

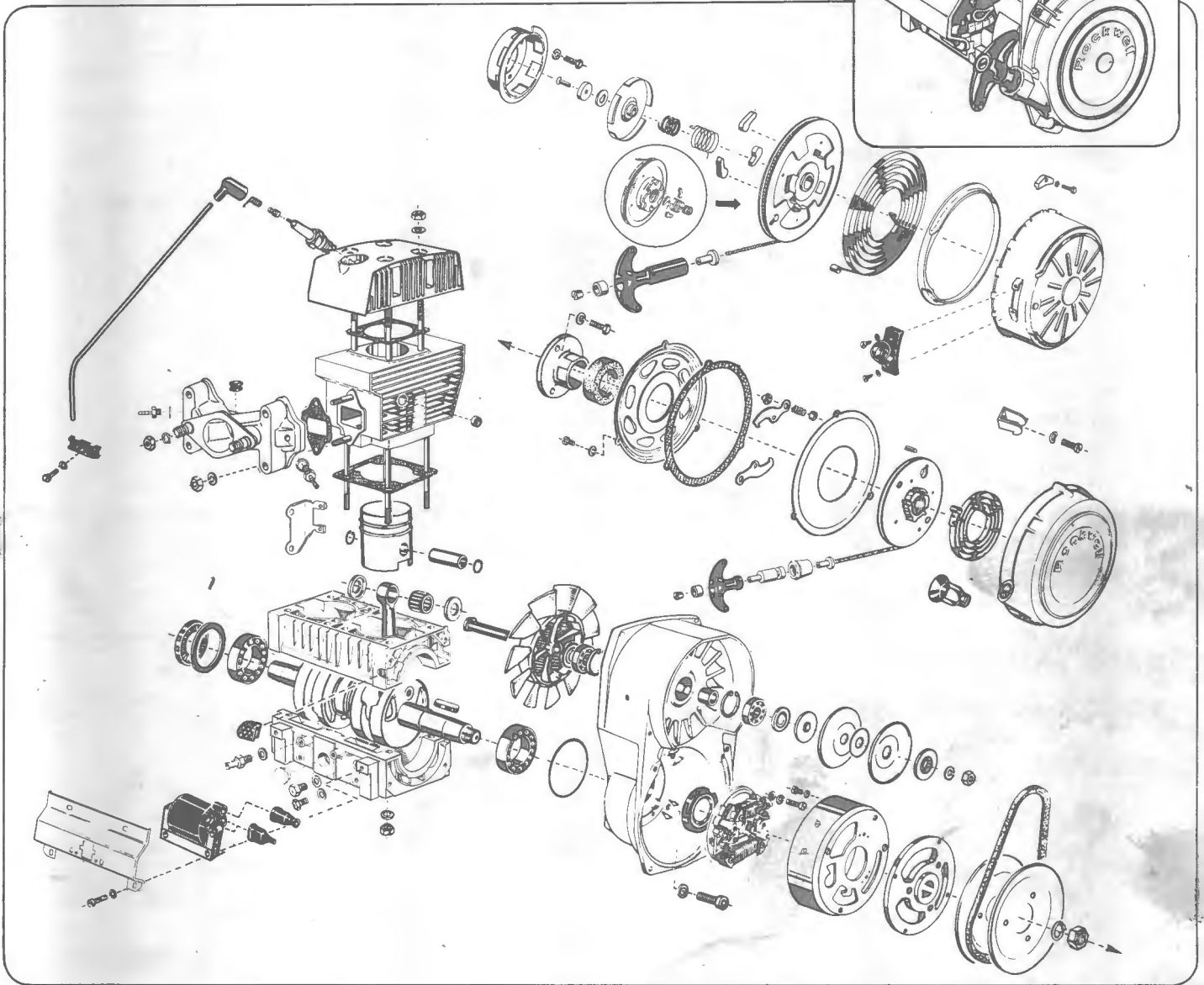
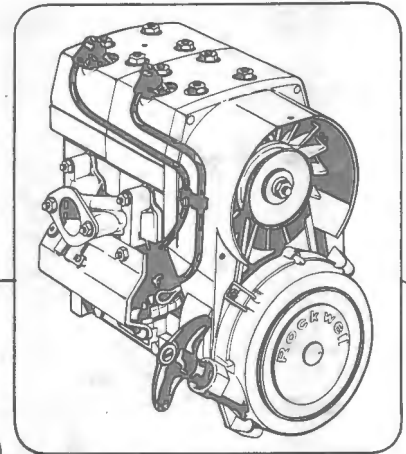
ROCKWELL

Bulletin SCP-7740

Model 2F 400-6 (Scorpion)
Axial-Fan Cooled Twin Cylinder Engine

SPARE PARTS LIST

General View Model 2F 400-6



WHEN ORDERING SPARE PARTS:

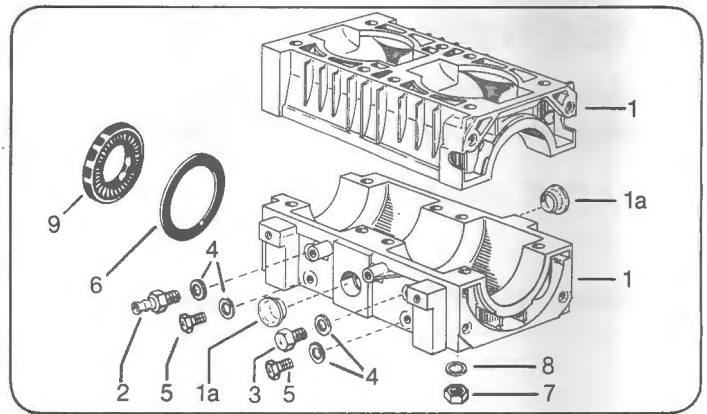
1. Indicate engine model number and serial number.
2. Order parts by part number, not by illustration number.
3. Give exact description of part required.
4. Specify quantity.

