



MARINE

ILLUSTRATED

PARTS MANUAL

MODEL MP 8.1L

LEVITATOR

MY 2006

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“TYPICAL VIEWS ARE SHOWN”

ENGINE ROTATION

Engine Rotation is identified as “RH” or “LH” with the engine model number. Rotation always is determined from the flywheel end looking toward the front of the engine. In some instances, propeller shaft rotation may be opposite to that of the engine.

When ordering a replacement engine, production block or parts for the engine, be certain to check engine rotation. **DO NOT rely on propeller rotation in order to determine engine rotation.**

LEFT-HAND ROTATION is STANDARD ROTATION.

(Flywheel turns counterclockwise when viewed from flywheel end of the engine.)

RIGHT-HAND ROTATION is OPPOSITE ROTATION.

(Flywheel turns clockwise when viewed from flywheel end of the engine.)

HOW TO READ THIS PARTS BOOK:

ITEM	PART NO.	QTY.	DESCRIPTION	MODEL ID
1	RB001018A	AR	Base Engine Assembly, 8.1L Standard, bottom mount starter	25-810-02

①

②

③

④

⑤

- ① ITEM NUMBER - This number corresponds with the number in the exploded view on the facing page.
- ② PART NUMBER - This is the designated part number for the particular component or assembly.
- ③ QUANTITY - This refers to the number of pieces used.
- ④ DESCRIPTION - This identifies what the component or assembly is.
- ⑤ MODEL ID - This identifies a component or assembly that is unique to a specific engine model.

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Symbols shown throughout parts list are defined here or on the bottom of the individual parts list page.

- AR = As Required
 - OPT = Optional
 - NSS = Not Serviced Separately
 - NA = Not Available
 - OS = Oversize
 - US = Undersize
 - TBD = To Be Determined
 - NI = Not Illustrated
- =====

REPLACEMENT PARTS:



WARNING:

Electrical, ignition and fuel system components on Crusader Engines are designed and manufactured to comply with U.S. Coast Guard rules and regulations to minimize risks of fire or explosion.

Use of replacement electrical, ignition and fuel system components which do not comply with these rules and regulations could result in a fire or explosion hazard and should be avoided.

GASKET AND DECAL KIT NUMBERS:

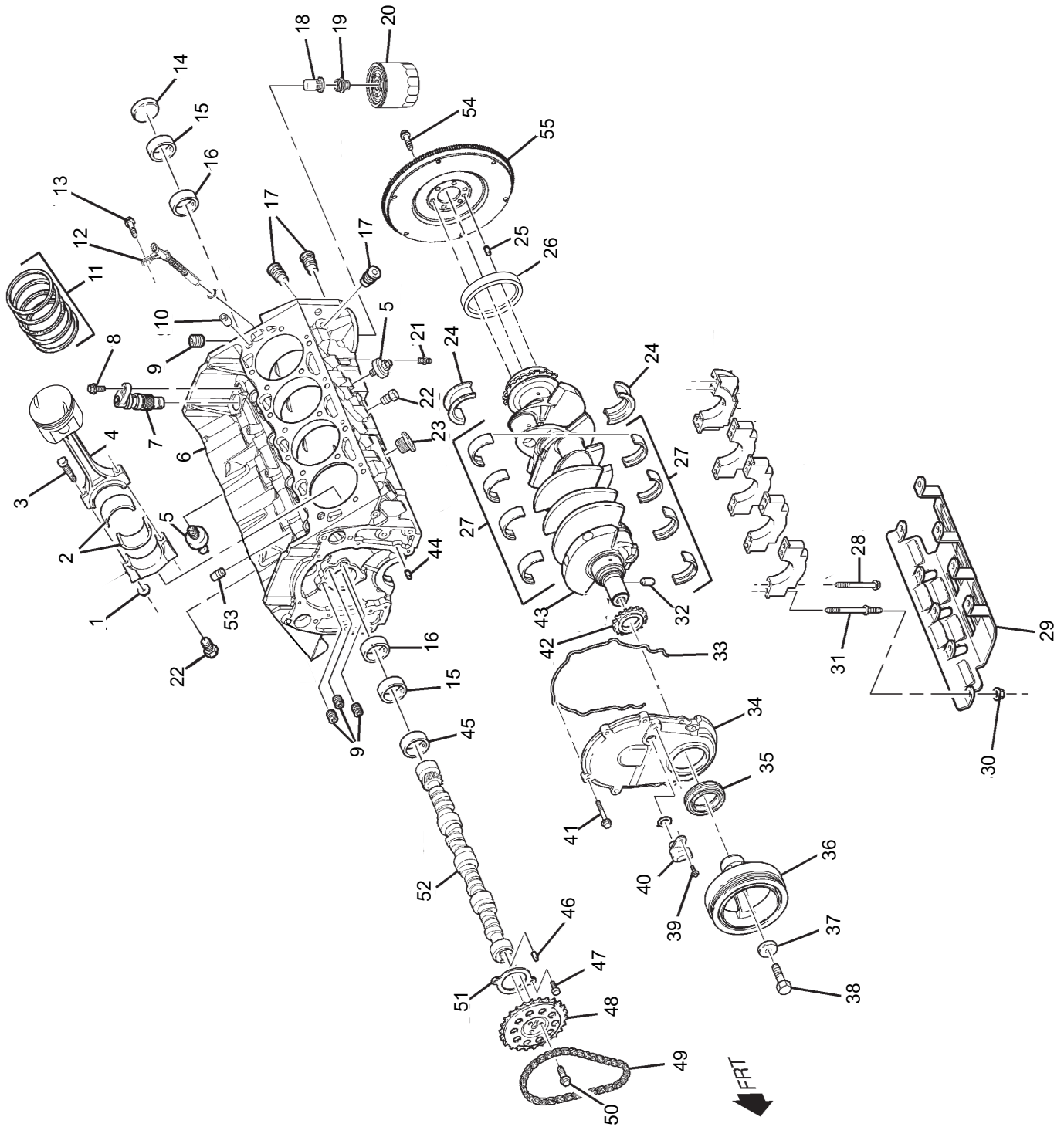
Description	Part Number
Complete Engine Overhaul Gasket Set	TBD
Valve Grind Gasket Set	TBD
Oil Pan Gasket Set	RM0263
Intake Manifold Gasket Set	RM0267



MAINTENANCE ITEM PART NUMBERS:

Description	Part Number
Oil Filter	R077016
Spark Plug Set (Platinum)	RP030009
Spark Plug Wire Set	RK120019A
Accessory Drive Belt	R066024
Relay, 12V, GM / Fuel Pump, Starter, MEFI	R130011A
Fuse, Spade 20 AMP	R153017B

