

254400 to 254499

SERVICE ENGINE  **SALES MANUAL**

**MODEL 254400 SERIES ENGINES REPLACED WITH
 STANDARD SERVICE ENGINES**

In most cases, the Original Type numbers shown may be replaced by a Service Type Number without making any changes. Necessary changes of engine parts such as crankshafts, reduction parts, blower housings, etc., are noted. Other differences, such as mufflers, elbows, deflectors, etc., are not listed but are very important for safety and engine performance. Be sure the exhaust system on the replacement engine duplicates the system originally selected by the equipment manufacturer. Parts that are suitable for additional use should be transferred. Before making any conversion, check the data shown in the column labeled "REMOVE, ADD and NOTE." See if the changes, which are shown, are actually necessary on the application in question. Often a standard service engine will be a WORKABLE replacement without converting to such things as a special fuel tank or starter position.

If the crankshaft number does not appear in the "Original Engine" column, consult the Illustrated Parts List for the correct service replacement crankshaft number.

Engine Replacement Notes:

- NOTE 6:** Drill and Retap end of Crankshaft 7/16"-20 (1" Deep). Use 25/64" Tap Drill.
- NOTE 15:** For all Go-Karts use only a Model 136200 series engine as a replacement, regardless of the original Model.
- NOTE 30:** If the replacement engine supersedes to or is a Model 200000 series engine, refer to the illustrations located after the conversion data for this model series. To make the crankshaft center line the same add 695154 spacer kit, other overall dimensions which differ, are shown in the illustrations. If after making a visual inspection and it is determined the Model 200000 series engine cannot be used because of equipment interference, the original engine should be repaired with a short block and/or individual parts.

Short Block Notes:

The SHORT BLOCK part number shown, is the assembly which can be used to rebuild the Original Type Number. If a letter appears after the short block number, it indicates the short block must be modified. The change denoted by each letter is as follows:

NOTE R: Cut off 1-7/16" on Flywheel end of Crankshaft.

254400 to 254499

Original Engine			Make From		Remove		Add		Note	Change to Type	Trim	RPM	Short Block	
Type	Model	Crank	Model	Type #	Qty	Part #	Qty	Part #					Part #	Notes
0015	254422	262080	205432	0036					15 30		All	3600		
0025	254427	262083	No Replacement Repair With Individual Parts.						15		01	3600		
0026	254427	262083	205437	0041					15 30		01	3600		
0027	254427	262083	205437	0041					15 30		All	3600		
0028	254427	399725	205437	0041					15 30		01	3600		
0050	254427	262083	No Replacement Repair With Individual Parts.						15		All	3700		
0070	254422	262081	205432	0038					15 30		All	3700	399022	
0111	254422	262080	205432	0036					15 30		01	3600		
0120	254422	262064	205432	0036					15 30		01	4000		
0121	254427	262080	205437	0041					15 30		01	4000		
0122	254422	262081	205432	0038					15 30		01	3750	399022	
0123	254422	262081	No Replacement Repair With Individual Parts.						15		01	3750	399022	
0124	254427	262083	No Replacement Repair With Individual Parts.						15		01 02	2700 4000		
0125	254427	262080	205437	0041					15 30		01	2700		
0126	254422	262080	205432	0036					15 30		01	3600		

254400 to 254499

Original Engine			Make From		Remove		Add		Note	Change to Type	Trim	RPM	Short Block	
Type	Model	Crank	Model	Type #	Qty	Part #	Qty	Part #					Part #	Notes
0127	254427	262080	205437	0041					15 30		01	3600		
0128	254422	262080	205432	0036					15 30		01	4000		
0129	254427	262080	205437	0041					15 30		01	4000		
0130	254427	399726	205437	0041					15 30		01	3600		
0131	254427	262080	205437	0041					15 30		01	4000		
0132	254421	262080	205432	0036					15 30		01	3600		
0133	254422	399728	205432	0038					15 30		All	3750	399022	
0134	254427	399728	205432	0038					15 30		01	3750	399022	
0135	254422	399728	205432	0038					15 30		01	3750	399022	
0136	254421	262080	205432	0036					15 30		01	3600		
0137	254422	262292	205432	0036					15 30		01	4000		
0138	254422	262080	205432	0036					15 30		01	3600		
0215	254422	399725	205432	0036					15 30		All	3600		
0216	254422	399725	205432	0036					15 30		All	3600		
0225	254427	399726	No Replacement Repair With Individual Parts.						15		All	3600		
0226	254427	399726	205437	0041					15 30		All	3600		
0227	254427	399725	205437	0041					15 30		All	3600		
0228	254427	399725	205437	0041					15 30		01	3600		
0229	254427	399728	205437	0041					15 30		01	3600		
0269	254422	399728	205432	0038					15 30		01	3700	399022	
0270	254422	399728	205432	0038					15 30		All	3700	399022	
0300	254422	399725	205432	0036					15 30		01	3600		
0308	254427	399726	No Replacement Repair With Individual Parts.						15		01	3600		
0310	254422	399728	205432	0038					15 30		01	3600	399022	
0311	254427	399728	No Replacement Repair With Individual Parts.						15		01	3750	399022	
0312	254422	399728	205432	0038					15 30		01	3150	399022	
0313	254422	399728	205432	0038					15 30		All	3100	399022	
0314	254427	399728	No Replacement Repair With Individual Parts.						15		01	3150	399022	
0315	254422	399725	205432	0036					15 30		01	3600		
0316	254426	399725	205437	0041					15 30		01	3200		
0317	254427	399726	No Replacement Repair With Individual Parts.						15		01	4000		
0318	254422	399728	No Replacement Repair With Individual Parts.						15		01	3700	399022	

