

PARTS AND SERVICE MANUAL



1970-1971
SKI-DADDLER
SNOWMOBILES
MARK IV AND MARK V



AMF WESTERN TOOL DIVISION
Parts and Service Department
Whiteford Road, York, Pennsylvania, 17402 • 717/848-1177
AMF INCORPORATED

PART NO. 1002472

WARRANTY CERTIFICATE

AMF SKI-DADDLER SNOWMOBILE

PART I

AMF as manufacturer guarantees, to the original retail purchaser, each new snowmobile to be free of defects in material and workmanship under normal use. The manufacturer's obligation under this warranty is expressly limited to repairing or replacing any defective part under the conditions set forth as follows:

1. This warranty applies only to defects discovered between the date of retail purchase and the first day of the following month of May.
2. The part alleged to be defective shall be reported in writing to an authorized AMF dealer within thirty days of the discovery of the defect.
3. This warranty does not apply to items which are covered by the original manufacturer's warranty, such as engines, starters, batteries, drive belts, and light bulbs (see Warranty Certificate, Part II, Conditions). These items are warranted separately by their respective manufacturers through their authorized service dealers.
4. This warranty is voided if the snowmobile is operated on other than snow or ice, in competitive racing, in commercial usage, or has been used as a demonstrator.
5. The warranty registration card and 20-hour inspection checklist card must be mailed to AMF within seven days of date of purchase to qualify for the warranty.
6. Damage or deterioration resulting from misuse, neglect, accident, transit, alterations or unauthorized repair shall in no event be deemed a defect in material or workmanship.
7. This warranty does not cover normal wear or maintenance items, which are considered to be operating expense.
8. For other than predelivery claims, the warranty will not apply to Series XX, high-performance models.
9. AMF reserves the right to incorporate changes in design into this product without obligation to make these changes on units previously sold.
10. No express, implied or statutory warranty other than that herein set forth is made or authorized to be made by AMF.

PART II

This warranty covers defects in material and workmanship, however, certain items are considered normal operating expense items and are not covered under this warranty.

Conditions:

This warranty does not apply to:

1. Engine tune-up, cleaning or replacement of spark plugs.
2. Ski alignment.
3. Brake, variable-speed, or traction-belt adjustment, or variable-speed-belt replacement.
4. Brake lining or ski wear-rod replacement.
5. Paint, body dents and damaged fiberglass, chrome or trim due to use.
6. Engine damage due to lack of sufficient oil in fuel mixture, incorrect oil, too lean carburetor adjustment, or clutch or traction belt damage due to running engine at high RPM on kickstand, or with variable-speed belt removed.
7. Damaged or broken windshields.
8. Any snowmobile which shall be repaired or altered outside an AMF authorized repair service facility in anyway that in AMF's judgment affects its operation or reliability.
9. Traction-belt failure due to misalignment or abuse.
10. Use of sled for competition racing will void the warranty.
11. Lamps and lens (headlight and taillight).
12. Snowmobile when AMF-approved parts are not used in repair or replacement.
13. Any snowmobile for which warranty registration card has not been returned in accordance with the instructions provided.
14. Any parts replaced as a result of normal wear.
15. Deterioration of rubber or fabric components.
16. Fasteners.

NOTE: Save the Ski-Daddler Inspection Record, Form No. 4477QA attached to the snowmobile. This inspection tag identifies your sled by model and serial number and should be shown to your dealer when making any claim under the AMF Warranty.

WARRANTY CERTIFICATE

Dealer's Responsibility

During the warranty period it will be necessary for the dealer to:

1. Be responsible for warranty service to the consumer on warranted items regardless of geographical location of original purchase.
2. Mail to AMF within seven days, after completion, predelivery inspection warranty registration card and 20-hour inspection checklist card.
3. Complete a Warranty Allowance Request Form, No. 4414A, and submit it to AMF through his distributor, where applicable, within thirty days after repairs have been made.
4. Determine if the unit or part requiring repair or replacement is covered under this warranty.
5. Determine if the customer warranty has been properly registered and that the warranty period is still in effect.
6. Hold all defective parts replaced under this warranty until AMF disposition instructions are received or until warranty credit is received.
7. Identify all defective parts returned to AMF under warranty by the applicable warranty request number.
8. Assume the full cost of pick-up charges or travel expenses required to perform warranty service.

Owner's Responsibility

During this warranty period it may become necessary for the owner to:

1. Replace, clean or adjust spark plugs, ignition points and condenser.
2. Perform engine tune-up and adjust carburetor.
3. Adjust and align skis.
4. Add oil and lubricants.
5. Adjust brake.
6. Assume the full cost of freight for return of defective warranted parts to the factory.
7. Perform proper storage of snowmobile during off-season months.
8. Have 20-hour inspection of snowmobile made by his dealer.

IMPORTANT

WHILE THE WARRANTY COVERS DEFECTS IN MATERIAL AND WORKMANSHIP, CERTAIN MAINTENANCE ITEMS AS LISTED BELOW ARE CONSIDERED NORMAL OPERATING EXPENSE ITEMS AND ARE NOT COVERED UNDER THE WARRANTY.

- | | |
|--|--|
| 1. Engine tune-up cleaning or replacement of spark plugs. | ment, or clutch or traction belt damage due to running engine at high RPM on kickstand, or with variable speed belt removed. |
| 2. Ski Alignment. | 7. Broken windshields. |
| 3. Brake, variable speed, or traction belt adjustment, or variable speed belt replacement. | 8. Any modifications other than factory recommendations. |
| 4. Brake lining or ski wear rod replacement. | 9. Traction belt failure due to misalignment or abuse. |
| 5. Paint, body dents, damaged fiberglass, and chrome or trim damage due to use. | 10. Use of sled for competition racing will void the Warranty. |
| 6. Engine damage due to lack of sufficient oil in fuel mixture, incorrect oil, too lean carburetor adjustment, | |

NOTE: SAVE THE SKI-DADDLER INSPECTION RECORD, FORM NO. 4477QA ATTACHED TO THE SNOWMOBILE STEERING COLUMN. THIS INSPECTION TAG IDENTIFIES YOUR SLED BY MODEL AND SERIAL NUMBER AND SHOULD BE SHOWN TO YOUR DEALER WHEN MAKING ANY CLAIM UNDER THE AMF WARRANTY.

WARRANTY FLAT-RATE LABOR SCHEDULE

1. Remove and replace chain case cover	1/4 hour
2. Remove and replace chain and adjust tension.....	1/4 hour
3. Remove and replace driven clutch or bearings or V-belt	1/2 hour
4. Remove and replace drive clutch.....	1/2 hour
5. Remove and replace engine mount and/or strap (MARK IV)	1 hour
Remove and replace engine mount and/or strap (MARK V)	1-1/2 hours
6. Remove and replace drive sprockets, drive shaft or bearings.....	1 hour
7. Remove and replace traction belt (endless) and adjust	2 hours
8. Remove and replace rear idler shaft assembly or bearings	1/2 hour
9. Remove and replace rear support arms (2)	1/2 hour
10. Remove and replace throttle cable	1/4 hour
11. Remove and replace brake cable	1/4 hour
12. Remove and replace bogie support half (1 or both)	1/2 hour
13. Remove and replace bogie wheel	1/4 hour
14. Remove and replace steering spindle.....	1/4 hour
15. Remove and replace spindle arm	1/4 hour
16. Remove and replace carburetor	3/4 hour

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INTRODUCTION

This manual has been prepared to provide all authorized AMF Ski-Daddler Dealers, Distributors and technicians with the instructions necessary to service and maintain the 1970/1971 AMF MARKIV and MARK V series Ski-Daddler snowmobiles.

The series classification for each snowmobile is clearly shown on the left-hand side of the console control panel. The Model Number and Serial Number are permanently stamped on the nameplate attached to the rear right-hand side of the main frame assembly. When ordering accessories or replacement parts, always indicate the correct Model Number and Serial Number as shown on the nameplate.

The following list identifies the Ski-Daddler series classification, corresponding model numbers and engine designation covered in this manual.

Series Classification	Model Number	Engine
MARK IV-300	SD15P10B	JLO 295
MARK V-400	SD18P27A	Hirth 399
MARK V-400E	SD18E27A	Hirth 399
MARK V-400DE	SD18E25B	Kohler 399
MARK V-500DE	SD18E20B	Hirth 493
MARK V-640	SD18P21A	Hirth 634

SD15P10B

- Manufacturer's engine code number
- P = Prepared for electric starter;
- E = Equipped with electric starter
- Traction belt width in inches
- Ski-Daddler

This manual is presented in two sections. The first section, Maintenance, provides the instructions necessary for maintenance and service while the second section, the Illustrated Parts List is provided to facilitate the ordering of spare and replacement parts.

The Parts List section also contains a numerical listing of all items shown in the Illustrated Parts List. Thus, if the part number is known but not its application, refer to the numerical list. If the part number is not known, locate the item on the illustration to obtain the index number keyed to the applicable parts list.

IMPORTANT To keep the AMF Warranty in force, be certain to use only AMF-Approved replacement parts. The AMF-Warranty does not apply to parts covered by the original manufacturer's warranty such as engine or engine parts, starters, belts, carburetor, battery or other components or accessories not manufactured by AMF. Should any claim arise concerning these items, follow the manufacturer's instructions.

If the information in this manual is not applicable to all models, the exceptions will be noted and the correct information for the particular model will be given.

PREDELIVERY INSTRUCTIONS

The 1971 Ski-Daddlers are shipped completely assembled except for the windshield assembly, the ski assembly and the kickstand assembly. On the electric-start models, the battery is installed but not activated.

These assemblies, plus the attaching hardware will be found in the shipping container. Carefully open the carton and immediately inspect the equipment for any damage or missing items.

IMPORTANT: The owner must retain the Ski-Daddler Inspection Record, Form No. 4477QA. This form must be shown to the dealer should any claim arise under the AMF Warranty.

Install Ski Assembly

- Place the spindle pads (figure 1) in the spring mounting bracket with the thicker section and the directional arrow on the pad pointing forward.
- NOTE:** The spindle pads and attaching hardware, locknuts and 3-1/4-inch length screws, will be found in the plastic bag shipped with the sled.

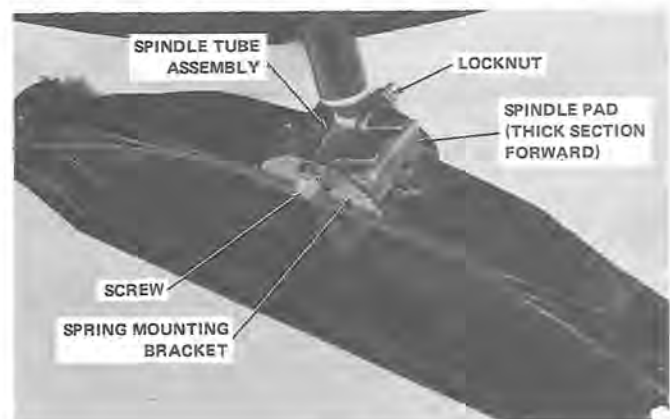


Figure 1

- Install the ski assembly by securing the spring mounting bracket and spindle pad to lower end of spindle tube assembly as shown in figure 1. Apply 30 foot-pounds torque to the locknut. Do not over-tighten bolt as the ski assembly should float freely on the spindle.

- Repeat procedure for opposite ski.

NOTE: Properly installed skis should toe out 0- to 1/2-inch at the front end (see figure 2) and should be symmetrical about the centerline of the sled. To align the skis, refer to the Steering and Ski Alignment procedures.



Figure 2

Install Windshield Assembly

- Disconnect hood harness at the quick disconnect.
- Remove hood and headlight assembly. Refer to Hood Removal and Installation procedure.
- Back off the locknut (figure 2) and remove the 7/8-inch length screw used to secure the hood harness clip and the end of the right-hand mounting strip to the hood.
- Remove the remaining screws securing the

right- and left-hand mounting strips to the hood. Remove the mounting strips.

- Remove the protective plastic cover from the windshield. Place the windshield in position on the hood assembly. Replace the mounting strips as shown in figure 2.

- Using the original screws, loosely secure the mounting strips and windshield to the hood assembly starting at the center and working to the sides. Be certain to position the 7/8-inch length screw in the end position shown in figure 2.

- Engage the ends of the mounting strips to the trim strip on the windshield and then tighten the screws, starting at the ends and working to the center. Remove the protective covering from the mounting strips. **NOTE:** Check mounting strips for sharp edges or corners. Use a fine tooth file to smooth any sharp edges and corners.

- Attach the hood harness clip to the 7/8-inch length screw and secure with locknut.

Activate Battery—Models SD18E20B, SD18E25B and SD18E27A Only

- Remove the hood and headlight assembly. Refer to Hood Removal and Installation.

CAUTION

Before activating the 12-volt storage battery, disconnect the battery cables and remove the battery. Activate the battery in accordance with the instructions contained on the package containing the electrolyte sulfuric acid. Reinstall the battery as follows:

- Place 12-volt battery on the battery support plate with positive (+) terminal post forward.
- Attach the negative (-) battery cable (and the BLACK wire lead from cigarette lighter SD18E20B only) to the negative terminal post.

NOTE: Cigarette lighter is standard equipment on Model SD18E20B only. May be purchased as an accessory item for any snowmobile equipped with a battery.

- Attach the positive (+) battery cable (and the RED wire lead from cigarette lighter SD18E20B only) to the positive terminal post.

- Position the holddown strap across the battery and over the holddown rods. Secure the strap and battery using locknuts and washers. Do not over-tighten.

- Replace the hood and headlight assembly.

Install Kickstand Assembly—Models SD18E20B, SD18E25B and SD18P21A Only

The attaching hardware required for kickstand installation will be found in the plastic parts bag shipped with the Ski-Daddler snowmobile. Check container against the following list to be certain no parts are missing or damaged.

Part No.	Description	Qty
37175	Kickstand assembly - 18 inch	1
32234	Spring	2
37186	Long spacer, 1-11/32 LG	2
33778	Short spacer, 13/32 LG	2
181575	Hex head bolt, 1/4-28 THD by 1-1/2 IN.	4
181578	Hex head bolt, 1/4-28 THD by 1-7/8 IN.	2
9000123	Locknut, 1/4-28 THD	6
33808	Formed washer	6
446188	Flat washer, 17/64 ID	4

- During initial installation, assemble all components loosely as shown in figure 3. After completing

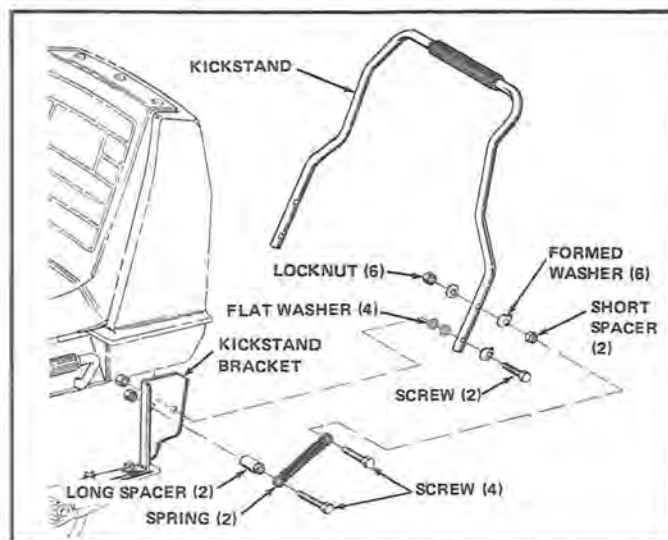


Figure 3

the installation, tighten all nuts and bolts securely but do not overtighten.

- Check the installation by setting the sled on the kickstand as shown in figure 13.

Fuel Mixture Instructions

WARNING

Never fill the gasoline tank while the engine is hot. Wipe off any spilled gasoline before attempting to start engine.

The correct oil-to-gasoline ratio is 20:1 (20 parts regular gasoline to 1 part oil). Too much oil will cause carbon deposits. Too little oil or a poor mix will cause insufficient lubrication and possible engine damage.

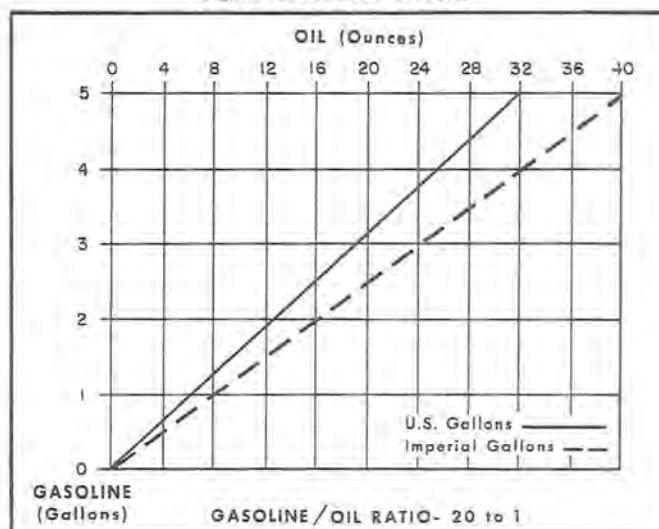
IMPORTANT: Gasoline and oil should be mixed at temperatures above zero. At temperatures below zero gas and oil mix with difficulty.

Fuels containing additives are not recommended for use in Ski-Daddler engines. For mixing with gasoline, use AMF-nondetergent oil prepared exclusively for use in air-cooled, 2-cycle engines.

IMPORTANT: Some outboard motor oils contain a detergent that works well in outboard motors that operate at much lower temperatures because they are water cooled. However, the detergents may cause spark plug fouling in the air-cooled engines used on Ski-Daddler snowmobiles.

Use a mixture of gasoline and oil as shown in the Fuel Mixture Chart. Never use gasoline left over from the summer or previous winter.

FUEL MIXTURE CHART



Mix the gasoline and oil thoroughly in a clean container kept for this purpose only. The best way to ensure a good mix is to pour the oil into a container with about one gallon of gasoline and mix thoroughly. Then add additional amounts of gasoline as shown on the Fuel Mixture Chart. Fill Ski-Daddler gas tank from this separate container of mixed fuel. Use a funnel with a fine-screen strainer when filling the tank.

Lubrication

There are three lubrication areas that require attention on a regular basis. A low temperature grease must be applied to the zerk fittings located on the steering spindle tubes; on each bogie wheel after approximately each 20 hours of use; and the chain case housing which must be checked after each 10 hours of use and No. 2 lithium bearing grease replaced as required.

NOTE: Do not add grease to chain case housing on Model SD18P21A. This unit has a self-lubricating system.

The bearing cup retainers that hold the seal bearings in the traction belt take-up assembly should be repacked with No. 2 lithium bearing grease whenever the bearings are removed during normal maintenance. No. 2 lithium bearing grease may also be applied to the inside of the drive sprocket bearing retainers during normal maintenance.

Grease may also be applied as required to the wear-plates and U-strap securing the steering column to the roll bar.

SERVICE AND REPAIR

Hood Removal and Installation

- To remove the hood and headlight assembly, disconnect the hood and the sled wiring harness at the quick-disconnect below the console on the right-hand side of the sled. Release the hood latch assemblies and then remove the hood and headlight assembly by lifting back end first.

- To install the hood and headlight assembly, place the hood in position on the sled so that the forward hood clip and the bottom edge of the hood engages the clips along the inside edge of the bumper.

- Engage the left- and right-hand latch assemblies to secure the hood to the main frame.

- Connect the sled wiring harness to the hood wiring harness at the quick-disconnect below the console on the right-hand side of the sled.

Hood Assembly Repair

AMF Fiberglass Repair Kits are available through your authorized AMF Distributor. For large repairs, order AMF Fiberglass Repair Kit No. 1510693. Smaller repairs can be made with Repair Kit No. 1510765. Paint all repaired areas on the hood using AMF-Orange color paint available in easy-to-use spray container, AMF Part No. 1510828. Follow the instructions in the kit when making repairs.

Replace Lamp Assemblies

Headlight. To replace the headlight bulb, raise the headlight assembly; remove the screws securing the cover assembly and remove the cover assembly. Remove the defective bulb and replace with new bulb. See illustrated parts list for correct replacement part numbers.

Taillight. Remove taillight lens to expose the taillight bulb. Remove the defective bulb and replace with a new bulb. See illustrated parts list for correct replacement part numbers.

Steering and Ski Assembly Alignment

Good steering ability requires that the skis be properly set and aligned with the sled body when the steering handle is placed in the straight-ahead position. To determine that the skis are properly aligned, measure the distance between the inside edges of the skis at the front end and at the rear. Properly aligned skis should toe out 0- to 1/2-inch maximum at the front. Therefore, the overall measurement at the front end of the skis should be 1/2-inch greater than at the rear. If the skis or steering mechanism are not properly set, adjust as follows.

- Place steering handle in a straight-ahead position.

- Remove the hood and headlight assembly. Refer to Hood Removal and Installation.

- Remove the bolt (1, figure 4), two spacers (2), bottom spacer and locknut securing the rod end bearing (3) to the spindle arm (6).

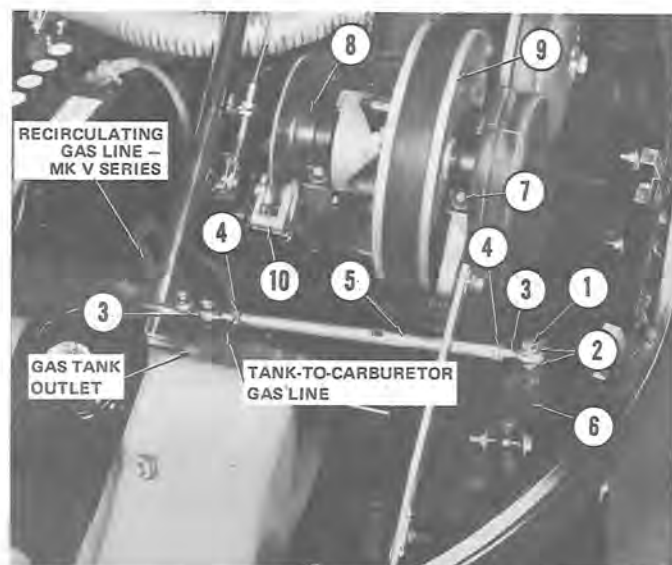


Figure 4

- Loosen the jam nuts (4) securing both rod end bearings (3) to the tie rod (5).

NOTE: If both skis need adjustment, repeat procedure for the opposite ski.

- Move the affected ski into proper alignment and recheck measuring points to insure that the skis toe out 0- to 1/2-inch maximum at the front end and are in the same orientation with the sled body as shown in figure 2.

- With skis properly set and steering handle in the straight-ahead position, rotate tie rod (5, figure 4) as required to bring rod end bearing (3) in line with the spindle arm (6).

- Secure rod end bearing (3) to spindle arm (6) as illustrated. Check for proper alignment and then tighten jam nuts (4) to secure both rod end bearings.

NOTE: If a greater adjustment is required than that permitted by the steering linkage assembly, it will be necessary to align the ski by making the adjustment at the spindle tube assembly as follows:

- Remove screw (5, figure 5) and locknut (6) securing spindle tube assembly (7) to spindle arm (8).

- Remove spindle arm (8) and rotate ski and spindle tube one notch in the required direction; replace and secure spindle arm to the spindle tube. Apply 20 foot-pounds torque to the locknut (6).

- Recheck the skis for proper toe out and alignment as previously described.

To Remove Drive Chain

- Remove the hood and headlight assembly. Refer to Hood Removal and Installation.

CAUTION

Always disconnect spark plug wires before working on the engine or drive elements.

- Remove the locknut securing the chain cover top and remove chain cover top.

- Loosen the bolts (1, figure 5) on both cam up-rights (2) and rotate the cam and shaft (3) as required to loosen the chain tension. During reassembly, apply 30 foot-pounds torque to the bolt (1).

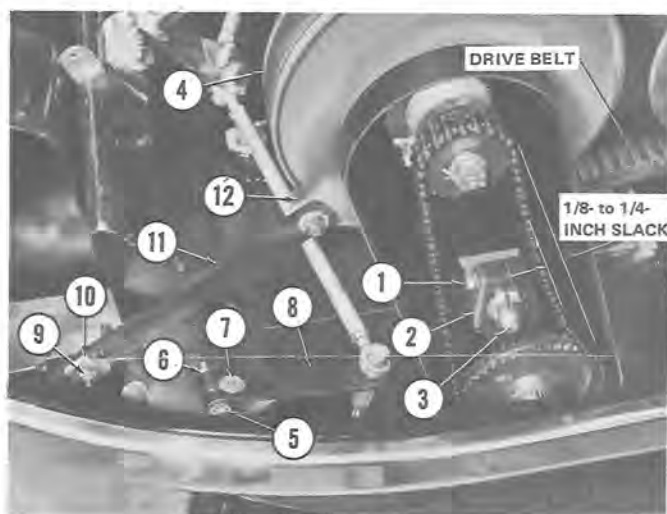


Figure 5

- Remove the cotter pin, slotted nut and washer securing the top sprocket to the driven clutch shaft. Remove the top sprocket and chain together.

- Reassembly is the reverse of removal. Perform drive chain adjustment procedures and add No. 2 lithium bearing grease as required to the chain case on all models except SD18P21A.

Drive Chain Adjustment

A properly adjusted drive chain (figure 5) should have a 1/8- to 1/4-inch slack. Check and adjust chain as follows:

- Remove the locknut securing the chain cover top and remove chain cover top.

- Rotate the upper sprocket to tension one side of the chain and then check the opposite side for proper slack. If adjustment is required, loosen the screws (1) securing the cam uprights (2) on each side.

- Rotate the cam (3) counterclockwise to tighten or until the chain is properly tensioned. Hold the cam in this position while tightening the cam upright bolts (1) on each side. Be certain the lateral alignment between the drive clutch and the driven clutch (4) is maintained while the cam upright bolts are tightened.

- Recheck chain tension before replacing the chain case cover.

To Remove Variable-Speed Drive Belt

- Remove the drive chain. Refer to paragraph To Remove Drive Chain.

- Remove the clutch guard assembly.

- Loosen the locknut (9, figure 5) and serrated washer (10). During reassembly, apply 10 foot-pounds torque to the locknut (9).

- Push the driven clutch toward the drive clutch sufficiently to allow removal of the variable-speed drive belt from the drive clutch.

- Remove the locknuts (7, figure 4) securing the bearing clamps (8) and remove the bearing clamps. During reassembly, apply 5 foot-pounds torque to the locknuts (7).

- Lift the driven clutch (9) and drive belt clear of the brake assembly (10) and remove the variable-speed drive belt.

- Install replacement drive belt. Use AMF Part No. 37172 on Model SD15P10B; AMF Part No. 1002110 on Model SD18P21A; AMF Part No. 1002147 on Model SD18E25B; and AMF Part No. 34914 on all other models.

NOTE: Variable-speed drive belt installation procedures are the reverse of removal except that the belt must first be placed around the driven clutch and then around the drive clutch. After installation, perform the drive chain adjustment, variable-speed belt adjustment and the drive clutch alignment procedures.

Variable-Speed Drive Belt Adjustment

Proper tension for a new drive belt should be obtained when the clutch centers are set to the B dimension shown in figure 6 for the applicable model snowmobile.

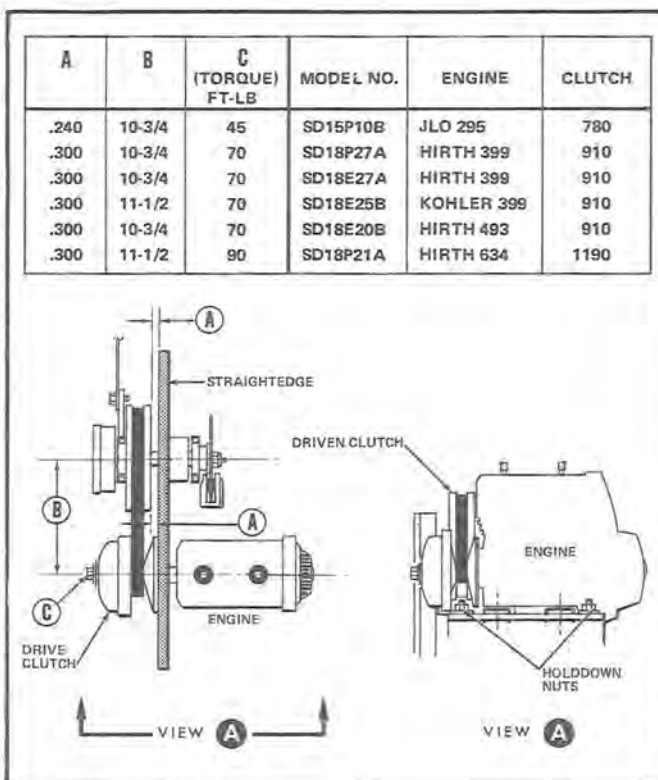


Figure 6

Proper tension for a used drive belt is obtained when opposite sides of the belt can be squeezed, between the drive clutches, to the following dimensions as measured between the top and bottom outside surface of the belt.

SD15P10B	2-3/4- to 3-1/4 inches
SD18P21A	4-1/4- to 4-3/4 inches
SD18P27A	4- to 4-1/2 inches
SD18E27A	4- to 4-1/2 inches
SD18E25B	4- to 4-1/2 inches
SD18E20B	4- to 4-1/2 inches

Measurement must be taken as close to the drive clutch flanges as possible. Be certain the driven clutch does not open when belt is squeezed.

IMPORTANT: Do not use antislip belt dressing. Belt slippage is a safety feature which prevents overstressing drive-system components.

