



3/25/2020

Waukesha gas engines Service Bulletin Index

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ATGL* /275GL* /GL+ Series

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0 Safety			
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1 Accessories			
1-2620F	Engine Protection Shutdown	All Waukesha Engines	11/2007
1-2876	Quick Disconnect K-Type Exhaust Thermocouples	All Waukesha Engines	5/2001
1-4034	Updated E-Stop Button	All Waukesha Engines	11/2015
1-4048	Stub Shaft Guards	All Waukesha Engines	10/2015
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4-2554J	ATGL Engine Auxiliary and Jacket Water Pumps	All ATGL Engines	4/2001
4-2569	AT Thermostat Repair Kits	12V-AT25GL Engines	7/1991
4-2775A	Intercooler Mounting Clarification	AT 8L-AT27 Engines	10/1998
4-2879	Service Only Part Numbers For Thermostatic Valve Replacement Kits	All Waukesha Engines	6/2001
4-3081	Coolant Fire Potential	All Waukesha Engines	6/2013
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5-2306A	Flywheel Ring Gears	All Waukesha Engines	7/1991
5-2781A	Crankshaft Counterweight Bolt Torque	All ATGL Engines	11/1999
5-2793	Operating Range Clarification	8L-AT27GL	10/1999
5-2818	New Torsional Vibration Damper	8L-AT27GL	5/1999
5-2821A	Correct Torque Specifications For Damper, Stub Shaft And Extension Shaft Bolts	All ATGL Engines	9/1999
5-2842	ATGL% New Crankshaft Split Gear Clamp Ring Torque Data	8L-ATGL/12V-ATGL	5/2000
5-2895B	New Hydrolastic Damper	8L-AT27GL	3/2003
5-2926B	Crankshaft End Play Correction In ATGL Repair & Overhaul Manuals	8L-ATGL, 12V-AT25/27GL And 16V-AT27GL	4/2005
5-2960B	Crankshaft Main Bearing Tensioning	All ATGL Engines	5/2007
5-2969	Vibration Dampers	12V-AT27GL And 16V-AT27GL	9/2006
5-2986	Crankshaft Polishing	All Waukesha Engines	4/2008
5-3019	Hydrolastic Damper and Crankshaft Release	12V-AT27GL	8/2009
5-4007	Use of Improperly Reconditioned Connecting Rods	VG/VP/ATGL/275GL	9/2014
5-4028	Connecting Rod Cap Bolts	All Waukesha Engines	5/2015
6 Cylinder Block and Crankcase			
6-2800D	New ATGL Oil Control Parts	All AT27 GL Engines	5/2002
6-2837D	ATGL Main And Connecting Rod Bearing Identification And Installation	All AT27GL Engines	5/2007
6-2899	ATGL Crankcase Lower Bore Repair\Restoration	All ATGL Engines	10/2002
6-2903	ATGL Piston Ring Groove Clearance	All ATGL Engines	9/2002
6-2967	New Water Manifold Jumper	16V-AT27GL	11/2006
6-2994	Identifying Piston Crown Damage	All Waukesha Engines	7/2008
6-3011A	New Cylinder Liner and Water Guide O-Rings	All ATGL Engines	8/2019
6-3013	New Water Jumper O-Ring	16V-AT27GL	2/2009
6-3054	Cylinder Sleeve O-Ring Lubrication	All APG, ATGL, VG/VP & VHP Engines	11/2010

ATGL* /275GL* /GL+ Series

Number	Description	Engine Models	Date
6-4030	Centrifugal Oil Filter	All engines equipped with centrifugal oil filter	4/2015
6-4097	Piston Cooling Galley Plugs	12V275GL+, 16V275GL+ and ATGL Engines	7/2018

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Number	Description	Engine Models	Date
7 Cylinder Heads			
7-2794C	New Cylinder Head Replacement Parts	All AT25/27GL Engines	2/2001
7-2934B	ATGL Valve Seat Insert Installation Procedure	All ATGL Engines	6/2007
7-3012	New Igniter Sleeve O-Ring	All ATGL Engines	2/2009
7-3092	Igniter Sleeve Lower O-Rings	AT27GL/275GL and GL+	4/2015
7-4093	Valve Seat Inserts	AT27GL/275GL and GL+	4/2017
8 Exhaust System			
8-3059	Exhaust Bellows Update	ATGL/275GL	4/2011
8-3062	Wastegate Housing Assembly Update	ATGL	11/2011
8-4047	Customer Exhaust Installation	All Waukesha Engines	10/2015
8-4061	NOx Sensor Modification	16V275GL+	1/2016
8-4078A	Insulation Interference	All 275GL+ Engines	8/2016
8-4113	Exhaust Deflagration	All 275GL+ Engines	1/2019
9 Fuel System			
9-2150A	Gas Pressure Regulator Recommendations (Special Warning)	All Natural Gas	7/1981
9-2661A	New Six Hole Prechamber Combustion Cup	8L-AT27GL and 12V-AT27GL	11/1995
9-2701A	Gas Sampling Procedures	All Waukesha Engines	11/2007
9-2702D	Gaseous Fuel Specification, S-7884-7	All Waukesha Engines	10/2014
9-2787	Revised Carburetor Setting	All AT27GL Engines	7/1998
9-2797	AT Prechamber Gas Differential Pressure	8L And 12V AT27GL Engines	11/1998
9-2853	StartUp and ShutDown Of Engines Equipped With Deltec, Carburetion	16V-AT27GL, VGF% F18/H24GLD And VGF L36/48GLD/GSID	7/2000
9-2898	Gas Valves For Constant Torque Engines	8L-AT27GL	4/2002
9-2947	Gas Admission Valve Retention Hardware	All ATGL Engines	4/2005
9-2966	Modified Carburetor And Fuel System Adjustment	16V-AT27GL	9/2006
9-3068	Fuel Valve Mounting	ATGL/275GL	1/2012
9-3090	Potential Gas Leak - Gas Inlet Shutoff Valve	ATGL/275GL	6/2014
9-4051	Updates to Gas Regulator Steppers	All VGF, VHP and ATGL/275GL Engines	11/2015
9-4075	Rod End Maintenance Manual Correction	275GL+	8/2016
9-4085	Low BTU Fuel	275GL+	6/2017
9-4107	Prechamber Fuel Regulator Bracket and Inlet Fuel Pipe Upgrade kits	12V/16V 275GL/GL+ Engines	8/2018
11 Ignition System			
11-1520A	Timing Tapes and Charts for Ignition Timing	All Gas	10/1972
11-1895G	Spark Plug Recommendations	All Waukesha Gas Engines	11/1999
11-2564	Custom Engine Control Ignition Module	12V-AT25GL	7/1991
11-2662	Custom Engine Control Ignition Module Hall-effect Pickup	AT, VHP, VGF Engines	2/1995
11-2684	Pressure Washing/Steam Cleaning Precaution For Electronic Devices Including CEC Product Modules	All Waukesha Engines	6/1995
11-2741A	Maintaining CSA Certification On Flange-Mounted Ignition Systems	ATGL, VHP, & VGF Engines Equipped With CSA Ignition Systems	1/2000
11-2746	Ignition System Components And Maintenance - CSA And Standard	All ATGL Engines	3/1997
11-2897	Upgrade On Long Life Spark Plug	All AT27GL Engines	5/2002
11-3044	Emergency Stop Button Replacement	All Waukesha Engines	9/2014

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Number	Description	Engine Models	Date
11-4035	Improved Ignition Power Module-Diagnostic (IPM-D)	All ESM Equipped Engines	5/2015

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Number	Description	Engine Models	Date
11-4068	Camshaft and Crankshaft Magnetic Pickups	All Waukesha Engines	4/2016
11-4095	Power Distribution Junction Box (PDB) Cover Modification Instructions	All ESM Equipped Engines	7/2017
12 Lubrication System			
12-1880AR	Lube Oil Recommendations for GE's Waukesha gas engines	ALL APG, ATGL, VGF, VHP, 275GL Engines	12/2019
12-2623B	Oil Pump Backlash Tool And Specifications	All ATGL Engines	2/2001
12-2677	Taking Oil Samples For Laboratory Analysis	All Waukesha Engines	6/1995
12-2810A	New Temperature Thermostats And Oil Feedback System	All ATGL Engines	7/2000
12-2954	Oil Catcher	All ATGL	5/2006
12-3051	Hollow Screw (Banjo Bolt) Torque Values	ATGL/275GL and GL+	11/2010
12-4005	Inspection of Spin-on Oil Filters	275GL, VHP, APG & VGF Engines	6/2014
13 Turbochargers			
13-2612	Wastegate Adjustment	8L-AT25/27GL and 12V-AT25GL	4/1994
13-2654B	Hardware Required For TCM Retrofit On Non-TCM Equipped Engines	12V-AT25GL	11/1999
13-2776C	TCM I and TCM II Retrofit	All 12V-AT25/27GL Engines	12/1999
13-2798A	TCM I and TCM II Retrofit	All 8L-AT 27GL Engines	12/1999
13-2802A	New Exhaust/Inlet/Discharge Connections	All AT25/27GL Engines	3/2001
13-2849B	New Turbocharger Inlet Elbows/Exhaust Connections And High Temp. Gaskets	12V-AT27GL, 12V-AT25GL With 181 Turbochargers and 12VAT25GL With 151 Turbochargers	8/2001
13-2851	Wastegate Valve Redesign	12V-AT27GL	5/2000
13-2929	New Compressor Discharge Elbow And Intercooler Inlet Gaskets	16V-AT27GL Engines	1/2004
13-2936	Wastegate Maintenance Recommendation	All ATGL Engines	5/2004
13-4036	Turbocharger Control Description Correction	275GL+	10/2015
13-4042A	Exhaust Outlet Elbow	12V275GL+	8/2017
13-4064	Updated Wastegate/Turbocharger Removal	P9394GSI	8/2016
14 Application and Installation			
14-2582	Lubricating Electric Motors	All Waukesha Engines	2/1993
14-2815	Cylinder Compression Check Procedure	All Waukesha Engines	8/1999
14-3070	Proper Vent Line Flex Coupling Installation	All Waukesha Engines	1/2012
14-3071	Engine Vibration Levels	All Waukesha Engines	10/2011
14-4094	O-ring and Flare Hydraulic Fittings	All Waukesha Engines	4/2017
15 Tool Recommendations			
15-2822	ATGL Connection Rod Bearing Tool Change	All ATGL Engines	8/1999
15-2845	ATGL Camshaft Gear Pump Kit And Adjusting Tool	All ATGL Engines	3/2000
15-2871	Ignition Analyzer	All Waukesha Engines	3/2001
15-3057	Spark Plug Sleeve Seat Resurfacing Tool	APG1000/16V150LTD, VGF, VHP, APG2000/3000, ATGL/275GL+	7/2011
15-3072	ATGL/275GL/GL+ Admission Valve Puller	All ATGL/275GL/GL+ Engines	2/2013
15-4066	New Rigging and Lifting System	275GL+	5/2016

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Number	Description	Engine Models	Date
16 Miscellaneous			
16-1561E	Dresser Couplings and Gaskets	All Waukesha Engines	9/1988
16-1740E	Location of Engine Serial Numbers on Crankcase or Block Castings	APG, 275GL/ATGL, VHP, VGF	4/2015
16-1851A	Exercise Recommendations for Standby Engines	All Waukesha Engines	2/1973
16-1855J	Waukesha Preservative Oil	All Waukesha Engines	8/2016
16-1858	Preparation of Generators for Long-Term Storage	As Applicable	9/1970
16-2644A	Landfill Gas Engine Components	All Waukesha Engines	7/1997
16-2779	Explosion Relief Valve Seal Replacement	All AT27GL Engines	12/2000
16-2864B	Procedures For Light Load Operation	All Waukesha Engines	8/2016
16-2913	ATGL Break-In Procedure After Rebuild	All ATGL Engines	1/2003
16-4056A	New Safety Labels	All Waukesha Engines	10/2018
17 Electronic Controls			
17-2716	AFM Lean Burn Retrofit Kits	12V-AT25/27GL, 8L-AT27GL	9/1996
17-2823A	Release of TCM II Interface Software Version 1.10c	All ATGL with TCM II	3/2000
17-2863A	Knock Sensor Torque Values	All APG, ATGL, VHP and VGF Engines	3/2010
17-2958C	Remote Programming of ECU	All ESM Equipped Engines	3/2015
17-2964	Battery Maintenance	All Waukesha Engines	9/2006
17-2975A	Stoichiometric Engine Oxygen Sensor Replacement	All ESM & CEC Engines with Oxygen Sensors	12/2008
17-2980A	ALM555 Troubleshooting	All ESM Equipped Engines	10/2009
17-2996	ESM Power Distribution Junction Box	All ESM Equipped Engines	9/2008
17-3008	ESM Oil Pressure and Shutdown Setpoints	All ESM Equipped Engines	12/2008
17-3048	Power Distribution Box Water Integrity	All Engines with ESM	10/2010
17-3093B	Updated Electronic Service Program	All Waukesha Engines with ESM	8/2016
17-3048A	PDB Reset and Water Integrity Guidelines	All Waukesha Engines with ESM	12/2014
17-4001A	Updated Power Distribution Junction Box	All Waukesha Engines with ESM	12/2014
17-4100	275GL+ Engine Wireways	12V275GL+ and 16V275GL+ Engines	6/2018
17-4103B	Start Improvement Software	12V275GL+ and 16V275GL+ Engines	1/2019
17-4110	ESM Camshaft and Crankshaft Magnetic Pickup Adjustment	All Engines with ESM/ESM2	8/2018
17-4112A	ESM2 Engine Hour Feature	All Engines with ESM2	5/2019
17-4114	ESM/ESM2 IPMD2 Ignition Upgrade	All 275GL+ Engines with ESM/ESM2	1/2019
17-4115	ESM2 HMI Software Update and Boot-up Process	All Engines with ESM2	4/2019
17-4116	Vibration Isolation Mount Kit	12V275GL+ and 16V275GL+ Engines	5/2019
17-4118	Troubleshooting Steps for Actuators	275GL+ and VHP	11/2019

