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MANUAL PREVIEW

Allis Chalmers

Parts Manual

L

Crawler

Parts Manual

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TELEGRAPHIC CODE

When ordering parts by telegraph, it is important that a one-word description of the part wanted be specified after each part number. In event the part number is transmitted incorrectly, it will help us to ascertain the part actually required. Confirm each telegraphic order by mail in order that it may be checked and, if not correctly transmitted, the error detected.

Shipping or other instructions in the body of a telegram which normally consists of many words, can be condensed into one by the use of the proper code word as given below.

AIRYX - Ship by Air Express
 SONST - Ship to me (us) by Express
 SOOTY - Ship by Express to
 SOYON - Ship to me (us) by Mail
 SOBOS - Ship by Mail to
 SORAT - Ship to me (us) by Freight
 SAPAT - Ship by Freight to
 SPLAT - When and how did you ship parts on my (our) order
 SPATS - When and how will you ship parts on my (our) order
 STAUB - Cancel my (our) parts order
 STUFE - Add to my (our) parts order
 SOMOR - Duplicate shipment of my (our) order

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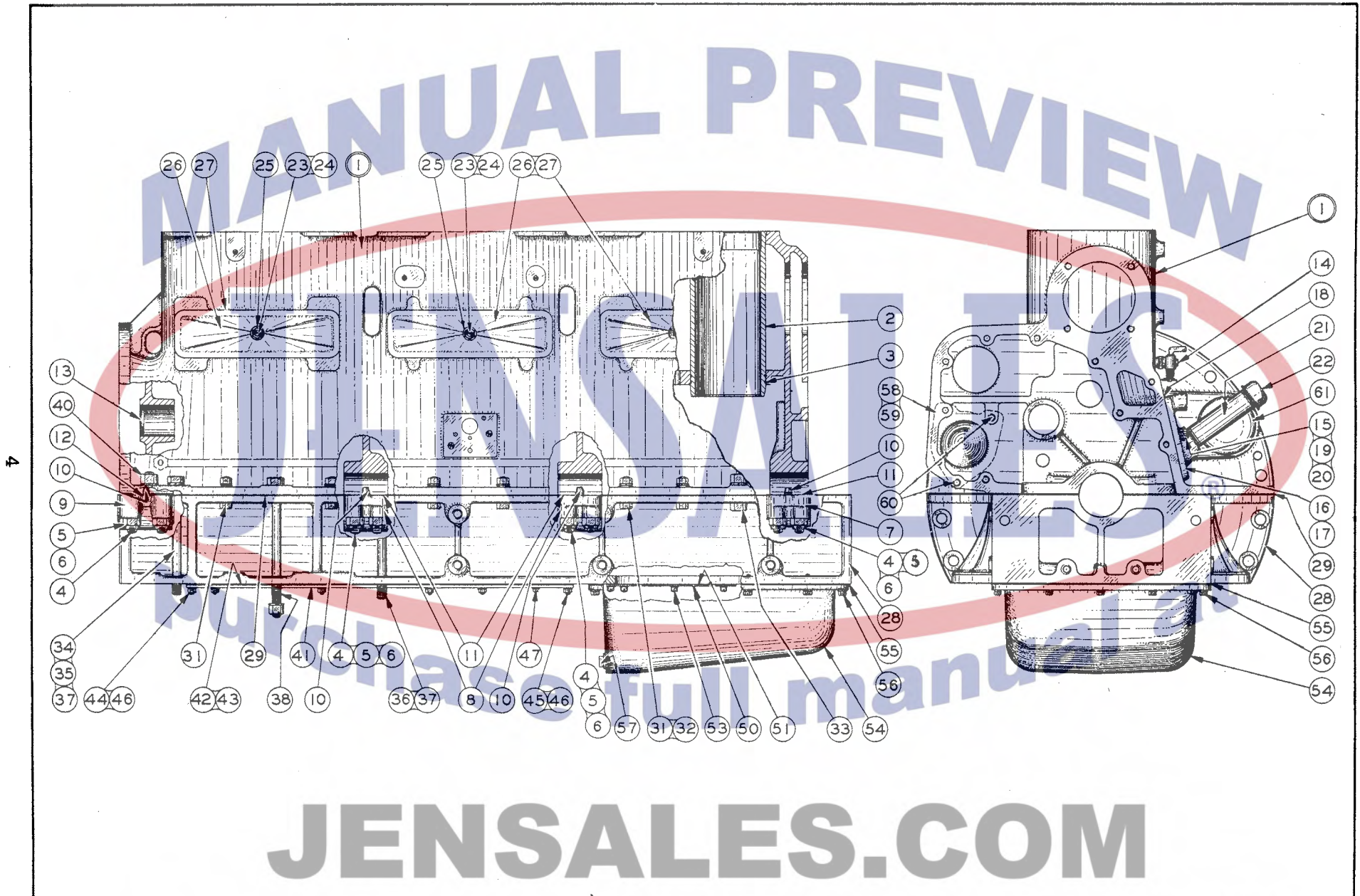


