

Technical Service Bulletin Number
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TSB101596



Technical Service Bulletin

Subject

Cylinder Head and Main Bearing Capscrew Thread Repair

Original Topic Number: 05t1-9.

Warranty Statement

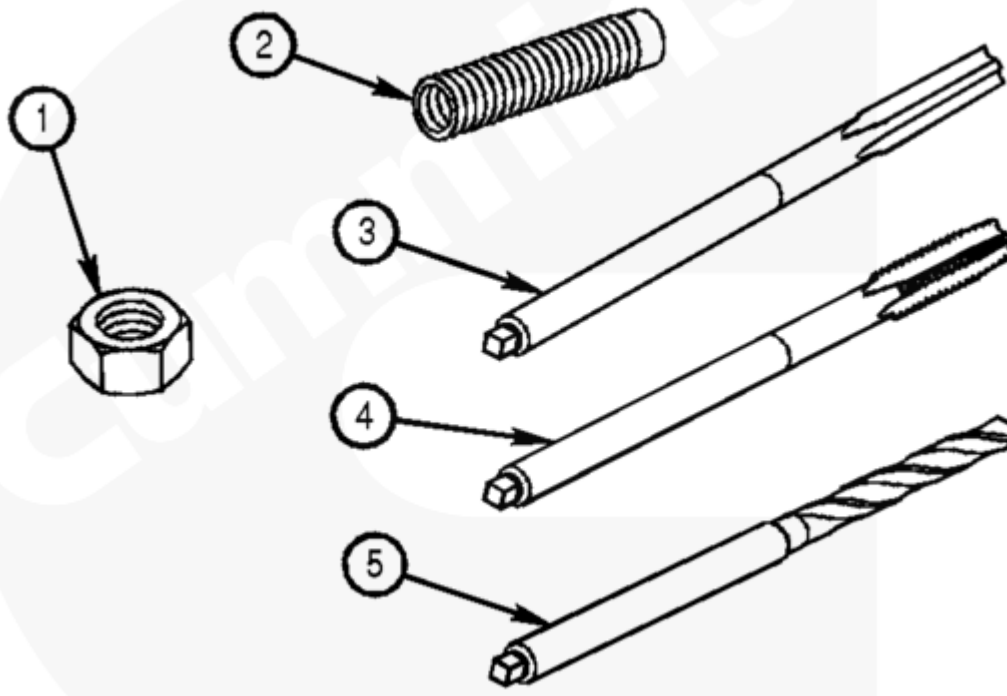
The information in this document has no effect on present warranty coverage or repair practices, nor does it authorize TRP or Campaign actions.

Contents

This document introduces the required components to salvage damaged cylinder head and main bearing capscrew hole threads on the ISX and QSX15 series engines.

The illustration and table below show the items required in addition to the thread salvage kit, Part Number 3164021.

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Figure 1, Items Purchased Separately.

Table 1: Items Use to Salvage ISX Main Bearing and Cylinder Head Capscrew Hole Threads		
Item Number	Part Number	Description
1	3163842	Jam nut
2	316445	Thread insert - 50 mm [2in]
2	3163717	Thread insert - 76 mm [3] in]
3	3163899	Reamer
4	3163901	Tap
5	31164335	Drill

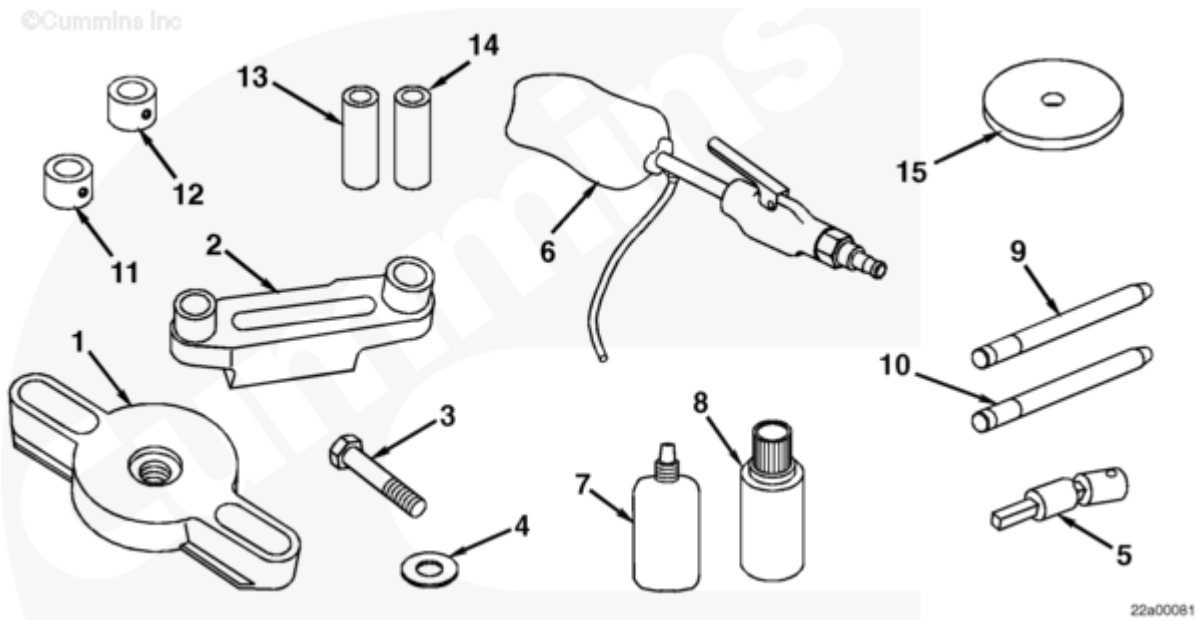


Figure 2, Thread Salvage Kit, Part Number 3164021.

1. Mounting plate
2. Drilling fixture
3. Hexagon head capscrews
4. Heavy washer
5. Universal drive socket
6. Chip vacuum
7. Thread-locking compound
8. Primer
9. Locating pin
10. Locating pin
11. Stop callar
12. Stop collar
13. Spacer
14. Spacer
15. Spacer

NOTE: Included in the thread salvage kit, but not shown, are plain washers and a storage case.

For Related Procedures reference to the following procedure. [Refer to Procedure 001-026 in Section 1.](#)

Document History

Date	Details
2015-8-24	Non-Product Problem Solving (PPS)

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