VHP* Series

Number	Description	Engine Models	Date
1 Accessories			
1-2197A	Temperature Sensors for Main Bearings	VHP	3/1982
1-2215A	Main Bearing Temperature Shutdown System	VHP 6 & 12 Cylinder	4/1989
1-2498	Engine Block Heaters	VHP GL 6 & 12 Cyl. Engines	3/1987
1-2507	Front End Belt Drive With Outboard Bearing	P9390G, GSI & GL	5/1987
1-2620F	Engine Protection Shutdown	All Waukesha Engines	11/2007
1-2876	Quick Disconnect K-Type Exhaust Thermocouples	All Waukesha Engines	5/2001
1-3000	Air Starter Inertia Drive	VHP 6 & 12 Cylinder Engines	10/2008
1-4034	Updated E-Stop Button	All Waukesha Engines	11/2015
1-4048	Stub Shaft Guards	All Waukesha Engines	10/2015
1-4058	TDI Air Starter	All Waukesha Engines	12/2015
1-4081	New Main Bearing Thermocouples	VHP	8/2017
2 Air System			
2-2909	Prevention Of Intake Manifold Fractures And Release Of Improved Manifold	All VHP 6 & 12 Cylinder G/GSI Engines	12/2002
2-2931A	Air Cleaner Rubber Elbow	All VHP 6 Cylinder Engines	11/2005
2-2961	Crankcase Breather Hose	All VHP 6 Cylinder Engines	5/2006
2-4073	Air Cleaner Retrofit Service Kits	VHP 12-Cylinder Blow-Thru and Draw-Thru GSI, GL, LT Engines	7/2016
2-4074	Intake Manifold Inspection	VHP 9390GSI built prior to 2011	10/2016
2-4102	New Air Filters	VHP P9390GU, P9390GSIU, L7044GSI, L7042GL, L7042GSI, L5794LT, L5794GSI, L5774LT, F3524GSI	10/2018
3 Camshaft			
3-3082	VHP Camshaft Appearance	All VHP Engines	2/2013
3-4072	Procedure for Checking Cam Timing	VHP 12-cylinder and P9394 engines	8/2016
4 Cooling System			
4-1947E	Coolant Recommendations to Minimize Cylinder Sleeve Cavitation Damage	VHP	10/1998
4-2429J	Cooling System Guidelines And Water Treatment Recommendations	All Waukesha Engines	6/2016
4-2571C	Jacket Water Temperature Control Valve	All VHP Engine Models	3/1998
4-2605	VHP Auxiliary Water Temperature Control Valve	All VHP Engine Models	7/1993
4-2630B	New Type Jacket Water Pump Impeller And Pulley	VHP 6 & 12 Cylinder Engines	4/2000
4-2768	Improved Flexmaster Couplings	VHP 12 Cylinder Engines	5/1998
4-2791	Retrofit Top Water Manifold With New Front Support Bracket	VHP 12 Cylinder	11/1998
4-2879	Service Only Part Numbers For Thermostatic Valve Replacement Kits	All Waukesha Engines	6/2001
4-2891	Wastegate And Intercooler Water Tubes Retrofit Instructions	12 Cylinder VHP and VHP Series Four	5/2002
4-2982	Water Pump Seals	All VHP Engines	11/2007
4-3001A	Auxiliary Water Pump Self Adjusting Belt Tensioner	VHP Extender Series	12/2009
4-3081	Coolant Fire Potential	All Waukesha Engines	6/2013
4-4004	Potential Auxiliary Water Piping Separation	P9390GSI	9/2014

VHP* Series

Number	Description	Engine Models	Date
4-4098	VHP Use of Strainers on Auxiliary Cooling System During Commissioning	VHP	9/2017
4-4121	Intercooler and Wastegate Coolant Tube Clamps	VHP Series Four and Series Five P9394	2/2020

VHP* Series

Number	Description	Engine Models	Date
5 Crankshaft			
5-1864E	Replacement Connecting Rod Selection, Part No. 205007 Series	VHP	1/1982
5-2306A	Flywheel Ring Gears	All Waukesha Engines	7/1991
5-2328G	Crankshaft and Main Bearing Identification & Replacement	All VHP Gas/Diesel And VHP Series Four,	10/2018
5-2611B	Crankshaft Counterweight Capscrews	All VHP Engines with Fully Counterweighted Crankshafts	10/2001
5-2665C	VHP Pulley, Damper Drive, And Crank Gear Retrofit And Torque Information	VHP 12 & 16 Cylinder Engines & Series Four VHP	6/2013
5-2669	Crankshaft Speed Ratings	VHP 6, 12 & 16 Cylinder Engines	6/1995
5-2921	Crankshaft Gear Installation	All VHP 6 and 12 Cylinder Engines	5/2003
5-2951C	New Style Vibration Damper	6 Cylinder GSI/GL, 12 Cylinder and 16 Cylinder GSI VHP Engines	2/2007
5-2957A	New Upper and Lower Thrust Rings	All VHP Engines	6/2007
5-2986	Crankshaft Polishing	All Waukesha Engines	4/2008
5-4008	New Timing Tapes	All VHP Engines	8/2015
5-4028	Connecting Rod Cap Bolts	All Waukesha Engines	5/2015
6 Cylinder Block and Crankcase			
6-2395B	Extractor Breather System	F3524GSI, L7042GSI, P9390GSI, and VGF GL models	12/2016
6-2807	New Bearing Cap Interference	12 Cylinder VHP	3/1999
6-2811	VHP Cylinder Head Stud Bore Resizing	Previous VHP	3/1999
6-2855	New Main Bearing Caps And Nuts	VHP 6 And 12 Cylinder Engines	8/2000
6-2856A	Chromium Ceramic Top Ring For Series Four, Engines	All VHP Series Four, Engines	9/2000
6-2906	New Cylinder Liners	All VHP Engines	11/2002
6-2910K	Current VHP Power Cylinder Configurations	All VHP Engines	10/2018
6-2946	VHP Crankcase	VHP	4/2005
6-2985A	Gear Backlash Measurement	All VHP V-12 and V-16 Engines	2/2016
6-2994	Identifying Piston Crown Damage	All Waukesha Engines	7/2008
6-3014	Oil Separator Diaphragm Kits	VHP, VGF, APG150	6/2009
6-3021B	Updated Cam Follower	VHP	2/2020
6-3041	Gear Housing Rework	VHP 12 Cylinder Extender	9/2010
6-3054	Cylinder Sleeve O-Ring Lubrication	All APG, ATGL, VGF & VHP Engines	11/2010
6-3096A	Closed-Crankcase Breather Kits	Standard and Series Four* 12-Cylinder Non-Draw-thru Fuel System and Non-Naturally Aspirated	8/2015
6-4014	Oil Prevention Leak Program	All VHP Extender Engines	3/2015
6-4015	VHP Oil Pan Pipe Plug	All VHP Engines	3/2015
6-4016	VHP Oil Inlet Cover Gasket	All VHP Extender Engines	3/2015
6-4017A	Crankcase Cross-Tie Capscrew Seals	All VHP Extender Engines	11/2015
6-4018A	Front Gear Housing Resealing Procedure	All VHP Extender Engines	5/2015
6-4019	Oil Pan Door Assemblies	All VHP and VGF Engines	3/2015
6-4020	Explosion Relief Doors	All VHP Engines	4/2015
6-4021	VHP Crankcase Resealing Procedure	All VHP Engines	3/2015
6-4029	VHP Piston Ring End Clearance	L7042GL and P9390GL	4/2015
6-4030	Centrifugal Oil Filter	All engines equipped with centrifugal oil filter	4/2015
6-4037A	New Oil Cooler Piping	VHP 12 Cylinder Engines	5/2015

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Number	Description	Engine Models	Date
6-4096	Crankcase Breather Kit	F3524GSI/GSID Engines	7/2018
6-4105	New Rear Main Crankshaft Seal	P9394 and P9390	7/2018
6-4119	Breather Regulator Valve	VHP 12- and 16-Cylinder Non-Draw-Thru and Non-Naturally Aspirated Engines	8/2019
7 Cylinder Heads			
7-1933A	Selecting Correct Cylinder Head Gaskets and Studs to Match Various Cylinder Heads, Cylinder Sleeves, and Crankcases	VHP	8/1975
7-2044C	Rocker Arm Parts Interchangeability	VHP	6/1991
7-2634	O-ring Sealing Of Pushrod Tubes	All VHP	7/1994
7-2738	Rocker Arm Support to Cylinder Head Compatibility	VHP, (Except 5115)	11/1996
7-2740A	Current Valve Stem Seals, Rocker Arms And Valve Guide Configurations	VHP, (Except Series Four,)	4/1999
7-2754A	Valve Guide Oiling Improvements - "Quick Fix Procedures"	VHP 3521GL, 5115GL, 7042GL And 9390GL Engines	4/1999
7-2770	Use Of Modified Diesel Cylinders Heads On VHP Gas Engines	All VHP Gas Engines	7/1998
7-2858	High Temperature Exhaust Valve	VHP G And GSI Engines Except Series Four,	4/2001
7-2866A	New Fixed Lifter Screw And Hydraulic Lifter	VHP Engines With Hydraulic Lifters Except Series Four,	7/2002
7-2874	Rocker Shaft Support Modifications	All VHP Series Four, Engines	4/2001
7-2878A	Valve Bridge Guide Product Improvement And Retrofit Instructions	All VHP Series Four, Engines	7/2002
7-2885A	Pushrod Identification	All VHP Gas Engines	4/2005
7-2912A	Valve Spring Tapers (Keepers)	VHP Series Four, Engines	11/2007
7-2915C	One Piece Rocker Arm Bushing Released	VHP Series Four, Engines	5/2008
7-2922A	New VHP Cylinder Head Gaskets	VHP Engines	2/2004
7-2923	New Bridge And Rocker Arm Sealing Plug Expanders	All VHP Engines	9/2003
7-2925	Improved Water Jumper Elbow	VHP Series Four, Engines	9/2003
7-2938B	Change To Finished Inside Diameters Of Valve Guides	All VHP Engines	2/2009
7-2949C	New Exhaust Valves, Valve Guides, and Cylinder Heads	All Non Series Four, VHP, Engines	8/2007
7-2965E	Cylinder Head Components & Overhaul Procedures	VHP Series Four, Engines	11/2019
7-2973	New Valve Bridge Assembly	VHP Series Four	2/2007
7-2984B	Cylinder Head Overhaul Procedures	All Non Series Four VHP Engines	10/2008
7-3006	Series Four® Valve Kits Without Exhaust Valve Seats	VHP Series Four	2/2009
7-3085B	Updated Spark Plug Carrier and Extension	All VHP Engines	6/2018
7-3095	Intake Valve Rotator Inspection	VHP Series Four	6/2014
7-3097A	VHP Valve Adjustment	All VHP Engines	11/2015
7-3099A	Spark Plug Carrier Extension Sealing	VHP Series Four Engines	5/2015
7-4003	Spark Plug Carrier Extension Clearance	VHP Series Four	6/2014
7-4027B	Updated VHP GL Cylinder Heads	Non Series Four VHP GL Engines	3/2016
7-4038	Oil Header to Cylinder Head Tubes and Connectors	VHP Series Four 12-Cylinder Engines	7/2015
7-4049A	Updated Valve Rotator	All VHP Engines	4/2016

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Number	Description	Engine Models	Date
7-4067A	Corrected Valve Spring Lengths	All VHP Engines	12/2016
7-4090	Valve Lifters	All VHP Engines	4/2017
7-4120	Improved Exhaust Rocker Arm Components	Series Four & Series Five Engines	3/2020
8 Exhaust System			
8-2720	New Turbo Exhaust Outlet Tees And Elbows For AFM Installation And Rework Instructions	VHP 2895, 3521, 7042, 9390 GSI And GL	8/1996
8-2968	Improved Exhaust Gaskets	All 6 and 12 Cylinder VHP Engines	9/2006
8-3031	VHP Vent Line Kits	VHP 16-Cylinder P9390	7/2010
8-3063	Updated Exhaust Manifold Gasket	All VHP Engines	2/2013
8-4041A	Exhaust Piping Components	VHP 12-Cylinder Engines	8/2017
8-4047	Customer Exhaust Installation	All Waukesha Engines	10/2015
8-4111	VHP Cylinder Head Exhaust Manifold Gasket Installation	All VHP engines	8/2018
9 Fuel System			
9-2150A	Gas Pressure Regulator Recommendations (Special Warning)	All Natural Gas	7/1981
9-2574D	Improved Admission Valve for VHP GL Engines	VHP GL	11/1999
9-2701A	Gas Sampling Procedures	All Waukesha Engines	11/2007
9-2702D	Gaseous Fuel Specification, S-7884-7	All Waukesha Engines	10/2014
9-2889A	High Altitude Carburetor Gas Valve	VHP GSI And VHP Series Four GSI	3/2002
9-2916A	Mooney Fuel Regulators	VHP GSI/GL/LT	5/2006
9-3016A	Gas Regulator Actuator Updates	VHP with Mooney AFR	7/2010
9-3055	VHP AFR Regulator Spring Update	All VHP with ESM and AFR	7/2011
9-3064	Regulator Adjuster	All VHP with Fisher 99 Regulator	4/2011
9-3089	Potential Gas Leak – Fuel Inlet Piping	All VHP GL, GSI and LT 12-Cylinder Extender* Models Built 2006 to Present	6/2013
9-4022	IMPCO 600VF Carburetor Gasket Potential Gas Leak	All VGF/VHP models using a 600VF Carburetor	12/2014
9-4051	Updates to Gas Regulator Steppers	All VGF, VHP and ATGL/275GL Engines	11/2015
9-4059A	Obsolete Mooney Regulators	All VHP engines	1/2016
9-4062	AFR2 Additional Information	VHP 12-Cylinder AFR2 and emPact Engines	7/2016
9-4076	AFR2 Setup	VHP engines with AFR2/emPact	10/2016
9-4092A	New Single Fuel Inlet Kit Assemblies	VHP 12-Cylinder GL, GSI and GSI Extender* Engines	7/2018
10 Governors			
10-1901A	Woodward Governor and Governor Drive Recommendations	VHP & VC	4/1976

