



## Billet Tappet Cover

P/N 120510-2V2

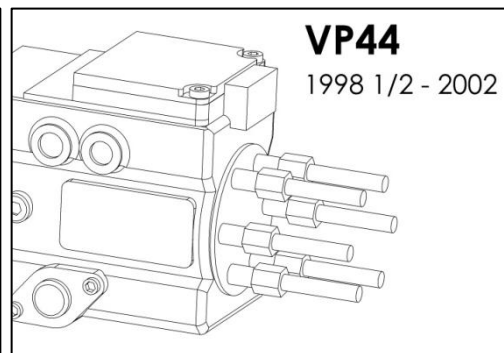
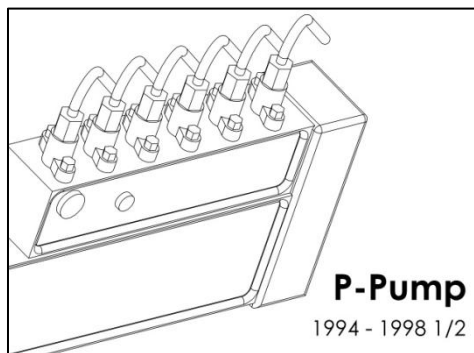
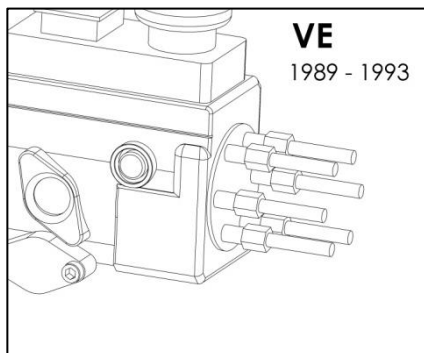


**FITS:** 1989 to 2002 12-Valve and 24-Valve 5.9L Cummins engines.

- 1998.5 to 2002 24-Valve engines must have been converted from the stock VP44 pump to P-Pump.
- Stock 1998.5 to 2002 24-Valve engines have VP44 pumps and must use tappet cover part # 120510-2VP44

**DOES NOT FIT:**

- VP44 equipped engine
- common rail engines



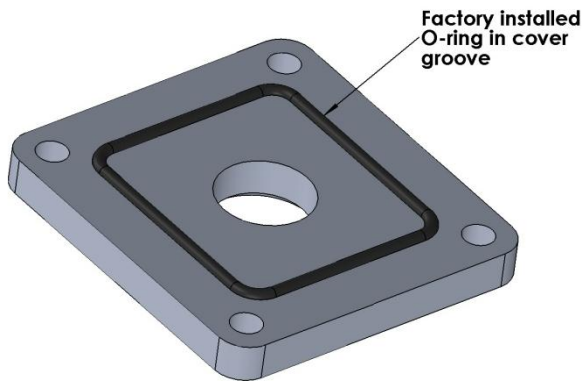
**FEATURES:**

- Billet machined construction.
- More roller rocker clearance for upgraded link bar lifters.\*
- Built in baffling
- -12AN O-ring boss breather ports.
- Includes O-ring seals and stainless hardware.

