



BRANCH SERVICE MEMO NO. 847LG

DEALER SERVICE MEMO NO. 535

TO: All Districts, Branches and Lawn & Garden Dealers

SUBJECT: Mower Chute Extension

DATE: 1/73

Several mowers are being shipped with a spring holding the mower chute extension in a vertical position for shipping purposes. When the pre-delivery check is being done on the units the spring is to be removed and discarded. The chute extension is then placed in the horizontal position and bolted with the bolts and nuts supplied.

Bill Borachok, Service Manager  
Lawn & Garden Equipment

db



TO: All Districts, Branches and Lawn & Garden Dealers

SUBJECT: Steering Nut RE 8E Riding Mowers

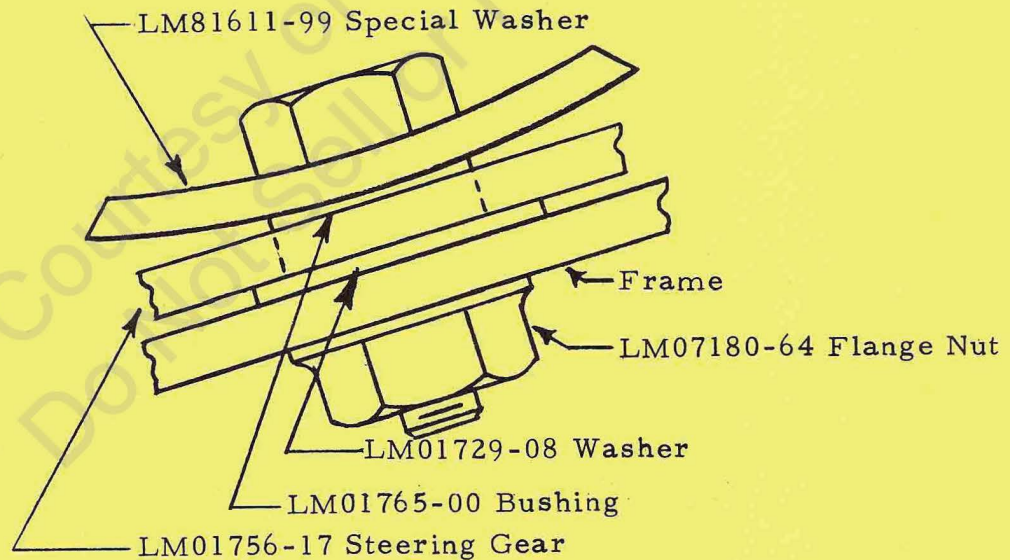
DATE: 2/73

We have found a few RE 8E riding mowers where the LM07180-35 nut on the steering gear has loosened.

We have replaced LM07180-35 in this application with a center lock nut LM07180-64. We are sending each district enough of the new nuts to rework all existing units.

The illustration shows the proper sequence of assembly. Every effort must be made to correct this assembly before the unit is operated.

All RE 8E units above S/N 965002190 have been reworked.



*Bill Borachok*

Bill Borachok, Service Manager  
Lawn & Garden Equipment

db



TO: All Districts, Branches and Chain Saw Dealers

SUBJECT: Service Information XL2

DATE: 2/73

1. Delete the following from the illustrated parts list.

<u>Item</u>	<u>Description</u>	<u>Part No.</u>
50	Plug	69400
63	Filter - oil	69518
75	Clip - hair pin	69418

2. Change the following in the illustrated parts list to show the correct quantity.

<u>Item</u>	<u>Description</u>	<u>Part No.</u>	<u>Quantity</u>
29	Washer - #8 flat	84101	3
35	Washer - lock	*83060	3

\*Part Number change

3. Change the following part numbers in the illustrated parts list.

<u>Item</u>	<u>Description</u>	<u>Part No.</u>
66	Cap-tanks (fuel and oil) Includes Gasket	A-69277-A 69585
76	Pin-adjusting	69254-1A
78	Nut-guide bar Washer - guide bar (not shown)	69600 69309-1
80	Drum & Sprocket .250, 9 tooth Includes Ring retaining clutch	A-69587 69226
91	Rod - throttle (front)	69255-A
93	Cover - handle	69140-A
Accessories -	Spark Arrestor	A-69586
	Circuit Plate (High Altitude)	A-69588
	Driver Main Nozzle Check Valve	24173

Cont'd.

4. Ordering the above parts by the new part number accomplishes this. New fuel and oil caps are easy to remove and install. The new guide bar adjusting pin is stronger and larger making for better engagement in the guide bar. Use of the washer and new guide bar nuts provides stronger clamping force maintaining chain tension plus the longer nut prevents the chain from leaving the chain saw if it does come off. The new front throttle rod prevents disengagement with the throttle lever. The new handle cover with the longer back leg with strengthening rib will stay on the handle.
  
5. Engaging loops of the new front throttle rod 69255-A were increased by 1/16" to prevent disengaging in some instances due to hang up. Using the new longer rod 69255-A on older units may require cutting the ends off if it interferes with the automatic chain oiler pressure line.

After installation check for slack in the rear throttle trigger to assure throttle shutter closing for idle.

