

# AP0025

## High Pressure Oil Rail Seal Kit

### Instruction Sheet

#### APPLICATION

- International® DT466, DT570, and HT570 diesel engines in serial number range: 2,000,001 through 2,999,999; and
- International® MaxxForce™ DT, 9, and 10 diesel engine in serial number range: 3,000,001 and up

**CAUTION:** Standard safety procedures must be followed as outlined in the vehicle's service manual to avoid possible injury or death.

#### STEP 1:

Remove valve cover to gain access to high pressure oil manifold.

#### STEP 2:

Remove high pressure oil manifold.  
Refer to appropriate service manual for proper disassembly instructions.

#### STEP 3:

Remove o-rings and backup rings from high pressure oil manifold (see figure 1).

#### STEP 4:

Remove oil inlet o-ring in cylinder head (see figure 2).

#### STEP 5:

Inspect high pressure oil manifold:

- Verify oil inlet tubes are moveable
- Check injector oil inlet adaptors for internal o-ring extrusion and high pressure oil leak paths
- Replace any adaptors that are not moveable or have o-ring extrusion/oil leaks paths

#### STEP 6:

Measure groove in injector oil inlet tubes (see figure 3).

*Continued on reverse.*



**Figure 1**

1. Injector oil inlet adaptor
2. Backup ring
3. Injector oil inlet seal
4. Oil inlet tube
5. Internal O-ring (not serviceable)



**Figure 2**

## GROOVE MEASUREMENT CHART

G Groove in Oil Inlet Tube	Backup Ring
5.080 mm (0.200 in)	1.8 mm (0.07 in)
4.877 mm (0.192 in)	1.6 mm (0.06 in)
4.420 mm (0.174 in)	1.1 mm (0.04 in)

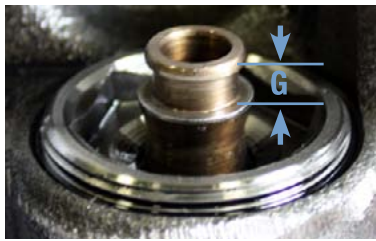


Figure 3

- Install new backup rings on injector oil inlet tubes according to groove measurements listed on table above
- Install new o-rings on injector oil inlet tubes (see figure 4)
- Coat new seals and backup rings with clean engine oil



Figure 4

### STEP 7:

Coat new oil inlet o-ring with clean engine oil and install into cylinder head (see figure 5).

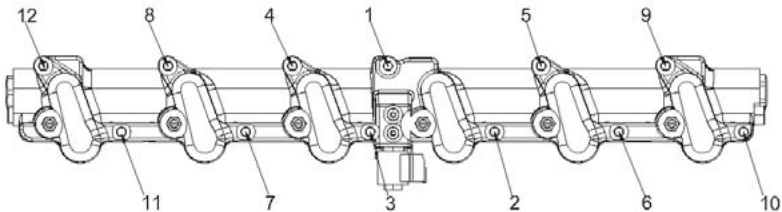
### STEP 8:

Install high pressure oil manifold on cylinder head.



Figure 5

**CAUTION:** Do not use manifold mount bolts to seat oil manifold to cylinder head. High-pressure oil manifold must be installed by hand or engine damage may occur. Install 12 high pressure oil manifold bolts hand tight. Torque bolts to 27 N-m (20 lbs-ft) in the sequence listed below.



### STEP 9:

Install valve cover.



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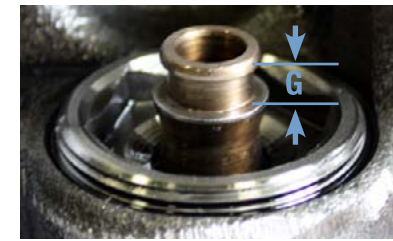


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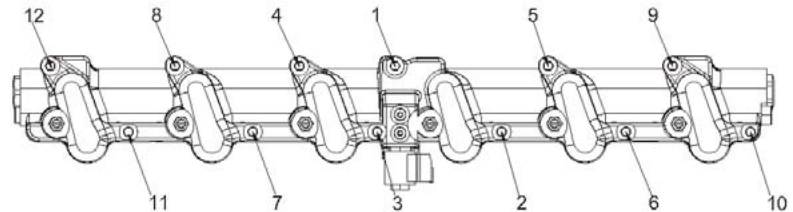
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