



BRANCH SERVICE MEMO NO. 961

DEALER SERVICE MEMO NO. 649

Distribution:

TO: All Districts, Branches & Chain Saw Dealers

SUBJECT: A-70365 Handlebar and Clamp Kit

DATE: 1-18-76

MODELS AFFECTED: SXL-AO - SXL - XL-Auto. - XL-660F - XL-500 Auto

The late model red and black SXL-AO Chain Saws are now equipped with a full radius handlebar which extends along the bottom of the fuel tank. To install this new handlebar on chain saws which have the angled type handlebar, part number A-70365 Handlebar and Clamp Kit is now available .

All the parts and instructions detailing how to install the new full radius handlebar on the older model SXL-AO are contained in this kit.

I. A-59790 & A-63909-4 Handlebars are obsolete and replaced by A-70365 Handlebar and Clamp Kit.

II. New Parts

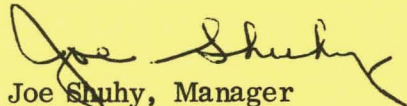
A-70365 Handlebar and Clamp Kit

Parts contained in this kit are:

1 pc	Handlebar
1 pc	63291-A Clamp
1 pc	80428-1 Socket Head Screw 1/4-20 x 1 inch

Part numbers shown above may be ordered seperately.

Please mark your parts list accordingly.


Joe Shuhy, Manager
Forestry Equipment

jp



BRANCH SERVICE MEMO NO. 962

DEALER SERVICE MEMO NO. 650

January 16, 1976

Distribution:

TO: All District, Branches & Chain Saw Dealers

SUBJECT: Screw, Bearing Retaining # 70306

DATE: 1-75

USAGE: Crankcase: XLS2 - 1A - XL-98-A - XL-900 Series
Drivecase: Super EZ - Super XL - Mini Series
Drivecase: SXL-AO - Family

Tools Required: # 25 Torx Driver Bit # 24982

A new bearing retaining screw # 70306 supersedes screw # 59704 in all above usage.

This new screw has a special torx drive recess that is the ultimate in torque delivery and should eliminate driver and head failure with the above screw.

The new screw # 70306 has a # 25 torx recess and will require a special driver bit # 24982 supplied thru Homelite Service. This bit will fit a standard 5/16" socket.

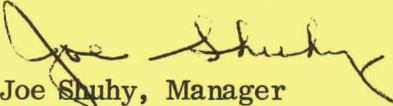
The torx recess tools are available in driver bit, key type (like allen wrench) and hand driver (like screw driver) types. They are readily available thru distributors of Apex, Proto, Magna, Snap On Tools throughout the United States. Sears Roebuck & Co. has a (9) piece key set that will handle screws from #6 thru 1/2" dia. for approximately \$2.00 per set.

We will be using torx recess screws for other applications in the future but will limit recess sizes to as few as possible.

Dealers and districts should order a supply of the # 25 torx bits # 24982 immediately so they can handle the new bearing retaining screw.

Those wishing to have the key type or hand driver type in addition to the driver bit can obtain them at their local supply houses.

Please mark your parts list accordingly.


Joe Shuhy, Manager
Forestry Equipment

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BRANCH SERVICE MEMO NO. 963

DEALER SERVICE MEMO NO. 651

Distribution:

TO: All Districts, Branches & Chain Saw Dealers

SUBJECT: Model # 350 Isolators and Isolator Pins

DATE: 2-76

ISOLATORS:

We have made changes to the isolators and isolator pins to improve the life of the isolator system of the model # 350 chain saw. You now have a choice of two types of isolators, the original # 12285 and a new harder isolator # 70228.

The harder isolator is presently being used in production of the 350-AO and bow saws and the softer isolator is used for the model 350 HG & SL saws. The harder isolator has increased life over the softer one with only a slight increase in vibration.

As shown these isolators will be supplied separately or in kits of (4). The configuration that identifies the two types of isolators is sketched on the back of this newsletter.

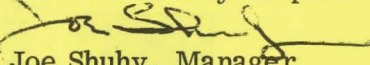
ISOLATOR PINS:

The thread size of the isolator pins has been increased from 1/4-20 to 5/16-18 to reduce thread stripping in the castings. We will supply only the new 5/16-18 improved thread for service. This will require retapping existing field units to the new thread size on saws produced prior to this change.

To prepare the hole for tapping to the new 5/16-18 thread, the 1/4-20 threads will have to be removed. Use a .257 dia. drill to remove the 1/4" threads. Tap the drilled holes with a 5/16-18 UNC-2A tap. If the 1/4-20 thread was stripped out, you may tap to 5/16-18 without drilling.

A-70622	Isolator Kit - For model 350-AO & Bow
70228	Isolator (separately) For model (350-AO & Bow)
A-70623	Isolator Kit - For model 350 HG & SL
12285	Isolator (separately) For model 350 HG & SL
A-70624 -A	Isolator Pin Kit - 5/16-18 thread size
12100- B	Isolator Pin - 5/16-18 thread size

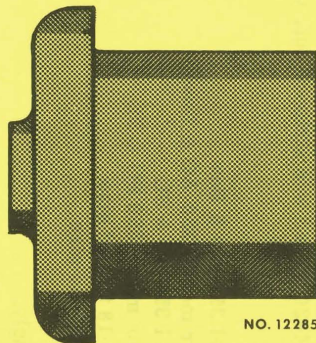
Please revise your parts list accordingly.


Joe Shuhy, Manager
Forestry Equipment

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MODEL 350 ISOLATORS

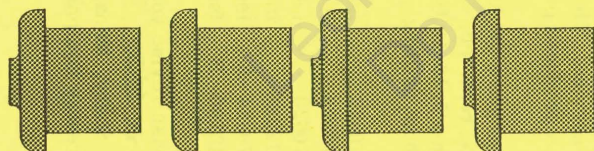
SUPPLIED SEPARATELY OR IN KITS OF 4
AS SHOWN BELOW



NO. 12285

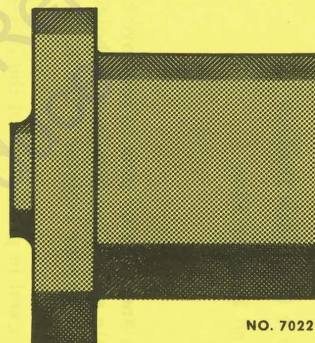
**12285 Isolator (separately)
for model 350 Hand Guard
and model 350 SL (Chain Brake)**

or



**In Kits of 4 – same as models above
Order Kit No. A-70623**

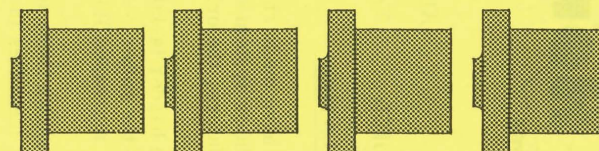
SUPPLIED SEPARATELY OR IN KITS OF 4
AS SHOWN BELOW



NO. 70228

**70228 Isolator (separately)
for model 350 Automatic Oiler
and model 350 Bow Saw**

or



**In Kits of 4 – same as models above
Order Kit No. A-70622**



BRANCH SERVICE MEMO NO. 964

DEALER SERVICE MEMO NO. 652

Distribution:

TO: All Districts, Branches & Chain Saw Dealers

SUBJECT: 375 Series PRO CUT Saw Chain

DATE: 2-76

USAGE: Super EZ-AO & 150-AO

"375 PRO CUT" is the name of the new saw chain introduced by Homelite. It is a true 3/8" pitch chain.

Because 375 PRO CUT looks like our 37 series chain, make sure you can tell them apart. Know which bars, sprockets and filing tools are required for each chain. Here are the particulars:

1. IDENTIFYING NUMBERS STAMPED ON THE CHAIN:

- a) 375 PRO CUT is stamped "375" on each tie-strap.
- b) Standard 3/8" pitch chain (38 series) is stamped "38" on each drive link tang.
- c) 37N and 37C (37 series) chains are stamped "37" on each drive link tang.
- d) 1/4" pitch (series 25) chains are stamped 25 on each drive link tang.

2. INTERCHANGEABILITY:

- a) 375 PRO CUT and standard 3/8" pitch chains are interchangeable. They use the same guide bars, 3/8" pitch drive sprockets and bar nose sprockets.
- b) 375 PRO CUT chain is not interchangeable with 1/4" pitch series 25, or 37 series (37N & 37C) chains. The 37 series chains are not true 3/8" pitch, and require a special drive sprocket at this time.

3. Chain Filing Instructions:

- a) 375 PRO CUT chain has its own instruction sheet (#17060) which is being packaged with the owners manuals on the saws being fitted for 375 PRO CUT chain. So far they have been included with manual 23754-B for the Super EZ-AO, and manual #24533-C for the model 150-AO. Read the enclosed copy of instruction sheet # 17060. It tells the buyer how to identify the chain on his saw (by the numbers on the chain) and whether he should follow filing instructions in his owners manual or the 375 PRO CUT instruction sheet.

- b) New PRO CUT chain is filed with a 5/32" (4 mm) diameter round file as are the 25 and 37 series chains. But, like series 25, you should switch to a 1/8" (3,2 mm) diameter file after half of the original cutter length has been filed away.
- c) The filing angles and depth gauge specifications for 375 PRO CUT are the same as those issued for 1/4" pitch series 25 chains. The top plate angle is 35 degrees (not 30°). The side plate angle is 85 degrees. The depth gauge setting is .020" (0,51 mm) -- NOT .025" (0,63 mm) which is specified for series 37 and 38 chain.


For your convenience we are including the 375 PRO CUT instruction sheet #17060 and a saw chain pitch identification sheet with this memo. Listed below are the currently available sharpening tools for these chains.

Saw Chain Sharpening Tools

5/32" File & Holder	#DA-92617	375 PRO CUT; 25 Series; 37 Series
7/32" File & Holder	#DA-92615	38 Series
5/32" Dia. Round File	# 92604	375 PRO CUT; 25 Series; 37 Series
3/16" Dia. Round File	# 92603	38 Series only - after 1/2 to 3/4 used up
7/32" Dia. Round File	# 92601	38 Series
1/8" Dia. Round File	# 92605	375 PRO CUT and 25 Series when half used up
.020 Gauge Depth Tool	#D- 92630	375 PRO CUT and 25 Series
.025 Gauge Depth Tool	#D- 92631	37 and 38 Series only

Please mark your records accordingly.

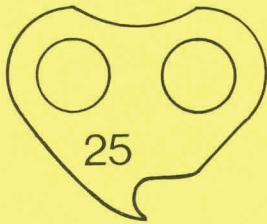
Branch memo to follow.


 Joe Shuhly, Manager
 Forestry Equipment

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NOTE: This page should be attached to Branch Service Memo # 964/652
PT # 17060 should also be attached to this. These two pages were
attached to 963/651 in error.

