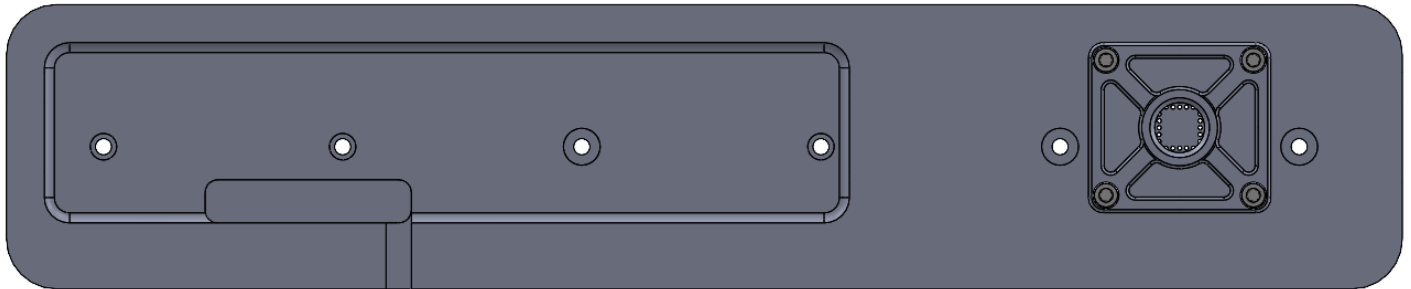




24V VP44 Tappet Cover

P/N 120510-2VP44P and 120510-2VP44NP

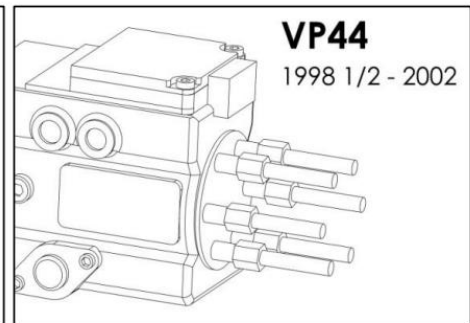
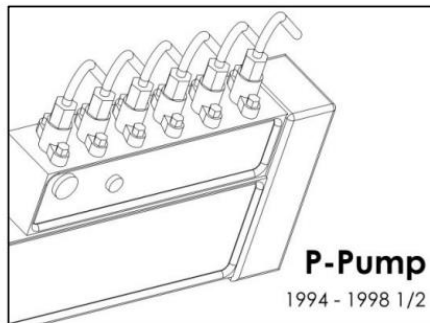
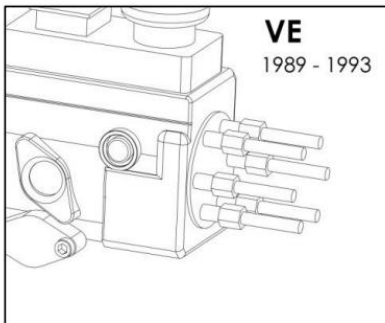


Fits:

- 1998.5 to 2002 24-Valve 5.9L Cummins engines with the VP44 injection pump

Does Not Fit:

- Common rail engines

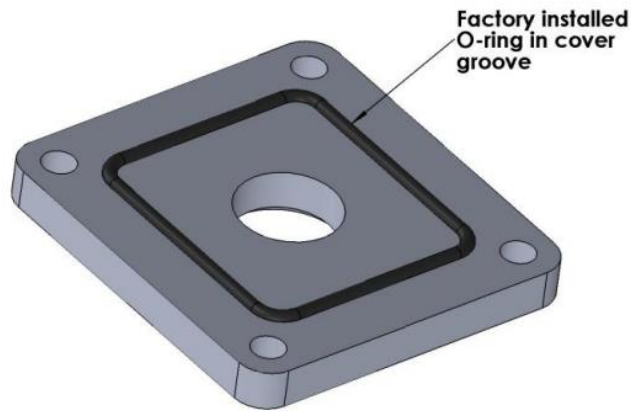


Features:

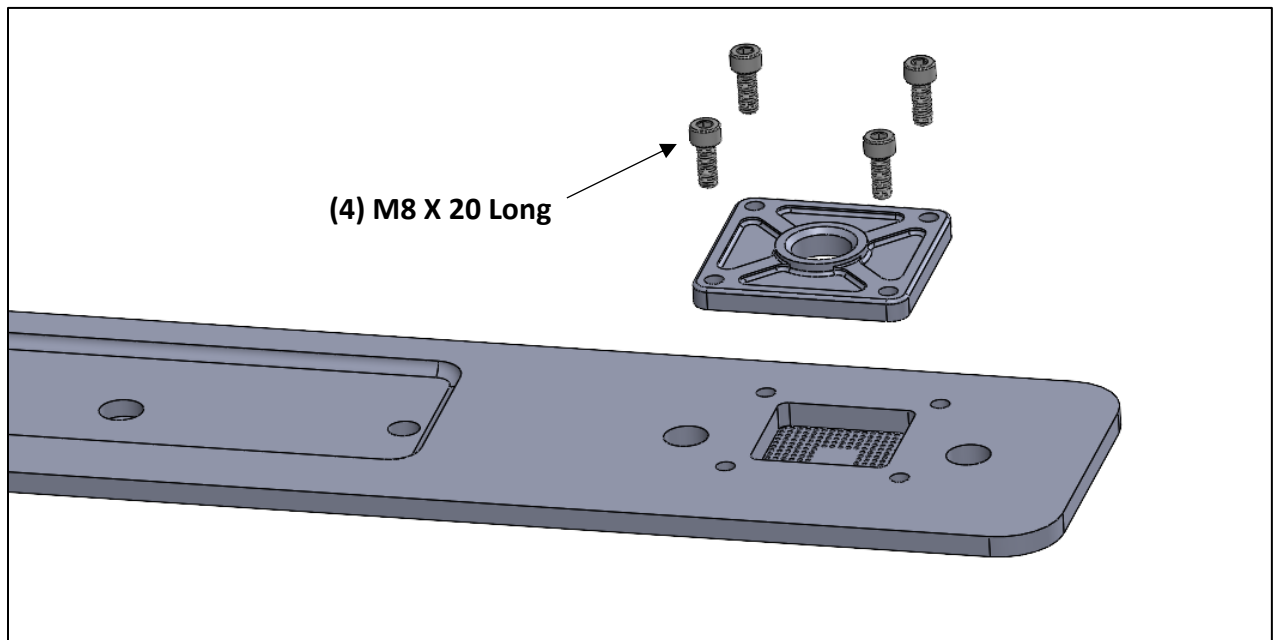
- Billet machined construction.
- Built in baffling.
- -12AN O-ring boss breather ports.
- Includes O-ring seals and stainless hardware.
- Accommodates mounting the computer in the stock location.

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 contaminants.
5. Clean and inspect engine's cover sealing face to confirm none of the original gasket or other debris is present.
6. If installing tappet cover without a breather, skip to step 9.
7. Confirm the new baffle cover O-ring is installed and fully seated in the groove of each cover.



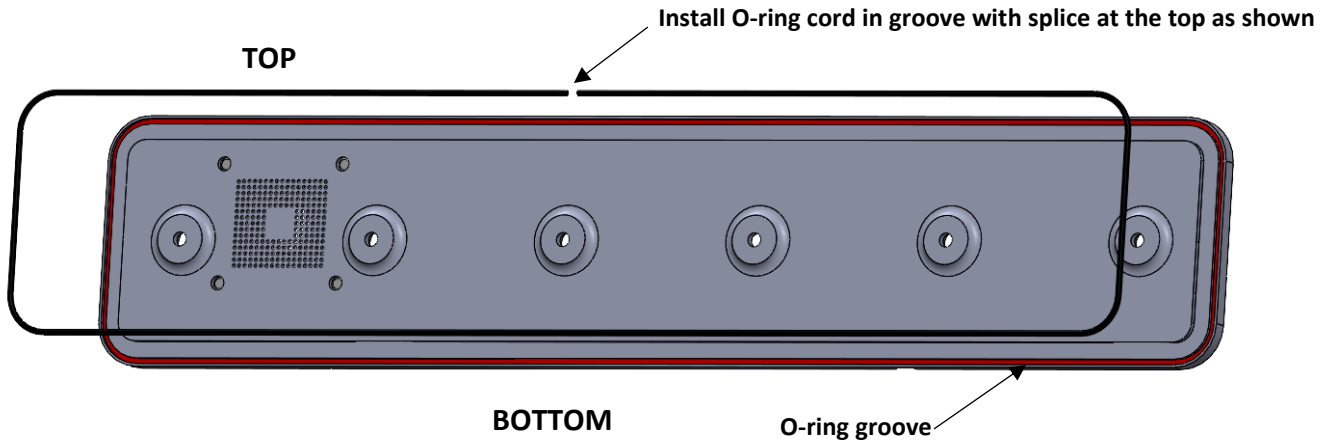
8. Install baffle cover to tappet cover using socket head bolts.



