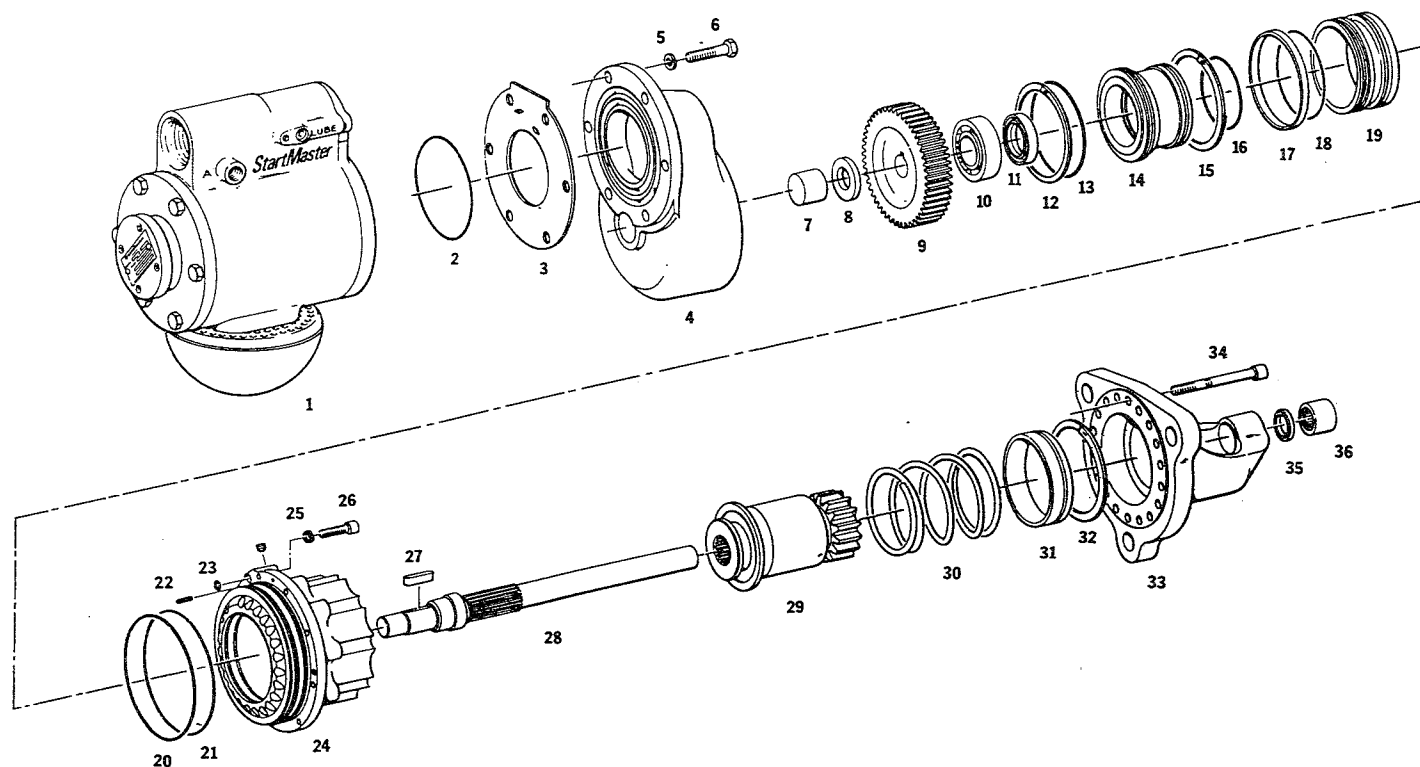


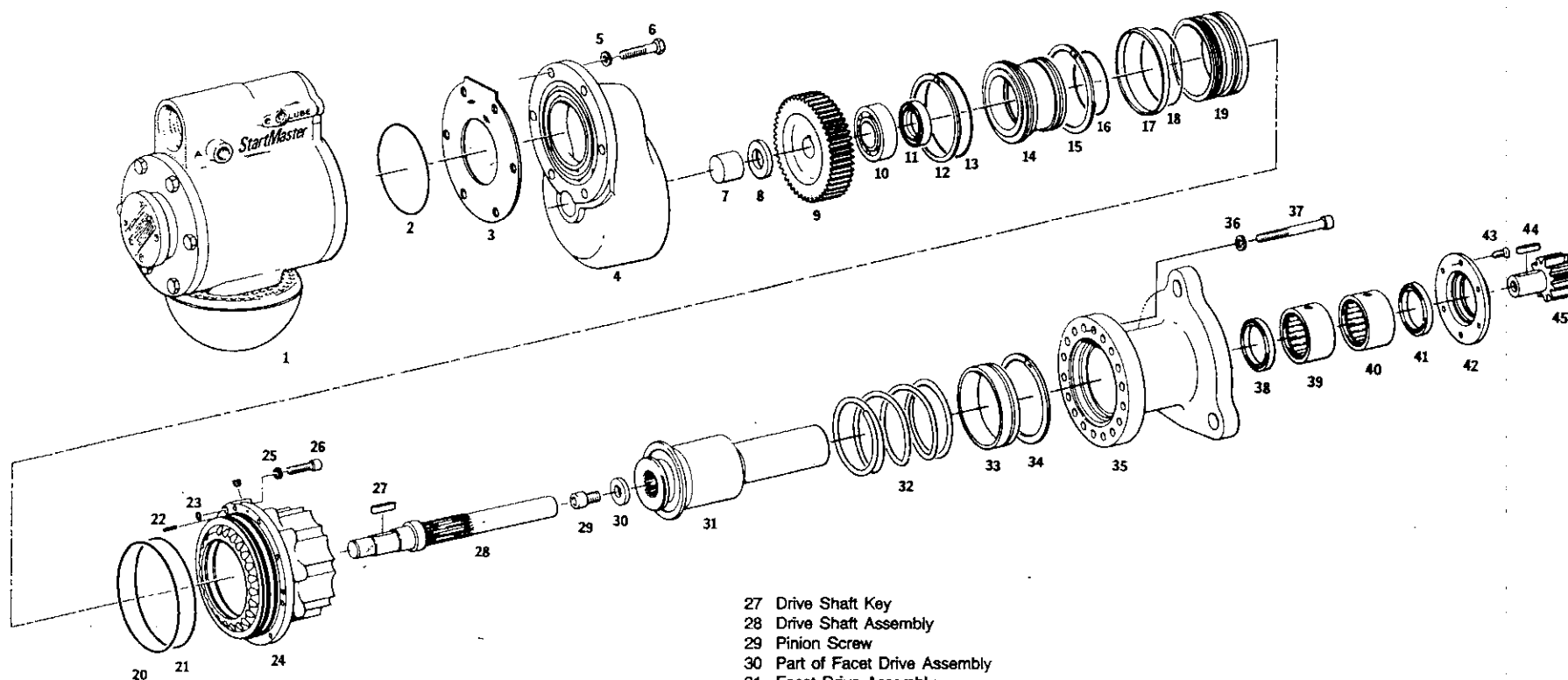
# SM 250

tem	Description	Qty	Fold Out #	Pos #
<b>5-25001</b>	<b>OVERHAUL KIT - SM250 AIR/GAS CONV/LBLESS/inertia</b>			
5-22538	SEAL SUPPORT ASSY	1	4	3 & 5
5-19459	O-RING - 5.00"ID X .070"W (-049)	2	4	29
5-20023	O-RING - 1/4"ID X .070"W (-010)PKG 23530	1	4	11
5-20027	O-RING - 1.75"ID X .070"W (-031)	1	4	24
5-20037	O-RING - 2.62"ID X .070"W (-038) (Seal, Exhaust Adapter Not Shown)	1	N/S	N/S
5-20773	O-RING - 4.00"ID X .070"W (-045)	2	1,2,3	20,21
5-21555	SEAL - SEQ PISTON	1	4	6
5-21563	SEAL - PISTON ACTUATOR	1	1,2,3	17
5-21569	O-RING - 2.88"ID X .070"W(-040)PKG 23548	1	1,2,3	13
5-21570	O-RING - 2.25"ID X .139"W(-228)PKG 23549	1	1,2,3	16
5-21571	O-RING - 2.75"ID X .103"W(-148)PKG 23550 (Fits under item 17)	1	1,2,3	17
5-21572	O-RING - 2.38"ID X .139"W(-229)PKG 23551	1	4	33
5-21573	O-RING - 3.25"ID X .070"W(-042)PKG 23552	1	1,2,3	2
5-21574	O-RING - 1.25"ID X .103"W(-124)PKG 23553 (Gas Only Models not shown)	1	N/S	N/S
