

MARINE
ENGINES**Crusader**PARTS
CATALOG

FIG. 4 INTAKE MANIFOLD ASSEMBLY STD.

QUANTITY

305

350

ITEM	PART NO.	DESCRIPTION	RH	LH	RH	LH
46	97405	FUEL PUMP	1	1	1	1
47	143343	ELBOW	2	2	2	2
48	91340	GASKET FUEL PUMP MOUNT	1	1	1	1
49	91607	PLATE, FUEL PUMP MOUNT	1	1	1	1
50	91341	GASKET PLATE TO BLOCK	1	1	1	1
51	20790	BOLT	2	2	2	2
52	NSS	PART OF 20790				
53	12179	PUSH ROD FUEL PUMP	1	1	1	1
54	33239	CHOKE ASS'Y 0° INST.	1	1	1	1
54	33240	CHOKE ASS'Y 15° INSTALLATION	1	1	1	1
55	96922	CLIP	1	1	1	1
56	273513	SCREW	1	1	1	1
57	181336	BOLT 5/16 - 24 x 3/4"	2	2	2	2
58	103320	WASHER 5/16 LOCK	2	2	2	2
59	143343	ELBOW	1	1	1	1
60	142427	NUT FLARE	1	1	1	1
61	97379	FUEL LINE	1	1	1	1
62	41062	COIL	1	1	1	1
63	436756	SCREW 10 - 32 x 1 - 1/2	1	1	1	1
65	41063	BRACKET, COIL MTG	1	1	1	1
66	97259	BRACKET FILTER MOUNTING	1	1	1	1
67	91365	FILTER ASS'Y	1	1	1	1
67	91606	FILTER ELEMENT	1	1	1	1
68	179837	BOLT 3/8 - 16 x 3/4	2	2	2	2
69	103321	WASHER 3/8 LOCK	2	2	2	2

FIG. 4 INTAKE MANIFOLD ASSEMBLY STD.

ITEM	PART NO.	DESCRIPTION	QUANTITY			
			RH	LH	RH	LH
70	45342	CAP, CARB VACUUM PART	1	1	1	1
71	91083	GASKET DIST. BASE	1	1	1	1
72	45285	VACUUM BREAK CONTROL 4BBL ONLY	1	1	1	1
NOTE: 1			97033 GASKET USE QTY. 1			
NOTE: 2			FOR 0° INSTALLATION CH220,270 AND ALL CH190, USE QTY. 2 FOR 15° CH220 AND 270 SEE DISTRIBUTOR BREAK DOWN SECTION FOR ADDITIONAL LISTINGS			
NOTE: 3			CARB KITS:			
	45334	OVERHAUL KIT 4BBL				
	45346	OVERHAUL KIT 2BBL				
	45336	GASKET KIT 4BBL				
	45347	GASKET KIT 2BBL				

MARINE
ENGINES



PARTS
CATALOG

QUANTITY	
RH	305
LH	350

ITEM	PART NO.	DESCRIPTION	RH	LH	RH	LH
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NOTE: 4 97316 THROTTLE CONTROL BRACKET