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

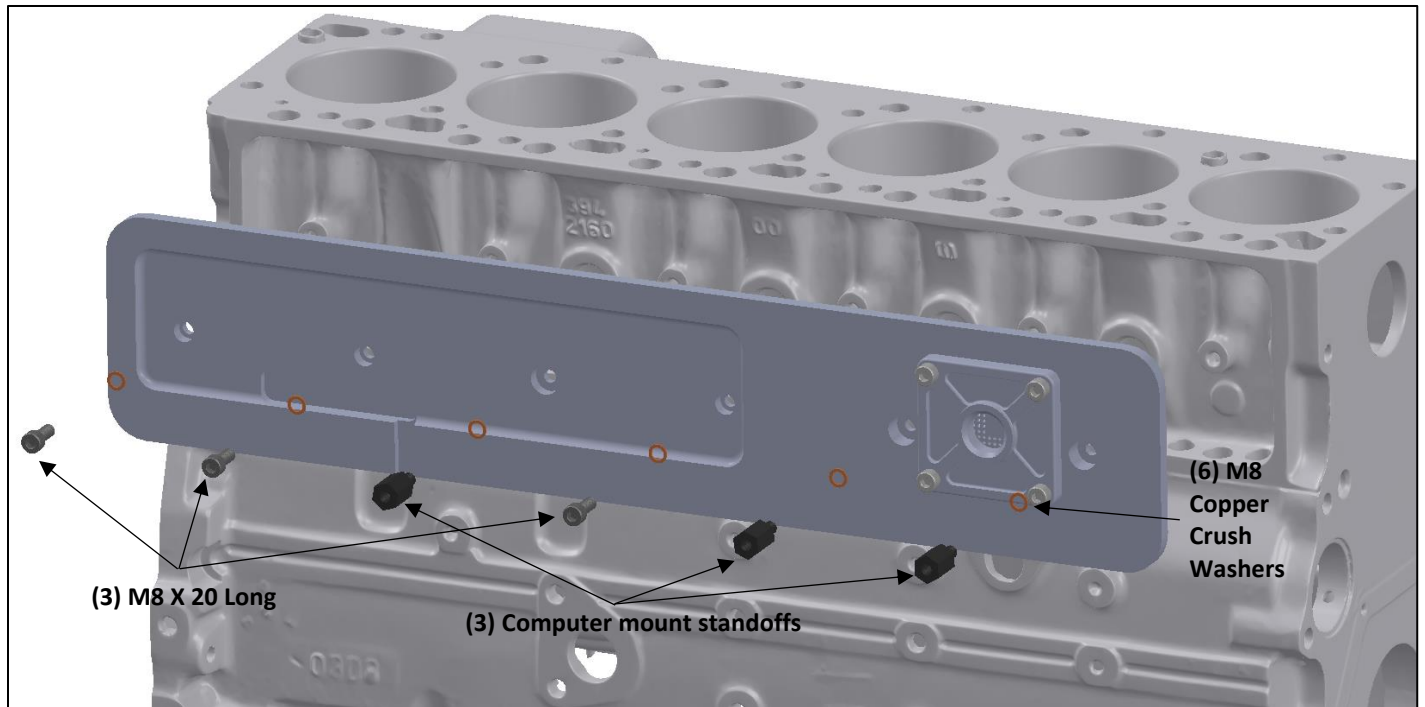
9. Install O-ring in new tappet cover:

- 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 finish with the splice at the center top.



