE MEMO NO. 563-CS

DEALER SERVICE MEMO NO. 277

Distribution: 5, 8

TO: All Branches and Chain Saw Dealers

SUBJECT: Air Deflector Part No. 63033

DATE: 8/6/65

Units Affected: XL-500 Chain Saw

Air Deflector, Part No. 63033 which was assembled between the muffler and cylinder of the XL-500 chain saw has been obsoleted.

The deflector is shown as Item #73 in figure 2 of the XL-500 Parts List. Please cross it out to indicate that this part will not be used any longer.

As we pointed out in our recent Service Memo (#561-CS, DSM #275 dated 7/22/65) clean air passages are most important for cool engine operation -- removal of the deflector helps keep cylinder fins clean.

A handwritten signature in cursive script that reads 'Walter N. Herold'.

Walter N. Herold
Service Manager

mr



Distribution: 5, 8, 9

TO: Homelite Branches, Chain Saw and Construction Equipment Dealers

SUBJECT: Carburetor Pump Diaphragms

DATE: 8/23/65

For some time, we have been using TEFLON pump diaphragms in all HL and HS carburetors. Tillotson recommended Teflon, primarily because of its excellent resistance to alcohol and aromatics which are often added to fuels, especially in the wintertime.

While Teflon was, therefore, standard equipment for production and while Teflon diaphragms were included in Gasket Sets and Repair Kits, we have always had some call for the old, thin rubberized diaphragms -- and we did keep a few in Service Parts stock.

The pendulum has now swung the other way and rubber seems to be preferred. Consequently, we are making the following changes:

<u>Fuel Pump Diaphragms</u>	<u>Going into Production</u>	<u>Going out of Production</u>
for HL Carburetors	████████ 57729	58193
for HS Carburetors	58980-R These are black rubber.	58980 These are Teflon. We will still keep a few in Spare Parts.

Please change your records accordingly.

Walter N. Herold

Walter N. Herold
Service Manager

mr



HOMELITE

a division of Textron Inc.

BRANCH SERVICE MEMO NO. 565-CS

DEALER SERVICE MEMO NO. 279

Distribution: 5, 8

TO: All Districts and Chain Saw Dealers

SUBJECT: Exhaust Silencer, Part No. A-63080

DATE: 9/1/65



Exhaust Silencer, Part No. A-63080 fits all XL saws with the large muffler body: XL Automatic, Super XL, XL-500, XL Automatic Gear Drive, Super XL-15. You can put the silencer on the XL-12, XL-15 and Super XL-12, but you will need the large

- | | |
|------------------------|-------------------|
| Muffler Body - A-59895 | 2 Studs - 59891-A |
| Muffler Cap - A-63246 | 2 Screws - 80825 |

The silencer is the part between the muffler body and the cap. It fits into the body in place of the simple baffle. Now go ahead, quietly, and order all you need --A-63080.

Walter N. Herold
Walter N. Herold
Service Manager

mr

Distribution: 5, 8

TO: All Branches and Chain Saw Dealers

SUBJECT: Worm for Automatic Oil Pump

DATE: 9/3/65

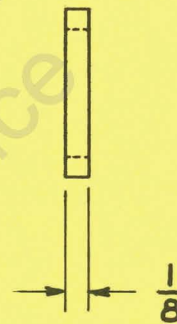
Unit Affected: XP-1100

The sketch here shows the oil pump worm used in early production



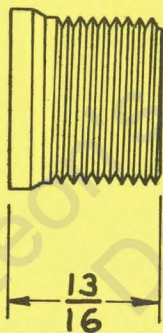
Worm 63084-1

requires 1/8" thick spacer



Spacer 63431

The sketch below shows set-up in later units.



Worm 63084

This worm is longer and does not require spacer. When replacing short worm with long one, remove and discard spacer.

Walter N. Herold
 Walter N. Herold
 Service Manager

mr



BRANCH SERVICE MEMO NO. 567

DEALER SERVICE MEMO NO. 281

Distribution: List Nos. 5 and 8
plus Rental Dealers

TO: All Branches and Chain Saw Dealers

SUBJECT: XP Mufflers - new, bigger studs

DATE: 9/3/65

Units Affected: All XP Chain Saws

Starting with XP-1000, S/N 1962315 and XP-1100, S/N 1961294 we are using 1/4 - 20 threaded studs to secure the muffler to the cylinder.

