

SECTION 8



Specifications

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SECTION 8 - SPECIFICATIONS

MERCURY
SNOWMOBILES



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Master Specifications

Model	200	220	250	Rocket (339cc)	Lightning (398cc)	Hurricane (644cc)	440 MAX (438cc) ①	Mark I (644cc)	Mark II ② (644cc)
Engine Mfg.	Hirth	Mercury	Mercury	CCW	CCW	Mercury	CCW	Mercury	Mercury
Horsepower	20	22	25	25	30	35	40	40	50
Displacement	292cc	399cc	439cc	339cc	398cc	644cc	438cc	644cc	644cc
No. of Cylinders	1	2	2	2	2	2	2	2	2
Bore	2.913" (73.99mm)	2.500" (63.50mm)	2.625" (66.68mm)	2.36" (59.94mm)	2.56" (65.02mm)	3.125" (79.38mm)	2.60" (66.04mm)	3.125" (79.38mm)	3.125" (79.38mm)
Stroke	2.680" (68.07mm)	2.480" (62.99mm)	2.480" (62.99mm)	2.36" (59.94mm)	2.36" (59.94mm)	2.5625" (65.09mm)	2.52" (64.01mm)	2.56" (65.02mm)	2.56" (65.02mm)
Carburetor	Till. HR-66A	Till. MD-147A	Till. MD-147A1	Till. HR-84A	Till. HR-113A▲	Till. OM-40A	Till. HD-115A	Till. OM-41A	Till. HD-127A
Dimensions									
• Length (Including Skis)	101-5/8" (258cm)	106" (269cm)	106" (269cm)	98" (249cm)	98" (249cm)	99" (249cm)	100" (254cm)	99" (249cm)	99" (249cm)
• Width	33½" (85cm)	34" (86cm)	34" (86cm)	35" (89cm)	35" (89cm)	35" (89cm)	35" (89cm)	35" (89cm)	35" (89cm)
• Height (Including Windshield)	44-5/8" (113cm)	46-7/8" (119cm)	47¼" (120cm)	41¼" (106cm)	41¼" (106cm)	39½" (100cm)	41" (104cm)	39½" (100cm)	39½" (100cm)
Track Width	15½" (39cm)	17" (43cm)	17" (43cm)	15½" (39cm)	15½" (39cm)	17" (43cm)	15¼" (39cm)	17" (43cm)	17" (43cm)
Electrical System	← 12-Volt Negative Ground →								
Battery Rating	N.A.	46 Amp.	32 Amp.	32 Amp.	32 Amp.	32 Amp.	32 Amp.	32 Amp.	32 Amp.
Fuel Tank Capacity	5 U.S. Gals. (4.15 Imp. Gals.) (18.9L)	6 U.S. Gals. (4.99 Imp. Gals.) (22.7L)		5 U.S. Gals. (4.15 Imp. Gals.) (18.9L)		5 U.S. Gals. (4.15 Imp. Gals.) (18.9L)	5 U.S. Gals. (4.15 Imp. Gals.) (18.9L)	5 U.S. Gals. (4.15 Imp. Gals.) (18.9L)	5 U.S. Gals. (4.15 Imp. Gals.) (18.9L)
Fuel Requirement	← Automotive Regular →								
Oil/Gas Ratio	← 50:1 Normal § 25:1 Severe →								
Compression Ratio	10.3:1	9:1	7.7:1	8:1	8:1	7.7:1	7.85:1	7.2:1	7.2:1
Ignition	Flywheel Mag.	Thunderbolt	Thunderbolt	Flywheel Magneto		Thunderbolt	Flywheel Mag.	Thunderbolt	Thunderbolt
Spark Plug Type	M225T1	UL 18V	UL18V	L81	L78	D77V	AC-S40FR ■	L77V	L77V
Spark Plug Gap	.020" (.508mm)	Perma Gap	Perma Gap	.018" (.457mm)	.018" (.457mm)	Perma Gap	.016"-.020" (.406mm-.508mm)	Perma Gap	Perma Gap
Point Gap	.014"-.018" (.356mm-.457mm)	N.A.	N.A.	.012" (.305mm)	.012" (.305mm)	.020" (.508mm)	.012"-.016" (.305mm-.406mm)	N.A.	N.A.
Timing (BTDC)	.113"-.132" (2.870mm-3.350mm)	15° @5000 RPM		.010"-.015" (.254mm-.381mm)		27°-30° (.180"-.222") (4.597mm-5.639mm) @6000 RPM	.015"-.024" (.381mm-.610mm)	32°-34° @3000 RPM	26°-28° @3000 RPM
Idle RPM	← 1250-1350 →					900-1000	1800-2000	900-1000	2400-2500
Max. RPM at WOT	5500	5000	5000	6000	6000	6000	6500-6800	6000	6200-6500
Clutch	← Centrifugal Operated Torque Sensing →								
Clutch Engagement RPM	2200	2500	2200	2400-2800	2400-2800	1800-2000	3000-3500	2700-3000	3200-3500
Piston Skirt Clearance	.0067"-.010" (.170mm-.254mm)	.006"-.009" (.152mm-.229mm)	.0045"-.0075" (.114mm-.191mm)	.004"-.010" (.102mm-.254mm)	.004"-.010" (.102mm-.254mm)	.004"-.010" (.102mm-.254mm)	.004"-.010" (.102mm-.254mm)	.004"-.010" (.102mm-.254mm)	.004"-.010" (.102mm-.254mm)
Reed Stop Height	N.A.	7/32" (5.56mm)	7/32" (5.56mm)	N.A.	N.A.	1/8" (3.18mm)	7/16" (11.11mm)	1/8" (3.18mm)	3/8" (9.53mm)
Reed Clearance	N.A.	.008" (.203mm)	.008" (.203mm)	N.A.	N.A.	.007" (.178mm)	.008" (.203mm)	.007" (.178mm)	N.A.
Crankshaft End Play	N.A.	.008"-.012" (.203mm-.305mm)	.008"-.012" (.203mm-.305mm)	N.A.	N.A.	.004"-.008" (.102mm-.203mm)	N.A.	.004"-.008" (.102mm-.203mm)	.004"-.008" (.102mm-.203mm)

① CHASSIS Serial No. 3447382 and BELOW

■ Or Champion RL78

▲ Lightning (398cc) Models, Engine Serial No. 3800000 and Below,

② CHASSIS Serial No. 3591478 and BELOW

N.A. = Not Applicable

§ Mercury Quicksilver Snowmobile Oil or Formula 50-D ONLY.