*Thomas W. Stever*

Thomas W. Stever, Service Manager  
Forestry Equipment

pk



TO: All District, Branches and Chain Saw Dealers

SUBJECT: Quiet Muffler and Shield Kit With Spark Arrestor

DATE: 2/73

Units Affected: Super 1050 Automatic

A quiet muffler and shield kit with spark arrestor is available for the Super 1050 Automatic.

The kit number is A-69401 consisting of the following parts:

1	A-69395-1	Body, Muffler
2	69397	Stud, Muffler
1	80581	Screw, Hex Hd. 1/4 - 20 x 5/8
1	69353	Baffle, Muffler
3	80821	Screw, Hex Hd. 12 - 24 x 1/2
1	A-63518	Arrestor, Spark
1	A-59963-2	Cap, Muffler
1	64409-2	Shield, Muffler

*Thomas W. Stever*

Thomas W. Stever, Service Manager  
Forestry Equipment

db



BRANCH SERVICE MEMO NO. 851CS

DEALER SERVICE MEMO NO. 539

TO: All Districts, Branches and Chain Saw Dealers

SUBJECT: Muffler Shield 69284-1

DATE: 3/73

Units Affected: XL-923, VI-944 and VI-955

Muffler shield 69284-1 is available for the above units.

Use of the muffler shield will aid in preventing contact with the muffler.

*Thomas W. Stever*

Thomas W. Stever, Service Manager  
Forestry Equipment

db



TO: All Districts, Branches and Chain Saw Dealers

SUBJECT: Smaller diameter ignition breaker point pivot

DATE: 2/73

Units Affected: 150 Automatic

Commencing with Serial No. 30271001 the above units will have a smaller breaker point pivot post to improve retention in the cylinder crankcase assembly.

Units built with the small breaker point pivot post require the following part number changed.

1	A-68624-B	Short Block, supersedes A-68624-A
1	A-68643-B	Cylinder & Crankcase, supersedes A-68643-A
1	A-69483	Points - breaker
1	69445	Seal
1	69446	Seal
1	64309	Pin-dowel
1	A-69533	Box, Breaker

Seal #69445 is installed over breaker point dowel pin between breaker box and cylinder crankcase to prevent entry of foreign material.

Seal #69446 is installed over crankshaft between cylinder-crankcase and breaker box to prevent entry of foreign material.

NOTE: Parts are not interchangeable individually.

Mark your parts list accordingly.

*Thomas W Stever*

Thomas W. Stever, Service Manager  
Forestry Equipment

db



TO: All Districts, Branches and Chain Saw Dealers

SUBJECT: Replacement Nose Assembly for Power Tip Guide Bars      DATE: 6/19/73

I. Power Tip Guide Bar #PT-16503

Service with:

#A-67050 - Repair Kit, Sprocket Nose Bar (Sandvick "metric series"  
Rollers and 3/16" dia. Rivets)

II. Power Tip Guide Bar #PT-16503-50

Service with:

#A-69496 - Repair Kit, Sprocket Nose Bar (Torrington "inch series"  
Rollers and 1/8" dia. Rivets)

Above Repair Kits are to be used for Bars as specified. Parts are not interchangeable.

A handwritten signature in cursive script, appearing to read "Joe Shuhy".

Joe Shuhy, Service Manager  
Forestry Equipment

pk

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





TO: All Districts, Branches and C/S Dealers

SUBJECT: Replacement Nose Assembly for Power Tip  
Guide Bars

DATE: 11/73

I. Power Tip Guide Bar #PT-16503

Service With:

#A-67050 - Repair Kit, Sprocket Nose Bar (Sandvick "metric series"  
Rollers and .193/.196" dia. Rivets) - Rivet #67426.

II. Power Tip Guide Bar #PT-16503-50

Service With:

#A-69496 - Repair Kit, Sprocket Nose Bar (Torrington "inch series"  
Rollers and .125/.127" dia. Rivets) - Rivet #69486.

III. Power Tip Guide Bar #PT-12504-50

Service With:

A-69682 - Repair Kit, Sprocket Nose Bar (Windsor "inch series"  
Rollers and .161/.164 dia. Rivets) - Rivet #69667.

Rivets to service above are now available separately and are not interchangeable.

Each Kit number has it's own specified rivet as shown above.

Above Repair Kits are to be used for Bars as specified. Parts are not inter-  
changeable.

A handwritten signature in cursive script that reads 'Joseph Shuhy'.

Joseph Shuhy, Service Manager  
Forestry Equipment

db



TO: All Chain Saw Dealers  
SUBJECT: Safety Pamphlets, Part No. 24231

DATE: 2/73

Please read the attached pamphlet. Its most important function is to help all Chain Saw operators use safe techniques. Special emphasis is placed on the correct way to hold and control the saw. We illustrate and stress it in the pamphlet: Always hold the saw firmly with both hands and use the correct grip!

While much of the information in the pamphlet is also available in Owners Manuals, we suspect that not everyone reads owners manuals; owners manuals don't always stay with the saw; they get mislaid and some are lost.

We feel that safety information is so important that we want to make sure that everybody who gets a saw from Homelite or from Homelite dealer also gets this pamphlet.