CYLINDER BLOCK ASSEMBLY - FIGURE 1

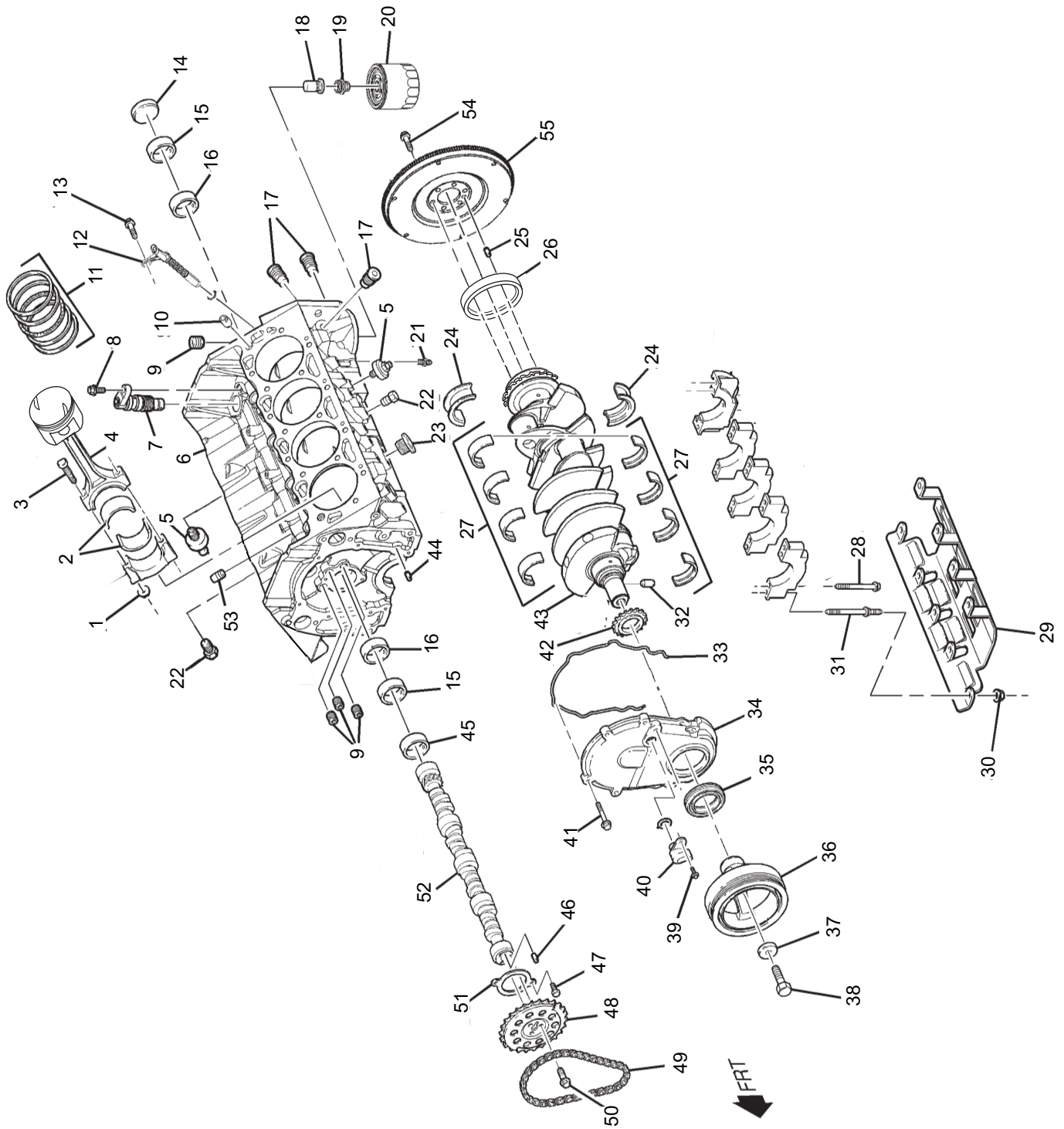


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CYLINDER BLOCK ASSEMBLY - FIGURE 1

ITEM	PART NO.	QTY.	DESCRIPTION	MODEL ID
*	RB001019A	AR	Base Engine Assembly , H.O., bottom mount starter	
1	R017080	16	Nut , connecting rod cap	
2	R007026	8	Bearing Set , connecting rod (STD)	
3	R009195	16	Bolt , connecting rod cap	
4	RA013015A	4	Piston and Connecting Rod Assembly (LH/STD)	
4	RA013015B	4	Piston and Connecting Rod Assembly (RH/STD)	
5	R020033	2	Sensor , knock	
6	NSS	1	Cylinder Block	
7	RA073001	1	Drive , oil pump	
8	TBD	1	Bolt , oil pump drive	
9	TBD		Plug , oil gallery	
10	R022021	4	Pin , cylinder head locating	
11	R015012	8	Ring Set , piston (STD)	
12	R020034	1	Sensor , crankshaft position	
13	TBD	1	Bolt , crankshaft position sensor	
14	R069065	1	Plug , camshaft	
15	R051039B	2	Bearing , camshaft #2 and #5	
16	R051039A	2	Bearing , camshaft #3 and #4	
17	TBD	4	Plug , engine block oil gallery	
18	TBD	1	Valve , oil bypass	
19	R079048	1	Fitting , oil filter	
20	R077016	1	Filter , oil	
21	R024183	2	Connector , engine oil cooler hose	
22	R069070	2	Plug , engine block coolant drain hole	
23	TBD	1	Plug , engine block coolant drain hole	
24	R007028	1	Bearing , crankshaft (thrust)	
25	TBD	2	Pin , flywheel locating	
26	R047224	1	Seal , crankshaft rear oil	
27	R007027	4	Bearing , crankshaft (STD)	
28	R009196	10	Bolt , crankshaft bearing cap	
29	R012023	1	Deflector , crankshaft oil	
30	TBD		Nut , crankshaft oil deflector	
31	R031032	9	Stud , crankshaft bearing cap	
32	TBD	1	Pin , crankshaft balancer locating	
33	RM0264	1	Gasket , engine front cover	
34	R004011	1	Cover , engine front cover (includes gasket and seal)	
35	R047225	1	Seal , crankshaft front oil	

CYLINDER BLOCK ASSEMBLY (cont'd) - FIGURE 1

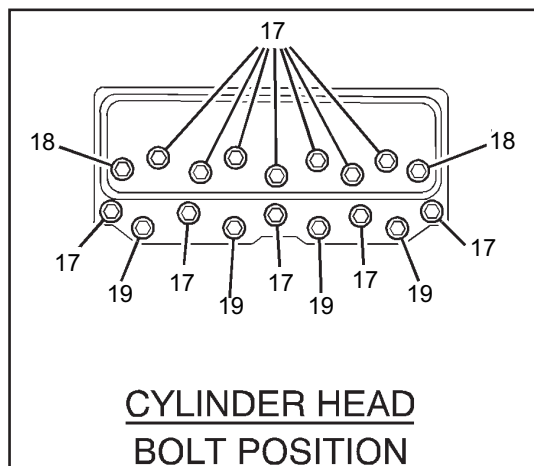
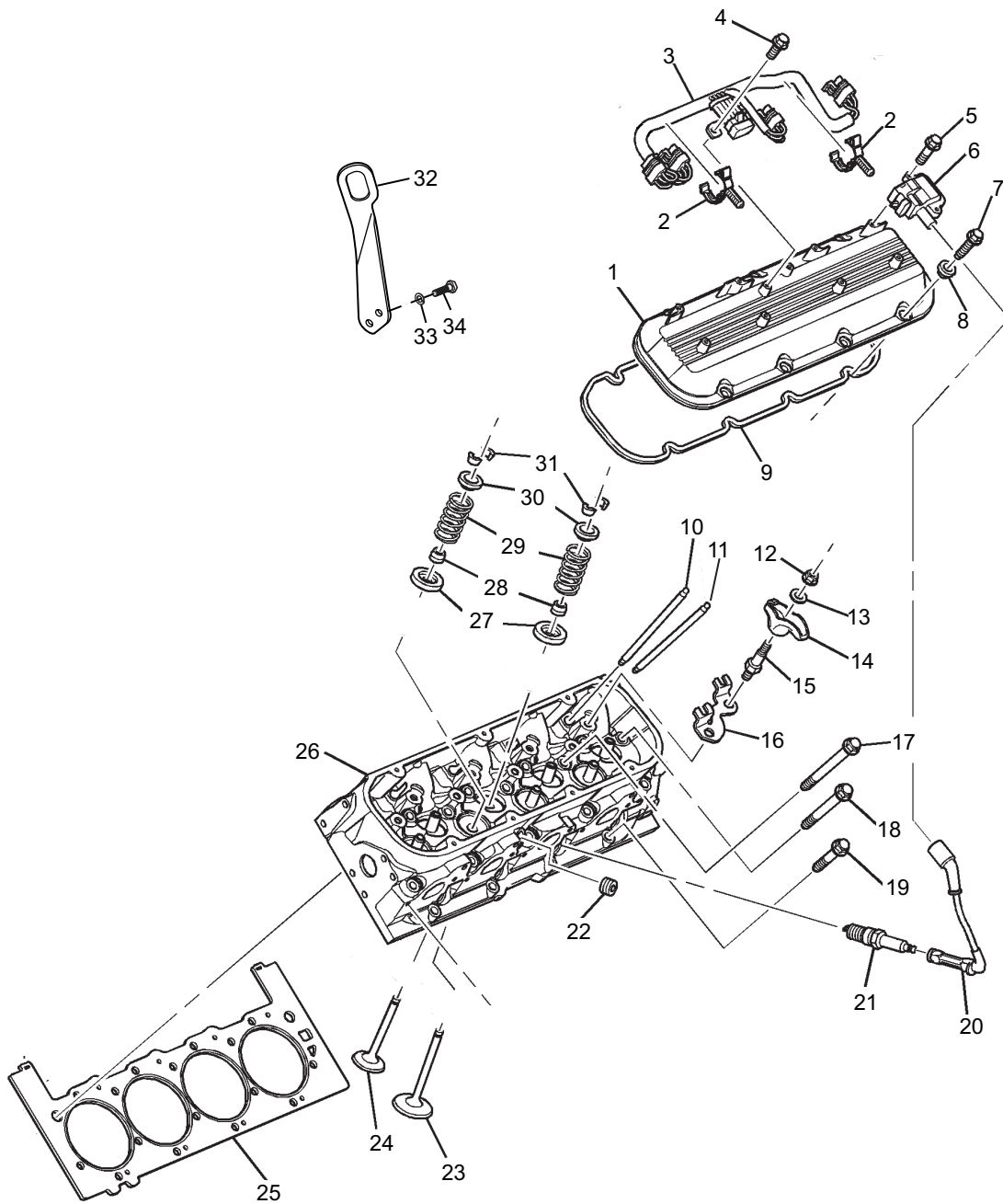


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CYLINDER BLOCK ASSEMBLY (cont'd) - FIGURE 1