VHP* Series

Number	Description	Engine Models	Date
11 Ignition System			
11-1520A	Timing Tapes and Charts for Ignition Timing	All Waukesha Engines	10/1972
11-1895G	Spark Plug Recommendations	All Waukesha Gas Engines	11/1999
11-2295A	Modified Drive for Flange Mounted Magnetos	All VHP Series Gas Engines	7/1993
11-2558E	VHP Ignition Timing	All VHP Gas Engines	6/2002
11-2662	Custom Engine Control Ignition Module Hall-effect Pickup	AT, VHP, VGF Engines	2/1995
11-2680	New CEC Timing Disc And Governor Drive Gear	VHP 6, 12 and 16 Cylinder Gas Engines	7/1995
11-2684	Pressure Washing/Steam Cleaning Precaution For Electronic Devices Including CEC Product Modules	All Waukesha Engines	6/1995
11-2741A	Maintaining CSA Certification On Flange-Mounted Ignition Systems	ATGL, VHP, & VGF Engines Equipped With CSA Ignition Systems	1/2000
11-2750A	VHP Spark Plug Maintenance	All VHP Gas Engines	5/1999
11-2862	Magneto Adaptor Changes	VHP 6 And 8 Cylinder Engines	11/2000
11-2867	Ignition Harness Support	VHP Series Four Engines	2/2001
11-2881A	VHP Ignition Timing	VHP L7044GSI Gas Engines	10/2001
11-2882A	VHP Ignition Harness Replacement	VHP 12 Cylinder Series Four And Standard VHP 12 Cylinder With CSA Ignition	2/2002
11-2890	VHP Ignition Harness Replacement	VHP 6 Cylinder Series Four And Standard VHP 6 Cylinder With CSA Ignition	2/2002
11-2937	Release Of Square-Cut Seal Ring To Be Used on Spark Plug Carrier Extension	VHP Series Four Engines	6/2004
11-3029	Wiring Retrofit for VHP Extender Engines	12 Cylinder VHP Extender Engines	10/2009
11-3044	Emergency Stop Button Replacement	All Waukesha Engines	9/2014
11-4035	Improved Ignition Power Module-Diagnostic (IPM-D)	All ESM Equipped Engines	5/2015
11-4068	Camshaft and Crankshaft Magnetic Pickups	All Waukesha Engines	4/2016
11-4070	New Ignition Coil Heat Shield Kit	P9394	8/2016
11-4095	Power Distribution Junction Box (PDB) Cover Modification Instructions	All ESM Equipped Engines	7/2017
12 Lubrication System			
12-1880AR	Lube Oil Recommendations for GE's Waukesha gas engines	ALL APG, ATGL, VGF, VHP, 275GL Engines	12/2019
12-2570A	Thermostats for Lube Oil System	VHP	3/1998
12-2580	Oil Pump Manifold	VHP 6 & 12	5/1992
12-2598	VHP Lube Oil Filter	All VHP	3/1993
12-2677	Taking Oil Samples For Laboratory Analysis	All Waukesha Engines	6/1995
12-2698D	Microspin	VHP, VGF, AT, F817, F1197	3/1999
12-2703	Proper Installation Of VHP Prelube Pumps	All VHP	6/1996
12-2773	Turbocharger Oil Supply Line Clamps	VHP 12 Cylinder Turbocharged Engines	5/1998
12-2835	Service Parts For New Type VHP Oil Coolers	VHP	11/1999
12-2872	Redesigned Oil Screen Baffle	VHP 6 And 12 Cylinder	5/2001
12-2902A	New Oil Pan And O-Ring Released	All 6 And 12 Cylinder VHP Engines	10/2003
12-2924A	Torque Procedure For VHP Oil Pans	All 6 And 12 Cylinder VHP Engines	10/2003

VHP* Series

Number	Description	Engine Models	Date
12-2935A	Valve Lifter Door Gasket	VHP 6 Cylinder Engines	3/2008
12-2939	VHP Oil Pump	All VHP 6 Cylinder Engines	4/2005
12-2976	Engine Mounting Methods	All 12 Cylinder VHP Engines with Extender Series® Deep Sump Oil Pans	5/2007
12-2992A	VHP Oil Cooler Tubing	12 Cylinder Extender Series® Engines	12/2009
12-3040	VHP Extender Oil Pickup	VHP Extender	2/2010
12-4005	Inspection of Spin-on Oil Filters	275GL, VHP, APG & VGF Engines	6/2014
12-4069	New Centrifugal Oil Filter	All VHP 12 Cylinder Engines	8/2016
12-4086	Kenco Oil Level Regulator Control Improvements	All 6 And 12 Cylinder VHP Engines	12/2016
13 Turbochargers			
13-2248C	Adjustment and Repair of Wastegates	Turbocharged VHP Gas & Diesel with AiResearch and Brown Boveri Turbochargers	2/1991
13-2613A	Control Pressure Settings For Adjustable Wastegates	VHP GL (Draw-thru)	6/1994
13-2852B	Series Four Wastegate Adjustments For Altitude	F3524GSI, L5774LT, L5794GSI/LT, L7044GSI	1/2003
13-2875A	New Turbocharger With Clipped Blade Turbine Wheel	F2895, F3521, L5790, And L7042 GL Engines	6/2002
13-2883C	Turbocharger Elbow Gasket Failures	All VHP 12 Cylinder Turbocharged Engines	1/2003
13-2905A	New Heat Shields For Series Four 6 And 12 Cylinder Engines	Series Four, 6 And 12 Cylinder Engines	12/2002
13-2919	New Right Bank Turbocharger Outlet Tube	All VHP Series Four, 12 Cylinder Engines	3/2003
13-2955	Turbocharger Connections	All Standard 12 Cylinder VHP Engines (Non Series Four,)	5/2006
13-4012A	New Pressure Differential Wastegates	VHP L5794GSI, L7044GSI, and L7042GSI S4	11/2015
13-4023B	Turbocharger Oil Drain Lines	VHP L7042GSI	6/2019
13-4044B	Pipe Nipple Wastegate Balance Line	VHP L5794GSI, L7044GSI, L5774LT, and L5794LT	8/2017
13-4064	Updated Wastegate/Turbocharger Removal	P9394GSI	8/2016
13-4082	Wastegate Adjustment Procedure and Normal Control Pressure Specifications	VHP 12-Cylinder L5794GSI, L7044GSI, L7042GSI S4; VHP 16- Cylinder P9349GSI	8/2017
13-4088	Wastegate Balance Lines	L5794/L7044GSI and L5794/L7044GSID	11/2019
14 Application and Installation			
14-2582	Lubricating Electric Motors	All Waukesha Engines	2/1993
14-2815	Cylinder Compression Check Procedure	All Waukesha Engines	8/1999
14-3070	Proper Vent Line Flex Coupling Installation	All Waukesha Engines	1/2012
14-3071	Engine Vibration Levels	All Waukesha Engines	10/2011
14-4053	Customer Exhaust System Support	VHP L5774, L5794, L7042, and L7044	10/2015
14-4094	O-ring and Flare Hydraulic Fittings	All Waukesha Engines	4/2017

VHP* Series

Number	Description	Engine Models	Date
15 Tool Recommendations			
15-2007B	Exhaust Manifold Support Bracket	All VHP	8/1980
15-2758A	4-Valve Spring Compressor	All VHP	4/2000
15-2762A	4-Valve Spring Compressor For CSA Extended Length Spark Plug Carriers	Current VHP With CSA Extended Length Spark Plug Carriers	4/2000
15-2861	New Borescope Kit	All Waukesha Engines Except ATGL	6/2000
15-2871	Ignition Analyzer	All Waukesha Engines	3/2001
15-2959	Piston Ring Expander Pliers	All VHP Engines	2/2006
15-3050	New Valve Guide Installation Tool	All VHP Engines	10/2010
15-3056	Cylinder Liner Protusion Gauge	APG1000, VGF, VHP	7/2011
15-3057	Spark Plug Sleeve Seat Resurfacing Tool	APG1000/16V150LTD, VGF, VHP, APG2000/3000, ATGL/275GL+	7/2011
16 Miscellaneous			
16-1561E	Dresser Couplings and Gaskets	All Waukesha Engines	9/1988
16-1740E	Location of Engine Serial Numbers on Crankcase or Block Castings	APG, 275GL/ATGL, VHP, VGF	4/2015
16-1851A	Exercise Recommendations for Standby Engines	All Waukesha Engines	2/1973
16-1855J	Waukesha Preservative Oil	All Waukesha Engines	8/2016
16-1858	Preparation of Generators for Long-Term Storage	As Applicable	9/1970
16-2523C	VHP Maintenance Recommendations	Standard VHP Engines (Excluding Series Four)	9/2003
16-2539	Waukesha Maintenance Recommendations	All Engine Generator Units	7/1989
16-2596	VHP Gas Engine Protection Logic	VHP Gas 6 And 12 Cylinder	8/1995
16-2644A	Landfill Gas Engine Components	All Waukesha Engines	7/1997
16-2864B	Procedures For Light Load Operation	All Waukesha Engines	8/2016
16-2868B	New Lifting Devices	VHP 12 And 16 Cylinder Engines	8/2018
16-4009	VHP Series Four Extender Maintenance Intervals	VHP L5794GSI, L7042GSI S4, L7044GSI	10/2015
16-4052	New Corrosion-Resistant Front Pulleys	VHP 6 And 12 Cylinder Engines	12/2015
16-4056A	New Safety Labels	All Waukesha Engines	10/2018
16-4060	Sale of Chemicals	All Waukesha Engines	8/2016
16-4063	Timing of First Oil Sample/Analysis	VHP 9394GSI/Late model Series 4 12 Cyl	2/2016

VHP* Series

Number	Description	Engine Models	Date
17 Electronic Controls			
17-2847A	Power Distribution Box And Engine Wiring Information	Standard VHP GSI and VHP Series Four Engines	10/2002
17-2863A	Knock Sensor Torque Values	All APG, ATGL, VHP and VGF Engines	3/2010
17-2877	Specification of the CEC AFM and DSM Serial Streams	All Equipped with AFM and DSM	5/2001
17-2888	Release Of Higher Temperature Rated DSM Filters	All DSM Equipped Engines	1/2002
17-2893	DSM Alarm And Shutdown Connections	All DSM Equipped	3/2002
17-2904A	Adapter Harness To Be Used With Retrofit Of Early Model Actuator Assemblies To Current Actuator Assemblies	All AFM-Equipped Engines	6/2003
17-2941	Updated Software - DSM Version 635 and AFM Version 4.5	All DSM or AFM Equipped Engines	4/2005
17-2958C	Remote Programming of ECU	All ESM Equipped Engines	3/2015
17-2964	Battery Maintenance	All Waukesha Engines	9/2006
17-2970A	ESM Power Connection and Grounding	All VHP Engines with ESM	6/2007
17-2971A	ESM Display Panel	VHP Engines Equipped with ESM	7/2007
17-2972	High Oil Pressure Faults During ESM ECU Cold Starts	VHP Engines	2/2007
17-2975A	Stoichiometric Engine Oxygen Sensor Replacement	All ESM & CEC Engines with Oxygen Sensors	12/2008
17-2980A	ALM555 Troubleshooting	All ESM Equipped Engines	10/2009
17-2996	ESM Power Distribution Junction Box	All ESM Equipped Engines	9/2008
17-3008	ESM Oil Pressure and Shutdown Setpoints	All ESM Equipped Engines	12/2008
17-3037	New ESM Calibration for High Jacket Water Operation	All VHP Engines with ESM	3/2010
17-3048	Power Distribution Box Water Integrity	All Engines with ESM	10/2010
17-3093B	Updated Electronic Service Program	All Waukesha Engines with ESM	8/2016
17-3048A	PDB Reset and Water Integrity Guidelines	All Waukesha Engines with ESM	12/2014
17-4001B	Updated Power Distribution Junction Box	All Waukesha Engines with ESM	8/2017
17-4013	New ESM Wireway Assemblies	All VHP 12-Cylinder Extender* Engines	10/2016
17-4079	AFR2 HMI Update	VHP 12-cylinder engines equipped with AFR2/emPact	8/2017
17-4091A	New ECU Calibrations for High BTU Fuels	VHP L7044GSI AFR, L7044GSI AFR2, P9394GSI AFR2	8/2017
17-4101	Engine Control Unit (ECU)	VHP 6- and 12-Cylinder ESM2 Engines	6/2018
17-4106A	ESM Alarm 555 INT FLT 38 Updates	VGF & VHP	2/2020
17-4110	ESM Camshaft and Crankshaft Magnetic Pickup Adjustment	All Engines with ESM/ESM2	8/2018
17-4112A	ESM2 Engine Hour Feature	All Engines with ESM2	5/2019
17-4115	ESM2 HMI Software Update and Boot-up Process	All Engines with ESM2	4/2019
17-4117	Improved O2 Sensor Available	VHP & VGF	10/2019
17-4118	Troubleshooting Steps for Actuators	275GL+ and VHP	11/2019