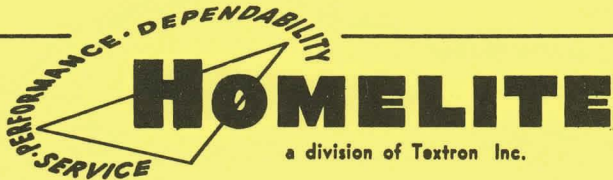
For this reason we will attach one to every saw. IN ADDITION, you may have more -- free for asking.\* We want one of these pamphlets on every saw (new , rental or repair) when it is picked up or delivered to a customer.

We wrote the message so that it fits all chain saws, not just Homelite. Please help your customers be safe. Make sure they know about holding saws the right way -- make sure they know about proper chain tensioning -- about the importance of keeping the chain sharp -- and about keeping by-standers or helpers out of the way. Let everybody know that Homelite cares.

Robert S. Townsend  
National Service Manager

db

\* Order additional Part No. 24231 Pamphlets in the usual manner.



TO: All Districts, Branches, & C/S Dealers

SUBJECT: Tillotson Main Nozzle Check Valve #69453

DATE: 3/73

Units Affected: 900 and 920 series

Main nozzle check valve #54444 ball type and #68284 disc type have caused field service problems.

It is possible for the ball type #54444 to stick in the closed position not allowing fuel to flow and for the disc type due to the method of retaining the disc to stick in the open position allowing the unit to back bleed, air entering and mixing with the idle fuel.

Both the above check valves cause problems difficult to diagnose. In some cases, they cause the mechanic to repair some other part of the unit to correct a carburetion problem and cause the operator to continually adjust his carburetor.

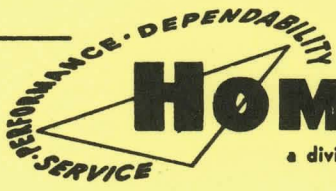
Tillotson has changed the method of retaining the disc valve to prevent its resting open at an angle. New part number is 69453.

Main nozzle check valve can be removed by disassembling metering side of carburetor, remove high speed adjusting screw then drive or push main nozzle check valve into venturi. It is small enough to roll out under choke shaft and shutter. Install replacement main nozzle check valve by driving or pressing it into carburetor body until it is flush with metering diaphragm floor.

*Thomas W. Stever*

Thomas W. Stever, Service Manager  
Forestry Equipment

db



BRANCH SERVICE MEMO NO. 858

DEALER SERVICE MEMO NO. 545

TO: All Districts, Branches and All Dealers

SUBJECT: #55399 and #72396 Condensers

DATE: 3/73

We have found some of the above condensers mixed up and mislabeled in stock. Check the condensers in your stock. They should be branded with the vendors part number as follows:

Part #55399 = Wico X9451

Part #72396 = Wico X8807

Adjust your stock accordingly.

Lars Johnson, Service Manager  
Construction Equipment

db



TO: All Districts and Branches and C/E Dealers

SUBJECT: Part #51255 Damper

DATE: 3/73

Units Affected: 152A25-1, 152A27-1, 1A, 153A35-1, 1A and 155A50-1, 1A

A dampening tube has been placed inside the foot springs to reduce the jiggling or vibration caused by engine vibration.

They are added as follows:

Model 152 and 153 - inside all four foot spring

Model 155 - inside the engine mounting springs only.

Parts are in stock and can be ordered.

Lars Johnson, Service Manager  
Construction Equipment

db



TO: All Districts, Branches and Lawn & Garden Dealers

SUBJECT: Lawn & Garden Equipment

DATE: 3/73

Attached please find a chart indicating the engine model and type used by Homelite on our Lawn & Garden equipment.

We hope this chart will serve you when you are in need of engine information.

Bill Borachok, Service Manager  
Lawn & Garden Equipment

db  
Attach.

Courtesy of undee7053  
Do Not Sell or Reproduce

Homelite Product	HP	Briggs & Stratton Model No.	B & S Type	Short Block
M-19	3.5	92908	0968-0	299242
M-19E	3.5	92905	1107	299242
M-21	3.5	92908	0735-01	299242
M-21E	3.5	92905	1108-01	299242
M-21S	3.5	92998	0736-01	
M-21SE	3.5	92995	0737-01	
RE-5	5	130202	0436-01	
RE-8E	8	190705	0822-01	390640
RM-5	5	130902	0340	298852
RM-5E	5	130907	0326	
RM-7E	7	170707	1187-01	299780
T-7	7	170707	1187-01	299780
T-8	8	191707	0637-01	390649
T-10	10	243431	0665-01	
T-12	12	302431	0131-01	
T-15	15	325431	0125-01	
T-16S	16	326431	0133-01	
T-16H	16	326431	0133-01	
R-3	3	80202	0252-2	295337
R-5	5	130292	0141-02	
R-8	8	190492	0794-01	
S-4	4	100202	0180-02	299250
S-8	8	190412	0695-01	
EDV	4	100212	0382-1	

