

Service Letter

Service Letter No. 393 July, 1994

SUBJECT: Replacement of 401A/B/C Housing Assembly with 425A

MODELS AFFECTED: 401A/B/C

The Model 425A housing assembly is the Jacobs® approved replacement option for the Model 401A/B/C housing assembly. The following is the recommended procedure for changing out a 401A/B/C housing assembly and replacing it with a 425A housing assembly.

1. Inspect the injector adjusting screws (P/N 012292) for wear and replace as required. Refer to the Model 425A installation manual for information on the proper injector adjusting screws. **Installation of the wrong screws will result in engine and engine brake damage.**
2. Replace the existing Cummins crossheads (2) with the Jacobs crossheads (2) P/N 019805. Install Cummins crosshead leveling screws and locknuts (Cummins P/N 147389 and 203131) into the Jacobs crossheads. Follow the crosshead leveling procedures and torque recommendations in the 425A installation manual.
3. Reset the engine overhead.
4. Install new rocker gasket, Jacobs P/N 013294.
5. Install the Model 425A housing. Location (front-center-rear) is not critical.
6. Set the slave lash according to Jacobs Engine Brake Application Information for Cummins Engines, Form No. 3218 (attached).
7. To ensure correct slave lash settings in the future, the appropriate slave lash tab (from tab set, P/N 018314) should be attached to each replacement housing.

NOTE:

THE SLAVE LASH TAB SET CONTAINS THREE (3) DIFFERENT SLAVE LASH TAB SETTINGS.

8. Install valve cover and gasket.

Special Instructions

The following parts are not included in the Model 425A packaged housing assembly and must be purchased separately.

Part Number	Description	Quantity
Jacobs P/N 019805	Crosshead	2
Jacobs P/N 01-013294	Gasket (package of 3)	1
Cummins P/N 147389	Crosshead Leveling Screw	2
Cummins P/N 203131	Crosshead Locknut	2