ITEM	PART NO.	QTY.	DESCRIPTION	MODEL ID
36	R064015A	1	Balancer , crankshaft (HO)	
37	R096146	1	Washer , crankshaft balancer	
38	TBD	1	Bolt , crankshaft balancer	
39	TBD	1	Bolt , camshaft position sensor	
40	TBD	1	Sensor , camshaft position sensor	
41	TBD	6	Bolt , engine front cover	
42	R054039	1	Sprocket , crankshaft	
43	R006030	1	Crankshaft (LH HO)	
44	R022022	1	Pin , engine front cover locating	
45	R051039A	1	Bearing , camshaft #1	
46	R022022	1	Pin , camshaft sprocket locating	
47	TBD	2	Bolt , camshaft retaining	
48	R054040	1	Sprocket , camshaft	
49	R055016	1	Chain , camshaft timing	
50	TBD	3	Bolt , camshaft sprocket	
51	R109050	1	Retainer , camshaft	
52	RA050024	1	Camshaft , engine (HO)	
53	TBD	3	Plug , engine block oil gallery	
54	TBD	6	Bolt , flywheel to crankshaft	
NI	RS2426	6	Lockwasher , flywheel to crankshaft	
55	RA138015A	1	Flywheel Assembly , (Bottom Mount Starter)	

CYLINDER HEAD ASSEMBLY - FIGURE 2

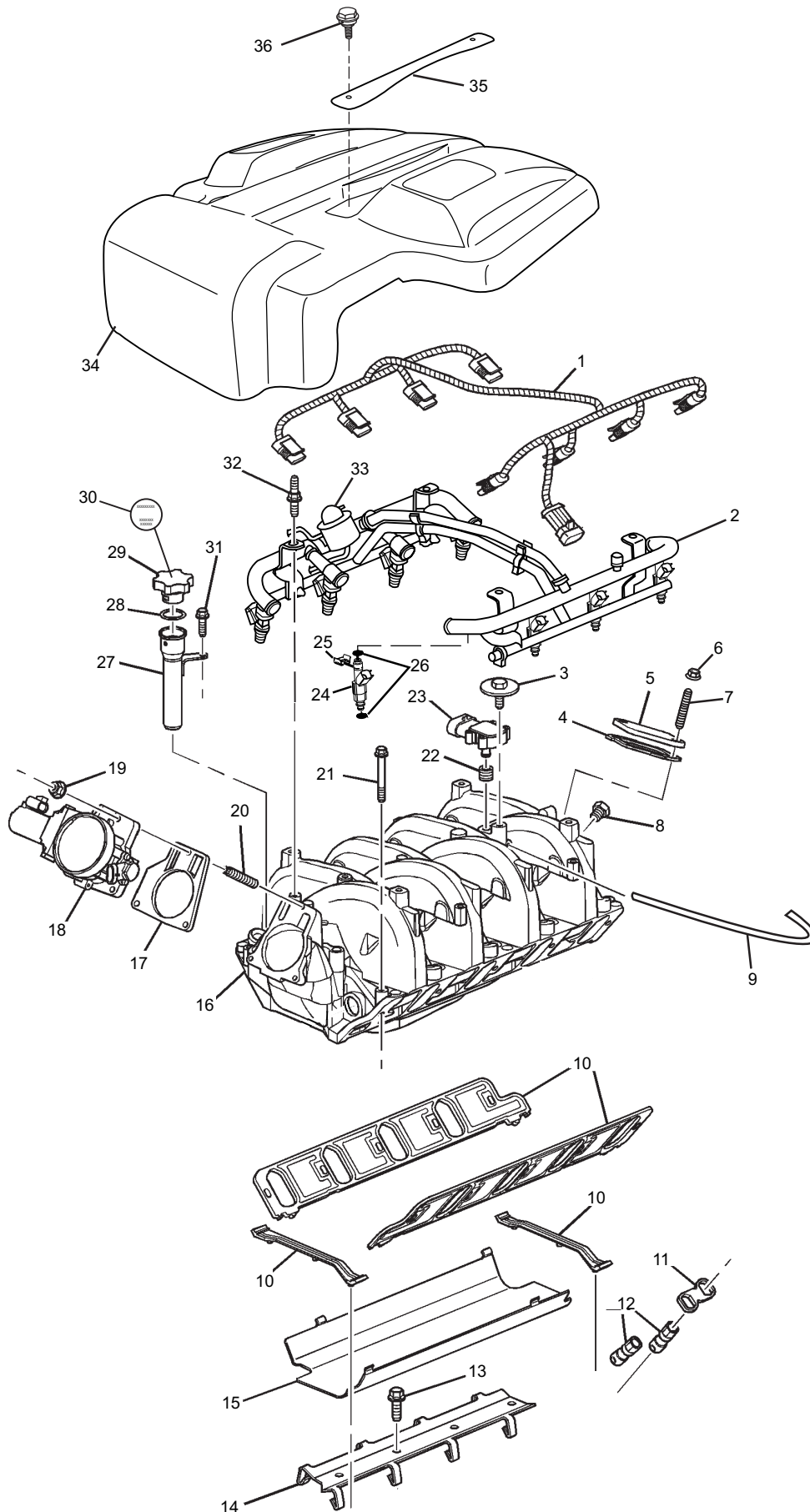


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CYLINDER HEAD ASSEMBLY - FIGURE 2

ITEM	PART NO.	QTY.	DESCRIPTION	MODEL ID
1	R033013	2	Cover , rocker	
2	R127096	4	Retainer , ignition coil wire harness	
3	R121074	2	Wire Harness , ignition coils	
4	TBD	2	Bolt , ignition coil wire harness retaining	
5	TBD	16	Bolt , ignition coil retaining	
6	R117013	8	Coil , ignition	
7	R009200	14	Bolt , rocker cover retaining	
8	R094039	14	Grommet , rocker cover retaining	
9	RM0261	2	Gasket , rocker cover	
10	R039021	8	Push Rod , intake	
11	R039022	8	Push Rod , exhaust	
12	R017079	16	Nut , rocker arm attaching	
13	TBD	16	Ball , rocker arm	
14	R038018	16	Rocker Arm , valve	
15	R095039	16	Stud , push rod guide attaching	
16	R037003	8	Guide , pushrod	
17	R009197	24	Bolt , cylinder head to block (long)	
18	R009198	4	Bolt , cylinder head to block (medium)	
19	R009199	8	Bolt , cylinder head to block (short)	
20	RK120019A	1	Spark Plug Wire Set	
21	R030009	8	Spark Plug	
22	TBD	2	Plug , pipe (1/2")	
23	R043033	8	Valve , intake	
24	R043034	8	Valve , exhaust	
25	RM0262B	1	Gasket , cylinder head (RH)	
25	RM0262A	1	Gasket , cylinder head (LH)	
26	R003014	1	Cylinder Head Assembly (RH)	
26	R003015	1	Cylinder Head Assembly (LH)	
27	R049013	16	Rotator , valve	
28	R047226	16	Seal , valve stem	
29	R046049	16	Valve Spring Assembly	
30	R049014	16	Cap , valve spring	
31	R049010	32	Retainer , valve stem	
32	R042013	1	Bracket , lift, rear	
33	93940000	2	Lockwasher , lift bracket attaching bolt	
34	98443025	2	Bolt , lift bracket attaching	