**NOTES:**

- 1) Order original engine from source of supply.
- 2) Original engine was equipped with Dial-trol. Transfer these parts to the replacement engine.
- 3) Transfer plastic choke plate from original engine to replacement engine, or install new choke plate #298819
- 4) Transfer electric starter parts from original engine to replacement engine.
- 5) Transfer #66538 rubber spark plug elbow and #297863 fuel tank cap, or add as new parts.
- 6) Add 93583 cylinder head stud and 260703 governor spring.
- 7) Transfer flush rotating blower housing screen group from original engine.
- 8) If necessary cut off 7/16" on flywheel side of crankshaft to make shaft same length as original engine & tra







TO: All Districts, Branches and Chain Saw Dealers

SUBJECT: Check Valve A-65948-1

DATE: 4/73

Units Affected: VI-944 and VI-955

When the copper manual discharge oil line A-69390 is used to replace the aluminum discharge oil line A-63299, you must use outlet check valve A-65948-1. The copper oil line has a larger outside diameter.

Mark your illustrated parts list accordingly.

*Thomas W. Stever*  
Thomas W. Stever, Service Manager  
Forestry Equipment

db



BRANCH SERVICE MEMO NO. 862CS

DEALER SERVICE MEMO NO. 549

TO: All Districts, Branches and Chain Saw Dealers

SUBJECT: Improved Chain Oiling System

DATE: 4/73

Unit Affected: XL 2

The XL 2 chain oiling system uses a pressurized oil reservoir to insure quick priming of the system. If the user forgets to loosen the oil reservoir cap after use, in some cases, the oil will continue to flow to the guide bar until the pressure is decreased. This pressurized system may also occasionally double the usual flow rate.

We have developed a "pressure regulating" connector which is inserted in the oil pressure line inside the oil reservoir. Now the user can forget to release the oil reservoir pressure without worrying about "puddle of oil accumulating". Neither will he have to worry about using too much oil and running out of oil before fuel.

We have already sent a large quantity of Part No. 69659-1 connectors to each district and branch office. We would like all XL 2 owners to have this additional feature. These connectors are available at no charge on a one for one basis - one connector for each XL 2 each dealer has purchased.

The "pressure regulating" connector is easy to install - see accompanying photo instructions.

A handwritten signature in black ink that reads "Joe Shuhy".

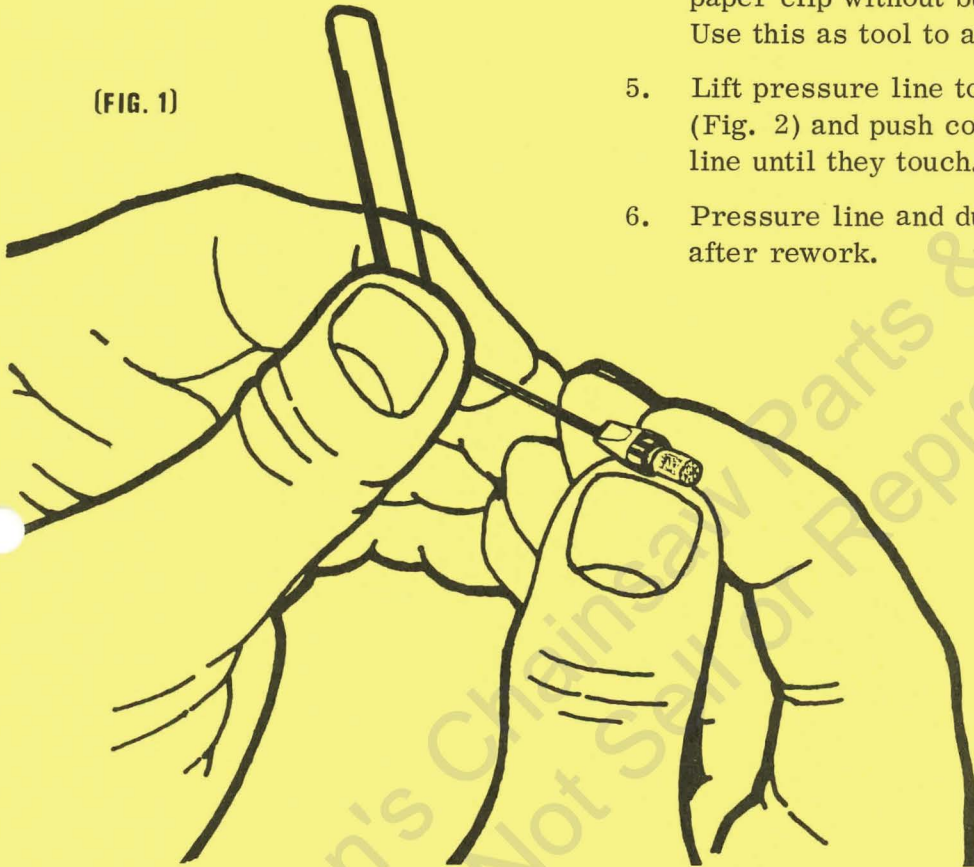
Joe Shuhy, Service Manager  
Forestry Equipment