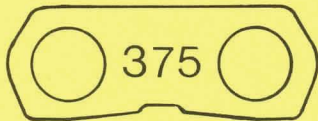
SAW CHAIN PITCH IDENTIFICATION



25 Series

1/4" Pitch

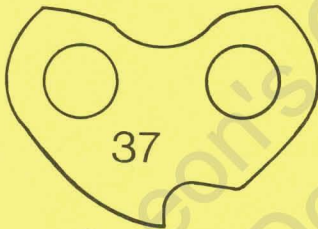
Use 5/32" dia. round file to sharpen
and 1/8" dia. after 1/2 tooth has been
filed away. .020 depth gauge standard.



375 Series

3/8" Pitch - Pro Cut

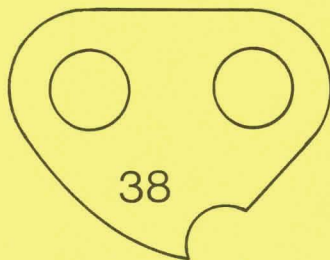
Use 5/32" dia. round file to sharpen
& 1/8" dia. after 1/2 tooth has been
filed away. .020 depth gauge standard.



37 Series

Low Profile

Use 5/32" dia. round file to sharpen.
.025 depth gauge.



3/8 Series

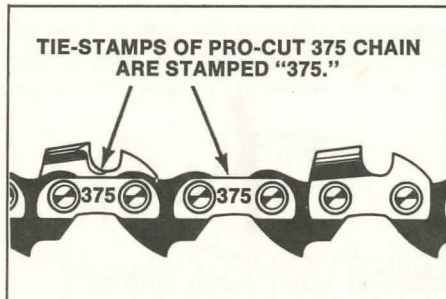
3/8" Pitch-Standard.

Use 7/32" dia. round file to sharpen
& 3/16" dia. after 1/2 to 3/4 of tooth
has been filed away. .025 depth gauge-std.

Home life

MAINTENANCE & ADJUSTMENT INSTRUCTIONS for PRO-CUT 375 CHAIN

Check your saw chain for the series designation. If tie-straps are stamped "375," use these instructions. If drive links are stamped "38," use filing instructions in your owner's manual.



Your saw has a fast-cutting HOMELITE® PRO-CUT 375 saw chain with a sprocket which matches it in pitch. When the chain is to be replaced, always have a new sprocket of matching pitch installed because a worn sprocket would be out-of-pitch and damage the new chain.

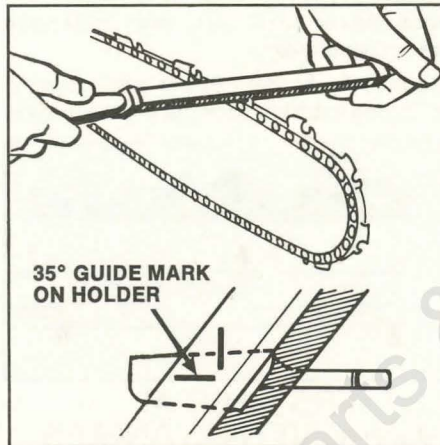
Not only for fastest cutting, but also for maximum life of the chain and all saw parts, always keep the chain in such good, sharp condition that bearing down hard to make the saw cut is unnecessary. When the sawdust turns from chips into a fine powder and you find yourself pressing hard to feed the chain, STOP IMMEDIATELY and file the chain.

FILING EQUIPMENT

Uniformity and accuracy are necessary for success in filing saw chain. These are easiest to obtain with the aid of a file holder which has the required 35° top filing angles marked on it, and also helps you to hold the file at the correct height (1/10 of file diameter above top plate of tooth) to produce the required side plate angle and beveled cutting edge.

ALL YOU HAVE TO DO IS MAINTAIN THE CORRECT FILING ANGLE, HEIGHT AND PRESSURE AGAINST THE TOOTH.

For new PRO CUT 375 chain, a 5/32" diameter (4mm) "fast-cut" round file (HOMELITE #92604) and holder (our Assembly DA-92617) is required. When about half of the original tooth steel has been filed away, you should switch to a 1/8" diameter (3.2mm) file (#92605). The reason for switching to the smaller diameter file on a "short-filed" tooth is the slight taper of the tooth's top plate which reduces the size of the tooth.



HOW TO FILE CUTTERS

A chain filing vise holds the cutters rock-steady during filing: but you can do a satisfactory job "on the bar" if you tighten up the tension enough that the chain doesn't wobble, and do all of the filing at the mid-point of the bar. Wear gloves for protection. Be sure to file all cutters to the same length. If you replace damaged cutters, file them back to the same length as the rest of the cutters so that each cutter has the same biting chance.

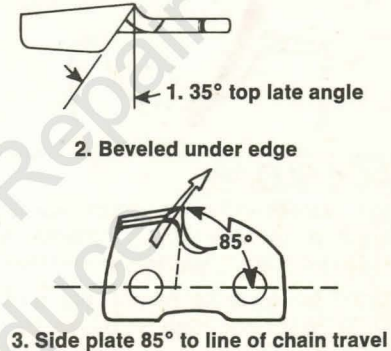
1. Hold file against cutter face at 35° angle (marked on file holder).
2. Keep file level—do not let it dip or rock.
3. File in one direction only—towards front corner of the tooth. Move file away from tooth face on return stroke.
4. Use light but firm pressure, mostly towards back of tooth. Avoid heavy downward filing pressure. The holder will keep 10% of the file above the top plate, automatically producing a beveled hollow-ground under edge.
5. Put a few firm strokes on every tooth, filing all cutters on one side of the chain, then all cutters on the other. Rotate file in holder occasionally.
6. A sharp edge will not reflect light. Examine the edge to see if the dulled area has been removed.



HOMELITE TEXTRON

Homelite Division of Textron Inc.

NOW EXAMINE YOUR FILING JOB—HERE'S WHAT YOU SHOULD GET:



CORRECTIVE FILING

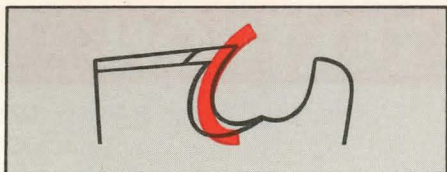
When teeth have hit hard objects such as stones, nails, etc., or cut dirt, sand, etc., the damaged area of the cutter must be filed away before the tooth will cut. NOTE: All cutters must be filed back to equal lengths to give them equal "bite", or the chain will not cut well. This can be done by hand, but it is easier and less expensive to have it done on an electric chain grinder. Your dealer or HOMELITE® factory service office (See "Yellow Pages") will charge you less for chain sharpening than it would cost you in hand files to do the job yourself. Electric chain sharpening has the added advantage of trueing up the chain to original factory shape.



IF SOME CUTTERS ARE LONGER THAN THE OTHERS, FILE THEM BACK TO THE LENGTH OF THE SHORT CUTTERS



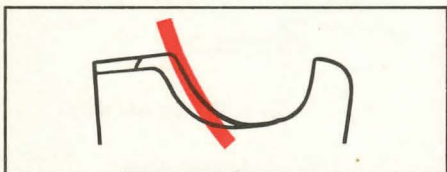
REFILE ANY TEETH HAVING ONE OR MORE OF THESE FAULTS:



FORWARD HOOK

Chain will grab and jerk, producing rough cutting.

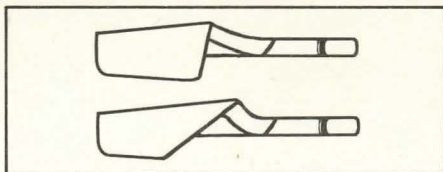
Caused by excessive downward filing pressure, or tip of file held too low on tooth.



BACK SLOPE

Chain resists entering wood (scrapes instead of cutting wood). Causes excessive heat and wear to bar and chain.

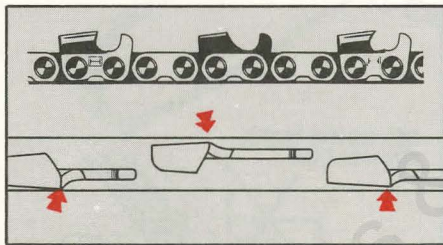
Caused by lowering handle end of file or holding file too high on the tooth.



IMPROPER TOP PLATE ANGLES

Blunt chain requires too much feed pressure. This top plate angle causes chain to bind, produces a rough cut, robs power from saw, and increases bar groove wear.

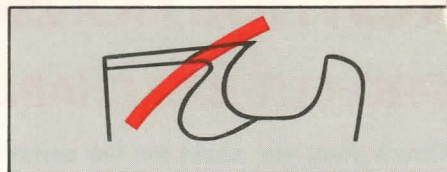
Caused by holding file at wrong angle or letting it drift or rock during the stroke.



CUTTERS FILED AT NON-MATCHING ANGLES

Chain will not cut at its best. May cut off line or "run" to one side, drag may slow down motor.

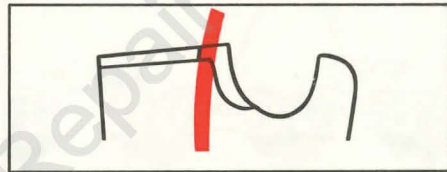
Caused by letting pressure and filing angle vary from tooth to tooth or one side filed with different angles and lengths than the other.



THIN FEATHERED EDGES

When they almost immediately break off, you have a dull chain. Usually found on chain filed with a hook (see "forward hook").

Caused by holding file with handle too low, or pressing down too hard on file.

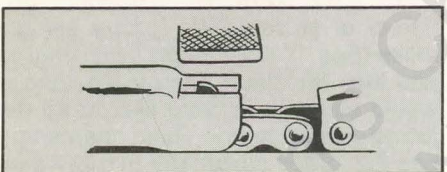


BLUNT CUTTING EDGES

Although edge is durable it won't cut properly; scrapes wood, robs power and produces dust instead of chips.

Caused by holding file too high on face of tooth, or keeping file handle too high.

HOW and WHEN TO SET DEPTH GAUGE CLEARANCE



Every second or third time the teeth are sharpened, or if a large amount of steel is removed from the cutters, the depth gauges should be jointed uniformly to a depth of .020 inches (0,51mm).

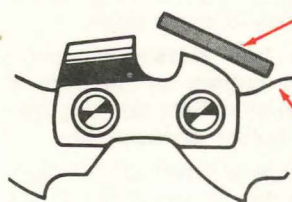
Use depth gauge tool #D92630 and a safe-edge (no teeth on edge) flat file #92609. Fit the tool over the chain so that the slotted end of the tool points toward the bar nose and the depth gauge projects up through the slot. File the depth gauge flush with the top of the tool. File all gauges to this height.

If the gauges are too high, the chain teeth will not get a good bite; if too low, the teeth will take too large a bite, causing the chain to grab and jerk. If some gauges are higher than others, the chain will cut off line, favoring the side having the lowest gauges.



