HOMELITE
a division of Textron Inc.

PERFORMANCE · DEPENDABILITY · SERVICE

BRANCH SERVICE MEMO NO. 778PT

DEALER SERVICE MEMO NO. 466

TO: All Districts, Branches and Construction Equipment Dealers

SUBJECT: Wiring 4-wire 230V180 cycle power tools DATE: 1/71

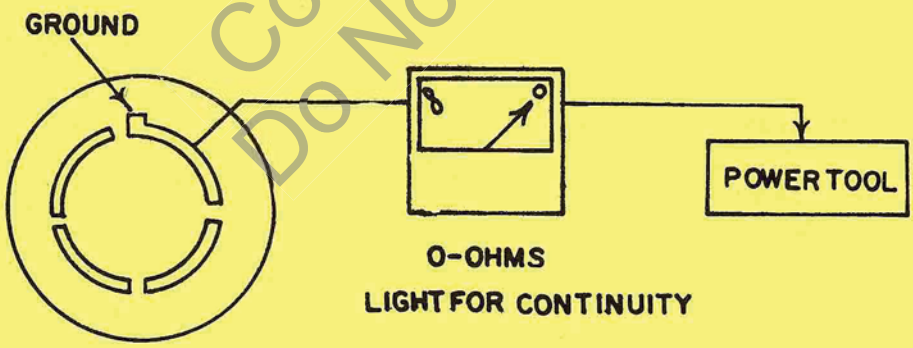
We have recently received reports that some users have received shocks when using some high cycle tools.

This can happen if the ground (green) wire at the generator is not grounded to the tool. If the ground wire should be attached to any one of three "hot" phases, the operator can be seriously shocked.

Before any high cycle tool is released from your shop regardless of what repair was made you must check the continuity of the green wire from the plug end to the body of the tool. Rentals must be checked each time they are sent out. The green wire must check out from the tool body to the ground prong of the cable end. The other three receptacle prongs should not be connected to the tool body.

The ground prong of older receptacles is marked "GR," the live prongs are marked X, Y and Z. Newer receptacles may only have the live prongs marked X, Y and Z with no marking on the ground prong. In all cases, the ground terminal is the bent tab prong.

This simple check can be made in a few seconds with an ohmmeter or battery operated continuity light and will save serious injury.



Courtesy of Underwoss
Do Not Sell or Reproduce

Robert S. Townsend
Service Manager

al

HOMELITE
a division of Textron Inc.

BRANCH **SERVICE MEMO NO.** 779CE

Dealer Service Memo No. 467

TO: All Districts, Branches and CE Dealers

SUBJECT: Change Effective Immediately in the Field -- all 10HY35-1A and 119HY35-2 Units Equipped with or being Converted to Automatic Idle Control

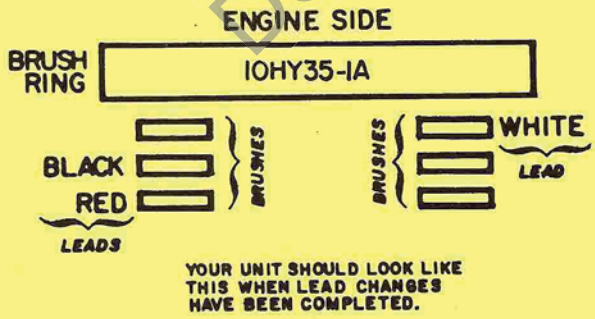
DATE: 3/71

Units equipped with idle controls have a circuit that can produce a high voltage (500V) between an AC brush and DC brush. With carbon accumulation and arcing it is possible to burn a hole in the brush ring.

To correct this condition and maintain phase rotation (sequence) it is necessary to switch the three wires on the AC brushes. The procedure is as follows:

10HY35-1A

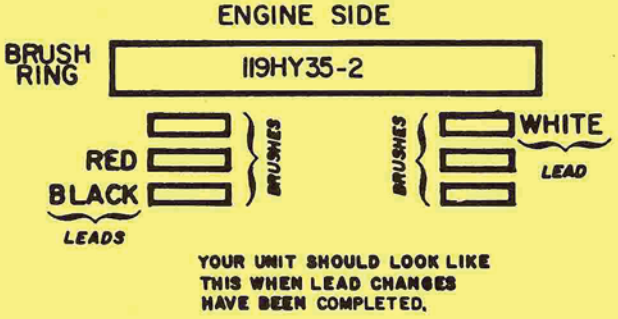
1) Remove the end covers.
2) Take a white wire from the center brush holder on the right side and connect it to the innermost brush holder.
3) Take the black wire from the outermost brush holder on the left side and attach it to the center brush holder.
4) Take the red wire from the innermost brush holder and attach it to the outermost brush holder.
5) Replace the end covers.



YOUR UNIT SHOULD LOOK LIKE THIS WHEN LEAD CHANGES HAVE BEEN COMPLETED.

119HY35-2

1) Remove the end covers.
2) Take the white wire from the center brush holder on the right side and connect it to the innermost brush holder.
3) Take the red wire from the outermost brush holder on the left side and attach it to the center brush holder.
4) Take the black wire from the innermost brush holder and attach it to the outermost brush holder.
5) Replace the end covers.



YOUR UNIT SHOULD LOOK LIKE THIS WHEN LEAD CHANGES HAVE BEEN COMPLETED.

Although this wiring change is necessary only for units with idle control, all 10HY35-1A and 119HY35-2 units will be so wired at the factory from now on.

Robert S. Townsend

Robert S. Townsend, Service Manager

al

Courtesy of undee 7055
Do Not Sell or Reproduce

BRANCH SERVICE MEMO NO. 781 CS

HOMELITE
a division of Textron Inc.

DEALER SERVICE MEMO NO. 469

TO: All Districts, Branches & Chain Saw Dealers

SUBJECT: Crankcase - Fuel Tank Cover **DATE:** 6/71

Units Affected: XL-101, XL-102, XL-103, XL-104, XL-113, XL-114, XL-122

Effective with Serial No. 3411704 (XL-113) the threaded insert type guide bar studs have been eliminated for the above model series. In addition the guide bar pad area and oil slot have been improved.

These changes required modifications to existing die equipment which will make it impossible to supply fuel tank covers Part No. A64786-1A for XL-101 and Part No. A65576-A for XL-102, XL-103, XL-104, XL-113, XL-114, XL-122 after present supply is exhausted. When supplies of tank covers are exhausted it will be necessary to install the complete tank crankcase.

To provide this continuity of service we will supersede crankcase A64796-D with crankcase A68042 (XL-101) also crankcase A64797-D is superseded by A68038 (XL-102, XL-103, XL-104, XL-113, XL-114 and XL-122) when present supplies are exhausted.