Model	440 MAX & 440 S/R (438cc) ③	Mark II (644cc) ④	400 S/T (398cc)	340 S/R (338cc)	440 M/X & 440 S/R (438cc) ⑤	340 S/T (339cc)	440 S/T (429.4cc)	440 T/T ⑥ (436cc)	340 T/T (339cc)	440 T/T ⑦ (436cc)
Engine Mfg.	CCW	Mercury	Kohler	Kohler	Kioritz	Kohler	Kohler	Kohler	Kohler	Kohler
Horsepower	40	50	Not Available	30	44	Not Available	Not Available	50	40	50
Displacement	438cc	644cc	398cc	338cc	438cc	339cc	429.4cc	436cc	339cc	436cc
No. of Cylinders	2	2	2	2	2	2	2	2	2	2
Bore	2.60" (66.04mm)	3.125" (79.38mm)	2.559" (65mm)	2.441" (62mm)	2.60" (66mm)	2.362" (60.0mm)	2.657" (67.5mm)	2.68" (68.0mm)	2.362" (60.0mm)	2.677" (68.0mm)
Stroke	2.52" (64.01mm)	2.56" (65.02mm)	2.362" (60mm)	2.205" (56mm)	2.52" (64mm)	2.362" (60.0mm)	2.362" (60.0mm)	2.36" (60.0mm)	2.362" (60.0mm)	2.362" (60.0mm)
Carburetor	Walbro WDA 47	Walbro WRA 35	Mikuni VM36-9	Walbro WDA 50	Walbro WDA 47A	Mikuni VM36-23	Mikuni VM36-24	Mikuni VM36-25	Mikuni VM 32-91	Mikuni VM 36-34
Dimensions										
Length (Including Skis)	98" (249cm)	99" (252cm)	99¼" (252cm)	98" (249cm)	105-3/8" (268cm)	99-7/16" (253cm)	99-7/16" (253cm)	99-7/16" (253cm)	99-7/16" (253cm)	99-7/16" (253cm)
Width	35" (89cm)	35" (89cm)	39½" (100cm)	34¼" (88cm)	35-3/8" (90cm)	39½" (100cm)	39½" (100cm)	39½" (100cm)	39½" (100cm)	39½" (100cm)
Height (Incl. Windshield)	440 MAX 41" (104cm) 440 S/R 37¼" (95cm)	40" (102cm)	35¾" (91cm)	39¼" (100cm)	440 M/X 39" (100cm) 440 S/R 37¼" (95cm)	35¾" (91cm)	35¾" (91cm)	35¾" (91cm)	35¾" (91cm)	35¾" (91cm)
Track Width	15¼" (39cm)	17" (43cm)	15" (38cm)	15¼" (38cm)	15¼" (38cm)	15" (38cm)	15" (38cm)	15" (38cm)	15" (38cm)	15" (38cm)
Electrical System	12-Volt Negative Ground									
Battery Rating	32 Amp.	32 Amp.	N.A.	N.A.	32 Amp.	N.A.	N.A.	N.A.	N.A.	N.A.
Fuel Tank Capacity	5 U.S. Gals. (18.9ℓ) (4.15 Imp. Gals.)	5 U.S. Gals. (18.9ℓ) (4.15 Imp. Gals.)	6.2 U.S. Gals. (23.5ℓ) (5.2 Imp. Gals.)	5 U.S. Gals. (18.9ℓ) (4.15 Imp. Gals.)	5 U.S. Gals. (18.9ℓ) (4.15 Imp. Gals.)	6.2 U.S. Gals. (23.5ℓ) (5.2 Imp. Gals.)	6.2 U.S. Gals. (23.5ℓ) (5.2 Imp. Gals.)	6.2 U.S. Gals. (23.5ℓ) (5.2 Imp. Gals.)	6.2 U.S. Gals. (23.5ℓ) (5.2 Imp. Gals.)	6.2 U.S. Gals. (23.5ℓ) (5.2 Imp. Gals.)
Fuel Requirement	Automotive Regular	Regular ▲▲	Automotive Premium ▲	Automotive Regular	Automotive Regular	Automotive Premium ▲	Automotive Premium ▲	Automotive Premium	Automotive Regular	Automotive Regular
Fuel/Oil Ratio	50:1 Normal Service	§ 25:1 Severe Service	20:1	50:1 Normal Service	§ 25:1 Severe Service	20:1	20:1	50:1 Normal Service § 25:1 Severe Service		
Compression Ratio	7.85:1	7.6:1	12.4:1	7.5:1	7.85:1	13.6:1	12.9:1	11.5:1	11.8:1	11.5:1
Ignition	Flywheel Magneto	Thunderbolt	Capacitor Discharge	Flywheel Magneto	Flywheel Magneto	Capacitor Discharge	Capacitor Discharge	Capacitor Discharge	Capacitor Discharge	Capacitor Discharge
Spark Plug Type	Champion RN3	Champion QL-77V	Champion N-19V or Champion N-55G	AC S42XLR	AC S43XLR	Champion N-19V or Champion N-55G	Champion N-19V or Champion N-55G	Champion N-19V	Champion QN-19V	Champion QN-19V
Spark Plug Gap	.016" - .020" (.406mm - .508mm)	Perma Gap	.020" - .025" (.51mm - .64mm)	.016" - .020" (.40mm - .51mm)	.016" - .020" (.40mm - .51mm)	.020" - .025" (.51mm - .64mm)	.020" - .025" (.51mm - .64mm)	Perma Gap	Perma Gap	Perma Gap
Point Gap	.012" - .016" (.304mm - .406mm)	N.A.	N.A.	.014" - .018" (.36mm - .46mm)	.012" - .016" (.30mm - .41mm)	N.A.	N.A.	N.A.	N.A.	N.A.
Timing (BTDC)	.002" - .004" (.051mm - .102mm)	21° @ 3000 RPM	*.060" (1.52mm) @ 3000 RPM	20° @ 2500 RPM or .088" - .092" (2.24mm - 2.34mm) Static	17° - 19° @ 2500 RPM or .004" - .006" (.102mm - .152mm) Static	*.060" (1.52mm) @ 3000 RPM	*.060" (1.52mm) @ 3000 RPM	.095" (2.41mm) @ 3000 RPM	.080" (2.03mm) @ 3000 RPM	.080" (2.03mm) @ 3000 RPM
Idle RPM	2000-2200	2200-2500	2000 (Trail Riding); 3000 (Competition)	2200-2400	2000-2200	2500-3000	2500-3000	2400-2600	2000	2000
Max. RPM at WOT	6800-7000	6300-6500	8300-8500	6800-7000	6800-7000	8250	8250	7000	7000	7000
Clutch	Centrifugal Operated Torque Sensing									
Clutch Engagement RPM	3300-3600	3200-3400	3800-4000	3300-3600	3300-3600	3800-4000	3800-4000	3400-3600	3100-3300	3100-3300
Piston Skirt Clearance	.004" - .010" (.102mm - .254mm)	.003" - .010" (.076mm - .254mm)	.0034" - .0066" (.0863mm - .1676mm)	.0038" - .010" (.096mm - .254mm)	.004" - .010" (.102mm - .254mm)	.0034" - .0066" (.0863mm - .1676mm)	.0034" - .0066" (.0863mm - .1676mm)	.0034" - .0066" (.0863mm - .1676mm)	.0034" - .0066" (.0863mm - .1676mm)	.0034" - .0066" (.0863mm - .1676mm)
Reed Stop Height	7/16" (11.11mm)	5/16" (7.94mm)	N.A.	N.A.	7/16" (11.11mm)	N.A.	N.A.	N.A.	N.A.	N.A.
Reed Clearance	.008" (.203mm)	N.A.	N.A.	N.A.	.008" (.203mm)	N.A.	N.A.	N.A.	N.A.	N.A.
Crankshaft End Play	N.A.	.004" - .008" (.102mm - .203mm)	.006" - .012" (.152mm - .305mm)	.006" - .012" (.152mm - .305mm)	N.A.	.006" - .012" (.152mm - .305mm)	.006" - .012" (.152mm - .305mm)	.006" - .012" (.152mm - .305mm)	.006" - .012" (.152mm - .305mm)	.006" - .012" (.152mm - .305mm)