pk

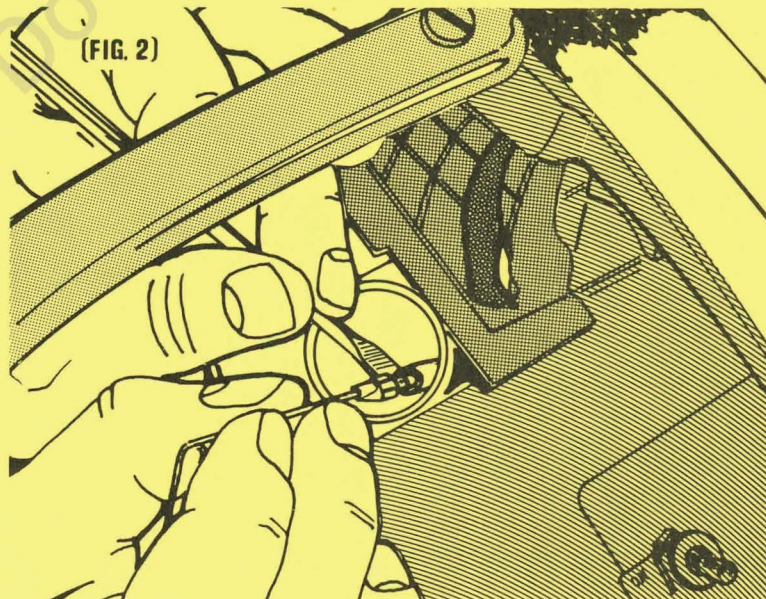
Instruction for Assembly of Oil Tank  
Pressure Regulating Fitting #69659-1

1. Remove oil cap to expose pressure line and duck bill check valve (Fig. 2).
2. Pull off duck bill and fitting from pressure line.
3. Remove existing fitting from duck bill and replace it with fitting #69659-1 with 1/4" of fitting exposed.
4. Insert 1/16" hex Allen wrench or large straightened paper clip without burrs into lip opening of valve (Fig. 1). Use this as tool to assemble valve to line.
5. Lift pressure line to convenient position with screwdriver (Fig. 2) and push connector with duck bill into pressure line until they touch.
6. Pressure line and duck bill must be in original location after rework.

(FIG. 1)



(FIG. 2)





TO: All Districts, Branches and Chain Saw Dealers

SUBJECT: New guided 3-shoe clutch with iron oilite clutch shoes DATE: 4/73

Units affected: XL-12, XLAO, SXLAO, XL-400, XL-400FP and XLBC-4

Commencing with S/N 30260052 on above units A-69480 clutch and cover will supersede A-63608 clutch and cover.

A breakdown of the two clutches is shown below:

	<u>NEW</u>	<u>OLD</u> <u>XL-400's</u>	<u>Old</u> <u>XL-12, XLAO,</u> <u>SXLAO, XLBC-4</u>
Clutch Assembly	A-69480		A-63608
Includes:			
Clutch Plate	65760-1	58927-2	63053-1
Clutch Shoe(3 per)	69461	58928-1(6per)	63052
Clutch Spring	67053	55123-C	63034
Clutch Cover	63051	58751-1	63051

When clutch assembly A-63608 is exhausted we will supply clutch assembly A-69480.

When clutch plates 63053-1 and spider 58927-2 are exhausted we will supply clutch assembly A-69480.

Clutch shoes 63052 and 58928-1 and clutch spring 63034 will continue to be available for a period of two years. Spring 55123-C and cover 58751-1 are still required for the other units.

Mark your parts book accordingly.

*Thomas W. Stever*  
 Thomas W. Stever, Service Manager  
 Forestry Equipment



BRANCH SERVICE MEMO NO. 864CS

DEALER SERVICE MEMO NO. 551

TO: All Districts, Branches and Chain Saw Dealers

SUBJECT: New Guided Shoe Clutch A-69459

DATE: 4/73

Units Affected: XL-102 Auto, XL-113, XL-114, XL-123 and VI-123

A new guided shoe clutch with iron oilite clutch shoes is available for the above units.

A breakdown of the two clutches is shown below:

	<u>NEW</u>	<u>OLD</u>
Clutch Assembly	A-69459	A-64910
Clutch Plate (1 required)	65760-2	64904-1
Clutch Shoe (3 required)	69458	64569-3
Clutch Spring (3 required)	63977	65842

When clutch assembly A-64910 is exhausted we will supply clutch A-69459.

When clutch plate 64904-1 is exhausted we will supply clutch assembly A-69459.

Clutch shoe 64569-3 and clutch spring 65842 will continue to be available for a period of two years. Mark your parts list accordingly.

*Thomas W. Stever*  
Thomas W. Stever, Service Manager  
Forestry Equipment

db



TO: All Districts, Branches and Chain Saw Dealers

SUBJECT: Clutch Assembly

DATE: 4/73

Units Affected: Super 2100 Automatic

Commencing with serial No. 30871001 the Super 2100 AO will be manufactured with the 3/4" wide clutch assembly as used on the 2100S.

This requires the following parts:

	<u>New</u>	<u>Old</u>
Crankshaft	A-67588	A-69197
Hub and Drum	A-67239	A-69203
Spider, Clutch	67591-1	67591-3
Cover, Clutch	67120-A	56238-A
Shoe, Clutch	55076-6	55076-9
Spring, Clutch	67441	68392

Mark your parts books accordingly.