To service fuel tank covers on Model XL-113, XL-114, XL-122 above Serial No. 3411704 or XL-102, XL-103, XL-104 where new type crankcase A68038 has been installed use cover Part No. A68040 and gasket 65364-A to service fuel tank covers on XL-101 where new crankcase A68042 has been installed use fuel tank cover A68043-1 and gasket 65364-A.

Fuel tank covers A68040 and A68043-1 use two guide bar bolts 67193 which are pressed into the fuel tank cover from the inside. When replacing guide bar bolts coat the shank of the bolt from under the head down 3/8" with aviation permatex or sealant #22788 (EZ847) before pressing into place.

Fuel tank covers A68040 and A68043-1 require new guide bar plates; 67300 inner and 67299 outer.

The complete tank-crankcase assemblies will include inner and outer guide plates, also a vented fuel cap A65283-A (the fuel tank is no longer vented into the air box).

Robert S. Townsend
Service Manager

al

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

HOMELITE
a division of Textron Inc.

BRANCH SERVICE MEMO NO. 783CS

DEALER SERVICE MEMO NO. 471

TO: All Districts, Branches & Chain Saw Dealers

SUBJECT: Changes XL-923 - XL-924W

DATE: 6/71

We have made several changes to the subject units. The attached pages can be inserted in your XL-923 - 924 parts book as a part number reference until parts books are revised.

Part No. A68025-B throttle handle with both cushion grips replaces A68025-A throttle handle for Model XL-921, 923 and 924. We will still supply throttle handle cover A65882-A for repair of units built prior to the use of cushion grips.

Model XL-923 units are equipped with cushion grip flush cut handle bar Part No. A68762-2. This cushion grip handle bar (flush cut) can be used in place of the vinyl coated wrap-around handle bar on the Model XL-924W. This installation will require the use of bracket 68766-2 and spacer 68765 plus parts listed for standard XL-924 handle bar mounting. The cushion grip handle bar cannot be used without the shock mount and grommets.

Cylinder Part No. A68853 is standard equipment on all XL-924W's above S/N 10831047 and will be supplied for service of all XL-923 and XL-924 models in place of A68771. The cylinder bore on this cylinder is finished in such a manner that small oil reservoirs are provided in the surface. These reservoirs provide: a good oil supply at all times, good break-in, reduced wear, maintaining good compression and power while extending cylinder life.

Carburetor A68251 (HS103A) replaces A67887-A (HS92B) and A67880 (HDC27) on Model XL-924W. This carburetor has improved acceleration from part throttle and has no high speed limit valve. Carburetor A67887-B (HS92C) replaces A67887-A on all XL-921, 923's. It has improved acceleration from part throttle and has a high speed limit valve.

Oil pump A68265 with increased flow rate has been incorporated in Model XL-923 - 924's above S/N 10401894.

Robert S. Townsend
Service Manager

al

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

Description	Part No.	XL-923		XL-924	XL-924W	Remarks
Handle Bar - Flush (rubber covered)	A68762-2	X	above S/N 3436419		‡	Must be used if flush cut cushion grip handle bar is used on 924W
Requires: Bracket, Handle Bar	68766-2	X			‡	
Spacer, Handle Bar (rubber)	68765	X			‡	
Plate, Handle Bar	65599	X				
Screw, Soc. Hd. 1/4 - 20 x 1	80428 (1)	X				
Plate, Handle Bar Bracket	65598	X				
Handle Bar - Flush (vinyl coated)	A65860-1			X		
Requires: Bracket, Handle Bar	65607-3			X		
Spacer, Handle Bar	65542			X		
Plate, Handle Bar	65599			X	‡	Must be used to mount flush cut cushion grip handle bar on 924W
Screw, Shoulder	65520 (2)			X	‡	
Mount, Shock	65509 (1)			X	‡	
Screw, Shoulder (bracket to c'case)	65521 (2)			X	‡	
Grommet, Handle Bar Bracket	65519 (2)			X	‡	
Grommet, Handle Bar	65518 (2)			X	‡	
Plate, Handle Bar Bracket	65598			X	‡	
Handle Bar - Wrap-around (vinyl coated)	A67626-3				X	
Requires: Bracket, Handle Bar	63011-5				X	
Plate, Handle Bar	65599				X	
Screw, 12/24 x 3/4	80867 (2)				X	Bracket to c'case
Screw, soc. hd. 1/4 - 20 x 1	80428 (3)				X	
Guard, Chain	68078-1				X	
Plate, Handle Bar Bracket	65598				X	
Handle Bar - rubber covered (full wrap)	A68899-1				X	
Requires: Bracket, Handle Bar	68766-4				X	
Bar to Bracket	80428 (1)				X	
Spacer, Handle Bar	68898-1				X	
Plate, Handle Bar	65599				X	
Screw, Shoulder	80954 (2)				X	Bar to tank
Mount, Shock	65509				X	
Screw, Shoulder (bracket to c'case)	65521 (2)				X	
Grommet, Handle Bar Bracket	65519 (2)				X	
Chain Guard	68078-1				X	Same chain guard
Plate, Handle Bar Bracket	65598				X	

‡ Use these parts to convert XL-924W from wrap-around to flush cut cushion grip.

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

Description	Part No.	XL-923	XL-924	XL-924W	Remarks
Handle, Throttle	A68025-B	X	X	X	Supersedes A68025-A
Includes: Cover, Throttle Handle (for grips)	A68806	X	X	X	Units without rubber grips
Grip, Cover Rubber	68768	X	X	X	use A65882-A
Grip, Handle	68767	X	X	X	
Cylinder (Wear Guard*)	A68853	X	X	§	Supersedes A68771 - Prod
Body, Muffler	A63535-2	X	X	X	on 924W only S/N 10831047
Screw, 12-24 x 5/8	80978 (3)	X	X	X	
Cap, Muffler	63520-3	X	X	X	
Screw, Shoulder	63855-A (3)	X	X	X	
Baffle, Muffler - 88 holes	63521-A	X	X		Quieter than 924 baffle
Baffle, Muffler - 149 holes	65633	(optional)		X	
Arrestor, Spark	A63540-B	(optional)		X	
Oil Pump - increased capacity	A68265	X	X	X	Above S/N 10401894
Carburetor (HS-103A) above S/N 10470709	A68251			X	No speed limiter - no flat
Body, Muffler	A63535-2	X	X	X	spot - replaces A67887-A--
Screw	80978 (3)	X	X	X	A67880 on XL-924
Cap, Muffler	A68911-1	X	X	X	
Stud	68874 (3)	X	X	X	"Down Draft"† muffler
Nut	81109-2 (3)	X	X	X	used in 924W built after
Baffle, Muffler	65633	X	X	X	June 1, 1971
Arrestor, Spark	A63540-B	X	X	X	

* Wear Guard a Homelite trademark

§ XL-924W built without compression release use Wear Guard cylinder Part No. A68913-1

† Down Draft Cap A68911-1 can be used on early XL-923 - 924 - 924W models - use 68874 studs & 81109-2 nuts

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

HOMELITE
a division of Textron Inc.