10. Install cover using socket head bolts and copper crush washers.

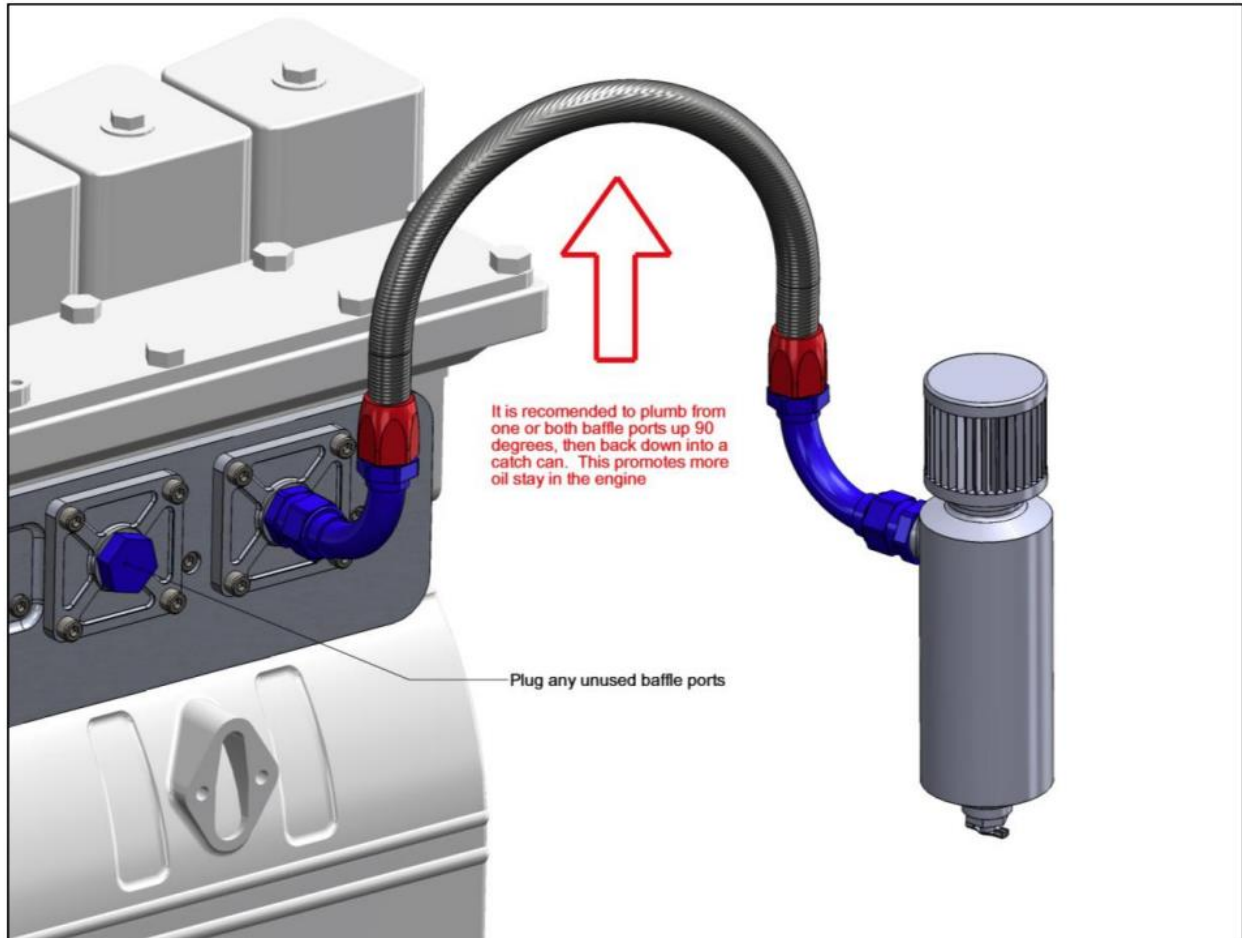
- a. If mounting computer in stock location, install the stock computer mount standoffs in the three larger countersunk holes as shown.



Torque to 18 FT-LBS

11. Plumb breathers (only part number 120510-2VP44P):

- a. Use a catch can designed for automotive engines.
- b. Install breather plumbing with -12 O-ring boss hose ends or adapters (not included).
- c. Best practice is to route the hose up 90 degrees coming out of the tappet cover breather port then make a 180 degree loop before continuing to the catch can.



12. Mount computer back to standoffs on tappet cover.

13. 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.

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