VGF* Series

Number	Description	Engine Models	Date
1 Accessories			
1-4034	Updated E-Stop Button	All Waukesha Engines	11/2015
1-4048	Stub Shaft Guards	All Waukesha Engines	10/2015
1-4058	TDI Air Starter	All Waukesha Engines	12/2015
2 Air System			
2-2886	Air Filter Retention	VGF GSID/GLD Engines	10/2001
3 Camshaft			
3-2722B	Checking Camshaft Timing By Measuring Valve Lift	All VGF Engines	9/2000
4 Cooling System			
4-2429J	Cooling System Guidelines And Water Treatment Recommendations	All Waukesha Engines	6/2016
4-2824	Auxiliary Water Pump Seal Replacement	VGF L36, P48 Engines	7/1999
4-2879	Service Only Part Numbers For Thermostatic Valve Replacement Kits	All Waukesha Engines	6/2001
4-2930	Water Pump Seal	All VGF Engines	1/2004
4-2952A	Water Pump	All VGF Engines	4/2006
4-3027A	APG1000 / VGF Jacket Water Heater Updates	APG1000, 16v150LTD and VGF Vee Engines	12/2010
4-3081	Coolant Fire Potential	All Waukesha Engines	6/2013
5 Crankshaft			
5-2306A	Flywheel Ring Gears	All Waukesha Engines	7/1991
5-2830	Main And Rod Bearing Design Change	All VGF Engines	2/2000
5-2834	Connecting Rod Bolt Torque	All VGF Engines	10/1999
5-2870	VGF Crankshaft Oil Seals	All VGF Engines	3/2001
5-2887	Main Bearing Cap Tightening Sequence (Dual Dowel Pin)	All VGF Engines	11/2001
5-2907	VGF Crankshaft Oil Seal Retainer	VGF L36 and P48 Engines	12/2002
5-2986	Crankshaft Polishing	All Waukesha Engines	4/2008
5-3002	Connecting Rod Bearing Installation	All VGF Engines	10/2008
5-3003A	Connecting Rod Wear Limits	All VGF Engines	2/2009
5-3028	Vibration Damper Adapter Installation	All VGF Engines	12/2009
5-3087	New Crankshaft Plugs	All VGF Engines & APG1000/16V150LTD	9/2013
5-4007	Use of Improperly Reconditioned Connecting Rods	VGF/APG/ATGL/275GL	9/2014
5-4028	Connecting Rod Cap Bolts	All Waukesha Engines	5/2015
6 Cylinder Block and Crankcase			
6-2395B	Extractor Breather System	F3524GSI, L7042GSI, P9390GSI, and VGF GL models	12/2016
6-2589	L36 Main Bearing Cap Installation And Torque Specifications	All VGF L36 Engines	12/1992
6-2831A	Piston Cooling Jet Supersession	All VGF Engines	3/2001
6-2833A	Crankcase Main Bearing Bore Dimension Correction	VGF L36/P48	12/1999
6-2839B	VGF Pistons, Cylinder Liners, and Rings	All VGF Engines	3/2007
6-2873A	New Closed Breather System	VGF F18GL And H24GL Engines	8/2002
6-2926B	Cylinder Head Capscrews	All VGF Engines	5/2006
6-2997A	Inline Main Bearing Bore Dimension and Bearing Cap Bolt Torque	VGF F18/H24	10/2008
6-2994	Identifying Piston Crown Damage	All Waukesha Engines	7/2008
6-3007	Camshaft Bore Dimensions	VGF F18/H24	2/2009

VGF* Series

Number	Description	Engine Models	Date
6-3014	Oil Separator Diaphragm Kits	VHP, VGF, APG150	6/2009
6-3018	Piston Cooling Jet Screw Torque	VGF L36 & P48	6/2009
6-4019	Oil Pan Door Assemblies	All VHP and VGF Engines	3/2015
6-3054	Cylinder Sleeve O-Ring Lubrication	All APG, ATGL, VGF & VHP Engines	11/2010
6-4030	Centrifugal Oil Filter	All engines equipped with centrifugal oil filter	4/2015
6-4039A	New Piston Rings	All VGF Engines	10/2015
7 Cylinder Heads			
7-2551C	Cylinder Head Changes	All VGF	10/1997
7-2841B	New Valve Guide Oiling Hardware	VGF F18/H24 LCR/HCR and L36/P48 HCR Engines	5/2002
7-2953B	Current VGF Cylinder Head Assemblies	All VGF Engines	9/2008
7-4050	Cylinder Head Gasket	All VGF Engines	9/2015
8 Exhaust System			
8-2581	Exhaust Manifolds And Heat Balance Data	VGF F18GL and H24GL	4/1992
8-2956	Exhaust Manifold Gaskets	All VGF Engines	11/2005
9 Fuel System			
9-2150A	Gas Pressure Regulator Recommendations (Special Warning)	All Natural Gas	7/1981
9-2701A	Gas Sampling Procedures	All Waukesha Engines	11/2007
9-2702D	Gaseous Fuel Specification, S-7884-7	All Waukesha Engines	10/2014
9-2708C	Deltec Carburetor Adjustment (Draw Through)	VGF L36/P48GLD/GSID	5/1998
9-2783	F18/H24GL Low Compression Ratio Fuel System Conversion	VGF F18/H24GL Engines	9/1998
9-2784	New Fuel Pressure Regulator	All VGF GL Engines	8/1998
9-2853	StartUp and ShutDown Of Engines Equipped With Deltec, Carburetion	16V-AT27GL, VGF F18/H24GLD And VGF L36/48GLD/GSID	7/2000
9-2884	New Impco 400 VF Carburetor Fuel Cone	F18GL and H24GL –LCR Engines	9/2001
9-2974	Carburetor Adjustment	F18GL, F18GL LCR, H24GL and H24GL LCR	3/2007
9-3075	New Fuel Pressure Regulator	VGF F18/H24 G, GLD, GSID Engines	10/2014
9-4022	IMPCO 600VF Carburetor Gasket Potential Gas Leak	All VGF/VHP models using a 600VF Carburetor	12/2014
9-4051	Updates to Gas Regulator Steppers	All VGF, VHP and ATGL/275GL Engines	11/2015
10 Governors			
10-2819	Improving Governor Cold Start Response	VGF L36/P48 Equipped With PSG And EG3P Governors	5/2000
11 Ignition System			
11-1520A	Timing Tapes and Charts for Ignition Timing	All Waukesha Engines	10/1972
11-1895G	Spark Plug Recommendations	All Waukesha Engines	11/1999
11-2653	Installing the CEC 24 Volt Generator	VGF F18, H24	1/1995
11-2662	Custom Engine Control Ignition Module Hall-effect Pickup	AT, VHP, VGF Engines	2/1995
11-2684	Pressure Washing/Steam Cleaning Precaution For Electronic Devices Including CEC Product Modules	All Waukesha Engines	6/1995
11-2731A	VGF Ignition Timing	All VGF	11/2009

VGF* Series

Number	Description	Engine Models	Date
11-2741A	Maintaining CSA Certification On Flange-Mounted Ignition Systems	ATGL, VHP, & VGF Engines Equipped With CSA Ignition Systems	1/2000
11-2782B	Refitting New Flange Mounted Shielded Ignition Coils	VGF Engines With Shielded Ignition Systems	11/1999
11-2854	Custom Engine Control Ignition Module Mounting Bracket	VGF 6 And 8 Cylinder Engines	8/2000
11-2933	Hall-effect Pickup Installation	VGF L36/P48 Engines	3/2004
11-3044	Emergency Stop Button Replacement	All Waukesha Engines	9/2014
11-4068	Camshaft and Crankshaft Magnetic Pickups	All Waukesha Engines	4/2016
11-4095	Power Distribution Junction Box (PDB) Cover Modification Instructions	All ESM Equipped Engines	7/2017
12 Lubrication System			
12-1880AR	Lube Oil Recommendations for GE's Waukesha gas engines	ALL APG, ATGL, VGF, VHP, 275GL Engines	12/2019
12-2677	Taking Oil Samples For Laboratory Analysis	All Waukesha Engines	6/1995
12-2687	New Engine Oil Pumps	VGF F18, H24	8/1995
12-2698D	Microspin	VHP, VGF, AT, F817, F1197	3/1999
12-2829	Improved Oil Filters	VGF L36/P48	8/1999
12-2869	Oil Pump Seal	All VGF Engines	5/2001
12-2943A	Pressure Regulator Spring	All VGF Engines	11/2005
12-2991	VGF Inline Oil Pumps	All 6 & 8 Cylinder VGF Engines	8/2008
12-4005	Inspection of Spin-on Oil Filters	275GL, VHP, APG & VGF Engines	6/2014
13 Turbochargers			
13-2859A	LCR Wastegate Adjustments For Elevation	VGF F18GL (LCR) and H24GL (LCR)	9/2006
13-2880A	New VGF Turbocharger	VGF H24 and P48 Engines	12/2001
13-2940	VGF Wastegate Mounting Plate	VGF F18/H24 Engines	5/2005
13-3009B	Inline Turbocharger Oil Supply / Return Tube Clamps	All Turbocharged F18 and H24 Engines	3/2016
13-4064	Updated Wastegate/Turbocharger Removal	P9394GSI	8/2016
14 Application and Installation			
14-2582	Lubricating Electric Motors	All Waukesha Engines	2/1993
14-2749D	Formulas For Predicting BHP and Intake Manifold Pressure	All VGF GL, GLD, GSID	1/2001
14-2766A	Differences Between Previous And Current Production 8.7:1, Low Compression Ratio Engines	VGF F18GL LCR Engines	11/1998
14-2815	Cylinder Compression Check Procedure	All Waukesha Engines	8/1999
14-3070	Proper Vent Line Flex Coupling Installation	All Waukesha Engines	1/2012
14-3071	Engine Vibration Levels	All Waukesha Engines	10/2011
14-4094	O-ring and Flare Hydraulic Fittings	All Waukesha Engines	4/2017
15 Tool Recommendations			
15-2658E	Offset Torque Wrench Adapter P/N 472001	VGF F18 and H24	10/2008
15-2861	New Borescope Kit	All Waukesha Engines Except ATGL	6/2000
15-2871	Ignition Analyzer	All Waukesha Engines	3/2001
15-3056	Cylinder Liner Protusion Gauge	APG1000, VGF, VHP	7/2011
15-3057	Spark Plug Sleeve Seat Resurfacing Tool	APG1000/16V150LTD, VGF, VHP, APG2000/3000, ATGL/275GL+	7/2011
15-4010	Cylinder Liner Removal and Installation Tools	All VGF and APG Engines	7/2015

VGF* Series

Number	Description	Engine Models	Date
16 Miscellaneous			
16-1561E	Dresser Couplings and Gaskets	All Waukesha Engines	9/1988
16-1740E	Location of Engine Serial Numbers on Crankcase or Block Castings	APG, 275GL/ATGL, VHP, VGF	4/2015
16-1851A	Exercise Recommendations for Standby Engines	All Waukesha Engines	2/1973
16-1855J	Waukesha Preservative Oil	All Waukesha Engines	8/2016
16-1858	Preparation of Generators for Long-Term Storage	As Applicable	9/1970
16-2539	Waukesha Maintenance Recommendations	All Engine Generator Units	7/1989
16-2644A	Landfill Gas Engine Components	All Waukesha Engines	7/1997
16-2696B	Waukesha Maintenance Recommendations	All VGF Engines	6/2003
16-2864B	Procedures For Light Load Operation	All Waukesha Engines	8/2016
16-2892	Intermediate Gear Bushing Installation	VGF F18 and H24 Engines	2/2002
16-2981	Engine Break-In	All VGF Engines	11/2007
16-4056A	New Safety Labels	All Waukesha Engines	10/2018
17 Electronic Controls			
17-2863A	Knock Sensor Torque Values	All APG, ATGL, VHP and VGF Engines	3/2010
17-3048A	PDB Reset and Water Integrity Guidelines	All Waukesha Engines with ESM	12/2014
17-4001A	Updated Power Distribution Junction Box	All Waukesha Engines with ESM	12/2014
17-4106A	ESM Alarm 555 INT FLT 38 Updates	VGF & VHP	2/2020
17-4110	ESM Camshaft and Crankshaft Magnetic Pickup Adjustment	All Engines with ESM/ESM2	8/2018
17-4112A	ESM2 Engine Hour Feature	All Engines with ESM2	5/2019
17-4115	ESM2 HMI Software Update and Boot-up Process	All Engines with ESM2	4/2019
17-4117	Improved O2 Sensor Available	VHP & VGF	10/2019

VSG Series

Number	Description	Engine Models	Date
1 Accessories			
1-2620F	Engine Protection Shutdown	All Waukesha Engines	11/2007
1-2876	Quick Disconnect K-Type Exhaust Thermocouples	All Waukesha Engines	5/2001
4 Cooling System			
4-2879	Service Only Part Numbers For Thermostatic Valve Replacement Kits	All Waukesha Engines	6/2001
5 Crankshaft			
5-2306A	Flywheel Ring Gears	All Waukesha Engines	7/1991
5-2986	Crankshaft Polishing	All Waukesha Engines	4/2008
5-4028	Connecting Rod Cap Bolts	All Waukesha Engines	5/2015
6 Cylinder Block and Crankcase			
6-2759	Crankcase, Cylinder Sleeve and O-Ring Seal Part Number Supersession	All VSG	8/1997
6-2994	Identifying Piston Crown Damage	All Waukesha Engines	7/2008
7 Cylinder Heads			
7-2705	New Valves And Valve Seat Inserts	All VSG	11/1995
9 Fuel System			
9-2150A	Gas Pressure Regulator Recommendations (Special Warning)	All Natural Gas	7/1981
9-2689	Carburetor And Regulator Changes	VSG F11G/GSI Engines	7/1995
9-2701A	Gas Sampling Procedures	All Waukesha	11/2007
9-2702D	Gaseous Fuel Specification, S-7884-7	All Waukesha Engines	10/2014
9-2732	VSG F11GSID Hard Starting	VSG F11GSID	7/1996
9-2820	VSG Fuel System Adjustment Procedures	All VSG	4/2000
9-2896	Hard Starting on Engines Running on Digester Gas	VSG-F11GSID	4/2002
11 Ignition System			
11-1520A	Timing Tapes and Charts for Ignition Timing	All Waukesha Engines	10/1972
11-1895G	Spark Plug Recommendations	All Waukesha Engines	11/1999
11-2576	VSG Ignition Timing	F11GSI, F11GSID	2/1992
11-2684	Pressure Washing/Steam Cleaning Precaution For Electronic Devices Including CEC Product Modules	All Waukesha Engines	6/1995
11-2764	New CSA Ignition Groups	VSG F11G/GSI/GSID	11/1997
11-3044	Emergency Stop Button Replacement	All Waukesha Engines	9/2014
12 Lubrication System			
12-2677	Taking Oil Samples For Laboratory Analysis	All Waukesha Engines	6/1995
12-2752	Oil Level Regulator Vent Tube Assembly	All VSG F11 Engines	3/1997
12-2983	Oil Pump	All VSG F11 Engines	11/2007
13 Turbochargers			
13-2673A	Turbocharger Field Retrofit	F11GSI/GSID New Concept	10/1996
13-2678	Turbocharger Field Retrofit	F11GSI/GSID Old Concept - Built Before July 1992	7/1995
13-4064	Updated Wastegate/Turbocharger Removal	P9394GSI	8/2016