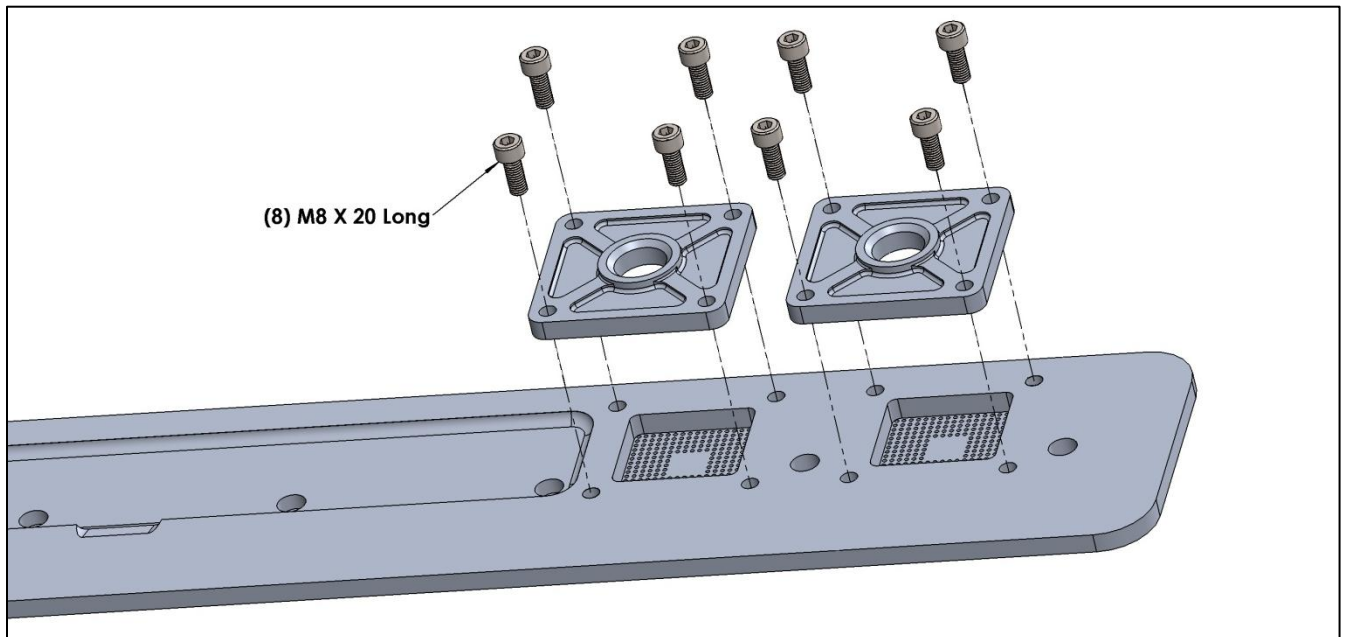
**\*WARNING:** Although this cover clears most aftermarket roller lifters, KMI cannot have knowledge of newly available lifters and all engine combinations. Before starting the engine confirm clearance to the cover or damage may occur.

## INSTALLATION INSTRUCTIONS:

1. Clean area around original cover to prevent contaminants from entering the engine.
2. Remove any components required to access the tappet cover (see engine service manual for details on disassembly and reassembly).
3. Remove original tappet cover.
4. Inspect tappet chamber and remove any contaminates.
5. Clean and inspect engine's cover sealing face to confirm none of the original gasket or other debris is present.
6. Confirm the new baffle cover O-ring is installed and fully seated to the groove of each cover.