- To adjust drive belt tension, loosen the locknut (9, figure 5) securing the clutch rod tensioner to the main frame assembly.

NOTE: If the drive belt is wearing unevenly, check alignment as described in Drive Clutch Alignment procedures.

- Move the driven clutch (4) in the direction required to obtain proper belt tension. Hold this position while tightening the locknut (9) to secure the clutch rod tensioner. Be certain the washer (10) and bar serrations are properly engaged. Apply 10 foot-pounds torque to the locknut (9).

To Remove Drive Clutch

- Remove the hood and headlight assembly. Refer to Hood Removal and Installation.

CAUTION

Always disconnect spark plug wires before working on the engine or drive elements.

- Remove the clutch guard assembly.
- Loosen the locknut (9, figure 5) and serrated washer (10) securing the clutch rod tensioner (11) to the main frame. During reassembly, apply 10 foot-pounds torque to the locknut (9).
- Push the driven clutch toward the drive clutch sufficiently to allow removal of the variable-speed drive belt from the drive clutch.
- To remove the drive clutch from Models SD15P-10B and SD18P21A only, remove the clutch adapter bolt and washer. If necessary, use a clutch puller and remove the drive clutch. During reassembly, apply 45 foot-pounds torque to the clutch adapter bolt on Model SD15P10B only, and 90 foot-pounds torque on Model SD18P21A. **NOTE:** If the clutch nut is removed from the drive clutch used on Model SD15P10B, reinstall the nut, apply 125 foot-pounds torque and be certain to engage the lockplate tangs.

- To remove the drive clutch from Models SD18P27A, SD18E27A, SD18E25B and SD18E20B, remove the clutch adapter bolt and washer, flatten the lock plate tangs and remove the clutch nut and lock plate. If necessary, use a clutch puller to remove the drive clutch. During reassembly, apply 150 foot-pounds torque to the clutch nut and then apply 70 foot-pounds torque to the clutch bolt. Be certain to engage the lock plate tangs.

- Reassembly is the reverse of removal. Perform variable-speed drive belt adjustment and drive clutch alignment procedures.

Drive Clutch Alignment

- Remove the hood and headlight assembly. Refer to Hood Removal and Installation.

CAUTION

Always disconnect spark plug wires before working on the engine or drive elements.

- Remove the clutch guard.
- Loosen the engine holddown nuts (figure 6) securing the engine supports to engine mount straps.
- Place a straightedge on the fixed face of the drive clutch and move the engine until the offset between the straightedge and the front and rear edges of the driven clutch is set to the A dimension as shown in figure 6. Rotate driven clutch 90-degrees and repeat procedure.
- Tighten engine holddown nuts and recheck alignment. Apply 25 foot-pounds torque when tightening the engine holddown nuts.

To Remove Driven Clutch

NOTE: The procedures required to remove the driven clutch are the same as those described in paragraph To Remove Variable-Speed Drive Belt.

To Remove Brake Assembly

- Remove hood and headlight assembly. Refer to Hood Removal and Installation.

CAUTION

Always disconnect the spark plug wires before working on the engine or drive elements.

- Disconnect brake cable and housing at brake mounting bracket and at brake actuating lever.
- Remove the two bolts and lockwashers securing the mounting bracket to the driven clutch mounting.
- Remove the brake assembly.
- Installation procedures are the reverse of removal. Refer to Brake Adjustment procedures.

Brake Adjustment

- To adjust the brake pads (5, figure 7) to the disk (1), remove the cotter pin (2) and tighten or loosen the castle nut (4) as required to permit the brake pads (5) to just clear the brake disk. Reinstall the cotter pin. To adjust for excessive play in brake cable or lever position, loosen jam nuts (6) and move brake housing (3) as required. Tighten jam nuts.

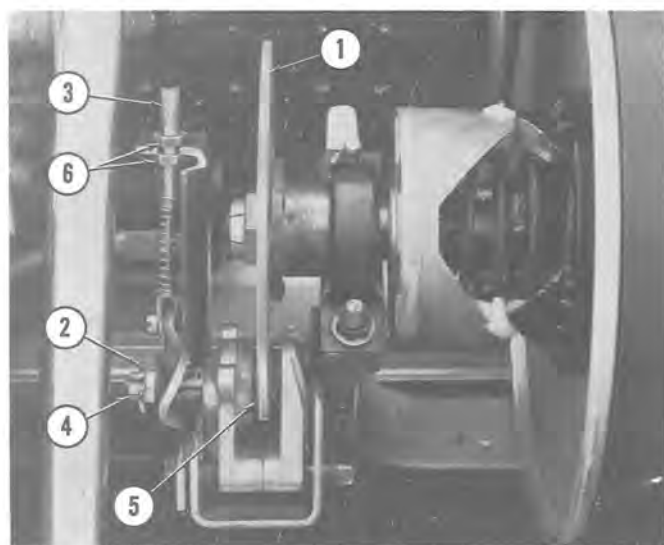


Figure 7

To Remove Carburetor

- Loosen the throttle and if used, the choke control cable adjustment screws and release both cables at the carburetor (see figure 8).
- Remove the screws securing the air intake filter or baffle (figure 9) and choke control bracket mounted on carburetor used on Models SD15P10B, SD18E20B and SD18E25B only.
- Remove the impulse line at the carburetor used on all models except SD15P10B.

- Release the tank-to-carburetor gas line (figure 8). Wipe up any spilled gasoline immediately. NOTE: On all Mark V series Ski-Daddlers, release the carburetor-to-tank recirculating gas line at the recirculation elbow. Be certain to note the position of the gas lines to insure proper reassembly. Wipe up any spilled gasoline immediately.

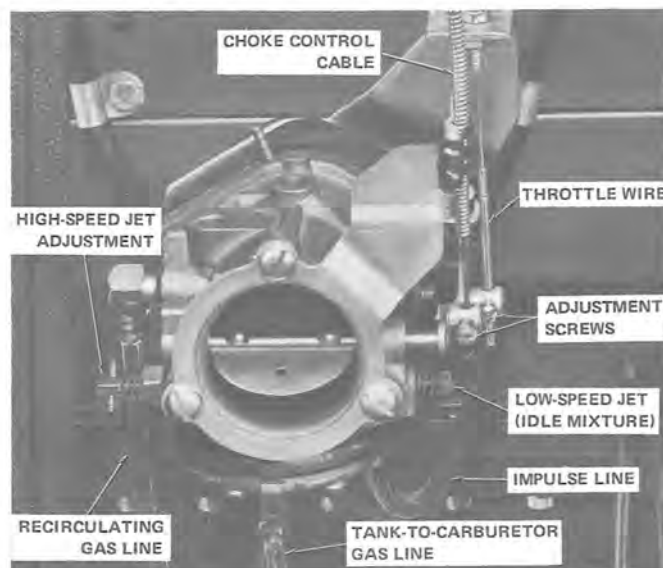


Figure 8

IMPORTANT: Model SD15P10B uses a fuel pump attached to the inside surface of the console tongue with two screws and nuts. If necessary to replace the fuel pump, be certain to note the position of the fuel lines to insure proper reassembly. Wipe up any spilled gasoline immediately.

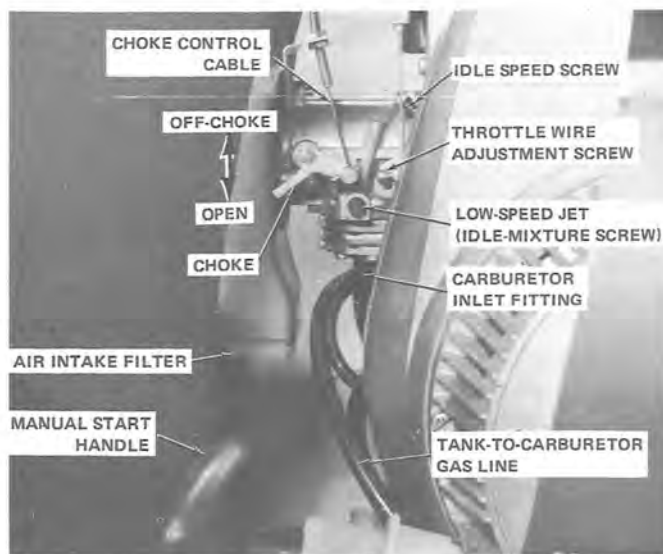


Figure 9

● Remove the nuts securing the carburetor to the intake manifold and remove the carburetor.

NOTE: Do not damage gaskets when removing carburetor.

● Installation is the reverse of removal. Adjust carburetor as described in Carburetor Adjustment procedures.

Carburetor Adjustments

The Tillotson Model HD and HR carburetors used on Ski-Daddler Models SD18E20B, SD18P27A, SD18E25B, SD18E27A and SD18P21A are equipped with a recirculation system.

CAUTION

Never run the engine with the carburetor-to-tank recirculating gas line disconnected (see figure 8)

The Bendix Model carburetor used on Ski-Daddler Model SD15P10B is a float type carburetor and does not require a recirculation system. The fuel is

pumped to the carburetor through an external fuel pump mounted on the console assembly. The carburetion system maintains a fuel reservoir in the float chamber to insure smooth starting and idling characteristics.

When adjusting the carburetor, best results will be obtained if the adjustments are made on a warm engine. During carburetor adjustments, DO NOT FORCE ADJUSTMENT SCREWS INTO SEATS.

● TO ADJUST CARBURETOR – Close the high-speed jet (DO NOT FORCE). Then open the high-speed jet (figure 8) to the settings shown on the carburetor settings chart for your particular engine (see figure 10).

The high- and low-speed jet adjustment screws for the Bendix carburetor used on Model SD15P10B are located on top of the carburetor and are identified as HI and LO.

CAUTION

The engine can be seriously damaged if operated with a lean gas mixture (high-speed jet turned in too far).

CARBURETOR SETTINGS CHART

MODEL NO.	ENGINE	HIGH-SPEED JET	LOW-SPEED JET
SD18E20B	Hirth 493	1 + 1/8 - 0 Open	1-1/8 + 1/8 - 0 Open
SD18E27A	Hirth 399	1 + 1/8 - 0 Open	1 + 1/8 - 0 Open
SD18P27A	Hirth 399	1 + 1/8 - 0 Open	1 + 1/8 - 0 Open
SD18P21A	Hirth 634	1-1/8 + 1/8 - 0 Open	1-1/8 + 1/8 - 0 Open
SD18E25B	Kohler 399	1-5/8 + 1/8 - 0 Open	1-1/8 + 1/8 - 0 Open
SD15P10B	JLO 295	1 + 1/8 - 0 Open	1-1/2 + 1/8 - 0 Open

NOTE: The carburetor settings shown are for normal operation at sea level. For high altitude operation and for extreme temperature variations, the settings may have to be adjusted accordingly.

Figure 10

● Turn the low speed jet (idle-mixture screw) shown in figure 8 all the way in (DO NOT FORCE), then open as shown in figure 10 for the particular model sled. This adjustment controls the mixture at idling speeds. A lean idle mixture will result in poor acceleration.

Keep the idle speed slower than the clutch engaging speed by adjusting the idle-speed screw. NOTE: Do not use the low-speed jet to adjust for idle speed.

NOTE: Figure 8 shows a throttle-wire adjustment screw. If the throttle plate fails to open completely when the throttle control lever is depressed, loosen the throttle-wire adjustment screw and readjust the wire as required to open the throttle.

To Remove Starting Motor Assembly—Models SD18E20B, SD18E25B and SD18E27A Only

● Remove the hood and headlight assembly. Refer to Hood Removal and Installation.

CAUTION

Always disconnect spark plug wire before working on the engine or drive elements.

● Disconnect the battery-to-solenoid positive (+) cable at the battery to prevent sparking and possible shorting.

● Disconnect the solenoid-to-starting motor cable at the starting motor.

● Back off the two nuts securing the starting motor assembly to the engine. Remove the engine wiring harness, ground wire and the battery-to-starting motor ground wire attached to the upper stud and remove the starting motor assembly.

● Reassembly is the reverse of removal.

To Remove Engine and Support Assembly—Models SD18E20B, SD18E25B, SD18E27A, SD18P27A and SD18P21A Only

● Remove the hood and headlight assembly. Refer to Hood Removal and Installation.

CAUTION

Always disconnect the spark plug wires before working on the engine or drive elements.

● Remove the console door assembly by turning the door fastener counterclockwise to release.

● Remove the screws, washers and locknuts securing the console tongue assembly to the tool box and to the mini-console (see figure 11).

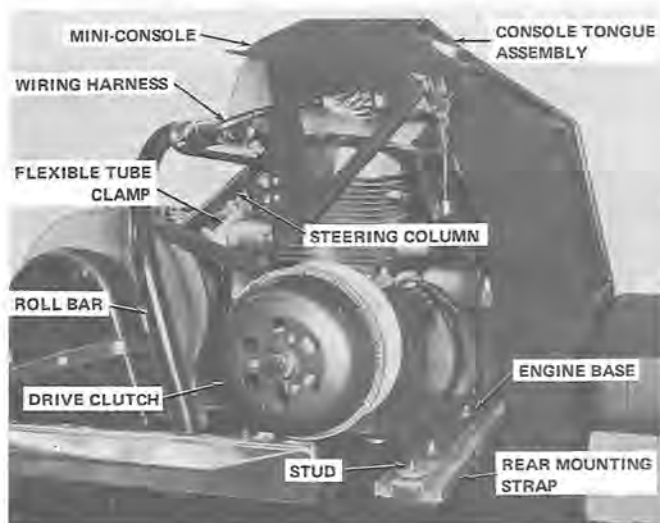


Figure 11

● Remove the drive clutch. Refer to paragraph To Remove Drive Clutch.

● Loosen the flexible tube clamps securing the muffler exhaust tube to the engine exhaust manifold and release the exhaust tubes.

● Disconnect the throttle and choke control cables and remove the carburetor as described in paragraph To Remove Carburetor.

● Remove the starting motor assembly. Refer to paragraph To Remove Starting Motor Assembly, Models SD18E20B, SD18E25B and SD18E27A only.

● Remove the heat shield located between the engine and the muffler. Remove the attaching hardware at the muffler bracket and/or heat shield bracket and at the top near the steering column.

- Remove the bolts (10, figure 12), spacers and nuts securing the steering linkage to the steering column arm (9). During reassembly, apply 15 foot-pounds torque to the nuts securing the steering linkage.

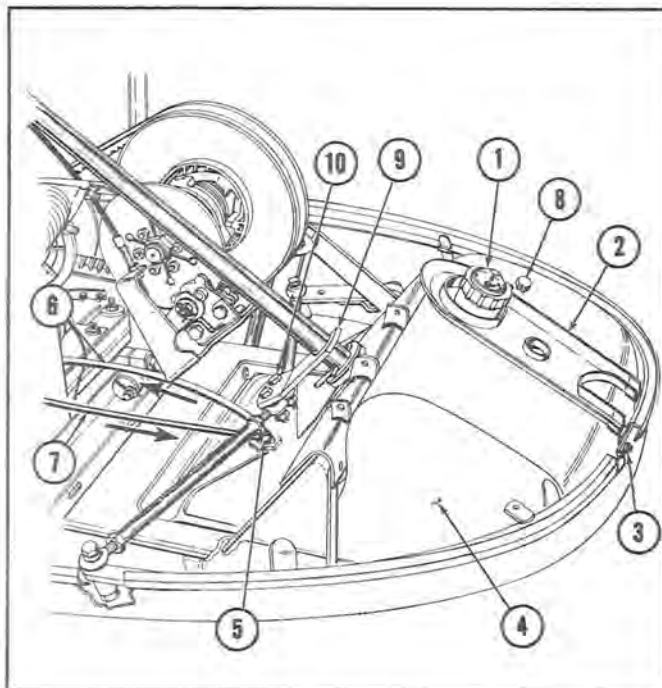


Figure 12

- Remove the bottom cotter pin securing the steering column to the main frame steering column support.

● On models equipped with an electric starter, disconnect the wiring harness at the battery, electrical panel, taillight and engine. Release the wire V-clips in the tool box and at the foot rest and remove the wiring harness. On manual start models disconnect the wiring harness at the taillight and engine. NOTE: Replace the metric nut after removing the black ground lead from the engine.

- Remove the two screws, formed washers and locknuts at each end of the roll bar and remove the roll bar, steering column and mini-console as a unit.

● Remove the locknuts and washers securing the engine mounting straps to the main frame studs, and remove the engine, engine base and mounting straps.

- Remove the carriage bolts, nuts and washers securing the engine mounting straps to the engine

base. Remove the straps for reassembly. During reassembly, apply 25-foot-pounds torque to the nuts securing the engine base.

- Installation is the reverse of removal.

To Remove Engine and Support Assembly—Model SD15P10B Only

- Remove the hood and headlight assembly. Refer to Hood Removal and Installation.

CAUTION

Always disconnect the spark plug wires before working on the engine or drive elements.

- Remove the console door assembly by turning the door fastener counterclockwise to release.

● Remove the six screws, washers and locknuts securing the console tongue assembly to the tool box and to the mini-console (see figure 11).

- Remove the drive clutch. Refer to paragraph To Remove Drive Clutch.

● Loosen the flexible tube clamps securing the muffler exhaust tube to the engine exhaust manifold and release the exhaust tubes.

- Disconnect the throttle and choke control cables and remove the carburetor as described in paragraph To Remove Carburetor.

● Disconnect the yellow wire lead and the black wire lead at the engine and the black ground wire lead at the starter cover. Replace the metric nut to secure the cover after removing the black wire lead.

● Remove the heat shield located between the engine and the muffler. Remove the attaching hardware at the muffler bracket, heat shield bracket and at the top near the steering column.

● Remove the locknuts and washers securing the engine mounting straps to the main frame. NOTE: During reassembly, tighten the locknuts just sufficiently to permit the washers to be turned by hand — then tighten the locknuts one additional turn.

- Lift the engine until the engine mounting straps clear the studs shown in figure 11. Rotate the engine

counterclockwise and remove the engine toward the rear and clear of the sled.

- Remove the carriage bolts, washers and locknuts securing the mounting straps to the engine base. Remove the mounting straps and bar washers. NOTE: During reassembly, the mounting straps and bar washer must be secured to the engine base before installing the replacement engine.

- Installation procedures are the reverse of removal.

To Remove Gas Tank

- Remove the hood and headlight assembly. Refer to Hood Removal and Installation.

CAUTION

Always disconnect spark plug wires before working on the engine or drive elements.

- Check gas cap and indicator assembly to be certain tank is empty, or nearly empty.

- Remove the gas cap and indicator assembly (1, figure 12).

- Remove the bolts (3) and washers securing the gas spill chute (2) to the main frame and remove the gas spill chute.

- Disconnect the tank-to-carburetor gas line (6) and the recirculating gas line (7) at the gas tank outlet fitting (5). Wipe up any spilled gasoline immediately.

- Remove the gas tank (4) by carefully sliding the tank up and away from main frame. IMPORTANT: Do not damage the gas tank outlet (5) when removing the tank.

CAUTION

Do not attempt to make any repairs to the gas tank. Use extreme care when removing the gas tank. Do not remove tank near flame or open fire.

- Gas tank installation procedures are the reverse of removal. NOTE: If the original tank is not to be installed, it will be necessary to remove the gas tank outlet (5) and the attached gas line filter; also the

pressure relief valve (8). These items are to be installed on the replacement tank.

To Remove Muffler

- Remove the hood and headlight assembly. Refer to Hood Removal and Installation.

CAUTION

Always disconnect the spark plug wires before working on the engine or drive elements.

- Loosen the flexible tube clamp securing the flexible exhaust tube to the muffler and release the tube. NOTE: All Mark V series Ski-Daddlers have dual exhaust tubes and muffler.

- Loosen the bolt and nut securing the muffler to the mounting band assembly. Remove the muffler.

- Installation procedures are the reverse of removal.

To Remove Bogie Wheel

CAUTION

Always disconnect the spark plug wires before working on the engine or drive elements.

- Raise back end of Ski-Daddler so that traction belt clears the ground.

- Remove the locknut (3, figure 13) securing the bogie wheel assembly (2) to the axle shaft and remove the wheel.

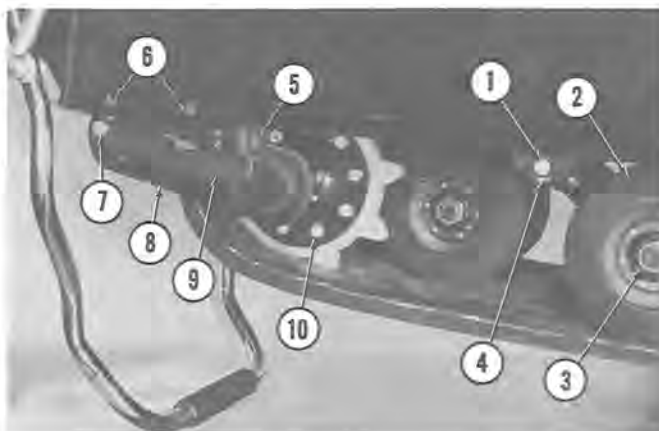


Figure 13

- During reassembly, torque the locknut (3) to 28 foot-pounds. Be certain the wheel assembly (2) is installed with grease fittings on the outside.

To Remove Bogie Wheel and Support Assembly

CAUTION

Always disconnect the sparkplug wires before working on the engine or drive elements.

- Raise back end of Ski-Daddler so traction belt clears the ground.
- Remove the screws (1, figure 13) and washers securing the bogie wheel support shaft (4) to the main frame.
- Remove the bogie wheel and support assembly.
- Reassembly is the reverse of removal.

To Remove Bogie Wheel Torsion Springs

- Remove the bogies as described in paragraph To Remove Bogie Wheel and Support Assembly.
- Remove the support shaft and separate the bogie wheel support halves.
- Pry the tabs up sufficiently to remove the torsion springs. NOTE: The torsion springs are identified as right- and left-hand springs. Note the direction of the coils and the position of the springs to facilitate reassembly.
- Reassembly is the reverse of removal.

To Remove Traction Belt Take-Up Assembly

- Remove the rear bogies. Refer to paragraph To Remove Bogie Wheel and Support Assembly.
- Release track tension by loosening adjusting bolts (5, figure 13).
- Release the support arm torsion springs connected to the main frame.
- Remove the right- and left-hand adjusting angle locknuts (6), washers and carriage bolts securing the traction belt take-up assembly to the main frame.

- Remove the traction belt take-up assembly as a unit.

NOTE: The traction belt take-up assembly consists of the rear sprocket assembly, spacer and associated hardware held together by the rear support arm assemblies. If necessary to remove seals, sprockets or idler wheel, proceed as follows.

- Carefully pry the oil seal away from the rear support arm assembly (8, figure 13) and remove the support arm and adjusting angle (9) clear of the sprocket shaft and bearing.
- Remove the press-on bearings and oil seals. During reassembly repack bearings with No. 2 lithium bearing grease.
- Remove the screws (10) and nuts securing the sprocket plate and the sprocket to the drive shaft. Remove the plate and sprocket.
- To remove the idler wheel, remove the screws (10) and nuts securing the sprocket plates and remove the idler wheel by stretching the wheel over the sprocket plates.

● Reassembly is the reverse of removal. During reassembly follow instructions outlined in paragraphs Track Alignment and Track Tension Adjustment.

To Remove Sprocket Seals and Bearings

- Sprocket seals and bearings are located on each end of the traction belt take-up assembly and the drive sprocket assembly drive shafts. To replace the seals or bearings it will be necessary to remove the traction belt take-up assembly or the drive sprocket assembly as described in the applicable paragraph.

To Remove Drive Sprocket Assembly

- Remove the hood and headlight assembly and set the machine on its right-hand side.

CAUTION

Always disconnect spark plug wires before working on the engine or drive elements.

- Remove the locknut securing the chain cover and remove the chain cover top.

- Remove the lower sprocket from the drive sprocket shaft and remove the sprocket and chain as described in paragraph To Remove Drive Chain.

- Remove the bogie wheel and support assemblies. Refer to paragraph To Remove Bogie Wheel and Support Assembly.

- Remove the traction belt take-up assembly. Refer to paragraph To Remove Traction Belt Take-Up Assembly.

- Using a screw driver, carefully pry the oil seals (figure 14) away from the bearings at each end of the drive shaft.

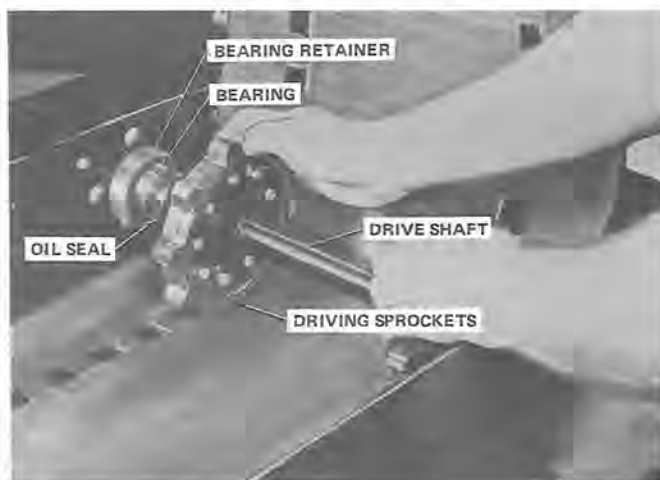


Figure 14

- Remove the carriage bolts and nuts securing the bearing retainer to the chain case side of the main frame. Remove the retainer. During reassembly apply No. 2 lithium bearing grease to the bearing retainers.

- Move the drive shaft and sprocket assembly toward the chain side until the opposite end of the shaft clears the bearing retainer. Remove the drive sprocket assembly.

- To replace the sprockets, remove the ball bearing and oil seal. Remove the screws and nuts securing the support plate and sprocket to the drive shaft and sprocket plate assembly. Remove the sprocket.

- Remove the screws and nuts securing the sprocket plates to the idler wheel. Remove the idler wheel by stretching wheel over the sprocket plate.

- Reassembly is the reverse of removal. During reassembly follow instructions outlined in the paragraphs Track Tension Adjustment, Track Alignment and Drive Chain Adjustment.

To Remove Traction Belt

- Remove the bogie assemblies. Refer to paragraph To Remove Bogie Wheel and Support Assembly.

- Remove the traction belt take-up assembly. Refer to paragraph To Remove Traction Belt Take-Up Assembly. NOTE: It is not necessary to disassemble the traction belt take-up assembly when removing the traction belt.

- Remove the drive sprocket assembly. Refer to paragraph To Remove Drive Sprocket Assembly.

- Remove the traction belt.

- Reassembly is the reverse of removal. During reassembly follow instructions given in paragraphs Traction Belt Alignment, and Drive Chain Adjustment.

Traction Belt Adjustment

IMPORTANT: The traction belt must be checked regularly for proper alignment and tension. When necessary to adjust the belt, first perform the traction belt alignment and then complete the traction

Traction Belt Tension Alignment

- Set the snowmobile on a level surface and raise the back end so the traction belt clears the ground.

- Stand to rear of sled and visually check the space between the frame tunnel and the edges of the traction belt. On a properly aligned track this space should be the same.

- If the track is not centered, loosen the two locknuts (1, figure 15) on that side where the edge of the track is closest to the inside edge of the tunnel. Tighten the adjusting screw (3) until track is centered.

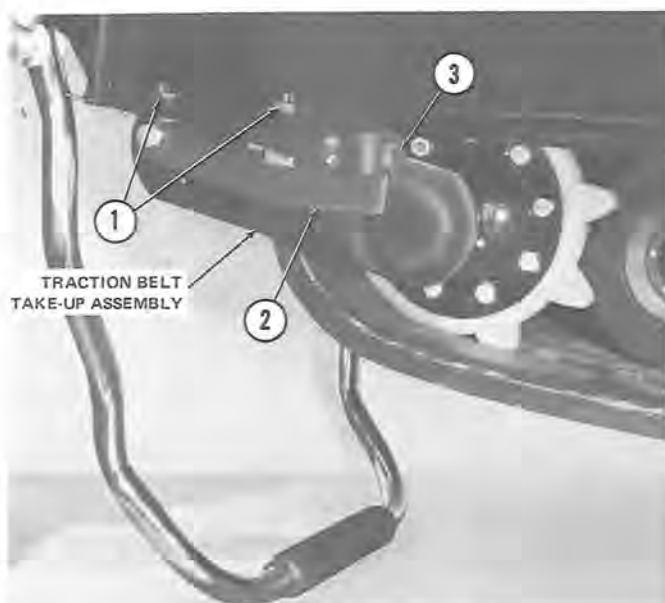


Figure 15

CAUTION

Never run the engine inside a building without first opening all doors and windows to insure proper ventilation.

- With the back end of the snowmobile raised, start the engine. Allow track to rotate several turns and then recheck track alignment to ensure that proper alignment is maintained.

- After track alignment is complete, tighten all locknuts (1) and then check traction belt tension as described in the following paragraph.

Traction Belt Tension Adjustment

IMPORTANT: Always check the traction belt for proper alignment before performing the traction belt tension adjustment procedures.

- Set the snowmobile on a clean, flat surface.

NOTE: A properly tensioned track should have a 1- to 1-1/4-inch sag at the approximate top center of the track except for Model SD18P21A, which

should have a 1/2- to 1-inch sag at the center. This can be determined as follows:

- Rest a straight bar (figure 16) of sufficient length along the top surface and near the edge of the track. Insert the straight bar through the back end of the snowmobile and check for proper sag. Repeat procedure on opposite side and note the difference, if any, in the track tension.