③ CHASSIS Serial No. 3709838 thru 3795657

④ CHASSIS Serial No. 3787640 and ABOVE

⑤ CHASSIS Serial No. 4064097 thru 4070296

⑥ CHASSIS Serial No. 4210249 and Below

⑦ CHASSIS Serial No. 4347125 and Above

N.A. = Not Applicable

§ Mercury Quicksilver Snowmobile Oil
or Formula 50-D ONLY▲ 96 AVERAGE Octane Minimum for Trail
Riding and 100/130 Av Gas for Competition* Advance Timing to .080"
(2.03mm) BTDC for Competition

■ Trail Riding

● Competition

▲▲ 89 AVERAGE Octane Minimum (If Not
Available, Use Automotive Premium)

TORQUE SPECIFICATIONS

Models 220-250

Location	Type Fastener	Size Fastener	Torque	
			In. Lbs.	Ft. Lbs.
CHASSIS				
Clutch Bell Weights	Bolt	10-32	60	
Brake Cable	Nut	¼-20	24	
Steering Flange to Crossmember	Bolt	¼-28	60	
Sprocket to Hub	Bolt	¼-28	60	
Bearing Lock Collar	Screw		120	
Chaincase Cover to Chaincase	Screw	5/16-18	216	
Weak Skeg to Ski	Nut	5/16-18	168	
Front Fuel Tank Mount	Nut	5/16-18	48	
Rear Fuel Tank Mount	Nut	5/16-24	168	
Brake to Chaincase	Bolt	5/16-24	216	
Steering (Top Bushing Clamp)	Bolt	5/16-24	120	
Steering Arm	Bolt	5/16-24	216-264	
Chaincase to Chassis (Lower)	Bolt	5/16-24	120	
Bogie Pivot Shaft to Chassis	Screw	3/8-16		25-30
Eccentric Adjustment (220 Only)	Screw	3/8-16	72	
Eccentric Adjustment (220 Only)	Nut	3/8-16		30-35
Eccentric Clamping (2547827 and Up)	Bolt	3/8-24	168	
Idler Arm - Adjustment	Bolt	3/8-24		25-30
Idler Arm - Retaining	Bolt	3/8-24	180-240	
Flangette - Right Side	Bolt	3/8-24	180-240	
Flangette - Left Side	Bolt	3/8-24	240-300	
Chaincase to Chassis (Upper)	Bolt	3/8-24	216	
Ski Pivot to Spindle	Bolt	3/8-24		25
Spring to Ski Pivot	Bolt	3/8-24		25
Spring to Ski (Rear)	Bolt	3/8-24		25
Engine Mount Extension	Bolt	7/16-20		35-40
Engine Mount Bracket	Bolt	7/16-20		35-40
Bogie Wheel to Axle	Nut	5/8-18	240-300	
Drive Sheave Adaptor and Driver Sprocket	Nut	3/4-16		75-100
ENGINE				
Reed Stop	Screw	8-32	24	
Center Main Clamping (220 Only)	Screw	10-24	24	
Trigger Mounting Plate	Screw	¼-20	72	
Center Main Clamping (250 Only)	Screw	¼-20	60	
Starter Ratchet to Blower	Screw	¼-20	72	
Air Duct to Engine Support	Bolt	¼-20	60	
Connecting Rod	Nut	¼-28	180	
Intake Manifold	Nut	¼-28	72	
Blower Housing	Screw	5/16-18	120	
PTO End Mount Plate	Bolt	5/16-18	192	
Exhaust Pipe to Cylinder (220 Only)	Screw	5/16-18	180	
Exhaust Elbow to Cylinder (250 Only)	Nut	5/16-18	180	
Center Main Retaining	Screw	5/16-18	180	
Exhaust Pipe Hanger (220 Only)	Screw	5/16-18	120	
Electric Starter Attaching	Screw	5/16-18	120	
Carburetor	Nut	5/16-24	120	
Backplate - Blower	Nut	5/16-24	192	
Electric Starter Mounting	Screw	3/8-16	240	
Exhaust Pipe Hanger (250 Only)	Screw	3/8-24		25
Engine to Mounting Rail	Bolt	3/8-24		25-30
Cylinder to Crankcase	Nut	3/8-24		29*
Flywheel	Nut	½-20		60-65
Blower	Screw	½-20		40-45
Sheave Shaft - L.H. (220 Only)	Nut	½-20		25
Sheave Shaft - R.H.	Nut	9/16-18		35
Spark Plug		14mm	240	

* 300 In. Lbs. with 2" Adaptor on C-91-25666 Torque Wrench
Metric Conversion: 1 In. Lb. = 1.15kg-cm; 1 Ft. Lb. = .14mkg

TORQUE SPECIFICATIONS

Models 200, Rocket (339cc) and Lightning (398cc)

Location	Type Fastener	Size Fastener	Torque	
			In. Lbs.	Ft. Lbs.