PACEMAKER ONLY

NOTE: 5 FOR CH190 USE BOLT # 180044

1/4 - 20 X 2" PLATED

FIGURE 5

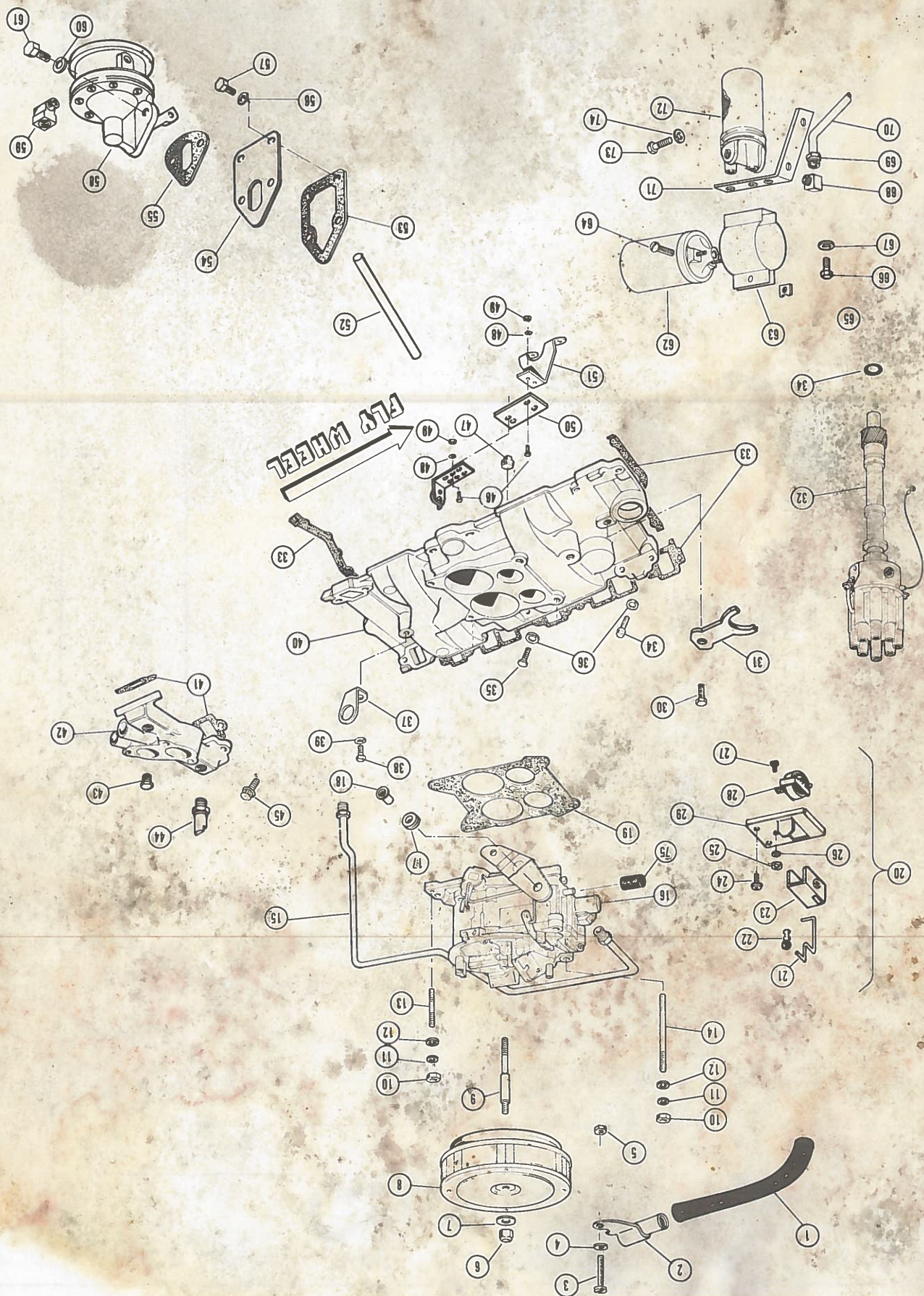


FIG. 5

INTAKE MANIFOLD ASSEMBLY LOW PROFILE

ITEM	PART NO.	DESCRIPTION	QUANTITY			
			RH	LH	RH	LH

1	23091	BREATHER HOSE	1	1	1	1
2	21064	VENT TUBE BRACKET	1	1	1	1
3	436673	SCREW #6 - 32 x 2	1	1	1	1
4	131014	WASHER #6 LOCK	1	1	1	1
5	427524	NUT #6 - 32	1	1	1	1
6	20231	NUT SELF LOCKING	1	1	1	1
7	103339	WASHER 1/4" FLAT	1	1	1	1
8	97214	FLAME ARRESTOR 4BB2	1	1	1	1
8	97456	FLAME ARRESTOR 2BB2 CH190	1	1	1	1
9	96926	STUD FLAME ARRESTOR 4BB2	1	1	1	1
10	102634	NUT 5/16 - 18	4	4	4	4
11	103320	WASHER 5/16 LOCK	4	4	4	4
12	103340	WASHER 5/16 FLAT	4	4	4	4
13	96817	STUD SHORT	4	4	2	2
14	96818	STUD LONG	2	2	2	2
15	97380	FUEL LINE 4BBL	1	1	1	1
16	96820	CARBURETOR 4BBL	1	1	1	1
17	20410	BUSHING	1	1	1	1
18	20409	SLEEVE	1	1	1	1
19	97033	GASKET 4BBL	1	1	1	1
19	91616	GASKET 2BBL	1	1	1	1
20	96986	CHOKE ASS'Y	1	1	1	1
21	97044	CHOKE ROD 4BBL	1	1	1	1
22	96992	CLIP	1	1	1	1
23	96989	COVER	1	1	1	1

