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Coding Information

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Title: A26 Connecting Rod Replacement Process

Applies To: All A26 engines built prior to 11/2019

CHANGE LOG

9/15/2025 - Removal of NED notations, and changes to SDS
2/3/2025 - Cleaned up old information
6/27/2024 - Clarified campaign is no longer paused
12/4/2023 - All PWR CYL campaigns were reactivated
9/21/2023- Included note on pausing campaigns. Included inspection times
9/18/2023 - International has temporarily paused proactive repair activity due to supplier constraints
8/31/2023- Included inspection summary for PWR CYL KITs
8/15/23 - Added SRTs for HX and HV
5/22/23 - Added quality hold alert to 2517649C93
4/4/2023 - Updated Proactive vs Reactive verbaige. Clarified completing 20504, 21505, and 22518 post repair. Added blurb to open case for torque data
2/17/2023 - Updated Broken Links. Updated verbaige
11/07/2022 - Updated: Authorized Dealer List / Updated Repair Instruction Flow / Transition from Blue Tag to Warranty Return
05/17/2022 - Updated Authorized Dealer List

DESCRIPTION

The purpose of this article is to describe all aspects of the A26 Connecting Rod Replacement Repair Processes.

To address an A26 connecting rod supplier quality spill, International is streamlining quality repair strategies to help avoid customer disturbance.

International is implementing connecting rod replacements which results in less downtime and damage avoidance.

SPECIAL TOOL(s) / SOFTWARE

Tools listed below should be available and in good working condition prior to the start of the repair to avoid any delays in the completion of the work.

Note: Other tools are required, refer to the service manual for the detailed list

Note: Always ensure calibration on Digital Torque Wrench is up to date

Note: International shipped Cylinder Kit Puller 12-192-01 to high A26 traffic dealer locations.

Tool Description	Tool Number	References
Cylinder Kit Puller Tool	12-192-01	TL1200005
Snap-On Digital Torque Wrench	CTECH3FR250A	IK1201391
Cylinder Head Lifting Bracket	12-342-03	
Engine Barring Tool	12-102-02	
Socket, ConRod Bolt (E18 TORX)	ZTSE4835	
Socket, Head Bolt (E24 TORX)	ZTSE4787	
Head Bolt Bottoming Tap	ZTSE4855	
Gauge, Cylinder Liner Height	ZTSE2515A	
Liner Protrusion Clamps	ZTSE4825	

SERVICE PARTS INFORMATION

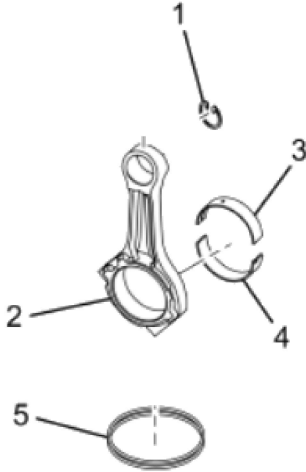
The following parts are required for Connecting Rod Replacement Repair:

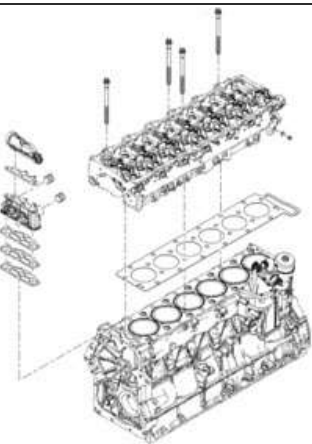
NOTE: Week of 5/15/23, 2517649C93/4 was placed on a quality hold. Inventory will be corrected and revised to 2517649C96.

NOTE: To install Assembled Power Cylinder Assembly, Red Cylinder Cap Plug 2523516C1 is available in PDC - It is reusable

Kit Description	Part Number	Quantity
Kit, Cylinder Head Removal & Installation	2517038C92	1
Kit, Power Cylinder	All repair should utilize 2517649C9*	6
Gasket, Oil Pan	3003425C2	1
Seal, O-Ring (Pick up tube)	06569361612	1
Kit, Oil Filter	3007498C94	1

Below table displays the differences between the parts kits:

Description	Part Number	Notes	Visual Description	Instructions
POWER CYLINDER KITS				
Kit, Reduced Power Cylinder	2522946C9*	1. RETAINER, PISTON PIN 2. ROD ASSEMBLY, CONNECTING 3. BEARING, CONNECTING ROD UPPER 4. SHELL, BEARING LOWER STANDARD 5. O-RING, CYLINDER SLEEVE 139.4 X 3.95		4328817R1
A26 Power Cylinder Kit (Assembled)	2517649C9*	Power Cylinder Assembly is Pre-Assembled with New Components		Disassembly: Power Cylinder Assembly Removal
A26 REMANUFACTURED POWER CYLINDER KIT (Assembled)	5012252R91	Power Cylinder Assembly is Pre-Assembled with New Components and a Remanufactured Piston		Assembly: 2017 A26 Manual > Power Cylinder Assembly > Installation
CYLINDER HEAD REMOVAL KITS				

Reduced Cylinder Head Removal Kit, R&I	2517038C92	Contains Components Required for Cylinder Head Removal and Installation (R&I)		
Full Cylinder Head Removal Kit	2517611C92	Contains Components Required for Cylinder Head Replacement		

REPAIR STEP(s)

WARNING! To prevent property damage, personal injury, and / or death, park vehicle on a hard, flat surface, turn the engine off, set the parking brake, and install wheel chocks to prevent the vehicle from moving in either direction.

WARNING! To prevent property damage, personal injury, and / or death, if the vehicle must be raised, do not work under the vehicle supported only by jacks. Jacks can slip or fall over.

WARNING! To prevent personal injury and / or death, always wear safe eye protection when performing vehicle maintenance.

WARNING! To prevent property damage, personal injury, and / or death, keep flames or sparks away from vehicle and do not smoke while servicing the vehicle's batteries. Batteries expel explosive gases.

WARNING! To prevent property damage, personal injury, and / or death, remove the ground cable from the negative terminal of the battery box before disconnecting any electrical components. Always connect the ground cable last.

NOTE: Campaigns 20504, 21505, and 22518 do **NOT** need to be completed. After warranty claim submission, campaigns will be marked complete

Refer to TIPS video for best practices Learning Management System (NavistarEducation.com)> TIPS> Power Cylinder Kit Installation & Best Practices (9273)

1. Park vehicle on a flat surface
2. Shift transmission into Park or Neutral and set parking brake
3. Turn ignition to Key OFF position
4. Install wheel chocks

NOTE: OPEN TECHNICAL SERVICE CASE FILE TO UPLOAD TORQUE DATA

5. Remove Cylinder Head [0000870980 2017 A26 Engine Service Manual](#)

6. Replace 6 Connecting Rods: (Cylinder Kit Puller NOT Required)

If equipped with Cylinder Kit Puller 12-192-01: Follow [Power Cylinder Assembly Removal Service Manual \(Draft 1\)](#)

- i. Reduced Power Cylinder Kit (2522946C92): [Instructions 4328817R1](#)
- ii. Assembled Power Cylinder Kit (2517649C93): [2017 A26 Manual> Power Cylinder Assembly > Installation](#)

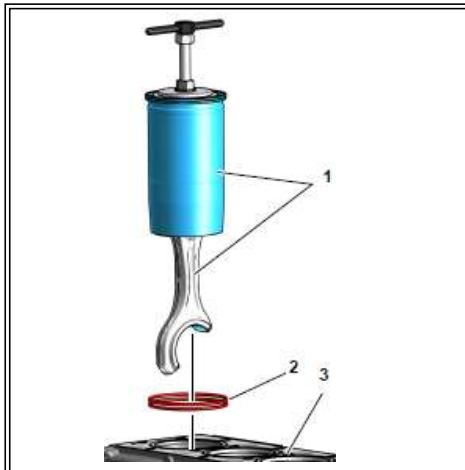


Figure #: Power Cylinder Assembly and Cylinder Puller Kit

Item 1: Power Cylinder Assembly
Item 2: Cylinder Sleeve O-rings
Item 3: Engine Block

CAUTION:

Ensure Piston, Connecting Rods, Piston Pin Retainer, and Connecting Rod Bearings ORIENTATION is correct prior to assembly

6A. TORQUE DATA

(PSET 1) Target Torque: 22.0 ft/lb (30 Nm), Minimum Torque: 22.0 ft/lb (30 Nm), Maximum Torque: 23.0 ft/lb (31.1 Nm), batch (2).