AFTER FILING WITH JOINTER, GAUGE WILL HAVE FLAT TOP

SO...



USE SAFE-EDGE FLAT FILE TO RECURVE THE FRONT SMOOTHLY

DO NOT NICK DRIVE LINK WITH THE FILE

Homelite Division of Textron Inc.

14401 Carowinds Boulevard
Charlotte, North Carolina 28217



BRANCH SERVICE MEMO NO. 965

DEALER SERVICE MEMO NO. 653

Distribution:

TO: All Districts, Branches & Chain Saw Dealers
SUBJECT: Fuel Lines (Improvement in Rubber Compound)

DATE: 3-12-76

Important!

We now have an excellent new "synthetic rubber tubing" that will not become "gummy" in "stale gas".

In recent years, changes in refinery processing have made gasoline inherently more stable. Antioxidants and metal deactivators are widely used to protect against gums & peroxides produced by oxidation. Nevertheless, oxidation will occur with time and gasoline deterioration will result to some degree.

We cannot overemphasize the importance of always using a "Fresh Supply" of gasoline for good chain saw operation. This will also assure use of fuel that was not stored beyond the "climatic season" for which it was blended.

In chain saws we have experienced the following:

Deteriorated fuel lines caused by peroxides in stale gasoline.

Carburetor malfunction (sticking inlet needles, clogged filters) caused by gum in stale fuel.

"Vapor lock" when winter grade gasoline is used in the summer.

The deterioration of the fuel lines in chain saws became a problem when occasional users stored their saws for extended periods without adequate preparation. Even though the XL-2 fuel line was made from a high grade compound, it's one fault was that it would not tolerate contact with "stale gas".

Since we cannot insure that the user will adequately prepare his saw for storage, we had to find a suitable material that would have all of the properties required of a fuel line, in addition to tolerating stale gas.

"THIS WE HAVE ACCOMPLISHED WITH THE NEW RUBBER COMPOUND"

We still recommend adding "STA-BIL" to the fuel mix or draining the fuel tank, when storing for extended periods as shown in our owners manuals.

This will protect against gums and peroxides forming in the fuel system, including the carburetor, and may avoid a costly carburetor overhaul.

We now also have tabulated part numbers for the various length lines that are made from identical material except for the length.

Presently we have (3) different size tubings made from the new compound in the tabulated form as shown below.

1. # 70308 - Series - Rubber Tubing (.365/.385 O.D. X .208/.228 I.D.)

This line is identified with a continuous green stripe throughout the length of the line.

2. # 70309 - Series - Rubber Tubing (.105/.115 I.D. X .030/.040 wall)

Identified with continuous red stripe.

3. # 70310 - Series - Rubber Tubing (.198/.218 O.D. X .050/.060 wall)

Identified with a continuous white stripe.

The rubber tubing is now identified with continuous colored stripes only, each color identifies a particular size tubing. In the future, an interrupted stripe or some other pattern may be used to identify a particular source.

The 70309 and 70310 series tubing is available in 10' lengths and the # 70308 in 12' lengths.

We strongly recommend that SERVICE CENTERS and DEALERS order these longer lengths in each series so they can cut individual lines as required and avoid a large inventory of the individual lines. They can also make lines that are no longer supplied and accomplish immediate delivery of any line for better customer service.

Availability

#70310 - Series - Immediately - Now in Service Parts Stock

#70308 & 70309 - Series - Will not be available until May 1, 1976. Continue to order old part number. Will automatically ship new numbers when available.

For your convenience we will show the lengths of the various lines

<u>Part #</u>	<u>Part Name</u>	<u>Length</u>	<u>Remarks</u>
70308-21	Tubing, Rubber	5-1/4"	Supersedes #55680 when exhausted
70308-99	Tubing, Rubber (Green Stripe)	12 - Ft.	Supersedes #67904 when exhausted
70309-09	Tubing, Rubber	2-1/4"	Supersedes #68561 and 69372 when exhausted
" -22	" "	5-1/2"	Supersedes #69755 when exhausted
" 24	" "	6"	" #69345 " "
70309-99	Tubing, Rubber (Red Stripe)	10-Ft.	Supersedes #69657 when exhausted
70310-01	Tubing, Rubber	1/4"	Supersedes #68239-A when exhausted
70310-16	Tubing, Rubber	4"	" #12693-A " "
" 19	" "	4-3/4"	" #12165-A " "
" 22	" "	5-1/2"	" #12254-A " "
" 29	" "	7-1/4"	" #69344 " "
" 30	" "	7-1/2"	" #12994 " "
" 32	" "	8"	" #68562 " "
" 37	" "	9-1/4"	" #68155 " "
" 42	" "	10-1/2"	" #12973 and A-68053-A
" 48	" "	12"	" #70084 when exhausted
" 49	" "	12-1/4"	" #68442 " "
70310-99	Tubing, Rubber (White Stripe)	10-Ft.	Supersedes #12974 & 69656 when exhausted

The following parts if needed can be cut from 70308-99:

56326	4"
57763	4-3/4"
A-56379	7-3/4"
A-55801	8"
59644-1	8-1/2"
74919	9"
76178	9-3/4"
A-69358	3" can be cut from 70309-99

Please revise your parts list accordingly.

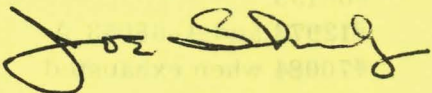
We strongly recommend that all "Districts, "Dealers" and "Service Centers" who have experienced "Fuel Line" deterioration problems with the XL, XL-2, or Super-2 chain saws, discontinue use of fuel line # 69344 immediately.

The #69344 lines can be either returned to the districts under warranty or be recut into lines # 70310-19 or # 70310-22 for use as oil lines or pulse lines where they will not come in contact with the "Stale gas".

Caution

Use only # 70310 series rubber tubing with the white stripe when servicing XL, XL-2 and Super -2 chain saws. This will assure you that you have used the very latest compound that will not degrade in stale fuel in improperly stored saws.

Although we have heard only occasional complaints on fuel line deterioration on other model saws, use only the above series "striped" lines for fuel lines on any saws which experienced deterioration.



Joe Shuhy, Service Manager
Forestry Equipment

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BRANCH SERVICE MEMO NO. 966

DEALER SERVICE MEMO NO. 654

Distribution:

TO: All Districts, Service Branches and Dealers

SUBJECT: Parts Availability Obsolete Units

DATE: 4/76

We have compiled, for your quick reference, a list of chain saws, pumps, generators and other miscellaneous units with the year they were last produced.

This list should be used in conjunction with General Marketing Bulletin #26-75G which lists all the parts used only in those units last produced through 1968.

Although a unit may fall into this category, it does not necessarily mean individual parts are not available, as they may be used in later units. Parts should be checked against the list of parts attached to Bulletin #26-75G before turning the customer away by telling him parts are no longer available.

Ane Parks

Ane Parks, Supervisor
Service Records

pgc

11/7/75

CHAIN SAWS - Year last built
(Does not include any units currently being produced.)

Model	Year	Model	Year
EZ	74	XL-913-FP	70
EZ-Automatic	71	XL-914	70
EZ-250-Automatic	71	XL-921	71
XL-Mini	73	XL-923-FP	71
XL-Mini-Auto	71	XL-923-RM	71
XL-Mini-Auto-FP	71	XL-924	71
Super-XL-Mini-FP	71	XL-924-W	72
XL-Automatic-E	65	VI-944	74
XL-Auto. Gear Drive	65	VI-944-C	73
Super-XL	68	XL-923	74
Super-XL-12	65	XP-1000	66
Super-XL-12-Auto	70	XP-1000-AO	65
XL-15	64	XP-1000-W	66
Super-XL-15	65	XP-1000-WAO	65
110 Electric	72	XP-1020	68
		XP-1020-W	66
XL-101	70	XP-1020-AO	68
XL-102	68	XP-1020-WAO	68
XL-102-Automatic	70	XP-1020-Automatic	68
XL-103	69	XP-1020-W-Automatic	68
XL-103-E	68	Super-XP-1020	68
XL-104	68	Super-XP-1020-W	67
XL-104-E	68	Super-XP-1020-Auto	68
XL-113	71	XP-1020-Automatic-E	68
XL-114	71	Super-XP-1020-W-Auto	67
XL-122	71	XP-1100	66
XL-122-E	69	XP-1100-1	66
VI-123	73	XP-1100-W	66
VI-123-2	73	XP-1100-W-1	66
XL-123	74	XP-1130	67
VI-125	73	XP-1130-1	68
XL-400-Automatic	72	XP-1130-W	67
XL-400-Auto-FP	72	XP-1130-W-1	67
XL-500-Automatic	66	Super-XP-1130-1-Auto	68
XL-660-Automatic	66	Super-XP-1130-2-Auto	70
XL-700	68	XP-1130-E	68
XL-800	66	Super-XP-1130-W-Auto	68
XL-800-AM	68	Super-XP-1130-W-1-Auto	67
XL-800-E	67	1130-G-Automatic	72
XL-850	68	1050-Automatic	72
XL-870	69	Super-1050-E	74
XL-870-CD	70	2000-Automatic	69
XL-875	68	2000-E-Automatic	68
XL-875-CD	69	2000-P-Automatic	68
XL-900-E	68	Super-2000-Automatic	69
XL-900-E-AM	68	2100 (auto)	70
XL-901	70	2100-S	72
XL-903	70	3100-G	72
XL-903-E	69		
XL-903-E-AM	69	Buz	60
XL-904	69	Buz-Mod	61
XL-913	70		

Model	Year	Model	Year
C-5	64	5-63	62
C-5-G	64	6-22	58
C-5-G-B	64	6-22-A	58
C-7	64	6-63	62
C-7-G	64	7-19	59
C-7-G-B	64	7-19-A	59
C-9	64	7-19-C	60
C-9-G	64	7-19-CA	60
C-9-G-B	64	7-19-TK	59
C-51	67	7-21	58
C-51-A-O	66	7-21-A	58
C-52	71	7-21-C	60
C-71	67	7-21-CA	60
C-91	66	7-21-C-FM	60
ECS	55	7-21-CA-FM	60
ECS-C	57	7-29	57
ECS-20	55	7-29-A	57
HCS	56	7-63	62
EZ	57	8-29	59
EZ-1	57	8-29-A	59
EZ-1 (x)	57	8-29-AS	59
EZ-6	58	9-23	60
EZ-6-A	58	9-26	60
WIZ	60	9-26-A	59
WIZ-MOD	61	9-26-A1	60
WIZ-MOD-B	65	26-LCS	54
Super Wiz	65	26-LCS-A	54
WIZ-55	68	500	61
Super-Wiz-55	74	500-MOD	62
Super-77	70	600-D	61
Super-77-1	69	600-D-1	61
Super-Wiz-80	74	600-D-Mod	62
ZIP	62	600-D-1-MOD	62
Zip-Modified	62	660-D	61
Zip-B	68	660-DA	61
Zip-5	60	700-D	60
Zip-5E	59	700-D-1	61
Zip-5EX	60	700-DA	60
Zip-6	61	700-DA-1	61
Zip-6-Modified	61	700-G	61
17	56	700-G-1	61
17-A	56	700-G1-LR	61
17-L	57	700-GA	61
17-LA	56	700-GA-1	61
4-20	61	700-GA1-LR	61
4-20-A	57	700-GFM	60
5-20	56	700-GA-FM	60
5-20-A	56	707-D	61
5-20-L	57	707-D-1	61
5-20-LA	57	707-D-A	61
5-30	54	707-DA-1	61
5-30-A	54	707-G	61
5-30-N-Revised	65	707-G-1	62
5-30-N-1	63	707-G-A	61
5-30-N-S	56	707-G-A-1	62