The parts listed below are affected:

Cylinder	58175-A (12-24 thread)	now	58175- <u>B</u>	(1/4-20 thread)
Stud	59982 (12-24 thread, 5/16" body)	"	59982- <u>A</u>	(1/4-20 thread, 3/8" body)
Muffler Body	A-59927 (15/64" holes)	"	A-59927- <u>A</u>	(17/64" holes)
Muffler Baffle	59978 (11/32" holes)	"	59978- <u>A</u>	(13/32" holes)

To rework earlier units, cylinders can be retapped* 1/4-20 to accept the stronger studs. Old muffler bodies and baffles must be re-drilled to accept the larger thread and body of the new studs. (Muffler caps and the two screws to hold them to the studs are not changed.)

Walter N. Herold
Service Manager

las

* No drilling is required, a 1/4-20 tap works very well directly in the old 12-24 hole.



BRANCH SERVICE MEMO NO. 568CS

DEALER SERVICE MEMO NO. 282

Distribution: 5, 8

TO: All Branches and Chain Saw Dealers

SUBJECT: GUIDE BAR ADJUSTING SCREW

DATE: 9/22/65

Units Affected: All XL Chain Saws

Guide Bar Adjusting Screw #63225 supersedes Screw #80885 in the XL series saws. The new screw has a "fillister" head instead of a round head.

The change was made to reduce the packing of sawdust around the screw head.

Please mark your records as follows:

#80885 Rd. Head Screw - order #63225 for XL bar adjuster

Walter N. Herold
Walter N. Herold
Service Manager

mr



Distribution: 5, 8, 9, 14

TO: Homelite Branches and Dealers

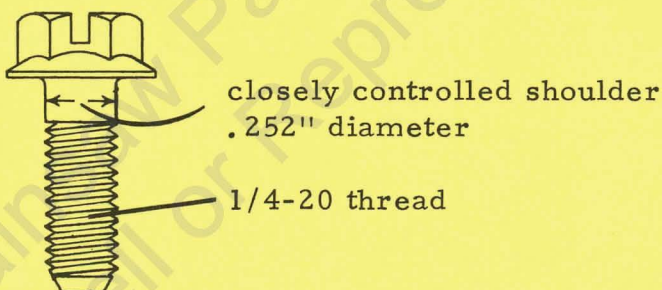
SUBJECT: Fuel Tank to Crankcase Fastening

DATE: 10/1/65

Units Affected: All XL's

The method of fastening the fuel tank to the crankcase has been improved:

- a) The three holes in the crankcase have been opened up from a 12-24 thread to 1/4-20 thread.
- b) The three screws to fasten the tank are now special "shoulder" screws, Part No. 63407.



- c) The holes in the tank have been opened up to match the new shoulder screws. The part number for the tank becomes 58732-A.

Existing units can be serviced with the new set-up as follows:

- 1) Tap the three mounting holes 1/4-20. (no tap drill is required -- the 1/4-20 tap works well in the 12-24 holes.)
- 2) Use a letter F drill (.257" diameter) to size the three holes in the fuel tank.
- 3) Reassemble with the new 63407 shoulder screws, using Loctite on each screw.

Service Parts will only supply latest tanks and crankcases. The crankcase, Part Nos. A-59801-B (for the XL-500) and A-58799-B (for all other XL units) describe the crankcases with 1/4-20 threads for the tank. They also have the reduced chamfer for the new flat gaskets on the drivecase side as listed in Service Memo #572CS/285 which you should read now.

Walter N. Herold
Walter N. Herold
Service Manager



Distribution: 5, 8, 14

TO: Homelite Branches and Dealers

SUBJECT: Crankcase to Drivecase Gasket

DATE: 10/1/65

Units Affected: All C and XP Chain Saws, All XL Units

Instead of an O-ring, we are now using a flat gasket between the crankcase and the drivecase in all units listed above.

The use of a flat gasket virtually eliminates the danger of cocking the two parts during assembly, thereby protecting the needle bearings from damage.