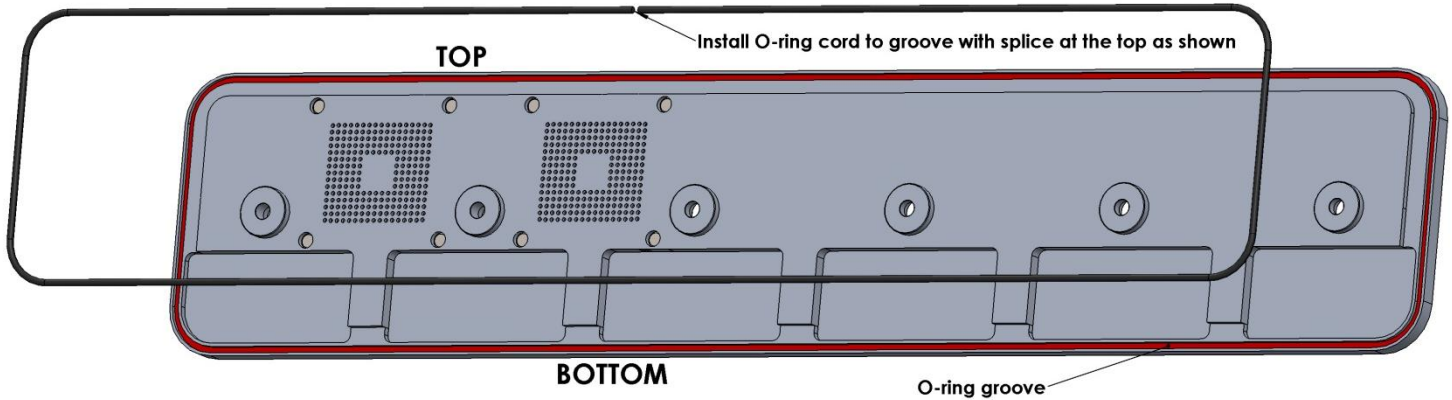


7. Install baffle covers to tappet cover using socket head bolts

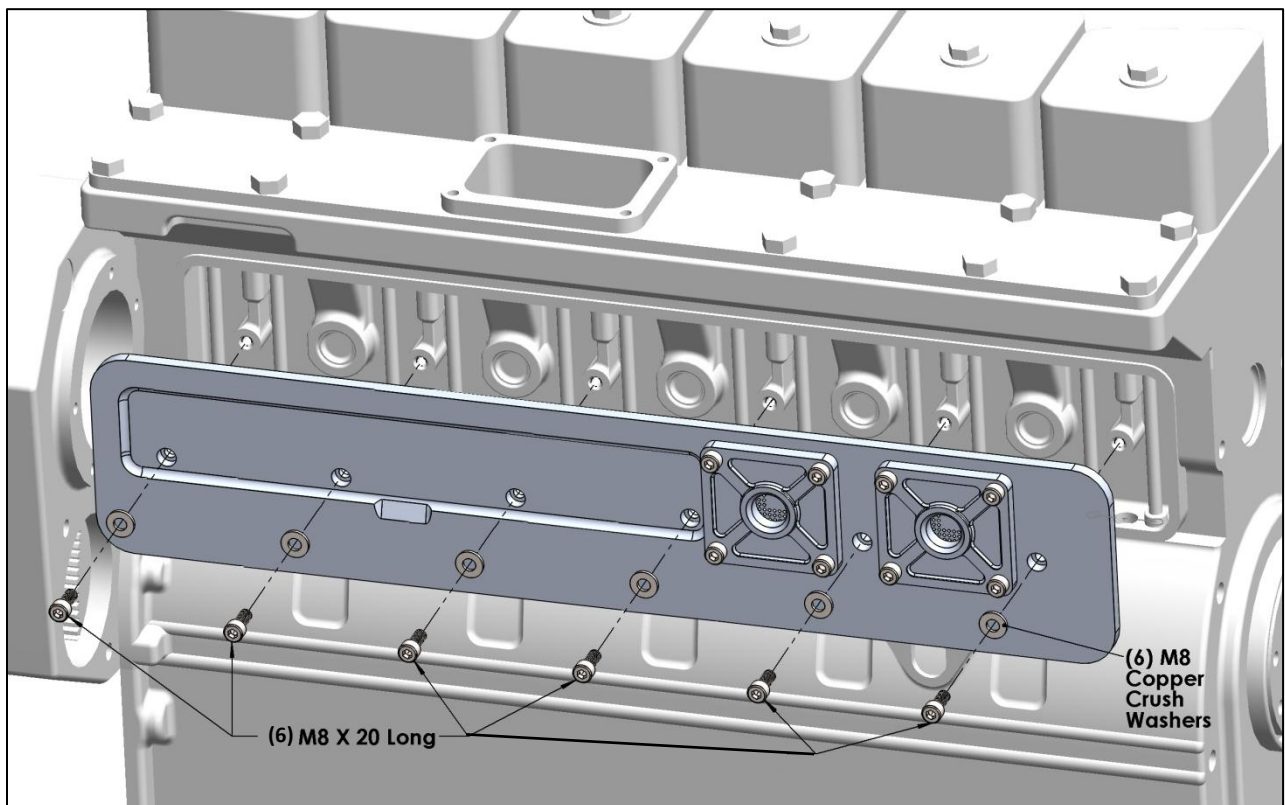


**Use Loctite® 242 or 243, then torque to 18 FT-LBS**

8. Install O-ring to new tappet cover:
  - a. Pre-install O-ring cord to groove in cover.
  - b. With sharp scissors, cut the O-ring cord about 1/8" longer than needed to completely fill the groove. Cut the cord end as square as possible.
  - c. Remove the O-ring cord.
  - d. Use Super Glue® or similar adhesive to glue the ends of the cord together.
  - e. After glue has dried, reinstall the O-ring. Start installing the O-ring at the bottom and finishing with the splice at the center top.



