



Installation Instructions

18SP633 – Install Low-Pressure Regulator Water Seal (P/N: 23535247)

KIT DESCRIPTION

This kit includes the parts required to repair CNG low-pressure regulator P/N 23528950.

KIT CONTENTS

This kit contains the parts listed in Table 1.


Part Number	Quantity	Description
—	1	Water Seal Gasket
—	6	Heat Exchanger Cover Screw
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Table 1 Content for Service Kit (P/N: 23535247)

INSTALLATION PROCEDURE

Install the water seal kit as follows (see Figures 1-5):

 WARNING:
PERSONAL INJURY
To avoid injury from hot surfaces, wear protective gloves, or allow engine to cool before removing any component.

 WARNING:
PERSONAL INJURY
To avoid injury from accidental engine startup while servicing the engine, disconnect/disable the starting system.

! WARNING:

EXPLOSION

To avoid injury from an explosion of natural gas, the following precautions must be taken:

- Do not smoke when installing or servicing the engine or fuel system.
- Installation or servicing of natural gas equipment must only be conducted in well ventilated, natural gas-compatible areas. Do not install or service equipment in an enclosed area where ignition sources are present without first ensuring that an undetected gas leak may be safely vented without being ignited.
- Natural gas fuel systems are pressurized. Relieve pressure from any fuel system component prior to installation or service of that component. Bleed natural gas lines before installing or servicing any component connected to the fuel lines.

1. With the engine shut down and at ambient temperature (cool to the touch), refer to the current *Series 50 Service Manual*, 6SE50 or the current *Series 60 Service Manual*, 6SE483, and depressurize the fuel system. Remove the CNG low-pressure gas regulator.
2. Remove and discard the six (6) cover-retaining screws. See Figure 1.

NOTE: The original cover screws are shorter than the new screws and must not be reused.

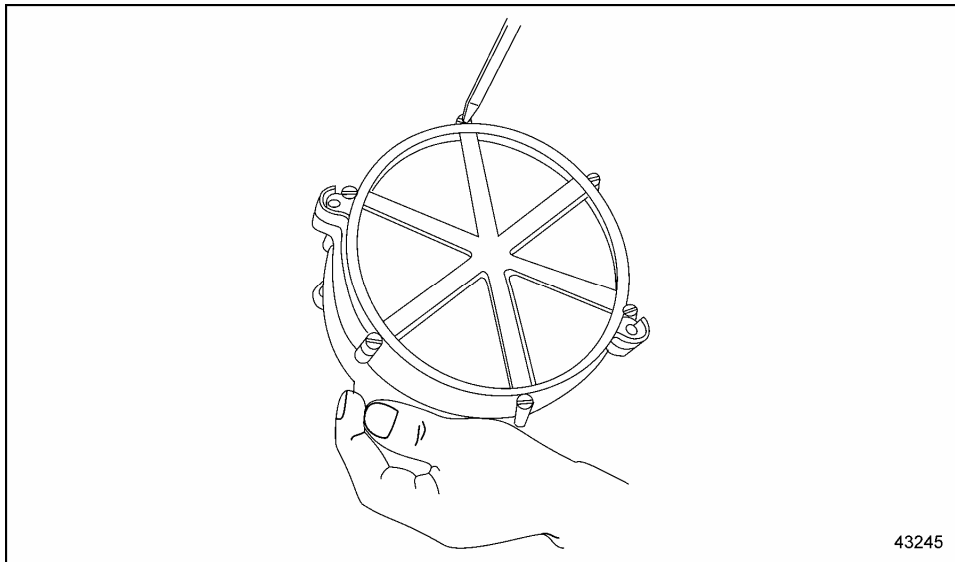


Figure 1 Remove Cover Screws from Regulator

3. Carefully separate the cover and gasket from the regulator body and place on a clean work surface.

NOTICE:

Failure to remove potential contaminants before assembling the regulator may lead to inefficient regulator operation, which could reduce gas pressure, causing engine stalling.

4. Remove the gasket and all residual gasket or sealing material from the regulator cover and body. Clean mating surfaces with pure mineral spirits and wipe dry. See Figure 2.