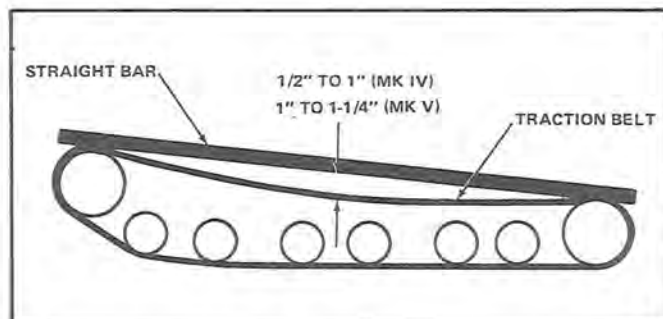


Figure 16

- If adjustment is necessary, loosen the two locknuts (1, figure 15) on each side of the sled just sufficiently to allow movement of the belt-adjusting angle (2).

- Turn the adjusting screws (3) clockwise to tighten and counterclockwise to loosen until proper track tension is achieved. **IMPORTANT:** Adjust both screws (3) equally so as not to disturb the track alignment.

CAUTION

Never run the engine inside a building without first opening all doors and windows to insure proper ventilation.

- Raise the back end of the snowmobile until the track clears the ground. Start the engine and allow track to rotate several turns. Then repeat the track tension adjustment procedure to ensure that proper tension is maintained.

- Retighten the locknuts (1) on both sides of the snowmobile.

Spark Plug Replacement

To maintain good engine performance the condition of the spark plugs should be checked periodically and the gap reset to 0.020-inch using feeler gauge.

During reassembly, apply 18 to 20 foot pounds torque.

Spark plug condition may be determined by the color. A carbonized plug is black; a burnt plug is pale grey, whereas a normal functioning spark plug is brown.

certain the gas tank-to-carburetor line used on all Mark V series Ski-Daddlers is connected to the OUT fitting on the gas tank outlet and to the inlet fitting on the carburetor. The recirculating, carburetor-to-tank line must be connected to the IN fitting on the gas tank outlet (figure 12) and to the recirculating elbow (figure 8).

SPARK PLUG CONVERSION CHART

MODEL NO.	ENGINE	LIGHT SERVICE		SEVERE SERVICE	
		CHAMPION	AC	CHAMPION	AC
SD18E20B	Hirth 493	K-8	*	K-7	SN82F
SD18E27A	Hirth 399	K-8	*	K-7	SN82F
SD18P27A	Hirth 399	K-8	*	K-7	SN82F
SD18P21A	Hirth 634	K-7	SN82F	K-60R	SN82F
SD18E25B	Kohler 399	K-8	*	K-7	SN82F
SD15P10B	JLO 295	K-9	SN83F	K-8	SN82F

*No AC conversion for light service spark plug.

When replacing spark plugs, refer to the preceding chart to insure proper spark plug heat ranges for your particular engine. NOTE: Replacement plugs should be U.S. Champion, AC spark plugs or equivalent available at your authorized Ski-Daddler Dealer.

Wiring Diagrams

Electrical wiring diagrams are provided for the trained technicians using this manual. Each diagram is identified with the model number of the snowmobile to which it applies (see figures 17, 18, 19 and 20).

Troubleshooting

ENGINE HARD TO START. Fuel line blocked or leaking; ruptured fuel-pump diaphragm; water in fuel, flooded, loose impulse line; ignition or switch wiring loose or grounded; spark plug(s) fouled or faulty; contact breaker points pitted or burned.

ENGINE STOPS. Fuel tank empty; fuel flow obstructed; ignition system faulty. Spark plug(s) fouled or dirty. Engine too hot and pistons seizing; carburetor setting too lean or incorrect grade of oil being used, impulse line loose.

ENGINE STOPS, FUEL TANK HALF EMPTY. Be

ENGINE OPERATES IRREGULARLY. Spark plug loose, fouled or faulty; ignition switch wiring grounded; carburetor out of adjustment or dirty. Engine holddown bolts loose; ignition timing off.

ENGINE WORKING FOUR-STROKE. Choke shut; carburetor settings incorrect; dirt preventing carburetor inlet needles from seating properly.

ENGINE LOSES POWER. Poor compression due to loose head and crankcase bolts. Faulty ignition; timing; piston rings sticking due to the use of improper oil. Carbon deposits in cylinder.

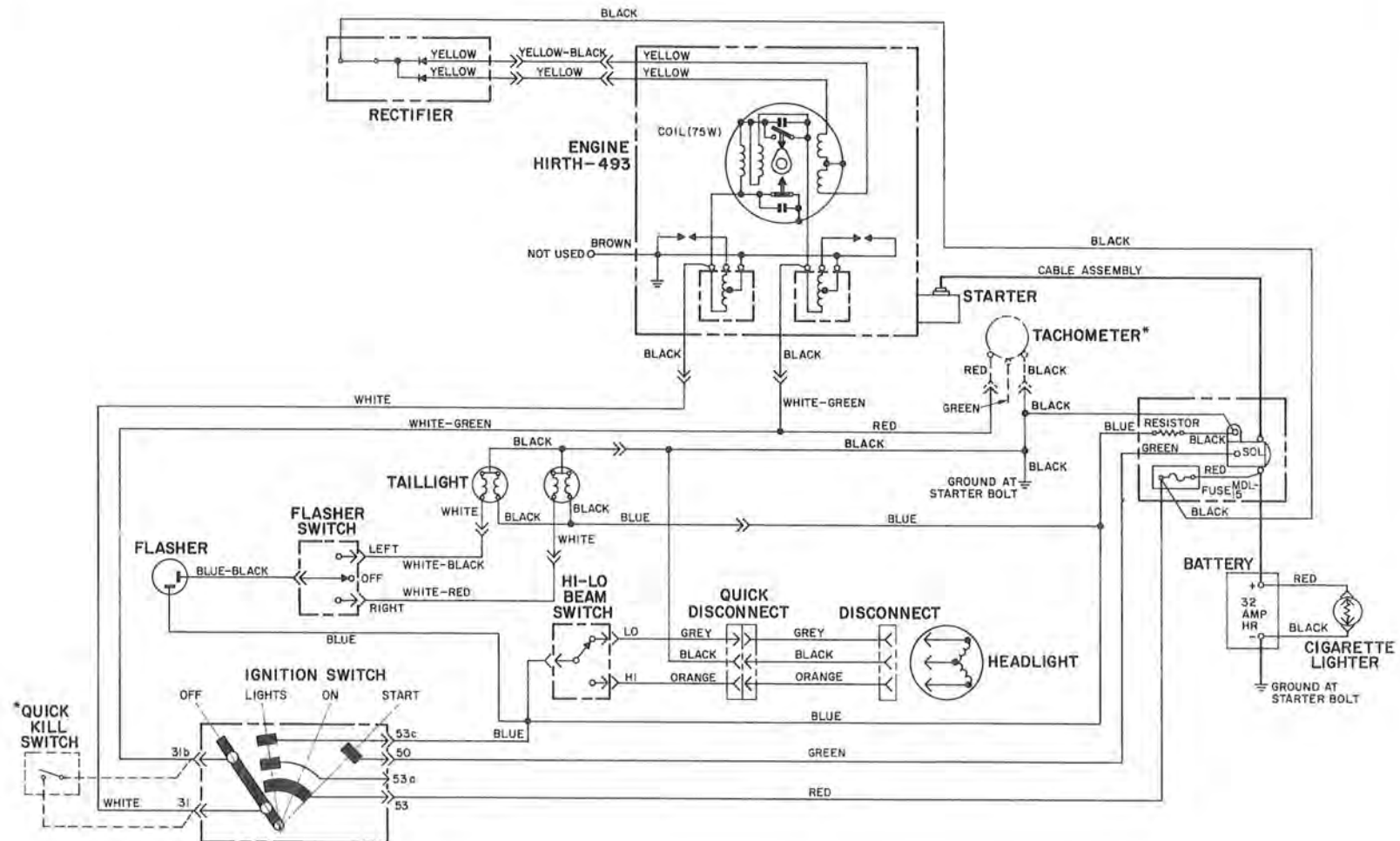
ENGINE BACKFIRES THROUGH CARBURETORS. Carburetor fuel-supply channel clogged. Carburetor set too lean.

ENGINE BACKFIRES THROUGH EXHAUST. Incorrect or faulty spark plug(s); faulty ignition coil or condenser; loose ignition wiring.

ENGINE OVERHEATS. Insufficient or incorrect grade oil in fuel mixture; carburetor or fuel line partly clogged; carburetor setting too lean; ignition timing too slow.

EXCESSIVE FUEL CONSUMPTION. Carburetor fuel line or gas tank leaking; choke closed; incorrect carburetor setting.

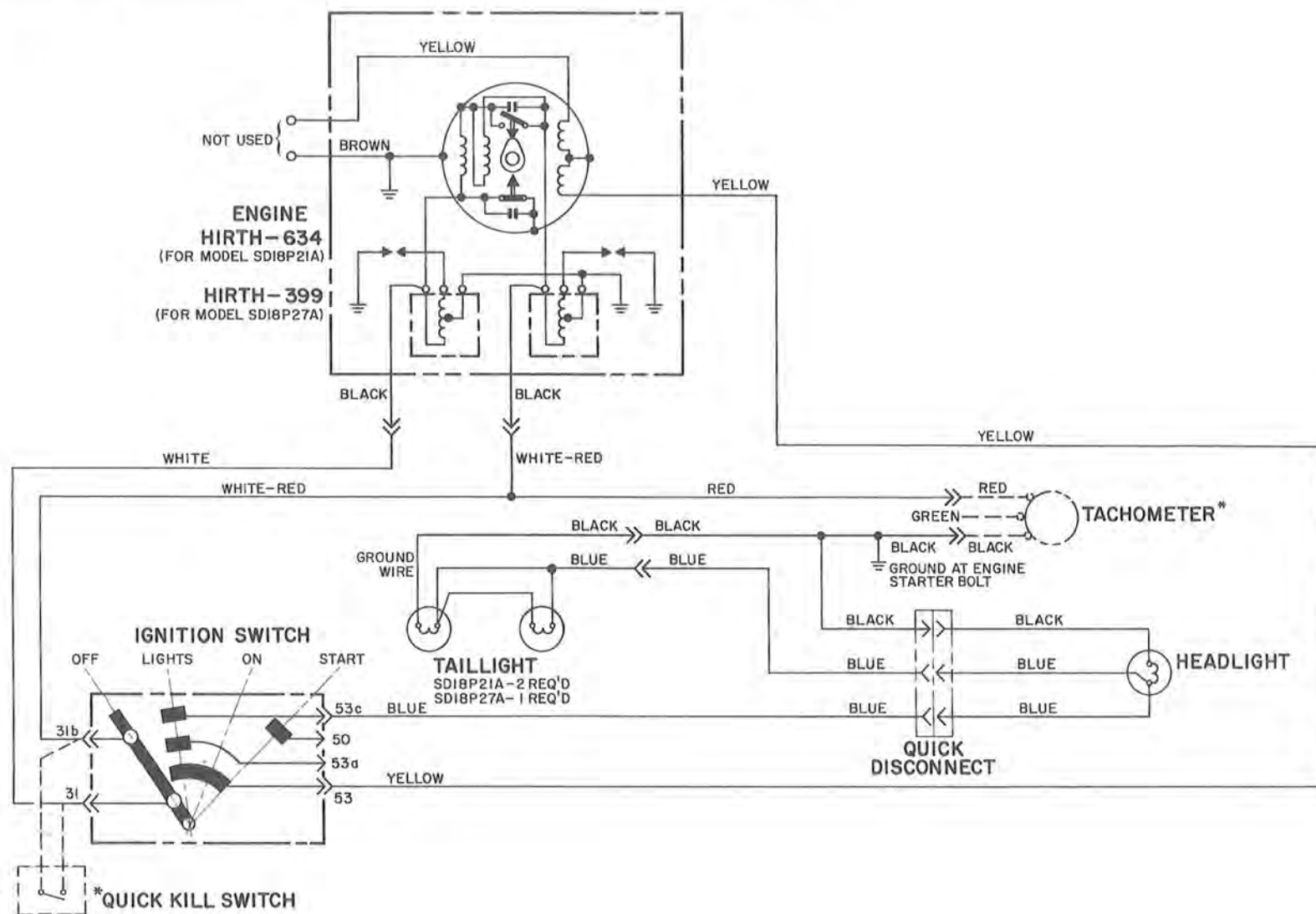
WIRING DIAGRAM, MODEL SD18E20B



*OPTIONAL EQUIPMENT

Figure 17

WIRING DIAGRAM, MODELS SD18P21A and SD18P27A



*OPTIONAL EQUIPMENT

Figure 18

WIRING DIAGRAM, MODELS SD18E25B and SD18E27A

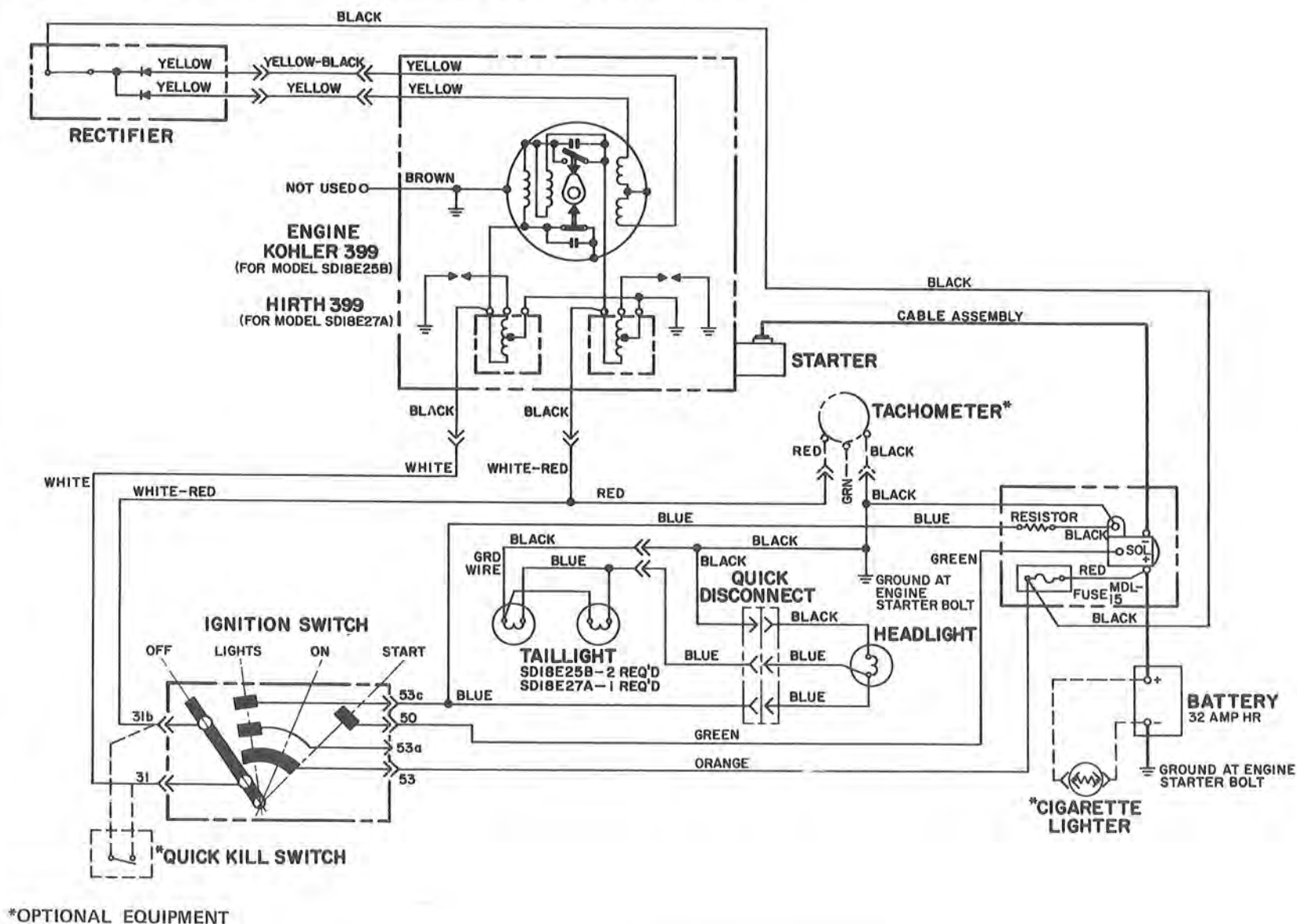
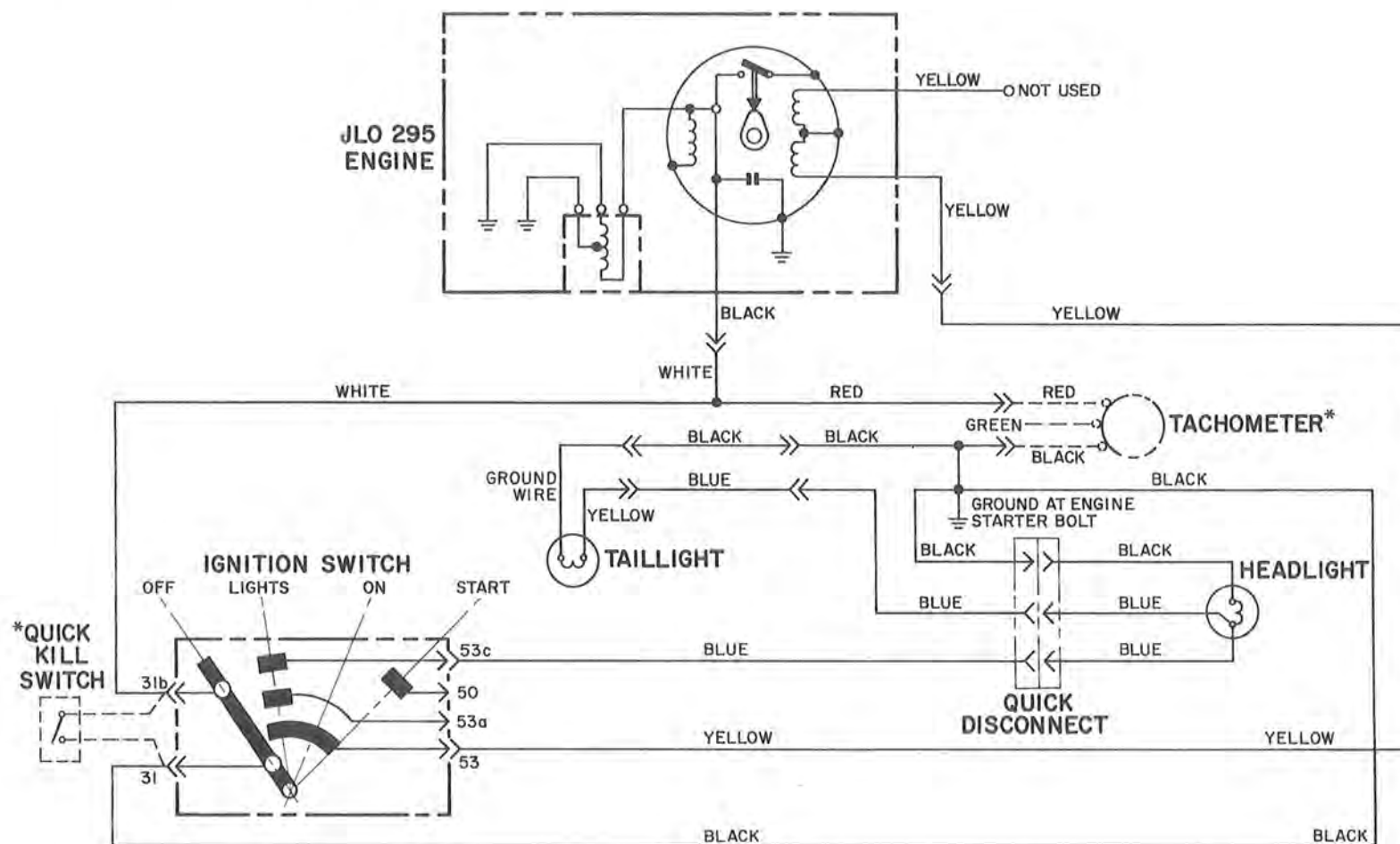


Figure 19

WIRING DIAGRAM, MODEL SD15P10B



*OPTIONAL EQUIPMENT

Figure 20

THROTTLE CONTROL. Excessive play in throttle control lever caused by loose throttle control cable.

STEERING. Poor steering ability caused by improperly adjusted skis; steering linkage loose or out of adjustment. U-bracket bolts on roll bar too tight or too loose. Spring, U-bracket loose.

BRAKES. Excessive play in handbrake due to loose brake cable or worn pads.

TRACTION BELT. Poor traction; check traction belt for alignment and tension; worn sprockets or flipped bogies.

CLUTCH. Automatic clutch fails to engage at

proper RPM's (see figure 21). Check variable-speed drive belt for proper tension and alignment.

CLUTCH ENGAGEMENT SPEEDS		
CLASS	ENGINE	ENGINE RPM
MARK IV	JLO 295	2300 to 2500
MARK V-400	Hirth 399	2400 to 2600
MARK V-400E	Hirth 399	2400 to 2600
MARK V-400DE	Kohler 399	2400 to 2600
MARK V-500DE	Hirth 493	2200 to 2400
MARK V-640	Hirth 634	2500 to 2700

Figure 21

ILLUSTRATED PARTS LIST

This section of the dealer's manual consists of an illustrated parts list and a numerical index.

PARTS LIST

The parts-list consists essentially of exploded-view illustrations keyed to the figure-reference column by index numbers. The Parts List is arranged in the in the following columns:

Figure-and-Index Number. The number preceding the dash refers to the figure number on which the item is shown. The number following the dash is the index number keyed to the item shown on the exploded view.

Part Number. The part number column identifies the item by its assigned part number.

Description. The description column identifies the part with descriptive nomenclature and identifies the model Ski-Daddler for which the part applies. If no model designation follows the part nomenclature, the part applies to all models covered in the particular figure.

Quantity. This column provides the total number of items required per assembly.

NUMERICAL INDEX

The numerical index is provided to afford dealers and distributors with a means of determining to which models their stock applies. The index consists of the following three columns:

Part-Number Column. The part-number column tabulates all parts called out in the parts list. The part numbers are listed in numerical order starting with the first digit in the number.

Index-Number Column. The index-number column reflects the figure-and-index number of the part within the parts list. The number preceding the dash refers to the figure number on which the item is shown. The number following the dash locates the item within the given figure.

Quantity Column. The quantity column reflects the total number of parts required for the particular figure-and-index-number application. In certain cases, quantities differ between sled models. This circumstance is covered by providing the larger quantity for the particular figure-and-index number. In referring to the given figure-and-index number in the parts-list section, the proper quantity per sled may be determined.

Addendum. Numbers added.

Figure & Index Number	Part Number	Description	Qty
1-	1002001	SKI-DADDLER, MARK V, MODEL NO. SD18E20B	1
	1002004	SKI-DADDLER, MARK V, MODEL NO. SD18P27A	1
	1002012	SKI-DADDLER, MARK V, MODEL NO. SD18E25B	1
	1002003	SKI-DADDLER, MARK V, MODEL NO. SD18E27A	1
	1002005	SKI-DADDLER, MARK V, MODEL NO. SD18P21A	1
	1002000	SKI-DADDLER, MARK IV, MODEL NO. SD15P10B	1
-1	34985	HOOD AND HEADLIGHT ASSEMBLY (Used on SD18E20B only) (See figure 2)	1
	1002168	HOOD AND HEADLIGHT ASSEMBLY (Used on SD18E27A and SD18E25B only) (See figure 2)	1
	1002167	HOOD AND HEADLIGHT ASSEMBLY (Used on SD18P27A and SD18P21A only) (See figure 2)	1
	1002154	HOOD AND HEADLIGHT ASSEMBLY (Used on SD15P10B only) (See figure 2)	1
-2	37030	WINDSHIELD, 15 IN. (Used on SD15P10B only)	1
	37029	WINDSHIELD, 18 IN. (Used on SD18E20B, SD18P27A, SD18E25B, SD18E27A and SD18P21A only)	1
-3	37080	BUMPER ASSEMBLY, RH (Used on SD15P10B only) (See figure 2)	1

Figure 1. Sheet 1 of 2

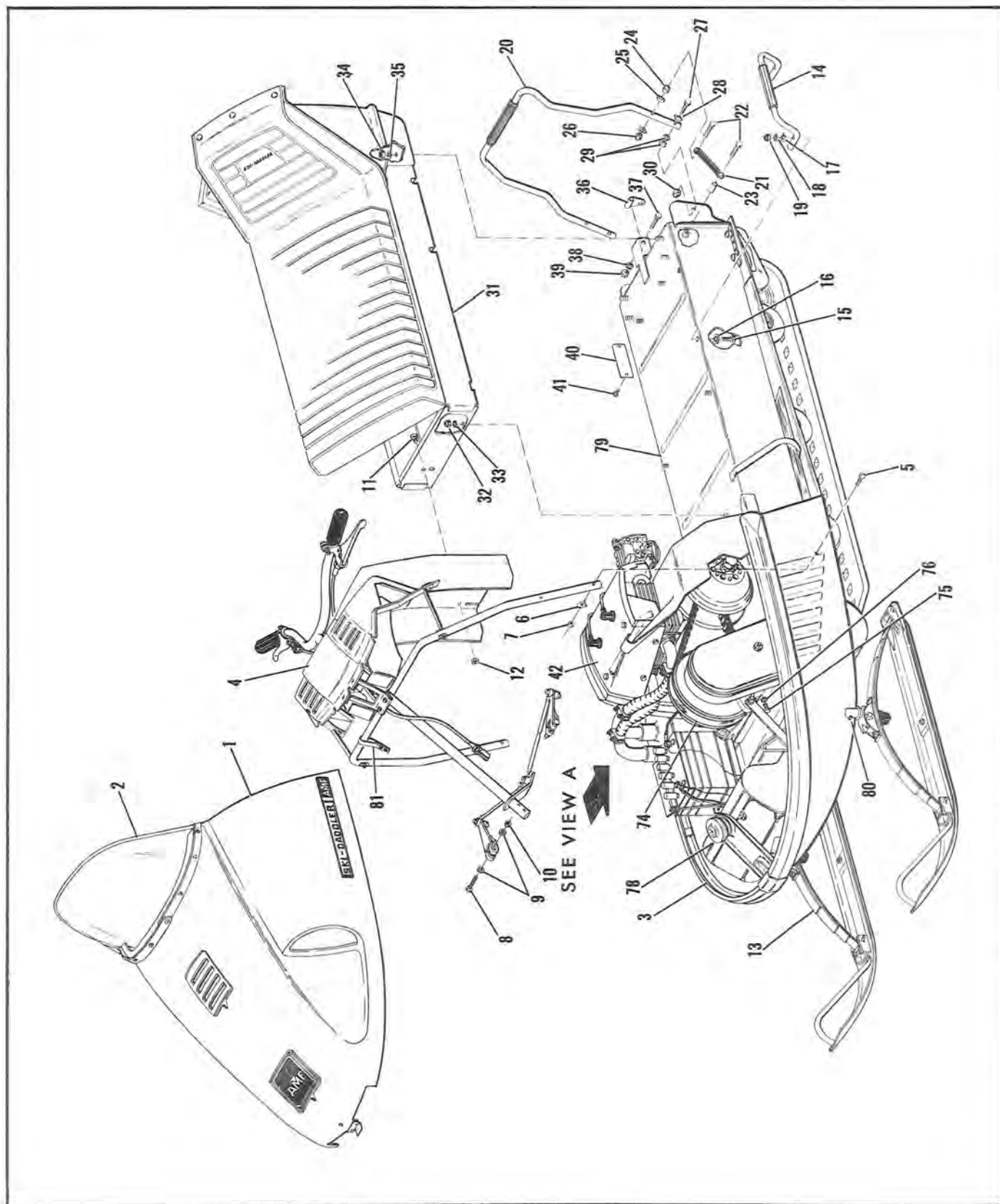


Figure & Index Number	Part Number	Description	Qty
1-	35000	BUMPER ASSEMBLY, RH (Used on SD18E20B, SD18P27A, ... SD18E25B, SD18E27A and SD18P21A only) (See figure 2)	1
	37081	BUMPER ASSEMBLY, LH (Used on SD15P10B only) (See figure 2)	1
	35001	BUMPER ASSEMBLY, LH (Used on SD18E20B, ... SD18P27A, SD18E25B, SD18E27A and SD18P21A only) (See figure 2)	1
-4	1002242	CONSOLES AND STEERING ASSEMBLY (Used on SD15P10B only) (See figure 3)	1
	1002243	CONSOLES AND STEERING ASSEMBLY (Used on SD18E20B only) (See figure 3)	1
	1002244	CONSOLES AND STEERING ASSEMBLY (Used on SD18E25B only) (See figure 3)	1
	1002245	CONSOLES AND STEERING ASSEMBLY (Used on SD18P27A only) (See figure 3)	1
	1002246	CONSOLES AND STEERING ASSEMBLY (Used on SD18E27A only) (See figure 3)	1
	1002247	CONSOLES AND STEERING ASSEMBLY (Used on SD18P21A only) (See figure 3)	1
-5	9415426	SCREW, Truss HD, 1/4-28 THD by 1-1/2 IN. LG	4
-6	33808	WASHER, Formed	4
-7	9000123	LOCKNUT, 1/4-28 THD	4
-8	181648	SCREW, HEX HD, 3/8-24 THD by 2 IN. LG	2
-9	120394	WASHER, Plain, 13/32 IN. ID	4
-10	9000125	LOCKNUT, 3/8-24 THD	2
-11	9000302	SCREW, Truss HD, 1/4-28 THD by 5/8 IN. LG (Used on SD18E20B, SD18E25B and SD18P21A only)	2
-12	9000123	LOCKNUT, 1/4-28 THD (Used on SD18E20B, ... SD18E25B and SD18P21A only)	2
-13	37245	SKI AND SPRING ASSEMBLY (Used on SD15P10B only) (See figure 3)	2
	1002278	SKI AND SPRING ASSEMBLY (Used on SD18E20B, ... SD18P27A, SD18E25B, SD18E27A and SD18P21A only) (See figure 3)	2
-14	37184	REAR HANDLE ASSEMBLY (Used on SD18E20B, ... SD18E25B and SD18P21A only)	2
-15	181573	BOLT, HEX HD, 1/4-28 THD by 1-1/4 IN. LG (Used on SD18E20B, SD18E25B and SD18P21A only)	4
-16	9416904	WASHER, Plain, 9/32 IN. ID by 1 IN. OD (Used on SD18E20B, SD18E25B and SD18P21A only)	4
-17	33808	WASHER, Formed (Used on SD18E20B, SD18E25B and SD18P21A only)	4
-18	446188	WASHER, Plain (Used on SD18E20B, SD18E25B and SD18P21A only)	4
-19	9000123	LOCKNUT, 1/4-28 THD (Used on SD18E20B, SD18E25B and SD18P21A only)	4
-20	37175	KICKSTAND ASSEMBLY (Used on SD18E20B, SD18E25B and SD18P21A only)	1
-21	32234	SPRING, Kickstand (Used on SD18E20B, SD18E25B and SD18P21A only)	2
-22	181578	BOLT, HEX HD, 1/4-28 THD by 1-7/8 IN. LG (Used on SD18E20B, SD18E25B and SD18P21A only)	4