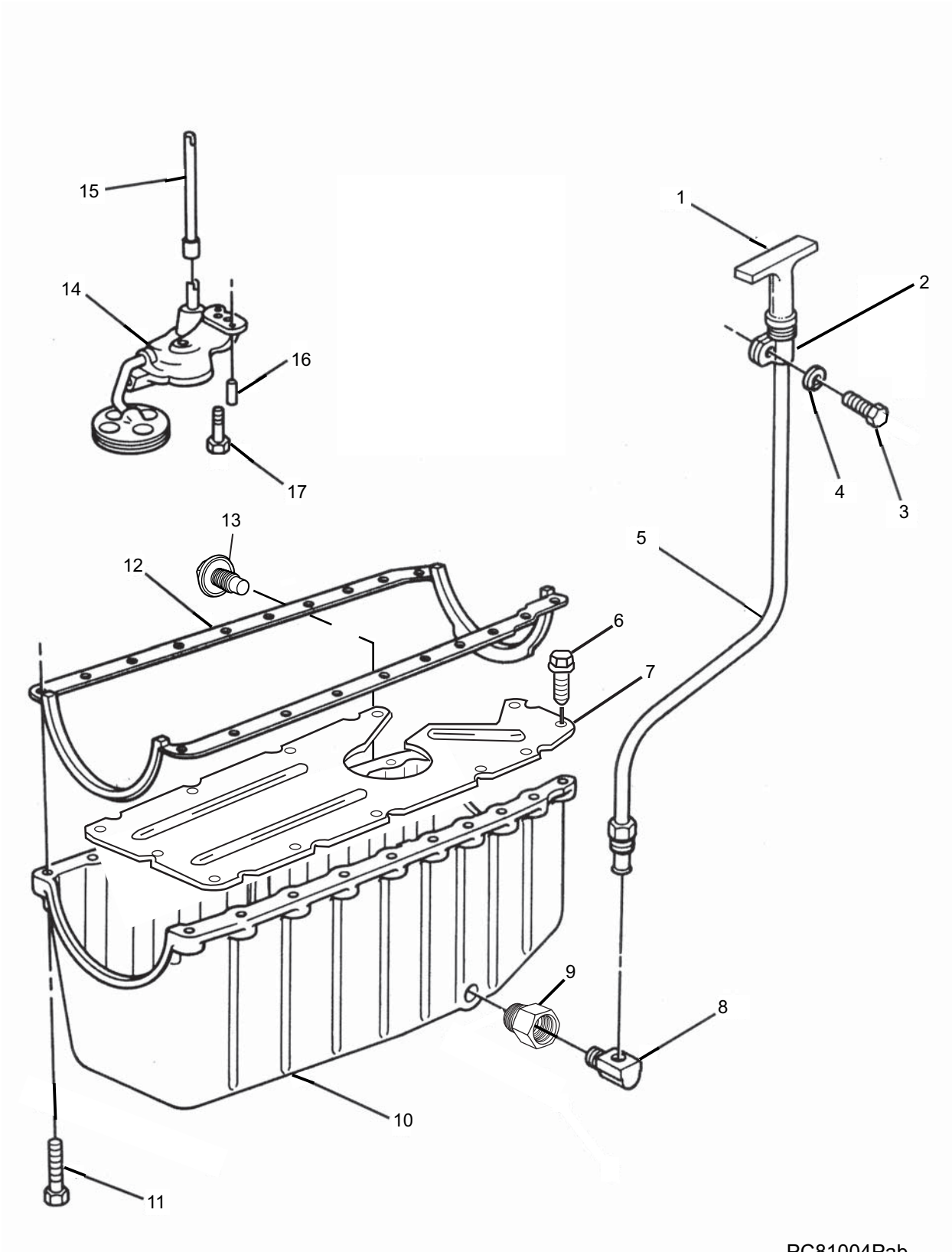
INTAKE MANIFOLD ASSEMBLY - FIGURE 3



INTAKE MANIFOLD ASSEMBLY - FIGURE 3

ITEM	PART NO.	QTY.	DESCRIPTION	MDOEL ID
1	R121075	1	Wire Harness , fuel injectors	
2	RA086001A	1	Fuel Rail Assembly , without fuel return line	
3	TBD	1	Bolt , MAP sensor retaining	
4	RM0265	1	Gasket , EGR blockoff cover	
5	TBD	1	Cover , EGR blockoff	
6	TBD	2	Nut , EGR blockoff cover attaching	
7	TBD	2	Stud , EGR blockoff cover attaching	
8	TBD	1	Plug , intake manifold core hole	
9	20237	1	Hose , fuel pressure regulator vacuum	
10	RM0267	1	Gasket Set , intake manifold	
11	R037004	8	Guide , valve lifter	
12	R040004	16	Lifter , valve	
13	TBD	4	Bolt , valve lifter retainer	
14	R090253	1	Retainer , valve lifter	
15	R012025	1	Guard , oil splash - lifter	
16	R002022	1	Intake Manifold	
17	RM0251	1	Gasket , throttle body mounting	
18	RA035036A	1	Throttle Body , (HO)	
19	TBD	3	Nut , throttle body attaching	
20	TBD	3	Stud , throttle body mounting	
21	R009201	10	Bolt , intake manifold to cylinder head	
22	TBD	1	Seal , MAP sensor	
23	R020036	1	MAP Sensor	
24	RA087006	8	Fuel Injector Assembly	
25	R127097	8	Retainer , fuel injector to fuel rail	
26	RK047227	8	O-Ring , kit fuel injector	
27	R034046A	1	Riser , oil fill	
28	NSS	1	O-Ring , oil fill riser cap	
29	R034038B	1	Cap , oil fill riser	
30	R143137	1	Decal , oil fill riser cap	
31	TBD	1	Bolt , oil fill riser attaching	
32	TBD	4	Stud , fuel rail assembly attaching	
33	R088001	1	Regulator , fuel pressure	
34	R060066	1	Cover , engine	
35	R109052	2	Retainer , engine cover	
36	R009204	4	Bolt , engine cover attaching	
NI	R143167	1	Decal , Levitator	
NI	R143158	1	Decal , "Ultra Low Emissions"	
NI	R143168-06	1	Decal , Emissions, C.A.R.B., MY '06	

OIL PAN and OIL PUMP ASSEMBLY - FIGURE 4

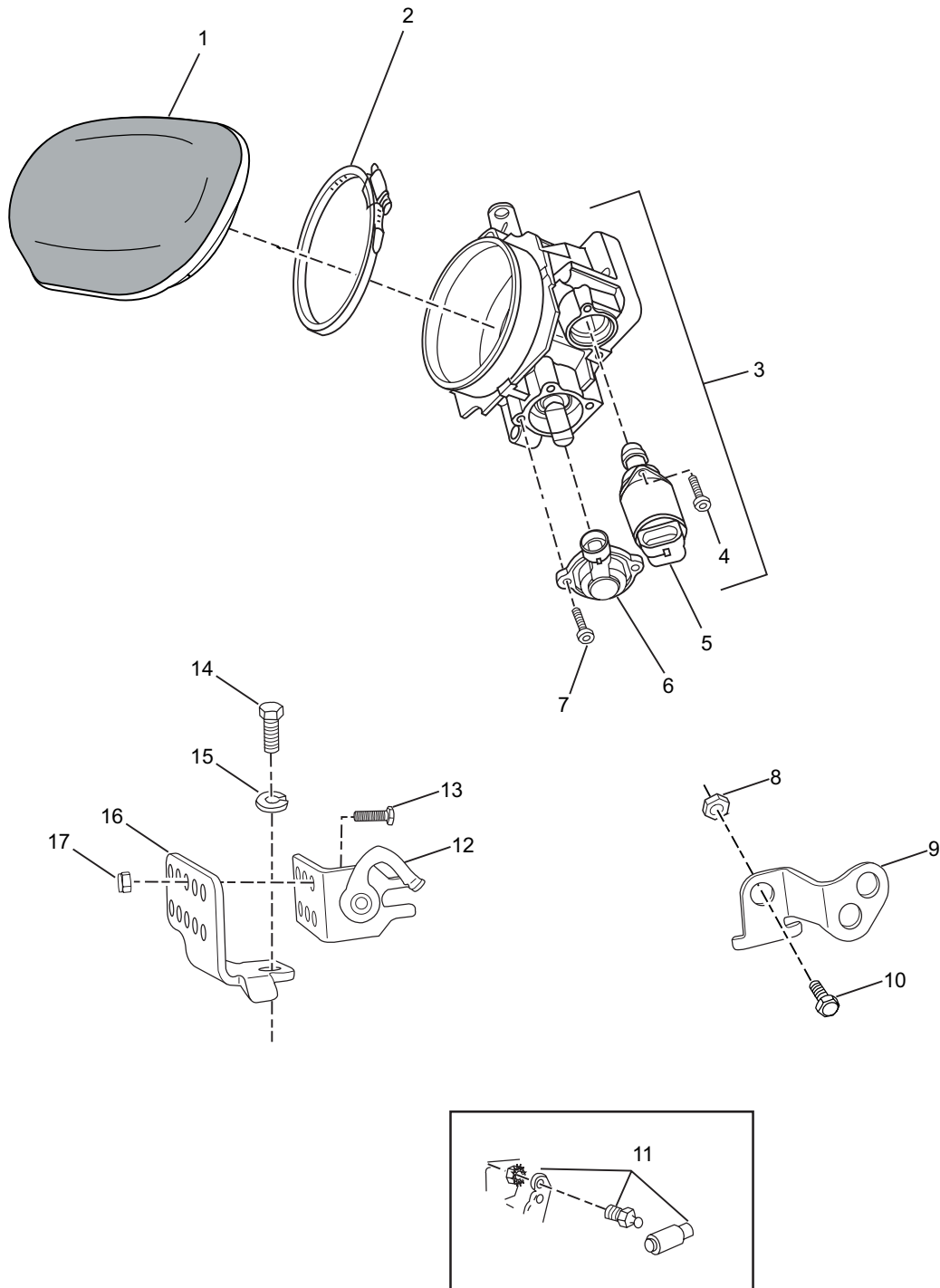


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OIL PAN and OIL PUMP ASSEMBLY - FIGURE 4

ITEM	PART NO.	QTY	DESCRIPTION	QUANTITY
1	R041085	1	Dipstick , oil level	
2	R127015	2	Clamp , dipstick tube attaching	
3	98443025	2	Bolt , dipstick tube attaching	
4	93940000	2	Lockwasher , dipstick tube attaching bolt	
5	R041083	2	Dipstick Tube	
6	TBD	12	Bolt , oil pan baffle	
7	R012026	1	Baffle , oil pan	
8	R024017	2	Elbow , dipstick tube to oil pan	
9	R024200	2	Adapter , dipstick elbow to oil pan	
10	R005023	1	Oil Pan	
11	TBD	20	Bolt , oil pan mounting	
12	RM0263	1	Gasket , oil pan	
13	TBD	1	Plug , oil drain	
14	RA070017	1	Oil Pump Assembly	
15	R058055	1	Shaft , oil pump to oil drive	
16	R022022	1	Pin , dowel - oil pump aligning	
17	TBD	2	Bolt , oil pump mounting	

