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INSTALLATION INSTRUCTIONS:


1. INSTALL NEW STARTER WITH EXISTING MOUNTING HARDWARE OR APPROVED REPLACEMENTS.
2. USE 4 EA. AN936-516 INTERNAL TOOTH LOCK WASHERS OR SUPPLIED M8 INTERNAL TOOTH LOCK WASHERS UNDER EACH NUT AND/OR BOLT HEAD.
3. TORQUE MOUNTING NUTS AND/OR BOLTS TO 100 INCH-POUNDS.
- ◇ 4. NL & NLR MODELS: FOR 12V OPERATION, LEAVE JUMPER WIRE BETWEEN THE 'B+' TERMINAL AND THE 'S' TERMINAL.  
NL/EC & NLR/EC MODELS (24V ONLY): LEAVE JUMPER WIRE BETWEEN THE 'B+' TERMINAL AND THE 'S' TERMINAL.
- ◇ 5. PLACE MS25171-1S AND MS25171-2S (OR SIMILAR) INSULATING NIPPLES OVER THE 'B+' AND 'S' TERMINAL CONNECTIONS WHEN INSTALLING.
6. PLACE POWER CABLE RING-TERMINAL OVER STARTER 'B+' TERMINAL. INSTALL SUPPLIED M8 INTERNAL TOOTH LOCK WASHER AND NUT ON STARTER 'B+' TERMINAL. USE A 13MM WRENCH TO TORQUE THE NUT TO 60 INCH-POUNDS.
- ◇ 7. USE A 7MM WRENCH TO TORQUE THE SUPPLIED M4 NUT ON THE 'S' TERMINAL TO 10 INCH-POUNDS.
8. CONTINUING AIRWORTHINESS: THE STARTER SHOULD BE RETURNED TO THE FACTORY FOR OVERHAUL AT 2700 HOURS OF ENGINE OPERATION OR WHEN A MAJOR OVERHAUL OF THE ENGINE IS PERFORMED, OR IF SERVICING IS REQUIRED. NO OTHER MAINTENANCE IS REQUIRED OR RECOMMENDED.
9. WHERE REQUIRED TO SUPPORT ANCILLARY EQUIPMENT, IT IS PERMISSIBLE TO DRILL OUT THE THREADED HOLE OR OTHERWISE ALTER BOSS 'A'.  
BOSSSES 'B', 'C', & 'D' MAY BE TRIMMED TO WITHIN 1/8" OF THE STARTER CASE AND DISCARDED WHERE REQUIRED TO CLEAR OTHER DEVICES NEAR THE STARTER.

REVISIONS

ECO	REV	DESCRIPTION	BY	DATE
128414	J	1) REVISED NOTES 4, 5 & 7.	LWE	06/26/19

Diagram showing the front view of the Sky-Tec starter motor. Dimensions include a vertical dimension of (3.9) inches. Labels include 'TIMING HOLE', 'D', 'A', 'B', 'C', 'THREADED 5/16-18 BOSS FOR ALTERNATOR SUPPORT STRUT', and 'ACCESSORY ATTACHMENT POINTS, WHEN USED'.

Diagram showing the side view of the Sky-Tec starter motor. Dimensions include (2.8), (2.3), and (9.3) inches. Labels include 'S' TERMINAL', 'PMA LABEL', and 'B+' TERMINAL'.

UNLESS OTHERWISE SPECIFIED			DRAFTER		LWE		06/26/19		 2900 Selma Highway Montgomery, AL 36108					
DIMENSIONS ARE IN INCHES AND APPLY AFTER HEAT TREAT AND PLATING .X±.015 .XX±.010 .XXX±.005 ANGLES±1° BREAK ALL EDGES AND MACHINE ALL INSIDE CORNER FILLETS .015 MAX; SURFACE FINISH $\sqrt{125}$ GEOMETRIC SYMBOLS PER ASME Y14.5 SPECIFICATION CLASSIFICATION			ENGINEER		B. HENARD		128414				NL INSTALLATION INSTRUCTIONS DRAWING NO. ST25001			
			APPRVD.		N/A		N/A						SCALE SIZE SHEET CODE ID 1:2 B 1 OF 1 65PY1	
			FINISH		N/A		DRAWING NO.							
CLASSIFICATION		DIMENSION CALLOUT		NOTE NO. CALLOUT		DRAWING NO.		REV						
CRITICAL		<XX.XX>		<#>		ST25001		J						
MAJOR		[XX.XX]		[#]										
MINOR		XX.XX		#										
REFERENCE		(XX.XX)		(#)										
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			SCALE		SIZE		SHEET		CODE ID		DRAWING NO.			
1:2		B		1 OF 1		65PY1		ST25001		J				

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