Figure & Index Number	Part Number	Description	Qty
1-23	37186	SPACER, Long (Used on SD18E20B, SD18E25B and SD18P21A only)	2
-24	33778	SPACER, Short (Used on SD18E20B, SD18E25B and SD18P21A only)	2
-25	33808	WASHER, Formed (Used on SD18E20B, SD18E25B and SD18P21A only)	4
-26	9000123	LOCKNUT, 1/4-28 THD (Used on SD18E20B, SD18E25B and SD18P21A only)	4
-27	181575	BOLT, HEX HD, 1/4-28 THD by 1-1/2 IN. LG (Used on SD18E20B, SD18E25B and SD18P21A only)	2
-28	33808	WASHER, Formed (Used on SD18E20B, SD18E25B and SD18P21A only)	2
-29	446188	WASHER, Flat (Used on SD18E20B, SD18E25B and SD18P21A only)	4
-30	9000123	LOCKNUT, 1/4-28 THD (Used on SD18E20B, SD18E25B and SD18P21A only)	2
-31	37764	REAR CONSOLE, SEAT AND TOOL BOX ASSEMBLY (Used on SD18E20B only) (See figure 4)	1
	1002127	REAR CONSOLE, SEAT AND TOOL BOX ASSEMBLY (Used on SD18E25B and SD18P21A only) (See figure 4)	1
	1002169	SEAT AND TOOL BOX ASSEMBLY (Used on SD18P27A and SD18E27A only) (See figure 5)	1
	1002157	SEAT AND TAIL LAMP ASSEMBLY (Used on SD15P10B only) (See figure 5) ...	1
-32	9000123	LOCKNUT, 1/4-28 THD (Used on SD18E20B, SD18E25B and SD18P21A only)	6
	9000123	LOCKNUT, 1/4-28 THD (Used on SD18P27A and SD18E27A only)	4
-33	446188	WASHER, Plain, 17/64 IN. ID by 5/8 IN. OD (Used on SD18E20B, SD18E25B and SD18P21A only)	6
	446188	WASHER, Plain, 17/64 IN. ID by 5/8 IN. OD (Used on SD18P27A and SD18E27A only)	4
-34	9000124	LOCKNUT, 5/16-24 THD (Used on SD18E20B, SD18E25B and SD18P21A only)	4
	9000124	LOCKNUT, 5/16-24 THD (Used on SD18P27A and SD18E27A only)	2
-35	274865	WASHER, Plain (Used on SD18E20B, SD18E25B and SD18P21A only)	4
-36	37351	HINGE, Hitch	1
-37	181581	BOLT, HEX HD, 1/4-28 THD by 2-1/2 IN. LG	1
-38	120392	WASHER, Plain, 9/32 IN. ID by 5/8 IN. OD	1
-39	9000123	LOCKNUT, 1/4-28 THD	1
-40	37122	MODEL TAG, Ski-Daddler	1
-41	9000821	POP RIVET	2
-42	1002139	ENGINE AND SUPPORT ASSEMBLY (Used on SD15P10B only) (See figure 6)	1
	1002148	ENGINE AND SUPPORT ASSEMBLY (Used on SD18E20B only) (See figure 7)	1
	1002115	ENGINE AND SUPPORT ASSEMBLY (Used on SD18P27A only) (See figure 7)	1
	1002116	ENGINE AND SUPPORT ASSEMBLY (Used on SD18E27A only) (See figure 7)	1

Figure & Index Number	Part Number	Description	Qty
1-	1002123	ENGINE AND SUPPORT ASSEMBLY (Used on SD18P21A only) (See figure 7)	1
	1002172	ENGINE AND SUPPORT ASSEMBLY (Used on SD18E25B only) (See figure 7)	1
-43	9000324	BOLT, Carriage, 3/8-24 THD by 2-1/4 IN. LG	4
-44	32532	NUT	4
-45	32528	BUSHING	4
-46	33769	SPACER, Rubber	4
-47	37595	WASHER, 13/32 IN. ID by 1-1/2 IN. OD (Used on 3 mounts only-see item 53)	4
-48	9000125	LOCKNUT, 3/8-24 THD	4
-49	33768	SHOCK MOUNT (Used on SD18E20B, SD18P27A, SD18E27A, ... and SD18P21A only)	4
-50	1002366	HEAT SHIELD ASSY (Used on SD18E25B and SD18P21A only) ...	1
	37698	HEAT SHIELD ASSEMBLY (Used on SD18E20B, ... SD18P27A, SD18E27A and SD15P10B only)	1
-51	9000911	GROMMET, Heat shield	2
-52	37801	PAD, Heat shield (Used on SD18E20B, SD18E25B, SD18P21A, ... SD18E27A and SD15P10B only)	1
-53	37343	HEAT SHIELD (Used on SD18E20B, SD18P27A, ... SD18E27A, and SD15P10B only)	1
	1002364	HEAT SHIELD (Used on SD18E25B and SD18P21A only)	1
-54	37778	SPACER, Heat shield	1
-55	9000302	SCREW, Truss HD, 1/4-28 THD by 5/8 IN. LG	3
		(Used on SD18E20B, SD18P27A, SD18E27A, SD18P21A and SD15P10B only)	
	181561	SCREW, HEX HD, 1/4-28 THD by 1/2 IN. LG	2
		(Used on SD18E25B only)	
-56	120392	WASHER, Plain (Used on SD18E20B, SD18P27A, ... SD18E27A, SD18P21A and SD15P10B only)	3
	120392	WASHER, Plain (Used on SD18E25B only)	4
-57	9000123	LOCKNUT, 1/4-28 THD (Used on SD18E20B, ... SD18P27A, SD18E27A, SD18P21A and SD15P10B only)	3
	9000123	LOCKNUT, 1/4-28 THD (Used on SD18E25B only)	4
-58	1002238	WASHER ASSEMBLY (Used on SD18E20B, SD18P27A, ... SD18E27A and SD15P10B only)	1
-59	37765	BATTERY SUPPORT AND ELECTRICAL ASSEMBLY	1
		(Used on SD18E20B only) (See figure 7)	
	1002198	BATTERY SUPPORT AND ELECTRICAL ASSEMBLY	1
		(Used on SD18E25B and SD18E27A only) (See figure 7)	
-60	181566	BOLT, HEX HD, 1/4-28 THD by 3/4 IN. LG	2
		(Used on SD18E20B, SD18E25B and SD18E27A only)	
-61	181003	BOLT, HEX HD, 1/4-28 THD by 5/8 IN. LG	2
		(Used on SD18E20B, SD18E25B and SD18E27A only)	
-62	120392	WASHER, Plain, 9/32 IN. ID by 5/8 IN. OD	4
		(Used on SD18E20B, SD18E25B and SD18E27A only)	
-63	9000123	LOCKNUT, 1/4-28 THD (Used on SD18E20B, SD18E25B and SD18E27A only)	4
-64	1002091	TRACTION BELT TAKE-UP ASSEMBLY (Used on SD18E20B ... SD18P27A, SD18E25B, SD18E27A and SD18P21A only)	1
		(See figure 8)	
	1002092	TRACTION BELT TAKE-UP ASSEMBLY (Used on SD15P10B ... only) (See figure 8)	1

Figure 1. Sheet 2 of 2

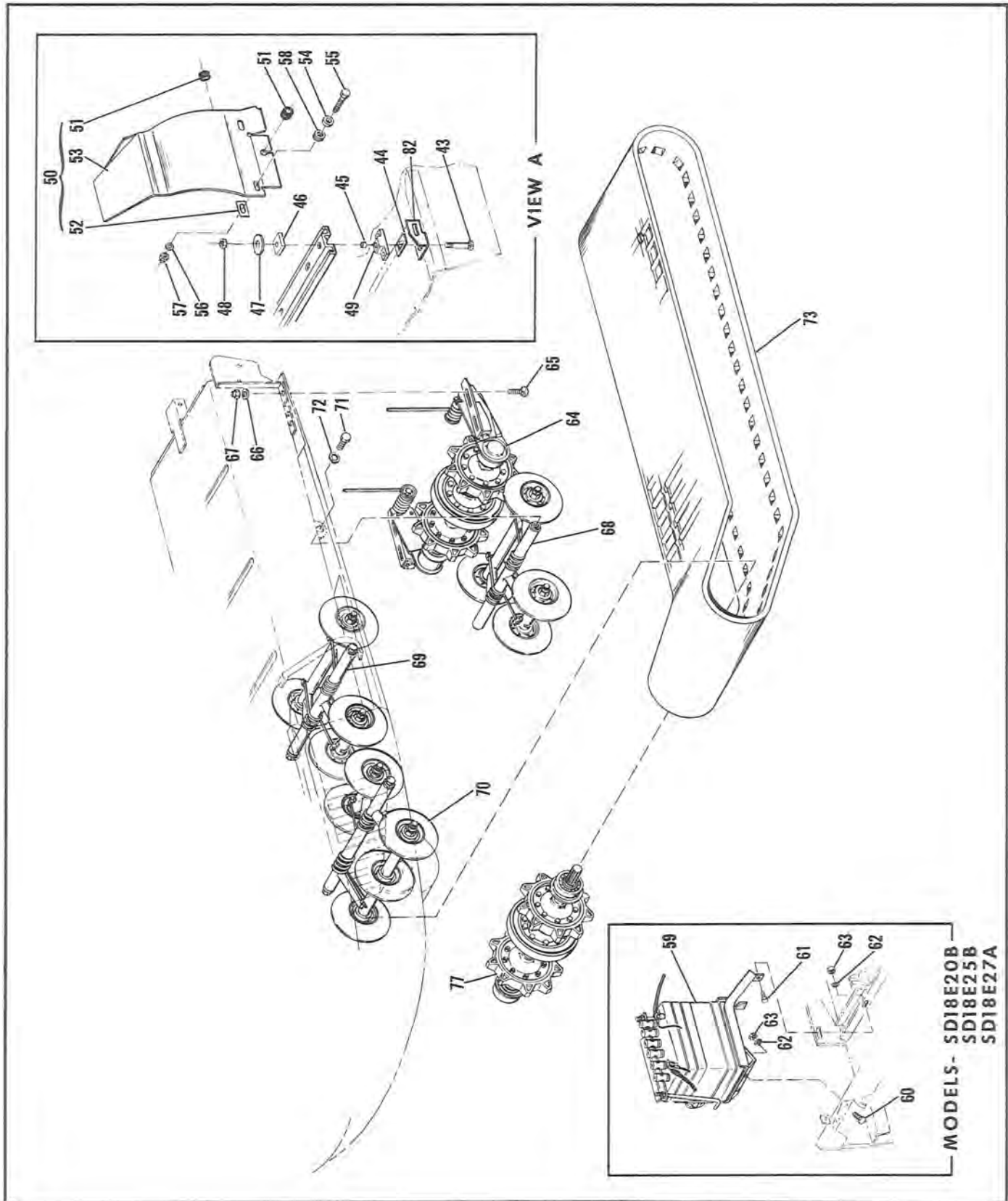


Figure & Index Number	Part Number	Description	Qty
1-65	9000322	BOLT, Carriage, 5/16-24 THD by 3/4 IN. LG	2
-66	456145	WASHER, Flat, 5/16 IN. ID	2
-67	9000124	LOCKNUT, 5/16-24 THD	2
-68	37083	BOGIE ASSY (Used on SD15P10B only) (See figure 9)	3
-69	34901	BOGIE ASSY, Middle and rear (Used on SD18E20B, SD18P27A, SD18E25B, SD18E27A and SD18P21A only) (See figure 9)	2
-70	1002111	BOGIE ASSY, Front (Used on SD18E20B, SD18P27A, SD18E25B, SD18E27A and SD18P21A only) (See figure 9)	1
-71	181595	SCREW, HEX HD, 5/16-24 THD by 3/4 IN. LG	6
-72	138485	WASHER, Lock	6
-73	34960	BELT, Traction, 15-inch (Used on SD15P10B only)	1
	37145	BELT, Traction, 18-inch (Used on SD18E20B, SD18P27A, SD18E25B and SD18E27A only)	1
	1002170	BELT, Traction, 18-inch (Used on SD18P21A only)	1
-74	1002200	DRIVEN CLUTCH AND CASTING ASSY (Used on SD18E20B only) (See Fig.10)	1
	1002201	DRIVEN CLUTCH AND CASTING ASSY (Used on SD18E25B only) (See Fig. 10)	1
	1002202	DRIVEN CLUTCH AND CASTING ASSY (Used on SD18P21A only) (See Fig. 10)	1
	1002203	DRIVEN CLUTCH AND CASTING ASSY (Used on SD18P27A and SD18E27A only) (See figure 10)	1
	1002140	DRIVEN CLUTCH AND CASTING ASSY (Used on SD15P10B only) (See Fig. 10)	1
-75	181643	BOLT, HEX HD, 3/8-24 THD by 1-1/2 IN. LG	2
-76	120382	WASHER, Spring lock	2
-77	37113	DRIVE SPROCKET ASSY (Used on SD15P10B only) (See figure 10)	1
	34929	DRIVE SPROCKET ASSY (Used on SD18E20B, SD18P27A, SD18E25B and SD18E27A only) (See figure 10)	1
	37762	DRIVE SPROCKET ASSY (Used on SD18P21A only) (See figure 10)	1
-78	37683	GAS CAP ASSY, Tank (See figure 11)	1
-79	1002076	MAIN FRAME ASSY - Weldment (Used on SD15P10B only)	1
	1002077	MAIN FRAME ASSY - Weldment (Used on SD18E20B only)	1
	1002078	MAIN FRAME ASSY - Weldment (Used on SD18P27A and SD18E27A only)	1
	1002234	MAIN FRAME ASSY - Weldment (Used on SD18E25B only)	1
	1002079	MAIN FRAME ASSY - Weldment (Used on SD18P21A only)	1
-80	706	GREASE FITTING	2
-81	37345	SUPPORT, Heat shield (Used on SD18E20B, SD18P27A, SD18E27A and SD15P10B only)	1
	1002363	SUPPORT, Heat shield (Used on SD18P21A and SD18E25B only)	1
-82	37344	BRACKET, Heat shield (Used on SD18E20B, SD18P27A, SD18E27A and SD15P10B only)	2
	1002365	BRACKET, Heat shield (Used on SD18P21A and SD18E25B only)	2

Figure & Index Number	Part Number	Description	Qty
2-	34985	HOOD AND HEADLIGHT ASSY (Used on SD18E20B only) (See figure 1)...	REF
	1002168	HOOD AND HEADLIGHT ASSY (Used on SD18E27A and SD18E25B only) (See figure 1)	REF
	1002167	HOOD AND HEADLIGHT ASSY (Used on SD18P27A and SD18P21A only) (See figure 1)	REF

Figure 2

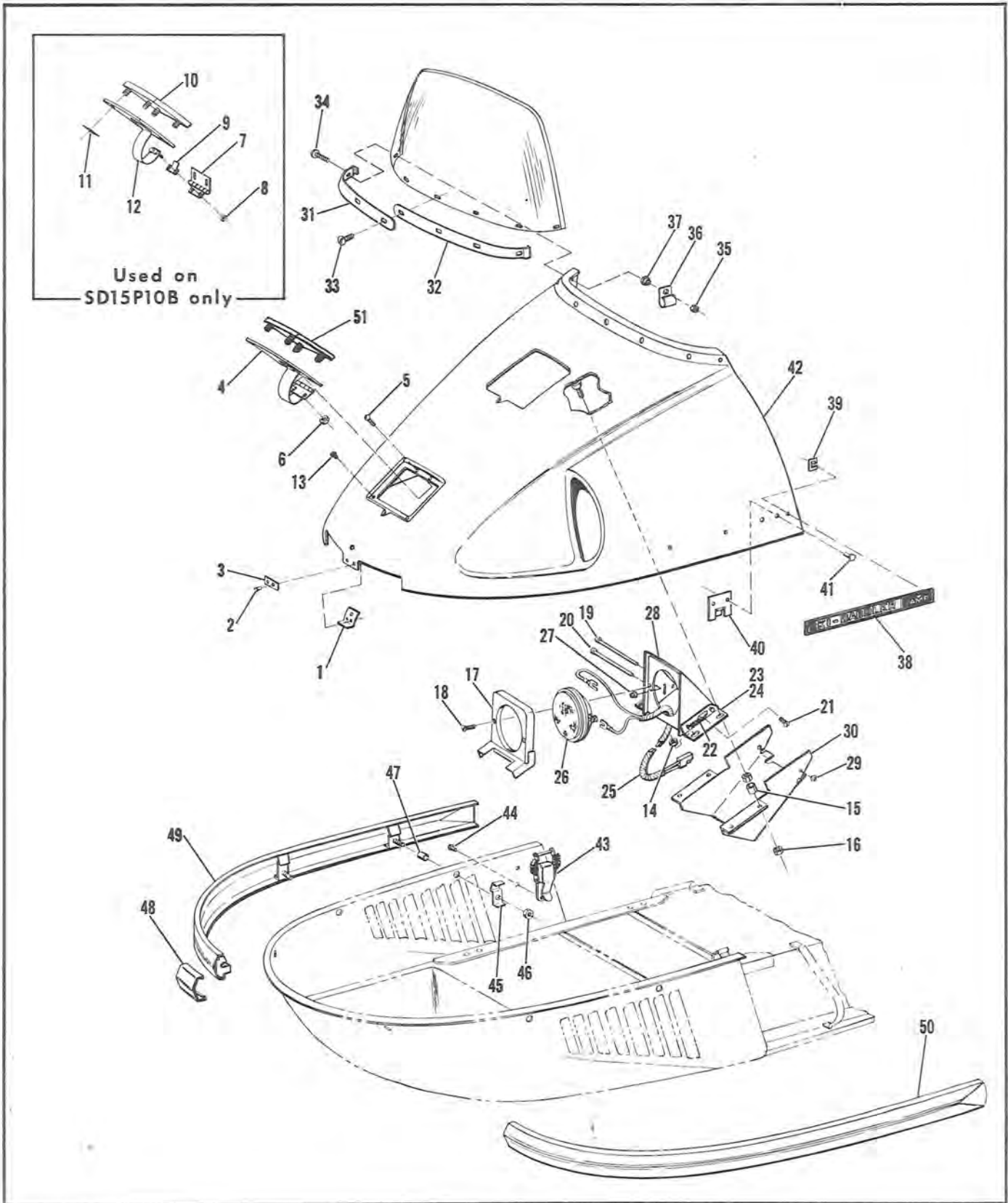


Figure & Index Number	Part Number	Description	Qty
2-	1002154	HOOD AND HEADLIGHT ASSEMBLY (Used on SD15P10B only) (See figure 1)	REF
-1	34984	CLIP, Hood	1
-2	34271	RIVET	3
-3	37045	PLATE, Hood	1
-4	1002096	GAS LID AND HINGE ASSEMBLY (Used on SD18E20B, ... SD18P27A, SD18E25B, SD18E27A and SD18P21A only)	1
	37000	GAS LID AND HINGE ASSEMBLY (Used on SD15P10B only)	1
-5	132908	SCREW, RD HD, 10-32 THD by 1/2 IN. LG	2
-6	9000122	LOCKNUT, 10-32 THD	2
-7	37006	HINGE ASSEMBLY (Used on SD15P10B only)	1
-8	9000122	LOCKNUT, 10-32 THD (Used on SD15P10B only)	2
-9	37005	SPRING, Flat (Used on SD15P10B only)	1
-10	34991	ESCUTCHEON, Gas cover (Used on SD15P10B only)	1
-11	445170	NUT, Spring, 3/16 IN. (Used on SD15P10B only)	4
-12	37001	GAS LID ASSEMBLY (Used on SD15P10B only)	1
-13	37051	RUBBER BUMPER, Gas lid	2
	*35021	HEADLIGHT ASSEMBLY (Used on SD18E20B only)	1
	*1002171	HEADLIGHT ASSEMBLY (Used on SD18E27A and SD18E25B only)	1
	*1002155	HEADLIGHT ASSEMBLY (Used on SD18P27A, SD18P21A and SD15P10B only)	1
-14	124818	JAM NUT, HEX HD, 1/4-20 THD	4
-15	33647	SPACER	2
-16	34058	LOCKNUT, 1/4-20 THD	4
-17	37055	COVER ASSEMBLY, Headlight	1
-18	437028	SCREW, PAN HD, 8-32 THD by 1-1/4 IN. LG	2
-19	35027	SHAFT, Pivot	1
-20	35028	SHAFT, Spring	1
-21	273407	SCREW, Truss HD, 8-32 THD by 3/8 IN. LG	4
-22	35029	SPRING, Extension	2
-23	35023	BRACKET, RH	1
-24	35024	BRACKET, LH	1
-25	37069	HARNES, Hood (Used on SD18E20B only)	1
	1002143	HARNES, Hood (Used on SD18P27A, SD18E25B, ... SD18E27A, SD18P21A and SD15P10B only)	1
-26	9000892	HEADLIGHT (Used on SD18E20B only)	1
	9000885	HEADLIGHT (Used on SD18E27A and SD18E25B only)	1
	9000884	HEADLIGHT (Used on SD18P27A, SD18P21A and SD15P10B only)	1
	37009	HOUSING ASSEMBLY (Consists of items 27 and 28)	1
-27	9000461	RIVNUT, 8-32 THD	2
-28	35022	HOUSING	1
-29	37471	GROMMET, Air duct	1
-30	37709	AIR DUCT, Hood	1
-31	37033	TRIM STRIP, RH (Used on SD15P10B only)	1
	37031	TRIM STRIP, RH (Used on SD18E20B, SD18P27A, ... SD18E25B, SD18E27A and SD18P21A only)	1
-32	37034	TRIM STRIP, LH (Used on SD15P10B only)	1
	37032	TRIM STRIP, LH (Used on SD18E20B, SD18P27A, ... SD18E25B, SD18E27A and SD18P21A only)	1
-33	125680	SCREW, Truss HD, 1/4-20 THD by 5/8 IN. LG	6
-34	187759	SCREW, Truss HD, 1/4-20 by 7/8 IN. LG	1
-35	9413314	LOCKNUT, 1/4-20 THD	1

*Includes applicable items -17 through -28.

Figure & Index Number	Part Number	Description	Qty
2-36	1002166	CABLE TIE	1
-37	9000555	JACKNUT, Molly	7
-38	34992	ESCUTCHEON, Side	2
-39	445170	NUT, Spring	6
-40	35011	STRIKE	2
-41	34271	RIVET	4
-42	35017	HOOD (Used on SD15P10B only)	1
	34986	HOOD (Used on SD18E20B, SD18P27A, SD18E25B and SD18P21A only)	1
-43	34989	CATCH, Hood	2
-44	34271	RIVET	4
-45	35005	GUIDE, Hood	6
-46	9000123	LOCKNUT, 1/4-28 THD	6
-47	34983	SPACER	6
-48	37591	COVER, Bumper	1
-49	37080	BUMPER ASSEMBLY, RH (Used on SD15P10B only)	1
	35000	BUMPER ASSEMBLY, RH (Used on SD18E20B, SD18P27A, SD18E25B, and SD18P21A only)	1
-50	37081	BUMPER ASSEMBLY, LH (Used on SD15P10B only)	1
	35001	BUMPER ASSEMBLY, LH (Used on SD18E20B, SD18P27A, SD18E25B, and SD18P21A only)	1
-51	1002025	GAS LID (Used on SD18E20B, SD18E25B, SD18P27A, SD18E27A and SD18P21A only)	1

Figure & Index Number	Part Number	Description	Qty
3-	1002243	CONSOLES AND STEERING ASSEMBLY (Used on SD18E20B only) (See figure 1)	REF
	1002245	CONSOLES AND STEERING ASSEMBLY (Used on SD18P27A only) (See figure 1)	REF
	1002244	CONSOLES AND STEERING ASSEMBLY (Used on SD18E25B only) (See figure 1)	REF
	1002246	CONSOLES AND STEERING ASSEMBLY (Used on SD18E27A only) (See figure 1)	REF
	1002247	CONSOLES AND STEERING ASSEMBLY (Used on SD18P21A only) (See figure 1)	REF
	1002242	CONSOLES AND STEERING ASSEMBLY (Used on SD15P10B only) (See figure 1)	REF
-1	*37040	STEERING LINKAGE ASSEMBLY (Used on SD15P10B only)	2
	*34976	STEERING LINKAGE ASSEMBLY (Used on SD18E20B, SD18P27A, SD18E25B, SD18E27A and SD18P21A only)	2
-2	33320	ARM, Spindle	2
-3	181651	BOLT, HEX HD, 3/8-24 THD by 2-3/4 IN. LG	2
-4	21777	SPACER	4
-5	30251	SPACER	2
-6	9000125	NUT, 3/8-24 THD	2
-7	37041	TIE ROD ASSEMBLY (Used on SD15P10B only)	2
	34942	TIE ROD ASSEMBLY (Used on SD18E20B, SD18P27A, SD18E25B, SD18E27A and SD18P21A only)	2
-8	181643	BOLT, HEX HD, 3/8-24 THD by 1-1/2 IN. LG	2

*Includes applicable items -2 through -13.

Figure & Index Number	Part Number	Description	Qty
3-9	21777	SPACER	4
-10	9000125	NUT, 3/8-24 THD	2
-11	30081	ROD END	4
-12	124925	JAM NUT, HEX, 3/8-24 THD	4
-13	37042	TIE ROD (Used on SD15P10B only)	2
	34943	TIE ROD (Used on SD18E20B, SD18P27A, SD18E25B, SD18E27A and SD18P21A only)	2
-14	181578	BOLT, HEX HD, 1/4-28 THD by 1-7/8 IN. LG	2
-15	147579	WASHER, Plain, 1/4 IN. ID	4
-16	34688	U-STRAP	1
-17	34694	WEARPLATE	1
-18	34689	WEARPLATE	1
-19	9000123	LOCKNUT, 1/4-28 THD	2
-20	37231	GRIP, Hand	2
-21	32185	THUMB CONTROL ASSEMBLY	1
-22	142443	SCREW, RD HD, 10-32 THD by 1-3/8 IN. LG	1
-23	9000122	LOCKNUT, 10-32 THD	1
-24	32187	LEVER, Thumb	1
-25	9417420	SCREW, Truss HD, 6-32 THD by 3/8 IN. LG	2
-26	32188	SPACER	2
-27	32186	CLAMP	1
-28	37159	BRAKE CONTROL ASSEMBLY	1
-29	37486	HAND CONTROL ASSEMBLY	1
-30	37149	THROTTLE CABLE, HOUSING AND BOOT ASSEMBLY	1
		(Used on SD18E20B, SD18P27A, SD18E27A, SD18P21A and SD15P10B only)	
	1002231	THROTTLE CABLE, HOUSING AND BOOT ASSEMBLY	1
		(Used on SD18E25B only)	
-31	34946	STEERING HANDLE AND COLUMN ASSEMBLY	1
-32	*34949	STEERING COLUMN ASSEMBLY (Used on SD18E20B, SD18P27A, SD18E27A, SD18P21A and SD15P10B only)	1
	1002239	STEERING COLUMN ASSEMBLY (Used on SD18E25B only)	1
-33	37166	CONSOLE DOOR ASSEMBLY (Used on SD18E25B and SD15P10B only)	1
	37451	CONSOLE DOOR ASSEMBLY (Used on SD18E20B only)	1
-34	37167	RETAINER, Console door (Used on SD18E20B, SD18E25B and SD15P10B only)	1
-35	37168	FASTENER, 1/4 turn (Used on SD18E20B, SD18E25B and SD15P10B only)	1
-36	37137	DOOR, Console (Used on SD18E25B and SD15P10B only)	1
	37448	DOOR, Console (Used on SD18E20B only)	1
-37	*1002261	CONSOLE TONGUE ASSEMBLY (Used on SD18E20B and SD18E25B only)	1
	*1002260	CONSOLE TONGUE ASSEMBLY (Used on SD15P10B only)	1
-38	9000302	SCREW, Truss HD, 1/4-28 THD by 5/8 IN. LG	2
		(Used on SD15P10B only)	
	9000302	SCREW, Truss HD, 1/4-28 THD by 5/8 IN. LG	4
		(Used on SD18E20B, SD18P27A, SD18E25B and SD18E27A only)	
-39	147579	WASHER, Plain (Used on SD15P10B only)	2
	147579	WASHER, Plain (Used on SD18E20B, SD18P27A, SD18E25B, SD18E27A and SD18P21A only)	4
-40	9000123	LOCKNUT, 1/4-28 THD	4

* 3-32 includes applicable items -20 through -31.