(NOTE: Parts included in Kits are not available separately)

Spare Parts List

Model 2F-400-6 (Scorpion)

Crankcase

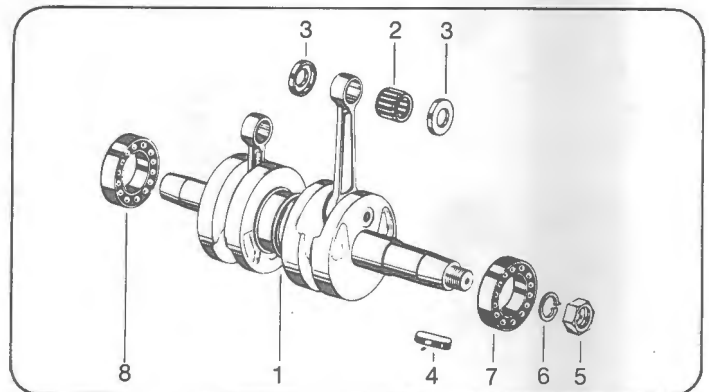


Engine Serial Numbers					
Illus. No.	Description	Part Number	Qty. Req'd.	Part Number	Qty. Req'd.
1	Crankcase	291-01-803-0	1		
1a	Plug	See Kit "C"	2		
2	Impulse Connector	See Kit "C"	1		
3	Plug	See Kit "C"	1		
4	Gasket Ring	See Kit "G"	4		
5	Plug	See Kit "C"	2		
6	Washer	338-03-007-0	1		
7	Nut	See Kit "A"	8		
8	Spring Washer	See Kit "A"	8		
9	Oil Seal	See Kit "G"	1		

Spare Parts List

Model 2F-400-6 (Scorpion)

Crankshaft

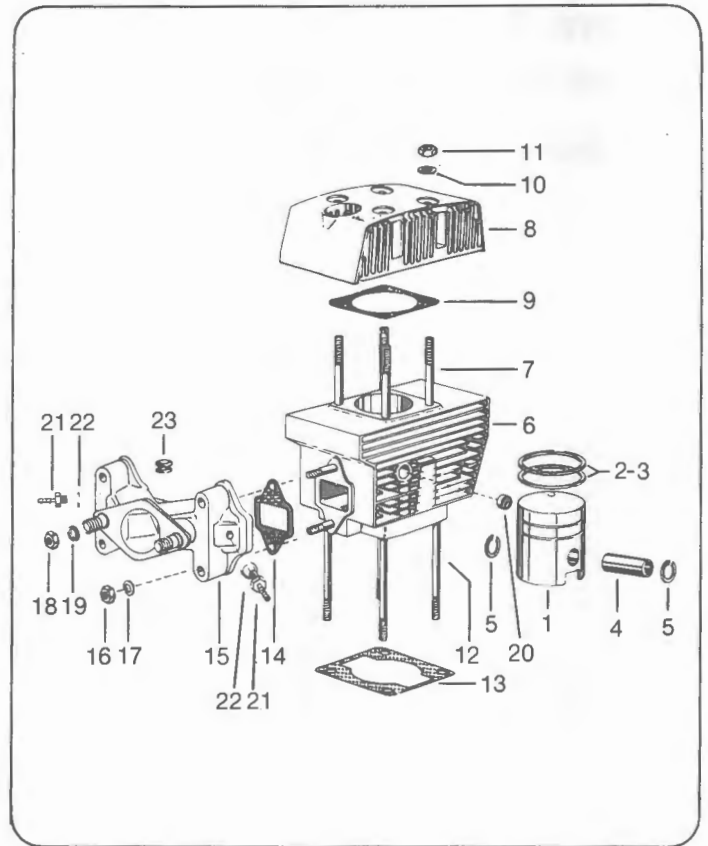


Engine Serial Numbers					
Illus. No.	Description	Part Number	Qty. Req'd.	Part Number	Qty. Req'd.
1	Crankshaft, complete (including items 2 thru 6)	291-86-901-0	1		
2	Needle Bearing	000-39-112-73	2		
3	Check Plate	338-03-013-0	4		
4	Key	See Kit "B"	1		
5	Nut	See Kit "B"	1		
6	Lock Washer	See Kit "B"	1		
7	Ball Bearing	000-39-075-21	1		
8	Ball Bearing (Double Row, P.T.O.)	000-39-061-69	1		

Spare Parts List

Model 2F-400-6 (Scorpion)