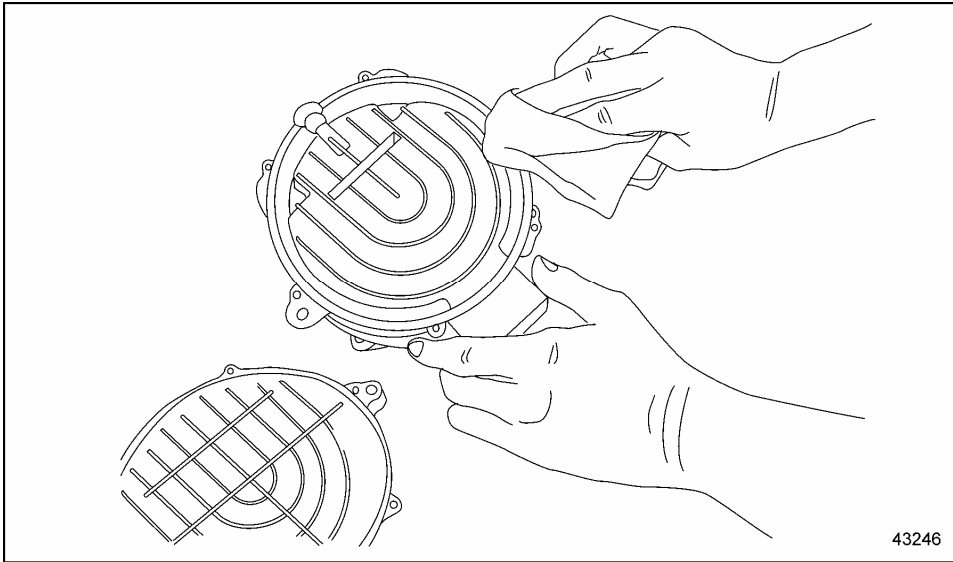


Figure 2 Clean Regulator Cover and Body Mating Surfaces

5. Inspect cover and body sealing surfaces for cracks and corrosion. If cracks or corrosion are found, the unit is not repairable and must be replaced.
6. If no cracks or corrosion are found, install the new gasket onto the regulator body, aligning the index holes as shown. See Figure 3.

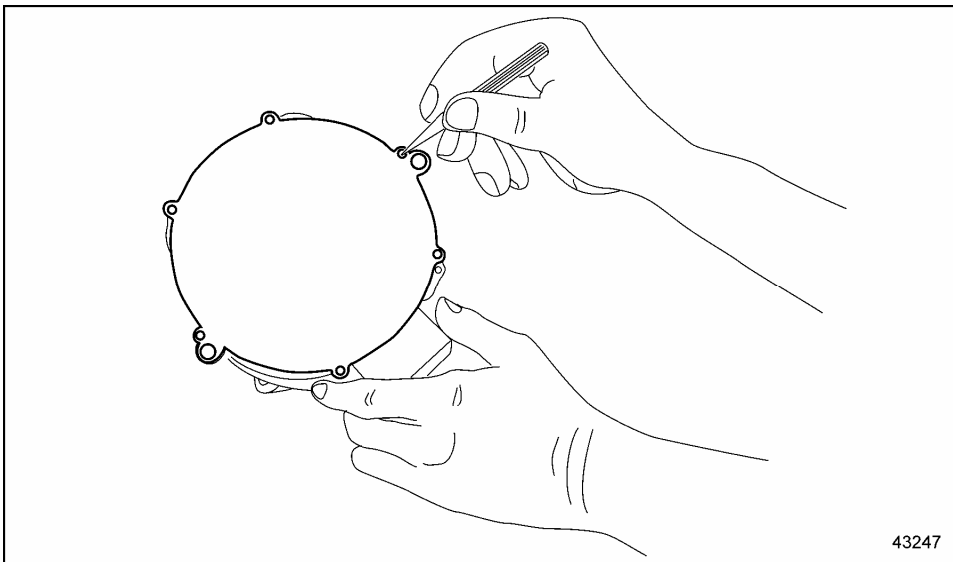


Figure 3 Align Gasket Index Holes with Regulator Body

7. Install the cover onto the body aligning the cover with the proper bolt holes. Install the six (6) new screws and tighten evenly until bolt heads contact the cover plate.
8. Using a criss-cross pattern, torque screws to 30 lb·in (3.9 N·m). See Figure 4.

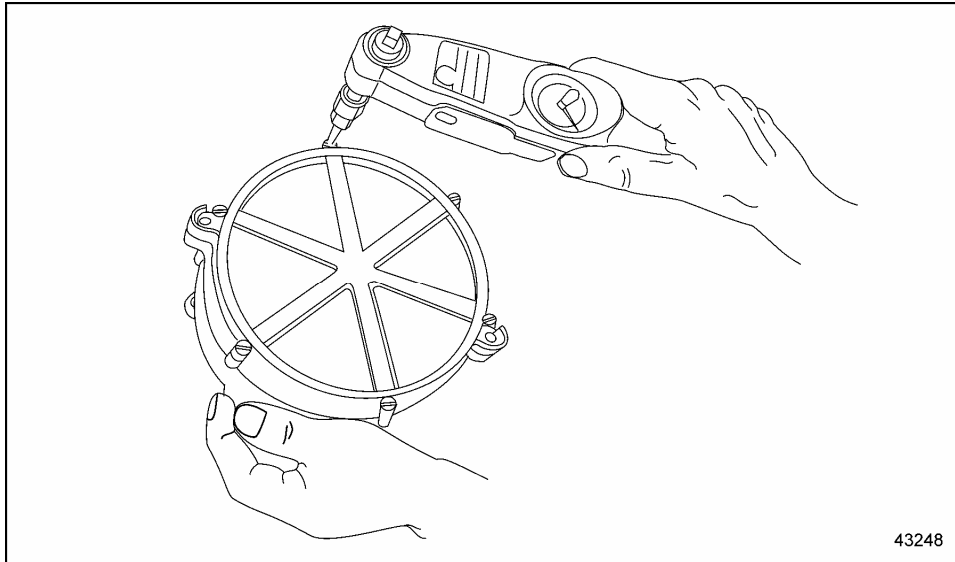


Figure 4 Torque Cover Screws to Specification

9. Refer to the current *Series 50 Service Manual* (6SE50), or the current *Series 60 Service Manual* (6SE483), and install the CNG gas regulator onto the engine.
10. After installation, pressurize the fuel system and check for gas leaks. Repair leaks are required.
11. Start the engine and check for proper regulator valve operation.
12. Shut down the engine.

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