BRANCH SERVICE MEMO NO. 785CS

DEALER SERVICE MEMO NO. 473

TO: All District and Branch Managers and Chain Saw Dealers

SUBJECT: Discontinuance of Stack Type Mufflers

DATE: 6/71

Effective with receipt of this memo do not ship any new units with stack type mufflers.

You may have a few C-52 models built prior to March 24th (S/N 10600504) with stack muffler Part No. 58184-1 factory installed. Replace prior to shipment or delivery Part No. 58184-1 stack muffler with Muffler Kit Part No. A59652.

The "stack" type muffler for service, shown below, will no longer be supplied.

Model	Stack Type		Can Type
C-52, C-51	58184-1	Replace with kit	A59652
XL12, XL15, SXL12	58584-2	Replace with kit	A59052-A
E-Z, XL-Mini	A68490 65058 65059-1	Replace with kit	A68254 or A68491
XL101	64131 or -1 64132	Replace with kit	A68893

Any existing orders or backorders for stack mufflers will automatically be filled with the quieter can type muffler.

Attached is a list of parts used to make up each kit.

Robert S. Townsend
Service Manager

jw

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

A59652 Muffler Kit

Includes:	58639	Deflector, Air	1
	A58419	Body, Muffler	1
	58423-A	Baffle, Muffler	1
	59337	Stud, Muffler	2
	58425-A	Cap, Muffler	1
	80837	Screw, Hex Hd. 12-24 x 3/8	2

A59052-A Muffler Kit

Includes:	A59049-A	Body, Muffler	1
	59050	Baffle, Muffler	1
	59065-B	Stud, Muffler	2
	A63246	Cap, Muffler	1
	80825	Screw, Hex Hd. 10-32 x 9/16	2
	80963	Screw, Pan Hd. 12-24 x 1/2	1

A68254 Muffler Kit

Includes:	A65152-2	Body, Muffler	1
	80870	Screw, Hex Hd. 10-32 x 3/8	3
	68253-1	Cap, Muffler	1
	64133-A	Screw, Shoulder	2

A68491 Muffler Kit

Includes:	A68433-1	Body, Muffler	1
	68431-1	Cap, Muffler	1
	80870	Screw, Hex Hd. Spinlock 10-32x3/8	5

A68893 Muffler Kit

Includes:	A64130	Body, Muffler	1
	80821	Screw, Hex Hd 12-24 x 1/2	3
	64126	Baffle, Muffler	1
	64125	Cap, Muffler	1
	64133-A	Screw, Shoulder	2

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

HOMELITE
a division of Textron Inc.

BRANCH SERVICE MEMO NO. 786 CS

DEALER SERVICE MEMO NO. 474

TO: All District & Branch Managers & Chain Saw Dealers

SUBJECT: 150 Rotor Nut **DATE:** 6/71

We know you are curious about the construction of the 150 engine. You will be taking these units apart to see what makes them tick.

CAUTION!!!

The crankshaft has left hand threads on both ends. The rotor nut must be turned clockwise to loosen and counterclockwise to tighten.

If you don't turn it clockwise to loosen you will break the end of the crankshaft.

Please caution all your shop and sales personnel that we cannot accept crankshafts broken in this manner under warranty.

Robert S. Townsend
Service Manager

al

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

BRANCH SERVICE MEMO NO. 787CS

DEALER SERVICE MEMO NO. 475

HOMELITE
a division of Textron Inc.

TO: All Districts, Branches & Chain Saw Dealers

SUBJECT: One-Piece Extruded Fuel Line **DATE:** 6/71

Units Affected: XL-921, 923, 924

A new one-piece extruded fuel line is now being used in the production of the above units. Our tests have shown the new fuel line to be superior to the molded fuel line in many ways --

Greater resistance to todays fuels

Greater flexibility at lower temperatures

Less distortion at high temperatures

Uniform wall thickness

Eliminates any rubber mold flashing to restrict fuel flow.

NEW PART NUMBERS

One-piece Fuel Line Kit #A68446 replaces 65593 and 65718 Fuel Line in XL-921, XL-923 and 924 Units.

A68446 Fuel Line Kit includes:

1	68442	Fuel Line
1	68445	Bushing
1	68046	Grommet
1	24464	Instruction Sheet

Part No. A68025-B Throttle Handle Assembly supersedes A68025 and A68025-A Throttle Handles. The fuel line hole is smaller in the new assembly so the new line can be used without bushing 68445.

A68025-B Throttle Handle Assembly includes:

1	68442	Fuel Line
1	68046	Grommet
1	24464	Instruction Sheet *

* INSTRUCTIONS

We have attached a copy of the Part No. 24464 instruction for your service manuals. Proper installation is important - please read attached instructions carefully.

CAUTION: To avoid damaging the fuel line - do not use pliers for assembly.

Lars Johnson
Service Department
al

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

INSTRUCTIONS 24464 Rev.1

For Installing Fuel Line 68442 and Grommet 68046 from Fuel Tank to Carburetor Inlet

MODEL SERIES: XL-921, XL-923, XL-924

EXPLANATION OF CHANGE:

Units have been improved by substitution of a one-piece fuel line which runs from the fuel filter at its fuel tank end to the carburetor inlet fitting.

NOTE: For easier installation of the one-piece fuel line, first remove the carburetor.

1. Remove the old fuel line and filter. Remove any burrs from the fuel outlet hole in the fuel tank.

2. Oil one end of the new fuel line and slip it onto the fuel inlet elbow of the carburetor.

   a) Units with the large diameter fuel line hole in the carburetor chamber will require Bushing 68445 to seal the hole around the fuel line.

   b) Oil the fuel line and slide the bushing onto and up the line until it meets the elbow on the carburetor.