- If results are above 25 ft/lb, loosen both of the rod bolts and retorque within the proper range

(PSET 2) Target Torque: 77.0 ft/lb (105 Nm), Minimum Torque: 77.0 ft/lb (104.3 Nm), Maximum Torque: 78 ft/lb (105.7 Nm), batch (2).

- If torque results are above 80 ft/lb, replace both of the rod bolts and start at step 1

(PSET 3) Target Angle: 90 degrees, Minimum Angle: 90 degrees, Maximum Angle: 91 degrees, batch (2).

- If torque results are 93 degrees or higher, replace both of the rod bolts and start at step 1
- Verify the final torque value is within a minimum of 95 ft/lb to a maximum of 150 ft/lb. If any are out of range, replace both of the rod bolts and start at step 1. Typically the final torque values for all 6 rods will be fairly consistent if done correctly
- Maximum torque variance on a single rod is 20 ft/lb. If that value is exceeded, replace both of the rod bolts and start at step 1

7. Install Cylinder Head [0000870980 2017 A26 Engine Service Manual](#)

8. Follow Engine Assembly procedures (Oil priming, fluid levels, MAF calibration, break-in procedure)

9. Install ECM Template

NOTE: A parameter template must be installed in the engine ECM via **SDS** after the repair is complete. This must be done before the truck is returned to service. [IK1201473 - Recall 22518 SDS Template to Enable Con-Rod](#) can be followed for basic template programming instructions, but the template within the article **SHOULD NOT** be installed if connecting rod replacement has occurred. The template from this article will ENABLE knock detection, while the goal after repairs, is to DISABLE knock detection.

i. Download Template - [Knock Detection Template](#)

NOTE: Template is currently a zip file. Open the zip file and extract the template to your desktop before trying to load it into SDS.

ii. ApplyTemplate

- iii. Look up parameter 3900 and verify it is set to "Knock Detection Disabled". A fresh health report can also be pulled, and verified similar to the IKNOW article listed above (IK1201473), but it should read "EBP Knock Detection Disabled"



BEST REPAIR PRACTICES

Shop Environment:

- Work area must be clean. Contamination to following components can lead to premature engine failure:
 - Crankshaft, Cylinder Sleeve
 - Engine Lubrication and High-Pressure Fuel Systems
 - Front and Rear Gear-Train

Steam Clean Engine and Engine Compartment: IF REQUIRED

- Prior to engine disassembly, remove contaminants that are built up around the EGR Cooler, Exhaust Manifold, Cylinder Head, Fuel System, and Oil Pan
- Properly cover electronics and open entrances

Engine Block and Cylinder Head Preparation for Assembly:

- Do **NOT** use an abrasive disc or wire wheel
- Utilize recommended tools to clean cylinder head, block deck surface, liner flanges, and counterbores
 - 3M Roloc Bristle cleaning disc "Green" or "Yellow" to clean surfaces
 - 3M Scotch Brite "Maroon" pads

Engine Preparation and Assembly:

- Clean components with brake cleaner or solvent
 - Do **NOT** use brake cleaner or solvents to clean NEW Connecting Rod Bearings
 - Air or blow dry components
- Clean all oil and residue from the backside of the connecting rod bearings and saddle surfaces of the connecting rods
- If required, store cleaned components in plastic bags to reduce contamination
- Utilize the proper lubrication
 - Utilize **P-80 LUBRICANT** to lubricate Cylinder Sleeve and new Cylinder Sleeve O-rings
 - Utilize **LUBRIPLATE 105** to lubricate new Connecting Rod Bearings

Connecting Rod Cap Installation:

- Ensure proper torque wrench settings are programmed prior to use. Reference [IK1201391](#)
- Add clean engine oil to the first 3 to 4 threads and washer surface of each new connecting rod bolt
- Initially seat the connecting rod cap and install bolts by hand. Alternate back and forth to seat the cap flush prior to torquing
- Alternate back and forth starting with: 2x each 22 (ft-lb), 77 (ft-lb), 90 degrees
- Anytime connecting rod bolts are replaced the connecting rod cap needs to be removed and ensure the connecting rod cap are centered

Torque Wrench Operation:

- Ensure your torque wrench has been calibrated by an authorized Snap-On repair facility. Reference [IK1201391](#)
- Torque wrench calibration / Snap-On repair center. Reference [TL2900164](#)

Torque Wrench Data Review (Connecting Rod Bolts):