PLATE 1 - CYLINDER BLOCK AND CRANKCASE GROUP

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CYLINDER BLOCK AND CRANKCASE

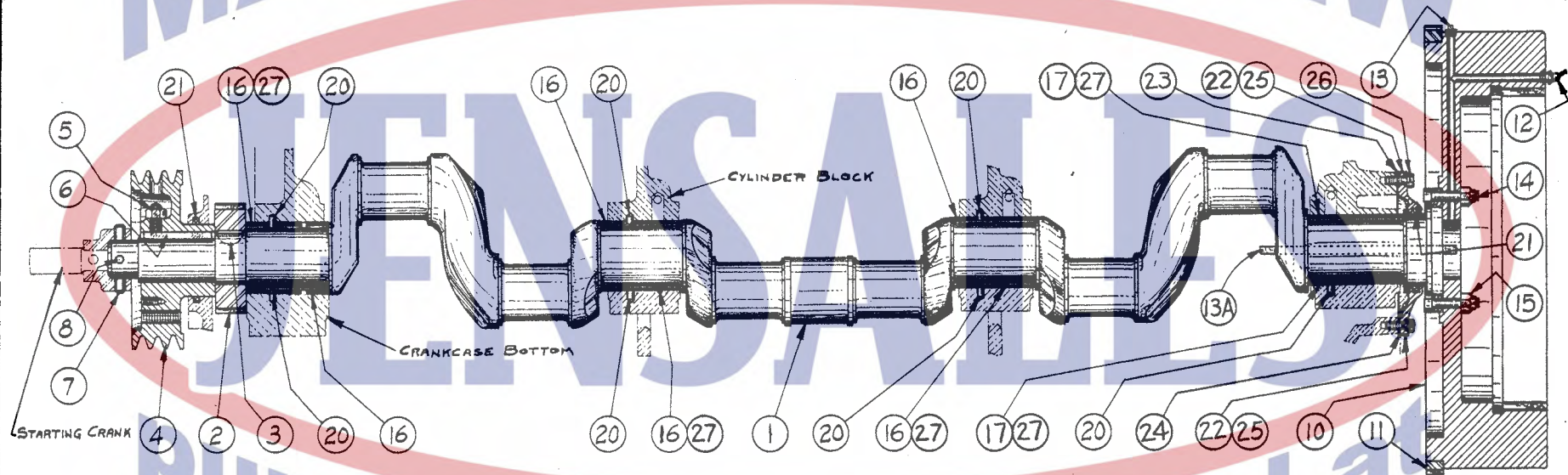
(See Plate 1)