VSG Series

Number	Description	Engine Models	Date
14 Application and Installation			
14-2582	Lubricating Electric Motors	All Waukesha Engines	2/1993
14-2707A	Intake Manifold Charge Density VS Brake Horsepower	VSG F11GSI	11/1995
14-2815	Cylinder Compression Check Procedure	All Waukesha Engines	8/1999
14-3070	Proper Vent Line Flex Coupling Installation	All Waukesha Engines	1/2012
14-3071	Engine Vibration Levels	All Waukesha Engines	10/2011
15 Tool Recommendations			
15-2861	New Borescope Kit	All Waukesha Engines Except ATGL	6/2000
15-2871	Ignition Analyzer	All Waukesha Engines	3/2001
16 Miscellaneous			
16-1561E	Dresser Couplings and Gaskets	All Waukesha Engines	9/1988
16-1851A	Exercise Recommendations for Standby Engines	All Waukesha Engines	2/1973
16-1855J	Waukesha Preservative Oil	All Waukesha Engines	8/2016
16-2539	Waukesha Maintenance Recommendations	All Engine Generator Units	7/1989
16-2644A	Landfill Gas Engine Components	All Waukesha Engines	7/1997
16-2796A	New Belt Tightener And Pulley Guard Update	All VSG F11 Engines	3/1999
16-2864B	Procedures For Light Load Operation	All Waukesha Engines	8/2016
16-4056A	New Safety Labels	All Waukesha Engines	10/2018

APG* Series

Number	Description	Engine Models	Date
0 Safety			
0-4099	Special Tool Hydraulic Lines	275GL+, ATGL, APG 2000/3000	11/2017
1 Accessories			
1-2620F	Engine Protection Shutdown	All Waukesha Engines	11/2007
1-2876	Quick Disconnect K-Type Exhaust Thermocouples	All Waukesha Engines	5/2001
1-4034	Updated E-Stop Button	All Waukesha Engines	11/2015
1-4048	Stub Shaft Guards	All Waukesha Engines	10/2015
1-4058	TDI Air Starter	All Waukesha Engines	12/2015
2 Air System			
2-3046	Intake Butterfly Valve (Throttle Valve) Update	APG1000/16V150LTD	12/2010
4 Cooling System			
4-2429J	Cooling System Guidelines And Water Treatment Recommendations	All Waukesha Engines	6/2016
4-2879	Service Only Part Numbers For Thermostatic Valve Replacement Kits	All Waukesha Engines	6/2001
4-3027A	APG1000 / VGF Jacket Water Heater Updates	APG1000, 16v150LTD and VGF Vee Engines	12/2010
4-3043	Intercooler Support Bracket Kit	APG1000/16V150LTD	4/2010
4-3053	Jacket Water Pump Repair Kit	APG1000/16V150LTD	4/2011
4-3067	Jacket Water Bypass Updates	APG1000/16V150LTD	10/2011
4-3081	Coolant Fire Potential	All Waukesha Engines	6/2013
4-4006	Required Inspection/Replacement of Rubber Flex Connectors	All APG 2000/3000 Enginators	8/2014
5 Crankshaft			
5-2306A	Flywheel Ring Gears	All Waukesha Engines	7/1991
5-2986	Crankshaft Polishing	All Waukesha Engines	4/2008
5-2998	Connecting Rod Bearing Dimension	APG1000/16V150LTD	12/2008
5-3087	New Crankshaft Plugs	All VGF Engines & APG1000/16V150LTD	9/2013
5-4007	Use of Improperly Reconditioned Connecting Rods	VGF/APG/ATGL/275GL	9/2014
5-4028	Connecting Rod Cap Bolts	All Waukesha Engines	5/2015
6 Cylinder Block and Crankcase			
6-2994	Identifying Piston Crown Damage	All Waukesha Engines	7/2008
6-3014	Oil Separator Diaphragm Kits	VHP, VGF, APG150	6/2009
6-3054	Cylinder Sleeve O-Ring Lubrication	All APG, ATGL, VGF & VHP Engines	11/2010
6-4030	Centrifugal Oil Filter	All engines equipped with centrifugal oil filter	4/2015
6-4077	New Closed-Crankcase Breather Kits	APG1000	8/2016
7 Cylinder Heads			
7-3034	Cylinder Head Updates	APG1000/16V150LTD	12/2010
7-3069A	APG Cylinder Head and Rocker Arm Housing Gasket Update	APG1000/16V150LTD	7/2015
7-4024A	Exhaust Valves, Exhaust Valve Set Inserts and Cylinder Head Assembly Updates	APG1000/16V150LTD	2/2016
8 Exhaust System			
8-4047	Customer Exhaust Installation	All Waukesha Engines	10/2015

APG* Series

Number	Description	Engine Models	Date
9 Fuel System			
9-2150A	Gas Pressure Regulator Recommendations (Special Warning)	All Natural Gas	7/1981
9-2701A	Gas Sampling Procedures	All Waukesha Engines	11/2007
9-2702D	Gaseous Fuel Specification, S-7884-7	All Waukesha Engines	10/2014
9-3022	Start Assist Instruction	APG1000/16V150LTD	8/2009
9-3052	Biogas Updates	APG1000/16V150LTD	12/2010
9-4055	Fuel Pressure Regulator Kit	APG1000/16V150LTD	1/2016
9-4087A	APG1000 Biogas Improved Fuel Valve	APG1000	2/2018
11 Ignition System			
11-1520A	Timing Tapes and Charts for Ignition Timing	All Waukesha Engines	10/1972
11-1895G	Spark Plug Recommendations	All Waukesha Engines	11/1999
11-2684	Pressure Washing/Steam Cleaning Precaution For Electronic Devices Including CEC Product Modules	All Waukesha Engines	6/1995
11-3044	Emergency Stop Button Replacement	All Waukesha Engines	9/2014
11-4068	Camshaft and Crankshaft Magnetic Pickups	All Waukesha Engines	4/2016
11-4095	Power Distribution Junction Box (PDB) Cover Modification Instructions	All ESM Equipped Engines	7/2017
12 Lubrication System			
12-1880AR	Lube Oil Recommendations for GE's Waukesha gas engines	ALL APG, ATGL, VGF, VHP, 275GL Engines	12/2019
12-2677	Taking Oil Samples For Laboratory Analysis	All Waukesha Engines	6/1995
12-3035	Kenco Oil Leveler and Crankcase Pressure Tap Point	APG1000/16V150LTD	3/2010
12-4005	Inspection of Spin-on Oil Filters	275GL, VHP, APG & VGF Engines	6/2014
13 Turbochargers			
13-2990	Turbocharger Cleaning	APG1000/16V150LTD	4/2008
13-3015	Wastegate Pressure Tube Restrictor Blockage	APG1000/16V150LTD	6/2009
13-3076	Updated Wastegate	APG1000/16V150LTD	6/2013
13-3084	APG1000 Compressor Bypass Elimination	APG1000/16V150LTD	12/2017
13-4064	Updated Wastegate/Turbocharger Removal	P9394GSI	8/2016
14 Application and Installation			
14-2582	Lubricating Electric Motors	All Waukesha Engines	2/1993
14-2815	Cylinder Compression Check Procedure	All Waukesha Engines	8/1999
14-2993	Generator Alignment Procedure	APG2000, APG3000	8/2008
14-3070	Proper Vent Line Flex Coupling Installation	All Waukesha Engines	1/2012
14-3071	Engine Vibration Levels	All Waukesha Engines	10/2011
14-4094	O-ring and Flare Hydraulic Fittings	All Waukesha Engines	4/2017
15 Tool Recommendations			
15-2861	New Borescope Kit	All Waukesha Engines Except ATGL	6/2000
15-2871	Ignition Analyzer	All Waukesha Engines	3/2001
15-3010	Cylinder Head Lifter P/N 472091	APG1000/16V150LTD	2/2009
15-3026	APG1000 Tools	APG1000/16V150LTD	12/2010
15-3056	Cylinder Liner Protusion Gauge	APG1000, VGF, VHP	7/2011
15-3057	Spark Plug Sleeve Seat Resurfacing Tool	APG1000/16V150LTD, VGF, VHP, APG2000/3000, ATGL/275GL+	7/2011
15-3058	Rod Journal Protector	APG2000/3000	4/2011
15-3060	Updated Valve Spring Compressor	APG1000/16V150LTD	4/2011
15-4010	Cylinder Liner Removal and Installation Tools	All VGF and APG Engines	7/2015

APG* Series

Number	Description	Engine Models	Date
15-4011	APG1000 Biogas Engine Diagnostic Tool	APG1000/16V150LTD	3/2015

APG* Series

Number	Description	Engine Models	Date
16 Miscellaneous			
16-1561E	Dresser Couplings and Gaskets	All Waukesha Engines	9/1988
16-1740E	Location of Engine Serial Numbers on Crankcase or Block Castings	APG, 275GL/ATGL, VHP, VGF	4/2015
16-1851A	Exercise Recommendations for Standby Engines	All Waukesha Engines	2/1973
16-1855J	Waukesha Preservative Oil	All Waukesha Engines	8/2016
16-1858	Preparation of Generators for Long-Term Storage	As Applicable	9/1970
16-2644A	Landfill Gas Engine Components	All Waukesha Engines	7/1997
16-2864B	Procedures For Light Load Operation	All Waukesha Engines	8/2016
16-3030A	Start and Run Checklists	APG1000/16V150LTD	5/2015
16-4056A	New Safety Labels	All Waukesha Engines	10/2018
17 Electronic Controls			
17-2863A	Knock Sensor Torque Values	All APG, ATGL, VHP and VGF Engines	3/2010
17-2958C	Remote Programming of ECU	All ESM Equipped Engines	3/2015
17-2964	Battery Maintenance	All Waukesha Engines	9/2006
17-2980A	ALM555 Troubleshooting	All ESM Equipped Engines	10/2009
17-2987	Wiring Diagram Supplement	APG 12V / 18V 220GL	3/2008
17-2988	Magnetic Pickup	APG 12V 220GL, 18V220GL, APG2000, APG3000	4/2008
17-2996	ESM Power Distribution Junction Box	All ESM Equipped Engines	9/2008
17-3008	ESM Oil Pressure and Shutdown Setpoints	All ESM Equipped Engines	12/2008
17-3020	APG1000 Paralleling Instructions	APG1000/16V150LTD	8/2008
17-3048	Power Distribution Box Water Integrity	All Engines with ESM	10/2010
17-3093B	Updated Electronic Service Program	All Waukesha Engines with ESM	8/2016
17-3048A	PDB Reset and Water Integrity Guidelines	All Waukesha Engines with ESM	12/2014
17-4001A	Updated Power Distribution Junction Box	All Waukesha Engines with ESM	12/2014

Number	Description	Engine Models	Date
0 Safety			
0-4099	Special Tool Hydraulic Lines	275GL+, ATGL, APG 2000/3000	11/2017

Number	Description	Engine Models	Date
1 Accessories			
1-2197A	Temperature Sensors for Main Bearings	VHP	3/1982
1-2215A	Main Bearing Temperature Shutdown System	VHP 6 & 12 Cylinder	4/1989
1-2498	Engine Block Heaters	VHP GL 6 & 12 Cyl. Engines	3/1987
1-2507	Front End Belt Drive With Outboard Bearing	P9390G, GSI & GL	5/1987
1-2620F	Engine Protection Shutdown	All Waukesha Engines	11/2007
1-2876	Quick Disconnect K-Type Exhaust Thermocouples	All Waukesha Engines	5/2001
1-3000	Air Starter Inertia Drive	VHP 6 & 12 Cylinder Engines	10/2008
1-4034	Updated E-Stop Button	All Waukesha Engines	11/2015
1-4048	Stub Shaft Guards	All Waukesha Engines	10/2015
1-4058	TDI Air Starter	All Waukesha Engines	12/2015
1-4081	New Main Bearing Thermocouples	VHP	8/2017

Number	Description	Engine Models	Date
2 Air System			
2-2886	Air Filter Retention	VGF GSID/GLD Engines	10/2001
2-2909	Prevention Of Intake Manifold Fractures And Release Of Improved Manifold	All VHP 6 & 12 Cylinder G/GSI Engines	12/2002
2-2931A	Air Cleaner Rubber Elbow	All VHP 6 Cylinder Engines	11/2005
2-2961	Crankcase Breather Hose	All VHP 6 Cylinder Engines	5/2006
2-3046	Intake Butterfly Valve (Throttle Valve) Update	APG1000/16V150LTD	12/2010
2-4073	Air Cleaner Retrofit Service Kits	VHP 12-Cylinder Blow-Thru and Draw-Thru GSI, GL, LT Engines	7/2016
2-4074	Intake Manifold Inspection	VHP 9390GSI built prior to 2011	10/2016
2-4102	New Air Filters	VHP P9390GU, P9390GSIU, L7044GSI, L7042GL, L7042GSI, L5794LT, L5794GSI, L5774LT, F3524GSI	10/2018

Number	Description	Engine Models	Date
3 Camshaft			
3-2722B	Checking Camshaft Timing By Measuring Valve Lift	All VGF Engines	9/2000
3-3082	VHP Camshaft Appearance	All VHP Engines	2/2013
3-4072	Procedure for Checking Cam Timing	VHP 12-cylinder and P9394 engines	8/2016

