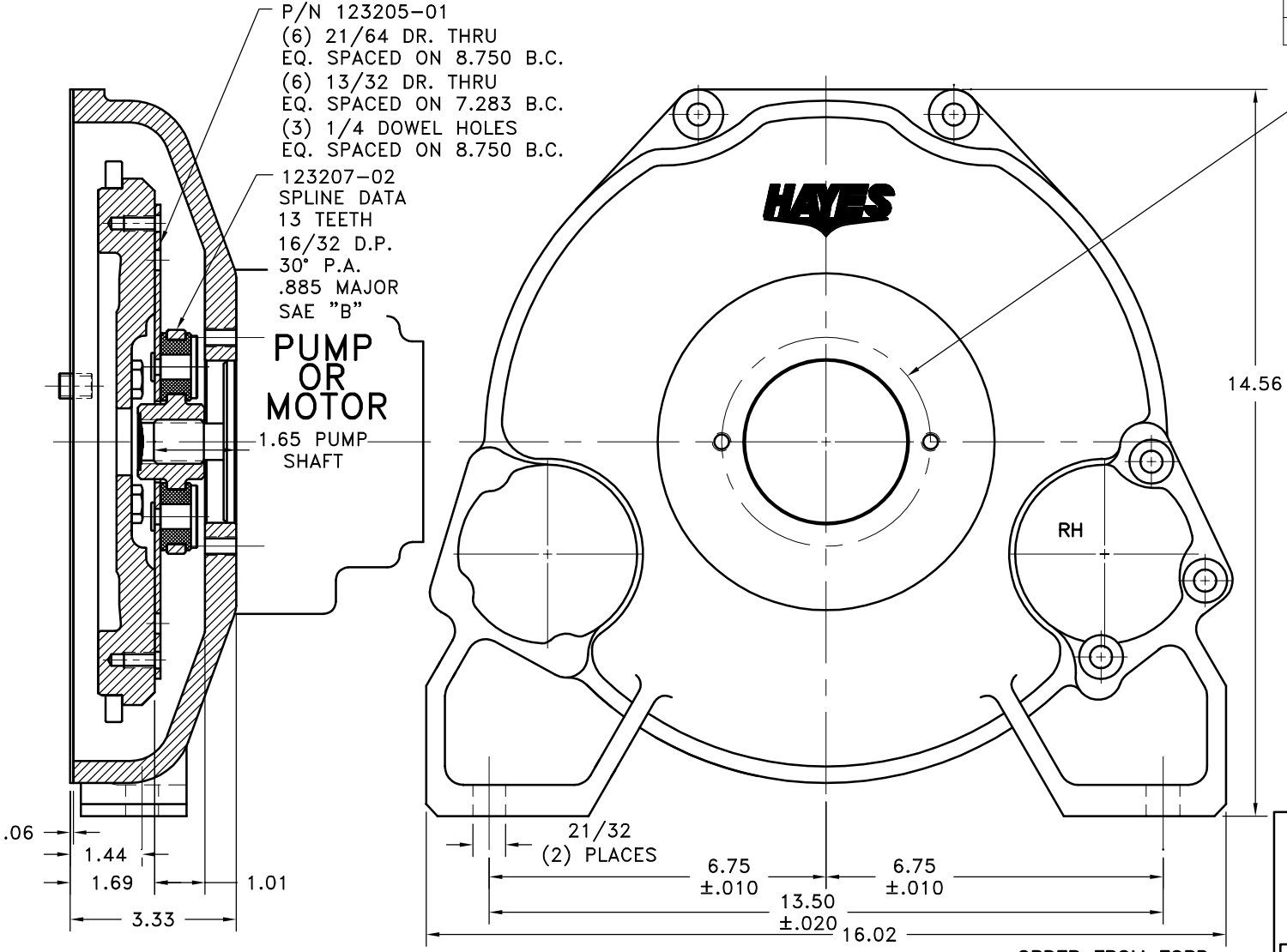


REV	DATE	CHANGE DESCRIPTION	MOD. BY	CK1	CK2



P/N 881445-01
 SAE A 2-BOLT
 3.25 PILOT
 (2) 3/8-16 TAPPED HOLES
 EQ. SPACED ON A 4.18 B.C.

P/N 123205-01
 (6) 21/64 DR. THRU
 EQ. SPACED ON 8.750 B.C.
 (6) 13/32 DR. THRU
 EQ. SPACED ON 7.283 B.C.
 (3) 1/4 DOWEL HOLES
 EQ. SPACED ON 8.750 B.C.

123207-02
 SPLINE DATA
 13 TEETH
 16/32 D.P.
 30° P.A.
 .885 MAJOR
 SAE "B"

**PUMP
 OR
 MOTOR**

1.65 PUMP
 SHAFT

**NOTE: THIS ASS'Y IS FOR A LH
 MARINE STARTER USED ON THE
 RIGHT HAND SIDE.**

UP TO 50 H.P.

QTY.	PART NUMBER	DESCRIPTION
2	9 70HM-6397-AA	DOWEL BUSHINGS
1	8 881445-01	VSG-413 HOUSING
1	7 881446-RH	STARTER PLATE
1	6 801912	GREASE
1	5 HP-1125-S-32	HUBBARD PLUG
6	4 123206-01	STEEL RIVET
6	3 H52500	NEOPRENE INSERT
1	2 123207-02	COUPLING HUB [13 16/32\3.000]
1	1 123205-01	FLYWHEEL PLATE [SPEC\3.000]

**ORDER FROM FORD
 COUPLING ASS'Y #123340-13**

NOTES:

- 1. HOUSING WILL FIT FORD ENGINE VSG-413, 4 CYLINDER, 1.3 LITER (79 CID)**
- 2. USE FURNISHED TEXACO 1912 COUPLING GREASE ON BOTH MALE AND FEMALE SPLINE.**
- 3. CAUTION: WHEN INSTALLING PUMP ON ENGINE HOUSING BE CAREFUL BOLTS DO NOT EXTEND PAST INSIDE FACE OF HOUSING AND RUB ON COUPLING ASSEMBLY.**

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SYMBOLS	DET.	PART NUMBER	DESCRIPTION	QTY.
▭ FLATNESS ▭ STRAIGHTNESS ▭ ANGULARITY ⊥ SQUARENESS // PARALLELISM ◎ CONCENTRICITY ⊕ TRUE POSITION ○ ROUNDNESS ↗ TOTAL RUN OUT ⌀ CYLINDRICITY ✓ FINISH	DO NOT SCALE DRAWING TOLERANCES UNLESS OTHERWISE SPECIFIED 1/2" MAXIMUM ANGLE ±1/2° FRACTION ±1/32 DECIMAL .00 ±.01 .000 ±.005 .0000 ±.0005		HAYES MANUFACTURING INC. ® TITLE FLYWHEEL COUPLING ASS'Y WITH VSG-413 HOUSING MATERIAL	
- UNLESS OTHERWISE SPECIFIED - REMOVE FIRST THREAD ON ALL TAPPED HOLES BREAK ALL SHARP CORNERS .010 TO .020 STAMP OR MARK DRAWING NO.		DRAWN BY SIETING CHECKED BY RJH	DATE 06-30-03 SCALE	DRAWING NO. 866764 SHEET OF REV.