Piston and Cylinder



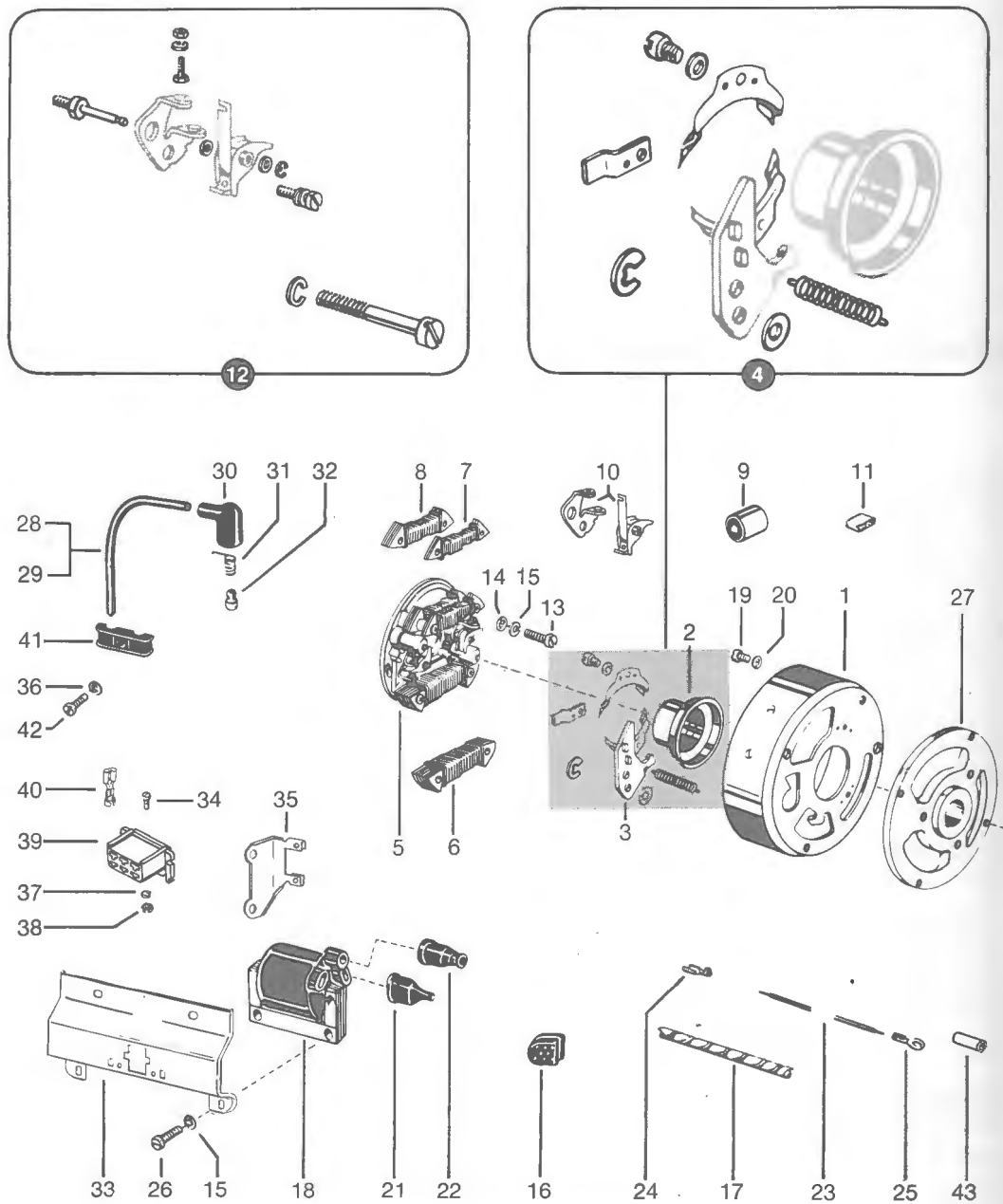
Engine Serial Numbers					
Illus. No.	Description	Part Number	Qty. Req'd.	Part Number	Qty. Req'd.
1	Piston, complete (including items 2 thru 5)	399-05-905-0	2		
2-3	Piston Rings (Set of 2)	000-42-139-81	2		
4	Wrist Pin	338-05-002-0	2		
5	Circlip	000-41-621-42	4		
6	Cylinder, complete (including items 7 thru 20)	See Kit "M"	2		
7	Stud	See Kit "M"	8		
8	Cylinder Head (Small Step)	399-07-062-0 (a)	2		
	Cylinder Head (Medium Step)	399-07-063-0	2		
9	Cylinder Head Gasket	See Kit "G"	2		
10	Washer	See Kit "A"	8		
11	Nut	See Kit "A"	8		
12	Stud	000-41-243-60	8		
13	Cylinder Base Gasket				
	Red 0.3 mm.	See Kit "G"	-		
	Black 0.5 mm.	See Kit "G"	-		
	Light Green 0.75 mm.	See Kit "G"	-		
	Dark Green 1.0 mm.	See Kit "G"	-		
14	Intake Gasket	See Kit "G"	2		
15	Intake Manifold	338-07-040-0	1		
16	Nut	See Kit "A"	4		
17	Spring Washer	See Kit "A"	4		
18	Nut	See Kit "A"	2		
19	Lock Washer	See Kit "A"	2		
20	Transfer Port Plug	000-42-300-58	4		
21	Nipple (Primer)	See Kit "C"	2		
22	Gasket Ring	See Kit "G"	2		
23	Grommet	See Kit "H"	1		

(a) For replacement use cylinder head 399-07-063-0 only.