FIG. 5 INTAKE MANIFOLD LOW PROFILE

QUANTITY

350

305

ITEM	PART NO.	DESCRIPTION	RH		LH	
			RH	LH	RH	LH

24	273513	SCREW AND WASHER ASS'Y	1	1	1	1
25	120361	NUT #10 - 24	1	1	1	1
26	120217	WASHER #10 LOCK	1	1	1	1
27	443874	SCREW #10 - 24 x 1/2"	1	1	1	1
28	96990	CHOKE COIL	1	1	1	1
29	97045	MOUNTING PLATE	1	1	1	1
30	179837	BOLT 3/8 - 16 x 3/4	1	1	1	1
31	20799	CLAMP, DIST.	1	1	1	1
32	41050	DISTRIBUTOR See Note 1	1	1	1	1
33	21006	INTAKE MANIFOLD GASKET SET	1	1	1	1
34	91083	DISTRIBUTOR BASE GASKET	1	1	1	1
35	179839	BOLT 3/8 - 16 x 1"	1	1	1	1
36	103321	WASHER 3/8" LOCK	8	8	8	8
37	96845	LIFTING EYE	2	2	2	2
38	179885	BOLT 1/2 - 13 x 1 1/2"	2	2	2	2
39	103323	WASHER 1/2" LOCK	2	2	2	2
40	96230	INTAKE MANIFOLD LOW PROFILE	1	1	1	1
41	96729	THERMOSTAT HSG. GASKET	2	2	2	2
42	96728	THERMOSTAT HOUSING LOW PROFILE	1	1	1	1
43	438159	PLUG 1/2 NPT	1	1	1	1
44	20326	ENGINE WATER TEMP. ALARM SENDER	1	1	1	1
45	20338	BOLT FERRY HEAD CAP	4	4	4	4
46	44374	SCREW #10 - 24 x 1/2	4	4	4	4
47	44705	PLUG 1/2 NPT	1	1	1	1
48	120217	WASHER #10 LOCK	4	4	4	4

PARTS CATALOG



MARINE ENGINES

FIG. 5 INTAKE MANIFOLD ASSEMBLY PROFILE

ITEM	PART NO.	DESCRIPTION	QUANTITY			
			RH	LH	RH	LH
49	120361	NUT # 10 NUT	4	4	4	4
50	97280	SPACER	1	1	1	1
51	96683	THROTTLE BRACKET	1	1	1	1
52	12179	FUEL PUMP PUSH ROD	1	1	1	1
53	91341	PLATE MTG GASKET	1	1	1	1
54	91607	FUEL PUMP MOUNTING PLATE	1	1	1	1
55	91340	FUEL PUMP MOUNTING GASKET	1	1	1	1
56	NSS	PART OF # 20790	—	—	—	—
57	20790	BOLT AND WASHER ASS'Y	2	2	2	2
58	97405	FUEL PUMP	1	1	1	1
59	143343	ELBOW	2	2	2	2
60	NSS	PART OF # 20791	—	—	—	—
61	20791	BOLT & WASHER ASS'Y	2	2	2	2
62	41062	COIL	1	1	1	1
63	41063	COIL MTG BRACKET	1	1	1	1
64	436756	SCREW #10 - 32 x 1 1/2"	1	1	1	1
66	181336	BOLT	2	2	2	2
67	133320	WASHER	2	2	2	2
68	143343	ELBOW	1	1	1	1
69	142427	FLARE NUT	1	1	1	1
70	97379	FUEL LINE	1	1	1	1
71	97259	FILTER MOUNTING BRACKET	1	1	1	1
72	91365	FILTER ASS'Y	1	1	1	1
72	91606	FILTER ELEMENT	1	1	1	1
73	179837	BOLT 3/8 - 16 x 3/4	1	1	1	1

ITEM	PART NO.	DESCRIPTION	RH	LH	RH	LH
74	103321	WASHER 3/8 LOCK	2	2	2	2
75	45342	CAP CARB VACUUM PORT	1	1	1	1
76	20808	KIT LOW PROFILE MANIFOLD	AR	AR	AR	AR
77	179847	BOLT THERMOSTAT HSG. Not Shown 3/8 - 16 x 2	3	3	3	3
NOTE 1		SEE DISTRIBUTOR BREAKDOWN SECTION FOR ADDITIONAL LISTINGS.				
NOTE 2		CARB KITS 45334 OVERHAUL KIT 4BBL 45346 OVERHAUL KIT 2BBL 45336 GASKET KIT 4BBL 45347 GASKET KIT 2BBL				