Number	Description	Engine Models	Date
4 Cooling System			
4-1947E	Coolant Recommendations to Minimize Cylinder Sleeve Cavitation Damage	VHP	10/1998
4-2429J	Cooling System Guidelines And Water Treatment Recommendations	All Waukesha Engines	6/2016
4-2554J	ATGL Engine Auxiliary and Jacket Water Pumps	All ATGL Engines	4/2001
4-2569	AT Thermostat Repair Kits	12V-AT25GL Engines	7/1991
4-2571C	Jacket Water Temperature Control Valve	All VHP Engine Models	3/1998
4-2605	VHP Auxiliary Water Temperature Control Valve	All VHP Engine Models	7/1993
4-2630B	New Type Jacket Water Pump Impeller And Pulley	VHP 6 & 12 Cylinder Engines	4/2000
4-2768	Improved Flexmaster Couplings	VHP 12 Cylinder Engines	5/1998
4-2775A	Intercooler Mounting Clarification	AT 8L-AT27 Engines	10/1998
4-2791	Retrofit Top Water Manifold With New Front Support Bracket	VHP 12 Cylinder	11/1998
4-2824	Auxiliary Water Pump Seal Replacement	VGF L36, P48 Engines	7/1999
4-2879	Service Only Part Numbers For Thermostatic Valve Replacement Kits	All Waukesha Engines	6/2001
4-2891	Wastegate And Intercooler Water Tubes Retrofit Instructions	12 Cylinder VHP and VHP Series Four	5/2002
4-2930	Water Pump Seal	All VGF Engines	1/2004
4-2952A	Water Pump	All VGF Engines	4/2006
4-2982	Water Pump Seals	All VHP Engines	11/2007
4-3001A	Auxiliary Water Pump Self Adjusting Belt Tensioner	VHP Extender Series	12/2009
4-3027A	APG1000 / VGF Jacket Water Heater Updates	APG1000, 16v150LTD and VGF Vee Engines	12/2010
4-3043	Intercooler Support Bracket Kit	APG1000/16V150LTD	4/2010
4-3053	Jacket Water Pump Repair Kit	APG1000/16V150LTD	4/2011
4-3067	Jacket Water Bypass Updates	APG1000/16V150LTD	10/2011
4-3081	Coolant Fire Potential	All Waukesha Engines	6/2013
4-4006	Required Inspection/Replacement of Rubber Flex Connectors	All APG 2000/3000 Enginators	8/2014
4-4004	Potential Auxiliary Water Piping Separation	P9390GSI	9/2014
4-4098	VHP Use of Strainers on Auxiliary Cooling System During Commissioning	VHP	9/2017
4-4121	Intercooler and Wastegate Coolant Tube Clamps	VHP Series Four and Series Five P9394	2/2020

Number	Description	Engine Models	Date
5 Crankshaft			
5-1864E	Replacement Connecting Rod Selection, Part No. 205007 Series	VHP	1/1982
5-2306A	Flywheel Ring Gears	All Waukesha Engines	7/1991
5-2328G	Crankshaft and Main Bearing Identification & Replacement	All VHP Gas/Diesel And VHP Series Four,	10/2018
5-2611B	Crankshaft Counterweight Capscrews	All VHP Engines with Fully Counterweighted Crankshafts	10/2001
5-2665C	VHP Pulley, Damper Drive, And Crank Gear Retrofit And Torque Information	VHP 12 & 16 Cylinder Engines & Series Four VHP	6/2013
5-2669	Crankshaft Speed Ratings	VHP 6, 12 & 16 Cylinder Engines	6/1995
5-2781A	Crankshaft Counterweight Bolt Torque	All ATGL Engines	11/1999
5-2793	Operating Range Clarification	8L-AT27GL	10/1999
5-2818	New Torsional Vibration Damper	8L-AT27GL	5/1999
5-2821A	Correct Torque Specifications For Damper, Stub Shaft And Extension Shaft Bolts	All ATGL Engines	9/1999
5-2830	Main And Rod Bearing Design Change	All VGF Engines	2/2000
5-2834	Connecting Rod Bolt Torque	All VGF Engines	10/1999
5-2842	ATGL% New Crankshaft Split Gear Clamp Ring Torque Data	8L-ATGL/12V-ATGL	5/2000
5-2870	VGF Crankshaft Oil Seals	All VGF Engines	3/2001
5-2887	Main Bearing Cap Tightening Sequence (Dual Dowel Pin)	All VGF Engines	11/2001
5-2895B	New Hydrolastic Damper	8L-AT27GL	3/2003
5-2907	VGF Crankshaft Oil Seal Retainer	VGF L36 and P48 Engines	12/2002
5-2921	Crankshaft Gear Installation	All VHP 6 and 12 Cylinder Engines	5/2003
5-2926B	Crankshaft End Play Correction In ATGL Repair & Overhaul Manuals	8L-ATGL, 12V-AT25/27GL And 16V-AT27GL	4/2005
5-2951C	New Style Vibration Damper	6 Cylinder GSI/GL, 12 Cylinder and 16 Cylinder GSI VHP Engines	2/2007
5-2957A	New Upper and Lower Thrust Rings	All VHP Engines	6/2007
5-2960B	Crankshaft Main Bearing Tensioning	All ATGL Engines	5/2007
5-2969	Vibration Dampers	12V-AT27GL And 16V-AT27GL	9/2006
5-2986	Crankshaft Polishing	All Waukesha Engines	4/2008
5-2998	Connecting Rod Bearing Dimension	APG16V150LTD, APG1000	12/2008
5-3002	Connecting Rod Bearing Installation	All VGF Engines	10/2008
5-3003A	Connecting Rod Wear Limits	All VGF Engines	2/2009
5-3019	Hydrolastic Damper and Crankshaft Release	12V-AT27GL	8/2009
5-3028	Vibration Damper Adapter Installation	All VGF Engines	12/2009
5-3087	New Crankshaft Plugs	All VGF Engines & APG1000/16V150LTD	9/2013
5-4007	Use of Improperly Reconditioned Connecting Rods	VGF/APG/ATGL/275GL	9/2014
5-4008	New Timing Tapes	All VHP Engines	8/2015
5-4028	Connecting Rod Cap Bolts	All Waukesha Engines	5/2015

Number	Description	Engine Models	Date
6 Cylinder Block and Crankcase			
6-2395B	Extractor Breather System	F3524GSI, L7042GSI, P9390GSI, and VGF GL models	12/2016
6-2589	L36 Main Bearing Cap Installation And Torque Specifications	All VGF L36 Engines	12/1992
6-2759	Crankcase, Cylinder Sleeve and O-Ring Seal Part Number Supersession	All VSG	8/1997
6-2800D	New ATGL Oil Control Parts	All AT27 GL Engines	5/2002
6-2807	New Bearing Cap Interference	12 Cylinder VHP	3/1999
6-2811	VHP Cylinder Head Stud Bore Resizing	Previous VHP	3/1999
6-2831A	Piston Cooling Jet Supersession	All VGF Engines	3/2001
6-2833A	Crankcase Main Bearing Bore Dimension Correction	VGF L36/P48	12/1999
6-2837D	ATGL Main And Connecting Rod Bearing Identification And Installation	All AT27GL Engines	5/2007
6-2839B	VGF Pistons, Cylinder Liners, and Rings	All VGF Engines	3/2007
6-2855	New Main Bearing Caps And Nuts	VHP 6 And 12 Cylinder Engines	8/2000
6-2856A	Chromium Ceramic Top Ring For Series Four, Engines	All VHP Series Four, Engines	9/2000
6-2873A	New Closed Breather System	VGF F18GL And H24GL Engines	8/2002
6-2899	ATGL Crankcase Lower Bore Repair\Restoration	All ATGL Engines	10/2002
6-2903	ATGL Piston Ring Groove Clearance	All ATGL Engines	9/2002
6-2906	New Cylinder Liners	All VHP Engines	11/2002
6-2910K	Current VHP Power Cylinder Configurations	All VHP Engines	10/2018
6-2926B	Cylinder Head Capscrews	All VGF Engines	5/2006
6-2946	VHP Crankcase	VHP	4/2005
6-2967	New Water Manifold Jumper	16V-AT27GL	11/2006
6-2985A	Gear Backlash Measurement	All VHP V-12 and V-16 Engines	2/2016
6-2997A	Inline Main Bearing Bore Dimension and Bearing Cap Bolt Torque	VGF F18/H24	10/2008
6-2994	Identifying Piston Crown Damage	All Waukesha Engines	7/2008
6-3007	Camshaft Bore Dimensions	VGF F18/H24	2/2009
6-3011A	New Cylinder Liner and Water Guide O-Rings	All ATGL Engines	8/2019
6-3013	New Water Jumper O-Ring	16V-AT27GL	2/2009
6-3014	Oil Separator Diaphragm Kits	VHP, VGF, APG150	6/2009
6-3018	Piston Cooling Jet Screw Torque	VGF L36 & P48	6/2009
6-3021B	Updated Cam Follower	VHP	2/2020
6-3041	Gear Housing Rework	VHP 12 Cylinder Extender	9/2010
6-3054	Cylinder Sleeve O-Ring Lubrication	All APG, ATGL, VGF & VHP Engines	11/2010
6-3096A	Closed-Crankcase Breather Kits	Standard and Series Four* 12-Cylinder Non-Draw-thru Fuel System and Non-Naturally Aspirated	8/2015
6-4014	Oil Prevention Leak Program	All VHP Extender Engines	3/2015
6-4015	VHP Oil Pan Pipe Plug	All VHP Engines	3/2015
6-4016	VHP Oil Inlet Cover Gasket	All VHP Extender Engines	3/2015
6-4017A	Crankcase Cross-Tie Capscrew Seals	All VHP Extender Engines	11/2015
6-4018A	Front Gear Housing Resealing Procedure	All VHP Extender Engines	5/2015
6-4019	Oil Pan Door Assemblies	All VHP and VGF Engines	3/2015
6-4020	Explosion Relief Doors	All VHP Engines	4/2015
6-4021	VHP Crankcase Resealing Procedure	All VHP Engines	3/2015
6-4029	VHP Piston Ring End Clearance	L7042GL and P9390GL	4/2015

Number	Description	Engine Models	Date
6-4030	Centrifugal Oil Filter	All engines equipped with centrifugal oil filter	4/2015
6-4037A	New Oil Cooler Piping	VHP 12 Cylinder Engines	5/2015
6-4039A	New Piston Rings	All VGF Engines	10/2015
6-4077	New Closed-Crankcase Breather Kits	APG1000	8/2016
6-4096	Crankcase Breather Kit	F3524GSI/GSID Engines	7/2018
6-4097	Piston Cooling Galley Plugs	12V275GL+, 16V275GL+ and ATGL Engines	7/2018
6-4105	New Rear Main Crankshaft Seal	P9394 and P9390	7/2018
6-4119	Breather Regulator Valve	VHP 12- and 16-Cylinder Non-Draw-Thru and Non-Naturally Aspirated Engines	8/2019

Number	Description	Engine Models	Date
7 Cylinder Heads			
7-1933A	Selecting Correct Cylinder Head Gaskets and Studs to Match Various Cylinder Heads, Cylinder Sleeves, and Crankcases	VHP	8/1975
7-2044C	Rocker Arm Parts Interchangeability	VHP	6/1991
7-2551C	Cylinder Head Changes	All VGF	10/1997
7-2634	O-ring Sealing Of Pushrod Tubes	All VHP	7/1994
7-2705	New Valves And Valve Seat Inserts	All VSG	11/1995
7-2738	Rocker Arm Support to Cylinder Head Compatibility	VHP, (Except 5115)	11/1996
7-2740A	Current Valve Stem Seals, Rocker Arms And Valve Guide Configurations	VHP, (Except Series Four,)	4/1999
7-2754A	Valve Guide Oiling Improvements - "Quick Fix Procedures"	VHP 3521GL, 5115GL, 7042GL And 9390GL Engines	4/1999
7-2770	Use Of Modified Diesel Cylinders Heads On VHP Gas Engines	All VHP Gas Engines	7/1998
7-2794C	New Cylinder Head Replacement Parts	All AT25/27GL Engines	2/2001
7-2841B	New Valve Guide Oiling Hardware	VGF F18/H24 LCR/HCR and L36/P48 HCR Engines	5/2002
7-2858	High Temperature Exhaust Valve	VHP G And GSI Engines Except Series Four,	4/2001
7-2866A	New Fixed Lifter Screw And Hydraulic Lifter	VHP Engines With Hydraulic Lifters Except Series Four,	7/2002
7-2874	Rocker Shaft Support Modifications	All VHP Series Four, Engines	4/2001
7-2878A	Valve Bridge Guide Product Improvement And Retrofit Instructions	All VHP Series Four, Engines	7/2002
7-2885A	Pushrod Identification	All VHP Gas Engines	4/2005
7-2912A	Valve Spring Tapers (Keepers)	VHP Series Four, Engines	11/2007
7-2915C	One Piece Rocker Arm Bushing Released	VHP Series Four, Engines	5/2008
7-2922A	New VHP Cylinder Head Gaskets	VHP Engines	2/2004
7-2923	New Bridge And Rocker Arm Sealing Plug Expanders	All VHP Engines	9/2003
7-2925	Improved Water Jumper Elbow	VHP Series Four, Engines	9/2003
7-2934B	ATGL Valve Seat Insert Installation Procedure	All ATGL Engines	6/2007
7-2938B	Change To Finished Inside Diameters Of Valve Guides	All VHP Engines	2/2009
7-2949C	New Exhaust Valves, Valve Guides, and Cylinder Heads	All Non Series Four, VHP, Engines	8/2007
7-2953B	Current VGF Cylinder Head Assemblies	All VGF Engines	9/2008
7-2965E	Cylinder Head Components & Overhaul Procedures	VHP Series Four, Engines	11/2019
7-2973	New Valve Bridge Assembly	VHP Series Four	2/2007
7-2984B	Cylinder Head Overhaul Procedures	All Non Series Four VHP Engines	10/2008
7-3006	Series Four® Valve Kits Without Exhaust Valve Seats	VHP Series Four	2/2009
7-3012	New Igniter Sleeve O-Ring	All ATGL Engines	2/2009
7-3034	Cylinder Head Updates	APG1000/16V150LTD	12/2010
7-3069A	APG Cylindr Head and Rocker Arm Housing Gasket Update	APG1000/16V150LTD	7/2015
7-3085B	Updated Spark Plug Carrier and Extension	All VHP Engines	6/2018
7-3095	Intake Valve Rotator Inspection	VHP Series Four	6/2014
7-3097A	VHP Valve Adjustment	All VHP Engines	11/2015
7-3099A	Spark Plug Carrier Extension Sealing	VHP Series Four Engines	5/2015
7-4003	Spark Plug Carrier Extension Clearance	VHP Series Four	6/2014