All units, even those which were originally built with O-rings, may be serviced with the flat gaskets. Those which we are building now with the flat gasket cannot use the O-ring because the 45° chamfer on the crankcase is now smaller.

Please mark your parts records as follows:

XL Units:	58785 O-ring	Superseded by	63355 Gasket
C & XP Saws:	58329 O-ring	Superseded by	63356 Gasket

Service Parts will automatically supply latest crankcases which will be identified with a new "dash" suffix.

A-58317-A1	will become	A-58317-B1
A-63072	will become	A-63072-A1
A-58799 and -A	will become	A-58799-B
A-59801	will become	A-59801-B


Walter N. Herold
Service Manager

mr



BRANCH SERVICE MEMO NO. 575CS

DEALER SERVICE MEMO NO. 287

Distribution: 5, 8

TO: Homelite Branches and Chain Saw Dealers

SUBJECT: Guide Bar Fasteners

DATE: 10/22/65

Units Affected: All Direct Drive Chain Saws
All Planetary Gear Drive Chain Saws

The lockwashers between the drivecase and the mounting nuts have been deleted from the units mentioned above.

This change eliminates wear of the drivecase cover which resulted from the "milling" action of the lockwashers.

However, on the XL planetary gear drive saws, two flat washers, Part No. 84056 are now used in place of the lockwashers to keep the corners of the nut from hitting the counterbore. All other units mentioned use the nuts only, without any washers.

A handwritten signature in black ink, appearing to read "Walter N. Herold". The signature is written in a cursive style.

Walter N. Herold
Service Manager

mr



Distribution: 5, 11

TO: All Homelite Branches and Yard Trac Dealers

SUBJECT: Replacement Wheel Bushings

DATE: 11/15/65

Units Affected: All Yard Trac Models

We can now supply replacement wheel bushings for most of the front and rear wheels used on the Yard Trac Mowers from 1960 through 1966.

FRONT WHEELS

<u>Year</u>	<u>Service Wheel</u>	<u>Replacement Bushing</u>	
1960 - 1961	66147	Not Available	
1962 - 1963	66147-A	Not Available	
1963 - 1964	A-66445	66661 Inner - 66667 Outer	} 3" wide tread Semi pneumatic tire
1964 - 1966	A-66473	66661 Inner - 66667 Outer	
1965 - 1966	A-66533	66669 Inner - 66670 Outer	Pneumatic tire

REAR WHEELS

<u>Year</u>	<u>Service Wheel or Hub</u>	<u>Replacement Bushing</u>	
1960 - 1962 Standard	A-66153	76153	
1960 - 1962 Deluxe	A-66158	66161	
1963 - 1966	66436	66660	Standard width tread
1965	66528	66660	Wide tread tire
1966	66528	66660	Wide tread tire

Robert S. Townsend

Robert S. Townsend
Ass't. Service Manager

bn

577-M



DEALER SERVICE MEMO NO. 288

Distribution: 5, 11

TO: Homelite Branches and Yard Trac Dealers

SUBJECT: Drive Disc

DATE: 11/1/65

Units Affected: All Yard Tracs

The Drive Plate has in some cases caused hard shifting by rising off the bearings. Effective with YTD-6, S/N 2030959, the Drive Plate is prevented from upward movement by the addition of a snap ring below the lower bearing.

The new Drive Plate and Snap Ring can be used in all existing Yard Tracs; however, a new spacer must be used between the two bearings and also under the lower bearing. The drive plate shaft has been changed as the two bearings will now be closer together.

Drive Plate	66000-A	supersedes	66000
Bearing Spacer	66011-A	"	66011 (between bearings)
Main Drive Spacer	66012-A	"	66012 (under lower bearing)
Drive Plate Shaft	66008-A	"	66008
Snap Ring	66642	(Install with the flat side toward the bearing)	

We will no longer supply the superseded parts when present stock is exhausted. These changes have been incorporated in the 1966 Yard Trac Parts Book, Part No. 23894.

