

ENGINE

GROUP PART NAME and DESCRIPTION	PART NUMBER	MODELS	P E A R
1.000 - ENGINE			
NOTE 1: For Hydra-Matic parts see Hydra-Matic Parts List.			
NOTE 2: To install these Engines on cars equipped with Supercharger, the Vibration Damper must be changed to conform.			
Engine (less Accessories and Manifolds, with Clutch and Housing)(7.3 Head)(Standard and Overdrive).....	215950	542 545	1
Engine (less Accessories and Manifolds, with Clutch and Housing)(6.86 Head Export)(Standard and Overdrive)...	215951	542 545	1
Flatwasher, 1/2" Sm.....	GM-120396	542 545	2
Locknut, 1/2"-20 Hx.....	GM-451019	542 545	2
Gasket Set, Engine Overhaul.....	208592	542 545	1
Consists of:			
1 - 200062 Gasket, Cylinder Head			
1 - 200128 Gasket, Timing Chain Cover			
1 - 200143 Gasket, Valve Tappet Cover			
1 - 200253 Gasket, Oil Pump			
2 - 200267 Gasket, Oil Pan End			
1 - 200269 Gasket, Oil Pan Drain Plug			
2 - 207186 Gasket, Oil Pan Side			
1 - 200279 Gasket, Intake and Exhaust Manifold			
1 - 201852 Gasket, Exhaust Manifold to Exhaust Pipe			
1 - 203376 Gasket, Exhaust to Intake Manifold (1951-1952)			
1 - 214121 Gasket, Exhaust to Intake Manifold (1953-1954)			
1 - 200283 Gasket, Fuel Pump to Block			
1 - 203355 Gasket, Carburetor to Intake Manifold			
1 - 200336 Gasket, Water Outlet Elbow			
1 - 207433 Gasket, Water Pump to Block			
1 - 203890 Gasket, Cylinder Block Front End Plate			
3 - 202145 Gasket, Valve Tappet Cover Nut			
1 - 202146 Gasket, Oil Pressure Relief Valve Plug			
2 - 204654 Oil Seal, Crankshaft Rear			
1.010 - ENGINE SUPPORT INSULATOR - FRONT			
Insulator.....	213100	542 545	2
Bolt, 5/16"-24 x 1" Hx. Hd.....	GM-121661	542 545	1
Bolt, 5/16"-24 x 3/4" Hx. Hd.....	GM-120741	542 545	3
Lockwasher, 5/16" Int. Ext. Tooth.....	GM-178532	542 545	4
Locknut, 5/16"-24 Hx.....	GM-451007	542 545	4
1.020 - ENGINE SUPPORT INSULATOR - REAR			
Insulator.....	207407	542 545	1
Bolt, 3/8"-24 x 1 1/16" Hx. Hd.....	GM-123512	542 545	2
Locknut, 3/8"-24 Hx.....	GM-451011	542 545	2