Item	Part Number	Qty.	Name
1	209123	1	Block Assembly, Cylinder (Includes items 3 thru 13 and Camshaft Bushings)
2	AM-41487	6	Sleeve, Cylinder
3	AM-8578	12	Packing Ring, Rubber
4	AM-8208	16	Stud, Main Bearing, 3/4" x 4-1/16" (Drilled)
5	208860	16	Nut, Main Bearing Cap, 3/4" Castle (Special)
6	206008	8	Lockwire, 8" Long
7	208859	1	Cap, Main Bearing - Front
8	208857	2	Cap, Main Bearing - Center
9	208858	1	Cap, Main Bearing - Rear
10	AM-7959	8	Dowel, Main Bearing Cap
11	AM-9541	6	Shim, Main Bearing - Front and Center
12	AM-8584	2	Shim, Main Bearing - Rear
13	910011	1	Plug, Expansion, 2-1/2" Dia. (For Camshaft Hole)
14	206585	1	Cock, Drain, 3/8" Pipe Thread
15	AM-8692	2	Stud, Front Crankcase Cover, 3/8" x 1-5/8"
	900367	2	Nut, Hex, 3/8" NC
	910804	2	Lockwasher, Heavy, 3/8"
16	AM-70896	1	Cover, Crankcase - Front (Purrolator Support)
17	AM-40867	2	Cover, Crankcase - Center and Rear
18	AM-4917	3	Gasket, Crankcase Cover
19	903631	4	Capscrew, Hex Head, 3/8" NC x 1-1/4"
20	206510	4	Washer, Copper, 13/32" I.D. x 15/16" O.D.
21	910222	1	Nipple, Pipe, 1-1/4" x 7"
22	901756	1	Cap, Pipe, 1-1/4"
23	AM-8667	3	Stud, Valve Tappet Cover, 1/2" x 3-3/8"
24	900369	6	Nut, Hex, 1/2" NC
25	205988	3	Washer, Copper, 17/32" I.D. x 1-1/16" O.D.
26	AM-5829	3	Cover, Valve Tappet
27	AM-4964	3	Gasket, Valve Tappet Cover
28	AM-95072	1	Bottom, Crankcase (When for tractors prior to L-26, order items 50 thru 53 also)
29	AM-41253	2	Gasket, Crankcase Bottom
	35068	16	Capscrew, Hex Head, 1/2" NF x 2-1/4"
31	911043	16	Nut, Hex, 1/2" NF
	910806	16	Lockwasher, Heavy, 1/2"
32	903639	1	Capscrew, Hex Head, 1/2" NC x 1-1/2"
	910806	1	Lockwasher, Heavy, 1/2"
	AM-8998	1	Bolt, Crankcase Bottom Dowel, 3/4" NC x 2-3/8"
33	900371	1	Nut, Hex, 3/4" NC
	910809	1	Lockwasher, Heavy, 3/4"
34	AM-8997	1	Bolt, Crankcase Bottom Dowel, 3/4" NC x 8-7/8"
	910809	1	Lockwasher, Heavy, 3/4"
35	AM-9018	2	Bolt, Crankcase Bottom, 3/4" NC x 9"
36	AM-9136	1	Bolt, Crankcase Bottom, 3/4" x 8-7/8" - Thin Head
37	910809	3	Lockwasher, Heavy, 3/4"
	AM-9017	2	Bolt, Crankcase Bottom, 3/4" NC x 9-3/4"
38	900371	2	Nut, Hex, 3/4" NC
	910809	2	Lockwasher, Heavy, 3/4"
39	71450	6	Spacer, Bolt, 5-1/2" Long (Used on tractors L-211 thru L-267 only) Not illustrated
	AM-9019	2	Bolt, Crankcase Bottom, 3/4" NC x 2-1/2"
40	900371	2	Nut, Hex, 3/4" NC
	910809	2	Lockwasher, Heavy, 3/4"
41	AM-41271	1	Plate, Crankcase Bottom Cover
42	AM-8832	2	Gasket, Crankcase Bottom Cover - Front and Rear Strip
43	AM-8833	2	Gasket, Crankcase Bottom Cover - Side Strip
44	U-386	18	Stud, Crankcase Cover, 3/8" x 1-3/8"
45	AM-9015	2	Stud, Crankcase Cover, 3/8" x 2"
46	900367	20	Nut, Hex, 3/8" NC
	910804	20	Lockwasher, Heavy, 3/8"
47	901783	1	Plug, Pipe, 1/4" Square Head, Brass
50	E-2397	1	Plate, Oil Sump Splash (Discontinued on tractor L-26)
	204836	1	Plate, Oil Sump Splash (Effective with tractor L-26)
	E-2398	3	Gasket, Oil Sump Splash Plate (Discontinued on tractor L-26)
51	AM-9009	2	Gasket, Oil Sump Splash Plate (Side Piece)
	AM-9010	1	Gasket, Oil Sump Splash Plate (End Piece)
53	900202	9	Capscrew, Fillister Head, 3/8" NC x 5/8"
	910804	9	Lockwasher, Heavy, 3/8"
54	AM-70725	1	Sump, Oil
55	AM-41254	1	Gasket, Oil Sump
56	903638	14	Capscrew, Hex, 1/2" NC x 1-1/4"
	910806	14	Lockwasher, Heavy, 1/2"
57	912768	1	Plug, Pipe, 1" Square Head
58	AM-8992	1	Cover, Generator Opening
59	AM-9089	1	Gasket, Generator Opening Cover
60	904706	2	Capscrew, Hex Head, 7/16" NC x 1-1/4"
	910807	2	Lockwasher, Heavy, 7/16"
61	AM-8686	1	Cover, Starter Hole
61A	034636	1	Plug, Cork (For Starter Set Screw Hole)
62	204999	1	Cover, Oil Passage
63	205000	1	Gasket, Oil Passage Cover
64	903631	2	Capscrew, Hex Head, 3/8" NC x 1-1/4"
65	206510	2	Washer, Copper, 13/32" I.D. x 15/16" O.D.