MARINE ENGINES		 Crusader		PARTS CATALOG	
QUANTITY					
305		350			
ITEM	PART NO.	DESCRIPTION		RH	LH
		NOTES		RH	LH

FIGURE 6

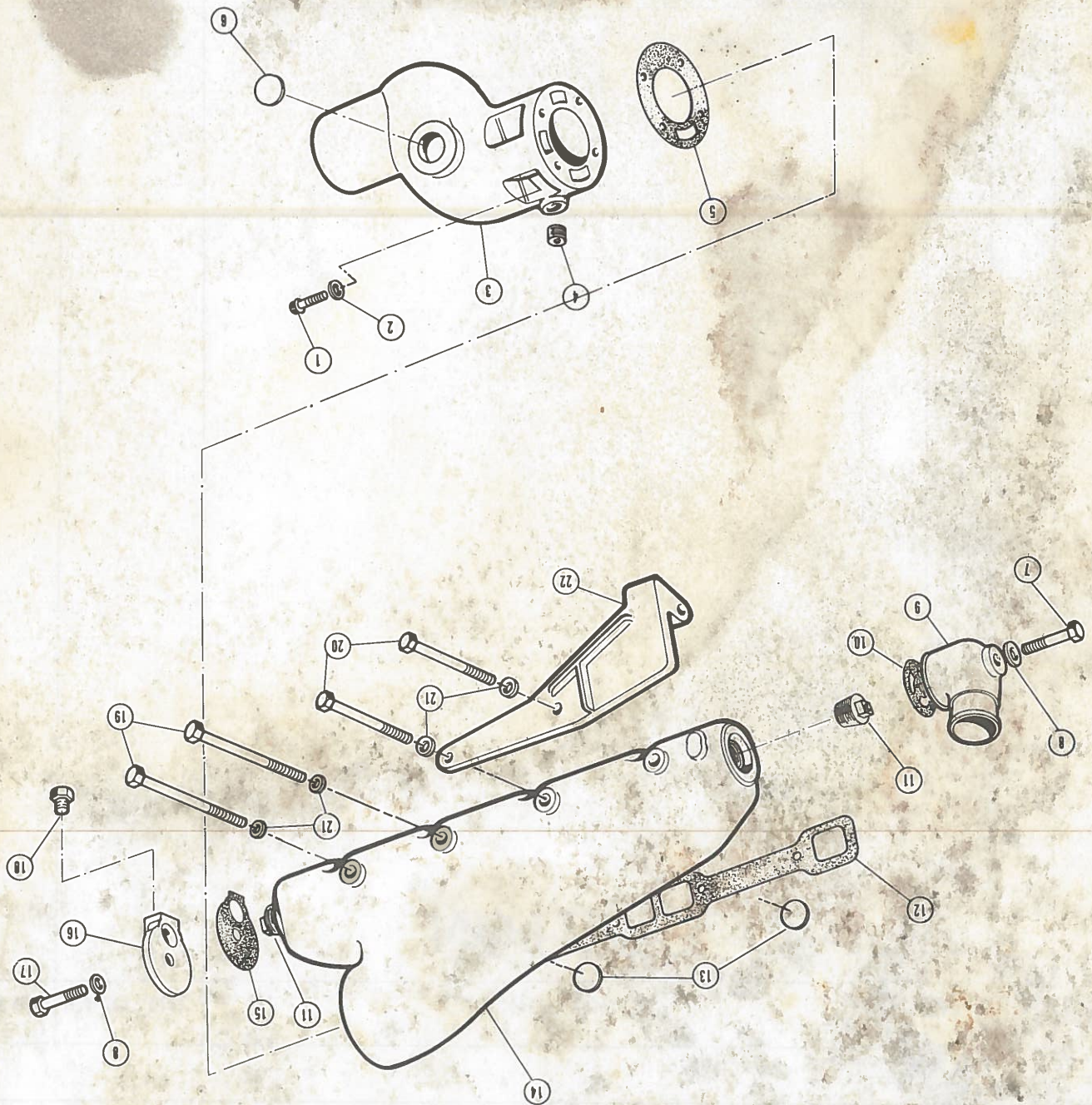


FIG. 6 EXHAUST MANIFOLD ASSEMBLY

QUANTITY

350

305

DESCRIPTION

ITEM PART NO.