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1.020 - ENGINE SUPPORT INSULATOR - REAR (CONT'D.)			
Bolt, 3/8"-16 x 3/4" Hx. Hd.....	GM-122119	542 545	2
Lockwasher, 3/8" Ext. Tooth.....	GM-138489	542 545	2
1.100 - CYLINDER BLOCK			
Block (incl. Pistons, Rings, Pins, Main and Camshaft Bearings) (Maroon Paint).....	215036	542 545	1
Plug, Camshaft Rear Expansion, 1 1/2" Dia.....	GM-103896	542 545	1
Plug, Water Jacket (Cup Type) 1 5/8" Dia.....	207145	542 545	6
Plug, Oil Header Pipe, 1/4" Ct'sk.....	200052	542 545	2
Draincock, Water Jacket.....	GM-103647	542 545	1
1.105 - CYLINDER BLOCK END PLATE - FRONT			
Plate.....	213395	542 545	1
Gasket.....	203890	542 545	1
Bolt, 7/16"-14 x 1" Hx. Hd.....	203878	542 545	1
Lockwasher, 7/16" Hy.....	GM-120383	542 545	1
Bolt, 5/16"-18 x 7/8" Hx. Hd.....	GM-120229	542 545	1
Bolt, 5/16"-18 x 7/8" Hx. Soc.....	200091	542 545	1
Bolt, 5/16"-18 x 3/4" Hx. Hd.....	GM-122007	542 545	1
Lockwasher, 5/16" Hy.....	GM-120638	542 545	3
1.200 - CYLINDER HEAD			
Head (7.3 to 1 Compression Ratio).....	213870	# 545	1
Head (6.86 to 1 Compression Ratio) (Export only).....	216097	542 ## 545	1
Head (7.3 to 1 Compression Ratio).....	216098	542 545	1
Bolt, 3/8"-16 x 2 7/8" Hx. Hd. (less Supercharger)...	207354	542 545	33
Bolt, 3/8"-16 x 2 7/8" Hx. Hd. with	209354	542 545	29
Bolt, 3/8"-16 x 3 1/4" Hx. Hd. Supercharger	215709	542 545	4
Bracket (to Heater Tube Clip).....	216082	542 545	1
Flatwasher, 13/32" x 3/4".....	200059	542 545	31
Flatwasher, 25/64" x 5/8".....	200060	542 545	1
Gasket.....	200062	542 545	1
Gasket (Steelbestos).....	214125	542 545	1
1.300 - CRANKSHAFT			
Crankshaft (incl. Bushing).....	207146	542 545	1
Bushing, Pilot.....	200064	542 545	1
Slinger.....	200069	542 545	1
1.303 - CRANKSHAFT OIL SEAL			
Seal (in Timing Chain Cover).....	200129	542 545	1

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GROUP PART NAME and DESCRIPTION	PART NUMBER	MODELS	P E A R
1.315 - CRANKSHAFT MAIN BEARING			
Bearing, No. 1 Std.....	202686	542 545	1
Bearing, No. 2 and 3 Std.....	200071	542 545	2
Bearing, No. 4 Std.....	207242	542 545	1
Bearing, No. 1 .001 Undersize.....	204851	542 545	*
Bearing, No. 2 and 3 .001 Undersize.....	204852	542 545	*
Bearing, No. 4 .001 Undersize.....	207243	542 545	*
Bearing, No. 1 .002 Undersize.....	202687	542 545	*
Bearing, No. 2 and 3 .002 Undersize.....	201929	542 545	*
Bearing, No. 4 .002 Undersize.....	207244	542 545	*
Bearing, No. 1 .010 Undersize.....	202691	542 545	*
Bearing, No. 2 and 3 .010 Undersize.....	200338	542 545	*
Bearing, No. 4 .010 Undersize.....	207245	542 545	*
NOTE: Engines with Engine Numbers followed by the letter "A" have .010" Undersize Main Bearings.			
Bearing, No. 1 .012 Undersize.....	202309	542 545	*
Bearing, No. 2 and 3 .012 Undersize.....	202310	542 545	*
Bearing, No. 4 .012 Undersize.....	207246	542 545	*
Bearing, No. 1 .020 Undersize.....	213264	542 545	*
Bearing, No. 2 and 3 .020 Undersize.....	200341	542 545	*
Bearing, No. 4 .020 Undersize.....	213265	542 545	*
1.320 - CRANKSHAFT MAIN BEARING CAPS			
Dowel, 3/16" Dia. (Front Cap).....	202690	542 545	2
Dowel Pin, 5/16" Dia.....	200077	542 545	5
Dowel Ring, No. 3 Cap.....	200078	542 545	1
Bolt, 1/2"-13 x 2 1/2" Hx. Hd. (No. 1, 2 and 4 Caps).	215025	542 545	6
Bolt, 1/2"-13 x 3 1/4" Hx. Hd. (No. 3 Caps).....	215026	542 545	2
1.325 - CRANKSHAFT BEARING FILLER BLOCK - FRONT			
Block (incl. Gasket).....	207181	542 545	1
Bolt, 5/16"-18 x 3/4" Hx. Hd. [] to []	GM-122007	542 545	2
Lockwasher, 5/16" Med. [] Block []	GM-120214	542 545	2
Bolt, 5/16"-18 x 7/8" Hx. Soc. [] to Front []	200091	542 545	1
Lockwasher, 5/16" Med. [] End Plate []	GM-120214	542 545	1
1.326 - CRANKSHAFT BEARING FILLER BLOCK - REAR			
Block (incl. Gaskets).....	207147	542 545	1
Bolt, 5/16"-18 x 1" Hx. Hd.....	GM-122017	542 545	2
Lockwasher, 5/16" Med.....	GM-120214	542 545	2
Oil Seal.....	204654	542 545	2
Guard (incl. Seal).....	207148	542 545	1

