



XP Series Service Bulletin

Number: XPB01

REV A

Initial Release

Date: 30 January 2015 **Service Bulletin No:** XPB01

Subject: Increased Rod Bolt Torque.

Engine Applications: All Superior XP-400 engines

Issue:

The connecting rod bolts (SV90842 and SV90843) for the XP-400 engines are designed with virtually the highest strength alloy available. The design torque for these rod bolts is 720 in-lbs. The XP-400 assembly data incorrectly calls for 480 in-lbs. Although there are no known cases of the lower torque value resulting in any issues, the connecting rod bolts should be torqued to the 720 in-lb specification in order to ensure proper bearing crush and bearing durability.

Time of Compliance:

Rod bolts must be torqued to the required specification within the next 5 hours of engine operation.

Procedure:

To determine if your engine(s) are affected, check the serial number on the Superior Air Parts data tag (mounted on the sump assembly) against the list of serial numbers in Table 1 below. If your engine does not have a Superior Air Parts data tag, contact the dealer from which the engine was purchased.

XP-400 Affected Serial Numbers

40B090005	40D130012	40J130019	40G140026
40M120006	40D130013	40B140020	40H140027
40A130007	40E130014	40B140021	40J140028
40A130008	40F130015	40D140022	40J140029
40C130009	40H130016	40D140023	40J140030
40C130010	40H130017	40E140024	40L140035
40D130011	40H130018	40E140025	

Table-1

If your engine's serial number is listed in table-1, call us at 972-829-4617.

(Replacement gasket sets for reinstalling cylinders will be furnished for affected engines.)

NOTE: Before each rod bolt is torqued to the correct torque specification, each bolt should be checked at 400 in-lbs. If the rod bolts advance at a torque lower than 400in-lbs, Superior Air parts will provide replacement bearings for each connecting rod with bolts that have a torque less than 400in-lbs.

Labor Allowance:

Superior shall reimburse the following labor allowances for the removal and installation of each cylinder assemblies, and the torque adjustment for the rod bolts.

All four cylinder change:
IO-400 – 18 hour

Connecting rods and Bolts:
IO- 400 – 0.75 hours

Hydraulic lifters:
IO-400 – 0.75 hours