<u>Model</u>	<u>Year</u>	<u>Model</u>	<u>Year</u>
707-G-2	62		
707-G-A-2	62		
707-G-3	62		
707-G-A-3	62		
770-D-1	64		
770-D-A-1	64		
770-G	64		
770-G-1	64		
770-G-A	64		
770-G-A-1	64		
770-G-2	64		
770-G-A-2	64		
770-G-3	64		
770-G-A-3	64		
770-G-S-1	63		
770-G-S-A-1	63		
775-D-1	67		
775-D-A-1	67		
775-G-1	65		
775-G-A-1	65		
900-D	60		
900-G	60		
900-GA	60		
900G-AX	61		
900-GX	61		
909-D	62		
909-G	62		
909-G-1	62		
990-D	64		
990-G	64		
990-G-1	64		
995-D	65		
995-G	65		
995-G-1	65		

12/4/75

PUMP - Year last built

(Does not include units currently being produced)

Model	Year	Model	Year
5-P	54	123TP4-1	74
5-P-2	61	123TP4-5	72
8S3-1	65	250DP3-1	69
8S3-1P	62	250S2-1	70
8S3-1R	65	250TP2-1	70
8S3-1-RK	60	251S3-1	68
8S3-2	65	251S3-2	68
8S3-2R	65	251TP3-1	68
9S3-1	66	251TP3-2	68
9S3-1A	72	270DP3-1	73
9S3-2	66	270S2-1	73
9S3-2R	65	270S2-1P	70
9TP3-1	66	270TP2-1	73
20DP3-1	68	DP3-1	70
20DP3-2	64	DP3-1A	72
20S1-1/2-1	57	DP3-3	66
20S1-1/2-1A	68	ES1-1/2-1	68
20S1-1/2-1A-K	68	ES2-1	68
20S1-1/2-2A	64	ES3-1	68
20X-DP-3	68	ETP3-1	72
23S2-1	59	ETP3-2	71
24S3-1	58	LM20S1-1/2-1A	64
24S3-1P	58	LM23S2-1	59
35S2-1	68	LM23S2-1A	64
35S2-1R	68	LM23S2-5A	62
35S2-2	65	LM24S2-1A	64
36S2-1	59	LM24S3-1	59
37S3-1	58	LM24S3-1A	64
43S1-1/2-1	65	LM24S3-5A	62
43S1-1/2-LP	60	M23S2-4	61
44DP3-1	68	XLS1-1/2-1	64
44DP3-2	65	XLS1-1/2-1A	71
44DP3-LP	60	XLS1-1/2-3	71
44S2-1	65	XLS2-1	73
44S2-2	64		
44S2-LP	60		
45S3-1	65		
45S3-2	65		
45TP3-1	65		
45TP3-1A	68		
45TP3-2	65		
45TP3-2A	66		
110S1-1/2-1	73		
110SU1-1/2-1	72		
110SU1-1/2-1A	74		
110SU1-1/2-1F	70		
111SU1-1/2-1	71		
111SU1-1/2-1F	70		
111SU2-1	72		
112TP2-1	68		
113S3-1	68		
113S3-2	68		
117TP3-1	69		

Model	Year	Model	Year
41A115-9-LP	62	151A15-1A	72
41A115/230-1	66	152A25-1	72
41A115/230-1B	65	153A35-1	72
41A115/230-9	61	155A50-1	72
41A115/230-9-LP	61	250A18-1	70
41A115/230/50-1	61	251A35-1	67
41A115/230/50-1B	66	251A35-2	67
41A115/230/50-1BK	62	251D28-9	67
41A220/380/3/50-1	64	251HY35-1	67
41A220/380/3/50-1B	62	270A20-1	71
41HY-1	65	270A20-1A	72
41HY-1B	66	270A20-1B	72
41HY-1C	64	270A20-1C	74
42A115/230-1	62	AHY-1	62
42A115/230-1B	66	AHY-3	67
42A115/230-LP	60	A32A115/230-2	56
42A220/380/3/50-1	61	A115/1/60-1	58
42A220/380/3/50-1B	66	A115/1/60-7	64
46A115-1	61	A230/3/180-2	63
46A115-1B	66	HY50-1	72
46A115-9	62	M13A120D28-17	56
46A115-LP	61	XLA115-1	65
46A230-1	65	XLA115/1/400-1P	67
112A15-1	71	XLA220/50-1	65
113A25-1	71		
115HY40-1	67		
116A50-2	70		
116A50-2L	71		
118A35-1	68		
118A35-2	68		
119A35-1	71		
119A35-1L	71		
119A35-2	71		
119A35-2L	71		
119HY35-1	72		
119HY35-2	72		
119HY35-2A	73		
119HY35-2B	74		
128A10-1	72		
128A10-1A	73		
128A10-1B	74		
129A15-1	72		
129A15-1A	73		
129A220/50-1	73		
130A22-1	72		
130A22-1A	73		
130A22-1B	74		
131A30-1	72		
131A30-1A	73		
131A220/50-1	73		
132A220/50-1	73		
137A9/50-1	74		
138A17/50-1	74		
139A27/50-1	74		
151A15-1	72		

GENERATORS - YEAR last built
(Does not include any units currently being produced)

Model	Year	Model	Year
7D28-20	62	24D14-3	55
7D28-21	56	24D28-1	58
8A115-1	62	24D28-2	57
8A115-1A	65	24D28-3B	59
8A115-4	64	24D28-4	55
8A115/50-1	59	24D28-9	56
8A115/230-1	60	24D28-23A	55
8A115/230-1A	64	24D28-24A	55
8A115/230-50-1	61	24D60-1	57
8A115/230-50-1A	64	24D120-1	56
8A115/230-50-1K	59	24D120-2	56
8A220/380/3/50-1	63	24D120-7	56
8D28-3B	63	24D160-1	56
8D28-8A	61	24D230-1	58
8D28-9	67	24HY-1	57
8D28-10	67	24X-5	62
8D28-12	64	24X-6	60
8HY-1	62	24X-8	69
8HY-1A	65	32A115/230-1	59
9A34-1	72	32A115/230-3	57
9A115-1	66	32A115/230-9	59
9A115-1A	71	32A115/230/3/60	57
9A115/230-1	66	32A120/208-15	58
9A115/230-1A	71	32A120/208/3/60-1	57
9A220/380/3/50-1	68	32A120/208/3/400-15	60
9D28-9	68	32A120/208/3/400-17	58
9D28-10	68	32A220/380/3/50-1	59
9HY-1	66	32D28-23	54
9HY-1A	72	32D120-23	56
9HY-1B	73	32HY-1	58
10A35-1L	71	34D28-1	56
10A35-2L	71	34D28-4	59
10HY35-1L	71	34D28-5	70
15A115-1	57	34D28-9	68
15AD120-15-A	54	35A115-1	65
15AD120-16	57	35A115-1A	67
18A120D28-5	54	35A115-3	61
20A115-1	56	35A115/50-1	64
20A220/1/50-3	55	35A115/1/50-1	64
20.5A120/1/400-23	59	35A115/1/50-1K	64
20.5D28-23A	57	35A115/230-1	59
23A115-1	55	35A115/230-50-1	59
24A66.4/115/3/400-15	54	35A230/50-1	65
24A115-1	58	35A230/50-3	59
24A115-7	58	35A230/50-3A	61
24A115/208/3/400-15	57	35A230/50-3B	65
24A115/230	56	35A230/50-3C	64
24A115/230/50-1	57	35A230/50-4	67
24A120/1/400-23	55	35A230/50-4A	70
24A120/208/3/60-1	54	41A115-1	60
24A120/208/3/400-17	55	41A115-1B	66
24A380/220/3/50-1	57	41A115-9	62
24AD120-23-A	57	41A115-9B	66

MISCELLANEOUS UNITS

(Does not include any units currently being produced)

<u>Model</u>	<u>Year</u>	<u>Model</u>	<u>Year</u>
<u>BRUSH CUTTERS</u>		<u>YARD TRAC</u>	
17BC (GBC)	63	730-9S	69
GBC	63	M-26	59
GBC (DBC)	63	M-26-E	59
XLBC	65	M-26-60	61
XLBC-A	68	M-26-60-E	61
XLBC-B	71	M-26-60-L	61
		M-26-60-LE	61
<u>BLOWER</u>		YTLD	62
20B-1	66	YTL-E-MD	62
44B-1	67	YTL-E-MS	62
250B-1	67	YTL-ES	62
XL-MB	70	YTL-MD	62
XL-MB-1	67	YTLS	62
<u>MULTI PURPOSE SAW</u>		YTD-5	64
Chipper	73	YTD-6	66
EZ-10	72	YTD-7-S	67
XL-88	70	YTD-8-F	68
XL-98	72	YTD-8-L	68
		YTD-8-S	68
		YTD-26	63
<u>CIRCULAR SAW</u>		<u>MISCELLANEOUS</u>	
XL-100	68	DA-1	59
XL-100-A	72	EP-1	61
XL-100G-1	68	XL-Bogue	70
XL-100-G-1A	73	XLH-1	71
XL-100-SW	70	XLWE-1	72
XL-120	71		
<u>KART</u>			
KR-82	60		
KR-95	62		
KL-100	62		
<u>YARD TRAC</u>			
526-OL	69		
526-OS	69		
526-1	71		
526-1E	71		
526-9S	68		
730-OL	70		
730-OLE	70		
730-OS	70		
730-1	71		
730-1E	71		
730-9L	69		
730-9-LE	69		



BRANCH SERVICE MEMO NO. 967

DEALER SERVICE MEMO NO. 655

Distribution:

TO: All Districts, Branches, Construction & Industrial Equipment Dealers.