3-37 includes applicable items -41, -43 and -104 through -106.

Figure 3. Sheet 1 of 2

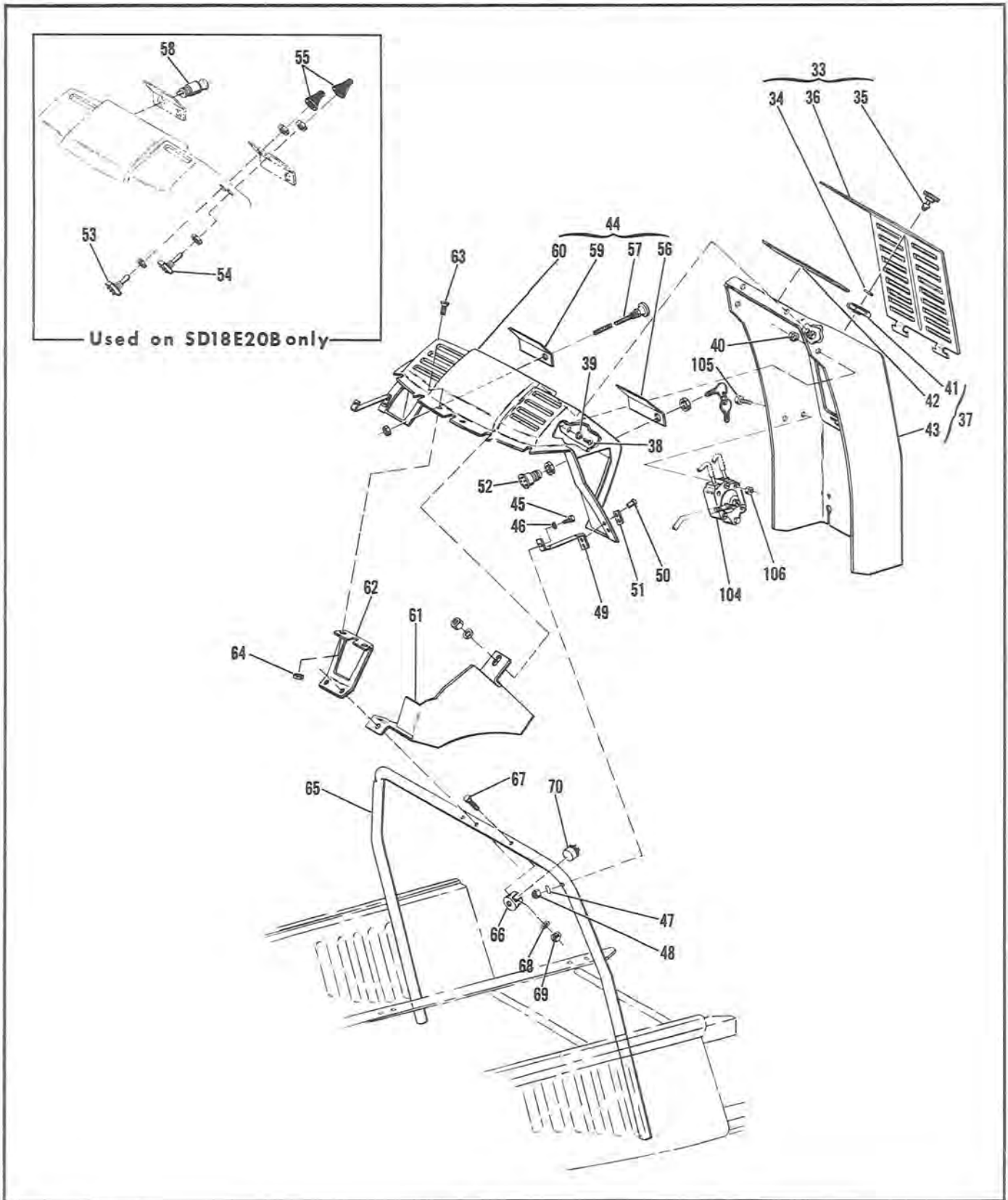


Figure & Index Number	Part Number	Description	Qty
3-41	37169	CLIP-ON RECEPTACLE, Console door (Used on SD18E20B, SD18E25A and SD15P10B only)	1
-42	1002222	DECAL, Console tongue (Used on SD18E20B and SD18E25B only) .	1
	1002223	DECAL, Console tongue (Used on SD15P10B only)	1
-43	37133	CONSOLE TONGUE (Used on SD18E20B and SD18E25B only)	1
	1002305	CONSOLE TONGUE, Modified (Used on SD15P10B only)	1
-44	*1002249	MINI-CONSOLE ASSEMBLY (Used on SD18E20B only)	1
	*1002251	MINI-CONSOLE ASSEMBLY (Used on SD18P27A only)	1
	*1002250	MINI-CONSOLE ASSEMBLY (Used on SD18E25B only)	1
	*1002252	MINI-CONSOLE ASSEMBLY (Used on SD18E27A only)	1
	*1002253	MINI-CONSOLE ASSEMBLY (Used on SD18P21A only)	1
	*1002248	MINI-CONSOLE ASSEMBLY (Used on SD15P10B only)	1
-45	9415426	SCREW, 1/4-28 THD by 1-1/2 IN. LG	2
-46	147579	WASHER, Plain	2
-47	33808	WASHER, Formed	2
-48	9000123	LOCKNUT, 1/4-28 THD	2
-49	37374	BAR, Console support (Used on SD15P10B only)	2
	37036	BAR, Console support (Used on SD18E20B, SD18P27A, ...	2
		SD18E25B, SD18E27A and SD18P21A only)	
-50	34271	RIVET	4
-51	37135	PLATE, Console back-up	2
-52	37072	SWITCH, Key (with keys)	1
-53	37075	SWITCH, Toggle, 2 positions (Used on SD18E20B only)	1
-54	37076	SWITCH, Toggle, 3 positions (Used on SD18E20B only)	1
-55	1500480	BOOT, Rubber, toggle switch (Used on SD18E20B only)	2
-56	1002206	DECAL, LH (Used on SD15P10B only)	1
	1002207	DECAL, LH (Used on SD18E20B only)	1
	1002208	DECAL, LH (Used on SD18E25B only)	1
	1002209	DECAL, LH (Used on SD18P27A only)	1
	1002210	DECAL, LH (Used on SD18E27A only)	1
	1002211	DECAL, LH (Used on SD18P21A only)	1
-57	37230	CONTROL, Choke (Used on SD18E20B, SD18E25B and	1
		SD15P10B only)	
-58	1500477	LIGHTER, Cigarette (Used on SD18E20B only)	1
-59	1002218	DECAL, RH (Used on SD18E20B, SD18E25B, SD18P21A	1
		and SD15P10B only)	
	1002219	DECAL, RH (Used on SD18P27A and SD18E27A only)	1
-60	35044	MINI-CONSOLE	1
-61	37286	AIR DUCT, LH (Used on SD18E20B, SD18E25B and	1
		SD15P10B only)	
	37285	AIR DUCT, RH (Used on SD18E20B, SD18E25B and	1
		SD15P10B only)	
-62	37037	BRACKET, Console	1
-63	120612	SCREW, Flat HD, 10-32 THD by 5/8 IN. LG	2
-64	9000122	LOCKNUT, 10-32 THD	2
-65	37038	ROLL BAR (Used on SD18E20B, SD18P27A, SD18E25B, ...	1
		SD18E27A and SD18P21A only)	
	37039	ROLL BAR (Used on SD15P10B only)	1
-66	37432	BRACKET, Flasher (Used on SD18E20B only)	1
-67	436756	SCREW, Pan HD, 10-32 THD by 1-1/2 IN. LG	1
		(Used on SD18E20B only)	
-68	446143	WASHER, Plain (Used on SD18E20B only)	1
-69	9000122	LOCKNUT, 10-32 THD (Used on SD18E20B only)	1

* 3-44 includes applicable items -49 through -60.

Figure 3. Sheet 2 of 2

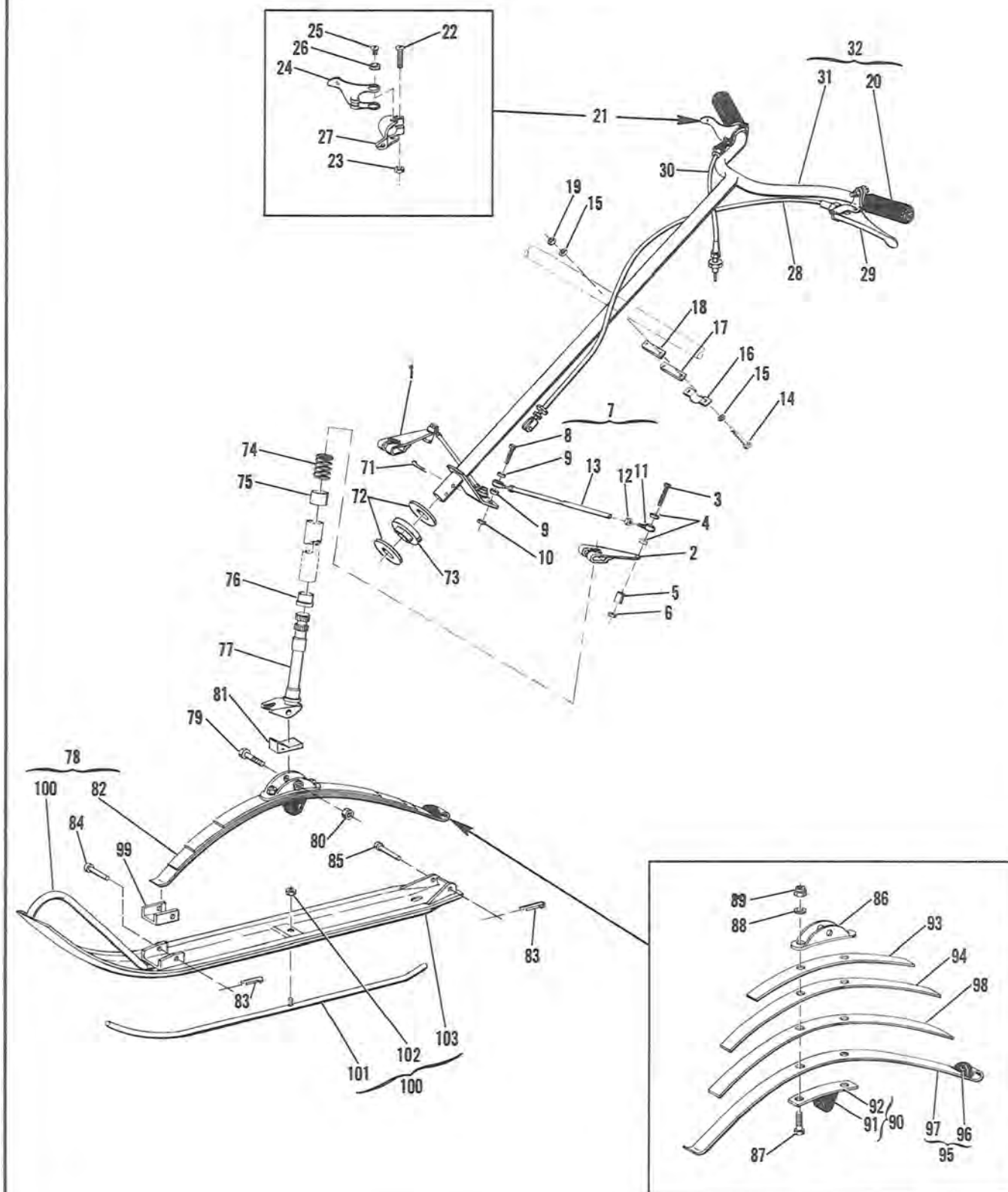


Figure & Index Number	Part Number	Description	Qty
3-70	37077	FLASHER (Used on SD18E20B only)	1
-71	137258	COTTER PIN, 3/16 IN. DIA by 1-3/4 IN. LG	2
-72	37124	WASHER, Steering column	2
-73	34945	BUSHING, Steering column support	1
-74	30149	SPRING, Spindle	2
-75	33753	BUSHING, Plain	2
-76	33756	BUSHING, Flange	2
-77	37222	SPINDLE	2
-78	*37245	SKI AND SPRING ASSEMBLY (Used on SD15P10B only)	REF
		(See figure 1)	
	*1002278	SKI AND SPRING ASSEMBLY (Used on SD18E20B, SD18P27A, SD18E25B, SD18E27A and SD18P21A only) (See figure 1)	REF
-79	189329	SCREW, HEX HD, 3/8-24 THD by 3-1/2 IN. LG	2
-80	9000125	LOCKNUT, 3/8-24 THD	2
-81	37226	PAD, Spindle	2
-82	*37411	SKI SPRING ASSEMBLY (Used on SD15P10B only)	2
	*1002275	SKI SPRING ASSEMBLY (Used on SD18E20B, SD18P27A, SD18E25B, SD18E27A and SD18P21A only)	2
-83	144518	COTTER PIN	4
-84	33748	PIVOT PIN, Spring	2
-85	28762	PIN, Pivot	2
-86	37412	BRACKET ASSEMBLY, Spring mounting	2
-87	181643	SCREW, HEX HD, 3/8-24 THD by 1-1/2 IN. LG	4
-88	274517	WASHER, Flat, 3/8 IN. ID	4
-89	9000125	LOCKNUT, 3/8-24 THD	4
-90	*34969	BUMPER ASSEMBLY	2
-91	33297	BUMPER	2
-92	33296	PLATE, Spring	2
-93	33731	LEAF SPRING, Top	2
-94	33730	LEAF SPRING, Middle	2
-95	*37249	LEAF SPRING, Main	2
-96	37250	BUMPER, Main leaf	2
-97	33729	SPRING, Main leaf	2
-98	1002276	LEAF SPRING (Used on SD18E20B, SD18P27A, SD18E25B, SD18E27A and SD18P21A only)	2
-99	33746	WEAR PLATE, Ski	2
-100	*37246	SKI AND WEAR ROD ASSEMBLY	2
-101	34919	WEAR ROD ASSEMBLY, Ski-weldment	2
-102	9000123	LOCKNUT, 1/4-28 THD	2
-103	37247	SKI ASSEMBLY	2
-104	1002132	FUEL PUMP (Used on SD15P10B only)	1
-105	446897	SCREW, Truss HD, 10-32 THD by 1-1/2 IN. LG	2
		(Used on SD15P10B only)	
-106	9000122	LOCKNUT, 10-32 THD (Used on SD15P10B only)	2

* 3-78 includes applicable items -82 through -103.

3-82 includes applicable items -86 through 98.

3-90 includes items -91 and -92.

3-95 includes items -96 and -97.

3-100 includes items -101 through -103.

Figure 4

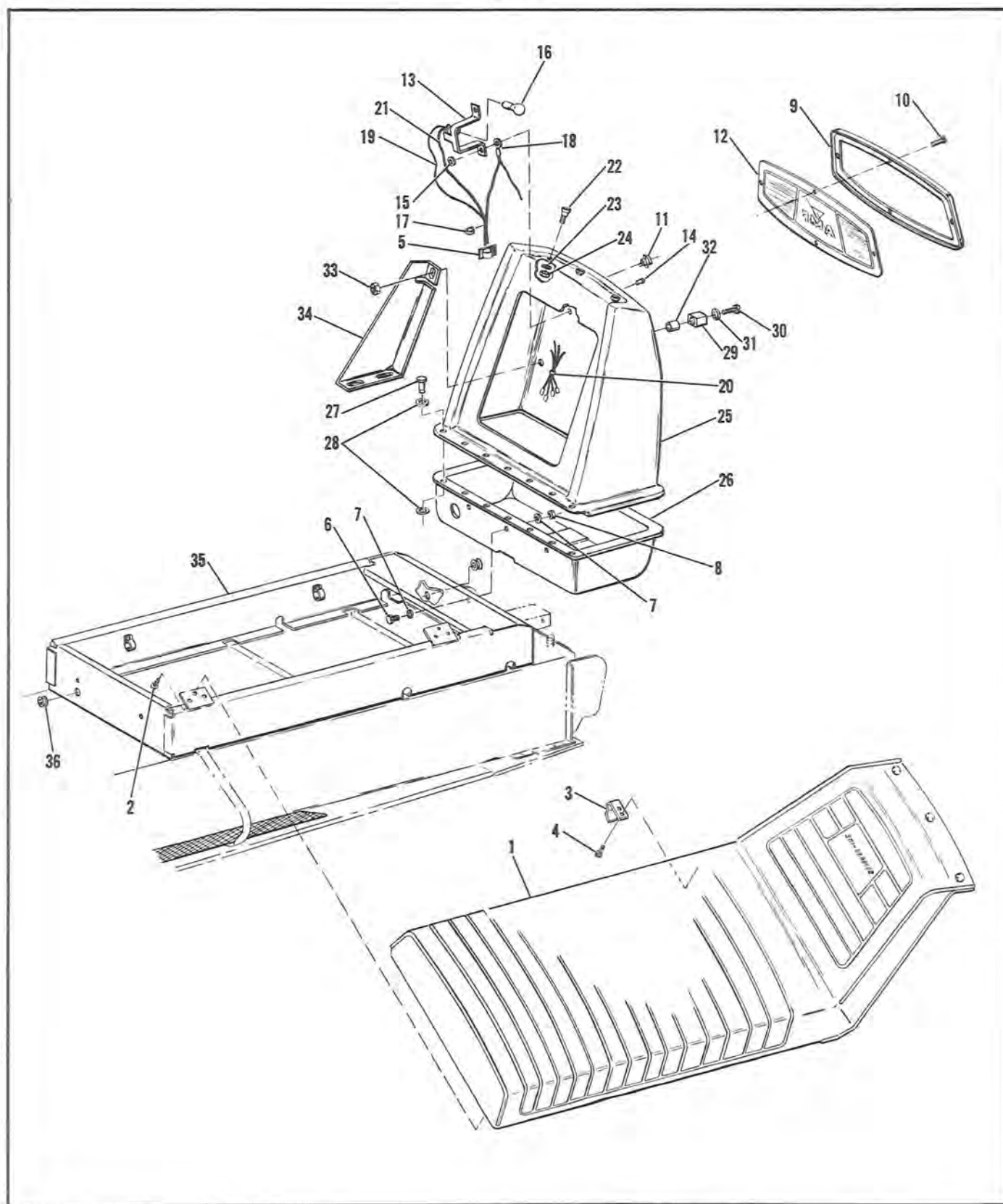


Figure & Index Number	Part Number	Description	Qty
4-	37764	REAR CONSOLE, SEAT AND TOOL BOX ASSEMBLY	REF
	1002127	(Used on SD18E20B only) (See figure 1) REAR CONSOLE, SEAT AND TOOL BOX ASSEMBLY	REF
		(Used on SD18E25B and SD18P21A only) (See figure 1)	
-1	*37165	SEAT	1
-2	144815	SCREW, PAN HD, Self-tapping, No. 8 by 5/8 IN. LG	6
-3	33611	LATCH, Spring	2
-4	144815	SCREW, PAN HD, Self-tapping, No. 8 by 5/8 IN. LG	4
-5	33610	CLIP, Wiring	3
	37147	REAR CONSOLE ASSEMBLY (Used on SD18E25B and SD18P21A only)	1
	37146	REAR CONSOLE ASSEMBLY (Used on SD18E20B only)	1
-6	9000302	SCREW, Truss HD, 1/4-28 THD by 5/8 IN. LG	3
-7	9416904	WASHER, Flat	6
-8	9000123	LOCKNUT, 1/4-28 THD	3
-9	37257	COVER, Taillight lens	1
-10	132712	SCREW, Machine oval HD, 6-32 THD by 3/4 IN. LG	4
-11	9000551	NUT, Molly jack, 6-32 THD	4
-12	37156	LENS, Taillight	1
-13	37155	BRACKET AND SOCKET ASSEMBLY (Used on SD18E25B and SD18P21A only)	2
	37152	BRACKET AND SOCKET ASSEMBLY (Used on SD18E20B only) ..	2
-14	34024	RIVET	4
-15	37651	WASHER, Rivet burr	2
-16	33584	BULB, Taillight (Used on SD18E25B and SD18P21A only)	2
	37078	BULB, Taillight (Used on SD18E20B only)	2
-17	37288	TIE, Cable	1
-18	37278	WIRE, Taillight ground	1
-19	37395	WIRE, Taillight	1
-20	37392	WIRE, Taillight, left turn signal (Used on SD18E20B only)	1
-21	37394	WIRE, Taillight, right turn signal (Used on SD18E20B only)	1
-22	37373	STUD, Rear console, 8-32 THD by 5/8 IN. LG	3
-23	37644	WASHER, Rear console	3
-24	9000121	LOCKNUT, 8-32 THD	3
	37237	CONSOLE, Rear	1
-25	37148	CONSOLE, Rear, upper	1
-26	37238	CONSOLE, Rear, lower	1
-27	37251	RIVET	7
-28	221158	WASHER, Flat, 3/32 ID by 1/4 OD	14
-29	37646	BUMPER, Kickstand	2
-30	422420	SCREW, RD HD, 1/4-28 THD by 1-1/4 IN. LG	2
-31	9414920	WASHER, Plain	2
-32	37647	SPACER	2
-33	9000123	LOCKNUT, 1/4-28 THD	2
-34	37157	BRACKET, Rear console, RH	1
	37158	BRACKET, Rear console, RH	1
-35	37205	TOOL BOX, Weldment	1
-36	128157	GROMMET, Rubber	2

* Seat Cover, Black, AMF Part No. 1002494 available as optional equipment.

Figure 5

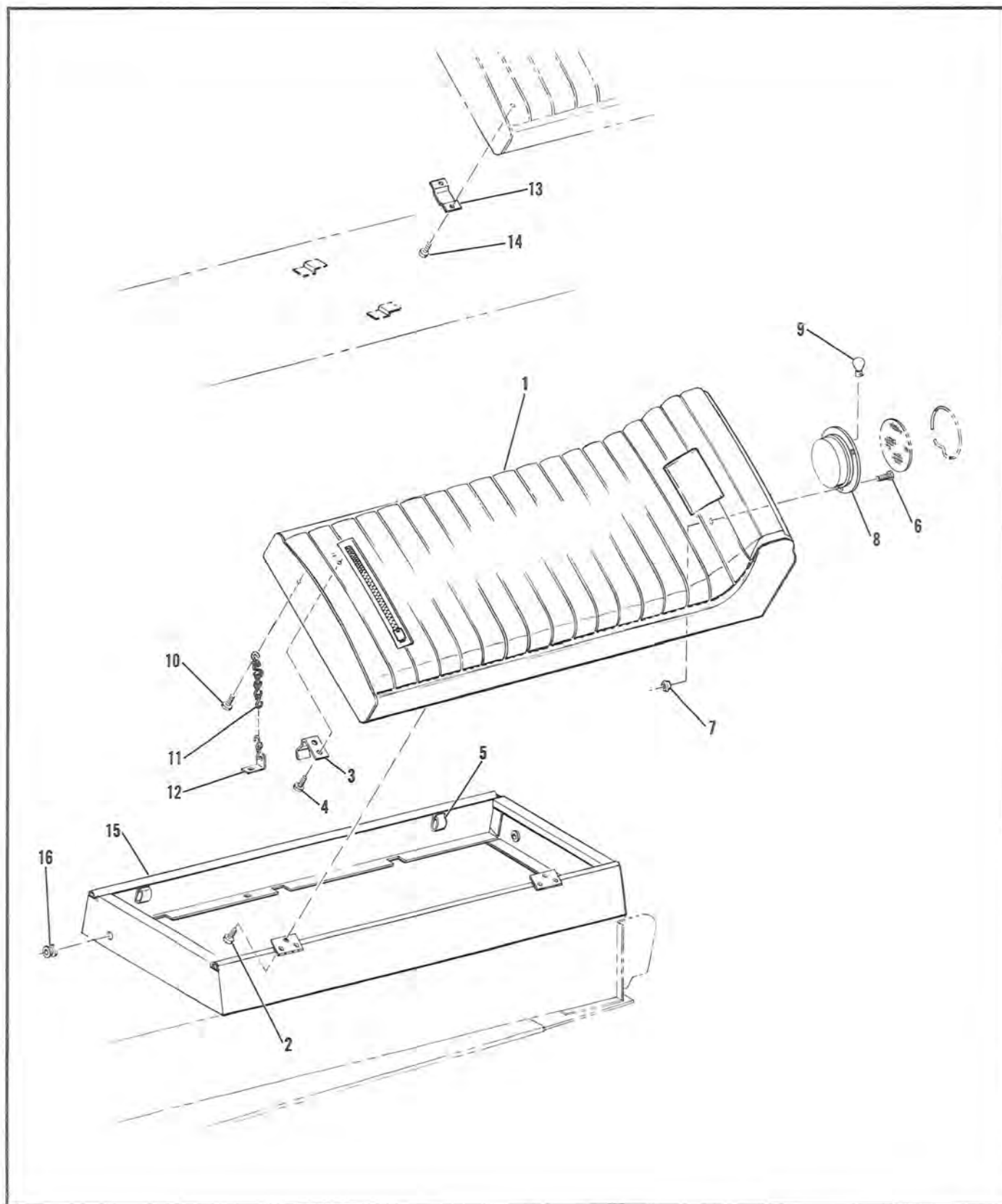


Figure & Index Number	Part Number	Description	Qty
5-	1002169	SEAT AND TOOL BOX ASSEMBLY (Used on SD18E27A and SD18P27A only) (See figure 1)	REF
	1002157	SEAT AND TAIL LAMP ASSEMBLY (Used on SD15P10B only) (See figure 1)	REF
-1	*1002136	SEAT, Black (Used on SD18E27A and SD18P27A only)	1
	**1002137	SEAT, Orange (Used on SD15P10B only)	1
-2	144815	SCREW, PAN HD, 6-32 THD by 3/4 IN. LG (Used on SD18E27A and SD18P27A only)	6
-3	33611	LATCH, Spring (Used on SD18E27A and SD18P27A only)	2
-4	144815	SCREW, PAN HD, 6-32 THD by 3/4 IN. LG (Used on SD18E27A and SD18P27A only)	4
-5	33610	CLIP, Wiring (Used on SD18E27A and SD18P27A only)	2
-6	436667	SCREW, PAN HD, 6-32 THD by 3/4 IN. LG	3
-7	9000552	NUT, Molly jack, 6-32 THD	3
	1002158	TAILLIGHT MOUNT ASSEMBLY	1
-8	1002159	TAILLIGHT MOUNT	1
-9	33584	BULB, Taillight	1
-10	144815	SCREW, PAN HD, 6-32 THD by 3/4 IN. LG (Used on SD18E27A and SD18P27A only)	1
-11	30313	CHAIN, 25-Links (Used on SD18E27A and SD18P27A only)	1
-12	37400	RETAINER, Spring (Used on SD18E27A and SD18P27A only)	1
-13	33395	RECEPTACLE, Seat clip (Used on SD15P10B only)	2
-14	144815	SCREW, PAN HD, 6-32 THD by 3/4 IN. LG (Used on SD15P10B only)	4
-15	1002118	TOOL BOX, Weldment (Used on SD18E27A and SD18P27A only)	1
-16	128157	GROMMET, Rubber (Used on SD18E27A and SD18P27A only)	2

* Seat Cover, Black, AMF Part No. 1002495 available as optional equipment.

