ACCOUNT TEAM COVERAGE

Please Deliver To: Service Managers and Warranty Decision Makers

FROM: Cummins Global Warranty Administration Communications

Subject: ISX15/X15 CM2350 Rocker Lever Replacement - EDS Guided ATC for Multiple Customers

Number: Atc2248 **Date:** 18-Oct-2019

Expires: 20-Oct-2022 (U.S./Canada)
20-Oct-2022 (International)

Attention: U.S. / Canadian Dealers
U.S. / Canadian Distr./Branches and Div. Offices (Automotive)

If additional information is required, please contact your Cummins Warranty Operations Group Leader.

DESCRIPTION:

This ATC is being issued to address suspect Valve Rocker Assemblies on certain X15 CM2350 X114B or ISX15 CM2350 X101 engines. This field action provides authorization for certified repair locations to replace the Intake and Exhaust Valve Rocker assemblies on eligible engines with assemblies that include improved oil delivery to the roller and pin interface.

NOTE: Necessary parts **must** be on hand before beginning this field action.

NOTE: This field action provides for retroactive coverage for repairs completed by Cummins authorized repair locations in anticipation of and prior to the release date of this publication.

ACTION:

In order to qualify for repair under this field action, an engine:

1 will be covered Regardless of coverage status, and

2 **must** show as OPEN on QuickServe® Online for this field action.

NOTE: The ESN list is attached for reference.

After verifying that the engine meets the above requirements, perform the following actions:

NOTE: Data is needed from each ESN that is either campaigned or repaired in the field. Using EDS or Guidanz, add a new DS with the Engine Serial Number, mileage, etc., and enter "Field Action for rocker lever" in to the fault code search field in EDS or Guidanz and follow the solution to provide the data necessary data.

- 1) Measure the valve lash. Refer to Procedure 003-004 of the appropriate Service manual. Record the values measure in inches starting from Cylinder 1 through Cylinder 6 in the applicable EDS solution. Here is an example of the request format, represented in inch measurements:
  - Intake: 0.014; 0.012; 0.013; 0.012; 0.011; 0.013
  - Exhaust: 0.025; 0.027; 0.024; 0.024; 0.025; 0.026
- 2) Remove the rocker lever assemblies and inspect the lever rollers. Please refer to Procedure 003-009 of the appropriate Service Manual and Service Bulletin 3666052.

Based on inspection results, follow the appropriate repair direction outlined below.

Repair Path A: If no damage is found, document the repair through the EDS solution S00006291 - "Rocker Levers-Non-Failed (Rocker Lever Check)";

- A.1) Complete installation of new Intake and Exhaust Valve Rocker Assemblies. Please refer to Procedure 003-009 of the appropriate Service Manual.

  NOTE: Rocker levers **must** be lubricated as directed. Failure to lubricate the rocker lever as directed can cause extensive engine damage. Please refer to the Assemble section of Procedure 003-009.
- A.2) File one claim for **only** the applicable parts and labor listed in this field action.

Repair Path B: If the Rocker Lever Rollers are found damaged document the repair through EDS solution S00006294 "Rocker Levers-Failed (Camshaft Check)"

- B.1) Complete installation of the new intake and exhaust valve rocker assemblies. Please refer to procedure 003-009 of the appropriate Service Manual.

NOTE: Rocker levers **must** be lubricated as directed. Failure to lubricate the rocker lever as directed can cause extensive engine damage. Please refer to the Assemble section of Procedure 003-009.

- B.2) Document the Cylinder Location and lever position of the failed Rocker levers. Record the values under EDS solution S00006294 in the comments field. Please refer to Attachment B for a graphic illustration of the Cylinder and Lever location details.
- B.3) Please refer to Service Bulletin 3666052 Camshaft Reuse Guidelines for Cummins Engines with Roller Followers or Roller Tappets for cam reuse and repair direction.

  NOTE: Any Camshaft repairs done in accordance with Service Bulletin 3666052 CANNOT be filed to this field action and **must** be filed to applicable coverage.
- B.4) File two claims:
- B.4) a) File one claim to this campaign for **only** the applicable parts and labor listed in this field action.
- B.4) b) The remainder of the repair cost directed by Service Bulletin 3666052 should be filed per TRP#2249.