Used on engines #2937 thru 3002 only. On left side of crankcase. Not illustrated

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PLATE 2 - CRANKSHAFT AND FLYWHEEL

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CRANKSHAFT AND FLYWHEEL
(See Plate 2)

Item	Part Number	Qty.	Name
1	281592	1	Crankshaft Service Group (Consists of one Crankshaft, one AM-8762 Gear, one 905127 Key, one U-3522 Wick, six AM-9541 Shims and two AM-8584 Shims) See Note below.
2	AM-8762	1	Gear, Crankshaft, 38 Teeth
3	905127	1	Key, Woodruff, #B, 5/16" x 1"
4	AM-70723	1	Pulley, Fan Drive
5	901323	2	Setscrew, Headless, Cup Point, 1/2" NC x 1-1/2" } Discontinued
6	911035	2	
7	904612	1	
8	AM-8804	1	Pin, Starting
9	910214	1	Setscrew, Socket Head, Cup Point, 5/16" NF x 3/8"
10	E-2409A	1	Flywheel with Ring Gear (Discontinued approx. on engine #2870. Drilled for lubricating fitting)
11	205891	1	Flywheel with Ring Gear (Effective approx. with engine #2870)
12	AM-70721	1	Gear, Flywheel Ring
13	910261	1	Fitting, Lubricating - Lincoln #5100
14	901651	1	Plug, Pipe, 1/8" Square Head
15	U-3522	1	Wick, Pilot Bearing Oiling (Effective approx. with engine #2870)
16	AM-8083	7	
17	903556	7	Bolt, Flywheel
18	900802	7	Nut, Hex Castle, 1/2" NF
19	209567	6	Bearing Shell, Front and Center, .005" Undersize } Also see item 27
20	209562	6	
21	209118	6	
22	209563	6	
23	209564	2	
24	209565	2	
25	209119	2	Bearing Shell, Rear, .023" Undersize
26	209566	2	
27	AM-4543	7	Bearing Shell, Rear, .065" Undersize
28	AM-8951	4	Bearing Shell, Rear, .083" Undersize
29	211027	1	Dowel, Main Bearing Shell
30	AM-8824	1	Seal, Crankshaft
31	AM-8823	1	Retainer Assembly, Crankshaft Seal (both halves)
32	AM-8953	4	Gasket, Seal Retainer - Upper
33	AM-8822	7	Gasket, Seal Retainer - Lower
34	206004	1	Dowel, Seal Retainer
35	206005	1	Screw, Seal Retainer, 3/8" x 1"
36	209877	1	Lockwire, 1/16" x 18"
37	209878	1	Lockwire, 1/16" x 24"
38	209879	1	Main Bearing Shell Set, .005" Undersize (Consists of six 209567 Shells, two 209564 Shells)
39	209880	1	Main Bearing Shell Set, .023" Undersize (Consists of six 209562 Shells, two 209565 Shells)
40	209881	1	Main Bearing Shell Set, .065" Undersize (Consists of six 209118 Shells, two 209119 Shells)
41	209882	1	Main Bearing Shell Set, .083" Undersize (Consists of six 209563 Shells, two 209566 Shells)

