

Crankshaft Installation on 2007-16 Cummins/Dodge 4.5 & 6.7L Diesel Engines

The AERA Technical Committee offers the following information regarding the crankshaft installation for 2007-16 Cummins/Dodge 4.5 & 6.7L diesel engines. This information is being provided to show the difference in the proper torque values, depending on the bolts used.

Cummins/Dodge has determined the desired clamping force applied to the crankshaft main bearing bolts differs if new or previously used bolts are used. Refer to the following values and steps for the bolts being used at the time of engine assembly.

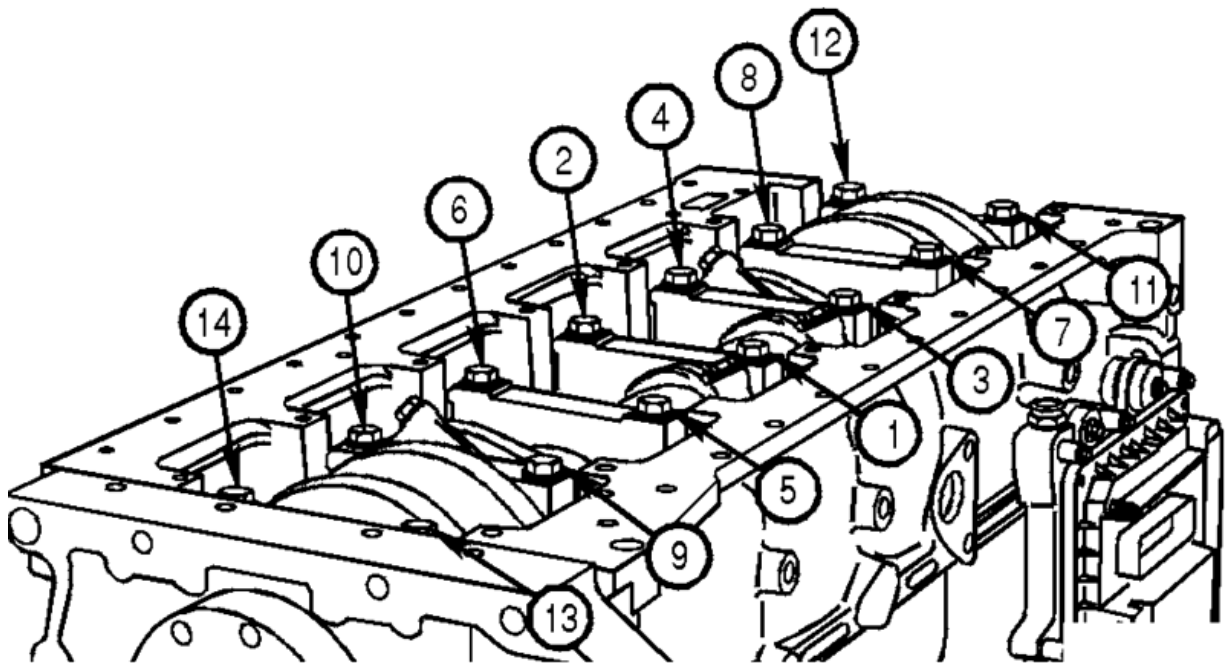


Figure 1. 6.7L Main Bearing Bolt Torque Sequence

Torque Value:

Previously Installed Main Bearing Bolts

1. 37 FT/LBS (50 Nm)
2. 44 FT/LBS (60 Nm)
3. 59 FT/LBS (80 Nm)
4. Rotate Bolts 90° More

Torque Value:

New Main Bearing Bolts

1. 89 FT/LBS (120 Nm)
2. Loosen ALL Bolts Completely
3. 44 FT/LBS (60 Nm)
4. 63 FT/LBS (85 Nm)
5. Rotate Bolts 120° MORE