5-21575	O-RING - 1.31"ID X .103"W(-125)PKG 23554	1	4	4
5-21576	O-RING - 1.38"ID X .139"W(-220)PKG 23555	1	4	14
5-21577	O-RING - .81"ID X .139"W(-211)PKG 23556	1	4	2
5-21586	ACTUATOR PISTON BEARING GUIDE (SM-250 (Wood Ring)	1	1,2,3	N/S
5-22118	O-RING GAUGE/INST A-B0 (Oring Identifier Guide Sheet)	0	N/A	N/A
5-22318	GEAR CASE GASKET B-B6000	1	1,2,3	3
		1	1,2,3	23
5-22616	O-RING - 7/32"ID X .070"W (-009)	2	4	36
5-22680	O-RING - .50"ID X .070"W (-014)	1	4	10
5-22682	O-RING - 1.50"ID X .070"W (-029)	1	4	15
5-23275	ROTOR BLADE - 250/500	5	4	31
5-22521	AIRFOIL SM-250	1	4	1
5-22522	AIRFOIL SEAL RETAINER SM-250	1	4	1
5-19129	THRUST WASHER	1	1,2,3	8
5-19134	SEAL - DRIVE SHAFT	1	1,2,3	11
5-19348	NEEDLE BEARING	2	1	36
5-21282	BALL BEARING	2	4	25
5-21553	BALL BEARING	1	1,2,3	10
5-19349	SEAL - DRIVE SHAFT /ST	1	1	35
5-20035	SEAL WASHER - 1/4"ID (Washer Exhaust Adapter)	1	N/S	N/S
5-20036	SEAL WASHER - 5/16"ID (Special Seal Washers used on Gas Models Only)	12	N/S	N/S