MECHANICAL THROTTLE BODY and RELATED COMPONENTS - FIGURE 5

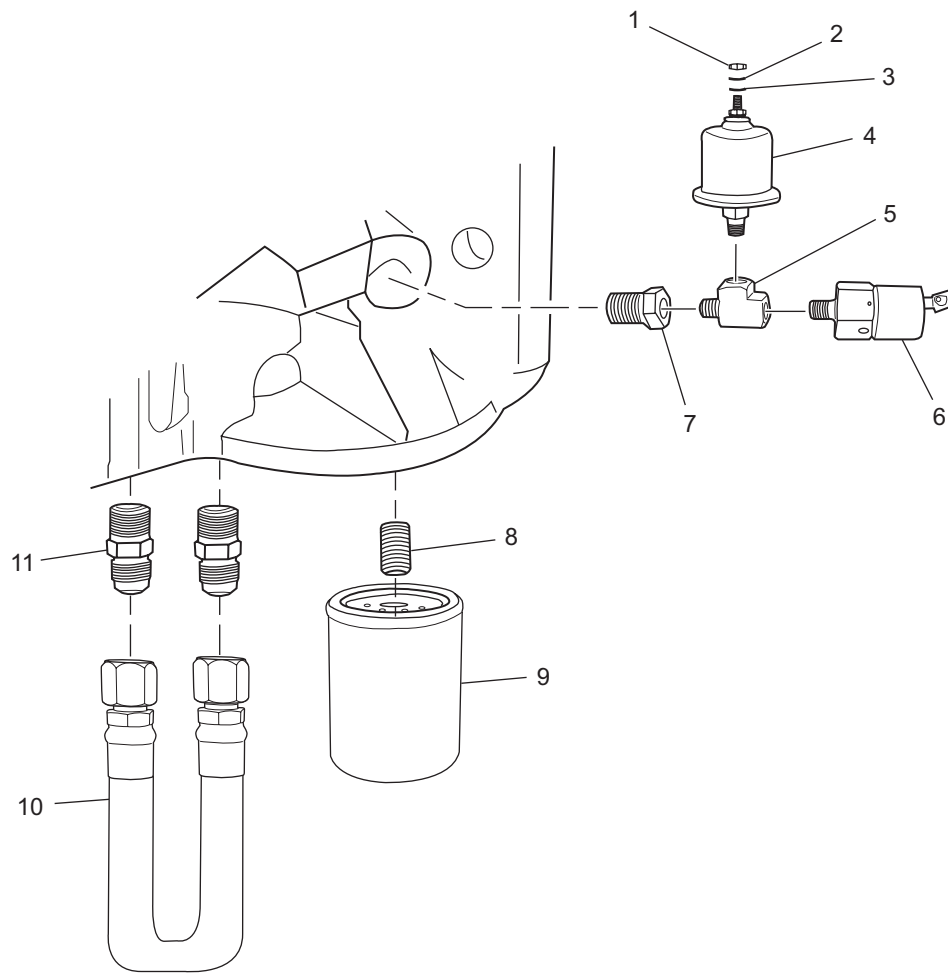


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MECHANICAL THROTTLE BODY and RELATED COMPONENTS - FIGURE 5

ITEM	PART NO.	QTY	DESCRIPTION	MODEL ID
1	R145021	1	Flame Arrestor	
2	RS3857	1	Clamp , retaining	
3	RA035036A	1	Throttle Body Assembly	
4	TBD	2	Screw , IAC valve attaching	
5	49060	1	Valve , idle air control	
6	49061	1	Sensor , throttle position	
7	TBD	2	Screw , TP sensor attaching	
8	RS1078	1	Nut , retaining bolt	
9	R090230	1	Throttle Arm , throttle body	
10	RS0251	1	Bolt , throttle arm retaining	
11	R178014	1	Ball Joint Assembly , cable attaching	
12	R090086	1	Cable Clip , throttle attaching	
13	RS5122	2	Bolt , cable clip mounting	
14	98223016	1	Bolt , bracket mounting	
15	93920000	1	Lockwasher , bracket mounting	
16	R090229	1	Throttle Bracket , intake	
17	RS2055	2	Locking Nut , cable clip mounting bolt	

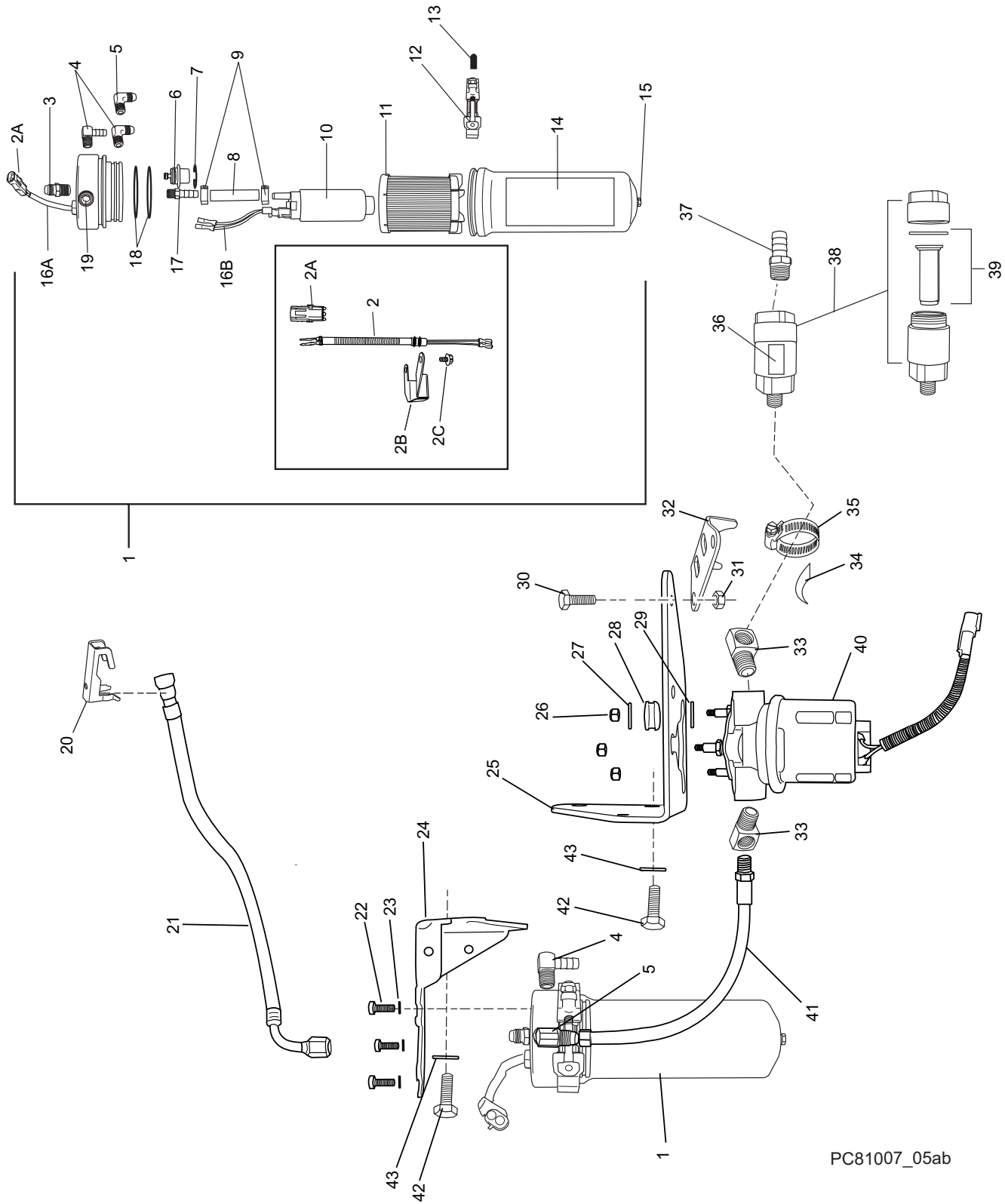
OIL FILTER COMPONENTS - FIGURE 6



OIL FILTER COMPONENTS - FIGURE 6

ITEM	PART NO.	QTY.	DESCRIPTION	MODEL ID
1	95011000	1	Nut , sender terminal	
2	95300300	1	Lockwasher , sender terminal	
3	92300200	1	Washer , sender terminal	
4	R020001	1	Sender , oil pressure	
5	R024145	1	Tee , sender attaching	
6	R020015A	1	Switch , oil pressure	
7	RS3677	1	Adapter , sender attaching tee	
8	R079065	1	Nipple , oil filter attaching	
9	R077016	1	Filter , oil	
10	RA045103A	1	Hose Assembly , oil bypass	
11	R024183	2	Fitting , oil bypass hose	