Robert S. Townsend

Robert S. Townsend
Ass't. Service Manager

mr



BRANCH SERVICE MEMO NO. 578a

DEALER SERVICE MEMO NO. 290a

Distribution: 5

TO: All Branches and Chain Saw Dealers

SUBJECT: Chain Sizes 72D59E and 72D58E

DATE: 7/8/66

Units Affected: XL Chain Saws


In the original service memo we reserved the 3/8 pitch 72D chain with 59 drive links for XL saws with planetary gears and for the 15" bars on C and XP chain saws.

We also said that 58 drive link chain should be used with 16" bars on all direct drive XL's.

This is no longer true. With the 8 tooth 3/8 pitch sprocket as used on the XL-850 - or when this sprocket is put on an XL-800 - the 59 drive link chain is again called for when using 16" bars.

With 20" bars, the 72D69E is just a little tight -- but we feel it is better to stay with the 69 link chain there, rather than going to 70 links.

We have under development a 7 tooth 3/8 pitch sprocket for the XL-800 and XL-850. Once that sprocket becomes available we will, of course, revert to 72D58E for the 16" units involved.

Walter N. Herold 
Service Manager

nap



Distribution: List Nos. 5 & 8

TO: All Branches and Chain Saw Dealers

SUBJECT: Idle Speed Adjustments

DATE: 11/29/65

Units Affected: I All C and XP Saws
II All XL Saws

The changes described below were made to increase the accuracy with which idle speed settings can be made and maintained.


In principle we have removed any linkage between the throttle lever and the adjusting screw so that the throttle comes back to the same place every time the trigger is released.

On the C and XP saws, perhaps more than on the others, this has been mentioned as a source of complaints -- making the change now should do much to help remedy the situation.

I. C and XP Saws

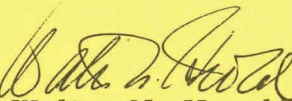
- a) The external idle speed adjustment screw is removed. The resulting hole should be plugged with plug screw P/N 71505.
- b) Internal idle adjustment screw P/N 71509 and spring P/N 28064 are put back right onto the carburetor.
- c) New Service carburetors will be shipped with the idle speed adjustment screw and spring.
- d) Order extra screws, springs and plugs as needed since older units can be changed easily.

(over)

- II. On the XL units the change is a "factory" change which includes new machining of the carburetor chamber and a carburetor with a new throttle lever.
- a) Carburetor A-58767-C incorporates a new throttle lever with a longer arm.
 - b1) Carburetor chamber A-59507-A has a 5/16 - 18 tapped hole in the left side and the 10-32 tapped hole used before. When we ship, both holes are plugged, (71505 Plug in the 10-32 hole, 63303 Plug in the 5/16 - 18 hole). This is done so that the chamber can be used for service of old and new units. The chamber fits XL-12, Super XL-12, XL-15 and the XL-100 Circular Saw.
 - b2) Carburetor chamber A-59931-A has the 5/16 - 18 tapped hole in the left side and a 1/4 - 28 tapped hole used before. Again, both holes are plugged -- the 1/4 - 28 plug is P/N 63310. This chamber fits the XL Automatic, XL-AO Gear, Super XL, Super XL-15 and the XL-500.
 - c) The new 5/16 - 18 adjustment screw, acting directly on the throttle lever, is kept from turning by a "NYLOCK" insert. The screw carries P/N 63302 and looks  like this.

Summary of new parts or parts reinstated:

10 - 32 Plug Screw	71505
1/4 - 28 Plug Screw	63310
5/16 - 18 Plug Screw	63303
C Carburetor	A-59427-A for C's
XP Carburetor	A-59928-A for XP's
XL Carburetor	A-58767-C
C and XP Idle Speed Screw	71509
C and XP Idle Speed Spring	28064
XL Idle Speed Screw	63302
XL (flat reed) Carburetor Chamber	A-59507-A
XL (pyramid reed) Carburetor Chamber	A-59931-A


Walter N. Herold
Service Manager



Distribution: 5, 8

TO: All Branches and Chain Saw Dealers

SUBJECT: Muffler Mounting

DATE: 11/30/65

Units Affected: XL Engines

XL Cylinders and XL sheet metal Muffler Bodies have been revised to allow use of a third attachment screw.