SUBJECT: 4 Cycle Engine Chart

DATE: April-76

Enclosed you will find 2 copies of a chart showing pertinent information regarding the 4 cycle engines used on Homelite Construction and Industrial Equipment. We have sent you 2 copies so that you can put one copy in your book and have the other copy in your service area. If you need additional copies, you can obtain them by ordering ST-2983.

Bill Borachok

Bill Borachok - Service Manager
Construction & Industrial Equipment

jp

Homelite Construction & Industrial Equipment

4 Cycle Engines

Briggs & Stratton

Homelite Product	Homelite P/N	H.P.	Model #	Type	Short Block	Crankshaft	Universal Engine
110SU1 1/2-1B	50782	2	60132	0313-04	295339	260103	80232 0036
111S1 1/2-1	50859	3	80232	0556-01	295343	260182	80232 0036
111S2-1	A43169	3	80232	0351-01	295343	260182	80232 0036
120S3-1	54848-2	7	170432	1141-01	None	260663	170432 1141
AP215-1	54965-A	3	80232	0621-01	295345	260111	80232 0035
AP220-1	54965-A	3	80232	0621-01	295345	260111	80232 0035
AP315-1	54965-A	3	80232	0621-01	295345	260111	80232 0035
AP320-1	54965-A	3	80232	0621-01	295345	260111	80232 0035
121TP2-1	A50498	5	130232	0337-01	299252S Note 1	260939	130232 0035 Note 1, 11
120TP3-1A	54848-2	7	170432	1141-01	None	260663	170432 1141
160TP4-1	A42562-A	16	326431	0181-01	None	261219	326431 0020 Note 9
111DP2-1	54965-A	3	80232	0621-01	295345	260111	80232 0035
111DP3-1	54965-A	3	80232	0621-01	295345	260111	80232 0035
115P2 1/2-1A	43700	9	233431	0264-01	None	260762	233431 0020 Note 1, 2A, 3, 4
170A15-1	A43085	4	100232	0437-01	299253S Note 1	260727	130232 0038
172A20-1	A42211	5	130232	0534-01	299253S Note 1	260942	130232 0038
174A27-1	42828	7	170432	1335-01	299774	260359	170432 1070 Note 12
176A35-1	53855	8	190432	0865-01	390634	261072	190432 0570 Note 12
178A50-1	A50964	10	243431	0631-01	None	260887	243431 0520 Note 2
180A75-1	42485	16	326431	0205-01	None	261245	326431 0020 Note 10
185HY35-1	A50964	10	243431	0631-01	None	260887	243431 0520 Note 2
PCA-20	51398	4	100232	0486	299251	260928	Order from Factory
111B-1	A43169	3	80232	0351-01	295343	260182	80232 0036

Lauson-Tecumseh

129A15-1B	53851	3 1/2	H35	45331-J	755072 Note 5	30541	None
130A22-1C	A42324	5	HS50	67070-A	754192 Note 6	34025	None
131A30-1B	53853	7	H70	130109-B	757113 Note 8	32670	756171 Note 7

Kohler

PCS30	A51366	4	K-91T	31919C	None	220711	31900 Note 13
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Note 1 Add 260860, 26826, 292259, 230127, 230126

Note 2 Remove 260895/291675 Add 260887/299539

Note 2A Reverse Engine Base

Note 3 Change Type # to 0264

Note 4 Remove 291665/260761 Add 291710/260762

Note 5 Add 80022/30541

Note 6 Remove 33676/307568 Add 34025/32700A

Note 7 Remove 32880/31451A Add 32670/31577B

Note 8 Add 80116/32670

Note 9 Remove 261218/391062/ (2) 92645 Add 261219/291710 (2) 93583

Note 10 Remove 261218/299609/211981/222359 Add 261245/291675/2111889/221953

Note 11 Transfer Control Rod Group, Strap & Grommet Assy. or add 299545 & 390341

Note 12 Transfer Fuel Tank or add 291488

Note 13 Transfer Fuel Tank from original engine or order and install kit # 221277

Change Gov. speed to 3650 R.P.M.—Transfer base or add 391165.

Change Gov. speed to 3750 R.P.M.—Transfer base or add 391165.



Distribution:

TO: All Districts, Service Branches and Lawn & Garden Dealers

SUBJECT: RE8E, 3 Speed - Incorrect Wiring of Charging System

DATE: 4/76

Make the following test to determine if unit is incorrectly wired:

1. Disconnect alternator wire at engine.
2. First disconnect (-) negative battery lead and then (+) positive battery lead from battery.
3. Check for continuity between alternator wire that you disconnected from engine and (+) positive battery lead that you disconnected from battery.
 - (a) If you have continuity the charging system is wired correctly. Re-connect wires and test is completed.
 - (b) If you DO NOT have continuity continue to Step #4.
4. Remove mower pan from unit.
5. Stand unit on end with rear wheels toward floor.
6. Remove small wire from the large terminal on the top of starting solenoid. This is the terminal that also has a large wire going to the starter motor. Connect the small wire to the large terminal on the bottom of solenoid. This is the terminal that also has a large wire going to the battery. Be sure to tighten nuts on large terminals on solenoid. Repeat Step #3. A warranty claim may be submitted if you have to change the wire in Step #6-- .5 of an hour will be allowed for the repair.

Billy Butler
Billy Butler
Field Service Representative

pgc



BRANCH SERVICE MEMO NO. 969

DEALER SERVICE MEMO NO. 657

Distribution:

TO: All District, Branches and Chain Saw Dealers

SUBJECT: Part #24982 "Torx" Driver (#25 Recess)

DATE: 4/76

Dealer Service Memo #650 dated January 1976 advised you that part #24982 Driver was required to drive the new "Torx" bearing retaining screw Part #70306. We have been advised that some of the first drivers that Service Parts shipped out were oversized and will not fit the #70306 screw.

IDENTIFICATION:

The Manufacturer's number is stamped on the body of the driver. The oversized driver is 440TX30. The TX30 indicates it is used on a #30 Torx recess.

The correct number is 440TX25 or 480TX25. 440 has a 1/4" hex. body--480 has a 5/16" hex. body.

After inspecting your stock please return the oversized drivers to your District Office for credit and reorder.

Joe Shuhy, Service Manager
Forestry Equipment

pgc



BRANCH SERVICE MEMO NO. 971

DEALER SERVICE MEMO NO. 659

Distribution:

TO: All Districts, Branches & Chain Saw Dealers

SUBJECT: Ground Terminal #68591-A

DATE: 5/76

Usage: 150 AO Series Chain Saws

A new ground terminal #68591-A supersedes #68591. This new terminal will stop point box distortion and rapid point gap closing.

Saws built after S/N 40015907 - Lot #5280 (October 6, 1975) have this new type terminal.

We would appreciate hearing from you immediately about any units after this S/N that are found with points closed.

Saws found with closed points that were built prior to this change should have the new terminal installed to avoid further close in.

The new terminal exerts an upward force rather than the sideways force that was closing in the point gap. This was the cause of the premature closing and the many justifiable complaints you have submitted.

Care must be exercised not to distort the contact during assembly that could cause a loss of tension and continuity. A 7/32" open end wrench should be used to adjust the point gap. This wrench could be ground down to provide additional clearance for convenience.

The terminals are chemically cleaned for good continuity; however, if the contact does not have good continuity it can be sanded with a small piece of emery cloth.

Please revise your parts lists accordingly.

Joe Shuhy
Service Manager-Forestry Equipment

sal

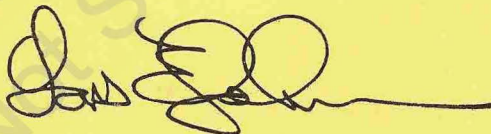
Distribution:**TO:** All Districts, Branches, Service Branches and Dealers**SUBJECT:** Shipping of Units**DATE:** 5/76

We have recently received a chain saw from the field with full tanks of gas and chain oil.

This memo is to remind you that the shipping of flammables and specifically gasoline through common carriers or the mail is a direct violation to the shipping codes.

It is especially important that no Homelite field location, its dealers or customers ship any product containing fuel or oil in its tanks. All units must be drained prior to packaging for shipping.

We would appreciate your advising your people of this notice so that Homelite and its associated dealers are not involved in this dangerous practice.



Lars Johnson
National Service Manager

sal

Distribution:**TO:** All Districts, Branches and Chain Saw Dealers**SUBJECT:** Driven Gear and Hub # A-56824-A
Sprocket Shaft # 56070-A
Screw # 82289**DATE:** 6/76**Usage:** Super Wiz - 55 - 66 & 80 Chain Saws
Ref: Branch Service Memo # 910CS - DSM # 598

Units built after S/N 51120040 were produced using the new method to assemble the sprocket shaft to the gear and hub using steel plug nuts. This change was made to make the assembly more reliable and prevent loosening in operation.

We have since heard from dealers and districts on some failures occurring after very short operation. We found we assembled some units with low improper torque and plug nuts that were not chamfered properly. This caused the thread termination of the screw to bind in the plug nut before achieving clamping force. Suspect saws are prior to S/N 26100651 - Lot # 6126 of the new numbering system.

When servicing the subject hub and sprocket shaft assembly adhere to the following procedure for best results.

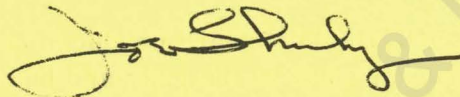
- 1.) Check to see that plug nuts have a 1/32" min. chamfer at 1/4 - 20 thread, on side closest to head of sprocket shaft.
- 2.) Clean parts thoroughly.
- 3.) Apply loctite on sprocket shaft dia. that assembles into hub.
- 4.) Apply loctite to (4) 1/4 - 20 screw threads.
- 5.) Torque (4) screws to 150" lbs.
- 6.) Stake (4) screws so they cannot rotate in sprocket shaft.
- 7.) Remove excess loctite by wiping clean.
- 8.) Cure for 24 hours or use heat lamp for fast cure.

(2)

Saws built after S/N 26100651 Lot # 6126 have been loctited and torqued properly and should not fail in operation.

We would appreciate hearing from you immediately on any failures above this serial number.

Production assemblies will not be staked since the loctite used (Retaining Compound - green) is much stronger than what is available in the field.



Joe Shuhy
Service Manager
Forestry Equipment

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



BRANCH SERVICE MEMO NO. 974

DEALER SERVICE MEMO NO. 662

Distribution:

TO: All Districts, Branches and Chain Saw Dealers

SUBJECT: .404 Pitch- Chain Repair Kit
Part No. #40C63-7
K3-92007-6A

DATE: 6/76

Recent complaints from the field indicate that the above repair kit has some incorrect parts in the package. The drive link is .404 but the preset tie strap and tie strap are for 3/8 chain.

Identification

The repair kit in question is marked with the Part No. #40C63-7 and a computer No. #K3-92007-6A.

The .404 chain requires a larger diameter rivet than the 3/8 chain. Therefore, if the preset tie strap is sloppy in the drive link rivet hole they should not be used.