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GROUP PART NAME and DESCRIPTION	PART NUMBER	MODELS	P E A R
1.330 - VIBRATION DAMPER			
Damper (incl. Water Pump Pulley).....	207409	542 545	1
Damper (incl. Water Pump Pulley)(use with Supercharger)	216078	542 ## 545	1
Bolt, 3/4"-16 x 1 1/2" Hx. Hd.....	GM-100088	542 545	1
Flatwasher (1.692" O.D. x 7/8" I.D. x .034" Thick with Keyway).....	216080	542 545	1
Lock (use with Slotted Flatwasher).....	216081	542 545	1
Key, 1/4" x 1".....	GM-113782	542 545	1
Pulley (use with Supercharger).....	216079	542 ## 545	1
Bolt, 7/16"-20 x 1 1/16" Hx. Hd.....	GM-123545	542 ## 545	4
Lockwasher, 7/16" Hy.....	GM-120383	542 ## 545	4
1.360 - FLYWHEEL			
Flywheel (incl. Ring Gear).....	207149	542 545	1
Bolt, 3/8"-24 x 1 1/4" Hx. Hd.....	200098	542 545	6
Lockwasher, 3/8" Int. Tooth.....	GM-138542	542 545	6
Nut, 3/8"-24 Hx.....	200099	542 545	6
Ring Gear.....	207150	542 545	1
1.370 - TIMING POINTER			
Pointer.....	207411	542 545	1
Bolt, 7/16"-14 x 1 1/8" Hx. Hd.....	GM-106336	542 545	1
Lockwasher, 7/16".....	GM-120383	542 545	1
Bolt, 5/16"-18 x 7/8" Hx. Hd.....	GM-120229	542 545	1
Lockwasher, 5/16" Hy.....	GM-120638	542 545	1
1.400 - CONNECTING ROD			
Rod, No. 1, 3 and 5 (less Bearing).....	200101	542 545	3
Rod, No. 2, 4 and 6 (less Bearing).....	200102	542 545	3
Bolt.....	203309	542 545	12
Nut.....	203310	542 545	12
Bushing.....	200107	542 545	6
1.405 - CONNECTING ROD BEARING			
Bearing, No. 1, 3 and 5 Std.....	212996	542 545	3
Bearing, No. 2, 4 and 6 Std.....	212997	542 545	3
Bearing, No. 1, 3 and 5 .001 Undersize.....	212998	542 545	*
Bearing, No. 2, 4 and 6 .001 Undersize.....	212999	542 545	*
Bearing, No. 1, 3 and 5 .002 Undersize.....	213000	542 545	*
Bearing, No. 2, 4 and 6 .002 Undersize.....	213001	542 545	*
Bearing, No. 1, 3 and 5 .010 Undersize.....	213002	542 545	*
Bearing, No. 2, 4 and 6 .010 Undersize.....	213003	542 545	*
NOTE: Engines with Engine Numbers followed by letter "A" have .010" Undersize Connecting Rod Bearings.			