*Thomas W. Stever*  
Thomas W. Stever, Service Manager  
Forestry Equipment

db



TO: All Districts, Branches and C/S Dealers

SUBJECT: 1) Cap for Grease Gun 24258-1  
2) Oil Pressure Line and Fuel Line

DATE: 5 / 73

1) Our supplier changed the cap from metal to a grey plastic. The plastic cap will break quite easily sometimes in shipment.

New black plastic caps #24806 are available as a replacement. Order the replacement cap #24806 from Jerry Scruggs, Service Parts, Gastonia.

2) Fuel line and oil line are available in ten foot lengths. Order by the following part numbers:

#69656 Fuel Line (10 ft.)

Use for:	A-68053	10 9/16"	EZ's
	68155	9 1/16"	XL-12
	68239-A	1/4"	XL-400 Auto (Sleeve Trigger)
	68562	8"	150 Auto
	69344	7 1/4"	XL-2

#69657 Oil Line (10 Ft.)

Use for:	68561	2 1/8"	150 Auto
	69345	5 7/8"	XL-2
	A-69358	3"	XL-2 (pressure line)

All lines should be cut to allow for a taper for ease of assembly.

Joe Shuhy, Service Manager  
Forestry Equipment

db



BRANCH SERVICE MEMO NO. 867CS

DEALER SERVICE MEMO NO. 554

TO: All District, Branches and Chain Saw Dealers

SUBJECT: Part No. 68377 Crankshaft

DATE: 6/1/73

Units Affected: XL-400 AO and XL-400 AO FP

Crankshaft #68377 has been reinstated for service replacements on Model XL-400 AO chain saws.

Part No. 68180-A crankshaft will still be available for Model XL-400 AO FP chain saws.

Walter Frederick  
Service Department

db

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





BRANCH SERVICE MEMO NO. 868CS

DEALER SERVICE MEMO NO. 555

TO: All Districts Branches & Chain Saw Dealers

SUBJECT: Idle Speed Adjusting Screw

DATE: 6/73

Units Affected: XL-923 Series - VI-944, VI-944C, VI-955

Carburetor #A-69684 supersedes #A-68251-B in above model saws. The new carburetor has the old type "built in" idle stop screw #58993 and spring #58973 as part of the carburetor. The screw and spring replace the external idle stop screw #63369 that was assembled in the side of the carburetor chamber.

This change should eliminate the complaint where the nylon locking screw would not hold the idle adjustment.

Kit idle speed adjustment #A-69672 is available to convert units built prior to this change. The kit includes the above screw and spring as well as a plastic plug #53572 to plug external idle stop hole in the carburetor chamber.

Carburetor and plug #A-69684 is available to service all above units and includes plastic plug #53572.

Mark your parts list accordingly.

  
Joseph Shuhy, Service Manager  
Forestry Equipment

db



TO: All Districts, Branches and Chain Saw Dealers

SUBJECT: Cylinder and Gasket Assemblies for Chain Saws

DATE: 7/73

The following new cylinder and gasket assemblies are released that include the correct gasket for the respective cylinder.

This was done to insure that a new gasket is available each time a cylinder is replaced.

Reuse of cylinder gaskets can cause flange bow, skirt closure and loosening of cylinder that contributes to heavy piston wear, drag, pick-up, seizure and flange breakage. A new gasket should also be used each time a cylinder is removed and reassembled.

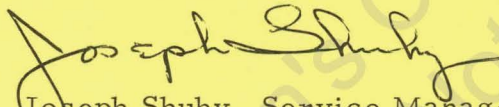
For convenience, the list includes the cross reference of the old cylinder number to the new cylinder number, the cylinder gasket required for each and the unit usage.

<u>OLD Cylinder #</u>	<u>Superseded by</u>	<u>NEW Cylinder #</u>	<u>Cyl. gasket incl. in each cyl. assembly</u>	<u>Unit Usage</u>
56182-1A	" "	A-69707	56864	7-21, 5-20's, 6-22, 7-19, EZ, EZ-6, 6-63, 600D's, ZIP-5's
56834-1	" "	A-69708	56864	660D, 700D, 700G, 7063
58174-A1	" "	A-69709	58292	C-9's, C-91's
58174-2	" "	A-69710	58292	C-5, C-7, C-51, C-71, C-52, C-72
58175-2	" "	A-69711	58292	XP1000's, XP1100's
58175-3	" "	A-69712	64453	SXP1020 AO's, SXP1130's, S1130GAO S1050 Auto
A-58289	" "	A-69713	56875-A	900D, 900G, 909D, G, 990D&G, 995D&G
58706-B1	" "	A-69714	59771	SXL12, SXL, XLAO, SXLAO, XL100G1, -1A XL120, SXL12 Auto

Cont'd.