1	20257	BOLT FERRY HEAD CAP	8	RH
2	103321	WASHER 3/8 LOCK	8	RH
3	96560	ELBOW ASS'Y	2	RH
4	444709	PLUG 3/4 NPT	2	RH
5	96562	GASKET ELBOW	2	RH
6	20244	CUP PLUG 1 1/4" S.S.	2	RH
7	20271	BOLT S.S.	2	RH
8	116103	WASHER 3/8 COPPER SEALING	4	RH
9	96144	ELBOW WATER INLET	2	RH
10	96216	GASKET WATER INLET ELBOW	2	RH
11	96339	PLUG SPECIAL	4	RH
12	96306	EXHAUST MANIFOLD GASKET	2	RH
13	20244	CUP PLUG 1 1/4 S.S.	4	RH
14	96120	EXHAUST MANIFOLD LEFT	1	RH
14	96121	EXHAUST MANIFOLD RIGHT	1	RH
15	96331	GASKET, DRAIN COVER	2	RH
16	96292	COVER, DRAIN	2	RH
17	20272	BOLT S.S.	2	RH
18	127951	PLUG 1/4 NPT	2	RH
19	186289	BOLT 3/8 - 16 x 5	6	RH
20	187491	BOLT 3/8 - 16 x 5 1/2	2	RH
21	103321	WASHER 3/8	8	RH
22	96422	ALTERNATOR MOUNTING BRACKET	1	RH

FIGURE 7

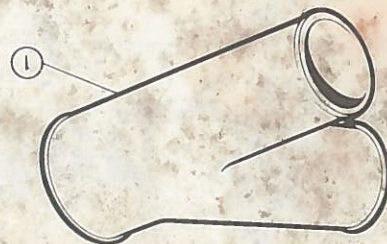
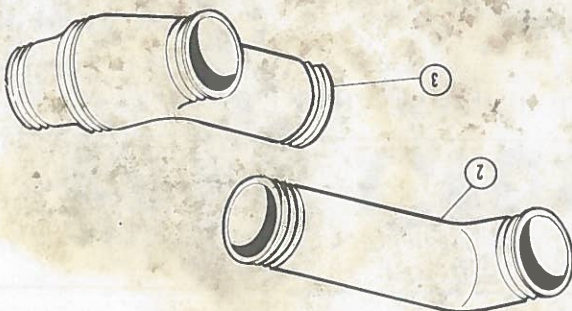
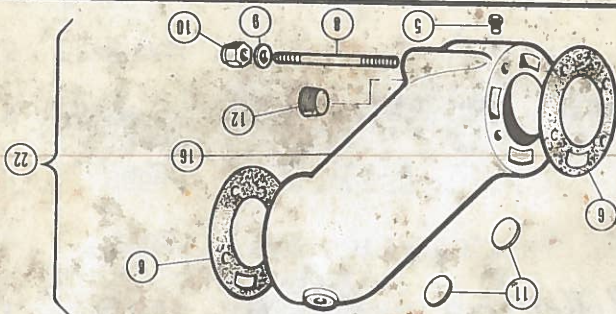
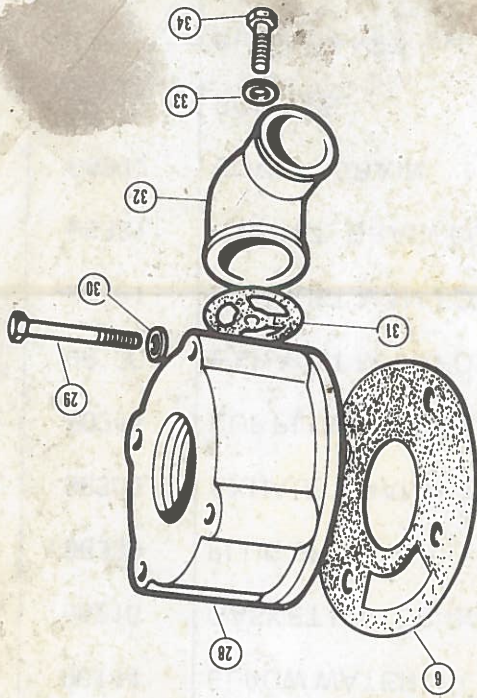
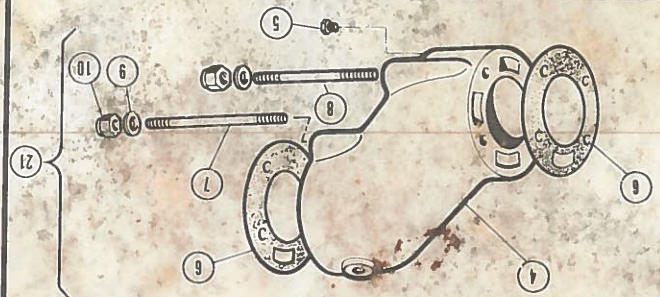
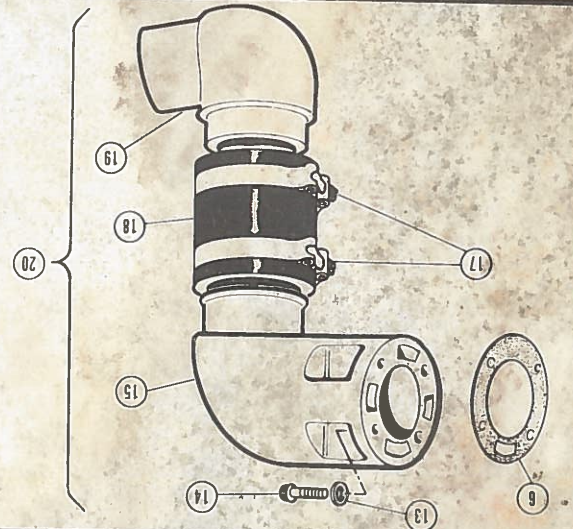
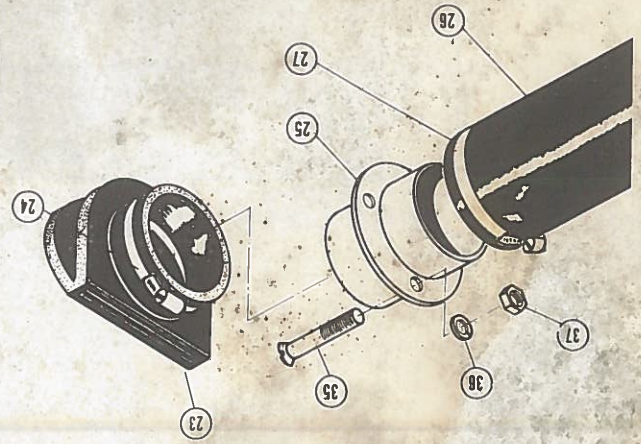