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GROUP PART NAME and DESCRIPTION	PART NUMBER	MODELS	P E R C A R
1.405 - CONNECTING ROD BEARING (CONT'D.)			
Bearing, No. 1, 3 and 5 .012 Undersize.....	213004	542 545	*
Bearing, No. 2, 4 and 6 .012 Undersize.....	213005	542 545	*
Bearing, No. 1, 3 and 5 .020 Undersize.....	213266	542 545	*
Bearing, No. 2, 4 and 6 .020 Undersize.....	213267	542 545	*
1.410 - PISTONS			
Piston, Std.....	207247	542 545	6
Piston, .010 Oversize.....	207249	542 545	*
Piston, .020 Oversize.....	207250	542 545	*
Piston, .025 Oversize.....	207251	542 545	*
Piston, .030 Oversize.....	207252	542 545	*
Piston, .040 Oversize.....	207253	542 545	*
Piston, .050 Oversize.....	207254	542 545	*
Piston, .060 Oversize.....	207255	542 545	*
NOTE: Engines with Engine Numbers followed by the letter "N" have .020" Oversize Pistons.			
1.415 - PISTON RINGS			
Ring, Top Compression, Std.....	216087	542 545	6
Ring, Top Compression, .020 Oversize.....	216088	542 545	6
Ring, 2nd Compression, Std.....	200111	542 545	6
Ring, 2nd Compression, .010 Oversize.....	200361	542 545	6
Ring, 2nd Compression, .020 Oversize.....	200362	542 545	6
Ring, 2nd Compression, .030 Oversize.....	200363	542 545	6
Ring, Oil Control, Upper, Std.....	216089	542 545	6
Ring, Oil Control, Upper, .020 Oversize.....	216090	542 545	6
Ring, Oil Control, Lower, Std.....	200112	542 545	6
Ring, Oil Control, Lower, .010 Oversize.....	200364	542 545	6
Ring, Oil Control, Lower, .020 Oversize.....	200365	542 545	6
Ring, Oil Control, Lower, .030 Oversize.....	200366	542 545	6
Expander, Oil Control, Upper, Std. - .010 Oversize.....	216091	542 545	6
Expander, Oil Control, Upper, .020 - .030 Oversize.....	216092	542 545	6
1.417 - PISTON RING SETS - OIL CONTROL			
Ring Set (Chrome)(Std. to .009 Oversize).....	213951	542 545	1
Consists of:			
6 - 213956 Ring, Top Compression			
6 - 213961 Ring, 2nd Steel Section			
6 - 213966 Ring, Steel Section Oil Control			
6 - 208677 Ring, Slotted Oil Control			
Ring Set (Chrome)(.010 to .029 Oversize).....	213952	542 545	1
Consists of:			
6 - 213957 Ring, Top Compression			
6 - 213962 Ring, 2nd Steel Section Compression			
6 - 213967 Ring, Steel Section Oil Control			
6 - 208681 Ring, Slotted Oil Control			

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GROUP PART NAME and DESCRIPTION	PART NUMBER	MODELS		P E A R
1.417 - PISTON RING SETS - OIL CONTROL (CONT'D.)				
Ring Set (Chrome)(.030 to .039 Oversize).....	213953	542	545	1
Consists of:				
6 - 213958 Ring, Top Compression				
6 - 213963 Ring, 2nd Steel Section				
6 - 213968 Ring, Steel Section Oil Control				
6 - 213023 Ring, Slotted Oil Control				
Ring Set (Chrome)(.040 to .049 Oversize).....	213954	542	545	1
Consists of:				
6 - 213959 Ring, Top Compression				
6 - 213964 Ring, 2nd Steel Section Compression				
6 - 213969 Ring, Steel Section Oil Control				
6 - 208685 Ring, Slotted Oil Control				
Ring Set (Chrome)(.050 to .069 Oversize).....	213955	542	545	1
Consists of:				
6 - 213960 Ring, Top Compression				
6 - 213965 Ring, 2nd Steel Section Compression				
6 - 213970 Ring, Steel Section Oil Control				
6 - 208689 Ring, Slotted Oil Control				
1.420 - PISTON PIN				
Pin, Std.....	200109	542	545	6
Pin, .003 Oversize (Orange).....	201472	542	545	*
Pin, .005 Oversize (Purple).....	201473	542	545	*
Retaining Ring.....	200110	542	545	12
1.500 - CAMSHAFT				
Camshaft (Steel).....	203017	542	545	1
Thrustplate.....	200114	542	545	1
Bolt, 5/16"-18 x 5/8" Hx. Hd.....	GM-120228	542	545	2
Lockwasher, 5/16" Hy.....	GM-120638	542	545	2
1.510 - CAMSHAFT BEARINGS				
Bearing, No. 1.....	200115	542	545	1
Bearing, No. 2.....	200116	542	545	1
Bearing, No. 3.....	200117	542	545	1
Bearing, No. 4.....	200118	542	545	1
1.600 - TIMING GEAR				
Gear (on Crankshaft).....	207170	542	545	1
Key, 1/4" x 1".....	GM-113782	542	545	1
Gear (on Camshaft).....	200119	542	545	1
Key, 5/32" x 5/8".....	GM-106750	542	545	1
Lock.....	200121	542	545	1
Nut, 7/8"-18 Hx.....	200122	542	545	1