CHASSIS

Chassis to Spring Retainer Rod	Screw	¼-20	60	
Brake Cable to Brake Arm	Nut	¼-28	24	
Sprocket to Hub	Bolt	¼-28	48-60	
Bearing Lock Collar	Screw		120	
Chassis to Front Crossmember	Bolt	5/16-18	144-180	
Front Fuel Tank Mount	Nut	5/16-18	36-48	
Chaincase Cover to Chaincase	Screw	5/16-18	180-240	
Steering Shaft Mount	Bolt	5/16-18	96-120	
Wear Skeg to Ski	Nut	5/16-18	144-180	
Chassis to Chaincase (Lower)	Bolt	5/16-24	180-240	
Chassis to Rear Brace	Screw	5/16-24	144-180	
Rear Fuel Tank Mount	Nut	5/16-24	144-180	
Brake to Chaincase	Screw	5/16-24	180-240	
Steering Arm	Bolt	5/16-24	216-264	
Idler Arm Retainer	Screw	3/8	180-240	
Chassis to Bogie Shaft	Screw	3/8-16		25-30
Chassis to Chaincase (Upper)	Bolt	3/8-24	180-240	
Flangette to Chassis	Bolt	3/8-24	240-300	
Flangette to Chaincase	Bolt	3/8-24	180-240	
Chaincase Eccentric Locking	Bolt	3/8-24	168	
Ski Pivot to Spindle	Bolt	3/8-24		25
Spring to Ski Pivot	Bolt	3/8-24		25
Spring to Ski (Rear)	Bolt	3/8-24		25
Chassis to Engine Support	Bolt	7/16-20		35-40
Driven Sheave to Jackshaft	Screw	7/16-20		35-40
Tie-Rod End, Jam	Nut	½-20	240	
Driver Sprocket to Jackshaft	Nut	¾-16		25-30

200 ENGINE

Carburetor Filter Mounting	Stud	¼	132	
Muffler to Chassis	Bolt	¼-28	24	
Exhaust Pipe to Muffler	Screw	5/16-24	240-300	
Throttle Control Bracket	Screw	10-16	12	
Crankcase Clamping	Bolt	6mm	84	
Cylinder Head	Nut	8mm	240	
Exhaust Pipe to Cylinder	Nut	8mm	168	
Carburetor	Nut	8mm	168	
Engine Support	Bolt	7/16-20		35-40
Engine Mount Plate	Screw	½-13		40-45
Clutch to Crankshaft	Screw	½-20		25
Clutch Bell	Screw		96-120	
Flywheel	Nut			45-50
Spark Plug		18mm	240	

ROCKET (339cc) and LIGHTNING (398cc) ENGINE

Carburetor Intake Silencer	Screw	¼-20	36-60	
Crankcase Clamping	Screw	8mm	144-180	
Cylinder Head to Cylinder	Nut	8mm	180-216	
Cylinder to Crankcase	Nut	8mm	144-180	
Mounting Plate to Rail	Bolt	3/8-24		30
Throttle Bracket to Carburetor	Screw	5/16-18	60-84	
Engine Mount Plate	Screw	7/16-14		25-30
Clutch to Crankshaft	Screw	½-20		50-60*
Clutch Bell	Screw			150
Flywheel	Nut			45-50
Spark Plug		14mm	180-240	

* Retorque after Warmup

Metric Scale: 1 In. Lb. = 1.15kg-cm; 1 Ft. Lb. = .14mkg

TORQUE SPECIFICATIONS

Hurricane Model

Location	Type Fastener	Size Fastener	Torque	
			In. Lbs.	Ft. Lbs.

CHASSIS

Tie Rod End (Castle)	Nut	3/8-24	240	
Handlebar	Screw	5/16-24		30
Driven Sheave to Jackshaft	Screw	7/16-20		35-40
Chaincase Cover to Chaincase	Screw	5/16-18	180-240	
Sprocket to Jackshaft	Nut	9/16-18		25-30
Chaincase Cover Plug		5/8-18	120-180	
Connector, Speedometer Drive	Screw	13/16-16	240-300	

ENGINE

Check Valve Retainer	Screw	6-32	11	
Cam Retainer	Screw	8-32	22	
Stator Attaching	Nut	10-24	29	
Ring Gear to Fan	Screw	10-24	40-45	
Air Intake to Shroud	Screw	10-24	15	
Coil to Fan Housing	Screw	10-24	20-30	
Reed Stop	Screw	10-32	28-32	
Fuel Pump Cover	Screw	10-32	32-34	
Fuel Pump Attaching	Nut	10-32	32-34	
Air Intake to Carburetor	Nut	10-32	20-30	
Electric Starter (Rear)	Nut	¼-20	50	
Shroud to Engine	Screw	¼-20	45-65	
Fan Housing Cover	Screw	¼-20	45-65	
Switch Box to Fan Housing	Screw	¼-20	45-65	
Connecting Rod	Nut	¼-28	180	
End Cap (PTO End)	Screw	5/16-18	150	
Electric Starter (Front)	Nut	5/16-18	60-65	
Carburetor	Nut	5/16-24	120	
Crankcase to Cylinder Block	Bolt	5/16-24	150	
Flywheel to Hub	Nut	5/16-24	220-240	
Muffler Mount	Nut	5/16-24	60-65	
Engine Mount Bracket	Nut	3/8-24	210-260	
Flywheel to Crankshaft	Screw	½-20		40-45
Clutch to Crankshaft	Screw	½-20		50-60
Sheave Shaft	Nut	9/16-18		35
Exhaust Pipe		2-1/8-12		80
Spark Plug		18mm	240	

Metric Scale: 1 In. Lb. = 1.15kg-cm; 1 Ft. Lb. = .14mkg

TORQUE SPECIFICATIONS

440 MAX, 440 M/X and 440 S/R Models

Location	Type Fastener	Size Fastener	Torque	
			In. Lbs. (kg-cm)	Ft. Lbs. (mkg)