FUEL CONTROL CELL (FCC) COMPONENTS - FIGURE 7

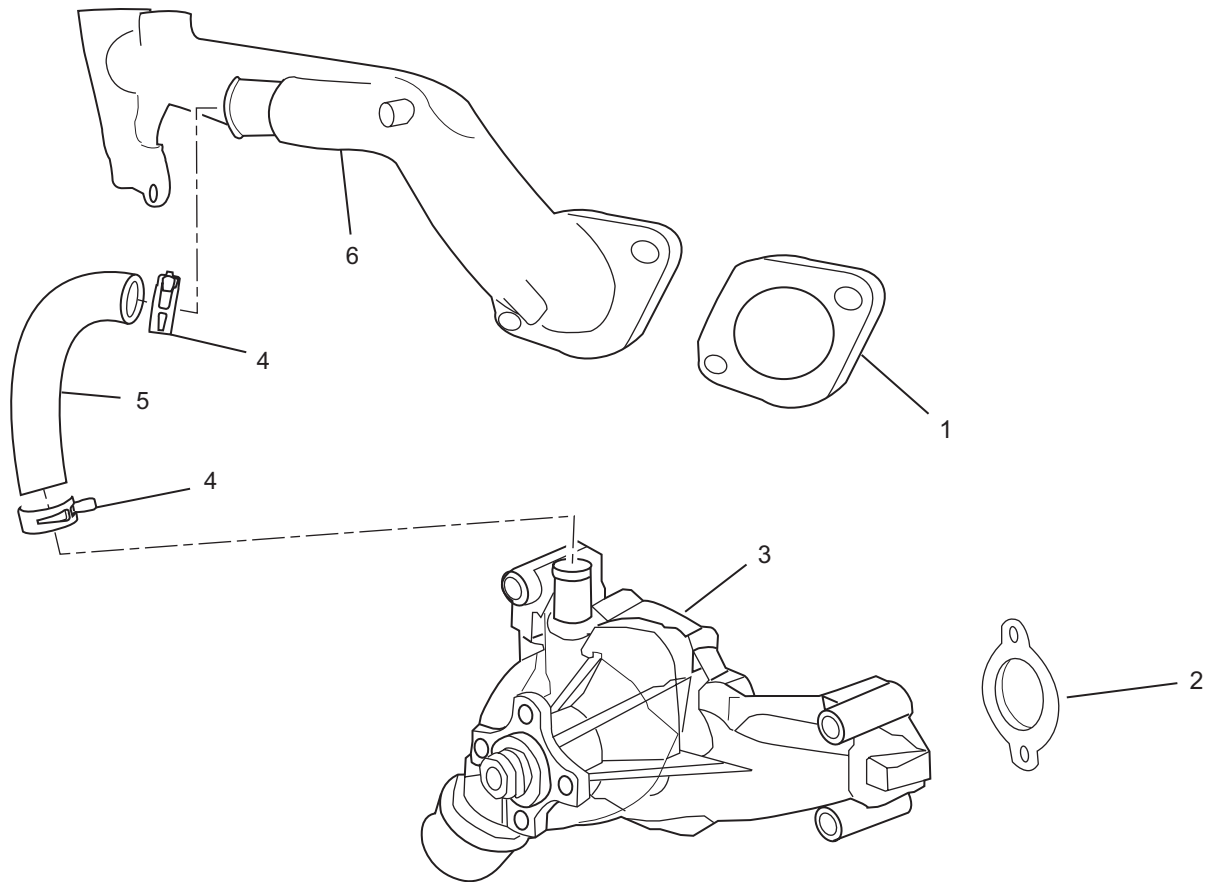


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FUEL CONTROL CELL (FCC) COMPONENTS - FIGURE 7

ITEM	PART NO.	QTY.	DESCRIPTION	MODEL ID
1	RA080030A	1	Fuel Control Cell Assembly	
2	R1210085B	1	Harness , 1-piece, FCC pass through (1-piece harness does not retro fit for 2-piece harness)	
2A	7172040	1	Connector , W/P 2-way Female	
2B	R012030	1	Baffle , FCC used w/1-piece harness	
2C	91620025	2	Screw , self tapping, baffle/1-piece harness retaining	
3	R024175	1	Fitting , 1/4 NPT X SAE	
4	R024225	1	Fitting , 1/4 NPT to 3/8 Hose (return to tank)	
4	R024224	AR	Fitting , 1/4 NPT to SAE (return to tank)	
5	R024163	1	Fitting , 1/4 NPT X SAE (from LPFP)	
6	R088004	1	Regulator , fuel pressure (FCC System Only)	
7	R048070	1	Retainer , fuel pressure regulator	
8	R045098B	1	Hose , 5/16id X 1/2od X 2 1/2	
9	R127087	2	Clamp , Oetiker, 5/8	
10	RA080027	1	Pump , high pressure fuel	
11	R080026	1	Filter , fuel (FCC)	
NI	RP080026	1	Kit , FCC filter and O-rings	
12	R171010	1	Clamp , FCC	
13	R128002	1	Cover , T-bolt end	
14	R143112A	1	Decal , FCC	
15	RS3554	1	Plug , pipe, hex head, 1/8	
16A	RA121060	1	Harness , FCC Feed through	
16B	RA121061A	1	Harness , FCC internal	
17	R024219	1	Fitting , 1/8 NPT X 5/16 Barb	
18	R047241	1	O-Ring , FCC sealing	
19	RS3550	1	Plug , pipe, hex socket, 1/4	
20	R127100	1	Retainer , fuel line	
21	RA085090	1	Hose Assembly , FCC to fuel rail (inlet)	
22	RS0302	3	Bolt , FCC attaching	
23	RS2180	3	Lockwasher , FCC attaching	
24	R090227	1	Bracket , FCC mounting	
25	R090228A	1	Bracket , low-pressure fuel pump mounting	
26	RS1521L	3	Locking Nut , low-pressure fuel pump	
27	R096141	3	Washer , flat, mounting, upper	
28	R094035A	3	Grommet , isolator	
29	R096142	3	Washer , fuel pump mounting, lower	
30	RS0251	2	Bolt , pre-filter bracket attaching	
31	RS1078	2	Nut , w/lockwasher, pre-filter bracket attaching	
32	R090272	1	Bracket , pre-filter mounting	
33	R024192	2	Fitting , 90 degree, LPFP	
34	R094040	1	Isolator , rubber, w/ adhesive	
35	RS3858	1	Clamp , pre-filter 1 1/4"	
36	R143174	1	Decal , pre-filter	
37	R024218	1	Fitting , fuel inlet, pre-filter, 3/8 NPT X 1/2 hose barb	
38	RA077014	1	Fuel Pre-filter Assembly, 150 micron	
39	RP077014	1	Kit , fuel filter and seal	
40	RA080018	1	Fuel Pump , low-pressure	
41	RA085070	1	Hose Assembly , low-pressure pump to FCC	
42	98443030	4	Bolt , FCC/LPFP bracket attaching, block	
43	93940000	4	Lockwasher , FCC/LPFP bracket attaching, block	
NI	R143114	1	Decal , Warning, fuel leaks	