254400 to 254499

Original Engine			Make From		Remove		Add		Note	Change to Type	Trim	RPM	Short Block	
Type	Model	Crank	Model	Type #	Qty	Part #	Qty	Part #					Part #	Notes
0319	254422	399725	205432	0036					15 30		01	3600		
0320	254422	262292	205432	0036					15 30		01	4000		
0321	254427	399725	205437	0041					15 30		01	4000		
0322	254427	399725	205437	0041					15 30		01	4000		
0323	254427	399725	205437	0041					15 30		01	3600		
0324	254427	399726	205437	0041					15 30		01	3600		
0325	254422	399728	205432	0038					15 30		All	3150	399022	
0326	254427	399725	205437	0041					15 30		01	3200		
0327	254427	399728	205432	0038					15 30		01	3750	399022	
0328	254422	399724	No Replacement Repair With Individual Parts.						15		01	4000		
0329	254425	399728	No Replacement Repair With Individual Parts.						15		01	3600		
0330	254427	399726	No Replacement Repair With Individual Parts.						15		01	3600		
0331	254422	399725	205432	0036					15 30		All	3600		
0332	254422	399728	205432	0038					15 30		01	3700	399022	
0333	254422	399728	205432	0038					15 30		01	3750	399022	
0334	254427	399728	No Replacement Repair With Individual Parts.						15		01	3600	399022	
0335	254422	399724	No Replacement Repair With Individual Parts.						15		01	4000		
0336	254427	262080	No Replacement Repair With Individual Parts.						15		01	3600		
0337	254427	262080	205437	0041					15 30		01	2700		
0338	254427	262080	205437	0041					15 30		01	3600		
0339	254427	262080	205437	0041					15 30		01	4000		
0340	254422	399728	No Replacement Repair With Individual Parts.						15		01	3750		
0341	254422	399728	205432	0038					15 30		01	3150	399022	
0342	254422	262080	205432	0036					15 30		01	3200		
0343	254422	262080	205432	0036					15 30		01	3600		
0344	254422	399728	No Replacement Repair With Individual Parts.						15		01	3750	399022	
0345	254422	399728	205432	0038					15 30		01	3150	399022	
0346	254422	262080	205432	0036					15 30		01	3600		
0347	254427	399728	No Replacement Repair With Individual Parts.						15		All	3750		
0348	254427	262064	No Replacement Repair With Individual Parts.						15		01	3600		
0349	254422	262064	No Replacement Repair With Individual Parts.						15		01	4000		
0350	254427	262080	205437	0041					15 30		01	3250		
0351	254427	399728	No Replacement Repair With Individual Parts.						15		01	3750	399022	R
0352	254422	399728	No Replacement Repair With Individual Parts.						15		01	3150	399022	
0353	254427	262080	No Replacement Repair With Individual Parts.						15		01	3600		
0354	254427	399728	No Replacement Repair With Individual Parts.						15		01	3700	399022	