Spare Parts List

Model 2F-400-6 (Scorpion)

Electrical Equipment



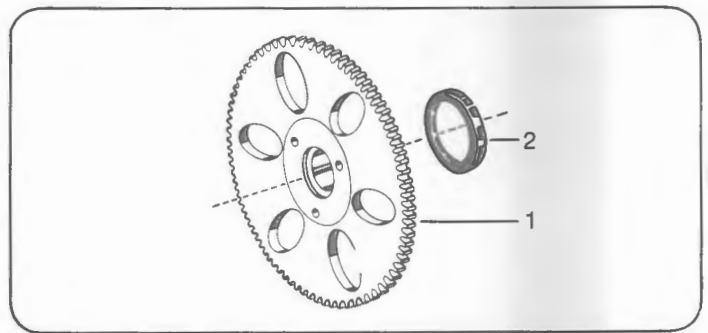
Engine Serial Numbers →

Illus. No.	Description	Part Number	Qty. Req'd.	Part Number	Qty. Req'd.
1	Magneto Flywheel Assembly	000-43-051-99	1		
2	Cam	See Kit "K"	1		
3	Centrifugal Weight	See Kit "K"	1		
4	Centrifugal Weight Parts Kit	See Kit "K"	1		
5	Armature Plate Assembly (including items 6 thru 12)	000-43-053-39	1		
6	Lighting Coil (100 Watt)	—	-		
7	Lighting Coil (20 Watt)	—	-		
8	Ignition Coil	—	-		
9	Condenser	See Kit "I"	2		
10	Breaker Points (Set of 2)	See Kit "I"	2		
11	Lubricating Wick	See Kit "K"	1		
12	Parts Kit for Points & Coils	See Kit "I"	1		
13	Screw	See Kit "B"	2		
14	Washer	See Kit "B"	2		
15	Lock Washer	See Kit "B"	6		
16	Grommet	See Kit "H"	2		
17	Spiral Band	See Kit "H"	1		
18	Ignition Coil	000-43-056-06	2		
19	Screw	See Kit "C"	4		
20	Lock Washer	See Kit "C"	4		
21	Protective Cap	See Kit "H"	4		
22	Protective Cap	See Kit "H"	2		
23	Ground Wire	See Kit "H"	2		
24	Connector (Spade Type)	See Kit "H"	4		
25	Connector (Eyelet Type)	See Kit "H"	2		
26	Screw	See Kit "B"	4		
27	Flywheel Flange	338-11-022-0	1		
28	Ignition Cable (14")	See Kit "H"	1		
29	Ignition Cable (20-7/16")	See Kit "H"	1		
30	Spark Plug Connector	See Kit "H"	2		
31	Spring	See Kit "H"	2		
32	Contact Nut	See Kit "H"	2		
33	Cover Plate	338-11-008-2	1		
34	Screw	See Kit "H"	2		
35	AMP Connector Bracket	291-11-001-1	1		
36	Spring Washer	See Kit "B"	1		
37	Lock Washer	See Kit "H"	2		
38	Nut	See Kit "H"	2		
39	AMP Connector Housing	See Kit "H"	1		
40	AMP Connector (Spade Type)	See Kit "H"	5		
41	Ignition Cable Bracket	See Kit "H"	1		
42	Screw	See Kit "B"	1		
43	Sleeve	See Kit "H"	1		

Spare Parts List

Model 2F-400-6 (Scorpion)

Ring Gear

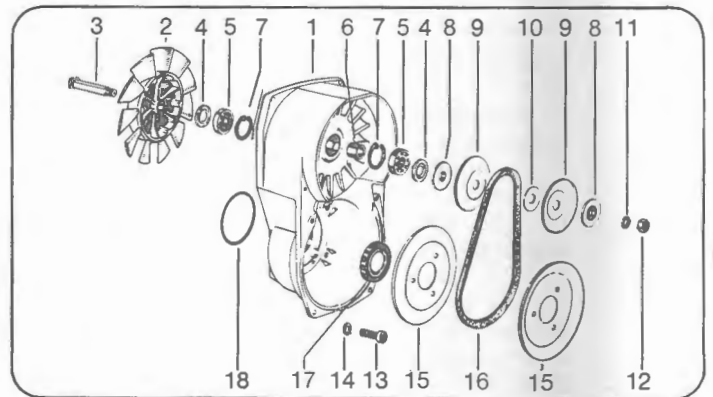


Engine Serial Numbers					
Illus. No.	Description	Part Number	Qty. Req'd.	Part Number	Qty. Req'd.
1	Ring Gear	See Kit "P"	1		
2	Oil Seal	See Kit "P" & G"	1		

Spare Parts List

Model 2F-400-6 (Scorpion)