Return Material

Inspect your stock and return your defective repair kits to your District Office for credit.

The correct material is available from stock.

A handwritten signature in black ink, appearing to read "Joe Shuhy".

Joe Shuhy
Service Manager - Forestry Equipment

sal

Distribution:**TO:** All District, Service Branches and Lawn and Garden Dealers**SUBJECT:** Wrong Part Number**DATE:** 6/76

Reference T-16H Operator's Manual form 1651656, page 27,
reference #24, SHOULD READ 154269 seal.

Make note of this correction and order as needed by part
number and description.

Billy Butler
Billy Butler

Field Service Representative

pgc

Distribution:**TO:** All District, Service Branches and Lawn and Garden Dealers**SUBJECT:** Wrong Part Number**DATE:** 6/76

Reference RE-8E, three speed Operator's Manual form 1654678, page 29, reference #58,
SHOULD READ 157679 Bearing, roller.

Make note of this correction and order as needed by part number and description.

Billy Butler

Billy Butler

Field Service Representative

pgc

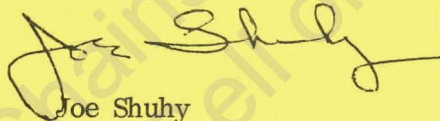
Distribution:**TO:** All Districts, Branches, Service Branches and Dealers**SUBJECT:** High Lift Plunger # A-70304**DATE:** 9/76**USAGE:** 350 AO Oil Pump

Oil pump plunger # A-70304 with an increased stroke is available through Service Parts.

It should only be used in applications that require additional chain oil since the standard plunger supplies enough for all normal cutting.

The customer must be informed that with the increased output, the unit will run out of chain oil before it runs out of fuel. The oil tank must be refilled when empty to avoid damage that may result from a dry pump.

Please mark your parts lists accordingly.



Joe Shuhy
Service Manager -
Forestry Equipment

Distribution:**TO:** All Districts, Branches, Service Branches and Dealers**SUBJECT:** Rotor # 65061 (R. E. Phelon)**DATE:** 9/76**USAGE:** EZ Series

We have received reports that some subject rotors were shipped to the field that were not fully machined. These rotors were machined on the O. D. & insert only and not on the underside which is required to clear the stator box.

The known codes on the defective boxes are 5K03 - 5D10 and 570, however, others may be involved.

Would you please inspect your stock immediately and return all rotors that are not machined on the underside.

Return your defective parts to your district office for credit.

The correct material is available from stock.



Joe Shuhy
Service Manager-
Forestry Equipment

Distribution:**TO:** All Districts, Branches, Service Branches and Dealers**SUBJECT:** Wrong Reference Numbers**DATE:** 9/76

Reference Homelite S-4 Snow Thrower illustrated parts list # 24596-4, page 4.

Reference # 30 in illustrated parts drawing should be # 24.

Reference # 24 in illustrated parts drawing should be # 30.

Make note of this correction and order parts as needed by part number and description.

Billy Butler
Billy Butler
Field Service Representative

courtesy of under 7059
Do Not Sell or Reproduce

Distribution:**TO:** All Districts, Branches, Service Branches and Dealers**SUBJECT:** New Special Tools**DATE:** 9-76

The following tools are now available to help in servicing the new construction equipment:

Submersible Pumps
(SP150-1, SP200-1, SP200-2, SP300-1)

A43293 Impeller Removal Wrench

A43294 Cap & Shell Removal Tool

Vibrators (VCH178-1, VCH250-1)

A24981 Eccentric & Stator Puller

Instructions for use are supplied with the tool.

Bill Borachok

Bill Borachok

Service Manager

Construction & Industrial Equipment

Distribution:**TO:** All Districts, Branches, Service Branches and Dealers**SUBJECT:** Submersible Pumps**DATE:** 9-76

Some prior information relative to voltage conversion kit and level control kit part numbers has caused confusion in the field. The following chart will clear up that confusion.

<u>Model</u>	<u>Voltage Desired</u>		<u>Level Control Kit</u>
SP 150-1	115 volt	Factory Wired	A-43005-A
	230 volt	A-43238 Kit Required	A-43279-A
SP 200-1	115 volt	A-43237 Kit Required	A-43005-A
	230 volt	Factory Wired	A-43279-A
SP 200-2	115 volt	Factory Wired	A-43005-A
	230 volt	A-43339 Kit Required	A-43279-A
SP 300-1	230 volt	Factory Wired	A-43279-A



Bill Borachok
Service Manager -
Construction & Industrial Equipment

Distribution:**TO:** All Districts, Branches, Service Branches and Dealers**SUBJECT:** Flexible Shaft Vibrators**DATE:** 9-76

Some continuing questions keep arising regarding the flexible shaft vibrators which we will answer here:

1.) Can two or more shafts be connected?

ans: Two or more VS-60 shafts can be connected together by using the 43500 connector.

The following maximum lengths should be adhered to in order to get satisfactory performance and life.

VFS 300-1	with VH 1 3/8, VH 1 11/16, VH 2 1/8 Head	35'
VFS 200-1	with VH 1 3/8, VH 1 11/16 Head	28'
VFS 200-1	with VH 2 1/8 Head	21'
VFS 100-1	with VH 1 3/8, VH 1 11/16	21'

The VS 50 shafts cannot be coupled together and the maximum length is 10'.

2.) Can I use the Homelite shafts and heads with Dart motor?

ans: You can use the VS 60 shafts with Dart motors by using 43668 adapter. We do not have an adapter for using the VS 50 shafts on Dart motors.

3.) Can I use the Homelite motors with Dart shafts and heads?

ans: You can use the VFS 200 & VFS 300 motors with Dart Blue-line shafts by using a 43669 adapter.

4.) Is a carrying strap available for the Homelite vibrators?

ans: Yes. P/N 43624.

Bill Borachok

Bill Borachok

Service Manager-

Construction & Industrial Equipment

Distribution:**TO:** All Districts, Branches, Service Branches and Dealers**SUBJECT:** Universal Guide Bars**DATE:** 9-76

In order to reduce the numbers of bars required to service all of our chain saws, Homelite has introduced a universal guide bar for standardization.

Due to the necessity of depleting existing inventories, the phasing in of the bars will not be complete until approx. October of this year. To take the burden of cross referencing from your shoulders during the transition period and supply you with a complete accurate reference for the future, an "Order Reference" (Exhibit 1) is attached.

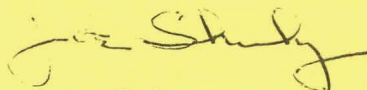
This "Order Reference" list of all chain saws currently sold and delineates the new bars, shims, "S" clip (if required) and associated loops of chain.

Please also note that if old type bars are used on the following models, the old shims also must be used for proper chain clearance and to seal the oil at the bar pad properly. 150 - AO, SEZ AO, 350 Series, 360 Series.

In working off inventories of the old bars, be sure you have sufficient stock of the old shims for the above models. The new shims for the other models shown on the attached reference sheet are compatible with the old bars.

To help facilitate depletion of inventories of "old bars" (Exhibit 2) is attached. This gives you a complete list of bars that will be dropped from the system. Two other charts (Exhibits 3 & 4) explain Homelite's bar and chain numbering system & sprocket nose repair kits required.

We would also bring your special attention to the new "D" letter designation incorporated in most of the new part numbers. This signifies that the bar can accommodate Homelite's exclusive "Safe-T-Tip".



Joe Shuhy
Service Manager
Forestry Equipment

* ORDER REFERENCE *

<u>Model</u>	<u>Approx. Bar Cutting Length</u>	<u>Guide Bar</u>	<u>Shim (s)</u>	<u>"S" Clip (If Required)</u>	<u>Chain</u>
<u>CONSUMER</u>					
XL (10")	10"	HT10001-D4	69360		375-N50-42
XL (12")	12"	HT12001-D4	69360		375-N50-48
XL2 37 LPC/XL2-CC	12"	(1) PT12371-D4	69360		375-C50-48
Super 2/VI Super 2	14"	(1) PT14371-D4	69360		375-C50-53
150 AO	16"	PT16381-D5	70397 & 70398	(2) 69966	375-C50-59
SEZAO	16"	(3) PT16381-D3	67300-A & 67299-A		375-C50-59
XL-12/SXLAO	16"	PT16381-D5	70399 & 70400	(5)	(4) 38-C50-59
	16"	GW16001-D5	70399 & 70400		(4) 38-C50-59
	20"	PT20381-D5	70399 & 70400		38-C50-70
	20"	GW20001-D5	70399 & 70400		38-C50-70
	20"	SP20381-A5	70399 & 70400		38-C50-70
	24"	PT24381-D5	70399 & 70400		38-C50-81
	24"	GW24001-D5	70399 & 70400		38-C50-81
	24"	SP24381-A5	70399 & 70400		38-C50-81

- (1) PT12371-D4 and PT14371-D4 will accept the new Homelite Safe-T-Tip and both the 37 and 375 series saw chain. In order to use 375 chain, sprocket and drum A-70221-A must also be used. Previous bars PT12371-B4 and PT14371-A4 will only accept the 37 series saw chain.
- (2) Old shims not compatible - shims and "S" clip available in Kit A-70688
- (3) Will eventually be changed to PT16381-D5 (will then require shims # 70397 & 70398 and "S" clip #69966 or Kit #A-70688.
- (4) If it is necessary to use Omark saw chain we recommend using a 60 drive link count.
- (5) Kit # A-70618 available for changeover, includes shims # 70399 & 70400.
- NOTE: Sprocket & Drum # A-70221 will only accept 37- series chain.