5-21840	O-RING - 2.88"ID X .103"W (-150)	1	1,2,3	18
5-19132	KEY	1	1,2,3	27

- 1 Air Motor Assembly (See Fold out #4)
- 2 Lower End Plate Seal
- 3 Gear Case Gasket
- 4 Gear Case
- 5 Gear Case Lockwasher (Seal Washer for Nat. Gas Models)
- 6 Gear Case Screw
- 7 Gear Case Bearing
- 8 Thrust Washer
- 9 Drive Shaft Gear
- 10 Drive Shaft Bearing
- 11 Drive Shaft Seal
- 12 Retaining Ring
- 13 Drive Housing Seal
- 14 Bearing Retainer
- 15 Retaining Ring
- 16 Bearing Retainer Seal
- 17 Actuator Piston Ring
- 18 Actuator Piston Seal
- 19 Actuator Piston
- 20 Drive Housing Seal
- 21 Drive Housing Seal
- 22 Gear Case Pin
- 23 Drive Housing Seal
- 24 Drive Housing
- 25 Drive Housing Lockwasher
- 26 Drive Housing Screw
- 27 Drive Shaft Key
- 28 Drive Shaft Assembly
- 29 Facet Drive Assembly
- 30 Drive Return Spring
- 31 Drive Housing Bushing
- 32 Retaining Ring
- 33 Drive Housing Adapter
- 34 Drive Housing Adapter Screw
- 35 Drive Shaft Seal
- 36 Drive Housing Adapter Bearing