Fan Case



Engine Serial Numbers					
Illus. No.	Description	Part Number	Qty. Req'd.	Part Number	Qty. Req'd.
1	Fan Housing (Unpainted)	338-14-002-0	1		
	Fan Housing (Black)	338-14-017-0 (a)			
2	Fan (Unpainted)	399-14-003-0	1		
	Fan (Black)	399-14-004-0 (b)			
3	Shaft	338-14-007-0	1		
4	Nilos Ring	See Kit "C"	2		
5	Ball Bearing	000-39-071-13	2		
6	Spacer	338-14-008-0	1		
7	Circlip	See Kit "C"	2		
8	Clamp Washer	338-14-009-0	2		
9	Pulley Half (Small)	399-14-002-0	2		
10	Spacer	338-14-012-0	4		
11	Lock Washer	See Kit "C"	1		
12	Nut	See Kit "C"	1		
13	Screw	See Kit "B"	4		
14	Lock Washer	See Kit "B"	4		
15	Pulley Half (Large)	399-14-001-0	2		
16	V-Belt	000-42-175-08	1		
17	Oil Seal	See Kit "G"	1		
18	O-Ring	See Kit "G"	1		

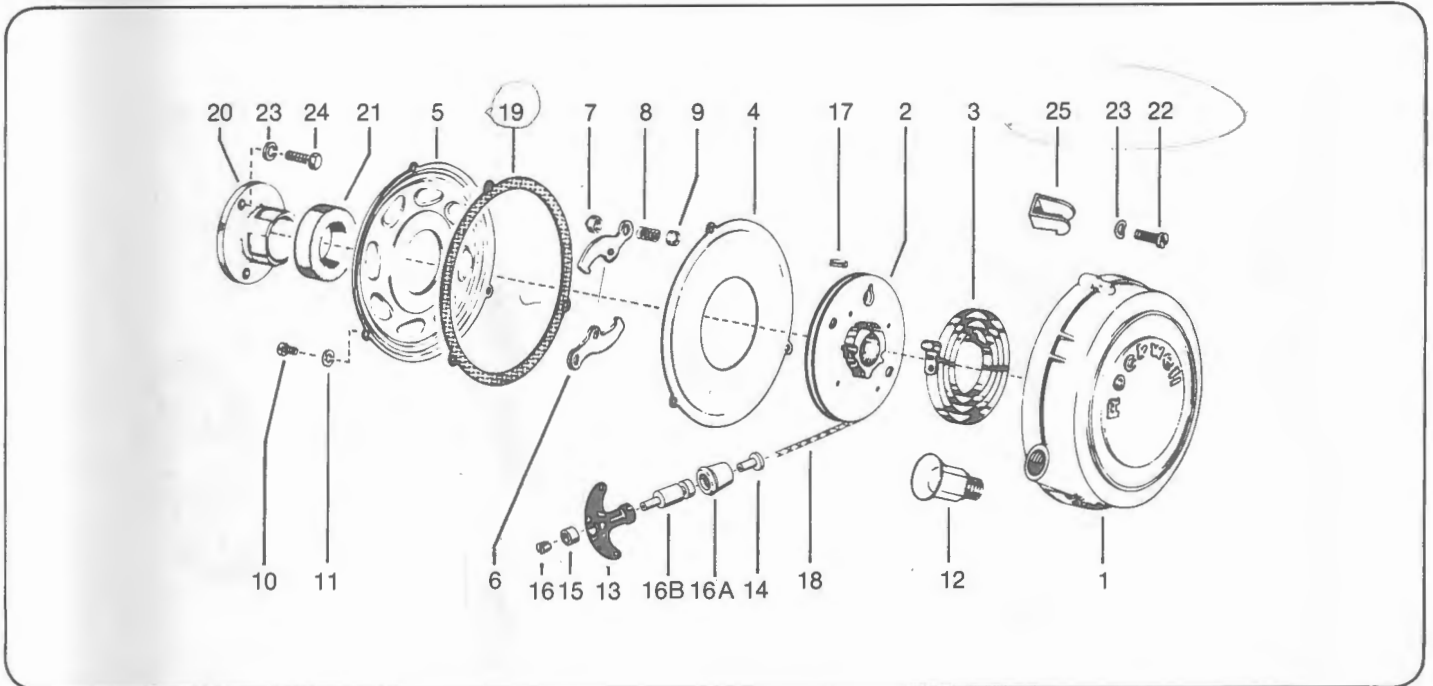
(a) For replacement use fan housing 338-14-002-0.

(b) For replacement use fan 399-14-003-0.

Spare Parts List

Model 2F-400-6 (Scorpion)

Recoil Starter (Aluminum)