<u>Model</u>	<u>Approx. Bar Cutting Length</u>	<u>Guide Bar</u>	<u>Shim (s)</u>	<u>"S" Clip (If Required)</u>	<u>Chain</u>
<u>PROFESSIONAL</u>					
350, 360	16"	PT16381-D5	70397 & 70398 (2)	69966 (4)	38-C50-59
	16"	GW16001-D5	70397 & 70398 (2)	69966 (4)	38-C50-59
	20"	PT20381-D5	70397 & 70398 (2)	69966	38-C50-70
	20"	GW20001-D5	70397 & 70398 (2)	69966	38-C50-70
	20"	SP20381-A5	70397 & 70398 (2)	69966	38-C50-70
	24"	GW24001-D5	70397 & 70398 (2)	69966	38-C50-81
	24"	SP24381-A5	70397 & 70398 (2)	69966	38-C50-81
SXL-925, VI955, 450	15"	GW16001-D5	70399 & 70400		38-C50-59
	15"	PT16381-D5	70399 & 70400		38-C50-59
	19"	GW20001-D5	70399 & 70400		38-C50-70
	19"	PT20381-D5	70399 & 70400		38-C50-70
	19"	SP20381-A5	70399 & 70400		38-C50-70
	23"	GW24001-D5	70399 & 70400		38-C50-81
	23"	PT24381-D5	70399 & 70400		38-C50-81
	23"	SP24381-A5	70399 & 70400		38-C50-81
	29"	GW30001-D5	70399 & 70400		38-C50-98
	29"	SP30381-A5	70399 & 70400		38-C50-98
	31"	SP31403-A2	70399 & 70400		40-C63-94
	36"	SP36403-A2	70399 & 70400		40-C63-107
S1050 AO, Super 2100	23"	GW23003-A1	67669-A & 67670-A		40-C63-71
	27"	GW27003-A1	67669-A & 67670-A		40-C63-82
	32"	GW32003-A1	67669-A & 67670-A		40-C63-94
	37"	GW37003-A1	67669-A & 67670-A		40-C63-107
	43"	GW43003-A1	67669-A & 67670-A		40-C63-123
650, Super 650	19"	GW20003-D2	70399 & 70400		40-C63-64
	23"	GW24003-D2	70399 & 70400		40-C63-74
	29"	GW30003-D2	70399 & 70400		40-C63-89
	31"	SP31403-A2	70399 & 70400		40-C63-94
	36"	SP36403-A2	70399 & 70400		40-C63-107
	43"	SP43403-A2	70399 & 70400		40-C63-123

NOTE: 450 15" requires 38-C50-60 saw chain

EXHIBIT #1
Continued

(3.)

<u>Model</u>	<u>Approx. Bar Cutting Length</u>	<u>Guide Bar</u>	<u>Shim (s)</u>	<u>"S" Clip (If Required)</u>	<u>Chain</u>
PROFESSIONAL Continued					
S1130G	19"	GW19003-A1	56956-A & 56957-B		50-C63-51
Super Wiz 66	23"	GW23003-A1	56956-A & 56957-B		50-C63-58
Super Wiz 80	27"	GW27003-A1	56956-A & 56957-B		50-C63-67
	32"	GW32003-A1	56956-A & 56957-B		50-C63-77
	37"	GW37003-A1	56956-A & 56957-B		50-C63-87
	43"	GW43003-A1	56956-A & 56957-B		50-C63-100
	50"	GW50003-A1	56956-A & 56957-B		50-C63-113
	60"	GW60003-A1	56956-A & 56957-B		50-C63-134
C-72	14"	PT16381-D5	56871-B & 56872-C		38-C50-59
	14"	GW16001-D5	56871-B & 56872-C		38-C50-59
	18"	PT20381-D5	56871-B & 56872-C		38-C50-70
	18"	GW20001-D5	56871-B & 56872-C		38-C50-70
	18"	SP20381-A5	56871-B & 56872-C		38-C50-70
	22"	PT24381-D5	56871-B & 56872-C		38-C50-81
	22"	GW24001-D5	56871-B & 56872-C		38-C50-81
	22"	SP24381-A5	56871-B & 56872-C		38-C50-81
	28"	GW30001-D5	56871-B & 56872-C		38-C50-98
	28"	SP30381-A5	56871-B & 56872-C		38-C50-98

PT Guide Bar Repair Kits & Parts

<u>Bar #</u>	<u>Chain Series</u>	<u>Repair Kit #</u>	<u>Rivet # - Quan. - Size</u>			<u>Bear, Roll # - Quan.</u>	
PT-12504-50	25	A-69682-A	69875	(4)	(.161)	70737	(21)
PT-12251-D4	"	" "	" "	"	"	"	"
PT-12371-A4 & B4	37	A-70239-A or B	69875	(4)	(.161)	68326	(21)
PT-12371-C4 & D4	37 & 375	A-70239-B	69875	"	"	70737	(21)
PT-14371-A4-C4 & D4	"	"	"	"	"	"	"
PT-14165-50	38	A-69496	69486	(4)	(.125)	70737	(28)
PT-16503-50	"	"	"	"	"	"	"
PT-18205-50	"	"	"	"	"	"	"
PT-22245-50	"	"	"	"	"	"	"
PT-16381-B2-A5-D5	"	"	"	"	"	"	"
PT-20381-A5-D5	"	"	"	"	"	"	"
PT-24381-A5-D5	"	"	"	"	"	"	"

* EVOLUTION OF BARS *

	<u>New Bar</u>	<u>1</u>	<u>2</u>	<u>3</u>
1	HT10001-D4	HT10001-A4		
2	HT12001-D4	HT12001-A4		
3	PT12251-D4	PT12504-50	GW12504-50	
4	PT12371-D4	PT12371-C4	PT12371-B4	
5	PT14371-D4	PT14371-C4	PT14371-A4	
6	PT16381-D5	PT16381-A5	PT16381-B2	PT14165-50
	PT16381-D5	PT16381-D3*	PT16381-B3	PT16503-50
7	GW16001-D5	GW16001-A5	GW1416-50	
	GW16001-D5	GW16503		
8	GW19003-A1	GW1719-A		
9	PT20381-D5	PT20381-A5	PT18205-50	
	PT20381-D5	PT20503-50		
10	GW20001-D5	GW20001-A5	GW1820-50	
	GW20001-D5	GW20503		
11	GW20003-D2	GW20003-A5	GW1820-63	
12	SP20381-A5	SP19381-A2		
13	GW23003-A1	GW2123-A		
14	PT24381-D5	PT24381-A5	PT22245-50	
15	GW24001-D5	GW24001-A5	GW2224-50	
	GW24001-D5	GW24503		
16	GW24003-D2	GW24003-A5	GW2224-63	
17	SP24381-A5	SP23381-A2		
	SP24381-A5	SP24381-A3		
18	GW27003-A1	GW2528-A		
19	GW30001-D5	GW30001-A5	GW2830-50	
20	GW30003-D2	GW30003-A5	GW2830-63	
21	SP30381-A5	SP29381-A2		
	SP30381-A5	SP28381-A3		
22	SP31403-A2	N/C		
23	GW32003-A1	GW3033-A		
24	SP36403-A2	N/C		
25	GW37003-A1	GW3638-2		
26	GW43003-A1	GW4244-2		
27	SP43403-A2	N/C		
28	GW50003-A1	GW5063-2		
29	GW60003-A1	GW6063-2		

Please note that New Bars replaced bars in Column 1, Column 1 bars replaced in Column 2, etc.

* Temporarily being used on the Super EZ.

* B A R *

Typical Homelite designation of a guide bar and the significance of various digits.

PT-14371-D4

<u>PT</u>	<u>14</u>	<u>37</u>	<u>1</u>	-	<u>D</u>	<u>4</u>
1	2	3	4		5	6

- | | | |
|---|---|--|
| <p>1 Type of Bar:</p> <p>HT - Laminated with induction hardened nose.</p> <p>PT - Laminated with sprocket nose</p> <p>GW - Solid with gas welded hard tip nose</p> <p>SP - Solid with sprocket nose</p> | <p>2 Approximate cutting length of bar in inches</p> | <p>3 Pitch:</p> <p>00 None</p> <p>25 1/4"</p> <p>32 .325"</p> <p>37 3/8"</p> <p>38 3/8"</p> <p>40 .404"</p> <p>50 1/2"</p> |
| <p>4 Gauge</p> <p>1 .050"</p> <p>2 .058"</p> <p>3 .063"</p> | <p>5 Revision letter which signifies a change, e.g., "D" means that the bar can accommodate Homelite's exclusive "Safe-T-Tip"</p> | <p>6 Guide Bar Pad Configuration</p> <p>1 - S1050, S2100, S1130G, Wiz's</p> <p>2 - XL-12, SXLAO, 900's, 450's, 650's, C-72</p> <p>3 - 150, SEZAO, 350, 360</p> <p>4 - XL's, XL2's, Super 2, VI Super 2's</p> <p>5 - Denotes universal guide bar which can replace any of the bars with 2 or 3 configurations</p> |

Using the example at the top of the page we can readily determine that the bar is laminated with a sprocket nose, has an approximate cutting length of 14", 3/8" pitch, .050" gauge, can accommodate Homelite's revolutionary "Safe-T-Tip", and can be used on any of the XL family saws.

* C H A I N *

Typical Homelite designation of chain and the significance of the various digits.

375-C50-53

375 - C 50 - 53
 1 2 3 4

1 Pitch	2 Cutter Style or Distinguishing Feature	3 Gauge
25 - 1/4"	C Chipper	50 - .050"
32 - .325"	M Micro Chisel	58 - .058"
37 - 3/8"	L Super Chisel (Square File)	63 - .063"
375 - 3/8" Pro-Cut	AL Super Chisel (Round File)	
38 - 3/8"	N Non Chrome	
40 - .404"	P Drive Link Safety	
50 - 1/2"	S Tie Strap Safety	
	4 Identifies Repair Kits, Drive Link Count (Loops), Reel Footage	
	- 7 Repair Kit	
	- 26 thru 200 Loop drive link count	
	- R25 25' Reel	
	- R50 50' Reel	
	- R100 100' Reel	

Using the example at the top of the page, we can easily determine that the chain is Homelite's new superior Pro-Cut which is 3/8" pitch, cutter style is chipper, gauge is .050" and it is a loop of chain with 53 drive links.

SP-Sprocket Nose Bar Replacement Parts

COMPLETE SPROCKET NOSE ASSEMBLY

<u>Assembly Part #s</u>	<u>Sprocket Nose Pitch</u>	<u>Groove Gauge</u>
A69921	3/8"	.050 to .063
A69922	.404	.050 to .063

SPROCKET AND BEARING REPLACEMENT ASSEMBLY

<u>Assembly Part #s</u>	<u>Sprocket Nose Pitch</u>	<u>Groove Gauge</u>
A69942	3/8"	.050 to .063
A69943	.404	.050 to .063

Distribution:**TO:** All Districts, Branches, Service Branches and Dealers**SUBJECT:** Replacement Engines for 119 Generators**DATE:** 9-76

Briggs and Stratton has cancelled production of the 8 HP cast iron engine. In order to service the 119 generators in the field we have the following options:

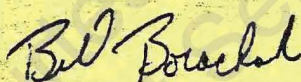
119A35-1, -2, -1L, -2L

Use Briggs and Stratton
8 HP Model 190432 type 0570 cool bore
10 HP Model 251412 type 0070 cool bore

119HY35-1, -2, -2A, -2B

Use Briggs and Stratton
8HP Model 190432 type 0570 cool bore
10 HP Model 251412 type 0070 cool bore
Homelite P/N 43163, 9HP Model 233431 type 024-01 cast iron*

* The 43163 cast iron engine requires kit A42614 because the flange diameter and bolt circles are different from the original engine.



Bill Borachok
Service Manager
Industrial & Construction Equipment

Distribution:**TO:** All Districts, Branches, Service Branches and Dealers**SUBJECT:** 120TP3-1A and Base Bending
120TP3-1A and 9TP3-1B Failure to Reprime**DATE:** 9-76120TP3-1A Base Bending

42121-1A engine support base for the 120TP3-1A supersedes 42121-1 engine support base. The new base has been strengthened to prevent the bending we have experienced with the old one.