Number	Description	Engine Models	Date
7-4024A	Exhaust Valves, Exhaust Valve Set Inserts and Cylinder Head Assembly Updates	APG1000/16V150LTD	2/2016
7-3092	Igniter Sleeve Lower O-Rings	AT27GL/275GL and GL+	4/2015
7-4027B	Updated VHP GL Cylinder Heads	Non Series Four VHP GL Engines	3/2016
7-4038	Oil Header to Cylinder Head Tubes and Connectors	VHP Series Four 12-Cylinder Engines	7/2015
7-4049A	Updated Valve Rotator	All VHP Engines	4/2016
7-4050	Cylinder Head Gasket	All VGF Engines	9/2015
7-4067A	Corrected Valve Spring Lengths	All VHP Engines	12/2016
7-4090	Valve Lifters	All VHP Engines	4/2017
7-4093	Valve Seat Inserts	AT27GL/275GL and GL+	4/2017
7-4120	Improved Exhaust Rocker Arm Components	Series Four & Series Five Engines	3/2020

Number	Description	Engine Models	Date
8 Exhaust System			
8-2581	Exhaust Manifolds And Heat Balance Data	VGF F18GL and H24GL	4/1992
8-2720	New Turbo Exhaust Outlet Tees And Elbows For AFM Installation And Rework Instructions	VHP 2895, 3521, 7042, 9390 GSI And GL	8/1996
8-2956	Exhaust Manifold Gaskets	All VGF Engines	11/2005
8-2968	Improved Exhaust Gaskets	All 6 and 12 Cylinder VHP Engines	9/2006
8-3031	VHP Vent Line Kits	VHP 16-Cylinder P9390	7/2010
8-3059	Exhaust Bellows Update	ATGL/275GL	4/2011
8-3062	Wastegate Housing Assembly Update	ATGL	11/2011
8-3063	Updated Exhaust Manifold Gasket	All VHP Engines	2/2013
8-4041A	Exhaust Piping Components	VHP 12-Cylinder Engines	8/2017
8-4047	Customer Exhaust Installation	All Waukesha Engines	10/2015
8-4061	NOx Sensor Modification	16V275GL+	1/2016
8-4078A	Insulation Interference	All 275GL+ Engines	8/2016
8-4111	VHP Cylinder Head Exhaust Manifold Gasket Installation	All VHP engines	8/2018
8-4113	Exhaust Deflagration	All 275GL+ Engines	1/2019

Number	Description	Engine Models	Date
9 Fuel System			
9-2150A	Gas Pressure Regulator Recommendations (Special Warning)	All Natural Gas	7/1981
9-2574D	Improved Admission Valve for VHP GL Engines	VHP GL	11/1999
9-2661A	New Six Hole Prechamber Combustion Cup	8L-AT27GL and 12V-AT27GL	11/1995
9-2689	Carburetor And Regulator Changes	VSG F11G/GSI Engines	7/1995
9-2701A	Gas Sampling Procedures	All Waukesha Engines	11/2007
9-2702D	Gaseous Fuel Specification, S-7884-7	All Waukesha Engines	10/2014
9-2708C	Deltec Carburetor Adjustment (Draw Through)	VGF L36/P48GLD/GSID	5/1998
9-2732	VSG F11GSID Hard Starting	VSG F11GSID	7/1996
9-2783	F18/H24GL Low Compression Ratio Fuel System Conversion	VGF F18/H24GL Engines	9/1998
9-2784	New Fuel Pressure Regulator	All VGF GL Engines	8/1998
9-2787	Revised Carburetor Setting	All AT27GL Engines	7/1998
9-2797	AT Prechamber Gas Differential Pressure	8L And 12V AT27GL Engines	11/1998
9-2820	VSG Fuel System Adjustment Procedures	All VSG	4/2000
9-2853	StartUp and ShutDown Of Engines Equipped With Deltec, Carburetion	16V-AT27GL, VGF F18/H24GLD And VGF L36/48GLD/GSID	7/2000
9-2884	New Impco 400 VF Carburetor Fuel Cone	F18GL and H24GL –LCR Engines	9/2001
9-2889A	High Altitude Carburetor Gas Valve	VHP GSI And VHP Series Four GSI	3/2002
9-2896	Hard Starting on Engines Running on Digester Gas	VSG-F11GSID	4/2002
9-2898	Gas Valves For Constant Torque Engines	8L-AT27GL	4/2002
9-2916A	Mooney Fuel Regulators	VHP GSI/GL/LT	5/2006
9-2947	Gas Admission Valve Retention Hardware	All ATGL Engines	4/2005
9-2966	Modified Carburetor And Fuel System Adjustment	16V-AT27GL	9/2006
9-2974	Carburetor Adjustment	F18GL, F18GL LCR, H24GL and H24GL LCR	3/2007
9-3016A	Gas Regulator Actuator Updates	VHP with Mooney AFR	7/2010
9-3022	Start Assist Instruction	APG1000/16V150LTD	8/2009
9-3052	Biogas Updates	APG1000/16V150LTD	12/2010
9-3055	VHP AFR Regulator Spring Update	All VHP with ESM and AFR	7/2011
9-3064	Regulator Adjuster	All VHP with Fisher 99 Regulator	4/2011
9-3068	Fuel Valve Mounting	ATGL/275GL	1/2012
9-3089	Potential Gas Leak – Fuel Inlet Piping	All VHP GL, GSI and LT 12-Cylinder Extender* Models Built 2006 to Present	6/2013
9-3090	Potential Gas Leak - Gas Inlet Shutoff Valve	ATGL/275GL	6/2014
9-3075	New Fuel Pressure Regulator	VGF F18/H24 G, GLD, GSID Engines	10/2014
9-4022	IMPCO 600VF Carburetor Gasket Potential Gas Leak	All VGF/VHP models using a 600VF Carburetor	12/2014
9-4051	Updates to Gas Regulator Steppers	All VGF, VHP and ATGL/275GL Engines	11/2015
9-4055	Fuel Pressure Regulator Kit	APG1000/16V150LTD	1/2016
9-4059A	Obsolete Mooney Regulators	All VHP engines	1/2016
9-4062	AFR2 Additional Information	VHP 12-Cylinder AFR2 and emPact Engines	7/2016
9-4075	Rod End Maintenance Manual Correction	275GL+	8/2016

Number	Description	Engine Models	Date
9-4076	AFR2 Setup	VHP engines with AFR2/emPact	10/2016
9-4085	Low BTU Fuel	275GL+	6/2017
9-4087A	APG1000 Biogas Improved Fuel Valve	APG1000	2/2018
9-4092A	New Single Fuel Inlet Kit Assemblies	VHP 12-Cylinder GL, GSI and GSI Extender* Engines	7/2018
9-4107	Prechamber Fuel Regulator Bracket and Inlet Fuel Pipe Upgrade kits	12V/16V 275GL/GL+ Engines	8/2018

Number	Description	Engine Models	Date
10 Governors			
10-1901A	Woodward Governor and Governor Drive Recommendations	VHP & VC	4/1976
10-2819	Improving Governor Cold Start Response	VGF L36/P48 Equipped With PSG And EG3P Governors	5/2000

Number	Description	Engine Models	Date
11 Ignition System			
11-1520A	Timing Tapes and Charts for Ignition Timing	All Waukesha Engines	10/1972
11-1895G	Spark Plug Recommendations	All Waukesha Engines	11/1999
11-2295A	Modified Drive for Flange Mounted Magnetos	All VHP Series Gas Engines	7/1993
11-2558E	VHP Ignition Timing	All VHP Gas Engines	6/2002
11-2564	Custom Engine Control Ignition Module	12V-AT25GL	7/1991
11-2576	VSG Ignition Timing	F11GSI, F11GSID	2/1992
11-2653	Installing the CEC 24 Volt Generator	VG F18, H24	1/1995
11-2662	Custom Engine Control Ignition Module Hall-effect Pickup	AT, VHP, VGF Engines	2/1995
11-2680	New CEC Timing Disc And Governor Drive Gear	VHP 6, 12 and 16 Cylinder Gas Engines	7/1995
11-2684	Pressure Washing/Steam Cleaning Precaution For Electronic Devices Including CEC Product Modules	All Waukesha Engines	6/1995
11-2731A	VGF Ignition Timing	All VGF	11/2009
11-2741A	Maintaining CSA Certification On Flange-Mounted Ignition Systems	ATGL, VHP, & VGF Engines Equipped With CSA Ignition Systems	1/2000
11-2746	Ignition System Components And Maintenance - CSA And Standard	All ATGL Engines	3/1997
11-2750A	VHP Spark Plug Maintenance	All VHP Gas Engines	5/1999
11-2764	New CSA Ignition Groups	VSG F11G/GSI/GSID	11/1997
11-2782B	Refitting New Flange Mounted Shielded Ignition Coils	VGF Engines With Shielded Ignition Systems	11/1999
11-2854	Custom Engine Control Ignition Module Mounting Bracket	VGF 6 And 8 Cylinder Engines	8/2000
11-2862	Magneto Adaptor Changes	VHP 6 And 8 Cylinder Engines	11/2000
11-2867	Ignition Harness Support	VHP Series Four Engines	2/2001
11-2881A	VHP Ignition Timing	VHP L7044GSI Gas Engines	10/2001
11-2882A	VHP Ignition Harness Replacement	VHP 12 Cylinder Series Four And Standard VHP 12 Cylinder With CSA Ignition	2/2002
11-2890	VHP Ignition Harness Replacement	VHP 6 Cylinder Series Four And Standard VHP 6 Cylinder With CSA Ignition	2/2002
11-2897	Upgrade On Long Life Spark Plug	All AT27GL Engines	5/2002
11-2933	Hall-effect Pickup Installation	VGF L36/P48 Engines	3/2004
11-2937	Release Of Square-Cut Seal Ring To Be Used on Spark Plug Carrier Extension	VHP Series Four Engines	6/2004
11-3029	Wiring Retrofit for VHP Extender Engines	12 Cylinder VHP Extender Engines	10/2009
11-3044	Emergency Stop Button Replacement	All Waukesha Engines	9/2014
11-4035	Improved Ignition Power Module-Diagnostic (IPM-D)	All ESM Equipped Engines	5/2015
11-4068	Camshaft and Crankshaft Magnetic Pickups	All Waukesha Engines	4/2016
11-4070	New Ignition Coil Heat Shield Kit	P9394	8/2016
11-4095	Power Distribution Junction Box (PDB) Cover Modification Instructions	All ESM Equipped Engines	7/2017

Number	Description	Engine Models	Date
12 Lubrication System			
12-1880AR	Lube Oil Recommendations for GE's Waukesha gas engines	ALL APG, ATGL, VGF, VHP, 275GL Engines	12/2019
12-2570A	Thermostats for Lube Oil System	VHP	\
12-2580	Oil Pump Manifold	VHP 6 & 12	5/1992
12-2598	VHP Lube Oil Filter	All VHP	3/1993
12-2623B	Oil Pump Backlash Tool And Specifications	All ATGL Engines	2/2001
12-2677	Taking Oil Samples For Laboratory Analysis	All Waukesha Engines	6/1995
12-2687	New Engine Oil Pumps	VGF F18, H24	8/1995
12-2698D	Microspin	VHP, VGF, AT, F817, F1197	3/1999
12-2703	Proper Installation Of VHP Prelube Pumps	All VHP	6/1996
12-2752	Oil Level Regulator Vent Tube Assembly	All VSG F11 Engines	3/1997
12-2773	Turbocharger Oil Supply Line Clamps	VHP 12 Cylinder Turbocharged Engines	5/1998
12-2810A	New Temperature Thermostats And Oil Feedback System	All ATGL Engines	7/2000
12-2829	Improved Oil Filters	VGF L36/P48	8/1999
12-2835	Service Parts For New Type VHP Oil Coolers	VHP	11/1999
12-2869	Oil Pump Seal	All VGF Engines	5/2001
12-2872	Redesigned Oil Screen Baffle	VHP 6 And 12 Cylinder	5/2001
12-2902A	New Oil Pan And O-Ring Released	All 6 And 12 Cylinder VHP Engines	10/2003
12-2924A	Torque Procedure For VHP Oil Pans	All 6 And 12 Cylinder VHP Engines	10/2003
12-2935A	Valve Lifter Door Gasket	VHP 6 Cylinder Engines	3/2008
12-2939	VHP Oil Pump	All VHP 6 Cylinder Engines	4/2005
12-2943A	Pressure Regulator Spring	All VGF Engines	11/2005
12-2954	Oil Catcher	All ATGL	5/2006
12-2976	Engine Mounting Methods	All 12 Cylinder VHP Engines with Extender Series Deep Sump Oil Pans	5/2007
12-2983	Oil Pump	All VSG F11 Engines	11/2007
12-2991	VGF Inline Oil Pumps	All 6 & 8 Cylinder VGF Engines	8/2008
12-2992A	VHP Oil Cooler Tubing	12 Cylinder Extender Series® Engines	12/2009
12-3035	Kenco Oil Leveler and Crankcase Pressure Tap Point	APG1000/16V150LTD	3/2010
12-3040	VHP Extender Oil Pickup	VHP Extender	2/2010
12-3051	Hollow Screw (Banjo Bolt) Torque Values	ATGL/275GL and GL+	11/2010
12-4005	Inspection of Spin-on Oil Filters	275GL, VHP, APG & VGF Engines	6/2014
12-4069	New Centrifugal Oil Filter	All VHP 12 Cylinder Engines	8/2016
12-4086	Kenco Oil Level Regulator Control Improvements	All 6 And 12 Cylinder VHP Engines	12/2016

