

**PARTS & SERVICE
NEWS**

REF NO.	AT01234
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SUBJECT: INTRODUCTION OF IMPROVED DOWEL PIN ON S(A, AA)6D140 ENGINE FOR SEPARATE MARKETING

PURPOSE: To introduce improved dowel pin effective to prevent occurrence of cracks in the cylinder block of the independently marketed S(A, AA)6D140 series engines

APPLICATION: Refer to page 4

FAILURE CODE: A200HA

DESCRIPTION:

1. Introduction

There is a possibility of occurrence of cracks in the cylinder block of the independently marketed S(A, AA)6D140 series engines depending on the outfitting conditions. This Service News will introduce a new dowel pin with an improved shape to prevent occurrence of the aforesaid cracks in the cylinder block.

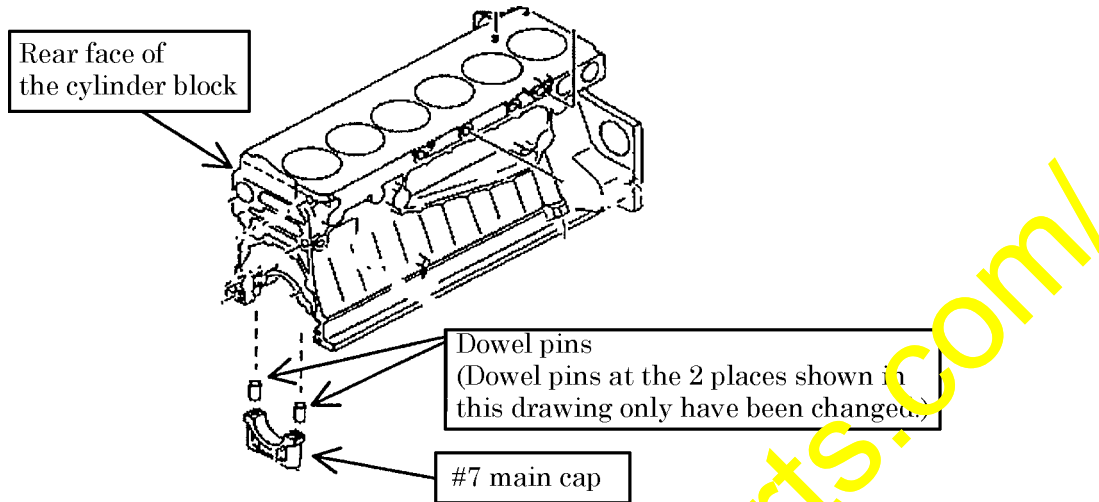
It is recommended to use this new dowel pin at the time of conducting overhauling of these engines or at a similar opportunity.

2. List of parts

Part No.	Part Name	Q'ty	Remarks
6211-22-1102 (6211-22-1101)	Block ass'y (Block ass'y)	1 (1)	The dowel pin indicated below only has been changed. (Type-2 cylinder block ass'y)
6211-21-1101 (6211-21-1102)	Block ass'y (Block ass'y)	1 (1)	The dowel pin indicated below only has been changed. (Type-1 cylinder block ass'y)
6212-22-1110 (04020-00514)	Pin (Pin)	2 (2)	

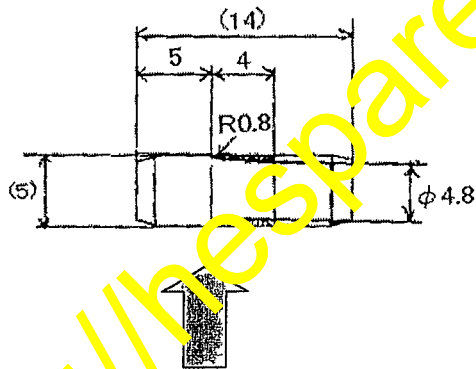
2. Contents of the modification

The shape of the dowel pins being used for installation of the #7 main cap has been changed to alleviate the stress being occurred in the cylinder block.