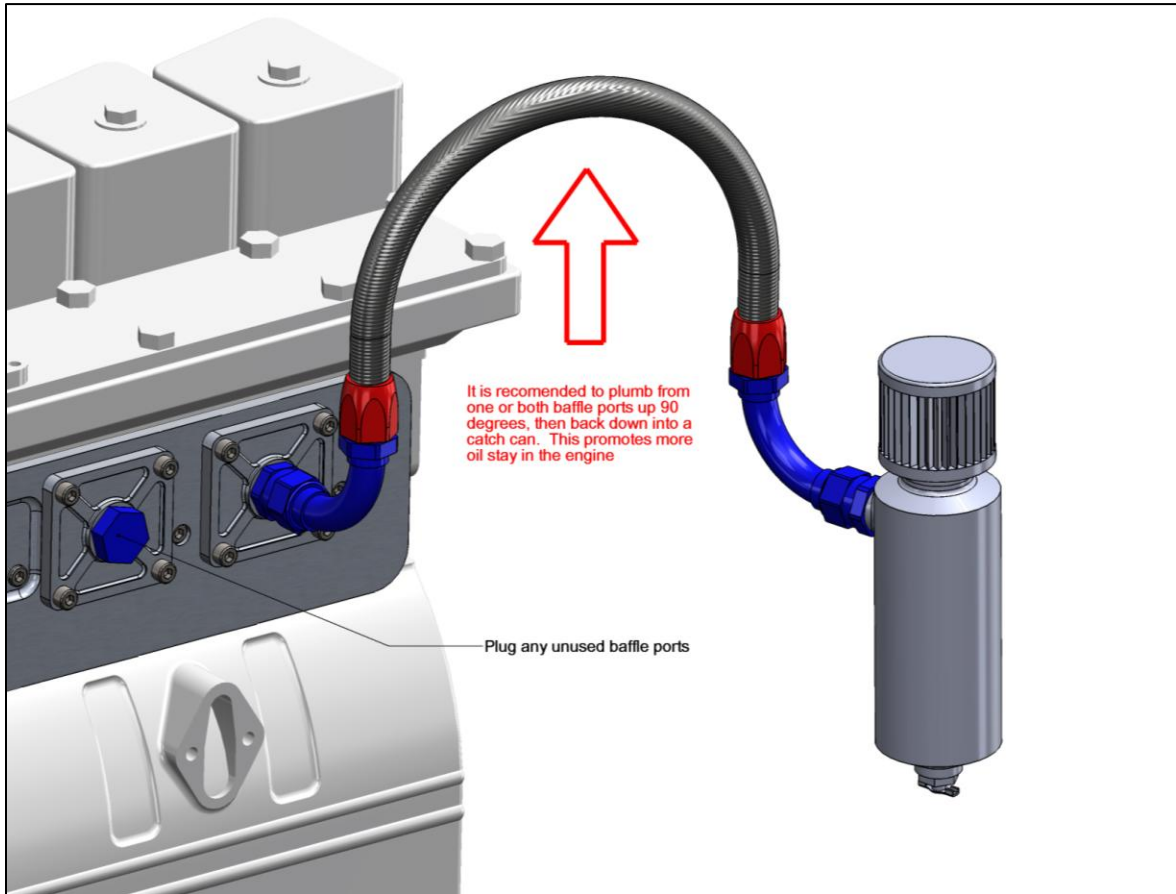
9. Install cover to engine using socket head bolts and copper crush washers.



**Torque to 18 FT-LBS**

10. Plumb breathers:

- a. Use a catch can designed for automotive engines such as P/N 08-0400 or 08-0410 from Peterson Fluid Systems.
- b. Install breather plumbing with -12 O-ring boss hose ends or adapters (not included).
- c. It is recommended to run a hose from one or both -12 vent holes to a catch can. If only one breather port is used, block the other one off with a -12 male O-ring boss plug. Best practice is to route the hose up 90 degrees coming out of the tappet cover breather port and then make a 180 degree loop before continuing to the catch can.



11. Confirm all connections and that parts such as injection pump are properly reinstalled.

**WARNING:** Before starting engine confirm lifters have clearance to the tappet cover and will not hit the cover during engine operation.

12. Check for leaks before and again after driving the vehicle.