**STARTMASTER 250 DRIVE ASSEMBLY**  
**FOLD-OUT NO. 1**  
**Section VIII**



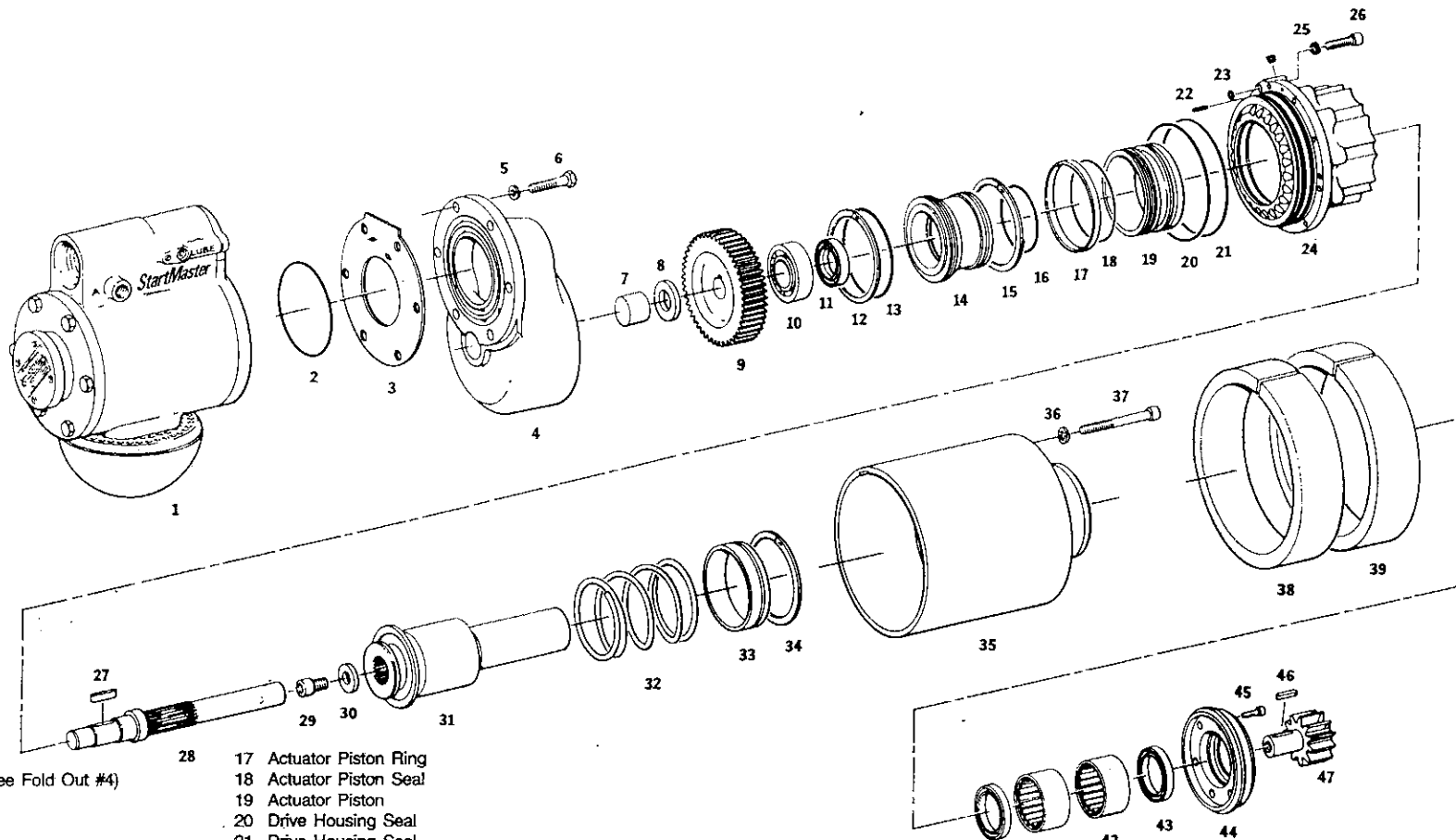
- 1 Air Motor Assembly (See Fold Out #4)
- 2 Lower End Plate Seal
- 3 Gear Case Gasket
- 4 Gear Case
- 5 Gear Case Lockwasher (Seal Washer for Nat. Gas Models)
- 6 Gear Case Screw
- 7 Gear Case Bearing
- 8 Thrust Washer
- 9 Drive Shaft Gear
- 10 Drive Shaft Bearing
- 11 Drive Shaft Seal
- 12 Retaining Ring

- 13 Drive Housing Seal
- 14 Bearing Retainer
- 15 Retaining Ring
- 16 Bearing Retainer Seal
- 17 Actuator Piston Ring
- 18 Actuator Piston Seal
- 19 Actuator Piston
- 20 Drive Housing Seal
- 21 Drive Housing Seal
- 22 Gear Case Pin
- 23 Drive Housing Seal
- 24 Drive Housing
- 25 Drive Housing Lockwasher
- 26 Drive Housing Screw