WATER PUMP / WATER CROSSOVER COMPONENTS - FIGURE 8

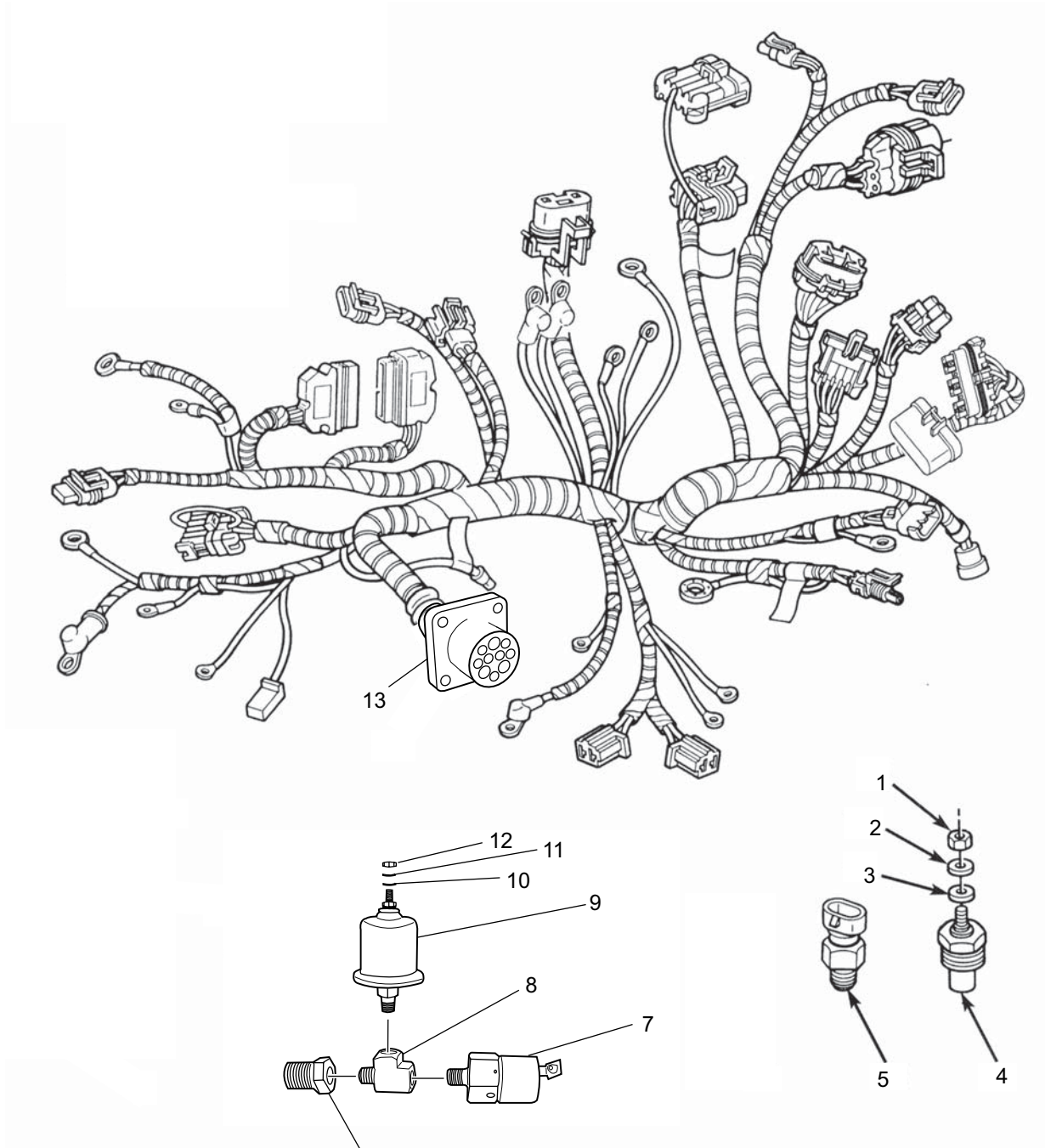


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WATER PUMP / WATER CROSSOVER COMPONENTS - FIGURE 8

ITEM	PART NO.	QTY.	DESCRIPTION	MODEL ID
1	RM0268	2	Gasket , water crossover to engine block	
2	RM0266	2	Gasket , water pump to engine block	
3	RA057030	1	Water Pump Assembly	
4	RS3864	2	Clamp , hose	
5	R045116A	1	Hose , circulation pump to water crossover	
6	R025034	1	Water Crossover	

WIRING HARNESS ASSEMBLY and SENDERS - FIGURE 9

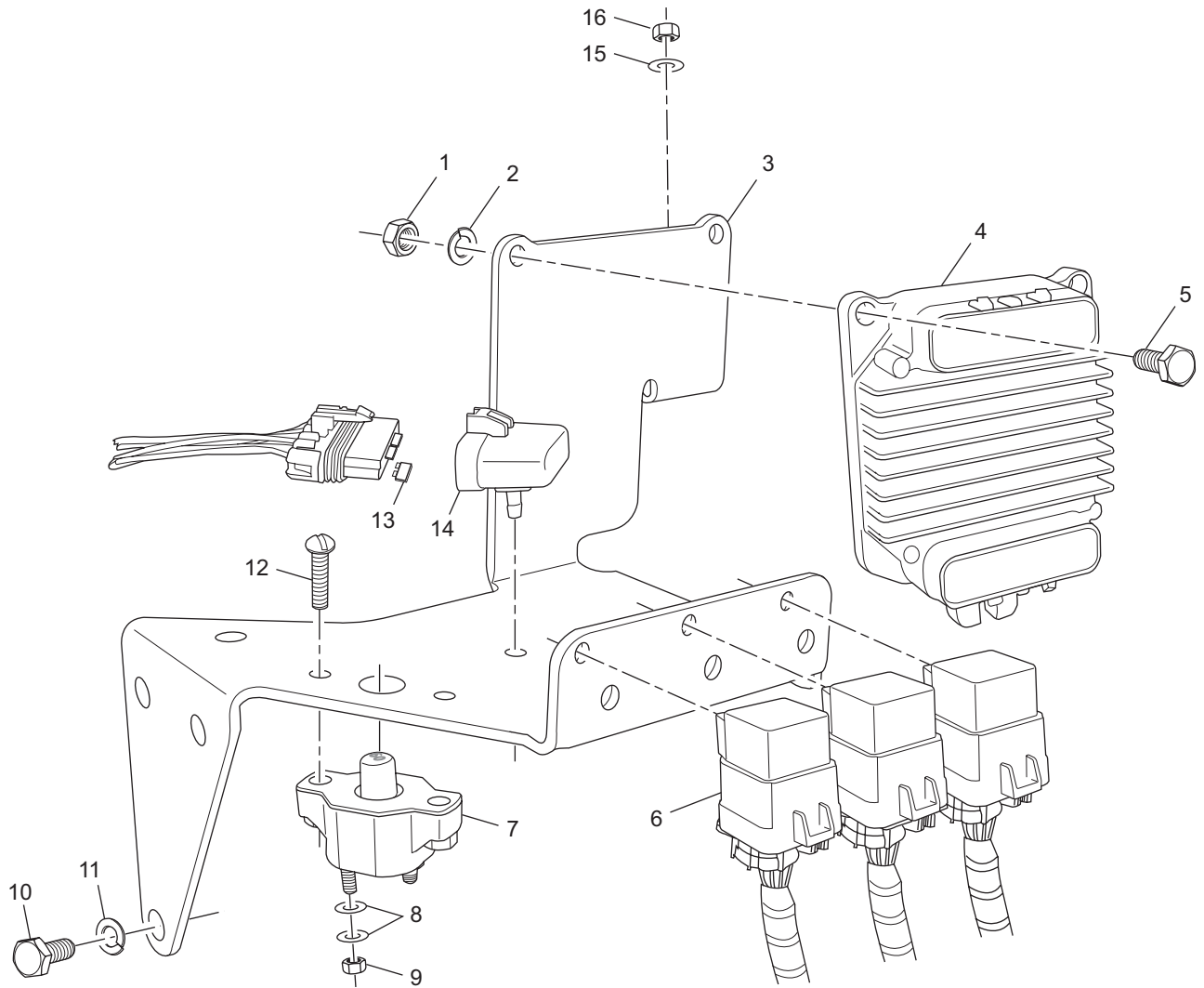


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WIRING HARNESS ASSEMBLY and SENDERS - FIGURE 9

ITEM	PART NO.	QTY.	DESCRIPTION	MODEL ID
1	RS1540	1	Nut , sender terminal	
2	RS2197	1	Lockwasher , sender terminal	
3	RS2746	1	Washer , sender terminal	
4	R020003	1	Sender , temperature (SS)	
5	R020019	1	Sensor , engine coolant temperature (ECT)	
7	RS3677	1	Adapter , sender attaching tee	
8	R020015A	1	Switch , oil pressure (SS)	
9	R024145	1	Tee , sender attaching	
10	R020001	1	Sender , oil pressure (SS)	
11	RS2746	1	Washer , sender terminal	
12	RS2197	1	Lockwasher , sender terminal	
13	RS1540	1	Nut , sender terminal	
14	RA121071B	1	Engine Wiring Harness Assembly	