ENGINE

Reed Stop	Screw	3mm	20 (25)	
Drive Sheave Plastic Slide	Bolt	8-32	30 (35)	
Shroud to Engine	Bolt	6mm	65 (75)	
Recoil Starter to Fan Housing	Screw	6mm	65 (75)	
Recoil Starter Pulley to Flywheel	Bolt	6mm	100 (115)	
Ignition Coil to Fan Housing	Bolt	6mm	100 (115)	
Intake Manifold to Crankcase	Nut	6mm	100 (115)	
Cylinder Head to Cylinder	Nut	6mm	100 (115)	
Drive Sheave Cover to Movable Sheave (440 S/R Chassis Serial No. 4067797 and Above)	Screw	¼-20	90 (115)	
Drive Sheave Arm and Roller Retainer	Bolt	¼-20	110 (125)	
Rewind Assembly to Rewind Case	Nut	8mm	150 (175)	
Crankcase Clamping	Nut	8mm	200 (230)	
Cylinder to Crankcase	Nut	8mm	200 (230)	
Exhaust Manifold to Cylinder	Nut	8mm	200 (230)	
Electric Starter (Drive End)	Nut	8mm	160 (185)	
Electric Starter (Bracket End)	Bolt	8mm	160 (185)	
Fan Housing to Crankcase	Bolt	8mm	200 (230)	
Carburetor to Intake Manifold	Nut	8mm	160 (185)	
Engine Mounting Plate to Support Bracket	Nut	3/8-24		30 (4)
Mounting Plate to Engine	Bolt	7/16-14		30 (4)
Fan to Fan Shaft	Nut	12mm		50 (7)
Drive Sheave to Crankshaft	Bolt	½-20		55* (8)*
Flywheel to Crankshaft	Nut	13mm		55 (8)
Spark Plug		14mm	240 (275)	
Drive Sheave Cover and Movable Sheave to Fixed Sheave Spindle (440 S/R Chassis Serial No. 4067797 and Above)	Bolt	7/8-9		75 (10)
Drive Sheave Bell (Chassis Serial No. 4065796 and Below)	Bolt	7/8-14		75 (10)

CHASSIS

* Retorque after warmup

Voltage Regulator to Chassis	Nut	10-32	30 (35)	
Voltage Regulator to Chassis	Nut	¼-20	65 (75)	
Terminal Stud to Battery	Nut	¼-28	50 (60)	
Rear Lift Handle to Chassis	Nut	¼-28	65 (75)	
Bumper to Lower Cowl	Nut	¼-28	75 (85)	
Slide to Support Rail (440 S/R)	Nut	¼-28	100 (115)	
Idler Wheel to Rear Axle (440 MAX)	Bolt	¼-28	175 (200)	
Track Sprocket to Front Drive Shaft	Bolt	¼-28	175 (200)	

Control Lever Mount to Handlebar	Screw	5/16-18	20 (25)	
Stabilizer Bar Bracket to Crossmember	Nut	5/16-18	90 (115)	
Battery Box to Chassis Extrusion	Nut	5/16-18	150 (175)	
Wear Skeg to Ski	Nut	5/16-18	160 (185)	
Brackets to Support Rail (440 S/R)	Nut	5/16-18	160 (185)	
Muffler Bracket to Crossmember	Nut	5/16-18	200 (230)	
Chaincase Cover to Chaincase	Bolt	5/16-18	150 (175)	
Drive Sheave Cover to Chassis	Nut	5/16-18	140 (160)	
Brake Disc to Driven Sheave (440 S/R Chassis Serial No. 4067797 and Above)	Bolt	5/16-18	180 (205)	
Fuel Tank to Chassis	Nut	5/16-24	50 (60)	
Stabilizer Link Bar to Ski	Nut	5/16-24	100 (115)	
Steering Arm to Steering Spindle	Bolt	5/16-24	240 (275)	
Crossmember and Rear Brace to Chassis	Bolt	5/16-24	180 (205)	
Chaincase to Chassis (lower)	Bolt	5/16-24	220 (255)	
Brake Bracket to Chaincase	Bolt	5/16-24	130 (150)	
Flangette to Chassis	Nut	5/16-24	125 (145)	
Eccentric Locknut	Nut	3/8-16	160 (185)	
Front Suspension Control Arm to Chassis (440 S/R)	Bolt	3/8-16	280 (325)	
Suspension Shock Absorber (440 S/R)	Bolt	3/8-16		30 (4)
Link Bracket to Rear Control Arm (440 S/R Chassis Serial No. 4067797 and Above)	Bolt	3/8-16		30 (4)
Suspension Pivot Shaft to Chassis	Bolt	3/8-16		30 (4)
Tie Rod to Steering Shaft (Chassis Serial No. 4064097 and Above)	Nut	3/8-24	160 (185)	
Tie Rod to Steering Arm	Nut	3/8-24	240 (275)	
Tie Rod to Steering Shaft (Chassis Serial No. 3795657 and Below)	Nut	3/8-24	240 (275)	
Handlebar	Bolt	3/8-24		30 (4)
Driver Sprocket to Jackshaft	Bolt	3/8-24		30 (4)
Ski Pivot to Steering Spindle	Bolt	3/8-24		30 (4)
Leaf Spring to Ski	Bolt	3/8-24		30 (4)
Ski Pivot to Leaf Spring	Bolt	3/8-24		30 (4)
Idler Arm Anchor to Chassis (440 MAX)	Nut	3/8-24		30 (4)
Rear Idler Rod to Idler Support (440 MAX)	Nut	3/8-24		30 (4)
Side Straps to Rear Suspension Roller (440 S/R)	Bolt	3/8-24		30 (4)
Rear Suspension Shock Mount to Chassis (440 S/R)	Nut	3/8-24		30 (4)
Chaincase to Chassis (upper)	Bolt	3/8-24		30 (4)
Cross Shaft (440 S/R)	Bolt	7/16-14		30 (4)
Ski Pivot to Steering Spindle	Bolt	7/16-20		50 (7)
Shock Absorbers to Suspension (440 S/R)	Bolt	7/16-20		30 (4)
Driven Sheave to Jackshaft	Bolt	7/16-20		45 (6)
Engine Support Bracket to Chassis	Bolt	7/16-20		30 (4)
Shock Absorber, Ski	Bolt	7/16-20		50 (7)
Idler Wheel to Rear Axle (440 S/R)	Bolt	½-13	250 (290)	
Drive Sprocket to Front Drive Shaft	Bolt	13/16-16		40 (6)

TORQUE SPECIFICATIONS

Mark I and Mark II Models

Location	Type Fastener	Size Fastener	Torque	
			In. Lbs. (kg-cm)	Ft. Lbs. (mkg)