<u>OLD Cylinder #</u>	<u>Superseded by</u>	<u>NEW Cylinder #</u>	<u>Cyl. gasket incl. in each cyl. assembly</u>	<u>Unit Usage</u>
58706-B2	" "	A-69715	58513	XL12, XLS1 1/2-4, 5, XL100A, XLBC4, XLA115
59458-1	" "	A-69716	59771	XL500Auto, XL660, XL660F Auto
A-59998	" "	A-69717	56864	SWIZ-66, 5-63, BUZ's 500's, ZIP's, EBC's, SWIZ, SWIZ-A
63165-1	" "	A-69718	63237	XL101 - 1 15/16 dia.
63165-3	" "	A-69719	65829	XL101 - 2" dia.
A-63258	" "	A-69720	56864	WIZ55, SWIZ55, 17's, 4-20's, WIZ, A, B
A-63522-A	" "	A-69721	56864	707D, G, 770D, G, 775D, G, SWIZ80, S77
A-63661	" "	A-69722	58292	XP1020's, XP1020AO's XP1130's, 1050 Auto
64405-1	" "	A-69723	65829	XL102Auto, XL122 after S/N3067771
A-64542-1A	" "	A-69724	63237	XL102, XL103, XL104, XL113 - 1 15/16 registered diameter
A-64542-2A	" "	A-69725	65829	XL102, XL103, XL104, XL113 - 2" registered diameter
A-65036-1	" "	A-69726	65018	EZAO, EZ-10, Chipper Narrow Skirt
A-65036-3	" "	A-69727	65018	EZAO, EZ-10, Chipper Wide Skirt
A-65180-1	" "	A-69728	65018	EZ - Narrow Skirt
A-65180-2	" "	A-69729	65018	EZ - Wide Skirt
A-65571	" "	A-69730	64453	SXP1020's, SXP1130-1 Auto, 1130G Auto, 1050Auto(after ECN186 92) Super 1050E
A-65795-1A	" "	A-69731	65829	XL123, VI123, VI125
A-67189-1	" "	A-69732	65829	XL104, XL114 2" registered diameter
A-67189-2	" "	A-69733	65829	XL104, XL114 1 15/16" registered diameter
A-67596	" "	A-67596-A	63778	XL700, XL901
A-67597	" "	A-67597-A	63778	XL903, XL904
A-67598	" "	A-67598-A	63778-1	XL870, XL875, XL913FP, XL98
A-67632-1A	" "	A-69734	67022	2000AO, 2000EAO, Super 2000

<u>OLD</u> <u>Cylinder #</u>	<u>Superseded by</u>	<u>NEW</u> <u>Cylinder #</u>	<u>Cyl. gasket incl. in</u> <u>each cyl. assembly</u>	<u>Unit Usage</u>
A-67744-2A	" "	A-69735	67022	2100S, 3100G, 2100
A-67747	" "	A-67747-A	63778	XL800, XL850, XL88
A-67874-1	" "	A-69736	65018	EZ250, Super EZAuto, SXLMini Auto (narrow skirt)
A-67874-3	" "	A-69737	65018	EZ250, SEZ-Auto, SXLMini Auto, VI Sup Mini-3, VISup Mini(wide skirt)
A-68294	" "	A-69738	63778-1	XL921
A-68853-A	" "	A-68853-B	63778-1	XL923, XL924, VI944
A-68980-1	" "	A-68980-1A	63778-1	XLS2-1, XL98A
A-69538	" "	A-69739	63778-1	XL923C
A-69628	" "	A-69674(oval port)	63778-1	VI944C, XL923, VI944
A-74472	" "	A-69740	74139	7-29, 8-29
A-68293	" "	A-69741	63778-1	XL913M, XL914M
A-69649 (oval port)			63778-1	XL924W, VI955
A-68758-A			68728-A	XL400AO, XL400AOF P

  
Joseph Shuhy, Service Manager  
Forestry Equipment

db



TO: All Districts, Branches and C/S Dealers

SUBJECT: Cylinder & Gasket #A-69674  
XL-923, VI-944, VI-944C chain saws (with  
compression release) Cylinder & Gasket  
#A-69649 - VI-955 and XL-924W

DATE: 8/73

Cylinder & Gasket #A-69674 is now available to service the subject chain saws that include the compression release.

The new cylinder has a single oval exhaust port opening that reduces noise, ring clipping and breakage and has better break specific fuel consumption and increased power.

Cylinder gasket #63778-1 is included with the cylinder and must be used to avoid flange bow and skirt close in, that results from using an old gasket.

The old gasket must be completely removed from cylinder pad face of crankcase, being careful not to damage crankcase surface during removal.

Cylinder and Gasket #A-69649 is now available to service the VI-955 and XL-924W chain saws that do not require the compression release.

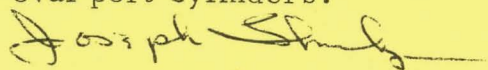
This cylinder is now cast without the compression release boss and has additional cast fins in it's place for better cooling and less distortion. It has a single oval exhaust port and the cylinder gasket #63778-1 is included for reasons stated above.

Both cylinder assemblies #A-69674 and A-69649 are processed with the new "wear guard" finish. This special treatment of the chrome plated bore improves the oil retention and increases cylinder life.

The finish can be recognized by the satin chrome appearance of the bore and one of the vertical head fins is stamped with the "wear guard" wording.

