



Cylinder Sleeve Installation on 2007-2013 Cummins 4.5 & 6.7L Diesel Engines

The AERA Technical Committee offers the following information regarding cylinder sleeve installation for 2007-2013 Cummins 4.5 & 6.7L diesel engines. This salvage repair may occur after one cylinder bore becomes excessively scored from abnormal combustion activity and the unavailability of adequate oversize pistons.

AERA machine shops report successful sleeve installation on these engines over the past five years even though Cummins did not offer a service sleeve until recently. The sleeve Part #4919951 is now available for any or all of the engines cylinders. A caution is expressed to install all sleeves required before boring to final size. Cummins also recommends a block torque plate be used for both sleeving and boring processes.

Previously published information by Chrysler Corporation, a major user of this engine design, originally discouraged cylinder sleeve installation because of the engines Siamese cylinder design. Seemingly now, using a block mounted torque plate should help alleviate those concerns.

Aftermarket sleeve suppliers report recent additions to their product lines offering a repair sleeve such as the CSL1180X which will accommodate both a standard and .020" (.500 MM) bore.