FIG. 7

EXHAUST OPTIONS

ITEM	PART NO.	DESCRIPTION	QUANTITY			
			RH	LH	RH	LH
1	91452	CONNECTOR EXHAUST "Y"	1	1	1	1
2	96937	EXHAUST CROSSOVER	1	1	1	1
3	96936	EXHAUST "Y"	1	1	1	1
4	96419	4" RISER	2	2	2	2
5	127951	PLUG 1/4 NPT	2	2	2	2
6	96562	GASKET EXHAUST RISER	AR	AR	AR	AR
7	20470	STUD S.S.	4	4	4	4
8	20471	STUD S.S.	4	4	4	4
9	116103	WASHER FLAT SEALING	8	8	8	8
10	20472	NUT SELF LOCKING	8	8	8	8
11	20244	PLUG CUP 1 1/4" S.S.	4	4	4	4
12	444709	PLUG 3/4 NDT	2	2	2	2
13	103321	WASHER 3/8 LOCK	8	8	8	8
14	20257	BOLT FERRY HEAD CAP	8	8	8	8
15	97386	SWIVEL ELBOW UPPER	2	2	2	2
16	97169	8" RISER	2	2	2	2
17	96455	CLAMP SPECIAL	4	4	4	4
18	22098	HOSE UPPER TO LOWER ELBOW 4" x 2 - 1/2"	2	2	2	2
19	97387	SWIVEL ELBOW LOWER	2	2	2	2
20	22095	SWIVEL ELBOW KIT	2	2	2	2
21	20280	4" RISER KIT Note 1	2	2	2	2
22	21097	8" RISER KIT Note 2	2	2	2	2
23	20860	EXHAUST OUTLET FLAPPER	2	2	2	2
24	22001	CLAMP EXHAUST OUTLET FLAPPER	2	2	2	2
25	21099	EXHAUST OUTLET FLANGE 3"	2	2	2	2