120TP3-1A and 9TP3-1B Failure to Reprime

A new end housing A43404 is available for the 120TP3-1A and 9TP3-1B. The new end housing incorporates a flapper valve in the inlet to prevent the water from siphoning out of the housing when the pump is shut down.

A43404 consists of the following parts:

1	51457-2A	Housing End
1	54289-1	Nipple
1	62657-3	Fitting Suction
1	62667	Valve
2	80272	Screw, Hex Hd. (1/2-13 x 1 1/4")
2	80032	Screw, Brass (10-32 x 1/2)
1	62669	Plate, Valve
1	62668	Plate, Valve
2	81111	Nut (10-32)
2	83020	Washer, Lock

The new end housing will be installed on all 120TP3-1A and 9TP3-1B pumps beginning with September 1976 production. Mark your parts lists for these pumps to reflect the change.

These new parts should be installed at no charge on any customer's equipment experiencing either of these problems.

We will accept warranty claims for the part plus .25 hours labor charge.

Your cooperation in satisfying our customers is appreciated.



Bill Borachok
Service Manager
Industrial & Construction Equipment

Distribution:

TO: All Districts, Branches, Service Branches and Dealers

SUBJECT: Corrosion - Transformer Conical Spring
Units Affected: 350, 360, 450, 650 and Super 650.

DATE: 11-76

Corrosion of the transformer conical spring can be prevented by use of silicone dielectric compound P/N 22636.

Apply sufficient amount to cover the conical spring.

Thomas W. Stever

Thomas W. Stever
Manager - Technical Services

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

Distribution:**TO:** All Districts, Branches, Service Branches and Dealers**SUBJECT:** Replacement Muffler**DATE:** 11-76

Units Affected: 650 - 650E

A failed or broken muffler on the above units should be replaced with the Super 650 muffler A-12739-1B.

It will be necessary to tap the muffler to cylinder mounting holes to accept the 1/4 - 20 socket head cap screw 82316 used on the Super 650 to retain the muffler to the cylinder.

Use a number 7 (5,1 mm) drill to enlarge the presently tapped 10-24 holes in the cylinder, then tap 1/4 - 20.

Use caution so as not to drill or tap too deep. The present depth of the hole is .785.

Torque the 1/4 - 20 socket head cap screw to 90 in lb. (6,3 kg 1 cm) .Retorque after initial run.

Thomas W. Stever

Thomas W. Stever
Manager - Technical Services

Distribution:

TO: All Districts, Branches, Service Branches and Dealers

SUBJECT: Starter Pawl Kit # A-70285-A

DATE: 11-76

Usage: XL, XL-2 & Super 2 series chain saws.

IMPORTANT: Please read carefully.

Subject kit # A-70285-A supersedes A-70285 and is now available in Gastonia Service Parts stock.

The new kit is identical to the old except it includes a new instruction sheet # 24978-A, revising the drilled hole size.

The new instruction sheet changes the drilled hole size from .204 dia. to .228 dia. (# 1 drill) in order to avoid cracking of the boss due to improper press fit.

All kits # A-70285 now in Service Parts stock will be reworked into a A-70285-A.

All kits # A-70285 in the field or dealer stock may be used, providing the holes are drilled according to this memo and the new instruction sheet # 24978-A, to the .228 diameter hole size.

A caution note is included in the Instruction sheets # 24978 & 24978-A that states any particular rotor may only be repaired one time with the kit & the oversize pins.

When a rotor has been repaired in the field with the subject kit, we recommend it be identified with a color code or stamped marking so it is not reworked a second time.

Also it should be obvious since the reworked rotors would no longer provide a satisfactory press fit and the oversize pins would be loose.

Do not attempt to use rotors with loose pins. Any rotor that is questionable should be replaced with a new rotor since it is a rotating part and would be dangerous.

Joe Shuhy

Service Manager - Forestry Equipment.



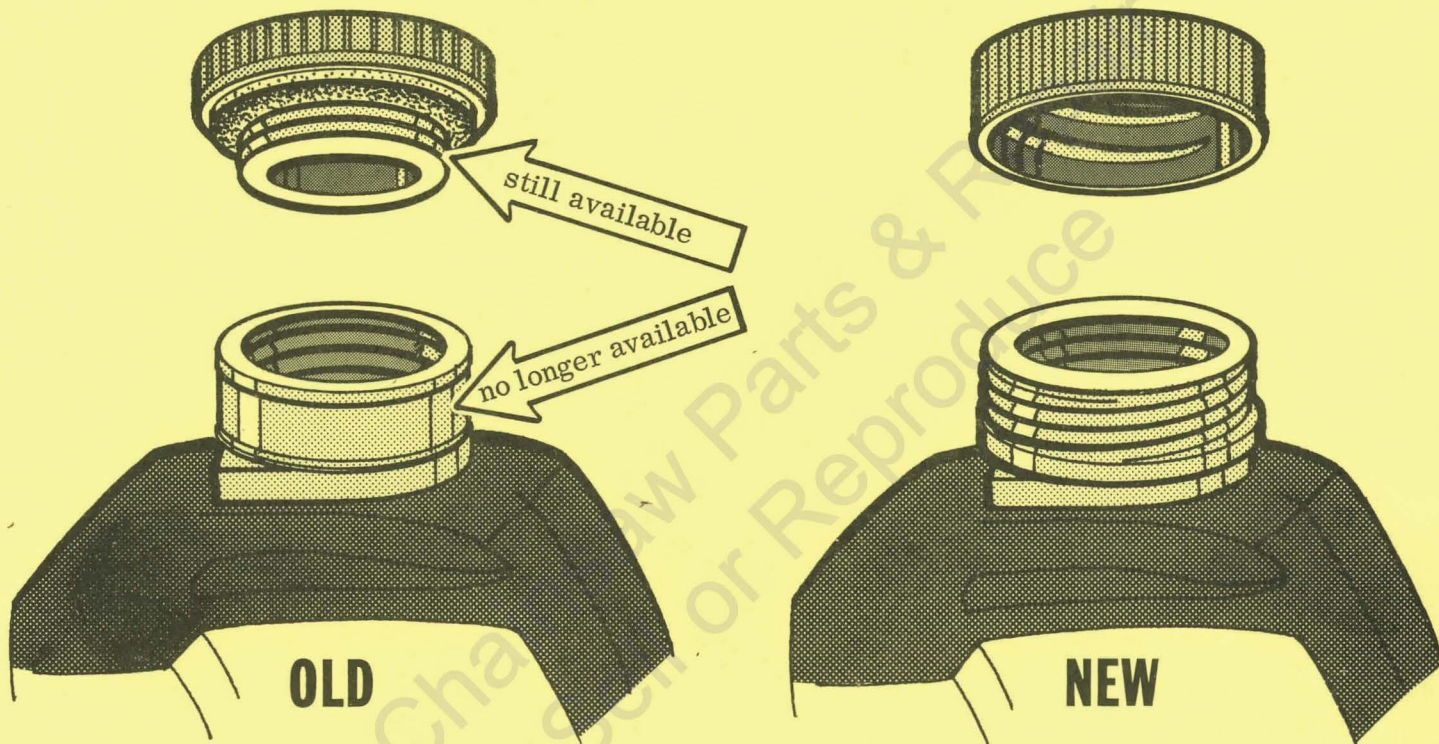
Distribution:

TO: All District, Service, Branch and Parts Managers

SUBJECT: New Threads for Oil Tanks and Fuel Tanks.

DATE: Nov. 1976

We have changed from tanks with internal threads to tanks with external threads.



Old Caps (still available)
Oil Cap (black) A 70446
Fuel Cap (red) A 70445


New Caps
A 70893 (black)
A 70894 (red)

Old Tanks
No longer available,
Order parts on right,
new caps are included

A 70898 Oil Tank *
A 70583 Oil Tank †
A 70899 Fuel Tank *
A 70582 Fuel Tank †

Note * for units without vibration isolation (XL, XL-2, Super-2)
† for units with vibration isolation (VIS-2, VI S-2 SL)

Please adjust your records and notify your dealers accordingly.

Joe Shuhy 
Service Manager - Forestry Equipment

Distribution:**TO:** All Districts, Branches, Service Branches and Dealers**SUBJECT:** Walbro H D C Carburetor**DATE:** 11-76

Units Affected: XL, XL-2, Super 2, 150 Automatic and Super EZ

New units which have been in storage may have a stuck inlet needle which prevents the unit starting.

The stuck needle, being unexpected and difficult to diagnose, causes some mechanics to repair some other part of the unit to correct a carburetor problem.

If after sufficient number of "cranks" the unit fails to fire, prime the unit with fuel, gasoline - oil mixture.

If the unit now runs, lightly jar the unit to release the stuck inlet needle. It may be necessary to repeat this procedure several times as the unit will consume the priming fuel quickly.

Failing to jar the needle loose on a unit which runs on priming fuel, will require that the carburetor be disassembled to free the inlet needle. Carburetor should be cleaned prior to reassembly.

If the unit fails to start on priming fuel proceed with normal trouble shooting procedure.

When the metering diaphragm pushes against the inlet control lever, the inlet control lever moves away from the fulcrum pin instead of lifting the inlet needle from its seat. This is caused by the "saddle" type attachment to the fulcrum pin.

This area of the carburetor will be redesigned so that the inlet control lever pivots on the fulcrum pin, thereby exerting a lifting force on the inlet needle. This design will alleviate the inlet needle sticking.

Thomas W. Stever
Thomas W. Stever
Manager - Technical Service

Distribution:**TO:** All Districts, Branches, Service Branches and Dealers**SUBJECT:** Improved Carburetion**DATE:** 12-76

Units Affected: Super 1050 AO, Super 1050E and Super 1130G

Carburetor Kit A-70611 is available to service the above units. This kit will improve overall performance.

It will be necessary to remove the air filter cover and air filter to adjust the idle mixture and idle speed as the adjustment needles do not protrude to the outside of the carburetor chamber.

Instruction sheet 17028 is included in Carb. Kit # A-70611.

Thomas W. Stever
Manager - Technical Service

Distribution:**TO:** All Districts, Branches, Service Branches and Dealers**SUBJECT:** Fuel Lines, Oil Lines and Pulse Lines**DATE:** 12-76

Units Affected: All Units

The materials used for rubber tubing, such as epichlorohydrin or acrylonitrile butadiene exhibit a more rapid degradation of physical properties when the material is stretched.

When a line is assembled to a unit, dress the line with some slack. Use caution in dressing the line so as to avoid excess slack or sharp bends, which will cause the line to collapse in the area of the sharp bend.

Thomas W. Stever

Thomas W. Stever
Manager - Technical Service