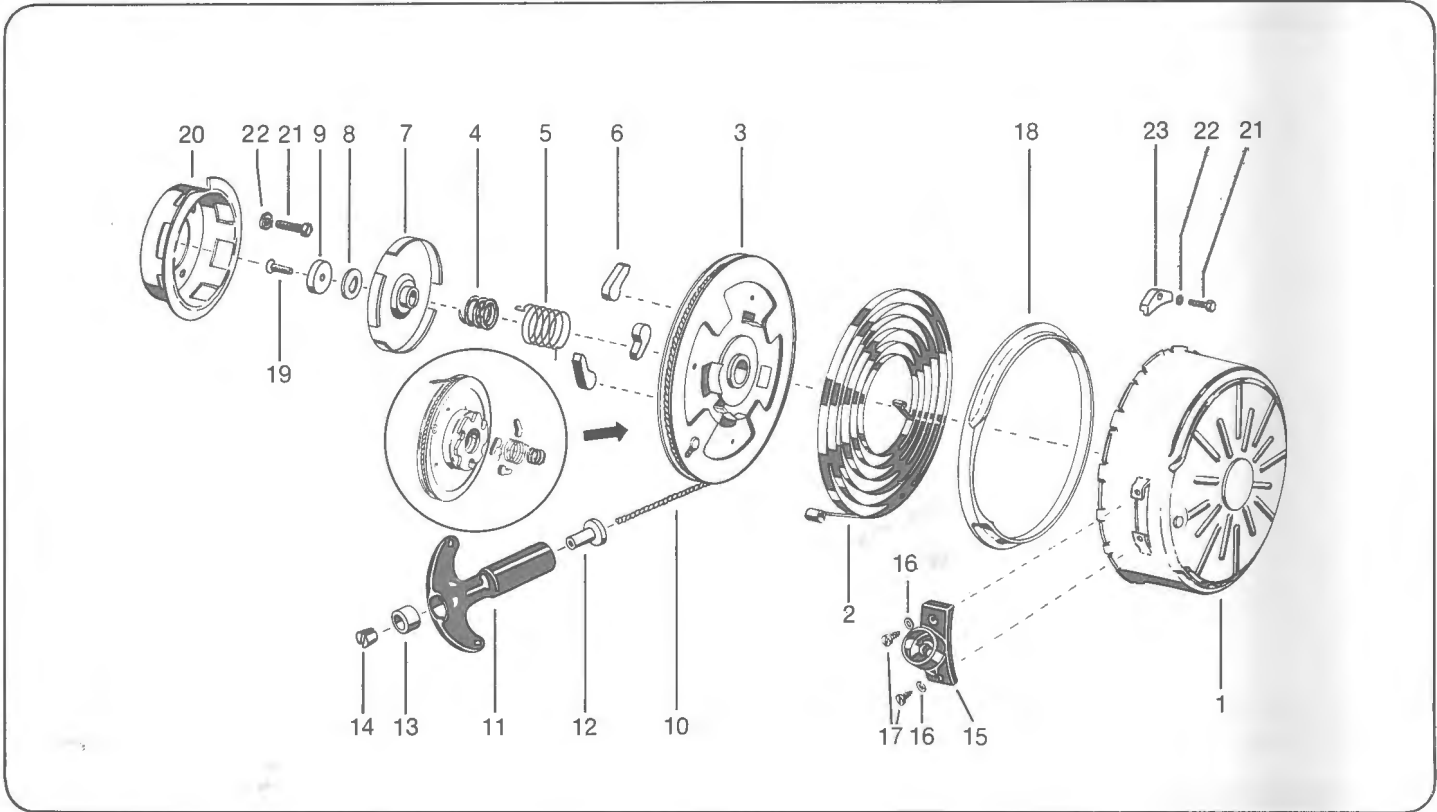


Engine Serial Numbers					
Illus. No.	Description	Part Number	Qty. Req'd.	Part Number	Qty. Req'd.
-	Recoil Starter, complete (including items 1 thru 19). Black	338-41-811-1			
1	Recoil Starter Housing, (Black)	338-41-017-0	1		
2	Rope Pulley	197-41-070-0	1		
3	Recoil Spring	See Kit "D"	1		
4	Intermediate Plate	338-41-006-0	1		
5	Cover Plate	338-41-005-0	1		
6	Starter Pawl	See Kit "D"	2		
7	Spring Cap	See Kit "D"	2		
8	Pressure Spring	See Kit "D"	2		
9	Inner Spring Cap	See Kit "D"	2		
10	Screw	See Kit "D"	3		
11	Star Washer	See Kit "D"	3		
12	Rope Bushing	See Kit "D"	1		
13	Handle	See Kit "F"	1		
14	Bushing	See Kit "F"	1		
15	Retaining Ring	See Kit "F"	1		
16	Retaining Key	See Kit "F"	1		
16A	Damper	See Kit "F"	1		
16B	Extension	See Kit "F"	1		
17	Roll Pin	See Kit "D"	2		
18	Rope; 74"	See Kit "D"	1		
19	Gasket	See Kit "E"	1		
20	Carrier	338-41-810-0	1		
21	Seal	See Kit "E"	1		
22	Screw	See Kit "A"	4		
23	Lock Washer	See Kit "A"	7		
24	Screw	See Kit "A"	3		
25	Recoil Starter Clamp	See Kit "A"	4		

Spare Parts List

Model 2F-400-6 (Scorpion)

Recoil Starter (Steel)



Engine Serial Numbers					
Illus. No.	Description	Part Number	Qty. Req'd.	Part Number	Qty. Req'd.
	Recoil Starter, complete (including items 1 thru 19), Black.	338-41-823-0	1		
1	Recoil Starter Housing, (Black)	338-41-822-0	1		
2	Recoil Spring	See Kit "L"	1		
3	Rope Pulley	338-41-813-0	1		
4	Pressure Spring	See Kit "L"	1		
5	Torsional Spring	See Kit "L"	1		
6	Pawl	See Kit "L"	3		
7	Pawl Retainer	338-41-023-0	1		
8	Washer	See Kit "L"	1		
9	Countersunk Washer	See Kit "L"	1		
10	Rope; 79"	See Kit "L"	1		
11	Handle	See Kit "R"	1		
12	Bushing	See Kit "R"	1		
13	Retaining Ring	See Kit "R"	1		
14	Retaining Key	See Kit "R"	1		
15	Rope Bushing	See Kit "L"	1		
16	Washer	See Kit "L"	2		
17	Screw	See Kit "L"	2		
18	Spacer	338-41-037-0	1		
19	Countersunk Screw	See Kit "L"	1		
20	Carrier	338-41-032-0	1		
21	Screw	See Kit "A"	7		
22	Lock Washer	See Kit "A"	7		
23	Recoil Starter Clamp	See Kit "A"	4		