MARINE ENGINES		Crusader		PARTS CATALOG	
FIG. 7 EXHAUST OPTIONS					
QUANTITY					
305					
350					
ITEM	PART NO.	DESCRIPTION	RH	LH	RH
26	22000	HOSE 3" ID x 36" NOTE 2	2	2	2
27	97507	CLAMP #56	2	2	2
28	96169	ADAPTER DRY EXHAUST	2	2	2
29	186282	BOLT 3/8 - 16 x 3 1/4	8	8	8
30	103321	WASHER 3/8 LOCK	8	8	8
31	96216	GASKET	2	2	2
32	96144	ELBOW WATER OUTLET	2	2	2
33	116103	WASHER FLAT SEALING	2	2	2
34	20271	BOLT	2	2	2
35	22002	SCREW 1/4 - 20 x 3" S.S.	8	8	8
36	22004	WASHER 1/4 FLAT S.S.	8	8	8
37	22003	NUT 1/4 - 20 S.S.	8	8	8
NOTE 1		RISER KITS ARE FURNISHED TO FIT BOTH RAW AND FRESH WATER COOLING SYSTEMS			
NOTE 2		HOSE # 22000 IS SUPPLIED 36" LONG CUT FOR SHORTER LENGTHS. LONGER LENGTHS AVAILABLE ON SPECIAL ORDER FROM CRUSADER MARINE PARTS DEPT.			

