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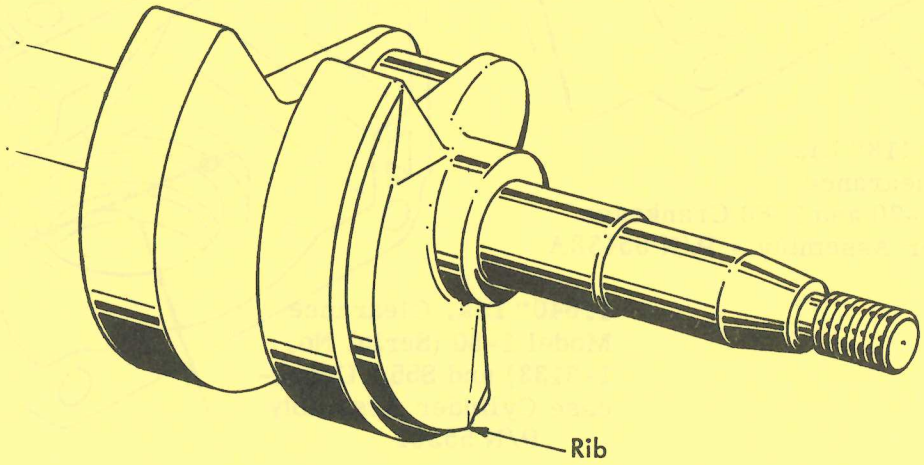
SERVICE BULLETIN # 1077A

MODEL 1-70, 1-80, MC-10 DATE 8/5/60

SUBJECT NEW CRANKCASE CYLINDER ASSEMBLY AND CRANKSHAFT

This bulletin replaces Service Bulletin #1077.

A new, better balanced Crankshaft, P/N 55517, which has been designed to reduce engine vibration, replaces crankshaft, P/N 55257, on Model 1-70, 1-80, and MC-10 engines. Improved balance is provided by a circular-shaped rib on the crankshaft counterweight (see illustration).



P/N 55517

Changes in the crankshaft made necessary a casting change in the crankcase cylinder. The new Crankcase Cylinder Assembly, P/N 55438A, replaces P/N 55438 and P/N 55301 and can be used on earlier Model 1-70, 1-80, S55A, and S44A engines when replacement is necessary.

When the 55438 and 55301 crankcase cylinder assemblies are replaced with the new 55438A Crankcase Cylinder Assembly, either the new Crankshaft, P/N 55517 or the old crankshaft, P/N 55257 can be used as shown in Table 1. However, the new Crankshaft, P/N 55517, cannot be used on the earlier engines which contain the 55438 and 55301 crankcase cylinder assemblies. The interference between the 55517 Crankshaft counterweight area and the old crankcase cylinder walls will cause the crankshaft to bind in the crankcase cylinder.

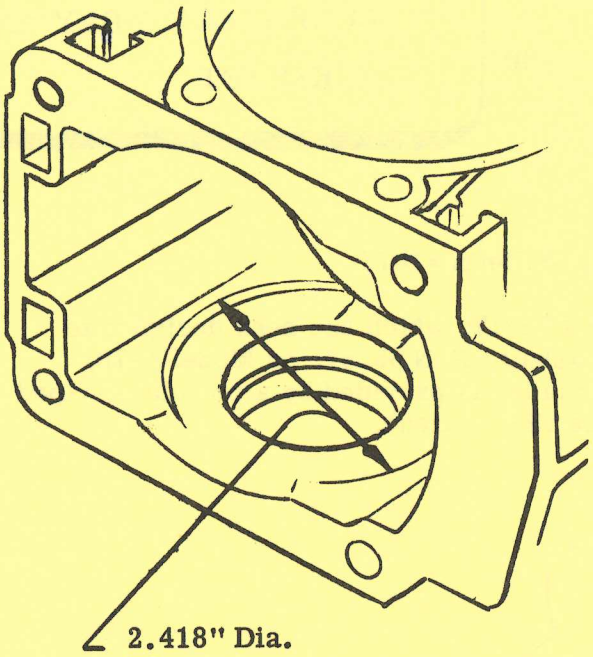
CRANKSHAFT	can be used on	CRANKCASE CYLINDER ASSY
P/N 55257 (old)	→	P/N 55301 (old)
P/N 55517 (new)	→	P/N 55438A (new)

Table 1

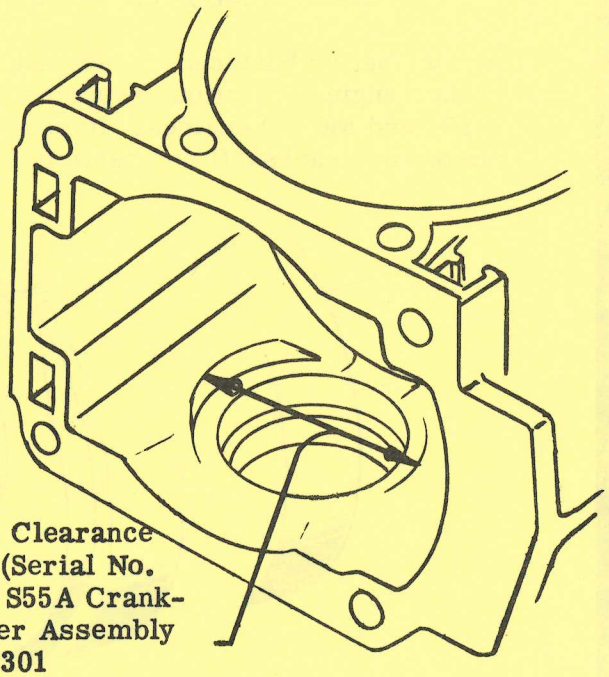
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The difference between the 55438A and 55301 crankcase cylinder assemblies is shown in the following illustration.



2.418" Dia. Clearance
Model 1-70 and 1-80 Crankcase Cylinder Assembly - P/N 55438A



1.640" Dia. Clearance
Model 1-80 (Serial No. 1-2133) and S55A Crankcase Cylinder Assembly P/N 55301

The part number changes described in this Bulletin should be transferred to your Model 1-70 and 1-80 Illustrated Parts Lists. All Model 1-80 engines beginning with serial number 1 through 2133 contained the 55301 crankcase cylinder assembly. All Model 1-80 engines after serial number 2133 and up to the present time contain the new 55438A Assembly and the new revisions of the 1-80 Illustrated Parts List will include the new number.

In addition, page 7 of the Interchangeable Parts List, #7003, dated September, 1959, should be changed as follows:

> Line 5, P/N 55438, should read: P/N 55438A, and an "X" (denoting interchangeability) should be entered for Models S44A, S55A, 1-70, and 1-80 on the same line.