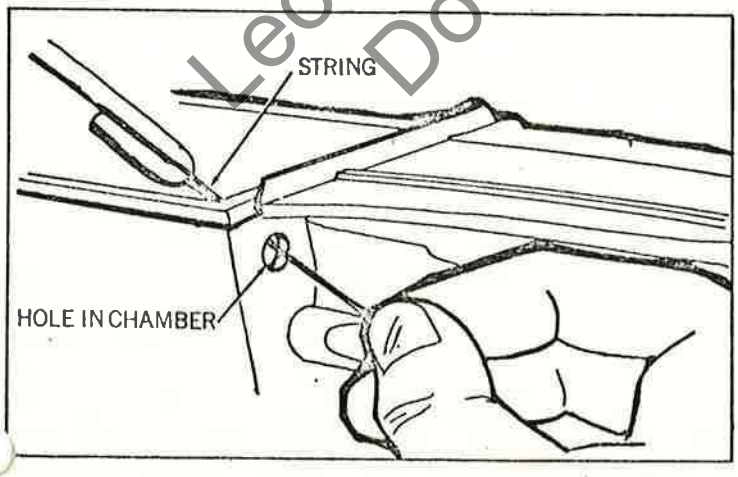
3. Units with the small diameter fuel line hole in the carburetor chamber should use the 'String" method for feeding the new line through the hole.

   a) Double a piece of strong, thin string and thread the loose ends through the hole from inside the carburetor chamber.

   b) Push about one inch of fuel line through the string loop and bend it back on itself, oil the bend in the fuel line and pull the string and fuel line through the hole.

   c) Pull until the carburetor seats against the manifold.

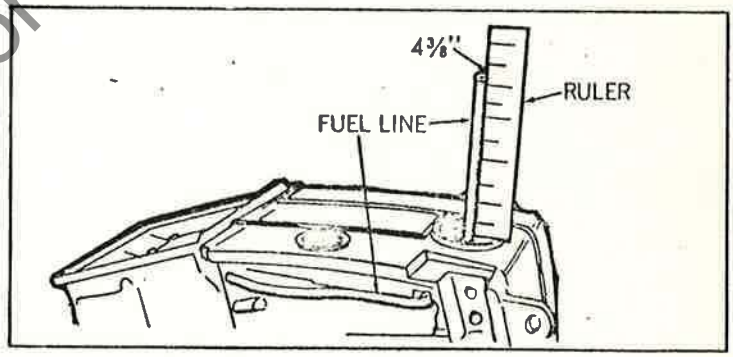
   NOTE: If the bushing was used, be sure to adjust it to seal the fuel line hole in the chamber.

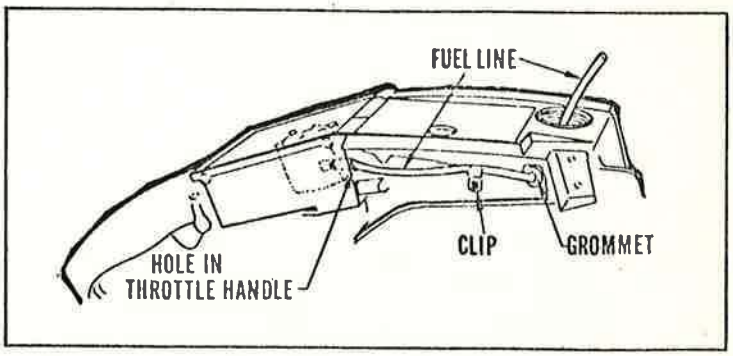


4. Oil grommet 68046 and push it into place in the outlet hole in the fuel tank. Double a piece of strong, thin string and thread the loose ends through the grommet and into the fuel tank. Grab the loose ends and bring them out through the fuel cap opening. Using the "string" method as described before, pull the fuel line into the tank and out the fuel filler opening.

5. Pull until the line measures 4-3/8"from the top of the opening to the end of the line.

   NOTE: The fuel line should be free of any sharp bends or kinks that would restrict fuel flow. This would especially occur at the grommets.





6. Attach the fuel line clip. Reassemble the fuel filter to the end of the new line and drop it back in the tank.

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

HOMELITE
a extron DIVISION
PORT CHESTER, N.Y. U.S.A.

PRINTED IN U.S.A.

EB174JZ

BRANCH SERVICE MEMO NO. 789 CS

DEALER SERVICE MEMO NO. 477

HOMELITE
a division of Textron Inc.
PERFORMANCE · DEPENDABILITY · SERVICE

Distribution:

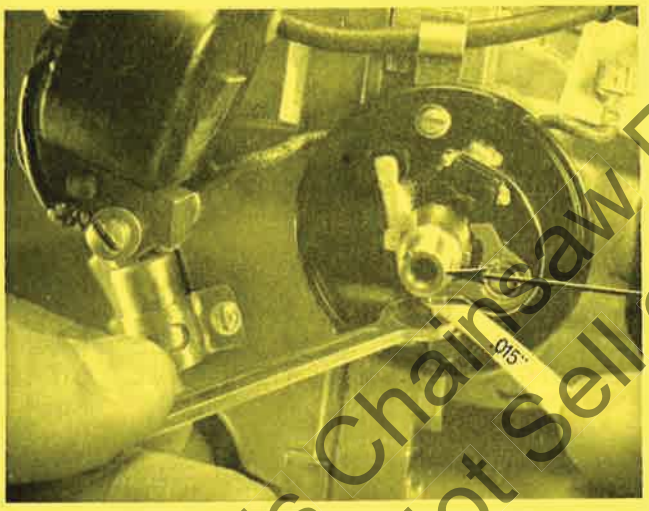
TO: All Districts, Branches and Chain Saw Dealers

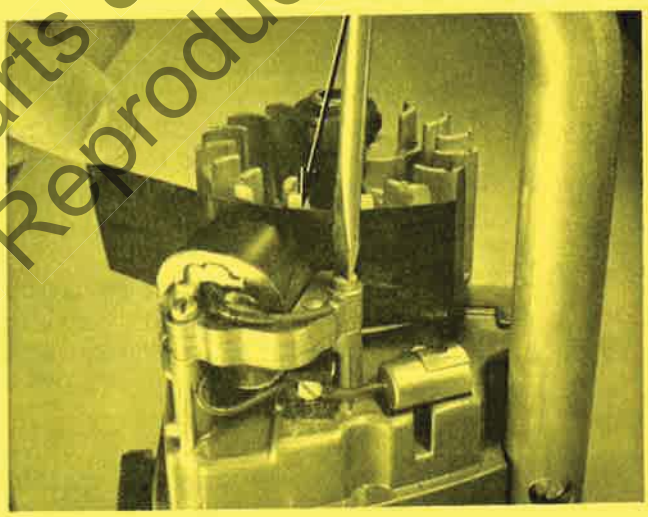
SUBJECT: 1) Magneto Air Gap
2) Crankcase to Cylinder Mating Surface Preparation

DATE: 7/71

Units Affected: 150 Automatic

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





1. On all reciprocating engines the crankshaft is forced in the direction of the piston downstroke during the power and compression portion of the stroke. This takes up all play between the crankshaft, main bearings and shaft supports in the direction of the downstroke.