MARINE ENGINES		 Crusader		PARTS CATALOG
		QUANTITY		
		305		350
ITEM	PART NO.	DESCRIPTION		
RH	LH	RH	LH	RH LH
NOTES				

FIGURE 8

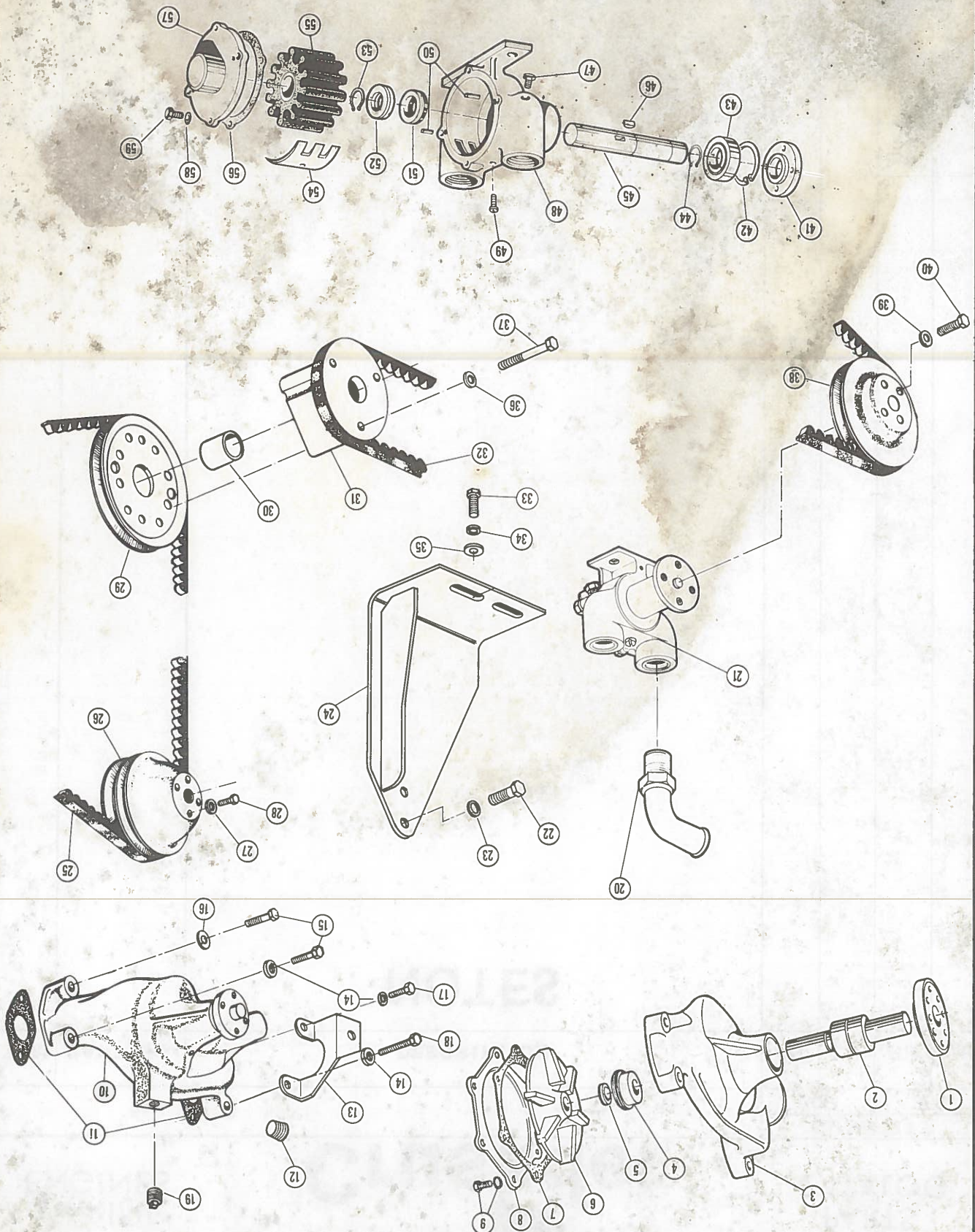


FIG. 8

CIRCULATION & RAW WATER PUMPS

QUANTITY

305

350

ITEM	PART NO.	DESCRIPTION	RH	LH	RH	LH
1	96972	HUB	1	1	1	1
2	96996	SHAFT & BRG ASS'Y	1	1	1	1
3	20204	BODY CIRC. PUMP	1	1	1	1
4	96122	SEAL CIRC. PUMP	1	1	1	1
5	96971	SEAL CERAMIC	1	1	1	1
6	96995	IMPELLER	1	1	1	1
7	20584	GASKET	1	1	1	1
8	96217	BACKING PLATE CIRC. PUMP	1	1	1	1
9	179791	BOLT & WASHER ASS'Y	6	6	6	6
10	20318	PUMP ASS'Y	1	1	1	1
11	91112	GASKET PUMP TO BLOCK	2	2	2	2
12	444588	PLUG 1/2 NPT	1	1	1	1
13	96944	COOLER BRACKET	1	1	1	1
13	97519	COOLER BRACKET WARNER V-DRIVE 9" COOLER	1	1	1	1
14	103321	WASHER 3/8 LOCK	3	3	3	3
15	179843	BOLT 3/8 - 16 x 1 1/2	1	1	1	1
16	103321	WASHER 3/8 LOCK	1	1	1	1
17	179850	BOLT 3/8 - 16 x 2 3/4"	1	1	1	1
18	179845	BOLT 3/8 - 16 x 1 3/4"	2	2	2	2
19	444588	PLUG 1/2 NPT	1	1	1	1
20	97442	ELBOW ASS'Y	1	1	1	1
21	97179	RAW WATER PUMP ASS'Y	1	1	1	1
22	179839	BOLT 3/8 - 16 x 1"	2	2	2	2
23	103321	WASHER 3/8" LOCK	2	2	2	2
24	96945	BRACKET RAW WATER PUMP MOUNT	1	1	1	1

MARINE ENGINES		Crusader		PARTS CATALOG	
FIG. 8 CIRCULATION & RAW WATER PUMPS					
QUANTITY					
305					
350					
ITEM	PART NO.	DESCRIPTION			
25	96307	ALTERNATOR & CIRC. PUMP BELT			
26	20114	PULLEY CIRC. PUMP			
27	103320	WASHER 5/16 LOCK			
28	181336	BOLT 5/16 - 24 x 3/4"			
29	20166	PULLEY CRANKSHAFT RAW WATER PUMP & ALT.			
30	96130	SLEEVE			
31	96946	PULLEY CRANKSHAFT RAW WATER PUMP			
32	97178	BELT RAW WATER PUMP			
33	179838	BOLT 3/8 - 16 x 1"			
34	103321	WASHER 3/8 LOCK			
35	20465	WASHER 3/8 FLAT SPECIAL			
36	103321	WASHER 3/8 LOCK			
37	181380	BOLT 3/8 - 24 x 2 1/4			
38	97177	PULLEY RAW WATER PUMP			
39	103320	WASHER 5/16 LOCK			
40	181336	BOLT 5/16 - 24 x 3/4 "			
41	97176	HUB RAW WATER PUMP			
42	20294	SNAP RING			
43	20292	BEARING			
44	20293	SNAPRING			
45	20304	SHAFT			
46	20295	KEY			
47	127950	PLUG 1/8 NPT			
48	20307	BODY			
49	20298	SCREW SPECIAL			

MARINE
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FIG. 8 CIRCULATION & RAW WATER PUMPS

ITEM		PART NO.	DESCRIPTION		QUANTITY	
					RH	LH
50		20290	PIN		1	1
51		20309	SEAL AND SEAT ASSEMBLY		1	1
52		20299	SEAL, WATER		1	1
53		20293	SNAP RING		1	1
54		20303	CAM, IMPELLER		1	1
55		20300	IMPELLER		1	1
56		20302	COVER GASKET		1	1
57		20308	COVER & BRG ASS'Y		1	1
58		20305	WASHER		4	4
59		20291	SCREW		4	4
					305	350
					RH	LH

FIGURE 9