ENGINE

Check Valve Retainer (Mark I)	Screw	6 - 32	10	(10)	
Drive Sheave Plastic Slide	Screw	8 - 32	30	(35)	
Advance Rotor Retainer to Flywheel	Screw	8 - 32	22	(25)	
Ignition Coil to Fan Housing	Bolt	10 - 24	30	(35)	
Stator Attaching	Screw	10 - 32	30	(35)	
Reed Stop	Screw	10 - 32	30	(35)	
Air Intake to Carburetor (Mark I)	Nut	10 - 32	25	(30)	
Fuel Pump Cover (Mark I)	Screw	10 - 32	30	(35)	
Fuel Pump to Crankcase (Mark I)	Nut	10 - 32	30	(35)	
Switch Box to Fan Housing	Bolt	¼ - 20	55	(65)	
Fan Housing Cover	Screw	¼ - 20	55	(65)	
Air Shroud to Engine	Bolt	¼ - 20	60	(70)	
Drive Sheave Arm and Roller Retainer	Bolt	¼ - 20	110	(125)	
Connecting Rod	Nut	¼ - 28	180	(205)	
Intake Manifold to Crankcase (Mark II)	Bolt	¼ - 28	100	(115)	
Intake Manifold to Crankcase (Mark II)	Nut	¼ - 28	100	(115)	
Center Main Bearing	Screw	¼ - 28	80	(90)	
End Cap (PTO End)	Bolt	5/16 - 18	200	(230)	
End Cap (Fan End)	Bolt	5/16 - 18	200	(230)	
Carburetor to Intake Manifold (Mark II)	Nut	5/16 - 24	110	(125)	
Crankcase to Cylinder Block	Bolt	5/16 - 24	180	(205)	
Recoil Ratchet and Fan to Flywheel	Nut	5/16 - 24	240	(275)	
Carburetor to Crankcase (Mark I)	Nut	5/16 - 24	120	(140)	
Muffler Mount	Screw	5/16 - 24	65	(75)	
Electric Starter Bracket to Crankcase	Bolt	5/16 - 24	180	(205)	
Carburetor to Intake Manifold (Mark II)	Nut	3/8 - 24	200	(230)	
Engine Mount to Chassis	Nut	3/8 - 24	235	(270)	
Engine Mount to Crankcase	Nut	3/8 - 24			30 (4)
Drive Sheave to Crankshaft	Bolt	½ - 20			55* (8)*
Flywheel to Crankshaft	Bolt	½ - 20			45 (6)
Recoil Starter to Fan Housing	Nut	9/16 - 18			25-28 (3.5-3.9)
Drive Sheave Bell	Bolt	7/8 - 14			75 (10)
Exhaust Pipe to Cylinder		2-1/8-12			80 (11)
Spark Plug		14mm	240	(275)	

* Retorque after Warmup

CHASSIS

Terminal Stud to Battery	Nut	¼ - 28	50	(60)	
Bumper to Chassis	Nut	¼ - 28	75	(85)	
Track Sprocket to Front Drive Shaft	Bolt	¼ - 28	175	(200)	
Idler Wheel to Rear Axle	Bolt	¼ - 28	175	(200)	
Control Lever Mount to Handlebar	Screw	5/16 - 18	20	(25)	
Wear Skeg to Ski	Nut	5/16 - 18	160	(185)	
Chaincase Cover to Chaincase	Bolt	5/16 - 18	150	(175)	
Fuel Tank to Chassis	Nut	5/16 - 24	50	(60)	
Handlebar	Bolt	5/16 - 24			30 (4)
Front Axle Bearing Retainer Cover to Chassis	Nut	5/16 - 24	125	(145)	
Steering Arm to Spindle	Bolt	5/16 - 24	240	(275)	
Bogie Pivot Shaft to Swing Frame	Bolt	3/8 - 16			30 (4)
Idler Pivot Plate to Swing Frame	Bolt	3/8 - 16	220	(255)	
Swing Frame Ends to Swing Frame	Bolt	3/8 - 24			30 (4)
Idler Pivot Plate to Adjustment Block	Bolt	3/8 - 24			30 (4)
Tie Rod to Steering Arm	Nut	3/8 - 24	240	(275)	
Tie Rod to Steering Shaft	Nut	3/8 - 24	240	(275)	
Driver Sprocket to Jackshaft	Bolt	3/8 - 24			30 (4)
Chaincase to Chassis	Nut	3/8 - 24			30 (4)
Leaf Spring to Ski	Bolt	3/8 - 24			30 (4)
Pivot to Leaf Spring	Bolt	3/8 - 24			30 (4)
Rear Shock Absorber to Swing Frame	Bolt	7/16 - 14			30 (4)
Driven Sheave to Jackshaft	Bolt	7/16 - 20			45 (6)
Rear Shock Absorber to Chassis	Bolt	7/16 - 20			30 (4)
Shock Absorber, Ski	Bolt	7/16 - 20			50 (7)
Ski Pivot to Steering Spindle	Bolt	7/16 - 20			50 (7)
Drive Sprocket to Front Drive Shaft	Bolt	13/16 - 16			40 (6)

TORQUE SPECIFICATIONS

340 S/R Model

Location	Type Fastener	Size Fastener	Torque	
			In. Lbs. (kg-cm)	Ft. Lbs. (mkg)

CHASSIS

Terminal Block to Chassis	Nut	10-32	30 (35)	
Voltage Regulator to Chassis	Nut	¼-20	65 (75)	
Bumper to Lower Cowl	Nut	¼-28	75 (85)	
Slide to Support Rail	Nut	¼-28	100 (115)	
Track Sprocket to Front Drive Shaft	Bolt	¼-28	175 (200)	
Control Lever Mount to Handlebar	Screw	5/16-18	20 (25)	
Drive Sheave Shroud to Chassis	Nut	5/16-18	140 (160)	
Chaincase Cover to Chaincase	Bolt	5/16-18	150 (175)	
Wear Skag to Ski	Nut	5/16-18	160 (185)	
Brackets to Suspension Support Rail	Nut	5/16-18	160 (185)	
Fuel Tank to Chassis	Nut	5/16-24	50 (60)	
Front Axle Bearing Retainer (Flangette) to Chassis	Nut	5/16-24	125 (145)	
Brake Bracket to Chaincase	Bolt	5/16-24	130 (150)	
Chaincase to Chassis (Lower)	Bolt	5/16-24	220 (255)	
Crossmember and Extrusions to Chassis	Bolt	5/16-24	180 (205)	
Steering Arm to Steering Spindle	Bolt	5/16-24	240 (275)	
Eccentric Locknut	Nut	3/8-16	160 (185)	
Suspension Pivot Shafts	Bolt	3/8-16		25 (3)
Tie Rod to Steering Shaft	Nut	3/8-24	175 (200)	
Tie Rod to Steering Arm	Nut	3/8-24	240 (275)	
Handlebar to Steering Shaft	Bolt	3/8-24		30 (4)
Ski Pivot to Leaf Spring	Bolt	3/8-24		30 (4)
Leaf Spring to Ski	Bolt	3/8-24		30 (4)
Driver Sprocket to Jackshaft	Bolt	3/8-24		30 (4)
Chaincase to Chassis (Upper)	Bolt	3/8-24		30 (4)
Suspension Shock Absorber Mount to Chassis	Bolt	3/8-24		30 (4)
Side Straps to Rear Suspension Roller	Bolt	3/8-24		30 (4)
Cross Shaft	Bolt	7/16-14		40 (6)
Shock Absorbers to Suspension	Bolt	7/16-20		30 (4)
Driven Sheave to Jackshaft	Bolt	7/16-20		45 (6)
Ski Pivot to Steering Spindle	Bolt	7/16-20		50 (7)
Idler Wheel to Rear Axle	Bolt	½-13	240 (275)	
Drive Sprocket to Front Drive Shaft	Bolt	13/16-16		40 (6)

