



Thank you for purchasing your OM617 to R150F adapter from Doomsday Diesel LLC! Please read this entire page **BEFORE** installation. Installation has been designed to be very simple. Please be aware of potentially sharp edges! The adapter plate must first be mated to the engine block. The back of the block should be bare. Make sure both 12mm dowel pins are in the engine block.

Adapter Plate to Engine:

- (7) M10-1.5x25 10.9 FHCS (flat head)

Use medium strength thread locker and torque to 40 lb*ft.

Now, insert the pilot bearing adapter into the crankshaft until it is fully seated. If it does not want to go in, freeze the adapter for 8 hours and heat the crankshaft with a MAP gas torch. Also ensure that you do not have the odd 1.366" crankshaft ID, found only on certain engines (both .951 and .952).

Flywheel to crankshaft:

- M10x1.0x24 10.9 HCS (10" flywheel)
OR
- M10x1.0x32 10.9 HCS (9-1/4" flywheel)

You **DO NOT** reuse the Mercedes spacer ring. If using TTY Mercedes crankshaft bolts, torque according to the Factory Service Manual. If you purchased flywheel bolts from me, apply medium strength thread locker and torque them in the same pattern as the service manual to 60 lb*ft.

The supplied galvanneal dust cover goes between the transmission bellhousing and the starter. It should correctly space the starter from the flywheel, just the same as the factory dust cover.

Bellhousing to Adapter Plate:

Start by installing the dowel pins into the adapter plate. This will help ensure the bellhousing goes on straight. It is a good idea to mount the plate to the bellhousing before final installation, so you can ensure the bolts aren't going to protrude thru the adapter plate. Bellhousings can vary, and the hardware and plate are designed to use every possible thread. If the hardware protrudes thru, simply grind the end off with an angle grinder until flush.

Holes may have to be drilled out on bellhousing for hardware to fit thru.

- (2) M10-1.25x30 8.8 HCS & Washer Positions 1
Use medium strength thread locker and torque to 32lb*ft. Make sure washers are installed.
- (2) M12-1.25x60 8.8 HCS & Washer Positions 2
Torque to 60lb*ft. Make sure washers are installed.
- (4) M12-1.75x80 8.8 HCS, Washers, and Lock Nut Positions 3
Torque to 49lb*ft.

All torque values were attained from Fastenal. This product is for off road use only. This kit carries no warranty.