254400 to 254499

Original Engine			Make From		Remove		Add		Note	Change to Type	Trim	RPM	Short Block	
Type	Model	Crank	Model	Type #	Qty	Part #	Qty	Part #					Part #	Notes
0355	254422	399728	205432	0038					15 30		01	3100	399022	
0356	254427	399728	No Replacement Repair With Individual Parts.						15		01	3700		
0357	254427	399728	No Replacement Repair With Individual Parts.						15		01	3700	399022	
0358	254422	399728	205432	0038					15 30		01	3700	399022	
0359	254427	399728	No Replacement Repair With Individual Parts.						15		01	3700	399022	
0360	254422	399728	No Replacement Repair With Individual Parts.						15		01	3150	399022	
0361	254422	399728	205432	0038					15 30		01	3150	399022	
0362	254427	399725	205437	0041					15 30		01	2900		
0363	254427	399728	No Replacement Repair With Individual Parts.						15		01	3150	399022	
0364	254422	399725	205432	0036					15 30		01	3900		
0365	254427	399726	205437	0041					15 30		01	3200		
0368	254422	399728	No Replacement Repair With Individual Parts.						15		01	3700		
0369	254427	399728	No Replacement Repair With Individual Parts.						15		01	3700		
0505	254422	399728	205432	0038					15 30		01	3750	399022	
0506	254422	399725	205432	0036					15 30		01	3600		
0507	254427	399725	No Replacement Repair With Individual Parts.						15		01	3600		
0508	254422	262292	No Replacement Repair With Individual Parts.						15		01	4000		
0509	254427	399725	205437	0041					15 30		01	4000		
0510	254427	399728	No Replacement Repair With Individual Parts.						15		01	3750	399022	
0511	254425	399728	No Replacement Repair With Individual Parts.						15		01	3600	399022	
0512	254422	399724	205432	0036					6 15 30		01	4000		
0513	254427	399725	205437	0041					15 30		01	4000		
0514	254422	399728	205432	0038					15 30		01	3150	399022	
0516	254427	399725	205437	0041					15 30		01	3600		
0517	254422	399724	205432	0036					6 15 30		01	4000		
0518	254427	399725	No Replacement Repair With Individual Parts.						15		01	3600		
0519	254427	399728	No Replacement Repair With Individual Parts.						15		01	3700	399022	
0520	254427	399728	No Replacement Repair With Individual Parts.						15		01	3700	399022	
0521	254422	399728	205432	0038					15 30		01	3700	399022	
0522	254427	399728	No Replacement Repair With Individual Parts.						15		01	3700	399022	
0523	254422	399728	No Replacement Repair With Individual Parts.						15		01	3750		
0524	254427	399728	No Replacement Repair With Individual Parts.						15		01	3750		
0525	254427	399725	205437	0041					15 30		01	3600	399022	
0526	254422	399724	205432	0036					6 15 30		01	4000		
0527	254422	399725	205432	0036					15 30		01	3600		
0528	254422	399728	No Replacement Repair With Individual Parts.						15		01	3750		
0529	254427	399728	No Replacement Repair With Individual Parts.						15		01	3750		