- Ensure (36) lines of data is recorded. Reference [IK1201391](#)> Section [Viewing Torque Wrench Data](#)
- If an over-torque occurs at 22 or 77 ft-lb both Connecting Rod Bolts can be backed off and retorqued
 - Ensure retorque process begins at 22 ft-lb
- If an over-torque occurs at 90 degrees both Connecting Rod Bolts need to be replaced
 - Connecting Rod Bolts are torque to yield. **DO NOT REUSE**

Post Repair & Road-test:

- Ensure knock calibration has been disabled
- Prior to engine start-up perform Engine Oil Priming Procedure listed within A26 engine service manual
- Vacuum test cooling system prior to fill
- Fill cooling and engine oil to proper levels
- Monitor oil pressure gauge for the first minute
- Idle engine for 30 minutes, no excessive RPM changes
- Listen for unusual noises
- Prior to road-test inspect engine for coolant and oil leaks
- Road-test vehicle for 60 minutes
- After proper engine operation has been verified, inspect engine for leaks
- Perform post repair Health Report

FAQ

- 1. Will this repair be exempted from the Repair Velocity metrics?**
 - a. The repair is being handled the same as engine replacement, which are not removed. The Repair Velocity target was set with engine replacement volume included.
- 2. How are parts orders managed for the connecting rods?**
 - a. Once the repair path is determined, the parts will be sent automatically, no need to order connecting rods.
 - b. Our parts expeditors use a Child Case File and the PO for the parts shipment is the Connecting Rod replacement Case File.
- 3. Is the oil replacement covered through the warranty claim?**
 - a. Yes, oil is covered.
- 4. Can you change the connecting rods from the bottom of the engine without removing the cylinders?**
 - a. No, there is not enough room to remove the wrist pin.

WARRANTY INFORMATION

- ***As of 11/7/22 - International will discontinue Blue Tag returns for A26 Connecting Rods and transition to the International Product Review Center (PRC) Warranty part return process***
- ***ALL connecting rods and bearings may be called back under appropriate Return Authorization (RA) form within the Warranty Claim Processing Portal (currently iClaim)***
- Refer to WPL2800136 for Digital Torque Wrench policy
 - Issues with wrench, reference [TL2900164](#)

Inspections should be included within the claim as T-time

2517649C93 - 0.2Hr

2517649C94 - 0.1Hr

Standard Repair Time(s):

Labor Op	Labor Description	HRs	Elemental Steps	Notes
LT12-1146UV-20	Connecting Rod, Replace	23,4	Link	• Utilizing CYL KIT PULLER • Utilizing <u>Reduced</u> PWR CYL KIT • Torque Data Upload • Includes packaging Blue Tag parts
RH12-1146UV-20	Connecting Rod, Replace	23,4	Link	• Utilizing CYL KIT PULLER • Utilizing <u>Reduced</u> PWR CYL KIT • Torque Data Upload • Includes packaging Blue Tag parts

LT12-1146UV-22	Complete Power Cylinder Assembly, Replace	21.7	Link	- Utilizing CYL KIT PULLER - Utilizing <u>Assembled</u> PWR CYL KIT - Torque Data Upload - Includes packaging Blue Tag parts
RH12-1146UV-22	Complete Power Cylinder Assembly, Replace	21.7	Link	- Utilizing CYL KIT PULLER - Utilizing <u>Assembled</u> PWR CYL KIT - Torque Data Upload - Includes packaging Blue Tag parts
HX12-1146UV-20	Connecting Rod, Replace	23.4	Link	- Utilizing CYL KIT PULLER - Utilizing <u>Reduced</u> PWR CYL KIT - Torque Data Upload - Includes packaging Blue Tag parts
HX12-1146UV-22	Complete Power Cylinder Assembly, Replace	21.7	Link	- Utilizing CYL KIT PULLER - Utilizing <u>Assembled</u> PWR CYL KIT - Torque Data Upload - Includes packaging Blue Tag parts
HH12-1146UV-20	Connecting Rod, Replace	23.4	Link	- Utilizing CYL KIT PULLER - Utilizing <u>Reduced</u> PWR CYL KIT - Torque Data Upload - Includes packaging Blue Tag parts
HH12-1146UV-22	Complete Power Cylinder Assembly, Replace	21.7	Link	- Utilizing CYL KIT PULLER - Utilizing <u>Assembled</u> PWR CYL KIT - Torque Data Upload - Includes packaging Blue Tag parts
	ECM Template	0.5		Only if required

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