

Enginetech Inc
For Technical Assistance Call:
1-800-410-3664 ext 340 or ext 237

TECHNICAL BULLETIN	
	September 2004 TB 2196
Mfg:	FORD
Model:	F-SERIES
Liter:	7.3L
V I N:	F
Year:	95-05

New End Plug Oil Control Method For
1994-2003 Navistar 7.3L Diesel Engines

AERA members have reported engine oil leaks on 1994-2003 Navistar 7.3L diesel engines. This leakage most often occurs shortly after cylinder head service has been completed.

To reduce the likelihood of reoccurring leaks, a new end plug and sealing system have been designed. These components are available only in a kit form with Part #1827535C94. Individual components are no longer available.

To install the plugs, follow the procedure listed below.

1. Remove and discard old end plug, back up ring and O-Ring from cylinder head.
2. Using a clean, dry, lint free cloth and brake cleaner, clean cylinder head internal threads of dirt, loose particles and any foreign material. Dry thoroughly with a clean dry lint free cloth.
3. To assure a proper seal, be sure to prevent any foreign material or brake cleaner from getting into the oil rail passage.
4. Lubricate new back up ring and new O-Ring with clean engine oil prior to installation onto new end plug. Install back up ring and O-Ring onto end plug. TO ASSURE A PROPER SEAL, BE CAREFUL, NOT TO GET ENGINE OIL ONTO THREADS OF END PLUG.
5. Apply a small bead of Loctite® #277 around threads of the new end plug.
6. Install end plug into cylinder head oil rail port. Tighten to the special torque value of 60 ft/lbs (81 NM). DO NOT START ENGINE FOR A MINIMUM OF ONE (1) HOUR. THIS ALLOWS THE LOCTITE® TO CURE.

Figure 1. Back Up Ring And O-Ring Locations On Cylinder Head End Plug

1. Cylinder Head Oil Rail End Plug
2. Back Up Ring

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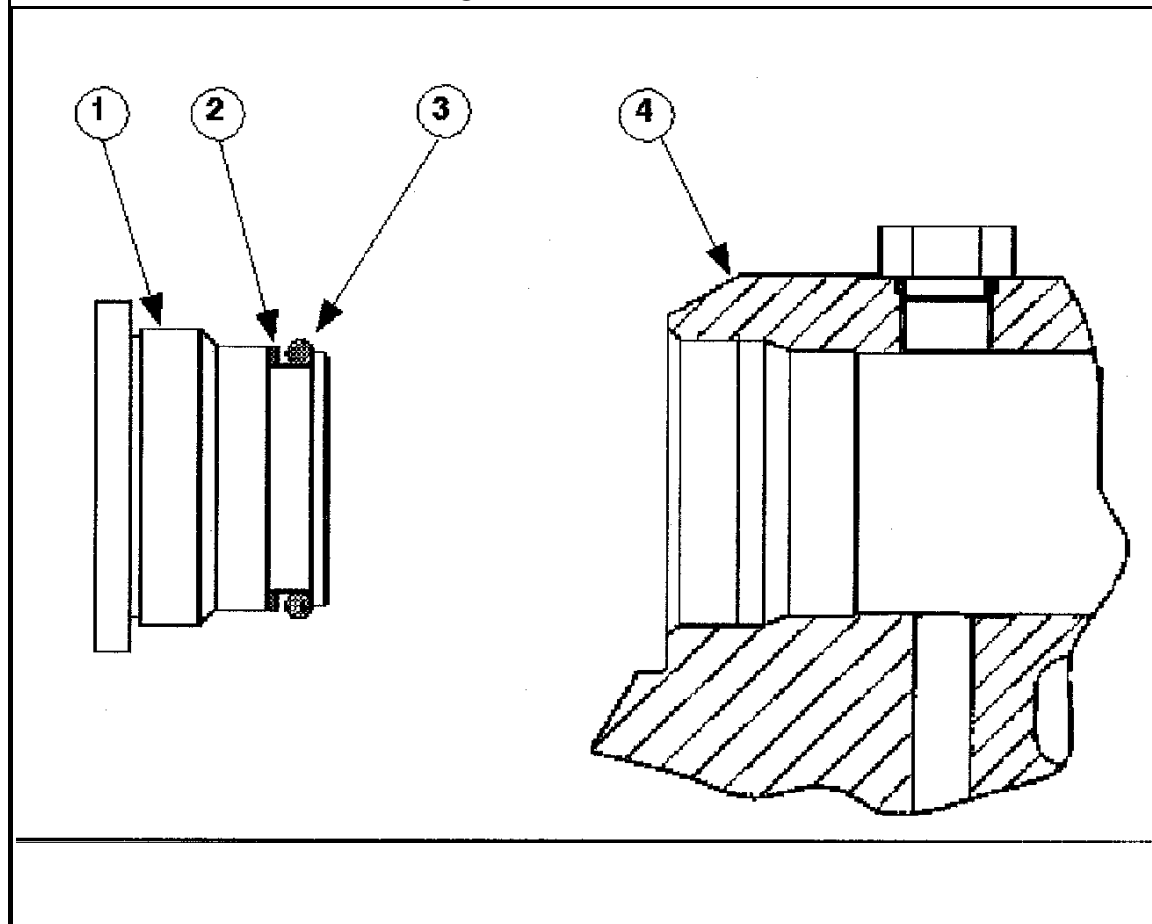
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3. O-Ring
4. Cylinder Head

The AERA Technical Committee

Bulletin Diagram: FIGURE 1. Back Up Ring And O-Ring Locations - CYLINDER HEAD



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