



Installation Instructions

18SP451 — Install Valve Adjusting Screw Service Kit 23522728

Introduction

Certain Series 50[®] engines manufactured prior to serial number 04R0015542 which were built with improved balance shafts may experience low oil pressure at idle. Low oil pressure is defined as less than 15 psi (103 kPa) at idle. This condition is caused by the increased lubrication requirements of the improved balance shafts. To eliminate the potential for low oil pressure at idle on these engines, service kit 23522728 has been released. Components of this kit are listed in Table 1.

Part No.	Qty.	Description
23520818	8	Unitized Adjusting Screw Assembly, Intake Valve
23520819	8	Unitized Adjusting Screw Assembly, Exhaust Valve
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Table 1. Valve Adjusting Screw Kit 23522728

Identification

Unlike the former screws, the new intake valve adjusting screw assemblies have no center drilled oil passage or cross-drilled annulus in the threaded area. They have a smaller allen socket head (5/32 in. vs. 3/16 in.) and a turned-down area around the allen socket which is visible when the screw assembly is installed in the rocker arm.

NOTE:

The intake and exhaust valve adjusting screw assemblies in this service kit are intended for installation in the drilled rocker arms of Series 50 engines *built prior to unit serial number 04R0015542 which have improved balance shafts*. Effective with this unit, rocker arms are no longer drilled. When properly installed, the new valve adjusting screw assemblies will increase engine oil pressure at idle, providing optimum lubrication to valve operating mechanism components. Installation of the new screw assemblies on engines built after unit number 04R0015542 will not affect gallery oil pressure.

NOTICE:

The *intake* valve adjusting screw assemblies in this kit are not interchangeable with the current injector adjusting screws. If a new intake valve adjusting screw assembly is installed in an injector position, premature wear-out of the screw will result.

Installation

To install the new valve adjusting screw assemblies, refer to section 1.3 of the current *Series 50 Service Manual* (6SE50) and proceed as follows:

1. Remove the valve and injector rocker arm assemblies.
2. Remove the former intake and exhaust valve adjusting screws and replace with the screw assemblies in the kit.
3. Replace the valve and injector rocker arm assemblies.
4. Refer to section 12.2 of the service manual to adjust intake and exhaust valve clearances and set injector heights.

NOTE:

Unitized adjusting screw assemblies 23520818, 23520819, and 23520820 can be used on any Series 50 or Series 60[®] engine.

