

Technical Service Bulletin Number	Revision Level	Date	Group Number
TSB120249			



Technical Service Bulletin

Subject

New ISX15 and QSX15 Factory Shimmed Cylinder Liner Assembly

Warranty Statement

The information in this document has no effect on present warranty coverage or repair practices, nor does it authorize TRP or Campaign actions.

Contents

The purpose of this document is to notify the field of a new ISX15 factory shimmed cylinder liner assembly. The design changes to the cylinder liner were made to address cylinder head gasket combustion seal leaks and counterbore mid-stop fretting.

The new factory shimmed cylinder liner incorporates a retained hardened brass shim at the mid-stop seating area. The new factory shimmed cylinder liner can easily be identified by a band machined in the lower outside diameter (OD) of the cylinder liner. This band is also visible when the cylinder liner is installed. Reference Figure 1 for location of the brass shim and machined band.

The new cylinder liner is backwards compatible with all previous small outside diameter flat top cylinder liners and can be mixed or matched within an engine.

The factory shimmed cylinder liner will only be available in a kit, with the shim installed. However, the hardened brass shim is a serviceable part and will be available separately for purchase.



[SMALL](#) | [MEDIUM](#) | [LARGE](#)

Figure 1

CAUTION

Engines equipped with a factory shimmed cylinder liner assembly can not be repaired with a non-shimmed cylinder liner.

Description	New Part Number	Old Part Number
Brass Shim	4311637	NA
Cylinder Liner	4311633	2882764
Cylinder Liner Kit	4309389	4089153

NOTE: The factory brass shim, Part Number 4311637, can not be installed on any previous cylinder liner designs.

NOTE: The factory brass shim, Part Number 4311637, can not be used in place of the service shim for an engine with the cylinder block counterbores machined.

NOTE: It is acceptable to install a factory shimmed cylinder liner assembly, on top of a service shim, on engines that have had the cylinder block counterbores machined.

Jamestown Engine Plant implemented the new cylinder liner into production in phases.

Phase 1 targeted engines built for Australia and began on 22 May 2012. The engine serial number (ESN) first is 79583578.

Phase 2 targeted ISX15 CM2250 engines and began on 4 September 2012. The ESN first is 79608640.

Document History

Date	Details
2012-9-14	Module Created

Last Modified: 28-Sep-2012

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