A tapped boss is provided on all new cylinder castings; a matching hole in the muffler bodies accepts a 12 - 24 x 1/2" Pan Head Screw, Part No. 80963.

This screw must be tightened first, but we suggest that you use the two muffler studs to "align" the muffler body and keep it from shifting, while you tighten the screw (proper torque is 50 inch pounds).

Muffler bodies without the third hole will be kept in spare parts stock for a while to service units built prior to this notice.

Part numbers are affected as follows:

1 3/4" Bore Cylinder	58706-B	supersedes	58706-A	(use up)
1 13/16" Bore Cylinder	58706-B1	supersedes	58706-A1	(use up)
2" Bore Cylinder	* 59458-B	supersedes	59458-A	(use up)

Muffler body with third hole

Muffler body without third hole

Small A59049-A

A59049

Large A59895-A

A59895

Third attachment screw is Part No. 80963.

* While the above changes were made, we also eliminated the vertical fin on top of the 2" Bore Cylinder (now Part No. 59458-B) to reduce chances of sawdust packing in the area and to allow easier passage for cooling air.

Walter N. Herold
Walter N. Herold
Service Manager



BRANCH SERVICE MEMO NO. 582CS

DEALER SERVICE MEMO NO. 293

Distribution: 5, 8

TO: All Branches and Chain Saw Dealers

SUBJECT: Filler Cap, Chain Oil

DATE: 12/6/65

Unit Affected: XP-1100

Magnesium Filler Cap, Part No. A-56580, replaces Plastic Cap,
Part No. A-58390-A.

Please change Index No. 116 on Page 5 of the XP-1100 parts book
accordingly.

A handwritten signature in black ink, appearing to read "Walter N. Herold".

Walter N. Herold
Service Manager

mr



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BRANCH SERVICE MEMO NO. 583CS

DEALER SERVICE MEMO NO. 294

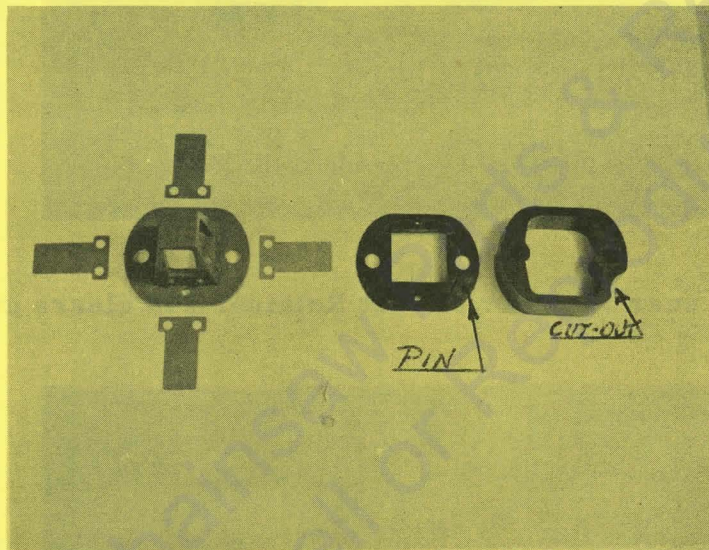
Distribution: 5, 8

TO: All Branches and Chain Saw Dealers

SUBJECT: New Reed Valve Assembly

DATE: 12/6/65

Units Affected: XL Engines with Pyramid Reed



The picture above shows the new molded Delrin Reed Valve Seat, Part No. 63253 (on the left, among the four reeds). You'll note that there are no more screws and no more springs.