CRANKSHAFT EXCHANGE OFFER

In order to provide tractor owners with the most economical and practical means of making crankshaft replacements, a Crankshaft Service Group (Item 1) has been made available on an exchange basis. Regardless of condition, the old crankshaft will be taken in for credit at prevailing exchange price in effect at time the new crankshaft is purchased. The old crankshaft must be delivered, transportation charges prepaid, to the Factory or Branch House through which purchase was made. Consult Branch House or Dealer for current exchange price.

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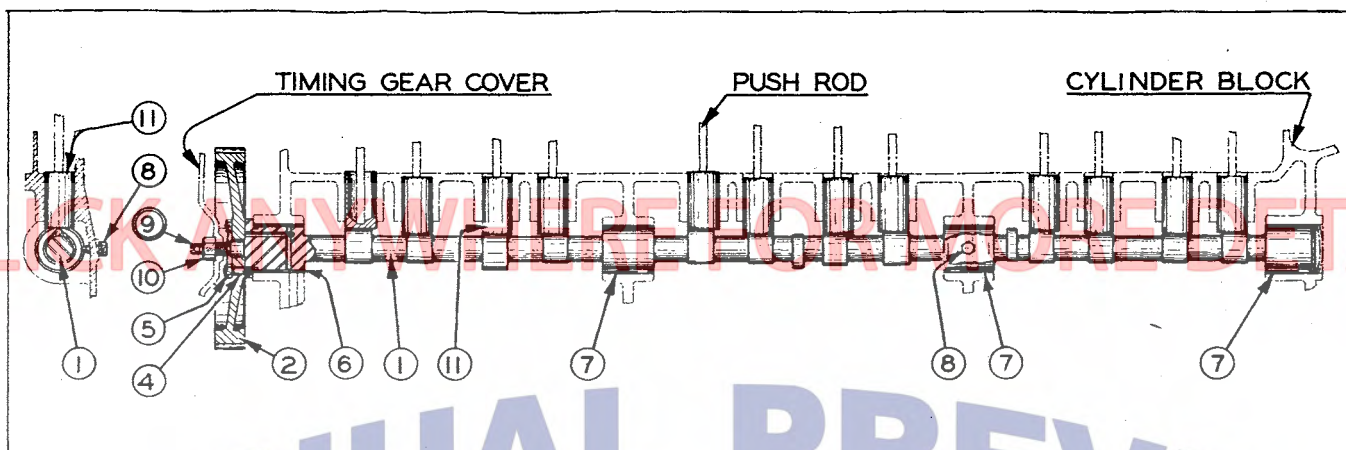


PLATE 3 - CAMSHAFT

CAMSHAFT
(See Plate 3)

Item	Part Number	Qty.	Name
1	AM-90201	1	Camshaft
2	AM-70771	1	Gear, Camshaft
3	E-2413	3	Capscrew, 3/8" x 1" (Discontinued on engine #1380. Order AM-9181 Stud and 904321 Nut)
4	AM-9181	5	Stud, Camshaft Gear
5	904321	5	Nut, Castle, 3/8" NF
6	206003	1	Lockwire, 20" Long
7	E-2375	1	Bushing, Camshaft - Front
8	AM-8201	3	Bushing, Camshaft - Center and Rear
9	AM-4759	4	Setscrew, Camshaft Bushing
10	910804	4	Lockwasher, Heavy, 3/8"
11	205807	1	Camshaft Thrust Screw Assembly (Consists of 1-Screw, 1-Plunger, 1-Plunger Pin, 1-Spring. Separate parts are not serviced)
12	911044	1	Nut, Hex, 5/8" NF
13	AM-8746	12	Tappet, Valve