254400 to 254499

Original Engine			Make From		Remove		Add		Note	Change to Type	Trim	RPM	Short Block	
Type	Model	Crank	Model	Type #	Qty	Part #	Qty	Part #					Part #	Notes
0530	254422	399728	No Replacement Repair With Individual Parts.						15		01	3150	399022	
0531	254426	399725	205437	0041					15		01	3200		
									30					
0532	254422	399724	205432	0036					6		01	4000		
									15					
									30					
0534	254427	399728	No Replacement Repair With Individual Parts.						15		01	3750	399022	
0535	254422	399724	205432	0036					6		01	4000		
									15					
									30					
0536	254422	399725	205432	0036					15		All	2900		
									30					
0537	254422	399728	No Replacement Repair With Individual Parts.						15		All	3150	399022	
0538	254422	399725	205432	0036					15		01	4000		
									30					
0539	254422	399728	205432	0038					15		01	3750	399022	
									30					
0540	254422	399728	205432	0038					15		01	3100	399022	
									30					
0541	254422	399728	205432	0038					15		01	3750	399022	
									30					
0542	254427	399728	No Replacement Repair With Individual Parts.						15		01	3750	399022	
0543	254426	399725	No Replacement Repair With Individual Parts.						15		01	3600		
0544	254412	399728	205432	0038					15		01	3750	399022	
									30					
0545	254417	399728	No Replacement Repair With Individual Parts.						15		01	3750	399022	
0546	254427	399725	No Replacement Repair With Individual Parts.						15		01	3750		
0547	254426	399725	No Replacement Repair With Individual Parts.						15		01	3600		
0548	254427	493729	No Replacement Repair With Individual Parts.						15		01	3800		
0549	254412	491645	No Replacement Repair With Individual Parts.						15		01	3750		
0550	254415	491645	No Replacement Repair With Individual Parts.						15		01	3750		
0551	254427	491645	No Replacement Repair With Individual Parts.						15		01	3750		
0552	254427	399725	No Replacement Repair With Individual Parts.						15		01	3600		
0553	254427	491645	No Replacement Repair With Individual Parts.						15		01	3700	399022	
0554	254427	399725	205437	0041					15		01	3600		
									30					
0555	254422	399725	205432	0036					15		01	3600		
									30					
0556	254412	399728	No Replacement Repair With Individual Parts.						15		01	3750	399022	
0557	254417	399728	No Replacement Repair With Individual Parts.						15		01	3750	399022	
0558	254422	399728	No Replacement Repair With Individual Parts.						15		01	3750		
0559	254427	399728	No Replacement Repair With Individual Parts.						15		01	3750		
0560	254427	399728	No Replacement Repair With Individual Parts.						15		01	3700		
0561	254427	399728	No Replacement Repair With Individual Parts.						15		01	3750		
0562	254422	399728	205432	0038					15		01	3150	399022	
									30					
0563	254412	399728	205432	0038					15		01	3750	399022	
									30					
0564	254422	399728	No Replacement Repair With Individual Parts.						15		01	3750		
0565	254422	399728	No Replacement Repair With Individual Parts.						15		01	3800	399022	
0566	254427	399728	No Replacement Repair With Individual Parts.						15		01	3750		
0567	254422	399728	No Replacement Repair With Individual Parts.						15		01	3750		
0568	254422	399728	No Replacement Repair With Individual Parts.						15		01	3150	399022	
0569	254427	399725	No Replacement Repair With Individual Parts.						15		01	3600		
0570	254427	399728	No Replacement Repair With Individual Parts.						15		01	3750	399022	
0571	254427	399725	No Replacement Repair With Individual Parts.						15		01	3400		
0572	254422	399728	No Replacement Repair With Individual Parts.						15		01	3800	399022	

254400 to 254499

Original Engine			Make From		Remove		Add		Note	Change to Type	Trim	RPM	Short Block	
Type	Model	Crank	Model	Type #	Qty	Part #	Qty	Part #					Part #	Notes
0573	254422	399725	205432	0036					15 30		01	4000		
0574	254422	399725	205432	0036					15 30		01	3750		
0575	254427	399728	No Replacement Repair With Individual Parts.						15		01	3750	399022	
0576	254412	399728	No Replacement Repair With Individual Parts.						15		All	3750		
0577	254416	399728	No Replacement Repair With Individual Parts.						15		01	3750		
0578	254412	399728	No Replacement Repair With Individual Parts.						15		01	3750		
1508	254422	399727	No Replacement Repair With Individual Parts.						15		All	4000		
1512	254422	399723	205432	0036					6 15 30		01	3700		
1526	254422	399723	205432	0036					6 15 30		01	4000		
1549	254412	491645	No Replacement Repair With Individual Parts.						15		01	3750		
1550	254415	491645	No Replacement Repair With Individual Parts.						15		01	3750		
1558	254422	491645	No Replacement Repair With Individual Parts.						15		01	3750		
1559	254427	491645	No Replacement Repair With Individual Parts.						15		01	3750		
1560	254427	491645	No Replacement Repair With Individual Parts.						15		02	3750		
1563	254412	491645	205432	0038					15 30		01	3750	399022	
1571	254427	399725	205437	0041					15 30		01	3400		
1572	254422	491645	No Replacement Repair With Individual Parts.						15		01	3800	399022	
1573	254422	399723	205432	0036					15 30		01	4000		
1575	254427	491645	No Replacement Repair With Individual Parts.						15		01	3000	399022	
1576	254412	491645	No Replacement Repair With Individual Parts.						15		01	3750		
1578	254412	491645	No Replacement Repair With Individual Parts.						15		01	3750		
4002	254422	399728	205432	0038					15 30		01	3800	399022	
4003	254422	399728	No Replacement Repair With Individual Parts.						15		01	3800	399022	
4004	254422	399728	No Replacement Repair With Individual Parts.						15		01 02 03 04	3800 3150 3150 3800	399022	
4005	254422	493729	No Replacement Repair With Individual Parts.						15		01	3600		
4006	254427	399728	No Replacement Repair With Individual Parts.						15		All	3800	399022	
4007	254427	399728	No Replacement Repair With Individual Parts.						15		All	3800	399022	
4010	254427	399728	No Replacement Repair With Individual Parts.						15		01 02 03 04	3800 3150 3800 3800	399022	
4012	254427	399725	205437	0041					15 30		All	4000		
4013	254427	399725	205437	0041					15 30		All	3200		
4014	254422	399725	205432	0036					15 30		All	3600		
4015	254422	399725	205432	0036					15 30		All	3600		
4016	254427	399725	205437	0041					15 30		01	3600		
4017	254427	399725	No Replacement Repair With Individual Parts.						15		All	3600		
4018	254427	399725	No Replacement Repair With Individual Parts.						15		01	3600		
4019	254427	399725	No Replacement Repair With Individual Parts.						15		All	3600		
4022	254422	399725	No Replacement Repair With Individual Parts.						15		01	3600		