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GROUP PART NAME and DESCRIPTION	PART NUMBER	MODELS	PEAR
1.605 - TIMING CHAIN			
Chain.....	200123	542 545	1
1.610 - TIMING CHAIN COVER			
Cover (incl. Seal).....	200126	542 545	1
Bolt, 5/16"-18 x 7/8" Hx. Hd.....	GM-120229	542 545	1
Lockwasher, 5/16" Med.....	GM-120214	542 545	1
Bolt, 5/16"-18 x 11/16" Hx. Hd.....	GM-121999	542 545	4
Lockwasher, 5/16" Hy.....	GM-120638	542 545	4
Nut, 5/16"-18 Hx.....	GM-120376	542 545	4
Bolt, 5/16"-18 x 7/8" Hx. Hd.....	GM-120229	542 545	3
Lockwasher, 5/16" Hy.....	GM-120638	542 545	3
Bolt, 5/16"-18 x 7/8" Hx. Hd.....	GM-120229	542 545	1
Lockwasher, 5/16" Hy.....	GM-120638	542 545	1
Gasket.....	200128	542 545	1
1.720 - VALVES			
Valve, Intake.....	203325	# 545	6
Valve, Exhaust.....	203326	542 545	6
Valve, Intake.....	215032	542 ## 545	6
Rotocap (Exhaust Valve).....	215033	542 ## 545	6
Guide, .0005 Oversize (marked "A").....	205702	542 545	*
Guide, .0055 Oversize (marked "L").....	205703	542 545	*
Spring, Intake and Exhaust.....	200133	542 545	12
Retainer.....	203327	542 545	12
Lock.....	203328	542 545	12
Gasket Set, Valve Grind.....	204504	542 545	1
Consists of:			
1 - 200062 Gasket, Cylinder Head			
1 - 200143 Gasket, Valve Tappet Cover			
3 - 202145 Gasket, Valve Tappet Cover Nut			
1 - 200279 Gasket, Exhaust and Intake Manifold to Block			
1 - 201852 Gasket, Exhaust Manifold to Exhaust Pipe			
1 - 203355 Gasket, Carburetor to Intake Manifold			
1 - 200336 Gasket, Water Outlet Elbow			
1.740 - VALVE TAPPET			
Tappet, Std.....	207171	542 545	12
Tappet, .001 Oversize.....	207290	542 545	*
Tappet, .002 Oversize.....	207292	542 545	*
Tappet, .005 Oversize.....	212769	542 545	*
Screw, Adjusting (27/32" Long).....	207172	542 545	12
Screw, Adjusting (29/32" Long).....	207256	542 545	12
1.750 - VALVE TAPPET COVER			
Cover (incl. Breather Tube).....	204112	542 545	1

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GROUP PART NAME and DESCRIPTION	PART NUMBER	MODELS		P E R C A R
1.750 - VALVE TAPPET COVER (CONT'D.)				
Gasket.....	200413	542	545	1
Stud, 1/4"-20 x 2 3/8".....	200141	542	545	3
Nut, 1/4"-20 Hx.....	200142	542	545	3
Gasket, 7/16" I.D.....	202145	542	545	3
Baffle, Valve Chamber Oil, Front.....	204114	542	545	1
Baffle, Valve Chamber Oil, Center.....	204113	542	545	1
NOTES				