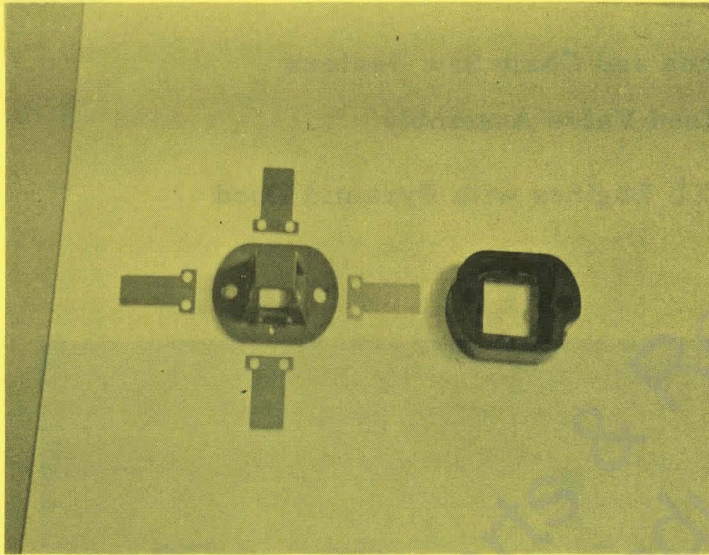
Instead, all four reeds are retained by a new molded rubber Reed Valve Retainer, Part No. 63260 (the center piece with the little "Pin").

Assembly is as easy as one - two - three.

(over)

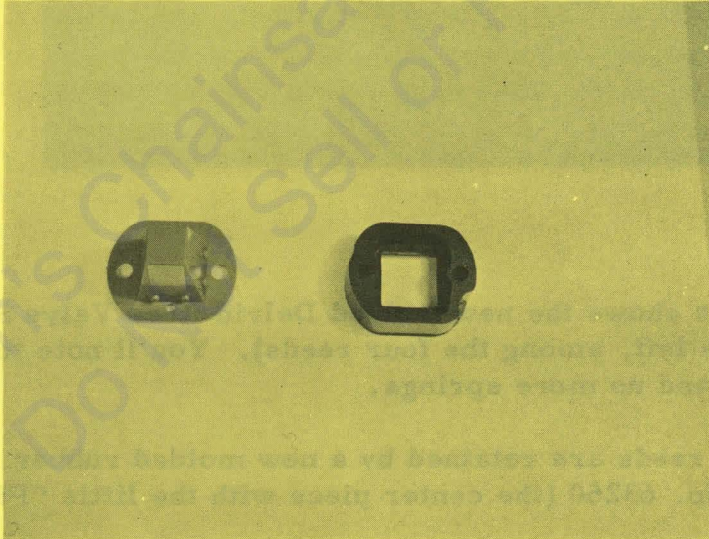
Lay out the parts as shown in diagram on Page 1. Then

1



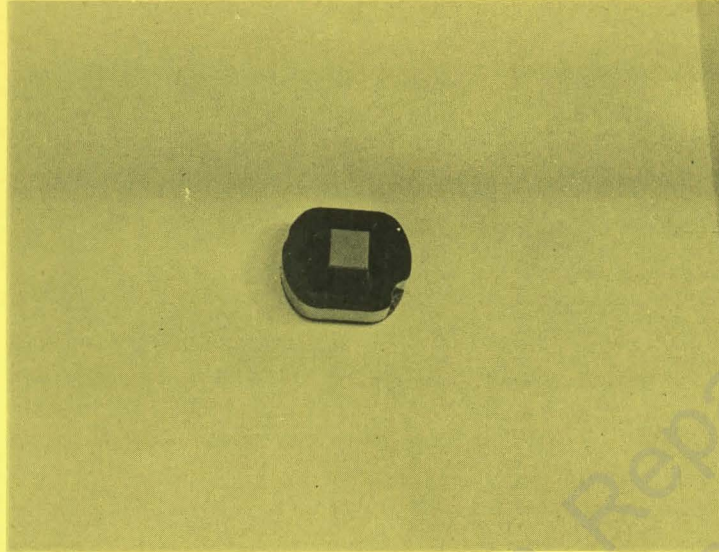
Place Spacer over Retainer so that Retainer Pin clears cut-out.

2



Place all four Reeds onto Reed Seat Posts.

3



Slide Retainer/Spacer Assembly over the Reeds to lock all parts together.

That's all there is to it. We will keep a few of the Reed Springs (Part No. 59679) in stock. After present stock of magnesium valve seats is used up, only Delrin seats will be supplied.

New Part Numbers:

Delrin Valve Seat	63253
Reed Valve Retainer	63260

A handwritten signature in cursive script, reading "Walter N. Herold".