** Seat Cover, Orange, AMF Part No. 1002496 available as optional equipment.

Figure & Index Number	Part Number	Description	Qty
6-	1002139	ENGINE AND SUPPORT ASSEMBLY (Used on SD15P10B only) (See figure 1)	REF
-1	37181	PIPE, Engine exhaust	1
-2	1002133	BRACKET, Throttle	1
-3	30270	IMPULSE LINE	1
-4	37225	WIRING CONNECTIONS, L295 engine	1
-5	33859	COVER, Air intake	1
-6	1500932	CLIP, Cable	1
-7	37666	BRACKET, Choke control	1
-8	1002131	CARBURETOR (See figure 12)	1
-9	1002182	DRIVE CLUTCH ASSEMBLY, 780 Series	1
-10	1002362	BOLT, Clutch adaptor	1
-11	138549	LOCKWASHER, INT. Tooth, 1/2 IN. ID	1
-12	37105	ENGINE, JLO 295	1
-13	180147	BOLT, HEX HD, 7/16-14 THD by 1-1/4 IN. LG	4
-14	120383	LOCKWASHER, 7/16 IN. ID	4
-15	37188	BASE, Engine	1
-16	9000323	BOLT, Carriage, 5/16-24 THD by 1 IN. LG	4

Figure 6

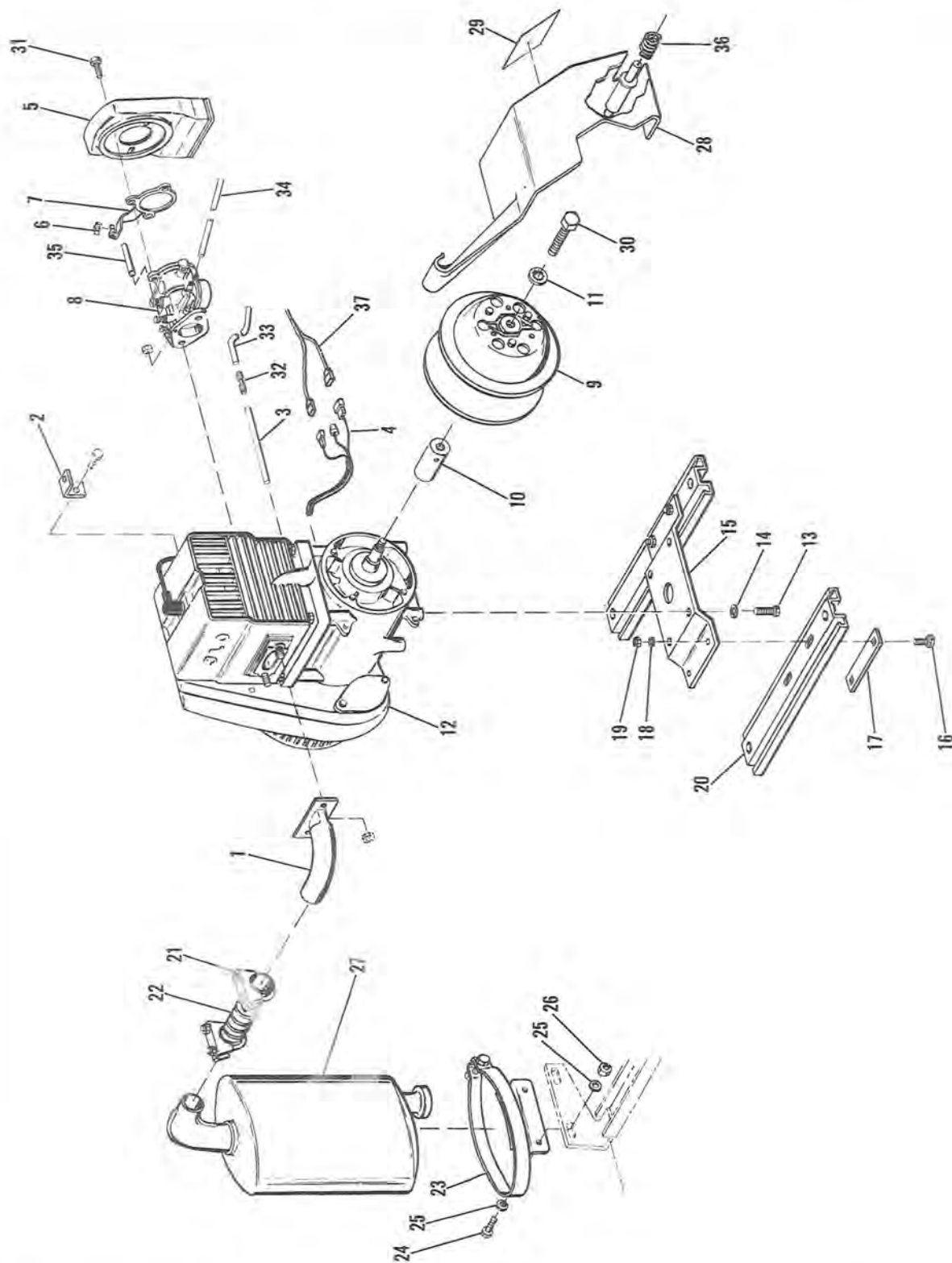


Figure & Index Number	Part Number	Description	Qty
6-17	37189	BAR WASHER	2
-18	120393	WASHER, Plain	4
-19	9000124	LOCKNUT, 5/16-24 THD	4
-20	37187	MOUNTING STRAP	2
-21	32588	CLAMP, Flexible tube	2
-22	37183	EXHAUST TUBE, Flexible	1
-23	34032	BAND ASSEMBLY, Mounting	1
-24	181566	SCREW, HEX HD, 1/4-28 THD by 3/4 IN. LG	2
-25	120392	WASHER, Plain, 9/32 IN. ID by 5/8 IN. OD	4
-26	9000123	LOCKNUT, 1/4-28 THD	2
-27	37173	MUFFLER	1
-28	1002044	CLUTCH GUARD AND DECAL ASSEMBLY	1
-29	37593	DECAL, Safety	1
-30	181710	BOLT, HEX HD, 1/2-20 THD by 2-3/4 IN. LG	1
-31	420998	SCREW, RD HD, 1/4-20 THD by 1-1/2 IN. LG	3
-32	1002356	CONNECTOR, Tubing reducer	1
-33	1002357	IMPULSE LINE, Fuel pump-to-engine	1
-34	1002358	GAS LINE, Fuel pump-to-carburetor	1
-35	1002519	TUBING, Carburetor vent	1
-36	1002086	SPRING, Compression	1
-37	1002142	SLED HARNESS	1

Figure & Index Number	Part Number	Description	Qty
7-	1002148	ENGINE AND SUPPORT ASSEMBLY	REF
		(Used on SD18E20B only) (See figure 1)	
	1002115	ENGINE AND SUPPORT ASSEMBLY	REF
		(Used on SD18P27A only) (See figure 1)	
	1002116	ENGINE AND SUPPORT ASSEMBLY	REF
		(Used on SD18E27A only) (See figure 1)	
	1002123	ENGINE AND SUPPORT ASSEMBLY	REF
		(Used on SD18P21A only) (See figure 1)	
	1002172	ENGINE AND SUPPORT ASSEMBLY	REF
		(Used on SD18E25B only) (See figure 1)	
-1	37101	EXHAUST MANIFOLD, 5-degree (Used on SD18E20B, SD18P27A and SD18E27A only)	1
	1002194	EXHAUST MANIFOLD (Used on SD18P21A only)	1
-2	37099	EXHAUST MANIFOLD, 45-degree (Used on SD18E20B, SD18P27A and SD18E27A only)	1
	1002193	EXHAUST MANIFOLD (Used on SD18P21A only)	2
-3	1002360	EXHAUST ELBOW (Used on SD18E25B only)	1
-4	1002361	EXHAUST ELBOW (Used on SD18E25B only)	1
-5	30270	IMPULSE LINE (Used on SD18E20B, SD18P27A, SD18E27A and SD18P21A only)	1
	34090	IMPULSE LINE (Used on SD18E25B only)	1
-6	37131	WIRING CONNECTIONS (Used on SD18E20B, SD18P27A, SD18E27A and SD18P21A only)	1
	38488	WIRING CONNECTIONS (Used on SD18E25B only)	1
-7	1500932	CLIP, Cable (Used on SD18E20B and SD18E25B only)	1
-8	37666	BRACKET, Choke control (Used on SD18E20B only)	1

Figure 7

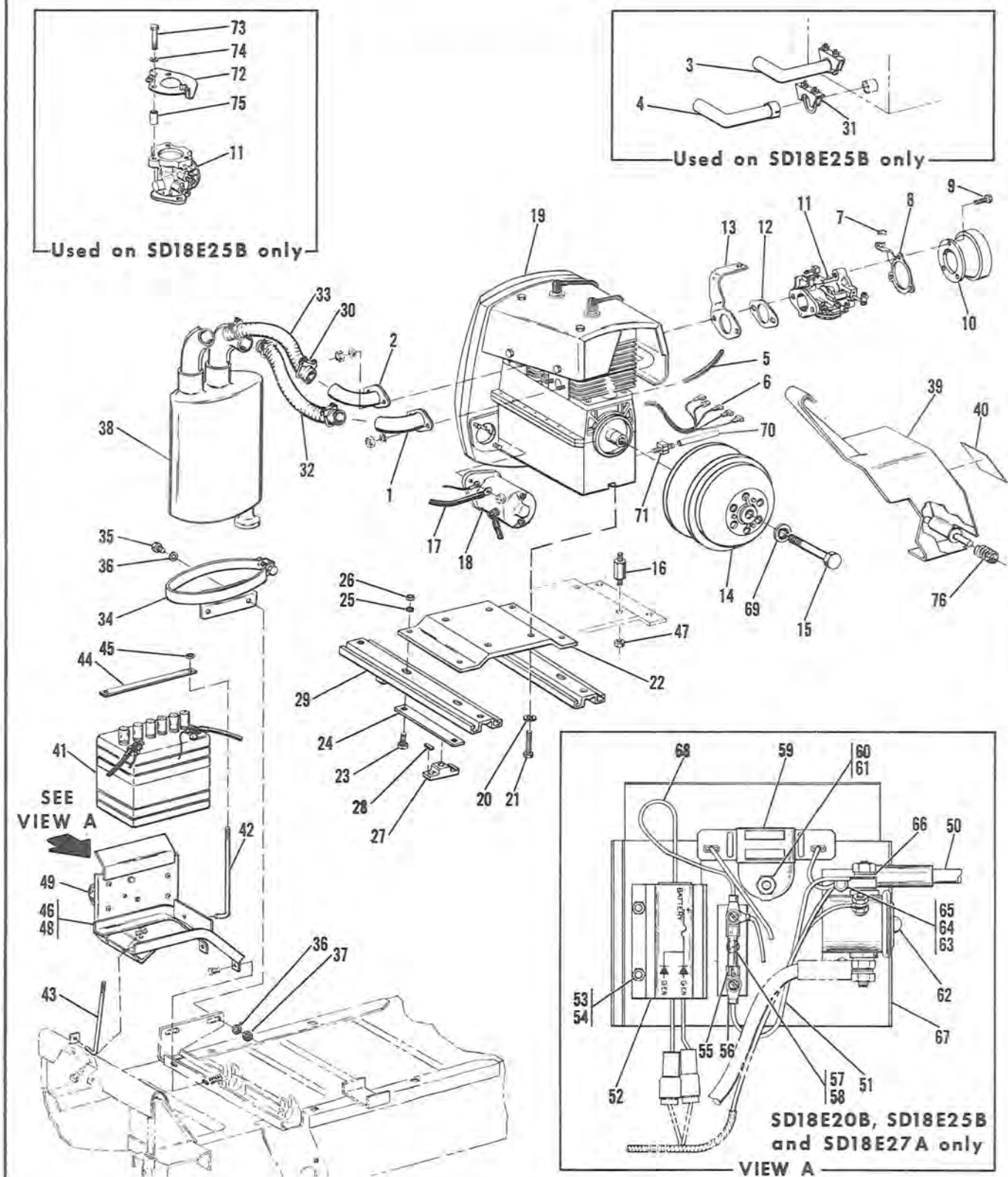


Figure & Index Number	Part Number	Description	Qty
7-9	420991	SCREW, RD HD, 1/4-28 THD by 5/8 IN. LG (Used on SD18E20B only)	3
-10	1002107	AIR INTAKE SILENCER (Used on SD18P27A, SD18E27A, ... and SD18E27A only)	1
-11	37258	CARBURETOR (Used on SD18E20B, SD18P27A, ... SD18E27A and SD18P21A only)	1
	1002277	CARBURETOR (Used on SD18E25B only)	1
-12	37191	GASKET (Used on SD18E20B, SD18P27A, SD18E27A and SD18P21A only)	1
-13	37190	BRACKET, Throttle (Used on SD18E20B, SD18P27A, ... SD18E27A and SD18P21A only)	1
-14	1002186	DRIVE CLUTCH ASSEMBLY (Used on SD18E20B only)	1
	1002184	DRIVE CLUTCH ASSEMBLY (Used on SD18P27A, ... SD18E25B and SD18E27A only)	1
	1002188	DRIVE CLUTCH ASSEMBLY (Used on SD18P21A only)	1
-15	189348	BOLT, HEX HD, 1/2-20 THD by 5 IN. LG	1
-16	1002403	STUD (Used on SD18E25B only)	4
-17	37383	CABLE, Battery-to-ground (Used on SD18E20B, ... SD18E27A and SD18E25B only)	1
-18	37054	STARTING MOTOR ASSEMBLY (Used on SD18E20B, ... SD18E27A and SD18E25B only)	1
-19	37079	ENGINE, 493 (Used on SD18E20B only)	1
	1002102	ENGINE, 399 (Used on SD18P27A and SD18E27A only)	1
	1002037	ENGINE, 634 (Used on SD18P21A only)	1
	38425	ENGINE, 399 (Used on SD18E25B only)	1
-20	180175	BOLT, HEX HD, 1/2-13 THD by 1-1/4 IN. LG	4
		(Used on SD18E20B, SD18P27A, SD18E27A and SD18P21A only)	
-21	120384	LOCKWASHER, 1/2 IN. ID	4
		(Used on SD18E20B, SD18P27A, SD18E27A and SD18P21A only)	
-22	37118	BASE, Engine (Used on SD18E20B, SD18P27A, and SD18E27A only)	1
	1002135	BASE, Engine (Used on SD18E25B only)	1
	1002101	BASE, Engine (Used on SD18P21A only)	1
-23	9000323	BOLT, Carriage, 5/16-24 THD by 1 IN. LG	4
-24	37126	BAR WASHER (Used on SD18E20B, SD18P27A, ... SD18E27A and SD18P21A only)	2
	1002259	BAR WASHER (Used on SD18E25B only)	2
-25	120393	WASHER, Plain	4
-26	9000124	LOCKNUT, 5/16-24 THD	4
-27	33768	SHOCKMOUNT	2
-28	37699	PAD, Shockmount (Used on SD18E20B, SD18P27A, ... SD18E27A and SD18P21A only)	4
-29	37438	MOUNTING STRAP	2
-30	32588	CLAMP, Flexible tube	4
-31	32588	CLAMP, Flexible tube (Used on SD18E25B only)	2
-32	37142	EXHAUST TUBE, Flexible, long	1
		(Used on SD18E20B, SD18P27A, and SD18E27A only)	
	1002228	EXHAUST TUBE, Flexible (Used on SD18P21A only)	1
	1002253	EXHAUST TUBE, Flexible (Used on SD18E25B only)	1
-33	1002353	EXHAUST TUBE (Used on SD18E20B, SD18P27A and SD18E27A only)	1
	1002229	EXHAUST TUBE, Flexible (Used on SD18P21A only)	1
	1002354	EXHAUST TUBE, Flexible (Used on SD18E25B only)	1

Figure & Index Number	Part Number	Description	Qty
7-34	34032	BAND ASSEMBLY, Mounting	1
-35	181566	SCREW, HEX HD, 5/16-24 THD by 3/4 IN. LG	2
-36	120392	WASHER, Plain, 11/32 IN. ID by 11/16 IN. OD	4
-37	9000123	LOCKNUT, 5/16-24 THD	2
-38	37095	MUFFLER WELDMENT (Used on SD18E20B, SD18P27A, ...	1
		and SD18E27A only)	
	1002226	MUFFLER WELDMENT (Used on SD18E25B only)	1
	1002195	MUFFLER WELDMENT (Used on SD18P21A only)	1
-39	1002085	CLUTCH GUARD AND DECAL ASSEMBLY	1
		(Used on SD18E20B, SD18E25B and SD18P21A only)	
	1002044	CLUTCH GUARD AND DECAL ASSEMBLY	1
		(Used on SD18P27A and SD18E27A only)	
-40	37353	DECAL, Safety (Used on SD18E20B, SD18E25B and	1
		SD18P21A only)	
	37593	DECAL, Safety (Used on SD18P27A and SD18E27A only)	1
-41	33979	STORAGE BATTERY (Used on SD18E20B, SD18E25B	1
		and SD18E27A only)	
-42	37064	BATTERY HOLDDOWN ROD, Long	1
		(Used on SD18E20B, SD18E25B and SD18E27A only)	
-43	1002117	BATTERY HOLDDOWN ROD, Short	1
		(Used on SD18E20B, SD18E25B and SD18E27A only)	
-44	37062	BATTERY HOLDDOWN STRAP	1
		(Used on SD18E20B, SD18E25B and SD18E27A only)	
-45	9000123	LOCKNUT, 1/4-28 THD (Used on SD18E20B, SD18E25B ...	2
		and SD18E27A only)	
-46	37765	BATTERY SUPPORT AND ELECTRICAL ASSEMBLY	REF
		(Used on SD18E20B only) (See figure 1)	
	1002198	BATTERY SUPPORT AND ELECTRICAL ASSEMBLY	1
		(Used on SD18E25B and SD18E27A only) (See figure 1)	
-47	9416107	LOCKNUT, 3/8-16 THD (Used on SD18E25B only)	4
-48	37071	SLED HARNESS (Used on SD18E20B only)	1
	1002164	SLED HARNESS (Used on SD18E25B and SD18E27A only) ...	1
	1002165	SLED HARNESS (Used on SD18P27A and SD18P21A only) ...	1
-49	37094	ELECTRICAL COMPONENT ASSEMBLY	1
-50	34014	CABLE ASSEMBLY, To battery (+)	1
-51	37387	JUMPER LEAD	1
-52	1002257	RECTIFIER	1
-53	436695	SCREW, PAN HD, 8-32 THD by 1/2 IN. LG	2
-54	9000121	LOCKNUT, 8-32 THD	2
-55	37382	FUSE, 15 amp	1
-56	37381	FUSE HOLDER	1
-57	133427	SCREW, Flat HD, 6-32 THD by 7/16 IN. LG	1
-58	9000126	LOCKNUT, 6-32 THD	1
-59	37377	RESISTOR, Fixed, 10 ohms $\pm 5\%$, 50W	1
-60	181003	BOLT, HEX HD, 1/4-28 THD by 5/8 IN. LG	1
-61	9000123	LOCKNUT, 1/4-28 THD	1
-62	37092	SOLENOID, Electric start	1
-63	436750	SCREW, PAN HD, 10-32 THD by 1/2 IN. LG	2
-64	121801	LOCKWASHER, Internal tooth No. 10 (Under locknut)	1
-65	9000122	LOCKNUT, 10-32 THD	2
-66	138538	LOCKWASHER, Internal tooth 5/16 IN. DIA	2
-67	37058	BATTERY SUPPORT, Weldment	1
-68	1002258	LEAD, Rectifier	1

Figure & Index Number	Part Number	Description	Qty
7-69	138549	WASHER, Shakeproof, 3/16 ID	1
-70	1002435	OIL LINE (Used on SD18P21A only)	1
-71	1002230	CHECK VALVE, Lubrication (Used on SD18P21A only)	1
-72	1002369	CAP ASSEMBLY, Carburetor (Used on SD18E25B only)	1
-73	121900	BOLT, HEX HD, 1/4-20 THD by 1 IN. LG	3
		(Used on SD18E25B only)	
-74	120423	LOCKWASHER, Internal, 1/4 ID (Used on SD18E25B only) ...	3
-75	1002372	SPACER, Carburetor cap (Used on SD18E25B only)	3
-76	1002086	SPRING, Compression	1

Figure & Index Number	Part Number	Description	Qty
8-	1002091	TRACTION BELT TAKE-UP ASSEMBLY (Used on	REF
		SD18E20B, SD18P27A, SD18E25B, SD18E27A and SD18P21A only) (See figure 1)	
	1002092	TRACTION BELT TAKE-UP ASSEMBLY (Used on SD15P10B	REF
		only) (See figure 1)	
-1	32266	SCREW, Adjusting	2
-2	32265	BLOCK, Adjusting	2
-3	456145	WASHER, Flat, 5/16 IN. ID	2
-4	9000124	LOCKNUT, 5/16-24 THD	2
-5	1002128	REAR SUPPORT ARM AND SPRING ASSEMBLY, RH	1
	1002129	REAR SUPPORT ARM AND SPRING ASSEMBLY, LH	1
-6	34684	ANGLE, Belt adjustment, LH	1
	34683	ANGLE, Belt adjustment, RH	1
-7	181651	SCREW, HEX HD, 3/8-24 THD by 2-3/4 IN. LG	2
-8	33705	SPACER, Rear support arm	2
-9	9000125	LOCKNUT, 3/8-24 THD	2
-10	32237	RETAINER	2
-11	33357	SPRING, Rear torsion, LH	1
	33356	SPRING, Rear torsion, RH	1
-12	1002089	REAR SUPPORT ARM ASSEMBLY, LH	1
	1002088	REAR SUPPORT ARM ASSEMBLY, RH	1
-13	37199	REAR SPROCKET ASSEMBLY (Used on SD15P10B only)	1
	37196	REAR SPROCKET ASSEMBLY (Used on SD18E20B, ...	1
		SD18P27A, SD18E25B, SD18E27A and SD18P21A only)	
-14	34648	BEARING	2
-15	30079	GREASE SEAL	2
-16	37192	SPROCKET SUPPORT PLATE ASSEMBLY	2
-17	181566	SCREW, HEX HD, 1/4-28 THD by 3/4 IN. LG	18
-18	9000123	LOCKNUT, 1/4-28 THD	18
-19	1002179	WHEEL, Idler (Used on SD18E20B, SD18P27A, SD18E25B, ...	1
		SD18E27A and SD18P21A only)	
-20	181566	SCREW, HEX HD, 1/4-28 THD by 3/4 IN. LG (Used on	9
		SD18E20B, SD18P27A, SD18E25B, SD18E27A and SD18P21A only)	
-21	9000123	LOCKNUT, 1/4-28 THD (Used on SD18E20B, SD18P27A, ...	9
		SD18E25B, SD18E27A and SD18P21A only)	

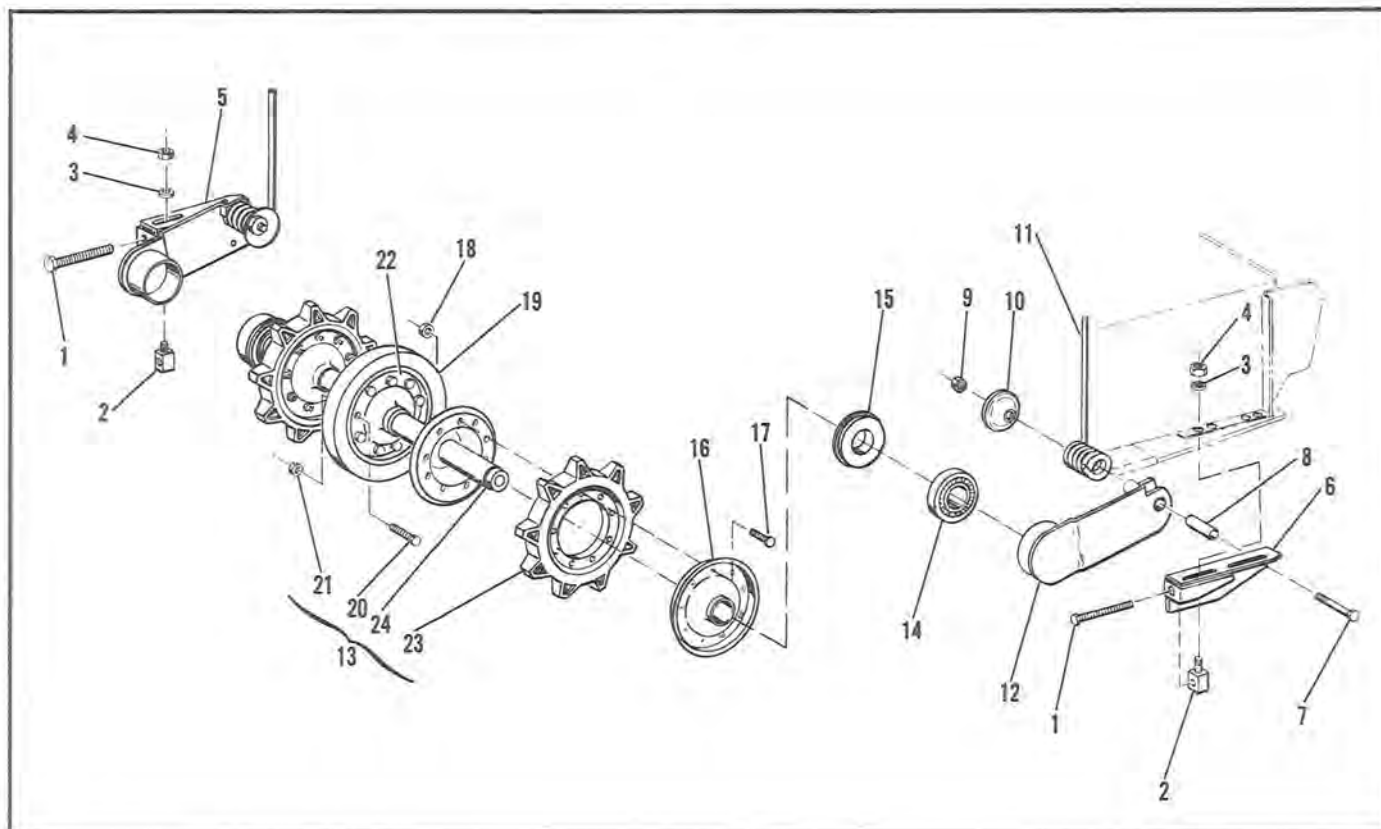
Figure 8


Figure & Index Number	Part Number	Description	Qty
8-22	37192	SPROCKET SUPPORT PLATE ASSEMBLY (Used on SD18E20B, SD18P27A, SD18E25B, SD18E27A and SD18P21A only)	1
-23	1002178	SPROCKET, Idler	2
-24	37200	REAR SHAFT AND SPROCKET PLATE ASSEMBLY (Used on SD15P10B only)	1
	37198	REAR SHAFT AND SPROCKET PLATE ASSEMBLY (Used on SD18E20B, SD18P27A, SD18E25B, SD18E27A and SD18P21A only)	1

Figure & Index Number	Part Number	Description	Qty
9-	37083	BOGIE ASSEMBLY (Used on SD15P10B only) (See figure 1)	REF
	34901	BOGIE ASSEMBLY, Middle and rear (Used on SD18E20B, SD18P27A, SD18E25B, SD18E27A and SD18P21A only) (See figure 1)	REF
-1	33712	TORSION SPRING, Bogie, RH (Used on SD15P10B only)	3

Figure & Index Number	Part Number	Description	Qty
9 -	33712	TORSION SPRING, Bogie, RH (Used on SD18E20B, SD18P27A, SD18E25B, SD18E27A and SD18P21A only)	2
-2	33711	TORSION SPRING, Bogie, LH (Used on SD15P10B only)	3
	33711	TORSION SPRING, Bogie, LH (Used on SD18E20B, SD18P27A, SD18E25B, SD18E27A and SD18P21A only)	2
-3	37085	BOGIE WHEEL AND SUPPORT ASSEMBLY - HALF (Used on SD15P10B only)	3
	34902	BOGIE WHEEL AND SUPPORT ASSEMBLY - HALF (Used on SD18E20B, SD18P27A, SD18E25B, SD18E27A and SD18P21A only)	2
-4	33713	WHEEL, Bogie (Used on SD15P10B only)	6
	33713	WHEEL, Bogie (Used on SD18E20B, SD18P27A, SD18E25B, SD18E27A and SD18P21A only)	4
-5	33736	LOCKNUT, 5/8-18 THD (Used on SD15P10B only)	6
	33736	LOCKNUT, 5/8-18 THD (Used on SD18E20B, SD18P27A, SD18E25B, SD18E27A and SD18P21A only)	4
-6	37086	BOGIE SUPPORT ASSEMBLY - HALF (Used on SD15P10B only) .	3
	34907	BOGIE SUPPORT ASSEMBLY - HALF (Used on SD18E20B, SD18P27A, SD18E25B, SD18E27A and SD18P21A only)	2
-7	37084	SUPPORT SHAFT, Bogie wheel (Used on SD15P10B only)	3
	33754	SUPPORT SHAFT, Bogie wheel (Used on SD18E20B, SD18P27A, SD18E25B, SD18E27A and SD18P21A only)	2
-8	37088	BOGIE WHEEL AND SUPPORT ASSEMBLY - HALF (Used on SD15P10B only)	3
	34903	BOGIE WHEEL AND SUPPORT ASSEMBLY - HALF (Used on SD18E20B, SD18P27A, SD18E25B, SD18E27A and SD18P21A only)	2
-9	33713	WHEEL, Bogie (Used on SD15P10B only)	6
	33713	WHEEL, Bogie (Used on SD18E20B, SD18P27A, SD18E25B, SD18E27A and SD18P21A only)	4
-10	33736	LOCKNUT, 5/8-18 THD (Used on SD15P10B only)	6
	33736	LOCKNUT, 5/8-18 THD (Used on SD18E20B, SD18P27A, SD18E25B, SD18E27A and SD18P21A only)	4
-11	37089	SUPPORT ASSEMBLY, Bogie (Used on SD15P10B only)	3
	34908	SUPPORT ASSEMBLY, Bogie (Used on SD18E20B, SD18P27A, SD18E25B, SD18E27A and SD18P21A only)	2
	1002111	BOGIE ASSEMBLY, Front (Used on SD18E20B, SD18P27A, SD18E25B, SD18E27A and SD18P21A only) (See figure 1)	REF
-12	33712	TORSION SPRING, Bogie, RH (Used on SD18E20B, SD18P27A, SD18E25B, SD18E27A and SD18P21A only)	1
-13	33711	TORSION SPRING, Bogie, LH (Used on SD18E20B, SD18P27A, SD18E25B, SD18E27A and SD18P21A only)	1
-14	33713	WHEEL, Bogie (Used on SD18E20B, SD18P27A, SD18E25B, SD18E27A and SD18P21A only)	3
-15	33736	LOCKNUT, 5/8-18 THD (Used on SD18E20B, SD18P27A, SD18E25B, SD18E27A and SD18P21A only)	2
-16	1002046	SHAFT, Bogie axle (Used on SD18E20B, SD18P27A, SD18E25B, SD18E27A and SD18P21A only)	1
-17	33907	BUSHING, Bogie (Used on SD18E20B, SD18P27A, SD18E25B, SD18E27A and SD18P21A only)	4
-18	33754	SUPPORT SHAFT, Bogie wheel (Used on SD18E20B, SD18P27A, SD18E25B, SD18E27A and SD18P21A only)	1