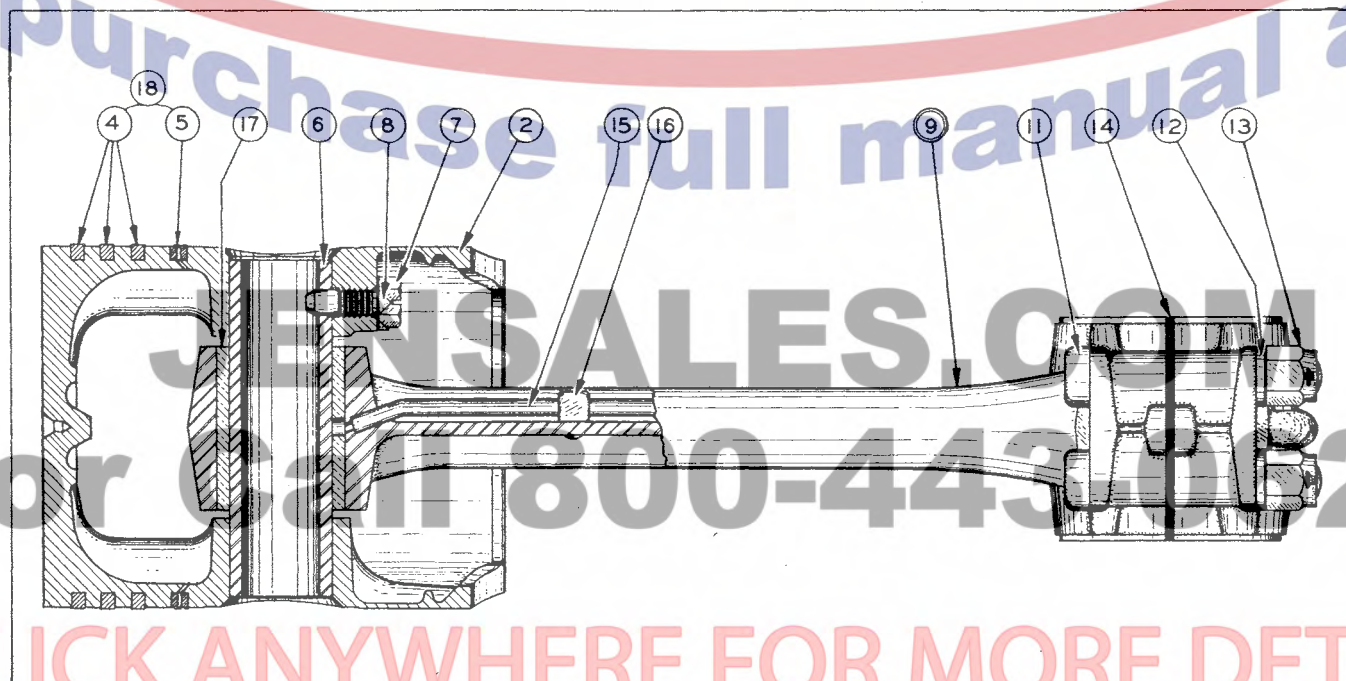


PLATE 4 - PISTON AND CONNECTING ROD

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FIRST TYPE CYLINDERHEAD
COVER AND BREATHER
(DISCONTINUED)

