

WAUKESHA

Intermediate Gas Engine

F1197 G
101 to 255 BHP

DESIGN FEATURES

ENGINE

Breather - Open system.

Crankcase - Integral with cylinder frame. Seven large diameter main bearings.

Crankshaft - Forged steel, with hardened journals, dynamically balanced. Vibration damper.

Cylinder heads - Two, interchangeable, valve-in-head type, with stellite faced exhaust valves and exhaust valve seat inserts.

Connecting rods - Drop forged alloy steel, rifle drilled for piston pin lubrication.

Cylinders - Replaceable wet cylinder liners of centrifugally cast alloy iron.

Engine rotation - Counterclockwise when facing flywheel.

Pistons - Aluminum alloy, oil cooled, with full floating piston pin.

STANDARD EQUIPMENT

AIR INDUCTION SYSTEM

Air cleaner - Oil bath air cleaner.

CONTROL SYSTEM

Governor - Waukesha centrifugal design.

Safety Shutdown - Low oil temperature and high water temperature cutoff switches. Mechanical fuel shut-off valve. Manual reset.

EXHAUST SYSTEM

Dry exhaust manifold with threaded flange connections for 4" (102 mm) OD pipe.

FLYWHEEL

With ring gear (144 teeth), machined for Twin Disc, three plate, 1 1/4 inch clutch.

Flywheel housing - SAE No. 0, foot-type.

FUEL SYSTEM

Updraft, carburetor with 2.5" (64 mm) diameter (NPT) inlet.

IGNITION SYSTEM

Low tension magneto and cables. One spark plug and one coil per cylinder.

INSTRUMENTATION

Engine-mounted ignition switch, safety switches, vacuum, water temperature, oil pressure and oil temperature gauges.

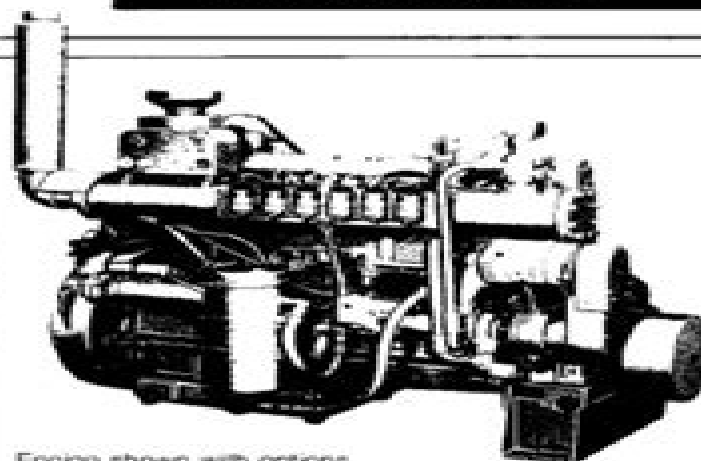
LUBRICATION SYSTEM

Full pressure system with high-capacity gear-type pump, shunt oil filter and rear sump.

Oil Cooler

WATER CIRCULATION SYSTEM

Gear-driven jacket water pump, with thermostatically controlled full flow bypass cooling circuit.



Engine shown with options

**Model F1197G Naturally Aspirated,
Six Cylinder, Four-Cycle Gas-Fueled Engine**

SPECIFICATIONS

Cylinders	Inline 6
Piston Displacement	1197 in. ³ (20 $\frac{1}{2}$)
Stroke Cycles	4
Bore & Stroke	6.25" X 6.5" (159 X 165 mm)
Compression Ratio	Standard 9:1 Optional 7:1
Jacket Water System Capacity	12 gal. (45l)
Lube Oil Capacity	12 gal. (45l)
Crankshaft Pulley	3 grooves; two, OD 8.31" one, OD 9.13"
Starting System	125-150 psi air/gas; 24V electric
Governor	Centrifugal
Dry Weight	4050 lb. (1840 kg)

OPTIONS

Air Cleaner - Dry element; oil bath with pre-cleaner.

Ignition - Solid state.

Fuel System - Optional carburetors, regulators, and solenoid valves for multi-fuel systems.

Instruments - Ammeter, tachometer, hourmeter.

Waukesha F1197 Gas Engine Maintenance Manual

L Elliott (Leonard Elliott) Brookes



Waukesha F1197 Gas Engine Maintenance Manual:

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