ENGINE

Shroud and Coil Cover to Engine	Bolt	¼-20	95 (110)	
Rewind Assembly to Rewind Housing	Bolt	¼-20	85 (100)	
Crankcase Drain Plugs	Bolt	¼-20	95 (110)	
Crankcase Clamping	Bolt	¼-20	95 (110)	
Fan Housing to Crankcase	Bolt	5/16-18	155 (180)	
Intake Manifold Clamping	Bolt	5/16-18	155 (180)	
Cylinder to Crankcase	Nut	5/16-18	185 (207)	
Cylinder Head to Cylinder	Nut	5/16-18	230 (265)	
Engine Mounting Plate to Engine	Bolt	3/8-16	230 (265)	
Carburetor to Intake Manifold	Nut	3/8-24	150 (175)	
Engine Mounting Plate to Engine Support Rail	Nut	3/8-24		30 (4)
Engine Support Rail to Chassis	Nut	7/16-20		30 (4)
Fan to Fan Shaft	Nut	5/8-18		32 (4)
Spark Plug		14mm	220 (255)	
Flywheel to Crankshaft	Nut	¾-16		90 (12)

DRIVE SHEAVE

Plastic Slide Bearing to Movable Sheave	Bolt	8-32	30 (35)	
Arm and Roller Retainers to Sheave Housing and Movable Sheave	Bolt	8-32	30 (35)	
Drive Sheave to Crankshaft	Bolt	½-20		55* (8*)
Sheave Housing and Movable Sheave to Fixed Sheave Spindle	Bolt	7/8-14		75 (10)

* Retorque after warmup

TORQUE SPECIFICATIONS

340 S/T, 400 S/T, 440 S/T, 340 T/T and 440 T/T Models

Location	Type Fastener	Size Fastener	Torque	
			In. Lbs. (kg-cm)	Ft. Lbs. (mkg)

CHASSIS

Handlebar	Nut	¼-28	110 (130)	
Handlebar	Nut	5/16-24	110 (130)	
Wear Skeg to Ski	Nut	5/16-24	210 (240)	
Chaincase Cover to Chaincase	Nut	5/16-24	130 (150)	
Front Axle Bearing Retainer Cover to Chassis	Nut	5/16-24	130 (150)	
Rear Control Arm to Control Arm Bracket	Bolt	3/8-16		25
Suspension Pivot Shaft to Chassis	Bolt	3/8-16		30 (4)
Idler Wheel to Rear Axle	Bolt	3/8-16		30 (4)
Idler Wheel to Front Support Rail Cross Shaft (400 S/T)	Bolt	3/8-16		30 (4)
Control Arm Pivot Shaft to Support Rail	Bolt	3/8-16		30 (4)
Front Crosstube to Support Rail	Bolt	3/8-24		30 (4)
Control Arm Bracket to Support Rail	Bolt	3/8-24		30 (4)
Rear Axle Bracket to Support Rail	Bolt	3/8-24		30 (4)
Front Suspension Spring Adjusting Block to Chassis	Bolt	3/8-24		30 (4)
Chaincase to Chassis	Nut	3/8-24		30 (4)
Tie Rod to Steering Arm	Bolt	3/8-24		30 (4)
Tie Rod to Steering Shaft	Bolt	3/8-24		30 (4)
Steering Arm to Steering Spindle	Bolt	3/8-24		30 (4)
Leaf Spring to Ski	Bolt	3/8-24		30 (4)
Ski Pivot to Leaf Spring	Bolt	3/8-24		30 (4)
Driver Sprocket to Jackshaft	Bolt	3/8-24		30 (4)
Control Arm Pivot Shaft to Support Rail (400 S/T)	Bolt	7/16-14		30 (4)
Front Suspension Spring Rest to Support Rail	Bolt	7/16-14		30 (4)
Front Control Arm to Control Arm Bracket	Bolt	7/16-14		30 (4)
Rear Suspension Shock Absorber to Rear Control Arm and Support Rail	Bolt	7/16-14		30 (4)
Front Suspension Shock Absorber to Front Crosstube and Shock Bracket	Bolt	7/16-20		50 (7)
Ski Pivot to Steering Spindle	Bolt	7/16-20		50 (7)
Shock Absorber, Ski	Bolt	7/16-20		50 (7)
Rear Suspension Shock Absorber to Support Rail (400 S/T)	Bolt	7/16-20		50 (7)
Drive Sprocket to Front Drive Shaft	Bolt	5/8-18		40 (6)

ENGINE

Exhaust Header to Cylinder	Screw	¼-20	95 (110)	
Rewind Assembly to Rewind Housing	Bolt	¼-20	95 (110)	
Flywheel Bell Housing to Crankcase	Screw	5/16-18	155 (180)	
Intake Manifold to Cylinder	Nut	5/16-18	120 (137)	
Crankcase Clamping	Bolt	5/16-18	155 (180)	
Cylinder Head to Cylinder	Nut	5/16-18	230 (265)	
Cylinder to Crankcase	Nut	5/16-18	185 (207)	
Cylinder to Crankcase	Nut	3/8-16	230 (265)	
Mounting Plate to Engine	Bolt	3/8-16	230 (265)	
Engine Mounting Plate to Chassis	Nut	3/8-16		30 (4)
Engine Mounting Plate to Chassis	Nut	7/16-20		50 (7)
Fan to Fan Shaft (440 T/T)	Nut	5/8-18		32 (4)
Spark Plug		14mm	220 (255)	
Flywheel to Crankshaft	Nut	¼-16		90 (12)