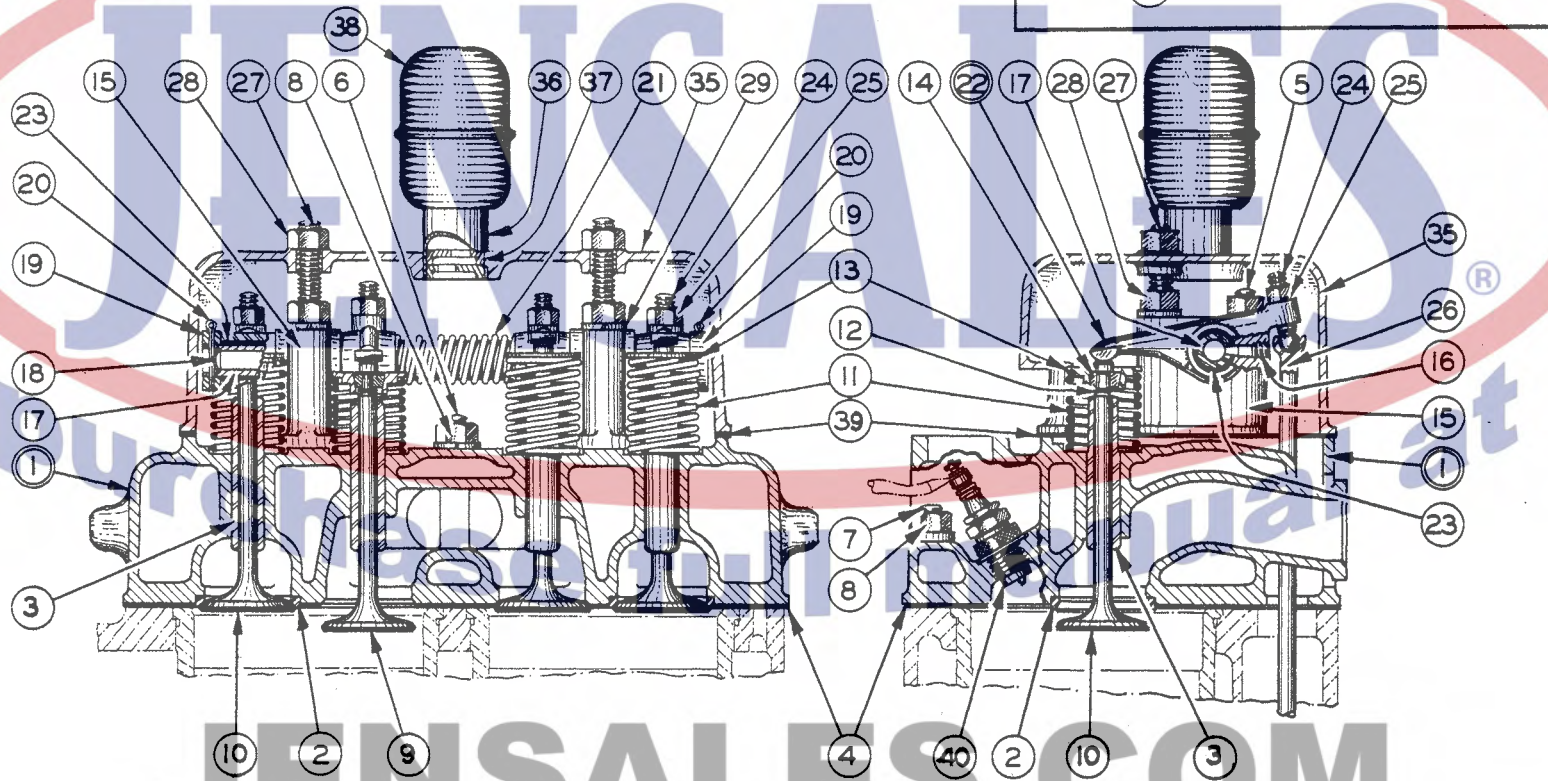


PLATE 5 - CYLINDER HEAD

or Call 800-443-0625

CYLINDER HEAD
(See Plate 5)