   In order to set the spark timing correctly and because the Model 150 coil is mounted on the crankcase side of the shaft, it is important to take up the play in the downstroke direction while the contact point and coil core-to-rotor air gaps are being set. This is done by pushing and holding the shaft toward the bottom leg of the core during the adjustment; otherwise the gap settings will be much too narrow on the compression and power stroke.

If you are curious as to why this needn't be done when setting the air gaps on other engines, such as the XL-12, recall that these other Homelites have the coil on the cylinder side of the shaft.

The pictures show the gaps being set and the arrows show the direction to push. The desired air gap settings for the 150 are:

Coil core-to-rotor	---	.012" (make with #24306 shim)
Breaker gap	---	.015" (make with 7/32" wrench and #22486 feeler gauge)

2. Crankcase to Cylinder Mating Surface Preparation

A substance called "RTV Silicone Rubber" is rubbed onto the mating surfaces of the crankcase and the cylinder before a Model 150 engine is assembled at the factory. This extremely thin film of uncured silicone rubber seals the surfaces together. The short block can be disassembled and serviced at least once without need to recoat the mating surfaces, unless the film has been picked or scratched off.

Practically all local"5 & 10¢" stores, hardware stores and supermarkets carry tubes of this sealer under different names and labels. Look for tubes of sealant or adhesive containing RTV (room temperature vulcanizing) silicone rubber, such as "Silicone Seal" (manufactured by General Electric) and "Glass & Ceramic Adhesive" (manufactured by Dow Corning).

If the surfaces need recoating, rub them clean with the fingers or a cloth instead of trying to patch. Put a small dab of sealer onto the surface and smear it over the area smoothly. Try to make a very thin and even film--just a slight tackiness is what you should feel.

The surfaces can be mated while the sealant is still tacky.

Robert S. Townsend
Service Manager

las

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

HOMELITE
a division of Textron Inc.

BRANCH SERVICE MEMO NO. 790CS

DEALER SERVICE MEMO NO. 478

TO: Districts, Branches & Chain Saw Dealers

SUBJECT: Gasket Set - Repair Kits **DATE:** 7/71

Units Affected: All Tillotson HS Series Carburetors

The following parts are released new:

Gasket Set	67866 (Tillotson GS-1 HS)
Repair Kit	67869 (Tillotson RK-1 HS)
Repair Kit	50590 (Tillotson RK-2 HS)
Repair Kit	67870 (Tillotson RK-3 HS)
Repair Kit	67981 (Tillotson RK-4 HS)

The above new gasket set and repair kits, used to service the Tillotson model HS series carburetors, have been released by Tillotson and will supersede all present gasket sets and repair kits as present stocks are exhausted.

The new gasket set (67866) includes the gaskets necessary for the repair of all Model HS series carburetors. The new repair kits, (67869, 50590, 67870, 67981) consist of items formerly included in the kits with the exception of the following:

Idle Mixture Screw
High Speed Mixture Screw
Inlet Needle, Seat and Gasket

These particular items must now be ordered separately.

Following is a list of the new gasket set and repair kits indicating which part numbers they supersede and the carburetors affected:

NEW KIT	SUPERSEDES	CARBURETORS AFFECTED
Gasket Set 67866 (Tillotson GS-1 HS)	58971, 65895	A58767-C (HS-4D), A59535-B (HS-5C), A59887 (HS-13A), A63448 (HS-26A), A54264-2 (HS-35B), A54617-B (HS-45C), A64465 (HS-46A), (HS-67A), A65578-A (HS-73A) A67819-A (HS-86B), A67887-B (HS-92C), A67887-C (HS-92D), A67887-A (HS-92B), A-68363 (HS-96A), A68251-A (HS-103B) A-50670 (HS-109A)

Cont'd.

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

NEW KIT	SUPERSEDES	CARBURETORS AFFECTED
Repair Kit 67869 (Tillotson RK-1 HS)	58972, 63679,54751 64758, 54988, 54988-A	A58767-C (HS-4D), A59535-B (HS-5C), A63448 (HS-26A), A54617-B (HS-45C), A64465 (HS-46A), A68363 (HS-96A), A50670 (HS-109A)
Repair Kit 50590 (Tillotson RK-2HS)	54446, 54446-A	A54264-2 (HS-35B)
Repair Kit 67870 (Tillotson RK-3 HS)	65896	(HS-67A), A65578-A (HS-73A), A67819-A (HS-86B), A67887-A (HS-92B), A67887-B (HS-92C), A67887-C (HS-92D), A68251-A (HS-103B)
Repair Kit 67981 (Tillotson RK-4 HS)	63026, 54568, 54800	A59887 (HS-13A), Gov't.

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

Robert S. Townsend
Service Manager

al

HOMELITE
a division of Textron Inc.

BRANCH SERVICE MEMO NO. 791 CS

DEALER SERVICE MEMO NO. 479

TO: Districts, Branches & Chain Saw Dealers

SUBJECT: Gasket Sets - Repair Kits **DATE:** 7/71

Units Affected: All Tillotson HL Series Carburetors

The following parts are released new:

Gasket Set #68656	(Tillotson GS- 1HL)
Gasket Set #68657	(Tillotson GS- 2HL)
Repair Kit #68661	(Tillotson RK-21HL)
Repair Kit #68663	(Tillotson RK-23HL)
Repair Kit #68664	(Tillotson RK-24HL)
Repair Kit #68659	(Tillotson RK-17HL)
Repair Kit #68662	(Tillotson RK-22HL)
Repair Kit #68660	(Tillotson RK-20HL)
Repair Kit #68658	(Tillotson RK-12HL)

The above new gasket sets and repair kits used to service the Tillotson Model HL series carburetors have been released by Tillotson and supersede all present gasket sets and repair kits as present stocks are exhausted.

The new gasket sets (68656 and 68657) include all the gaskets necessary for the repair of all Model HL carburetors. The new repair kits (68661, 68663, 68664, 68659, 68662, 68660, 68658) include items formerly included in the kits with the exception of the following:

Idle Mixture Screw
High Speed Mixture Screw
Inlet Needle, Seat and Gasket

These particular items must now be ordered separately.

Cont'd.

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

The following is a list of the new gasket sets and repair kits indicating the part numbers superseded and the carburetors affected.

