

# Rear Gasket / Flange Adapter Kit 4089679 For Cummins ISB02 15.2 Low Mount

Kit contains 4 - M8 X 30mm Socket Head Cap Screws, 1 - Aluminum Flange, 1 Flange Gasket  
The kit does not come with Lubriplate grease, a new pump gasket or pump bolts.

## Disassembly

1. If required remove the two M10 bolts holding either a steel cover plate or a hydraulic pump to the rear flange.
2. Remove the four M8 X 30 MM socket head cap screw, and **discard them**.
3. Carefully separate the rear flange adapter from the crankcase. **Be careful** not to damage/nick any of the machined surface of the crankcase. **Discard** the rear flange adapter and gasket.

## Cleaning & Inspection

1. Carefully remove any remaining gasket material from machined surfaces. **Avoid getting any debris into the crankcase and oil supply hole.** Wipe off the crankshaft.
2. Inspect the crankshaft sleeve for scratches, groves and wear. The sleeve can not be serviced in the field and will require the complete air compressor to be replaced if damaged or worn.

## Reassembly

1. With the machined surfaces wiped cleaned apply Lubriplate 105 grease to the crankshaft sleeve, flange adapter bore and machined lip around the bore.
2. Lay a new gasket on the adapter, be sure the oil inlet hole of the gasket lines up with the hole in the flange.
3. Insert the M8 SHCS into the adapter to help hold the gasket in place and slide the adapter over the crankshaft until the screws can be started into the crankcase threads. **Make sure the oil inlet hole lines up with the hole in the crankcase.**

### Bolt tightening Sequence

Step	Bolt	Torque Nm
1	A	20 ± 2 Nm
2	B	20 ± 2 Nm
3	C	20 ± 2 Nm
4	D	20 ± 2 Nm

4. After tightening bolts the crankshaft should rotate freely.
5. If required install steel cover plate with a new gasket and bolts (not supplied) torque to 20 ± 2 Nm, if a hydraulic pump is used follow manufactures instructions.