MATERIAL DISPOSITION:

Materials removed as a result of this field action **must** be returned to Cummins. Parts flagged via the Cummins Enhanced Parts Return (EPR) process should be returned following the stated instructions. Please return the parts to:

Cummins Service Support Center

910 S. Marr Road, Receiving Location 35

Columbus, IN 47201

Attn: Service Support Center Manager

Email: ssc@cummins.com

NOTE: Parts covered by the Field Action are to be returned to the Cummins Service Support Center. Please include a copy of the claim paperwork and a material return tag with the returned parts. Include the ESN number, the ATC #2248, and the claim number on the material return tag. For Cummins returns, record WebCumpas# on the outside of the box. For PACCAR returns, record CRA# or Eztrac#.

REIMBURSEMENTS:

Parts:

The following parts are covered under this field action:

Part Number	Quantity	Description
557946700	1	KIT,LEV

NOTE: SRTs to gain access that are required to complete the repair, that are sufficiently explained in the claim narrative, may also be claimed on this action.

Labor using applicable Access Code and Time:

SRT Code	Description	Time
00-139	Part Photograph/ECM Images/Datalogs to Factory Service Group	
00-400	Steam Clean - Single Component Repair	
00-90X	Administrative time	
03-056	ROCKER LEVER ASSEMBLY - REMOVE AND INSTALL, ALL - X15 CM2350 X114B (OPTIONAL)	
03-108	ROCKER LEVER ASSEMBLY - REMOVE AND INSTALL, ALL (OPTIONAL)	
99-902	CYLINDER PLACE AND VALVE LASH MEASUREMENT (QTY 3)	

Travel:

Travel is covered under this field action. Towing is **not** covered under this field action.

Other Claimables:

Consumables are **not** covered under this field action.

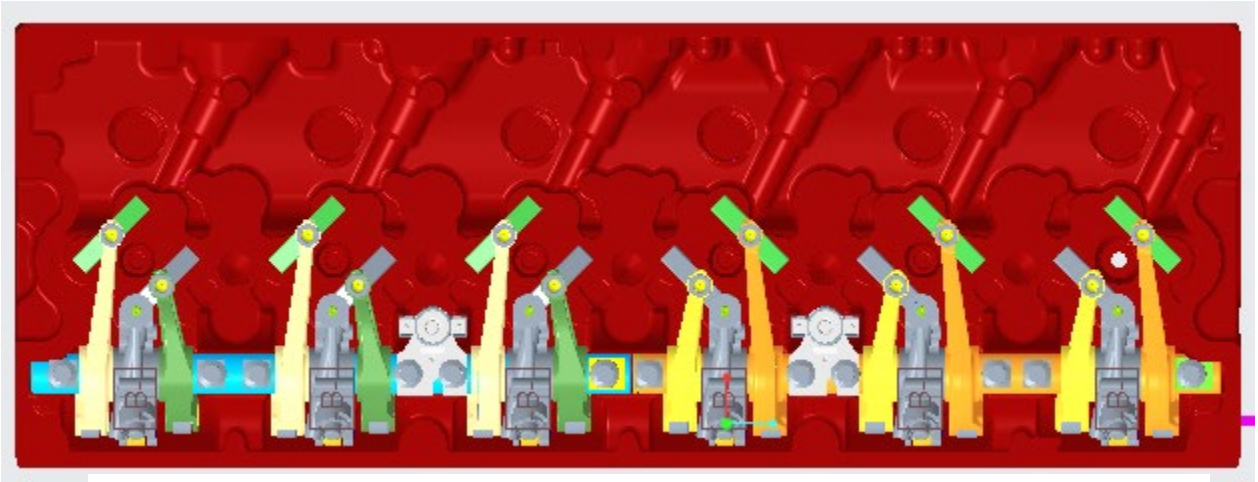
Claim Instructions:

For Cummins Dealers, claims for this Field Campaign **must** be filed via **RAPID**SERVE™ Web (rsw.cummins.com). For information regarding **RAPID**SERVE™ Web, please reference the "Warranty" tab in QuickServe® Online. If there are additional questions, please contact your local Cummins Distributor.

Account Code: 27
Pay Code: ..... Distributor = X
Pay Code: ..... Dealer = D
Pay Code: ..... International = I
Failure Code: ..... WRAVII

Attachments
atc2248_esn-list.xlsxatc2248_cylinder_position_and_level_location_attach-b.pdf

Front of Engine →



Cyl. 6 Cyl. 5 Cyl. 4 Cyl. 3 Cyl. 2 Cyl. 1

1. Intake Lever positions are identified by the longer lever pictured above
2. Exhaust Lever positions are identified by the shorter* lever pictured above

*The short lever located between the intake and exhaust levers is the brake lever