Figure 9

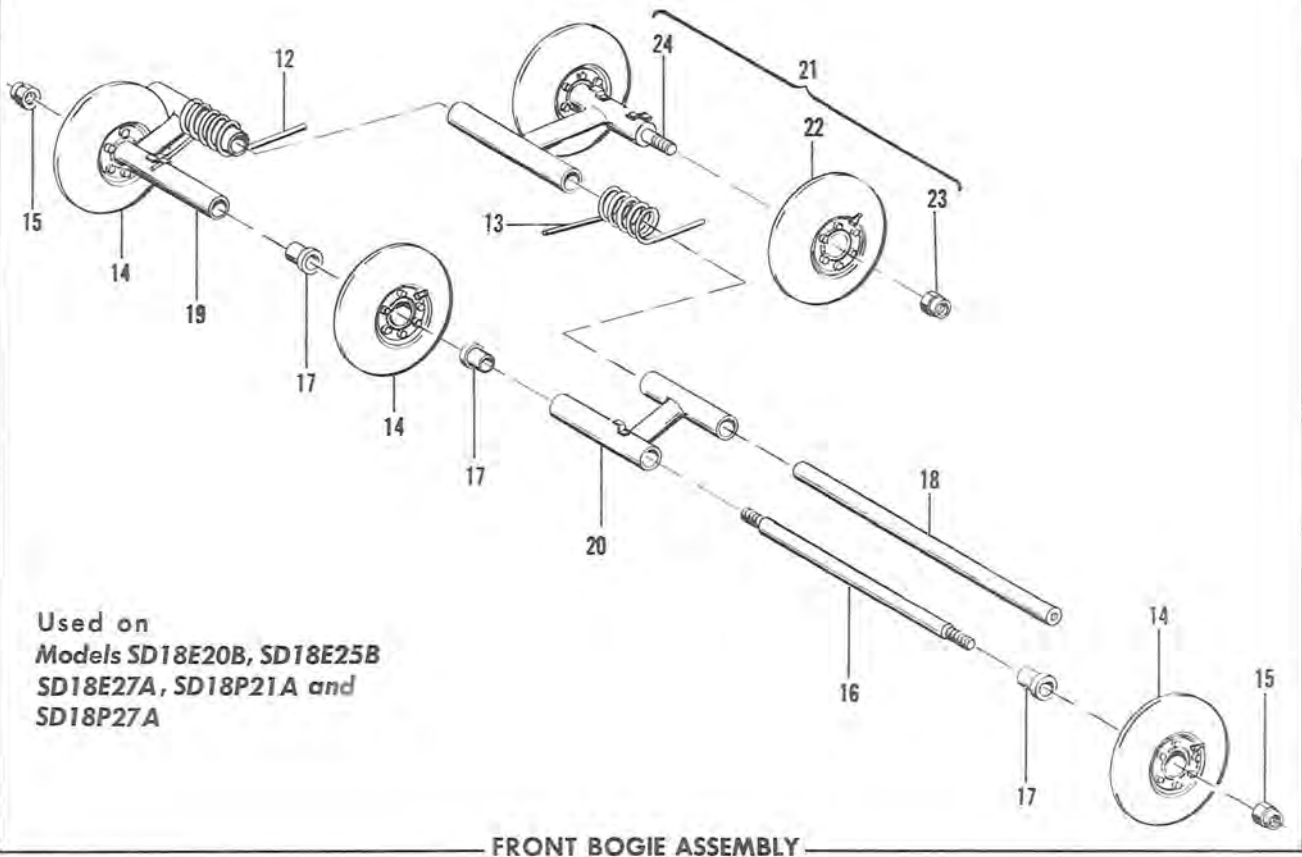
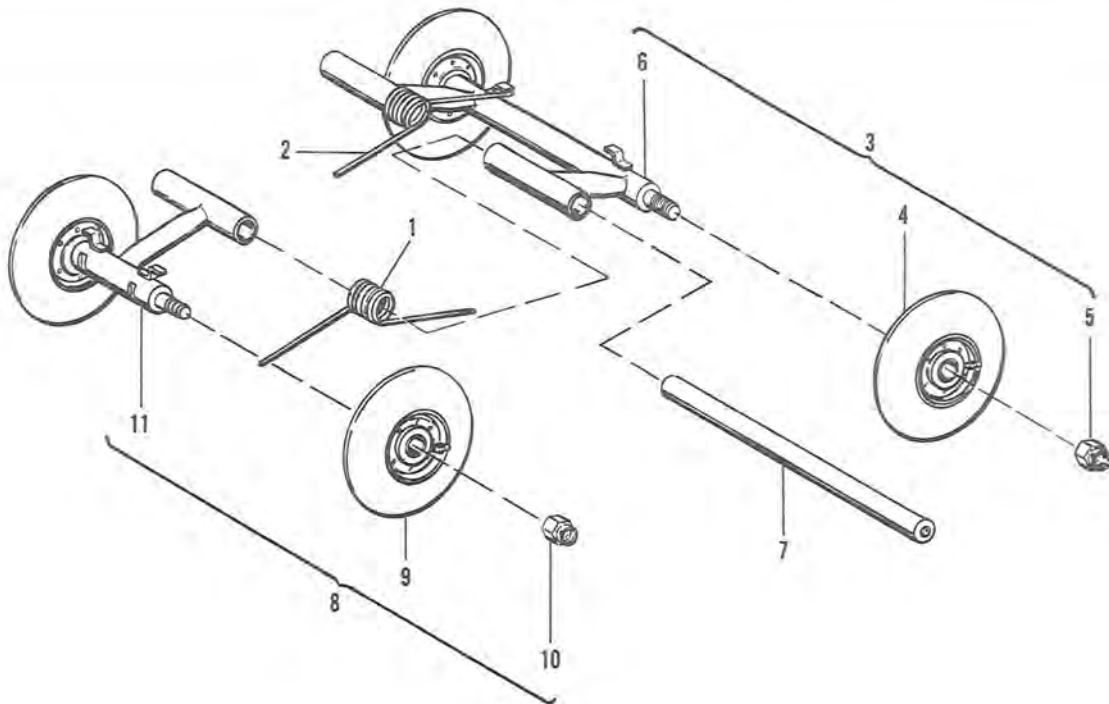


Figure & Index Number	Part Number	Description	Qty
9-19	1002112	SUPPORT ASSEMBLY, Bogie, RH (Used on SD18E20B, SD18P27A, SD18E25B, SD18E27A and SD18P21A only)	1
-20	1002113	SUPPORT ASSEMBLY, Bogie, LH (Used on SD18E20B, SD18P27A, SD18E25B, SD18E27A and SD18P21A only)	1
-21	34903	BOGIE WHEEL AND SUPPORT ASSEMBLY - HALF (Used on SD18E20B, SD18P27A, SD18E25B, SD18E27A and SD18P21A only)	1
-22	33713	WHEEL, Bogie (Used on SD18E20B, SD18P27A, SD18E25B, SD18E27A and SD18P21A only)	2
-23	33736	LOCKNUT, 5/8-18 THD (Used on SD18E20B, SD18P27A, SD18E25B, SD18E27A and SD18P21A only)	2
-24	34908	SUPPORT ASSEMBLY, Bogie (Used on SD18E20B, SD18P27A, SD18E25B, SD18E27A and SD18P21A only)	1

Figure & Index Number	Part Number	Description	Qty
10-1	1002018	CHAIN COVER, Top	1
-2	37140	ROLLER CHAIN, 35-2, 100-pitch (Used on SD18E20B, SD18P27A, SD18E25B, SD18E27A and SD15P10B only)	1
	37141	ROLLER CHAIN, 35-2, 102 pitch (Used on SD18P21A only)	1
-3	137258	COTTER PIN, 3/16 IN. by 1-3/4 IN. LG	1
-4	35042	SPROCKET, 35-2, 45 teeth (Used on SD18P27A, SD18E25B, SD18E27A and SD15P10B only)	1
	35041	SPROCKET, 35-2, 44 teeth (Used on SD18E20B and SD18P21A only)	1
-5	34629	SPACER	1
-6	180078	BOLT, HEX HD, 5/16-18 THD by 7/8 IN. LG	1
-7	37440	WASHER, Chain cover	1
	1002200	DRIVEN CLUTCH AND CASTING ASSEMBLY (Used on SD18E20B only) (See figure 1)	REF
	1002201	DRIVEN CLUTCH AND CASTING ASSEMBLY (Used on SD18E25B only) (See figure 1)	REF
	1002202	DRIVEN CLUTCH AND CASTING ASSEMBLY (Used on SD18P21A only) (See figure 1)	REF
	1002203	DRIVEN CLUTCH AND CASTING ASSEMBLY (Used on SD18P27A and SD18E27A only) (See figure 1)	REF
	1002140	DRIVEN CLUTCH AND CASTING ASSEMBLY (Used on SD15P10B only) (See figure 1)	REF
-8	37254	ROD TENSIONER, Clutch	1
-9	272726	STUD, 3/8-24 THD by 1-1/2 IN. LG	1
-10	9000125	LOCKNUT, 3/8-24 THD	1
-11	34277	SPROCKET, 35-2, 19 teeth (Used on SD18E25B and SD15P10B only)	1
	34304	SPROCKET, 35-2, 21 teeth (Used on SD18E20B only)	1
	34305	SPROCKET, 35-2, 23 teeth (Used on SD18P21A only)	1
	34278	SPROCKET, 35-2, 18 teeth (Used on SD18P27A and SD18E27A only)	1
-12	119120	COTTER PIN, 3/32 IN. by 1-1/4 IN. LG	1

Figure 10

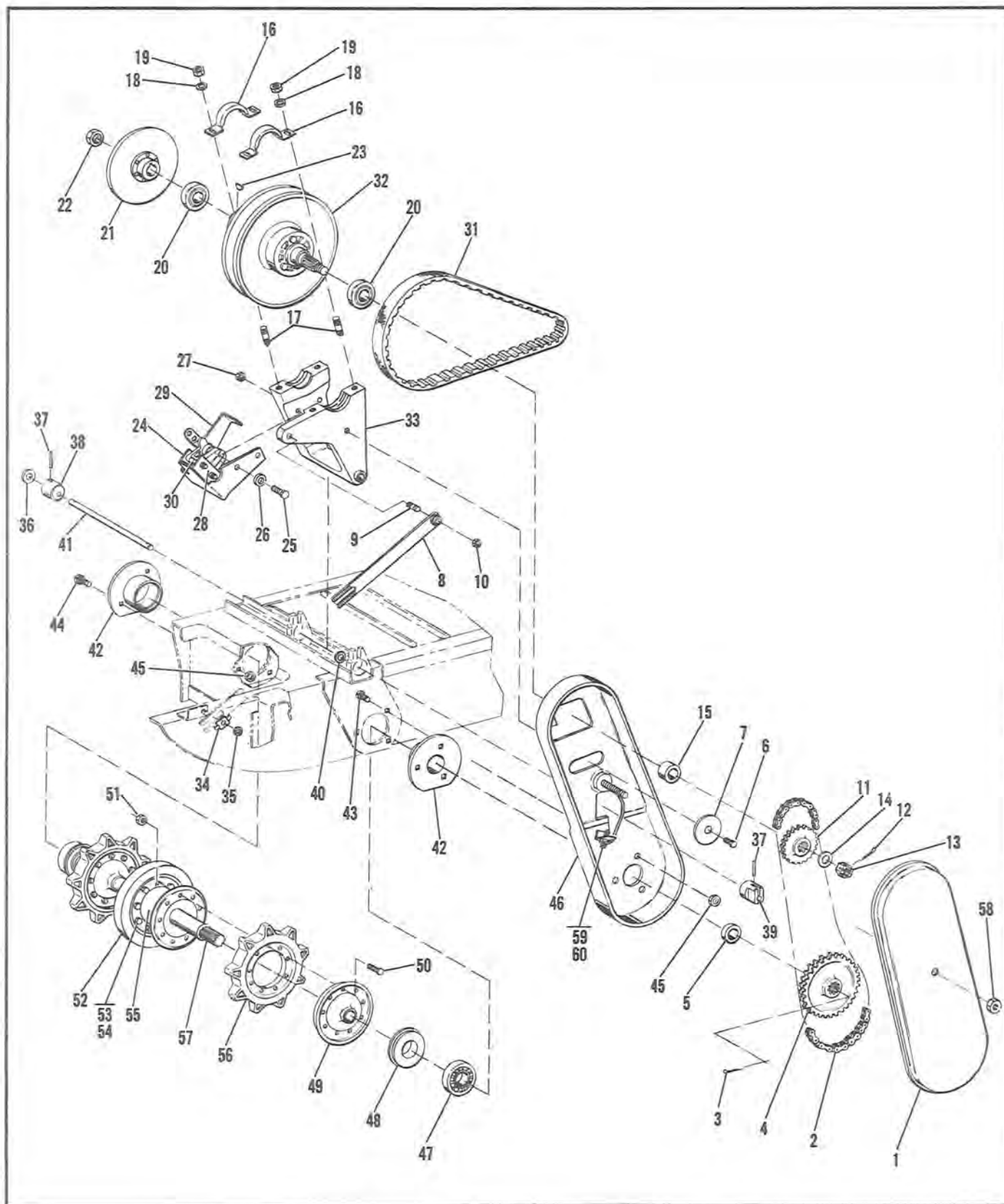


Figure & Index Number	Part Number	Description	Qty
10-13	125250	NUT, Slotted, 1/2-20 THD	1
-14	9417098	WASHER, Flat, 17/32 IN. ID by 1 IN. OD	1
-15	34628	SPACER	1
-16	34636	CLAMP, Bearing	2
-17	147664	STUD	4
-18	120393	WASHER, 11/32 IN. ID by 11/16 IN. OD	4
-19	9000124	LOCKNUT, 5/16-24 THD	4
-20	34645	BEARING, Driven clutch	2
-21	28784	HUB AND DISC ASSEMBLY	1
-22	272686	LOCKNUT, 3/4-16 THD	1
-23	106751	KEY, Woodruff, No. 9, 3/16 IN. by 3/4 IN. LG	1
-24	1002100	DISC BRAKE ASSEMBLY	1
-25	180077	BOLT, HEX HD, 5/16-18 THD by 3/4 IN. LG	2
-26	138538	LOCKWASHER, Internal tooth	2
-27	9000124	LOCKNUT, 5/16-24 THD	2
-28	1002098	BRAKE BRACKET	1
-29	1002099	ARM, Brake bracket	1
-30	1002134	CALIPER, Disc brake	1
-31	37172	BELT, Variable speed (Used on SD15P10B only)	1
	34914	BELT, Variable speed (Used on SD18E20B, SD18P27A and SD18E27A only)	1
	1002110	BELT, Variable speed (Used on SD18P21A only)	1
	1002147	BELT, Variable speed (Used on SD18E25B only)	1
-32	1002185	DRIVEN CLUTCH AND SHAFT ASSEMBLY	1
		(Used on SD18E20B only)	
	1002183	DRIVEN CLUTCH AND SHAFT ASSEMBLY	1
		(Used on SD18P27A, SD18E25B and SD18E27A only)	
	1002187	DRIVEN CLUTCH AND SHAFT ASSEMBLY	1
		(Used on SD18P21A only)	
	37170	DRIVEN CLUTCH AND SHAFT ASSEMBLY	1
		(Used on SD15P10B only)	
-33	1002020	DRIVEN CLUTCH MOUNTING (Make from 34926)	1
-34	37253	WASHER, Serrated	1
-35	9000124	LOCKNUT, 5/16-24 THD	1
-36	34826	RING, Circular push-on	1
-37	273938	PIN, Spring	2
-38	34950	CAM, Right side	1
-39	34952	CAM, Left side	1
-40	9417098	WASHER, Plain, 17/32 IN. ID by 1 IN. OD	1
-41	34965	SHAFT, Clutch mounting	1
-42	37024	BEARING RETAINER AND PLATE ASSEMBLY	2
-43	9000322	BOLT, Carriage, 5/16-24 THD by 3/4 IN. LG	3
-44	9000321	BOLT, Carriage, 5/16-24 THD by 5/8 IN. LG	3
-45	9000124	LOCKNUT, 5/16-24 THD	6
-46	1002045	CHAIN COVER ASSEMBLY, Bottom (Used on SD18E20B, SD18P27A, SD18E25B, SD18E27A and SD15P10B only)	1
	1002377	CHAIN COVER ASSEMBLY, Bottom (Used on SD18P21A only) ..	1
	37113	DRIVE SPROCKET ASSEMBLY (Used on SD15P10B only) (See figure 1)	REF
	34929	DRIVE SPROCKET ASSEMBLY (Used on SD18E20B, SD18P27A, SD18E25B and SD18E27A only) (See figure 1)	REF
	37762	DRIVE SPROCKET ASSEMBLY (Used on SD18P21A only) (See figure 1)	REF

Figure & Index Number	Part Number	Description	Qty
10-47	34648	BEARING, 25 MM bore	2
-48	30079	SEAL, Grease	2
-49	37192	SPROCKET SUPPORT PLATE ASSEMBLY	2
-50	181566	SCREW, 1/4-28 THD by 3/4 IN. LG	18
-51	9000123	LOCKNUT, 1/4-28 THD	18
-52	1002179	WHEEL, Idler (Used on SD18E20B, SD18P27A, SD18E25B, ... SD18E27A and SD15P10B only)	1
-53	9000123	LOCKNUT, 1/4 THD (Used on SD18E20B, SD18P27A, ... SD18E25B, SD18E27A and SD15P10B only)	9
-54	181566	SCREW, HEX HD, 1/4-28 THD by 3/4 IN. LG	9
		(Used on SD18E20B, SD18P27A, SD18E25B, SD18E27A and SD15P10B only)	
-55	37192	SPROCKET SUPPORT PLATE ASSEMBLY	2
		(Used on SD18E20B, SD18P27A, SD18E25B, SD18E27A and SD15P10B only)	
-56	1002178	SPROCKET, Drive	2
-57	37114	DRIVE SHAFT AND PLATE ASSEMBLY (Used on SD15P10B only)	1
	34931	DRIVE SHAFT AND PLATE ASSEMBLY	1
		(Used on SD18E20B, SD18P27A, SD18E25B and SD18E27A only)	
	37763	DRIVE SHAFT AND PLATE ASSEMBLY (Used on SD18P21A only)	1
-58	9000394	LOCKNUT, 5/16-18 THD	1
-59	1002374	ADAPTER (Used on SD18P21A only)	1
-60	9000231	LOCKNUT, 1/4-28 THD (Used on SD18P21A only)	1

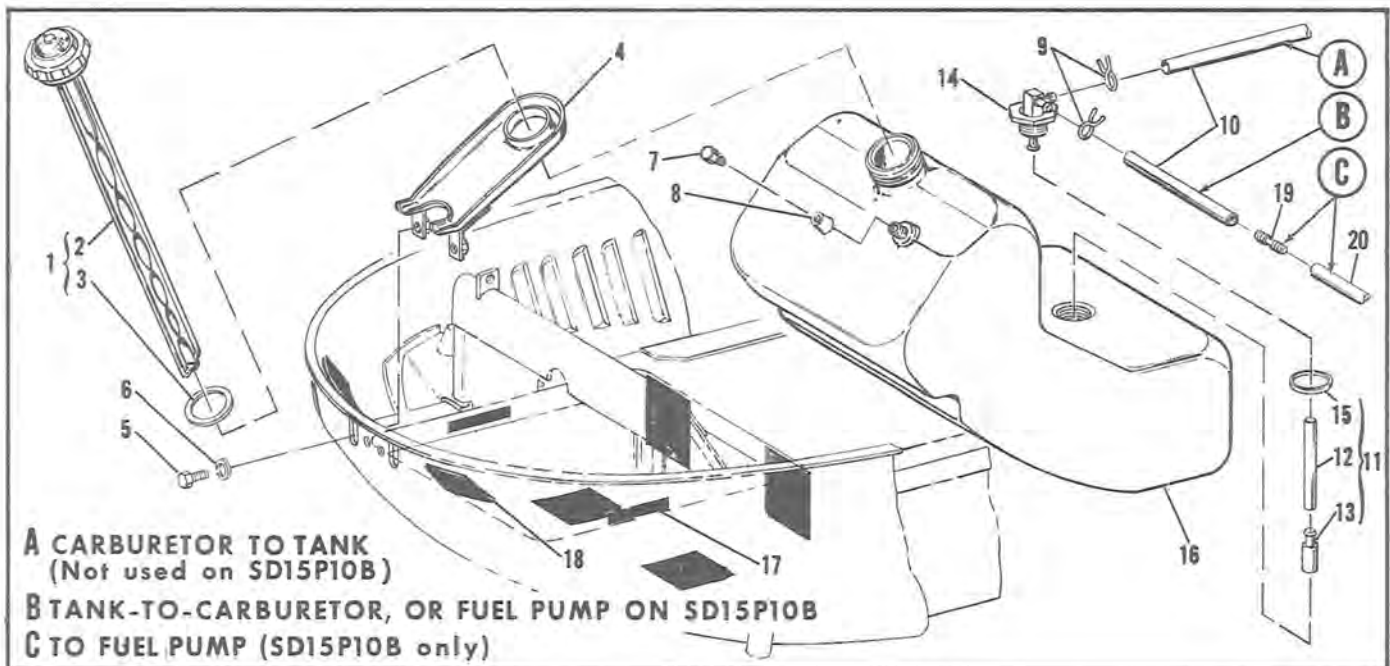
Figure 11


Figure & Index Number	Part Number	Description	Qty
11-1	37683	GAS CAP ASSEMBLY (See figure 1)	REF
-2	37265	GAS CAP AND INDICATOR ASSEMBLY	1
-3	37684	GASKET, Gas cap	1
-4	37357	SPILL CHUTE, Weldment, gas	1
-5	181566	BOLT, HEX HD, 1/4-28 THD by 3/4 IN. LG	2
-6	147579	WASHER, Plain	2
-7	37273	VENT AND PRESSURE RELIEF VALVE	1
-8	144107	PIPE REDUCER, 1/4 to 1/8 IN.	1
-9	30489	CLAMP, Hose (Used on SD18E20B, SD18P27A, SD18E27A, SD18E25B and SD18P21A only)	2
	30489	CLAMP, Hose (Used on SD15P10B only)	1
-10	37268	GAS LINE (Used on SD18E20B, SD18P27A, SD18E25B, SD18E27A and SD18P21A only)	37 IN.
	1002359	GAS LINE, Tank-to-fuel pump (Used on SD15P10B only)	1
-11	37277	GAS LINE ASSEMBLY, Tank (Used on SD18E20B, SD18P27A, SD18E25B, SD18E27A and SD18P21A only)	1
	37665	GAS LINE ASSEMBLY, Tank (Used on SD15P10B only)	1
-12	37267	GAS LINE, Gas tank	1
-13	37270	FILTER, Fuel tank	1
-14	37271	GAS OUTLET, Gas tank (Used on SD18E20B, SD18P27A, SD18E27A, SD18E25B, and SD18P21A only)	1
	34152	GAS OUTLET, Gas tank (Used on SD15P10B only)	1
-15	34154	GASKET, Gas tank outlet	1
-16	37259	GAS TANK, Plastic	1
-17	37418	PAD, Gas tank	2
-18	37636	PAD, Gas tank	8
-19	1002356	CONNECTOR, Tubing reducer (Used on SD15P10B only)	1
-20	1002357	GAS LINE, Fuel pump (Used on SD15P10B only)	1

Figure 12

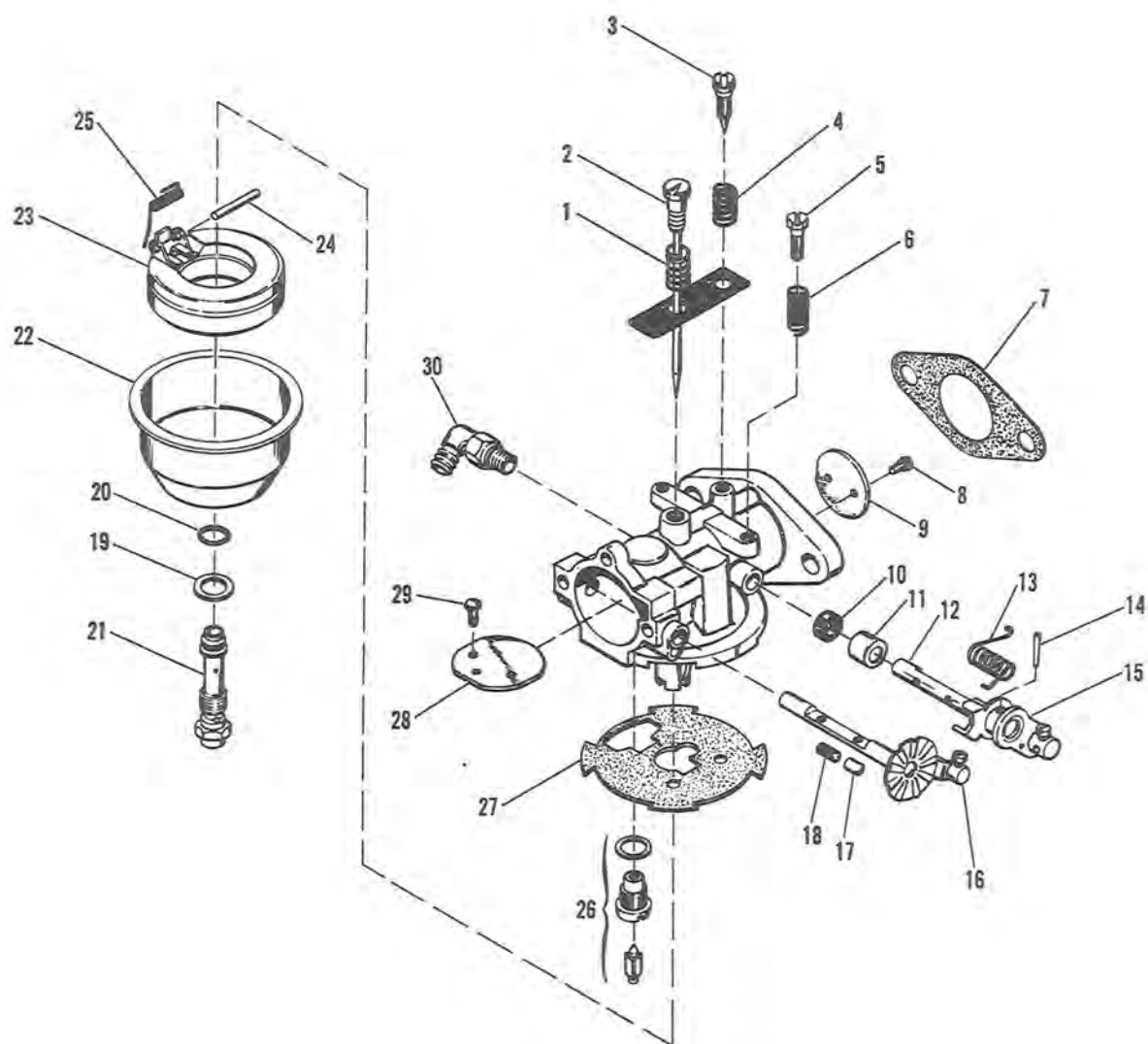


Figure & Index Number	Part Number	Description	Qty
12-	1002131	CARBURETOR (Used on SD15P10B only) (See figure 6)	REF
-1	1002330	SPRING, Main adjustment	1
-2	1002338	IDLE JET	1
-3	●1002315	SCREW, Idle adjustment	1
-4	1002316	SPRING	1
-5	1002317	SCREW	1
-6	1002318	SPRING	1
-7	●1002341	GASKET, Flange	1
-8	1002328	SCREW (Includes lockwasher)	2
-9	1002327	THROTTLE PLATE	1
-10	●1002313	SEAL, Rubber	1
-11	●1002314	SEAL, Retainer	1
-12	*1002326	THROTTLE SHAFT	1
-13	1002329	SPRING	1
-14	*1002325	PIN	1
-15	*1002324	LEVER AND STOP ASSEMBLY	1
-16	1002331	LEVER AND SHAFT ASSEMBLY	1
-17	1002332	PIN	1
-18	1002334	SPRING	1
-19	●1002337	WASHER, Fiber	1
-20	●1002336	O-RING	1
-21	1002335	JET AND TUBE ASSEMBLY	1
-22	1002323	FUEL BOWL	1
-23	1002319	FLOAT ASSEMBLY	1
-24	●1002320	FLOAT AXLE	1
-25	●1002321	SPRING, Float	1
-26	●1002339	FUEL VALVE AND SEAT ASSEMBLY	1
-27	●1002322	GASKET, Bowl-to-body	1
-28	1002333	CHOKE PLATE	1
-29	1002328	SCREW AND LOCKWASHER	2
-30	1002522	ELBOW CONNECTOR	1

* AMF Part No. 1002340 (includes items 12, 14 and 15) may be ordered for spares.

● Available in kits only, order Carburetor Repair Kit, AMF Part No. 1002312.