PARTS KITS

Parts Kit "B"	Part No. 399-71-802-0 ← ORDER BY THIS NUMBER ONLY Nuts, Bolts, Washers	Engine Serial Number	
		All	
Includes:		Part Number	Qty. Req'd.
Screw (Fan Housing), 8mm. Lock Washer (Fan Housing), 8 mm. Screw (Armature Plate), 5 mm. Washer (Armature Plate), 5 mm. Lock Washer (Armature Plate), 5 mm. Screw (Coil Cover), 5 mm. Lock Washer (Coil Cover), 5 mm. Screw (Ignition Cable Bracket), 6 mm. Spring Washer (Ignition Cable Brkt.), 6 mm. Nut (Crankshaft), 20 mm. Lock Washer (Crankshaft), 20 mm. Crankshaft Key	DO NOT ORDER BY THESE NUMBERS	000-41-741-28	4
		000-40-646-07	4
		000-41-501-15	2
		000-40-510-06	2
		000-40-645-05	2
		000-41-501-20	4
		000-40-645-05	4
		000-41-501-38	1
		000-40-422-08	1
		000-41-955-07	1
		000-40-645-20	1
		000-40-896-15	1

Parts Kit "C"	Part No. 399-71-803-0 ← ORDER BY THIS NUMBER ONLY Miscellaneous	Engine Serial Numbers	
		All	
Includes:		Part Number	Qty. Req'd.
Screw (Magneto), 6 mm. Lock Washer (Magneto), 6 mm. Nut (Fan), 10 mm. Lock Washer (Fan), 10 mm. Circlip (Fan Bearing) Nilos Ring (Fan Bearing) Screw (Drain), 8 mm. Plastic Plug (Crankcase) Plug (Impulse Hole) Impulse Nipple Nipple (Primer)	DO NOT ORDER BY THESE NUMBERS	000-41-504-35	4
		000-40-645-06	4
		000-41-952-02	1
		000-40-645-10	1
		000-40-614-32	2
		000-40-477-35	2
		000-41-010-89	2
		002-42-062-00	2
		000-41-480-53	1
		002-45-513-26	1
		338-07-038-0	2

Part Kit "D"	Part No. 399-62-801-0 ← ORDER BY THIS NUMBER ONLY Recoil Starter - 1st Version (Aluminum)	Engine Serial Numbers	
		All	
Includes:		Part Number	Qty. Req'd.
Starter Pawl Spring Cap (Inner) Spring Cap (Outer) Pressure Spring Recoil Spring Rope Bushing Rope; 74" Roll Pin Screw (Cover Plate), 4 mm. Star Washer (Cover Plate), 4 mm.	DO NOT ORDER BY THESE NUMBERS	252-41-065-1	2
		102-41-499-0	2
		252-41-066-0	2
		252-41-067-0	2
		252-41-429-2	1
		252-41-022-0	1
		252-41-806-1	1
		000-40-391-45	2
		000-41-534-43	3
		000-40-670-05	3

PARTS KITS

Parts Kit "E"	Part No. 399-62-802-0 ← Gaskets	ORDER BY THIS NUMBER ONLY	Engine Serial Numbers	
Includes;				
Gasket (Cover Plate) Dust Seal		DO NOT ORDER BY THESE NUMBERS	Part Number	Qty. Req'd.
			338-41-007-0 079-11-017-0	1 1

Parts Kit "F"	Part No. 399-62-803-0 ← Recoil Handle Assembly	ORDER BY THIS NUMBER ONLY	Engine Serial Numbers	
Includes;				
Handle Bushing Retaining Ring Retaining Key Damper Extension		DO NOT ORDER BY THESE NUMBERS	Part Number	Qty. Req'd.
			252-41-007-0 252-41-009-0 252-41-015-0 252-41-016-0 252-41-008-0 338-41-040-0	1 1 1 1 1 1

Parts Kit "G"	Part No. 399-61-801-1 ← Gaskets	ORDER BY THIS NUMBER ONLY	Engine Serial Numbers	
			All	
Includes;				
O-Ring (Fan Housing) Oil Seal (Manual Start), 400 cc./440 cc. Oil Seal (Fan Housing) Oil Seal (Electric Start), 400 cc. Oil Seal (Electric Start), 440 cc. Gasket (Impulse Nipple), 8 mm. Cylinder Head Gasket (400 cc.) Cylinder Head Gasket (440 cc.) Cylinder Base Gasket Red 0.3 mm. (.012") Black 0.5 mm. (.020") Light Green 0.75 mm. (.030") Dark Green 1.0 mm. (.040") Gasket (Intake Manifold) Gasket (Primer Nipple)		DO NOT ORDER BY THESE NUMBERS	Part Number	Qty. Req'd.
			002-52-665-00 000-42-315-78 000-42-315-48 000-42-319-45 000-42-318-91 000-35-000-84 399-07-006-1 438-07-002-1 338-07-025-0 338-07-008-0 338-07-026-0 338-07-027-0 338-07-011-0 000-35-000-54	1 1 1 1 1 4 2 2 2 2 2 2 2 2