Walter N. Herold
Service Manager

mr



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BRANCH SERVICE MEMO NO. 584-O

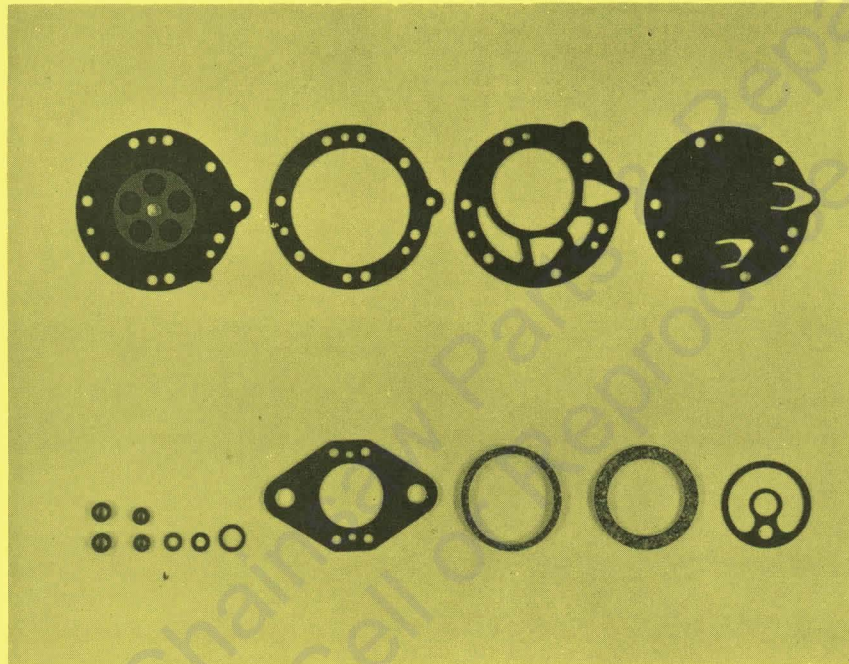
DEALER SERVICE MEMO NO. 295

Distribution: List No. 5

TO: All Branches and Dealers

SUBJECT: New Carburetor Service Kit
Homelite Part No. 63590

DATE: 12/8/65



Here, in one handy package, are all the gaskets and diaphragms needed to overhaul HL Carburetors.

The pump diaphragm is the thin rubber kind preferred by most people. The flange gasket is "universal" so you can fix all HL carburetors, not just those used by Homelite.

The parts are packed in a "see-through" envelope with a punched hole so that you can display the kit on a peg board together with your other fast moving items.

Order your supply from Homelite now.

Walter N. Herold
Service Manager



Distribution: 5

TO: All Homelite Branches and Mower Dealers

SUBJECT: Differential Idler Tension

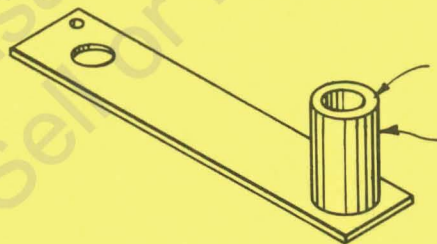
DATE: 12/13/65

Units Affected: All YTD-6 Models

We have found several differential idlers that are "sticking" -- do not exert enough tension on the chain.

This can be the result of too much length on the sleeve of the #A-66638 Arm and Sleeve Assembly or too short a length on the shoulder of the #66630 Shoulder Screw.

To correct the problem file .001 to .003 off the sleeve or until the arm moves freely and takes up the slack in the differential drive chain when assembled with torque of 80 inch pounds.



File this surface flat

90° to sides

Robert S. Townsend
Ass't. Service Manager

mr



BRANCH SERVICE MEMO NO. 588-M

DEALER SERVICE MEMO NO. 298

Distribution: 5

TO: All Homelite Branches and Mower Dealers

SUBJECT: Differential Assembly Kit

DATE: 12/22/65

We have available a differential assembly kit so that Models YTD-26, YTD-26A and YTD-5 Mowers may be equipped with differential drive if it is desired.

The Kit, Part No. A-66664 includes all parts and complete instructions to make this change.

Please add this part number to the parts list for Models YTD-26, YTD-26A and YTD-5 for future reference.

Robert S. Townsend
Robert S. Townsend
Ass't. Service Manager

mr