Number	Description	Engine Models	Date
13 Turbochargers			
13-2248C	Adjustment and Repair of Wastegates	Turbocharged VHP Gas & Diesel with AiResearch and Brown Boveri Turbochargers	2/1991
13-2612	Wastegate Adjustment	8L-AT25/27GL and 12V-AT25GL	4/1994
13-2613A	Control Pressure Settings For Adjustable Wastegates	VHP GL (Draw-thru)	6/1994
13-2654B	Hardware Required For TCM Retrofit On Non-TCM Equipped Engines	12V-AT25GL	11/1999
13-2673A	Turbocharger Field Retrofit	F11GSI/GSID New Concept	10/1996
13-2678	Turbocharger Field Retrofit	F11GSI/GSID Old Concept - Built Before July 1992	7/1995
13-2776C	TCM I and TCM II Retrofit	All 12V-AT25/27GL Engines	12/1999
13-2798A	TCM I and TCM II Retrofit	All 8L-AT 27GL Engines	12/1999
13-2802A	New Exhaust/Inlet/Discharge Connections	All AT25/27GL Engines	3/2001
13-2849B	New Turbocharger Inlet Elbows/Exhaust Connections And High Temp. Gaskets	12V-AT27GL, 12V-AT25GL With 181 Turbochargers and 12VAT25GL With 151 Turbochargers	8/2001
13-2851	Wastegate Valve Redesign	12V-AT27GL	5/2000
13-2852B	Series Four Wastegate Adjustments For Altitude	F3524GSI, L5774LT, L5794GSI/LT, L7044GSI	1/2003
13-2859A	LCR Wastegate Adjustments For Elevation	VG F18GL (LCR) and H24GL (LCR)	9/2006
13-2875A	New Turbocharger With Clipped Blade Turbine Wheel	F2895, F3521, L5790, And L7042 GL Engines	6/2002
13-2880A	New VGF Turbocharger	VG F H24 and P48 Engines	12/2001
13-2883C	Turbocharger Elbow Gasket Failures	All VHP 12 Cylinder Turbocharged Engines	1/2003
13-2905A	New Heat Shields For Series Four 6 And 12 Cylinder Engines	Series Four, 6 And 12 Cylinder Engines	12/2002
13-2919	New Right Bank Turbocharger Outlet Tube	All VHP Series Four, 12 Cylinder Engines	3/2003
13-2929	New Compressor Discharge Elbow And Intercooler Inlet Gaskets	16V-AT27GL Engines	1/2004
13-2936	Wastegate Maintenance Recommendation	All ATGL Engines	5/2004
13-2940	VG F Wastegate Mounting Plate	VG F18/H24 Engines	5/2005
13-2955	Turbocharger Connections	All Standard 12 Cylinder VHP Engines (Non Series Four,)	5/2006
13-2990	Turbocharger Cleaning	APG1000/16V150LTD	4/2008
13-3009B	Inline Turbocharger Oil Supply / Return Tube Clamps	All Turbocharged F18 and H24 Engines	3/2016
13-3015	Wastegate Pressure Tube Restrictor Blockage	APG1000/16V150LTD	6/2009
13-3076	Updated Wastegate	APG1000/16V150LTD	6/2013
13-3084	APG1000 Compressor Bypass Elimination	APG1000/16V150LTD	12/2017
13-4012A	New Pressure Differential Wastegates	VHP L5794GSI, L7044GSI, and L7042GSI S4	11/2015
13-4023B	Turbocharger Oil Drain Lines	VHP L7042GSI	6/2019
13-4036	Turbocharger Control Description Correction	275GL+	10/2015
13-4042A	Exhaust Outlet Elbow	12V275GL+	8/2017
13-4044B	Pipe Nipple Wastegate Balance Line	VHP L5794GSI, L7044GSI, L5774LT, and L5794LT	8/2017
13-4064	Updated Wastegate/Turbocharger Removal	P9394GSI	8/2016

Number	Description	Engine Models	Date
13-4082	Wastegate Adjustment Procedure and Normal Control Pressure Specifications	VHP 12-Cylinder L5794GSI, L7044GSI, L7042GSI S4; VHP 16-Cylinder P9349GSI	8/2017
13-4088	Wastegate Balance Lines	L5794/L7044GSI and L5794/L7044GSID	11/2019

Number	Description	Engine Models	Date
14 Application and Installation			
14-2582	Lubricating Electric Motors	All Waukesha Engines	2/1993
14-2707A	Intake Manifold Charge Density VS Brake Horsepower	VSG F11GSI	11/1995
14-2749D	Formulas For Predicting BHP and Intake Manifold Pressure	All VGF GL, GLD, GSID	1/2001
14-2766A	Differences Between Previous And Current Production 8.7:1, Low Compression Ratio Engines	VGF F18GL LCR Engines	11/1998
14-2815	Cylinder Compression Check Procedure	All Waukesha Engines	8/1999
14-2993	Generator Alignment Procedure	APG2000, APG3000	8/2008
14-3070	Proper Vent Line Flex Coupling Installation	All Waukesha Engines	1/2012
14-3071	Engine Vibration Levels	All Waukesha Engines	10/2011
14-4053	Customer Exhaust System Support	VHP L5774, L5794, L7042, and L7044	10/2015
14-4094	O-ring and Flare Hydraulic Fittings	All Waukesha Engines	4/2017

Number	Description	Engine Models	Date
15 Tool Recommendations			
15-2007B	Exhaust Manifold Support Bracket	All VHP	8/1980
15-2658E	Offset Torque Wrench Adapter P/N 472001	VGF F18 and H24	10/2008
15-2758A	4-Valve Spring Compressor	All VHP	4/2000
15-2762A	4-Valve Spring Compressor For CSA Extended Length Spark Plug Carriers	Current VHP With CSA Extended Length Spark Plug Carriers	4/2000
15-2822	ATGL Connection Rod Bearing Tool Change	All ATGL Engines	8/1999
15-2845	ATGL Camshaft Gear Pump Kit And Adjusting Tool	All ATGL Engines	3/2000
15-2861	New Borescope Kit	All Waukesha Engines Except ATGL	6/2000
15-2871	Ignition Analyzer	All Waukesha Engines	3/2001
15-2959	Piston Ring Expander Pliers	All VHP Engines	2/2006
15-3010	Cylinder Head Lifter P/N 472091	APG1000/16V150LTD	2/2009
15-3026	APG1000 Tools	APG1000/16V150LTD	12/2010
15-3050	New Valve Guide Installation Tool	All VHP Engines	10/2010
15-3056	Cylinder Liner Protusion Gauge	APG1000, VGF, VHP	7/2011
15-3057	Spark Plug Sleeve Seat Resurfacing Tool	APG1000/16V150LTD, VGF, VHP, APG2000/3000, ATGL/275GL+	7/2011
15-3058	Rod Journal Protector	APG2000/3000	4/2011
15-3060	Updated Valve Spring Compressor	APG1000/16V150LTD	4/2011
15-3072	ATGL/275GL/GL+ Admission Valve Puller	All ATGL/275GL/GL+ Engines	2/2013
15-4010	Cylinder Liner Removal and Installation Tools	All VGF and APG Engines	7/2015
15-4011	APG1000 Biogas Engine Diagnostic Tool	APG1000/16V150LTD	3/2015
15-4066	New Rigging and Lifting System	275GL+	5/2016

Number	Description	Engine Models	Date
16 Miscellaneous			
16-1561E	Dresser Couplings and Gaskets	All Waukesha Engines	9/1988
16-1740E	Location of Engine Serial Numbers on Crankcase or Block Castings	APG, 275GL/ATGL, VHP, VGF	4/2015
16-1851A	Exercise Recommendations for Standby Engines	All Waukesha Engines	2/1973
16-1855J	Waukesha Preservative Oil	All Waukesha Engines	8/2016
16-1858	Preparation of Generators for Long-Term Storage	As Applicable	9/1970
16-2523C	VHP Maintenance Recommendations	Standard VHP Engines (Excluding Series Four)	9/2003
16-2539	Waukesha Maintenance Recommendations	All Engine Generator Units	7/1989
16-2596	VHP Gas Engine Protection Logic	VHP Gas 6 And 12 Cylinder	8/1995
16-2644A	Landfill Gas Engine Components	All Waukesha Engines	7/1997
16-2696B	Waukesha Maintenance Recommendations	All VGF Engines	6/2003
16-2779	Explosion Relief Valve Seal Replacement	All AT27GL Engines	12/2000
16-2796A	New Belt Tightener And Pulley Guard Update	All VSG F11 Engines	3/1999
16-2864B	Procedures For Light Load Operation	All Waukesha Engines	8/2016
16-2868B	New Lifting Devices	VHP 12 And 16 Cylinder Engines	8/2018
16-2892	Intermediate Gear Bushing Installation	VGF F18 and H24 Engines	2/2002
16-2913	ATGL Break-In Procedure After Rebuild	All ATGL Engines	1/2003
16-2981	Engine Break-In	All VGF Engines	11/2007
16-3030A	Start and Run Checklists	APG1000/16V150LTD	5/2015
16-4009	VHP Series Four Extender Maintenance Intervals	VHP L5794GSI, L7042GSI S4, L7044GSI	10/2015
16-4052	New Corrosion-Resistant Front Pulleys	VHP 6 And 12 Cylinder Engines	12/2015
16-4056A	New Safety Labels	All Waukesha Engines	10/2018
16-4060	Sale of Chemicals	All Waukesha Engines	8/2016
16-4063	Timing of First Oil Sample/Analysis	VHP 9394GSI/Late model Series 4 12 Cyl	2/2016

Number	Description	Engine Models	Date
17 Electronic Controls			
17-2716	AFM Lean Burn Retrofit Kits	12V-AT25/27GL, 8L-AT27GL	9/1996
17-2823A	Release of TCM II Interface Software Version 1.10c	All ATGL with TCM II	3/2000
17-2847A	Power Distribution Box And Engine Wiring Information	Standard VHP GSI and VHP Series Four Engines	10/2002
17-2863A	Knock Sensor Torque Values	All APG, ATGL, VHP and VGF Engines	3/2010
17-2877	Specification of the CEC AFM and DSM Serial Streams	All Equipped with AFM and DSM	5/2001
17-2888	Release Of Higher Temperature Rated DSM Filters	All DSM Equipped Engines	1/2002
17-2893	DSM Alarm And Shutdown Connections	All DSM Equipped	3/2002
17-2904A	Adapter Harness To Be Used With Retrofit Of Early Model Actuator Assemblies To Current Actuator Assemblies	All AFM-Equipped Engines	6/2003
17-2941	Updated Software - DSM Version 635 and AFM Version 4.5	All DSM or AFM Equipped Engines	4/2005
17-2958C	Remote Programming of ECU	All ESM Equipped Engines	1/2012
17-2964	Battery Maintenance	All Waukesha Engines	9/2006
17-2970A	ESM Power Connection and Grounding	All VHP Engines with ESM	6/2007
17-2971A	ESM Display Panel	VHP Engines Equipped with ESM	7/2007
17-2972	High Oil Pressure Faults During ESM ECU Cold Starts	VHP Engines	2/2007
17-2975A	Stoichiometric Engine Oxygen Sensor Replacement	All ESM & CEC Engines with Oxygen Sensors	12/2008
17-2980A	ALM555 Troubleshooting	All ESM Equipped Engines	10/2009
17-2987	Wiring Diagram Supplement	APG 12V / 18V 220GL	3/2008
17-2988	Magnetic Pickup	APG 12V 220GL, 18V220GL, APG2000, APG3000	4/2008
17-2996	ESM Power Distribution Junction Box	All ESM Equipped Engines	9/2008
17-3008	ESM Oil Pressure and Shutdown Setpoints	All ESM Equipped Engines	12/2008
17-3020	APG1000 Paralleling Instructions	APG1000, 16v150LTD	8/2008
17-3037	New ESM Calibration for High Jacket Water Operation	All VHP Engines with ESM	3/2010
17-3048	Power Distribution Box Water Integrity	All Waukesha Engines with ESM	10/2010
17-3093B	Updated Electronic Service Program	All Waukesha Engines with ESM	8/2016
17-3048A	PDB Reset and Water Integrity Guidelines	All Waukesha Engines with ESM	12/2014
17-4001B	Updated Power Distribution Junction Box	All Waukesha Engines with ESM	8/2017
17-4013	New ESM Wireway Assemblies	All VHP 12-Cylinder Extender* Engines	10/2016
17-4079	AFR2 HMI Update	VHP 12-cylinder engines equipped with AFR2/emPact	8/2017
17-4091A	New ECU Calibrations for High BTU Fuels	VHP L7044GSI AFR, L7044GSI AFR2, P9394GSI AFR2	8/2017
17-4100A	275GL+ Engine Wireways	12V275GL+ and 16V275GL+ Engines	6/2018
17-4101	Engine Control Unit (ECU)	VHP 6- and 12-Cylinder ESM2 Engines	6/2018
17-4103B	Start Improvement Software	12V275GL+ and 16V275GL+ Engines	1/2019
17-4106A	ESM Alarm 555 INT FLT 38 Updates	VGF & VHP	2/2020
17-4110	ESM Camshaft and Crankshaft Magnetic Pickup Adjustment	All Engines with ESM/ESM2	8/2018

Number	Description	Engine Models	Date
17-4112A	ESM2 Engine Hour Feature	All Engines with ESM2	5/2019
17-4114	ESM/ESM2 IPMD2 Ignition Upgrade	All 275GL+ Engines with ESM/ESM2	1/2019
17-4115	ESM2 HMI Software Update and Boot-up Process	All Engines with ESM2	4/2019
17-4116	Vibration Isolation Mount Kit	12V275GL+ and 16V275GL+ Engines	5/2019
17-4117	Improved O2 Sensor Available	VHP & VGF	10/2019
17-4118	Troubleshooting Steps for Actuators	275GL+ and VHP	11/2019