NEW KIT	SUPERSEDES	CARBURETORS AFFECTED
Gasket Set 68657 (Tillotson GS-2HL)	64629, 63880, 58534	A57130 (HL273A), A65717 (HL261A), A63585 (HL222A), A59427A (HL141D)
Gasket Set 68656 (Tillotson GS-1HL)	55836, 57964, 57919 58386	A56760 (HL82A), A57440 (HL104A and HL105A), A57806 (HL119A), A58102 (HL117C), HL204A, HL142A)
Repair Kit 68658 (Tillotson RK-12HL)	77392	A56760 (HL82A)
Repair Kit 68661 (Tillotson RK-21HL)	58191, 77343, 56649 57920, 57987, 59503	A57440 (HL104A & HL105A), A57806 (HL119A), A58102 (HL117C), HL142A
Repair Kit 68659 (Tillotson RK-17HL)	57843	HL204A
Repair Kit 68662 (Tillotson RK-22HL)	58681, 58535	A59427-A (HL141D)
Repair Kit 68663 (Tillotson RK-23HL)	65606, 64630, 67524	A65717 (HL261A), A67130 (HL273A)
Repair Kit 68664 (Tillotson RK-24HL)	63789	A63585 (HL222A)

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

Robert S. Townsend
Service Manager

al

BRANCH SERVICE MEMO NO. 792CS

DEALER SERVICE MEMO NO. 480

HOMELITE
a division of Textron Inc.

TO: All Districts, Branches and Chain Saw Dealers

SUBJECT: Clutch Shoes
Units affected: XL-400 Auto and XL-400 Auto FP

DATE: July 28, 1971

A six shoe spider type clutch is now incorporated in the production of the above specified model units starting with S/N 10960564.

This clutch assembly consists of the following parts:

1	58927-2	Spider
6	58928-1	Shoe
2	55123-C	Spring
1	58751-1	Clutch Cover

Bill Patella

Bill Patella
Ass't. Service Manager

jw

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

HOMELITE
a division of Textron Inc.

BRANCH SERVICE MEMO NO. 793CS

DEALER SERVICE MEMO NO. 481

TO: All Districts, Branches & Chain Saw Dealers

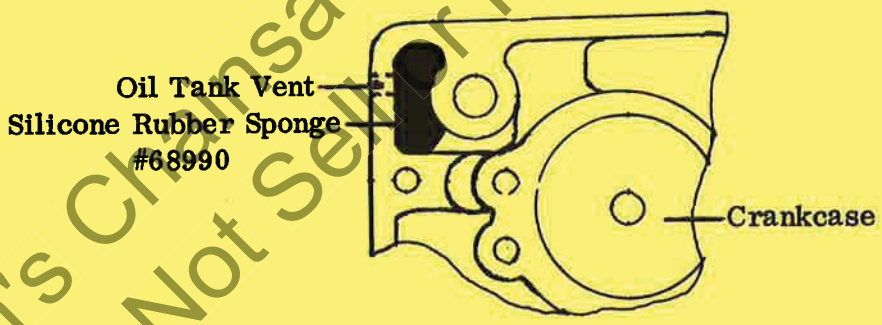
SUBJECT: Oil Leakage Oil Tank Vent

DATE: 8/71

Unit Affected: Model 150 Automatic Chain Saw

You may find that some Model 150 saws leak oil from the oil tank vent when the unit is stored, especially when some pressure exists in the tank.

In these cases, the felt vent filter (Part No. 68640) acts like a wick which allows the leakage. Replace vent filter Part No. 68640 with Part No. 68990 made from soft silicone sponge rubber. This filter will not "wick" but rather acts like a check valve when pressure exists in the oil tank.



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

Robert S. Townsend

Robert S. Townsend
Service Manager

al

HOMELITE
a division of Textron Inc.

BRANCH SERVICE MEMO NO. 794CS

DEALER SERVICE MEMO NO. 482

TO: All Districts, Branches & Chain Saw Dealers

SUBJECT: O-Ring for Cylinder Shield **DATE:** 8/71

Units Affected: 2100S, 3100G

To eliminate cracking of cylinder shield, from vibration place #68891 O-Ring between cylinder shield mounting screw and cylinder shield to provide a resilient cushion.

This O-Ring is incorporated in 2100S starting with Serial No. 10841014.

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

Bill Patella
Ass't. Service Manager

al

HOMELITE
a division of Textron Inc.

BRANCH SERVICE MEMO NO. 795CS

DEALER SERVICE MEMO NO. 483

TO: All Districts, Branches & Chain Saw Dealers

SUBJECT: Rotor & Starter Fingers **DATE:** 8/71

Units Affected: All Chain Saws and Construction Equipment using XL style Engines.

Starting immediately, the shoulder studs for the starter fingers are to be loctite to the rotor, using Loctite Part No. 23488-B.

Shoulder studs with 12-24 thread - assembling torque 80 to 90 inch lbs.

Shoulder studs with 10-32 thread - assembling torque 60 to 70 inch lbs.

Bill Patella

Bill Patella
Ass't. Service Manager

al

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

BRANCH SERVICE MEMO NO. 796CS

DEALER SERVICE MEMO NO. 484

HOMELITE
a division of Textron Inc.

TO: All Districts, Branches & Chain Saw Dealers

SUBJECT: Rewind Starter Assembly **DATE:** 8/71

Units Affected: 2100S, 3100G, C-72, 1050 AO, 1130G

Starter Assembly Part No. A64178-3A for units shown above now contains a new nylon bushing 64443-1 assembled to starter post, similar to the XL-12 arrangement.

This starter is incorporated in units beginning with:

1050AO	S/N 11090682
1130G	S/N 11160013
2100S	S/N 10841014

A64178-3A starter cover supersedes A64178-3.

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

Bill Patella

Bill Patella
Ass't. Service Manager

al

HOMELITE
a division of Textron Inc.

BRANCH SERVICE MEMO NO. 797CS

DEALER SERVICE MEMO NO. 485

TO: All Districts, Branches & Chain Saw Dealers

SUBJECT: Muffler Caps with Shield **DATE:** 8/71

Units Affected: XL-Mini Auto FP, Super Mini FP, Super EZ Auto, EZ-250 Auto, EZ, EZ Auto

The new quieter diffuser muffler cap with a shield to direct exhaust gases downward is now available for the above listed units.

A68949-1	EZ
A68950-1	Super Mini FP, XL-Mini Auto FP, Super EZ Auto, EZ-250 Auto, EZ Auto

New cap incorporated in Super Mini FP starting with Serial No. 12242201 and Super EZ Auto with Serial No. 12000742.

Bill Patella

Bill Patella
Ass't. Service Manager

al

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

BRANCH SERVICE MEMO NO. 798CS

DEALER SERVICE MEMO NO. 486

HOMELITE
a division of Textron Inc.

