

TECHNICAL SERVICE BULLETIN

BLACKWATER
E N G I N E S

TSB #:	CRMS100	ENGINE:	Cummins
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Cummins Rear Main Seal Installation Tool

All 5.9, 6.7 or 8.3 Cummins long blocks that require a single lip dry clutch seal ship with a # 3926126 rear seal & sleeve kit. Listed below are the Cummins service manual instructions and tooling part numbers for the correct installation procedure.. This tool is also required for the rear seal installation in a wet fly wheel housing application.

Use service tool, Part Number 3824078, to install the crankshaft seal/wear sleeve assembly, Install two (2) threaded studs into the crankshaft capscrew holes.

Apply a small amount of clean 15W-40 engine oil to the crankshaft, threaded studs, and the inside of the crankshaft rear seal/wear sleeve installation tool.

Reference Number	Part Number	Description
1	3163734	Plate
2	3163628	Stud
3	3163741	Hex Nut

Position the chamfered end of the wear sleeve (A) onto the end of the crankshaft (B).

Position the counterbore end of installation tool (C) over threaded studs and align with the wear sleeve, perpendicular to the end of the crankshaft.

Install the washers (D) and nuts (E) onto the threaded studs.

NOTE: The illustration shows a front gear train application with a rear crankshaft seal carrier. For rear gear train engines, the procedure for installing the crankshaft wear sleeve/seal into the flywheel housing bore is the same.

Alternately tighten the nuts ½ of a turn until the installation tool contacts the end of the crankshaft.

Do **not** exceed ½ of a turn of each nut to prevent wear sleeve binding and irregular stretch.

Torque Value: 20 n.m [177 ft-lb]

Remove the installation tool and the threaded studs.

