McCULLOCH SERVICE BULLETIN

NO. 1603

MODEL 1. SP 81
2. SP 80 and SP 81

DATE April 26, 1976

SUBJECT 1. Recommended Fuel/Oil Mixture.
2. Matched Piston/Cylinder Assemblies.

1 Because the SP 81 has a very high performance engine, it is necessary to slightly decrease the fuel/oil mixture to a ratio of 32:1 when using McCulloch Custom Lubricant (1 gal. of regular leaded gasoline to 4 oz. of McCulloch Custom Lubricant). If McCulloch oil is not available, use a good grade of SAE 40 two cycle oil mixed 20:1.

2 Beginning with the serial numbers listed below, SP 81 Piston and Cylinder assemblies will be selectively matched to provide the best fit between the cylinder bore and piston. This selective fit will assure better overall engine performance.

Model No.	Serial Numbers with Matched Piston/Cylinder Assy.
600438B	14-13343 and up
600438D	14-13717 and up
600438E	14-10301 and up
600438J	14-12001 and up

There will be three sets of matching piston and cylinder assemblies used in production and as service parts. These sets will be designated by the letters "A", "B", and "C". The letter designation on the cylinders will be located next to the muffler mounting boss on the top cooling fin as shown in Figure 1. The letter designation on the pistons will be located on the roof of the piston window as shown in Figure 2.

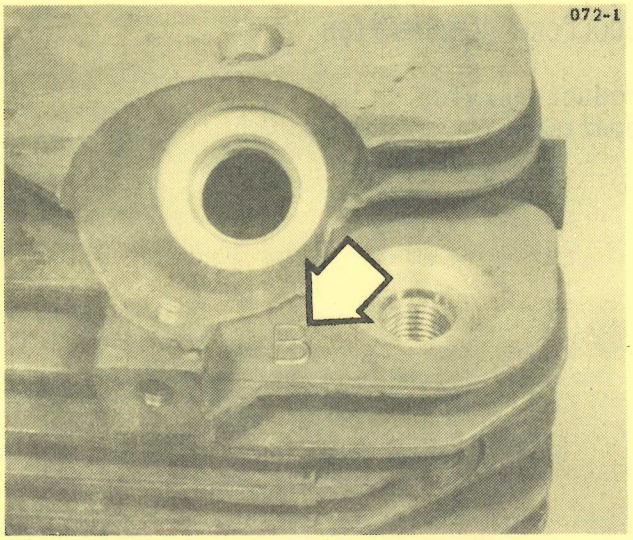


FIGURE 1

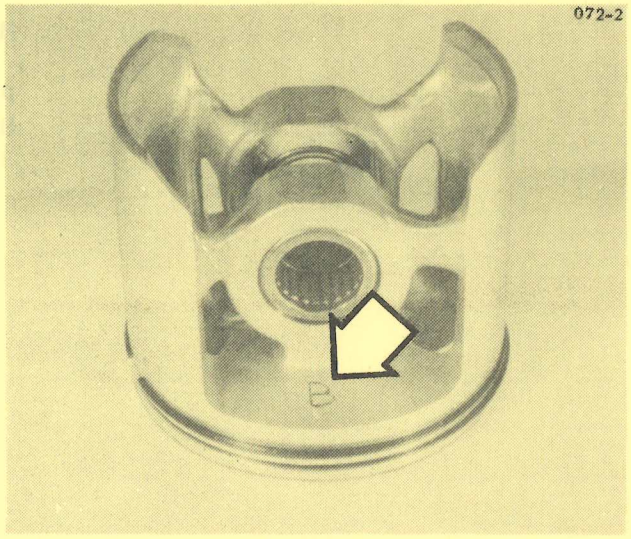


FIGURE 2

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In order to service SP 80 and SP 81 series units, four service parts assemblies will be produced. Service Kit, P/N 92450, will contain a matched piston and cylinder assembly designated either "A", "B", or "C". Individual service piston assemblies will have individual part numbers: P/N 92518 will contain a piston designated "A", P/N 92519 will contain a piston designated "B", and P/N 92520 will contain a piston designated "C". Individual service cylinder assemblies will no longer be available.

Any matched piston/cylinder assembly, from set "A", "B", or "C", may be used to service any SP 80 or SP 81 Series unit. However, when pistons only are needed for service, the piston assembly should be ordered which has the same letter designation as the cylinder with which it will be matched. If the cylinder is one which was produced previously and therefore does not have a letter designation, the piston with the letter "B" designation, P/N 92519, should be ordered.

If an order is placed for either the previously used Cylinder Assembly, P/N 87296, or Piston Assembly, P/N 87791, it will automatically be changed to the new item. An order for Cylinder Assembly, P/N 87296, will be changed to Piston/Cylinder Kit, P/N 92450. An order for Piston Assembly, P/N 87791, will be changed to Piston Assembly, P/N 92519.

PRICING AND STOCKING INFORMATION

Part No.	Description	List Price	Stock. Code
92450	Kit - Piston/Cylinder Asy	$68.95	A
92518	Piston Asy - A	15.70	A
92519	Piston Asy - B	15.70	B
92520	Piston Asy - C	15.70	A

McCULLOCH CORPORATION

Product Service
Department