TO: All Districts, Branches & Chain Saw Dealers

SUBJECT: XL-923-924 with Tillotson Carburetor HS92C and HS103A **DATE:** 8/71

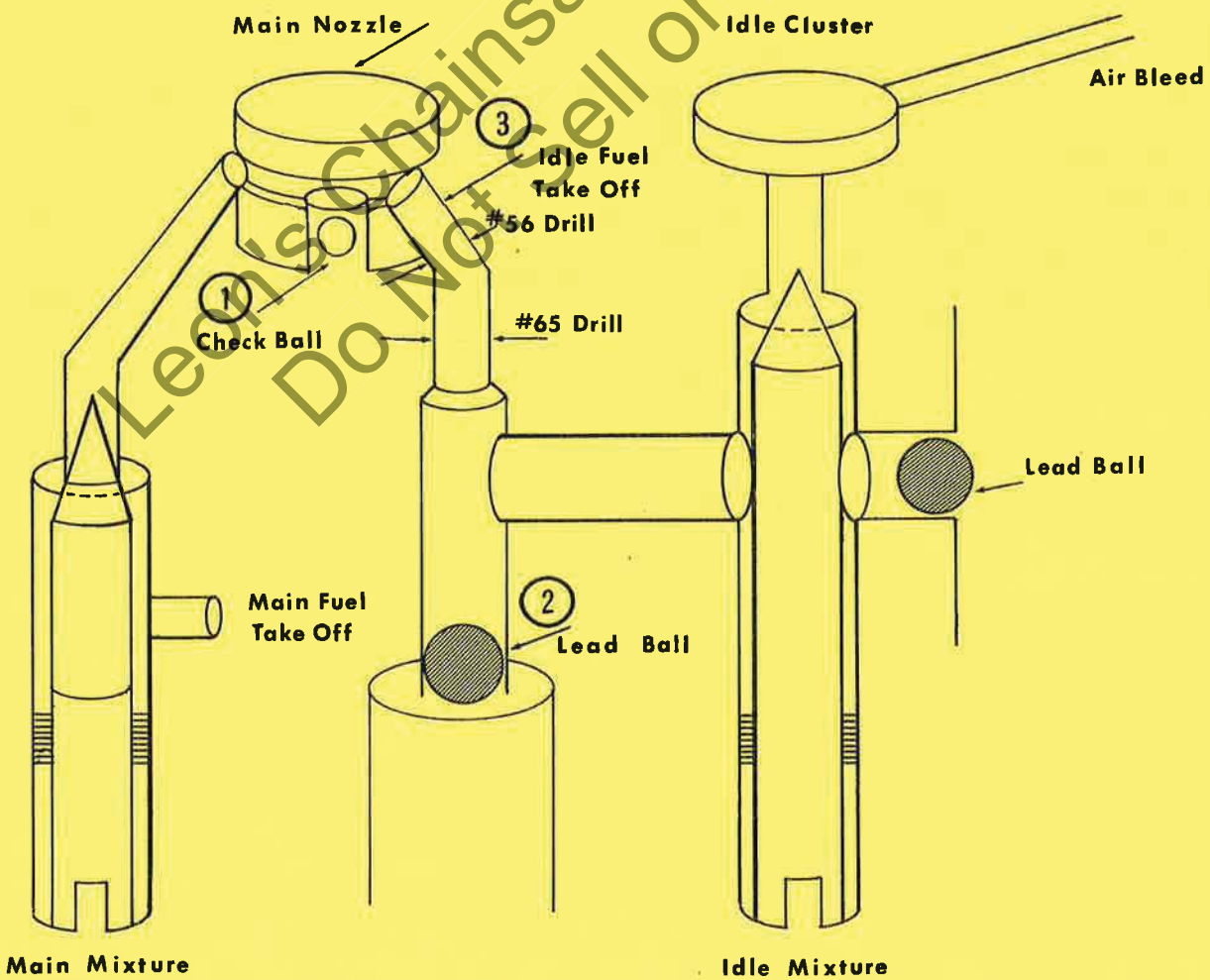
We have received reports that some 923's and 924's are hard to start when new.

If you encounter hard starting check the following as possible causes on new units only:

1) Main nozzle check ball (Part No. 54444) may be stuck in closed position both in new units and new replacement carburetors.

2) Lead shot between HI and LO needles left out.

3) The idle fuel take off hole not drilled or not drilled completely from main nozzle check valve bore.



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

We have just received from Tillotson a new disc type main nozzle check valve Part No. 68284. This assembly is less susceptible to sticking. Check Valve Part No. 68284 can be used interchangeably with Part No. 54444 in all applications.

Sticking main nozzle check valves can in most cases be freed by using a bent paper clip to move the ball.

The main nozzle check ball can also be unseated by air or hydraulic pressure applied through the high speed adjusting needle opening, but the main diaphragm must be removed first. In most cases, just the force required to knock the valve out of the body is enough to jar the ball loose.

NOTE: Tillotson models HS-92D Part No. A67887-C (XL-923, XL-924) and HS103 B Part No. A68251-A (XL-924W) will have disc type main nozzle check valve installed at time of manufacture.

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

Robert S. Townsend

Robert S. Townsend
Service Manager

al

HOMELITE
a division of Textron Inc.

