



Torque Plate Required for Cummins B Series Diesel Engines

The AERA Technical Committee offers the following information on torque plate usage for Cummins B series diesel engines. These engines are inline four and six cylinders with the 4.2126" (107.000 MM) cylinder bores.

The following table summarizes what repair sleeve and service tools to use, depending upon engine type. Cummins officially announced the availability of a cylinder salvage sleeve (repair sleeve) for the 4.2126" (107.000 MM) bore for the ISB & QSB engines in January of 2013. Aftermarket sleeves have been used for repair operations since the inception of the 4.2126" (107.000 MM) bore engines.

Engine Displacement (L)	Nominal Bore (mm)	Machined Bore Diameter For Sleeve Installation (mm)	Salvage Sleeve Part Number	Sleeve Driver Part Number	Use of Torque Plate, Part Number 2892406 (Optional/Required)
5.9	4.0157" (102.00 MM)	4.1142-4.1148" (104.500-104.515)	3904166	3823230	Optional
4.5 RGT	4.2126" (107.000 MM)	4.3189-4.3195" (109.700-109.715)	4919951	2892407	Required
6.7	4.2126" (107.000 MM)	4.3189-4.3195" (109.700-109.715)	4919951	2892407	Required

While the above chart lists the use of a torque plate optional for the 4.0157" (102.00 MM) bore size engines, many AERA machine shops routinely use a torque plate on those blocks for optimum engine performance.

Cummins also reports it is acceptable to repair in any variation of stock, oversized, and sleeved cylinders. Mismatching will not affect the rotating balance of the power cylinder components and this condition may occur during warranty procedures.