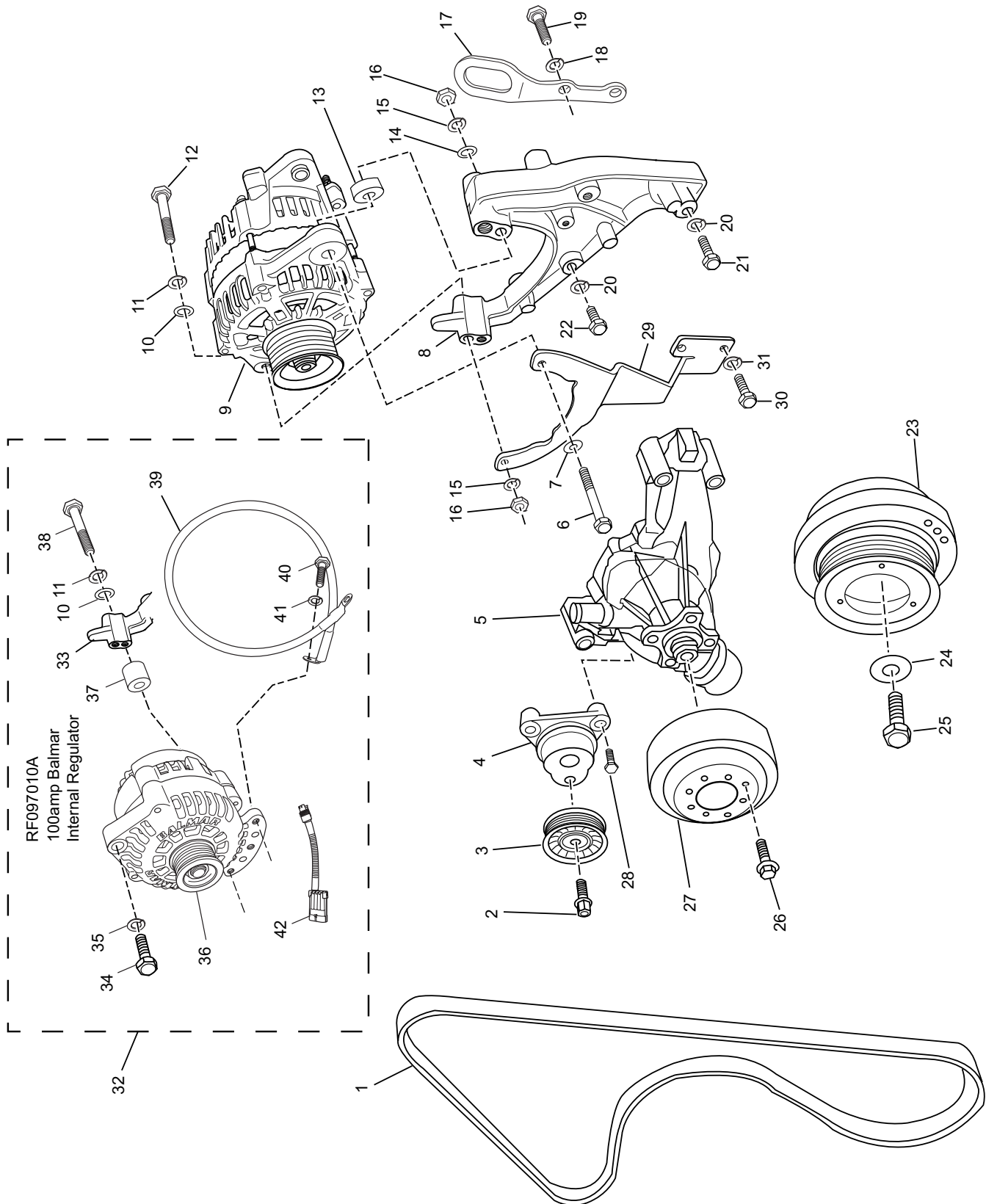
ECM and RELAYS - FIGURE 10



ECM and RELAYS - FIGURE 10

ITEM	PART NO.	QTY	DESCRIPTION	MODEL ID
1	RS1078	3	Nut , ECM mounting	3
2	92100000	3	Washer , ECM mounting	3
3	R090300	1	Bracket , ECM/relay mounting	1
4	R116021Z	1	Electronic Control Module (ECM) cksum 37787 (939B)	1
5	RS0254	3	Bolt , ECM mounting	3
6	R130011A	3	Relay Assembly , fuel pump and ignition	3
7	R153006C	1	Circuit Breaker Assembly (60 amp)	1
8	NSS	4	Washer , circuit breaker terminal	4
9	NSS	2	Nut , circuit breaker terminal	2
10	L00915	1	Bolt , ECM/relay mounting bracket attaching	1
11	93940000	1	Lockwasher , bracket mounting bolt	1
12	RS5084	2	Screw , circuit breaker mounting	2
13	R153017B	3	Fuses , 20 amp	3
14	R126014	1	Cover , fuse holder	1
15	RS2178	1	Lockwasher , ECM/relay bracket attaching	1
16	97224000	1	Nut , ECM/relay bracket attaching	1

ACCESSORY DRIVE SYSTEM COMPONENTS - FIGURE 11

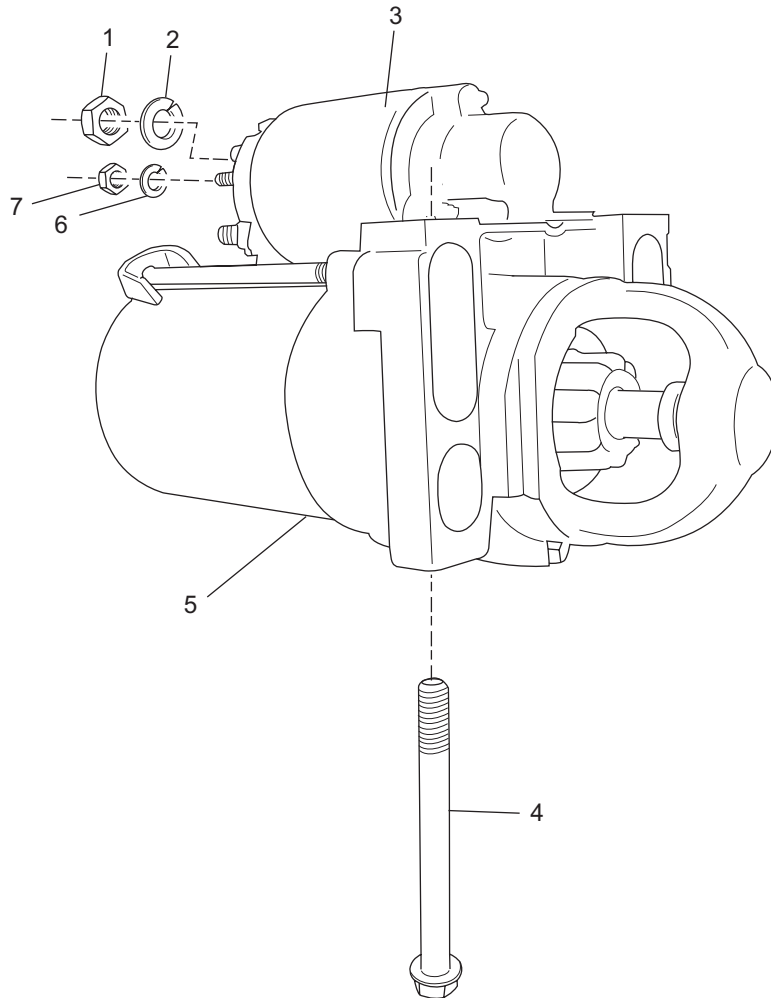


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ACCESSORY DRIVE SYSTEM COMPONENTS - FIGURE 11

ITEM	PART NO.	QTY	DESCRIPTION	MODEL ID
1	R066024	1	Belt , accessory drive	
2	NSS	1	Bolt , tensioner attaching	
3	NSS	1	Pulley , belt tensioner	
4	RA068001	1	Tensioner , belt (includes items #2 and #3)	
5	RA057030	1	Water Pump Assembly	
6	RS6547	1	Bolt , alternator attaching	
7	92930000	1	Washer , alternator attaching bolt	
8	R090225	1	Bracket , alternator mounting	
9	RA097007	1	Alternator Assembly (70 amp)	
10	92930000	1	Washer , alternator attaching bolt	
11	93930000	1	Lockwasher , alternator attaching bolt	
12	98333080	1	Bolt , alternator attaching	
13	R062081	1	Spacer , alternator mounting	
14	92930000	1	Washer , alternator mounting bolt	
15	93930000	2	Lockwasher , alternator mounting bolt	
16	RS7026	2	Nut , alternator mounting	
17	R042009	1	Bracket , lift	
18	93940000	2	Lockwasher , lift bracket attaching bolt	
19	98443025	2	Bolt , lift bracket attaching	
20	93940000	2	Lockwasher , alternator bracket attaching bolt	
21	98449055	1	Bolt , alternator bracket attaching bolt (long)	
22	98449040	1	Bolt , alternator bracket attaching (short)	
23	R064015A	1	Balancer , crankshaft (HO)	
24	TBD	1	Washer , crankshaft balancer	
25	TBD	1	Bolt , crankshaft balancer	
26	TBD	4	Bolt , engine circulating pump pulley mounting	
27	R065044	1	Pulley , engine circulating pump	
28	98443050	2	Bolt , belt tensioner mounting	
29	R090334	1	Bracket , alternator support (Not Used w/100A alternator)	
30	98443030	2	Bolt , alternator support bracket attaching	
31	93940000	2	Lockwasher , alternator support bracket attaching NOTE: Items 30 and 31 are the FCC bracket mounting bolts.	
32	RF097010A	1	Kit , Retrofit 100A Alternator	
33	R090225A	1	Bracket , alternator mounting (100 amp)	
34	90505200	1	Bolt , mounting (100 amp alternator only)	
35	93500000	1	Lockwasher , mounting (100 amp alternator only)	
36	RA097010	1	Alternator Assembly , (100 amp)	
37	R062082	1	Spacer , mounting (100 amp alternator only)	
38	98333075	1	Bolt , mounting (100 amp alternator only)	
39	R101016	1	Cable , ground (100 amp)	
40	98333025	1	Bolt , cable attaching (100 amp alternator only)	
41	RS2179	1	Lockwasher , cable attaching (100 amp alternator only)	
42	R121081	1	Harness , jumper, 100 amp alternator only	

STARTER ASSEMBLY COMPONENTS - FIGURE 12



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STARTER ASSEMBLY COMPONENTS - FIGURE 12

ITEM	PART NO.	QTY.	DESCRIPTION	MODEL ID
1	RS7019	1	Nut , solenoid terminal	
2	TBD	1	Lockwasher , solenoid terminal	
3	RU0050A	1	Solenoid , starter	
4	R009203	2	Bolt , starter mounting	
5	RA122015	1	Starter Motor Assembly	
6	93003000	1	Lockwasher , solenoid terminal	
7	RS7036	1	Nut , solenoid terminal	