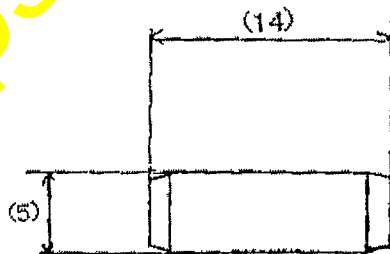


<Details of the change of the dowel pin>

● Shape of the pin after the change



● Shape of the pin before the change

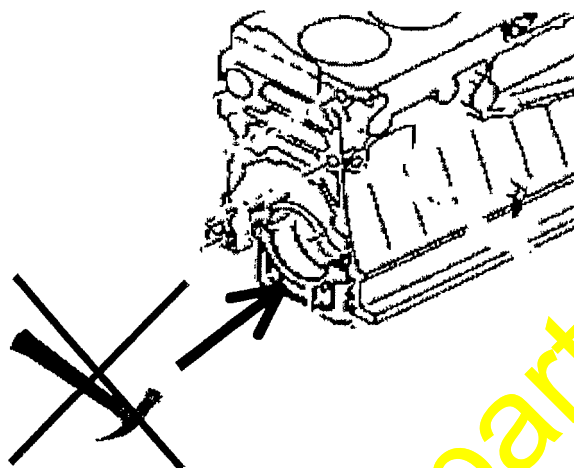


3. Modification procedures

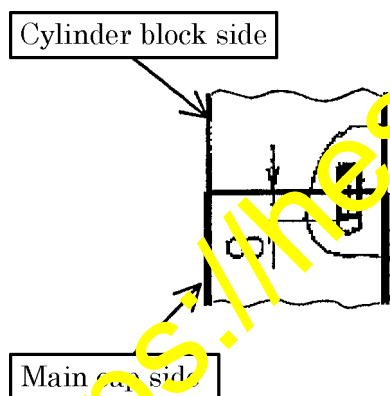
- (1) Remove and reinstall the main cap referring to the Shop Manual for the $\phi 140$ series engines.

<Note> Since the pins are being inserted as shown in this Service News, do not try to hammer the main cap forcibly in the longitudinal direction when removing and reinstalling the cap.

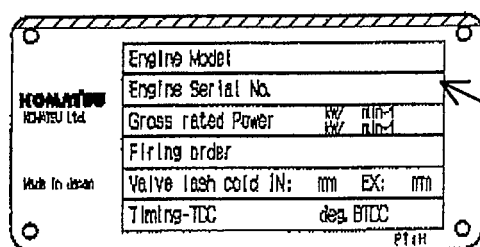
(If it is hammered forcibly in the longitudinal direction, the main cap or the cylinder block may be damaged.)



- (2) Adjust the projection of the new dowel pins from the cylinder block relevant to this modification to the following distance (8 mm).



* After implementing this modification, make a punch mark (●) after the "Engine Serial No." column on the engine nameplate for identification purposes.



Make a punch mark (●) here.

(Reference: The print of the nameplate differs depending on the specification of the engine.)

(Check table for the serial numbers of the engines which change has been made to implement the modification introduced in this Service News.)

Current Part No. New Part No.
(Part No. change: 04020-00514 → 6212-22-1110)

No.	Applicable engine models	Applicable serial Nos.		Implementation starting from:
		Already shipped engines	Already modified factory shipment engines	
1	EG300-5			
2	EG300B-5			
3	EG300BS-5			
4	EG300-L-5			
5	EB350A-L-1		Next production and after	
6	EG350B-L-1			
7	EG400-2			
8	EG400B-2			
9	EG400B-L-2			
10	EG400BS-2			
11	J6D140E-G1-2	- 70062	70063 -	Oct.16, '01
12	J6D140E-GD-2			
13	J6D140E-GE-2			
14	J6D140E-KC-2			
15	J6D140E-W2-2			
16	S6D140-1			
17	S6D140-G1-1			
18	S6D140-G2-1			
19	S6D140-G3-1		Next production and after	
20	S6D140-GD-1			
21	S6D140-GH-1			
22	S6D140-GN-1			
23	S6D140-GT-1			
24	S6D140-P-1			
25	SA6D140-PGA-1			
26	SA6D140A-1			
27	SA6D140-A1-1			
28	SA6D140-A2-1	- 29673	29674 -	Oct. 4, '01
29	SA6D140-A-G1-1		Next production and after	
30	SA6D140A-G2-1	- 29674	29675 -	Oct. 5, '01

No.	Applicable engine models	Applicable serial Nos.		Implementation starting from:
		Already shipped engines	Already modified factory shipment engines	
31	SA6D140A-G3-1			
32	SA6D140A-GA-1			
33	SA6D140A-GB-1			
34	SA6D140A-GD-1			
35	SA6D140A-GH-1			
36	SA6D140A-GJ-1			
37	SA6D140A-GN-1		Next production and after	
38	SA6D140A-GT-1			
39	SA6D140A-P-1			
40	SA6D140A-V1-1			
41	SA6D140B-1			
42	SA6D140B-A1-1			
43	SA6D140B-G1-1			
44	SA6D140B-G2-1	-29675	29676 -	Oct. 9, '01
45	SA6D140B-G3-1			
46	SA6D140B-GA-1			
47	SA6D140B-GN-1			
48	SA6D140-C2-1		Next production and after	
49	SA6D140-P-1			
50	SA6D140-W1-1			
51	SAA6D140-G1-1			
52	SAA6D140-G3-1	-29682	29683 -	Oct. 5, '01
53	T6D140E-W2-2		Next production and after	
54				
55				
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57				
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60				