254400 to 254499

Original Engine			Make From		Remove		Add		Note	Change to Type	Trim	RPM	Short Block	
Type	Model	Crank	Model	Type #	Qty	Part #	Qty	Part #					Part #	Notes
4023	254422	399728	No Replacement Repair With Individual Parts.						15		01	3150	399022	
4024	254427	399725	205437	0041					15		01	3600		
									30					
4025	254427	399725	No Replacement Repair With Individual Parts.						15		01	3600		
4026	254422	399728	205432	0038					15		All	3150	399022	
									30					
4027	254427	399725	205437	0041					15		All	3600		
									30					
4028	254427	399725	205437	0041					15		All	3600		
									30					
4029	254422	399724	205432	0036					6		01	3600		
									15					
									30					
4030	254422	399724	205432	0036					6		All	3600		
									15					
									30					
4031	254422	399725	205432	0036					15		01	3600		
									30					
4032	254427	399728	No Replacement Repair With Individual Parts.						15		01	3750		
4033	254427	399728	No Replacement Repair With Individual Parts.						15		All	3150	399022	
4034	254427	399728	No Replacement Repair With Individual Parts.						15		All	3150	399022	
4035	254427	399728	No Replacement Repair With Individual Parts.						15		01	3150	399022	
4036	254427	399725	205437	0041					15		01	4000		
									30					
4044	254422	399724	205432	0036					15		All	3750		
									30					
4045	254422	399724	205432	0036					15		All	3600		
									30					
4047	254427	399728	No Replacement Repair With Individual Parts.						15		01	3800		
4050	254427	399724	No Replacement Repair With Individual Parts.						15		01	3700		
4055	254422	399725	205432	0036					15		01	3600		
									30					
4070	254422	399728	205432	0038					15		01	3750	399022	
									30		01	3750		
											02	3150		
											04	3150		
											05	3150		
											06	3150		
											07	3150		
											08	3150		
											09	3150		
											10	3150		
4071	254422	399728	No Replacement Repair With Individual Parts.						15		01	3150	399022	
4072	254422	399728	205432	0038					15		01	3150	399022	
									30					
4090	254422	399725	205432	0036					15		01	3600		
									30					
5004	254422	399728	No Replacement Repair With Individual Parts.						15		All	3800		
5006	254427	399728	No Replacement Repair With Individual Parts.						15		01	3800	399022	
5007	254427	399728	No Replacement Repair With Individual Parts.						15		01	3800		
5012	254427	399728	205437	0041					15		01	4000		
									30					
5013	254427	399728	205437	0041					15		01	3200		
									30					
5014	254422	399725	205432	0036					15		All	3600		
									30					
5015	254422	399725	205432	0036					15		All	3600		
									30					

254400 to 254499

Original Engine			Make From		Remove		Add		Note	Change to Type	Trim	RPM	Short Block	
Type	Model	Crank	Model	Type #	Qty	Part #	Qty	Part #					Part #	Notes
5017	254427	399725	No Replacement Repair With Individual Parts.						15		01	3600		
5019	254427	399725	205437	0041					15		01	3600		
									30					
5024	254427	399725	205437	0041					15		01	3600		
									30					
5025	254427	399725	No Replacement Repair With Individual Parts.						15		01	3600		
5027	254427	399725	205437	0041					15		All	3600		
									30					
5028	254427	399725	205437	0041					15		All	3600		
									30					
5034	254427	399728	No Replacement Repair With Individual Parts.						15		01	3150	399022	
5035	254427	399728	No Replacement Repair With Individual Parts.						15		01	3150	399022	
5036	254427	399725	205437	0041					15		01	4000		
									30					
5044	254422	399725	205432	0036					15		01	3750		
									30					
5045	254422	399725	205432	0036					15		02	3600		
									30					
5070	254422	399728	205432	0038					15		All	3750	399022	
									30					
5075	254427	399728	No Replacement Repair With Individual Parts.						15		01	3750	399022	