BRANCH SERVICE MEMO NO. 799CS

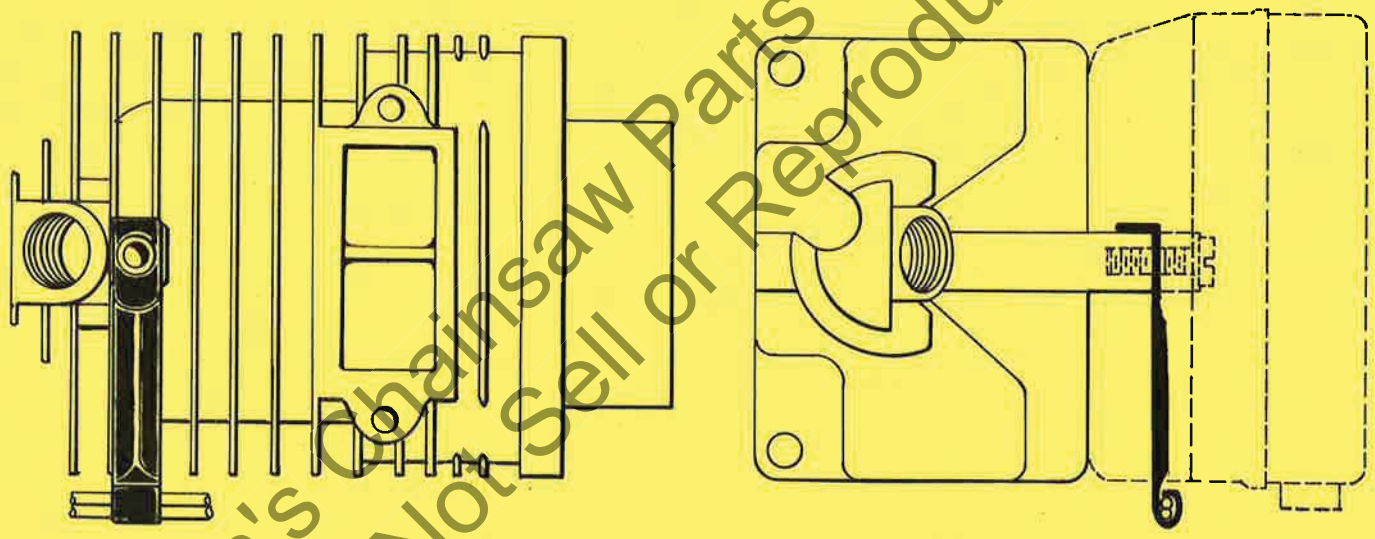
DEALER SERVICE MEMO NO. 487

TO: All Districts, Branches & Chain Saw Dealers

SUBJECT: Oil Line Breakage XL-400 **DATE:** 8/71

Oil housing castings are being changed to provide an area where the oil lines can be clamped to restrict movement due to vibration.

Clamp, (Part No. 68965) is available as a field fix for existing units if you encounter this problem. It is installed as shown below.



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

1. Remove approximately .030 (0, 8 mm) from top muffler mounting boss and form clamp to fit boss.

2. Place oil lines in clamp, and squeeze clamps tight with pliers.

Robert S. Townsend

Robert S. Townsend
Service Manager

al

HOMELITE
a division of Textron Inc.

BRANCH SERVICE MEMO NO. 800CS

DEALER SERVICE MEMO NO. 488

TO: All Districts, Branches & Chain Saw & Construction Equipment Dealers

SUBJECT: Rubber Cement for C.D. Ignition **DATE:** 8/71

To prevent shorting between ignition module and back plate C.D. magneto systems on the XL-924W, XL-98, XL-88, XL-924, add Dow Corning #502 Silastic around the module terminals of the back plate assembly. The #502 Silastic is applied after the back plate assembly has been electrically inspected 100%.

Secondary substitutes for Dow Corning #502 are RTV Silicon Rubber Cement or Dow Corning Bath tub caulking compound.

On the XL-98 and XL-88 units, metal dust may adhere to the ignition components and short them out. Once the ignition system is wiped clean and is once again functional, the above listed rubber cements should be sprayed on the ignition terminals to protect them.

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

Bill Patella
Ass't. Service Manager

al

BRANCH SERVICE MEMO NO. 800-ACS

DEALER SERVICE MEMO NO. 488-A

HOMELITE
a division of Textron Inc.

TO: All Districts, Branches, Chain Saw & CE Dealers

SUBJECT: Rubber Cement for C.D. Ignition **DATE:** 12/71

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

The word "sprayed" in the last paragraph should be "spread".

Please correct SM800CS dated 8/71.

Bill Patella

Bill Patella
Ass't. Service Manager

al

BRANCH SERVICE MEMO NO. 801CS

DEALER SERVICE MEMO NO. 489

PERFORMANCE · DEPENDABILITY · SERVICE

HOMELITE

a division of Textron Inc.

TO: All Districts, Branches & Chain Saw Dealers

SUBJECT: Testing & Repairing Model 150 Chain Oil Systems **DATE:** 9/71

The owners manual tells you to close the feed rate adjustment needle all the way in direction of the arrow on saw tank either to prevent the oil from leaking out when the saw is lying idle, or whenever you need maximum flow of oil to the chain. An inoperative pump may fool you into believing that the system works contrary to the instructions.

When the pump is not working, and the oil tank is fairly full, oil will seep out of the discharge hole if the feed rate needle valve is open, the oil flowing by gravity through the open valve and right on out the discharge hole. It will not seep out when the valve is closed.

Pressure testing and oil pump repairs are completely discussed in the "Model 150 Pictorial Service Guide" part number 24539 which will be available in September.

In the meantime, the attached sheet will explain the operation of the oil system (See Figures 1 and 2), and tell you how to test it, clean it, diagnose trouble and fix it.

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

Rod Ferguson, Supervisor
Technical Publications Dept.

al

HOMELITE
a division of Textron Inc.

BRANCH SERVICE MEMO NO. 803CS

DEALER SERVICE MEMO NO. 491

TO: All District, Branches & Chain Saw Dealers

SUBJECT: Heli-Coil Kits and Insert **DATE:** 10/71

We have received many requests from the field for a listing of Heli-Coil Kits and Inserts. The following are available:

A-22921	Heli-coil Tool Kit consists of pressure plate and T handle
A-22923	Heli-coil Pack 5/16 - 18 x 15/32, 24 inserts, tap and inserting tool
A-22924	Heli-coil Pack 3/8 - 16 x 9/16, 18 inserts, tap and inserting tool
A-23073	Heli-coil Pack 10/24 x 3/8, 30 inserts, tap and inserting tool
A-23723	Heli-coil Pack, 12/24 x .324, 30 inserts, tap and inserting tool
A-23523	Heli-coil Kit consists of:
A-22922	Heli-coil Pack, 1/4-20 x 3/8, 30 inserts, tap and inserting tool
A-23072	Heli-coil Pack, 8/32 x 1/4, 30 inserts, tap and inserting tool
A-23519	Heli-coil Pack, 10/32 x 9/32, 30 inserts, tap and inserting tool
	These packs are also available separately.

23060	Insert, 8/32 x 1/4
23063	Insert, 10/32 x 9/32
23529	Insert, 6/32 x .207
41510	Insert, 1/4 - 20 x 3/8
41740	Insert, 5/16 - 18 x 15/32
41741	Insert, 3/8 - 16 x 9/16
56604	Insert, 12-24 x .324
61208	Insert, 1/4 - 20 x 1/4
67910	Insert, 10-24 x 3/8
72122	Insert, 14MM - 1.25 MM
73062	Insert, 5/16 - 18 x 5/16
73610	Insert, 10 - 24 x 3/8

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

Bill Patella

Bill Patella
Ass't. Service Manager

al

BRANCH SERVICE MEMO NO. 803-A CS

DEALER SERVICE MEMO NO. 491-A

PERFORMANCE · DEPENDABILITY · SERVICE

HOMELITE

a division of Textron Inc.

TO: All Districts, Branches & Chain Saw Dealers

SUBJECT: A-22921 Heli-Coil Tool Kit Containing Pressure Plate and T Handle **DATE:** 12/71

We have exhausted our supply of A-22921 and have been informed by the vendor that they will no longer be supplied.

Bill Patella

Bill Patella
Ass't. Service Manager

al

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