- 27 Drive Shaft Key
- 28 Drive Shaft Assembly
- 29 Pinion Screw
- 30 Part of Facet Drive Assembly
- 31 Facet Drive Assembly
- 32 Drive Return Spring
- 33 Drive Housing Bushing
- 34 Retaining Ring
- 35 Drive Housing Adapter Assembly
- 36 Housing Adapter Lockwasher
- 37 Drive Housing Adapter Screw
- 38 Facet Drive Assembly Seal
- 39 Facet Drive Bearing
- 40 Facet Drive Bearing
- 41 Facet Drive Assembly Seal
- 42 Bearing Cover
- 43 Bearing Cover Screw
- 44 Drive Pinion Key
- 45 Drive Pinion

**STARTMASTER 251 DRIVE ASSEMBLY  
FOLD-OUT NO. 2**

Section VIII



- 1 Air Motor Assembly (See Fold Out #4)
- 2 Lower End Plate Seal
- 3 Gear Case Gasket
- 4 Gear Case
- 5 Gear Case Lockwasher (Seal Washer for Nat. Gas Models)
- 6 Gear Case Screw
- 7 Gear Case Bearing
- 8 Thrust Washer
- 9 Drive Shaft Gear
- 10 Drive Shaft Bearing
- 11 Drive Shaft Seal
- 12 Retaining Ring
- 13 Drive Housing Seal
- 14 Bearing Retainer
- 15 Retaining Ring
- 16 Bearing Retainer Seal

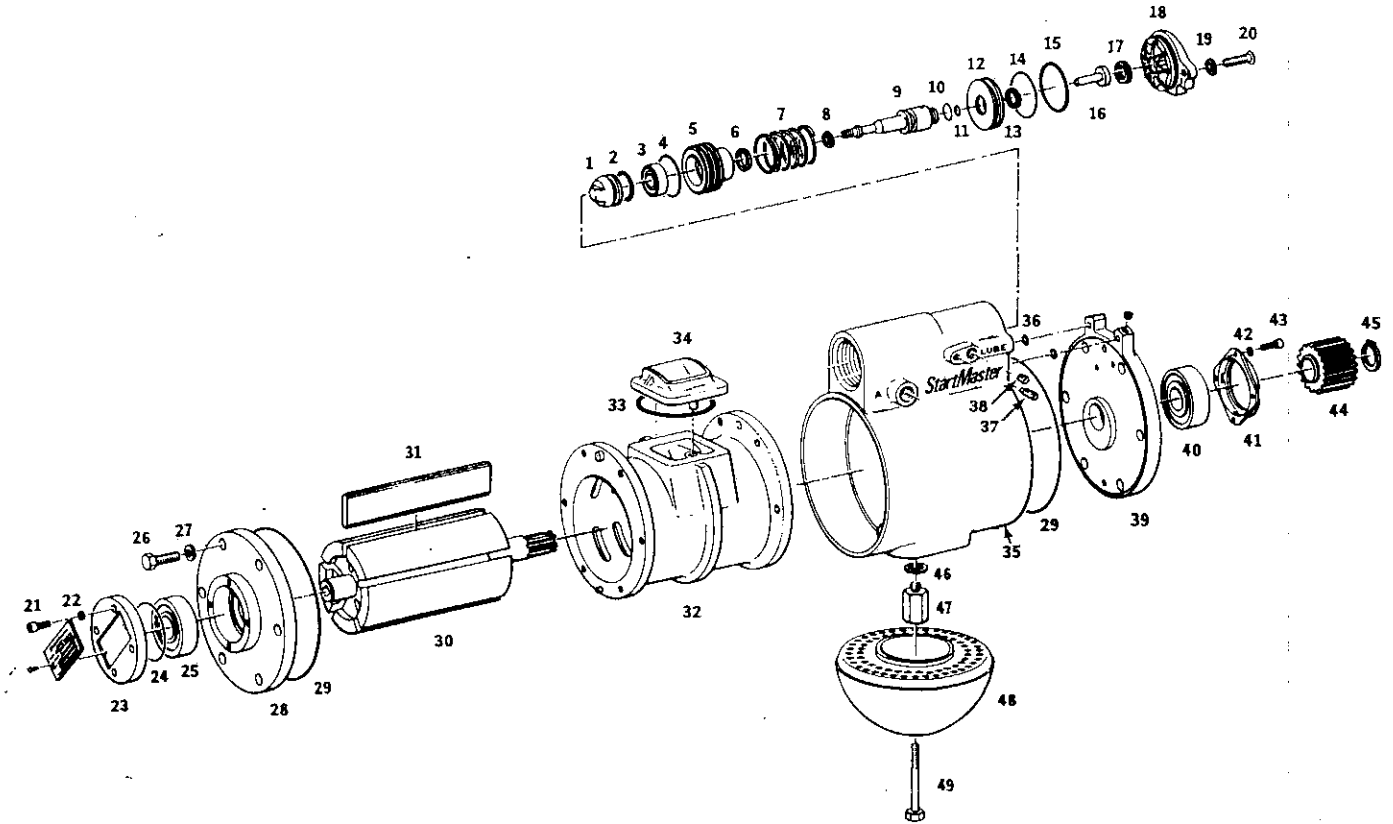
- 17 Actuator Piston Ring
- 18 Actuator Piston Seal
- 19 Actuator Piston
- 20 Drive Housing Seal
- 21 Drive Housing Seal
- 22 Gear Case Pin
- 23 Drive Housing Seal
- 24 Drive Housing
- 25 Drive Housing Lockwasher
- 26 Drive Housing Screw
- 27 Drive Shaft Key
- 28 Drive Shaft Assembly
- 29 Pinion Screw
- 30 Part of Facet Drive Assembly
- 31 Facet Drive Assembly
- 32 Drive Return Spring
- 33 Drive Housing Bushing
- 34 Retaining Ring