400 S/T DRIVE SHEAVE

Drive Sheave Cover to Movable Sheave Half	Bolt	¼-20	150 (175)	
Drive Sheave to Crankshaft	Bolt	¼-20		55 (8)

340 S/T, 440 S/T, 340 T/T and 440 T/T (Chassis Serial No. 4347125 and Above) DRIVE SHEAVE

Ramp to Movable Sheave	Bolt	8-32	27 (33)	
Spider to Fixed Sheave Spindle	Screw	10-24	42 (52)	
Roller and Weights to Spider Arm	Nut	10-32	41 (51)	
Sheave Housing to Movable Sheave	Screw	5/16-18	190 (220)	
Drive Sheave to Crankshaft	Bolt	¼-20		55 (8)

440 T/T (Chassis Serial No. 4210249 and Below) DRIVE SHEAVE

Plastic Slide Bearing to Movable Sheave	Bolt	8-32	30 (35)	
Arm and Roller Retainers to Sheave Housing and Movable Sheave	Bolt	8-32	30 (35)	
Drive Sheave to Crankshaft	Bolt	¼-20		55 (8)
Sheave Housing and Movable Sheave to Fixed Sheave Spindle	Bolt	7/8-14		75 (10)

CARBURETOR FIXED HIGH SPEED JET/METERING ROD SIZE-ELEVATION CHART

Snowmobile Model	Chassis Serial No.	Up to 2500' (762.5m)	2500' (762.5m)-5000' (1525m)	5000' (1525m)-7500' (2287m)	7500' (2287m)-10000' (3050m)	10000' (3050m)-and Up
220	All	.067"*	.063"	.063"	.063"	.061"
250	All	.069"*	.065"	.065"	.063"	.061"
Hurricane	All	.084"*	.080"	.080"	.0785"	.076"
440 MAX	3447382 and Below	.0785"	.070"	.068"	.066"	.064"
Mark I	All	.0785"*	.074"	.072"	.070"	.068"
Mark II	3591478 and Below	.064"*	.056"	.054"	.052"	.050"
440 MAX ●	3709838 and Above	.065"*	.071"	.073"	.081"	.083"
440 S/R ●	All	.065"*	.071"	.073"	.081"	.083"
Mark II ●	3787640 and Above	.079" ■	.081"	.083"	.085"	.085"
400 S/T	All	No. 250 to No. 380 ▲	No. 250 to No. 360 ▲	No. 250 to No. 340 ▲	No. 250 to No. 330 ▲	No. 250 to No. 320 ▲
440 T/T	All	No. 270*	No. 270 *	No. 240 ①	No. 240 ①	No. 240 ①
340 T/T	All	No. 200*	No. 200*	No. 180 or No. 160 ▲ ②	No. 180 or No. 160 ▲ ②	No. 180 or No. 160 ▲ ②

● Walbro carburetor with fixed high speed metering rod

* Indicates standard fixed high speed jet/metering rod

■ Mark II Snowmobiles with chassis Serial No. 3787640 thru 3788840 were equipped with .077" metering rods. The .079" metering rods (standard on Mark II Snowmobiles with chassis Serial No. 3788840 and above) may be used as a replacement for the .077" metering rod.

▲ The correct fixed high speed jet is dependent upon air temperature (in addition to elevation) in which snowmobile will be operated. Refer to "Fuel Systems", Section 4, Part A.

① Install 440 T/T carburetor elevation kit (D-1393-5874A2). Each kit contains 2 fixed high speed jets (No. 240), 2 smaller pilot jets and an instruction sheet.

② Install 340 T/T carburetor elevation kit (D-1393-6150A1). Each kit contains 4 fixed high speed jets (two No. 180 and two No. 160), 2 smaller pilot jets, 2 smaller needle jets and an instruction sheet.

FIXED HIGH SPEED JET PART NUMBERS

Jet Size	Part No.	Jet Size	Part No.	Jet Size	Part No.	Jet Size	Part No.	Jet Size	Part No.
.042"	C-1399-5315	.064"	C-1399-4216	.082"	C-1399-3518	No. 260	C-1393-5505	No. 380	D-1393-5606
.044"	C-1399-5316	.065"	C-1399-1465	.084"	C-1399-3517	No. 270	C-1393-5506	No. 390	D-1393-6236
.046"	C-1399-5317	.066"	C-1399-4215	No. 160	C-1393-6143	No. 280	C-1393-5507	No. 400	D-1393-6237
.048"	C-1399-5318	.067"	C-1399-1467	No. 170	C-1393-6144	No. 290	C-1393-5508	No. 410	D-1393-6238
.050"	C-1399-5227	.068"	C-1399-4214	No. 180	C-1393-6145	No. 300	C-1393-5509	No. 420	D-1393-6239
.052"	C-1399-5226	.069"	C-1399-1962	No. 190	C-1393-6146	No. 310	C-1393-5510	No. 430	D-1393-6240
.054"	C-1399-5225	.070"	C-1399-3811	No. 200	C-1393-6147	No. 320	C-1393-5511	No. 440	D-1393-6241
.056"	C-1399-5213	.072"	C-1399-3795	No. 210	C-1393-6148	No. 330	C-1393-5512	No. 450	D-1393-6242
.059"	C-1399-1459	.074"	C-1399-3794	No. 220	C-1393-5875	No. 340	C-1393-5513	No. 460	D-1393-6243
.061"	C-1399-1461	.076"	C-1399-3796	No. 230	C-1393-6149	No. 350	D-1393-6234	No. 470	D-1393-6244
.062"	C-1399-4217	.0785"	C-1399-3520	No. 240	C-1393-5873	No. 360	D-1393-5605	No. 480	D-1393-6245
.063"	C-1399-1463	.080"	C-1399-3519	No. 250	C-1393-5504	No. 370	D-1393-6235		

FIXED HIGH SPEED METERING ROD PART NUMBERS

Rod Size	Part No.	Rod Size	Part No.
.065"	C-1395-5389	.079"	C-1395-5450
.071"	C-1395-5447	.081"	C-1395-5451
.073"	C-1395-5449	.083"	C-1395-5448
.077"	C-1395-5445	.085"	C-1395-5456

NOTE: For operation at or above 5000 ft. (1525m) elevation on 220 or 250 models only, increase Maximum Spark Advance from 15° to 18° by advancing trigger to full advance position on adjusting plate. This is done by removing access cover from blower housing and moving trigger upwards as far as it will go in slotted plate.