

2062

Date: 11/19/13

**TO: All Lincoln Authorized Repair Facilities, All Lincoln Electric Distributors,
and All Lincoln Sales Offices**

Issue/Symptom:

Kohler Command Twin Engines; Rocker Arm Pivot Screw Torque Change
No power on one or both cylinders (missing). Unusually loud engine noise.

Scope:

Lincoln Model		Kohler Model
Ranger 225	K2857-1	CH23S, CH680, or CH730
Ranger 250GT	K2382-4, -5	CH23S, CH680, or CH730
Ranger 305G	K1726-5	CH23S, CH680, or CH730
Ranger 305G EFI	K3928-1	ECH740
Ranger 305 LPG	K2937-1	CH730LP

Lincoln Electric Serial Number Range: U1120709505 through U1131103656

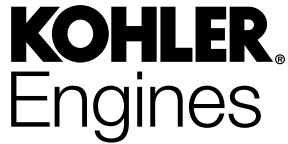
Kohler Engine Company Serial Number Range: 42182XXXXX through 43210XXXXX

The Kohler Engine Company issued a Service Bulletin regarding their Command Twin engine, models 620 – 752. The bulletin calls for general attention to possible loose engine rocker arm pivot screws and provides instruction for increased torque specification for the parts and models involved. Additionally the bulletin identifies the above serial number range specifically and instructs the rocker torque procedure be performed. Please check with your local Authorized Kohler Dealer for updates to Kohler Service Bulletin 318 (copy follows as page 2).

The above models of Lincoln Electric Welders, especially within the specified serial number range, should be inspected. Contact your local Authorized Kohler Service Center to arrange for application of the new rocker arm torque specification. Go to www.kohlerengines.com > Service & Dealer Locator.

Lincoln Authorized Repair Facilities are encouraged to follow Service Notice 9502 for reporting Kohler field correction of this issue through the Lincoln Electric Warranty database. If you have questions regarding Lincoln Electric application of this Service Notice, phone us at 888-935-3877. International inquiries to globalservice@lincolnelectric.com

Lincoln Electric Service Department
Cleveland Ohio U.S.A.



Service Bulletin

NO. **318**

MODEL
COMMAND TWINS 620-752

DATE ISSUED **8/13** DATE REVISED **10/13**

Rocker Arm Pivot Screw Torque Change

Reports of loose rocker arm pivot screws on Command twin engines has resulted in an increase of the torque spec to 18.6 N·m (165 in. lb.). If a loose pivot screw is experienced, please retorque the rocker pivot screws on both cylinders to 18.6 N·m (165 in. lb.) following the procedure below.

It is further recommended you perform this retorque procedure for any engine within the Serial Number range of **42182XXXXX-43210XXXXX**, when the valve cover is removed for service or repair. When filling out the related warranty claim please list M-640034-S as the defective part and insert ME5572U in the Work Unit field at the top of the claim.

1. Remove the (8) eight valve cover screws.
2. Remove both valve covers. Ensure the O-rings remain properly in place.
3. Bring the engine to top dead center piston position on cylinder #1 with both valves closed.
4. Ensure the rocker arms and push rods are in position and aligned properly on the valve stems.
5. Using a calibrated inch pound torque wrench, retorque the rocker arm pivot screws to 18.6 N·m (165 in. lb.).
6. Repeat procedure on cylinder #2.
7. Verify the O-rings are properly in place, then reinstall the valve covers.
8. Reinstall the valve cover screws and any previously used clips or brackets.
9. Torque the valve cover screws to 6.2 N·m (55 in. lb.).

While this increase in torque was found to be needed as a result of a component change made in 2012, we have found that this increased torque is backwards compatible, and can be used for all Command twin model engines listed above regardless of manufacturing date.

Routing	Service Manager	Sales Manager	Parts Manager	Chief Mechanic	Mechanic No. 1	Mechanic No. 2	Mechanic No. 3	Mechanic No. 4	Return This To
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