- 35 Drive Housing Adapter Assembly
- 36 Housing Adapter Lockwasher
- 37 Drive Housing Adapter Screw
- 38 Saddle Spacer
- 39 Saddle Spacer
- 40 Facet Drive Assembly Seal
- 41 Facet Drive Bearing
- 42 Facet Drive Bearing
- 43 Facet Drive Assembly Seal
- 44 Bearing Cover
- 45 Bearing Cover Screw
- 46 Drive Pinion Key
- 47 Drive Pinion

# STARTMASTER 2514 DRIVE ASSEMBLY FOLD-OUT NO. 3

Section VIII

- 1 Sequencing Valve Airfoil
- 2 Airfoil Seal
- 3 Part of Item #5
- 4 Seal Support Seal
- 5 Seal Support Assembly
- 6 Piston Seal
- 7 Sequencing Valve Spring
- 8 Airfoil Lockwasher
- 9 Sequencing Valve Piston
- 10 Piston Seal
- 11 Piston Seal
- 12 Piston Ring
- 13 Retaining Ring
- 14 Piston Seal
- 15 Sequencing Stop Seal
- 16 Dampening Plunger
- 17 Retaining Ring
- 18 Sequencing Stop
- 19 Sequencing Stop Lockwasher
- 20 Sequencing Stop Screw
- 21 Bearing Retainer Screw
- 22 Bearing Retainer Lockwasher
- 23 Bearing Cover
- 24 Bearing Cover Seal
- 25 End Plate Bearing
- 26 End Plate Screw
- 27 End Plate Lockwasher (Seal Washer for Nat. Gas Models)
- 28 Upper End Plate
- 29 End Plate Seal
- 30 Rotor Assembly
- 31 Rotor Blade
- 32 Air Motor Sleeve Assembly
- 33 Sleeve Adapter Seal
- 34 Sleeve Adapter
- 35 Air Motor Casing
- 36 End Plate Seal
- 37 Seal Support Screws
- 38 Pipe Plug
- 39 Lower End Plate
- 40 End Plate Bearing
- 41 Bearing Retainer
- 42 Bearing Retainer Lockwasher
- 43 Bearing Retainer Screw
- 44 Rotor Pinion
- 45 Pinion Retainer
- 46 Sleeve Lockwasher
- 47 Muffler Retaining Assembly
- 48 Air Starter Muffler (Exhaust Adapter for Nat. Gas Models)
- 49 Muffler Screw



**STARTMASTER SERIES 250 AIR MOTOR  
FOLD-OUT NO. 4**

Section VIII