Piston #A-69467 (thin piston rings) - This piston is now available for use with both above cylinders A-69674 and A-69649 and incorporates the thin piston rings #69452.

The old piston #A-67989-1 (standard width piston rings) can also be used with the oval port cylinders.

  
Joseph Shuhy, Service Manager  
Forestry Equipment



BRANCH SERVICE MEMO NO. 873CS

DEALER SERVICE MEMO NO. 560

Distribution:

TO: All Districts, Branches and C/S Dealers

SUBJECT: 2100S - Super 2100 Auto - 3100G Compression  
Release Guide Fasteners

DATE: 8/73

Lock nut #81238 (6-32) will replace #81126 to fasten the compression release guide to the carburetor chamber.

Due to the limited length screw that is necessary to clear the cylinder, the end locking feature of #81126 did not always keep screw from loosening.

The new lock nut #81238 has a center lock feature that should insure retention and eliminate loose screw from going thru carburetor.

Joseph Shuhy, Service Manager  
Forestry Equipment

db



TO: All Districts, Branches & C/S & C/E Dealers

SUBJECT: XL-98-A Multi-Purpose Saw Carburetor

DATE: 8/73

The high no-load speed of this unit is very critical. Engine speeds over 9000 rpm will produce blade speeds in excess of the rated speed of some abrasive wheels (5092 rpm). Therefore, the no-load maximum speed should be checked before delivery to a customer. This would apply to all unit repairs as well as new sales.

Check no load top speed as follows:

1. Check engine speeds with the blade arm removed.
2. High speeds cannot be manually adjusted. The fixed high speed jet and governor valve determines the high speed limit of the engine. With the throttle trigger in the full speed or wide open position determine the top speed RPM (various tachometers are commercially available). Speeds between 8-9000 rpm are good.
3. Speeds over 9000 rpm are not acceptable and repairs must be made.
4. Two possibilities for high rpm are:
  - a. Air leak in the engine. Pressure check for leaks.
  - b. High speed limiting valve is not operating. Replace the governor valve A-51347 and test again.

Units are tested at the factory. Service parts replacement carburetors and governor valves are not. Testing of these parts must be done at the time of repair.

Lars Johnson, Service Manager  
Construction Equipment

db



BRANCH SERVICE MEMO NO. 875CS

DEALER SERVICE MEMO NO. 562

TO: All Districts, Branches & C/S Dealers

SUBJECT: Model 150 Chain Saw Breaker Points  
Refer to Branch Service Memo 852-CS

DATE: 9/73

We have learned that breaker box A-68647 has been packaged with the incorrect breaker point. Boxes with code # "3C5" typed on outside in black are especially suspect.

Breaker box A-68647 should contain breaker that has a .220 diameter pivot post hole and is used to service units before S/N 30271001.

Some breaker boxes A-68647 were packaged with breaker that has a smaller .156 diameter pivot post hole.

Breaker box A-69533 should contain breaker with the .156 diameter hole and is used to service units after S/N 30271001.

Breaker points from A-68646 with the larger pivot hole can be added to A-68647 and used to service units with the larger pivot post.

*Joseph Shuhy* or

Joseph Shuhy, Service Manager  
Forestry Equipment

db





BRANCH SERVICE MEMO NO. 876CS

DEALER SERVICE MEMO NO. 563

TO: Districts, Branches & C/S Dealers

SUBJECT: Vibration Arm Mount

DATE: 9/73

Units Affected: VI-944 and VI-955

The following changes are made to reduce wear at the isolation mount arm to the throttle handle connection.

The vibration arm mount has been shorten and counter bore removed where the arm attaches to the throttle handle.

New part number for the vibration mount arm is A-69584 which includes washer 84006 and shoulder screw 69561.

Washer 84006 is installed between vibration mount arm and throttle handle.

Some of the new style vibration mount arms were shipped under the old part number 68922-2A. These can be identified as new type by the missing counter bore and shorter arm where attached to the throttle handle.

These new type vibration mount arms shipped under the old part number 68922-2A can be used by adding washer 84006 and shoulder screw 69561.

*Joseph Shuhy*

Joseph Shuhy, Service Manager  
Forestry Equipment

db



TO: All Districts, Branches and C/S Dealers

SUBJECT: Sprocket and Drum Assembly #A-69633

DATE: 11/73

Usage: XL-12 - XL-Auto - Super XL-Auto

The above units are now being built with Sprocket and Drum Assembly #A-69633 and supersedes Sprocket and Bearing #A-59552 and Inner Race #55584.

You order the new Sprocket and Drum Assembly under #A-69633 which consists of the following existing parts, that may now be in your stock under their individual numbers.

The three parts must be used together to be interchangeable.

A-69633 Sprocket and Drum consists of:

- (1) A-65884 - Sprocket and Drum Assembly
- (1) 65746-A - Race, Inner
- (1) 64124 - Bearing, Needle

The new bearing in the above assembly has a greater grease capacity due to its construction and will allow increased time between grease periods.

Change your parts lists accordingly.

Joseph Shuhy, Service Manager  
Forestry Equipment

db