

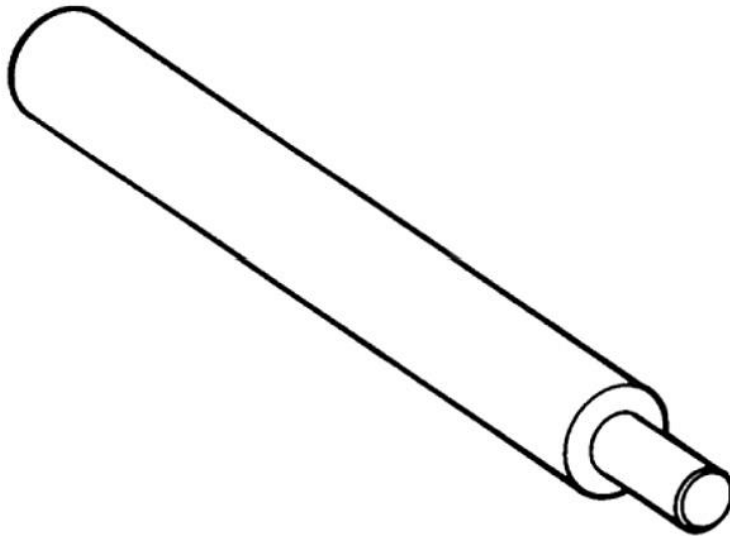


### TT00035

#### Revised Valve Stem Seal Tools on 1994-2010 Cummins M11, ISM, QSM Diesel Engines

S. B. International, Inc., offers the following information regarding revised tooling for 1994 - 2010 Cummins M11, ISM & QSM diesel engines. Through time the engine design has evolved and tooling has evolved along with it. Using the revised tooling will help greatly in providing a long-lasting repair.

The original valve stem installation tool was listed as Part #3823946 and resembled a valve guide removal tool as shown in **Figure 1**. It was designed to be used without the engine valve installed in the valve guide.



**Figure 1. Tool #3823946 Used Valves Uninstalled**

Over time it was determined an easier, much more effective installation could be made with the valves installed. Tooling was developed for that process for both the shorter and longer installed valve guides, which allowed the tools to bottom out on the cylinder head. Those tools are available with Cummins Part #3163602 and Part #3163603 as shown in **Figure 2**.



**Figure 2. Tool #3163602 For Guides 1.828" Height**

Part #3163602, valve stem seal installer should be used to install Part #4003965 seals on 1.828" high guides.

Part #3163603, valve stem seal installer should be used to install Part #4003965 seals on 1.079" high guides.

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