Item	Part Number	Qty.	Name
	E-2030A	3	Head Assembly, Cylinder (Discontinued on engine #2428. Requires 3/8" Dia. Manifold Studs) - Includes two AM-9140 Inserts and four E-2036 Guides.
1	206680	3	Head Assembly, Cylinder (Used on engines #2428 thru #3517. Requires 1/2" Dia. Manifold Studs) - Includes two AM-9140 Inserts and four E-2036 Guides.
	208951	3	Head Assembly, Cylinder (Effective with engine #3518) Includes two AM-9140 Inserts and four 208950 Guides.
2	AM-9140	6	Insert, Exhaust Valve Seat (Effective with engine #1277)
3	E-2036	12	Guide, Valve - 7/16" I.D. (Discontinued on engine #3518)
	208950	12	Guide, Valve - 1/2" I.D. (Effective with engine #3518)
4	206316	3	Gasket, Cylinder Head
5	AM-8995	6	Stud, Cylinder Head, 1/2" x 8-7/16"
6	AM-8993	12	Stud, Cylinder Head, 1/2" x 5-11/16"
7	AM-8994	12	Stud, Cylinder Head, 1/2" x 3-7/16"
8	911028	30	Nut, Hex, 1/2" NC (Discontinued on engine #1176)
	AM-8999	30	Nut, Hex, 1/2" NF (Effective with engine #1176)
9	E-2041	6	Valve, Inlet - 7/16" Dia. Stem (Discontinued on engine #3518)
	E-2041	6	Valve, Inlet - 1/2" Dia. Stem (Effective with engine #3518)
10	E-2042	6	Valve, Exhaust - 7/16" Dia. Stem (Discontinued on engine #3518)
	208913	6	Valve, Exhaust - 1/2" Dia. Stem (Effective with engine #3518)
11	AM-8652	12	Spring, Valve
12	E-2044A	12	Snap Wire, Valve Stem Safety (Discontinued on engine #3518)
	204227	12	Snap Wire, Valve Stem Safety (Effective with engine #3518)
13	E-2043	12	Retainer, Valve Spring (Discontinued on engine #3518)
	208912	12	Retainer, Valve Spring (Effective with engine #3518)
14	E-2044	24	Lock, Valve Spring Retainer (Half only) (Discontinued on engine #3518)
	AM-9316	24	Lock, Valve Spring Retainer (Half only) (Effective with engine #3518)
15	AM-41195	6	Bracket, Rocker Shaft
16	AM-8601	3	Set Screw, Rocker Shaft
17	AM-41193	3	Shaft, Rocker Arm
18	910001	6	Plug, Expansion, 5/8" Dia.
19	AM-8600	6	Collar, Rocker Shaft
20	900812	6	Pin, Cotter, 3/16" x 1-3/4"
21	AM-8602	3	Spring, Rocker Arm Spacing
22	206681	12	Rocker Arm with Bushing (Includes item 23)
23	AM-8701	12	Bushing, Rocker Arm
24	AM-8087	12	Screw, Valve Adjusting
25	911041	12	Nut, Hex, 3/8" NF
26	AM-8643	12	Push Rod
27	AM-8608	6	Stud, Cylinder Head Cover
28	911028	12	Nut, Hex, 1/2" NC
29	910806	6	Lockwasher, Heavy, 1/2"
30	E-2048	3	Cover, Cylinder Head
31	E-1468	3	Screen, Breather - Flat
32	E-1469	3	Screen, Breather - Angle
33	- - - - -	3	Pcs. Horse Hair, 1 Oz.
34	900865	3	Bolt, Stove, 1/4" x 3/4" with Nut
	900802	3	Lockwasher, Heavy, 1/4"
	900816	3	Washer, Plain, 1/4" U.S.S.
35	AM-70792	3	Cover, Cylinder Head (Effective with tractor L-26)
36	U-219	1	Tube, Breather, 2" Long (Three used on engines prior to #3518. Used only on center Head on later engines)
	208949	2	Tube, Breather, 4-3/8" Long (Effective with engine #3518)
37	U-857	2	Baffle, Breather Tube (Six used on engines prior to #3518. Used only on center Head on later engines)
38	U-267	1	Cap, Breather (Three used on engines prior to #3518. Used only on center Head on later engines)
	U-3196	2	Cap, Breather (Effective with engine #3518)
39	AM-41166	3	Gasket, Cylinder Head Cover
40	AM-9026	6	Spark Plug, 7/8" SAE (Low Octane Gasoline)
	213293	6	Spark Plug, 7/8" SAE (High Octane Gasoline)

Discontinued on tractor L-26. Not serviced. Order AM-70792 Cover, U-219 Tube, U-267 Cap and two U-857 Baffles.

or Call 800-443-0625