PARTS KITS

Parts Kit "H"	Part No. 399-71-804-0 ← Ignition Components	ORDER BY THIS NUMBER ONLY		Engine Serial Numbers		
				All		
Includes;			Part Number	Qty. Req'd.		
Ignition Cable (14") Ignition Cable (20-7/16") Spark Plug Connector Spring Contact Nut Ignition Cable Bracket Grommet, (10 holes) Spiral Band Ground Wire Connector (Eyelet Type) Connector (Spade Type) Connector Housing (AMP) Connector (Spade Type), AMP Screw (Connector Housing), 3 mm. Lock Washer (Connector Housing), 3 mm. Nut (Connector Housing), 3 mm. Protective Cap (Ignition Cable) Protective Cap (Ground Wire) Grommet (Manifold) Sleeve (Ignition & Light Wires)			DO NOT ORDER BY THESE NUMBERS		002-44-152-36	1
					002-44-152-52	1
					002-44-275-00	2
					002-44-276-00	2
					002-44-277-90	2
					002-50-120-08	1
					002-44-450-01	2
					002-44-127-48	1
					002-44-140-11	2
					000-43-100-04	2
					002-44-523-00	4
					291-11-004-0	1
					002-44-532-49	5
					000-41-500-65	2
					000-40-645-03	2
000-41-970-04	2					
002-44-499-00	2					
002-44-498-00	4					
002-44-424-17	1					
002-44-472-90	1					

Parts Kit "I"	Part No. 399-71-805-0 ← Ignition Point Components	ORDER BY THIS NUMBER ONLY		Engine Serial Numbers		
				All		
Includes;			Part Number	Qty. Req'd.		
Ignition Point (Set) Condenser Screw (Points) Washer (Points) Lock Washer (Points) Screw (Point Wires) Lock Washer (Point Wires) Hex Nut (Point Wires) Pivot Pin (Points) Washer (Pivot Pin) Circlip (Pivot Pin) Screw (Coil) Lock Washer (Coil)			DO NOT ORDER BY THESE NUMBERS		000-43-062-23	2
					000-43-065-16	2
						2
						2
						2
						2
						2
						2
						2
						2
	4					
	1					

PARTS KITS

Parts Kit "K"	Part No. 399-71-806-0 ← ORDER BY THIS NUMBER ONLY Magneto Flywheel Components	Engine Serial Numbers	
		All	
Includes;		Part Number	Qty. Req'd.
Cam Camholder Spring Holder Screw (Camholder) Spring Washer (Camholder) Spiral Spring Washer (Centrifugal Weight) Circlip (Centrifugal Weight) Lubricating Wick Centrifugal Weight	DO NOT ORDER BY THESE NUMBERS	000-43-057-27	1
			2
			1
		000-43-131-08	2
			1
			1
		000-43-063-13	1
		000-43-060-21	1

Parts Kit "L"	Part No. 399-62-804-0 ← ORDER BY THIS NUMBER ONLY Recoil Starter - 2nd Version (Steel)	Engine Serial Numbers	
		All	
Includes;		Part Number	Qty. Req'd.
Recoil Spring Starter Pawl Washer (Countersunk) Pressure Spring Torsional Spring Rope; 79" Rope Guide Screw (Rope Guide) Washer (Rope Guide) Washer (Rope Drum) Screw (Countersunk)	DO NOT ORDER BY THESE NUMBERS	252-41-429-2	1
			3
			1
			1
			1
			1
			1
			1
			2
			2
			1
	1		

Parts Kit "M"	Part No. 399-92-901-0 ← ORDER BY THIS NUMBER ONLY Cylinder and Piston Assembly	Engine Serial Numbers	
		All	
Includes;		Part Number	Qty. Req'd.
Piston, complete with Rings Wrist Pin Circlip Cylinder, complete with Upper Studs and Transfer Port Plugs	DO NOT ORDER BY THESE NUMBERS	399-05-807-0	1
			1
		000-40-621-42	2
		399-07-862-0	1

PARTS KITS

Parts Kit "P"	Part No. 399-71-807-0 ← ORDER BY THIS NUMBER ONLY Ring Gear	Engine Serial Numbers	
		Includes;	
Ring Gear Oil Seal	DO NOT ORDER BY THESE NUMBERS	Part Number	Qty. Req'd.
		291-11-801-0 000-42-319-45	1 1

Parts Kit "R"	Part No. 399-62-805-0 ← ORDER BY THIS NUMBER ONLY Recoil Handle Assembly	Engine Serial Numbers	
		Includes;	
Handle Bushing Retaining Ring Retaining Key	DO NOT ORDER BY THESE NUMBERS	Part Number	Qty. Req'd.
		338-41-041-0 252-41-009-0 252-41-015-0 252-41-016-0	1 1 1 1

NOTES

This image shows a blank sheet of white paper with horizontal ruling lines. The paper is oriented vertically and has three circular binder holes punched along the left edge. The word "NOTES" is printed in a bold, black, sans-serif font in the upper left corner. The rest of the page is empty, with no handwriting or other markings.

Rockwell

ROCKWELL MANUFACTURING COMPANY
ENGINE DIVISION, 400 North Lexington Ave., Pgh., Pa. 15208