NUMERICAL LIST

Part No.	Figure & Index Number	Qty	Part No.	Figure & Index Number	Qty	Part No.	Figure & Index Number	Qty
1002000	1-	1	1002127	1-31	1	1002182	6-9	1
1002001	1-	1		4-	REF	1002183	10-32	1
1002003	1-	1	1002128	8-5	1	1002184	7-14	1
1002004	1-	1	1002129	8-5	1	1002185	10-32	1
1002005	1-	1	1002131	6-8	1	1002186	7-14	1
1002012	1-	1	1002132	3-104	1	1002187	10-32	1
1002018	10-1	1	1002133	6-2	1	1002188	7-14	1
1002020	10-33	1	1002134	10-30	1	1002193	7-2	1
1002037	7-19	1	1002135	7-22	1	1002194	7-1	1
1002044	6-28	1	1002136	5-1	1	1002195	7-38	1
	7-39	1	1002137	5-1	1	1002198	1-59	1
1002045	10-46	1	1002139	1-42	1		7-46	1
1002046	9-16	1		6-	REF		10-28	1
1002076	1-79	1	1002140	1-74	1	1002199	10-29	1
1002077	1-79	1		10-	REF	1002200	1-74	1
1002078	1-79	1	1002143	2-25	1		10-	REF
1002079	1-79	1	1002147	10-31	1	1002201	1-74	1
1002085	7-39	1	1002148	1-42	1		10-	REF
1002088	8-12	1		7-	REF	1002202	1-74	1
1002089	8-12	1	1002154	1-1	1		10-	REF
1002091	1-64	1		2-	REF	1002203	1-74	1
	8-	REF	1002155	2-13	1		10-	REF
1002092	1-64	1	1002157	1-31	1	1002206	3-56	1
	8-	REF		5-	REF	1002207	3-56	1
1002096	2-4	1	1002158	5-7	1	1002208	3-56	1
1002100	10-24	1	1002159	5-8	1	1002209	3-56	1
1002101	7-22	1	1002164	7-48	1	1002210	3-56	1
1002102	7-19	1	1002165	7-48	1	1002211	3-56	1
1002107	7-10	1	1002166	2-36	1	1002218	3-59	1
1002110	10-31	1	1002167	1-1	1	1002219	3-59	1
1002111	1-70	1		2-	REF	1002222	3-42	1
	9-11	REF	1002168	1-1	1	1002223	3-42	1
1002112	9-19	1		2-	REF	1002226	7-38	1
1002113	9-20	1	1002169	1-31	1	1002228	7-32	1
1002115	1-42	1		5-	REF	1002229	7-33	1
	7-	REF	1002170	1-73	1	1002230	7-71	1
1002116	1-42	1	1002171	2-13	1	1002231	3-30	1
	8-	REF	1002172	1-42	1	1002234	1-79	1
1002117	7-43	1		7-	REF	1002238	1-58	1
1002118	5-15	1	1002178	8-23	2	1002239	3-32	1
1002123	1-42	1		10-56	2	1002242	1-4	1
	7-	REF	1002179	8-19	1		3-	REF
						1002243	1-4	1

Part No.	Figure & Index Number	Qty	Part No.	Figure & Index Number	Qty	Part No.	Figure & Index Number	Qty
1002243 (Cont)	3-	REF	1002340	12-12	1	138549	10-26	2
1002244	1-4	1	1002341	12-7	1		6-11	1
	3-	REF	1002354	7-33	1	142443	7-69	1
1002245	1-4	1	1002356	6-32	1	144107	3-22	1
	3-	REF		11-19	1	144518	11-8	1
1002246	1-4	1	1002357	6-33	1	144815	3-83	4
	3-	REF		11-20	1		4-2	6
1002247	1-4	1	1002358	6-34	1		4-4	4
	3-	REF	1002359	11-10	1		5-2	6
1002248	3-44	1	1002360	7-3	1		5-4	4
1002249	3-44	1	1002361	7-4	1		5-10	1
1002250	3-44	1	1002362	6-10	1	144579	5-14	4
1002251	3-44	1	1002364	1-53	1		3-15	4
1002252	3-44	1	1002366	1-50	1		3-39	4
1002253	3-44	1	1002369	7-72	1		3-46	2
	7-32	1	1002372	7-75	3	147664	11-6	2
1002257	7-52	1	1002374	10-59	1	1500477	11-17	4
1002258	7-68	1	1002377	10-46	1	1500480	3-58	1
1002259	7-24	2	1002435	7-70	1	1500932	3-53	2
1002260	3-37	1	1002519	6-35	1		6-6	1
1002261	3-37	1	1002522	12-30	1	180077	7-7	1
1002275	3-82	2	1002525	12-31	2	180078	10-25	1
1002276	3-98	2	106751	10-23	1	180147	10-6	1
1002277	7-11	1	119120	10-12	1	180175	6-13	4
1002278	1-13	2	120382	1-76	2	181003	7-20	4
	3-78	REF	120383	6-14	4		1-61	2
1002313	12-10	1	120384	7-21	4	181561	7-60	1
1002314	12-11	1	120392	1-38	1	181566	1-55	2
1002315	12-3	1		1-56	4		1-60	2
1002316	12-4	1		1-62	4		6-24	2
1002317	12-5	1		6-25	4		7-35	2
1002318	12-6	1		7-36	4		8-17	18
1002319	12-23	1	120393	6-18	4		8-20	9
1002320	12-24	1		7-25	4		10-50	18
1002321	12-25	1		11-18	4		10-54	9
1002322	12-27	1	120394	1-9	4		11-5	2
1002323	12-22	1	120423	7-74	3	181573	1-15	4
1002324	12-15	1	120612	3-63	2	181578	1-22	4
1002325	12-14	1	121801	7-64	1		3-14	2
1002327	12-9	1	121900	7-73	3	181581	1-37	1
1002328	12-8	2	124818	2-14	4	181595	1-71	6
	12-29	2	124925	3-12	7	181643	1-75	2
1002329	12-13	1	125250	10-13	1		3-8	2
1002330	12-1	1	125680	2-33	6		3-87	4
1002331	12-16	1	128157	4-37	2	181648	1-8	2
1002332	12-17	1		5-16	2	181651	3-3	2
1002333	12-28	1	132712	4-10	4		8-7	2
1002334	12-18	1	132908	2-5	2	181710	6-30	1
1002335	12-21	1	133427	7-57	1	187759	2-34	1
1002336	12-20	1	137258	3-71	2	189329	3-79	2
1002337	12-19	1		10-3	1	189348	7-15	1
1002338	12-2	1	138485	1-72	6	21777	3-4	4
1002339	12-26	1	138538	7-66	2		3-9	4

Part No.	Figure & Index Number	Qty	Part No.	Figure & Index Number	Qty	Part No.	Figure & Index Number	Qty
221158	4-28	14	33730	3-94	2	34903	9-8	2
272686	10-22	1	33731	3-93	2		9-21	1
272726	10-9	1	33736	9-5	6	34907	9-6	2
273407	2-21	1		9-10	6	34908	9-11	2
273938	10-37	2		9-15	2		9-24	1
274517	3-88	4		9-23	2	34914	10-31	1
274865	1-35	4	33746	3-99	2	34919	3-101	2
28762	3-85	2	33748	3-83	2	34929	1-77	1
28784	10-21	1	33753	3-75	2		10-	REF
30079	8-15	2	33754	9-7	2	34931	10-57	1
	10-48	2		9-18	1	34932	3-7	2
30081	3-11	4	33756	3-76	2	34943	3-13	2
30149	3-74	2	33768	1-49	4	34945	3-73	1
30251	3-5			7-27	2	34946	3-31	1
30270	6-3	1	33769	1-46	4	34949	3-32	1
	7-5	1	33778	1-24	2	34950	10-38	1
30313	5-11	1	33808	1-6	4	34952	10-39	1
30489	11-9	2		1-17	4	34960	1-73	1
32185	3-21	1		1-28	2	34965	10-41	1
32186	3-27	1		3-47	2	34969	3-90	2
32187	3-24	1	33859	6-5	1	34976	3-1	2
32188	3-26	2	33907	9-17	4	34983	2-47	6
32234	1-21	2	33979	7-41	1	34984	2-1	1
32237	8-10	2	34014	7-50	1	34985	1-1	1
32265	8-2	2	34024	4-14	4		2-	REF
32266	8-1	2	34032	6-23	1	34986	2-42	1
32528	1-45	4		7-34	1	34989	2-43	2
32532	1-44	4	34058	2-16	4	34991	2-10	1
32588	6-21	2	34090	7-5	1	34992	2-38	2
	7-30	4	34152	11-14	1	35000	1-3	1
	7-31	2	34154	11-15	1		2-49	1
33296	3-92	2	34271	2-2	3	35001	1-3	1
33297	3-91	2		2-41	4		2-50	1
33320	3-2	2		2-44	4	35005	2-45	6
33356	8-11	1		3-50	4	35011	2-40	2
33357	8-11	1	34277	10-11	1	35017	2-42	1
33395	5-13	2	34278	10-11	1	35021	2-13	1
33584	4-16	2	34304	10-11	1	35022	2-28	1
	5-9	1	34305	10-11	1	35023	2-23	2
33610	4-5	3	34628	10-15	1	35024	2-24	1
	5-5	2	34629	10-15	1	35027	2-19	2
33611	4-3	2	34636	10-16	2	35028	2-20	1
	5-3	2	34645	10-20	2	35029	2-22	4
33647	2-15	2	34648	8-14	2	35041	10-4	1
33705	8-8	2		10-47	2	35042	10-4	1
33711	9-2	3	34683	8-6	1	35044	3-60	1
	9-13	1	34684	8-6	1	37000	2-4	1
33712	9-1	3	34688	3-15	1	37001	2-12	1
	9-12	1	34689	3-18	1	37005	2-9	1
33713	9-4	6	34694	3-17	1	37006	2-7	1
	9-9	6	34826	10-36	1	37009	2-26	1
	9-14	3	34901	1-69	2	37024	10-42	2
	9-22	2		9-	REF	37029	1-2	1
33729	3-97	2	34902	9-3	2	37030	1-2	1

Part No.	Figure & Index Number	Qty	Part No.	Figure & Index Number	Qty	Part No.	Figure & Index Number	Qty
37031	2-31	1	37141	10-2	1	37251	4-27	7
37032	2-32	1	37142	7-32	1	37253	10-34	1
37033	2-31	1	37143	7-33	1	37254	10-8	1
37034	2-32	1	37145	1-73	1	37257	4-9	1
37036	3-49	2	37146	4-5	1	37258	7-11	1
37037	3-62	1	37147	4-5	1	37259	11-16	1
37038	3-65	1	37148	4-25	1	37265	11-2	1
37039	3-65	1	37149	3-30	1	37267	11-12	1
37040	3-1	2	37152	4-13	2	37268	11-10	37 In. Lg
37041	3-7	2	37155	4-13	2	37271	11-14	1
37042	3-13	2	37156	4-12	1	37273	11-7	1
37045	2-3	1	37157	4-34	1	37277	11-11	1
37051	2-13	2	37158	4-35	1	37278	4-18	1
37054	7-18	1	37159	3-28	1	37285	3-61	1
37055	2-17	1	37165	4-1	1	37286	3-61	1
37058	7-67	1	37166	3-33	1	37288	4-17	2
37062	7-44	1	37167	3-34	1	37343	1-53	1
37064	7-42	1	37168	3-35	1	37351	1-36	1
37069	2-25	1	37169	3-41	1	37353	7-40	1
37071	7-48	1	37170	10-32	1	37357	11-4	1
37072	3-52	1	37172	10-31	1	37373	4-22	3
37075	3-53	1	37173	6-27	1	37374	3-49	2
37076	3-54	1	37175	1-20	1	37377	7-59	1
37077	3-70	1	37181	6-1	1	37381	7-56	1
37078	4-16	2	37183	6-22	1	37382	7-55	1
37079	7-19	1	37184	1-14	2	37383	7-17	1
37080	1-3	1	37186	1-23	2	37387	7-51	1
	2-49	1	37187	6-20	2	37392	4-20	1
37081	1-3	1	37188	6-15	1	37394	4-21	1
	2-50	1	37189	6-17	2	37395	4-19	1
37083	1-68	3	37190	7-13	1	37400	5-12	1
	9-	REF	37191	7-12	1	37411	3-82	2
37084	9-7	3	37192	8-16	2	37412	3-86	2
37085	9-3	3		8-22	1	37418	11-17	2
37086	9-6	3		10-49	2	37432	3-66	1
37088	9-8	3		10-50	2	37438	7-29	2
37089	9-11	3	37196	8-13	1	37440	10-7	1
37092	7-62	1	37198	8-24	1	37448	3-36	1
37094	7-49	1	37199	8-13	1	37451	3-33	1
37095	7-38	1	37200	8-24	1	37471	2-29	1
37099	7-2	1	37205	4-36	1	37486	3-29	1
37101	7-1	1	37222	3-77	2	37591	2-48	1
37105	6-12	1	37225	6-4	1	37593	6-29	1
37113	1-77	1	37226	3-81	2		7-40	1
	10-	REF	37230	3-57	1	37595	1-47	3
37114	10-57	1	37231	3-20	2	37636	11-18	8
37118	7-22	1	37237	4-24	1	37644	4-23	3
37124	3-72	2	37238	4-26	1	37646	4-29	2
37126	7-24	2	37245	1-13	2	37647	4-32	2
37131	7-6	1		3-78	REF	37651	4-15	2
37133	3-43	1	37246	3-100	2	37665	11-11	1
37135	3-51	2	37247	3-103	2	37666	6-7	1
37137	3-36	1	37249	3-95	2		7-8	1
37140	10-2	1	37250	3-96	2	37683	1-78	1

Part No.	Figure & Index Number	Qty	Part No.	Figure & Index Number	Qty	Part No.	Figure & Index Number	Qty
	6-1	1	9000122	2-6	2	9000125	1-10	2
	11-1	REF		2-8	2		1-48	4
37684	11-3	1		3-23	1		3-6	2
37698	1-50	1		3-64	2		3-10	2
37699	7-28	4		3-69	1		3-80	2
37709	2-30	1		3-106	2		3-89	4
37762	1-77	1		7-65	2		8-9	2
	10-	REF	9000123	1-7	4		10-10	1
37763	10-57	1		1-12	2	9000126	7-58	1
37764	1-31	1		1-19	4	9000231	10-60	1
	4-	REF		1-30	2	9000302	1-11	2
37765	1-59	1		1-32	6		1-55	3
	7-46	REF		1-39	1		3-38	4
37778	1-54	1		1-57	4		4-6	3
37801	1-52	1		1-63	4	9000321	10-44	3
38425	7-19	1		2-46	6	9000322	1-64	2
38488	7-6	1		3-19	2		10-43	3
420991	7-9	3		3-40	4	9000323	8-16	4
420998	6-31	3		3-48	4		7-23	4
422420	4-30	2		3-102	2	9000324	1-43	4
436695	7-53	2		4-8	3	9000394	10-58	1
436750	7-63	2		6-26	2	9000461	2-27	2
446143	3-68	1		7-37	2	9000551	4-11	4
446188	1-18	4		7-45	2	9000552	5-7	3
	1-29	4		7-61	1	9000555	2-37	7
	1-33	6		8-18	18	9000884	2-26	1
436667	5-6	3		8-21	9	9000885	2-26	1
436756	3-67	1		10-53	9	9000892	2-26	1
437028	2-18	1	9000124	1-34	4	9000911	1-51	2
445170	2-11	4		1-67	2	9413314	2-35	1
	2-39	6		6-19	4	9414920	4-31	2
446897	3-105	2		7-26	4	9415426	1-5	4
456145	1-66	2		10-19	4		3-45	2
	8-3	2		10-27	2	9416107	7-47	4
706	1-80	2		10-35	1	9416904	1-16	4
9000121	4-24	3		10-45	6		4-7	6
	7-54	2		11-4	2	9417098	10-14	1
							10-40	1
						9417420	3-25	2

ADDENDUM

37344	1-82	2	1002098	10-28	1
37345	1-81	2	1002099	10-29	1
1002025	2-51	1	1002142	6-37	1
1002086	6-36	1	1002305	3-43	1
	7-76	1	1002353	7-32	1
			1002363	1-81	1
			1002365	1-82	2



CHANGE NOTICE

The following pages have been added to the Illustrated Parts List Section of the 1970/1971 Parts and Service Manual, Part No. 1002472.

Page No.

65	Added
66	Added
67	Added
68	Added

Please add the above pages to the back of the Numerical List to maintain page number continuity.



AMF WESTERN TOOL DIVISION
Parts and Service Department
Whiteford Road, York, Pennsylvania, 17402 • 717/848-1177
AMF INCORPORATED

Figure 13.

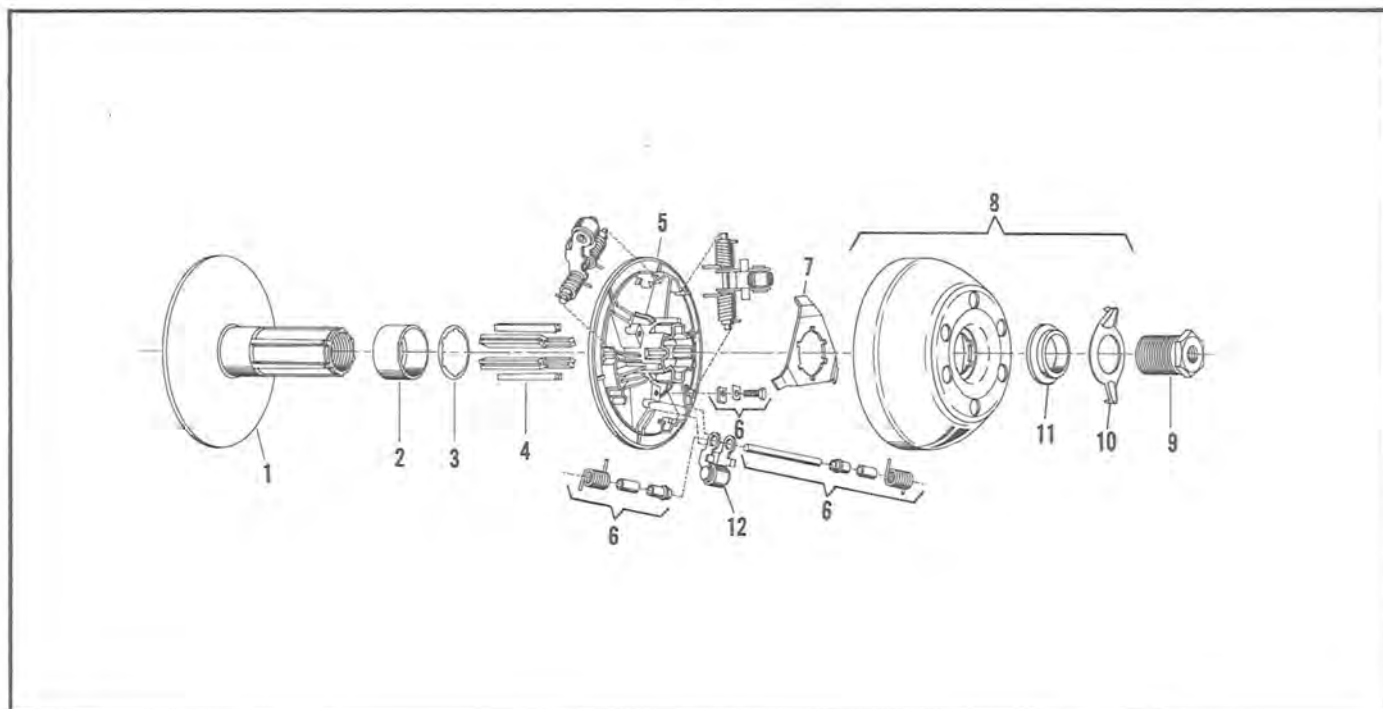


Figure & Index Number	Part Number	Description	Qty
13-	1002182	DRIVE CLUTCH ASSEMBLY (Used on SD15P10B only)	REF
-1	1002557	FIXED FACE AND HUB ASSEMBLY	1
-2	1002559	BEARING, Idler	1
-3	1002560	WASHER, Idler bearing	1
-4	1002561	LINER, Spline	6
-5	1002558	MOVABLE FACE ASSEMBLY	1
-6	1002643	SPRING KIT	1 set
-7	1002562	RETRACTOR, Roller weight	1
-8	1002563	RAMP PLATE ASSEMBLY	1
-9	*1002564	NUT	1
-10	1003063	LOCK PLATE	1
-11	1003089	WASHER, Ramp plate	1
-12	1003077	SERVICE KIT, Roller arm assembly	1 set

*Apply 125 ± 15 foot-pounds torque.

AMF PARTS LIST

Figure 14.

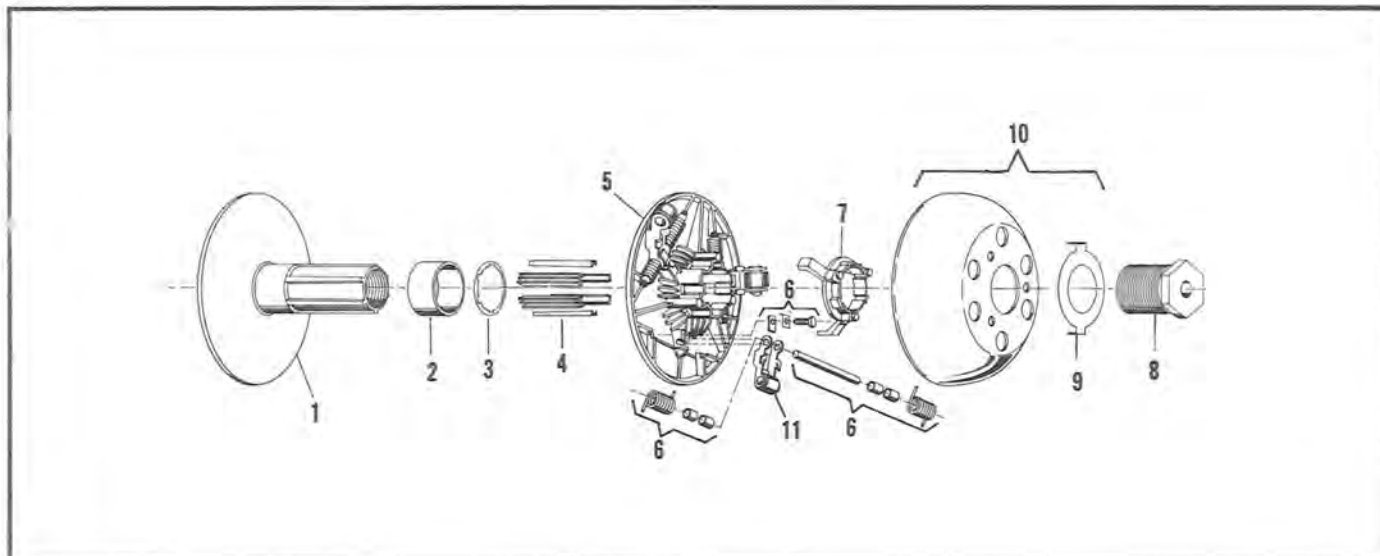


Figure & Index Number	Part Number	Description	Qty
14 -	1002186	DRIVE CLUTCH ASSEMBLY (Used on SD18E20B only) (See fig. 7)	REF
	1002184	DRIVE CLUTCH ASSEMBLY (Used on SD18P27A, SD18E27A and *SD18D27A only) (See figure 7)	REF
-1	37712	FIXED FACE ASSEMBLY (Used on SD18E20B, SD18P27A, SD18E27A and SD18D27A only)	1
-2	37713	BEARING, Idler (Used on SD18E20B, SD18P27A, SD18E27A and SD18D27A only)	1
-3	37714	WASHER, Idler bearing (Used on SD18E20B, SD18P27A, SD18E27A and SD18D27A only)	1
-4	37715	LINER, Spline (Used on SD18E20B, SD18P27A, SD18E27A and SD18D27A only)	6
-5	1002567	MOVABLE FACE ASSEMBLY (Used on SD18E20B only)	1
	1002565	MOVABLE FACE ASSEMBLY (Used on SD18P27A, SD18E27A and SD18D27A only)	1
-6	1002644	SPRING KIT (Used on SD18E20B, SD18P27A, SD18E27A and SD18D27A only)	1
-7	37718	SPIDER (Used on SD18E20B, SD18P27A, SD18E27A and SD18D27A only)	1
-8	**37936	NUT (Used on SD18E20B, SD18P27A, SD18E27A and SD18D27A only)	1
-9	37944	LOCK PLATE (Used on SD18E20B, SD18P27A, SD18E27A and SD18D27A only)	1
-10	1002568	RAMP PLATE (Used on SD18E20B only)	1
	1002566	RAMP PLATE (Used on SD18P27A, SD18E27A and SD18D27A only)	1
-11	1003078	SERVICE KIT, Roller arm assembly (Used on SD18P27A, SD18E27A and SD18D27A only)	1 set
	1003079	SERVICE KIT, Roller arm assembly (Used on SD18E20B only)	1 set

*Model SD18D27A replaces Model SD18E25B.

**Apply 150 ± 5 foot-pounds torque.

Figure 15.

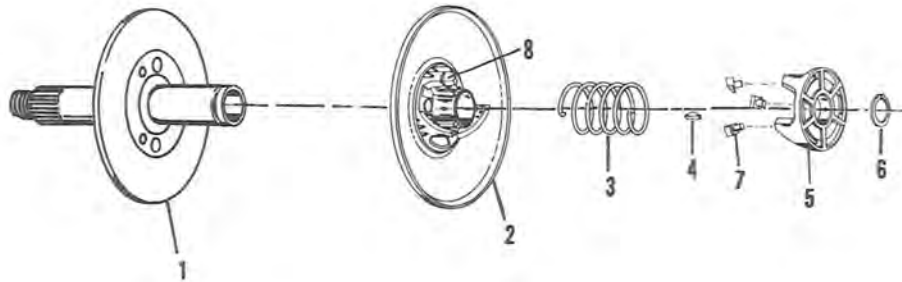


Figure & Index Number	Part Number	Description	Qty
15--	37170	DRIVEN CLUTCH AND SHAFT ASSEMBLY	REF
		(Used on SD15P10B only) (See figure 10)	
	1002185	DRIVEN CLUTCH AND SHAFT ASSEMBLY	REF
		(Used on SD18E20B only) (See figure 10)	
	1002187	DRIVEN CLUTCH AND SHAFT ASSEMBLY	REF
		(Used on SD18P21A only) (See figure 10)	
	1002183	DRIVEN CLUTCH AND SHAFT ASSEMBLY	REF
		(Used on SD18P27A, SD18E27A and *SD18D27A only)	
		(See figure 10)	
-1	37607	FIXED FACE AND SHAFT ASSEMBLY	1
		(Used on SD15P10B only)	
	37722	FIXED FACE AND SHAFT ASSEMBLY	1
		(Used on SD18E20B, SD18P27A, SD18E27A and SD18P21A only)	
	37908	FIXED FACE AND SHAFT ASSEMBLY	1
		(Used on SD15P10B only)	
-2	37608	MOVABLE FACE ASSEMBLY	1
		(Used on SD15P10B only)	
	1002575	MOVABLE FACE AND SLIPPER CAM ASSEMBLY	1
		(Used on SD18P21A only)	
	1002571	MOVABLE FACE AND SLIPPER CAM ASSEMBLY	1
		(Used on SD18E20B, SD18P27A, SD18E27A, and SD18D27A only)	
-3	37602	SPRING, 5-Coil black (Used on SD15P10B only)	1
	1002573	SPRING, 7-Coil yellow (Used on SD18P21A, ...	1
		SD18E20B, SD18P27A, SD18E27A and SD18D27A only)	
-4	37603	KEY, Morton Hi-Pro (Used on all models)	1
-5	37609	TORQUE BRACKET ASSEMBLY (Used on SD15P10B only) ..	1
	1002574	TORQUE BRACKET ASSEMBLY, Cam	1
		(Used on SD18E20B and SD18P21A only)	
	1002572	TORQUE BRACKET ASSEMBLY, Cam	1
		(Used on SD18P27A, SD18E27A and SD18D27A only)	
-6	37610	RING, Retaining (Used on all models)	1
-7	37604	BUTTON, Shoe ramp (Used on SD15P10B only)	3
-8	1003074	CAM, Slipper (Used on SD18E20B, SD18P21A, ...	3
		SD18P27A, SD18E27A and SD18D27A only)	

*Model SD18D27A replaces Model No. SD18E25B.

Figure 16.

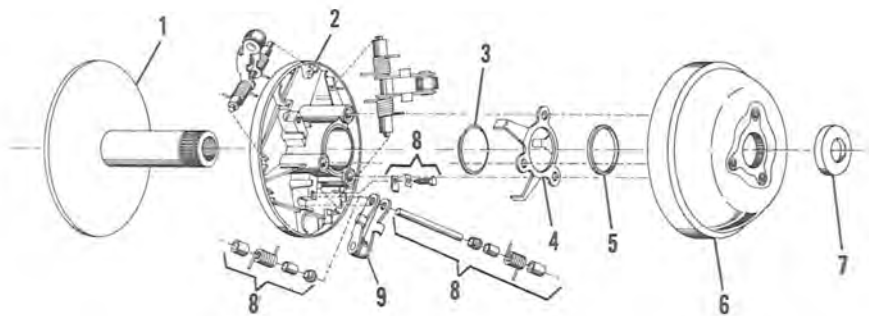


Figure & Index Number	Part Number	Description	Qty
16-	1002188	DRIVE CLUTCH ASSEMBLY (Used on SD18P21A only)	REF
-1	37927	(See figure 7) FIXED FACE AND HUB ASSEMBLY	1
-2	1002569	MOVABLE FACE ASSEMBLY	1
-3	1002570	RING, Retaining	1
-4	37903	RETRACTOR, Movable face	1
-5	37904	SPACER	1
-6	37905	RAMP PLATE	1
-7	37906	CUP WASHER, Retaining	1
-8	37900	SPRING KIT	1 set
-9	1003076	SERVICE KIT, Roller arm assembly	1 set