

KENT-MOORE

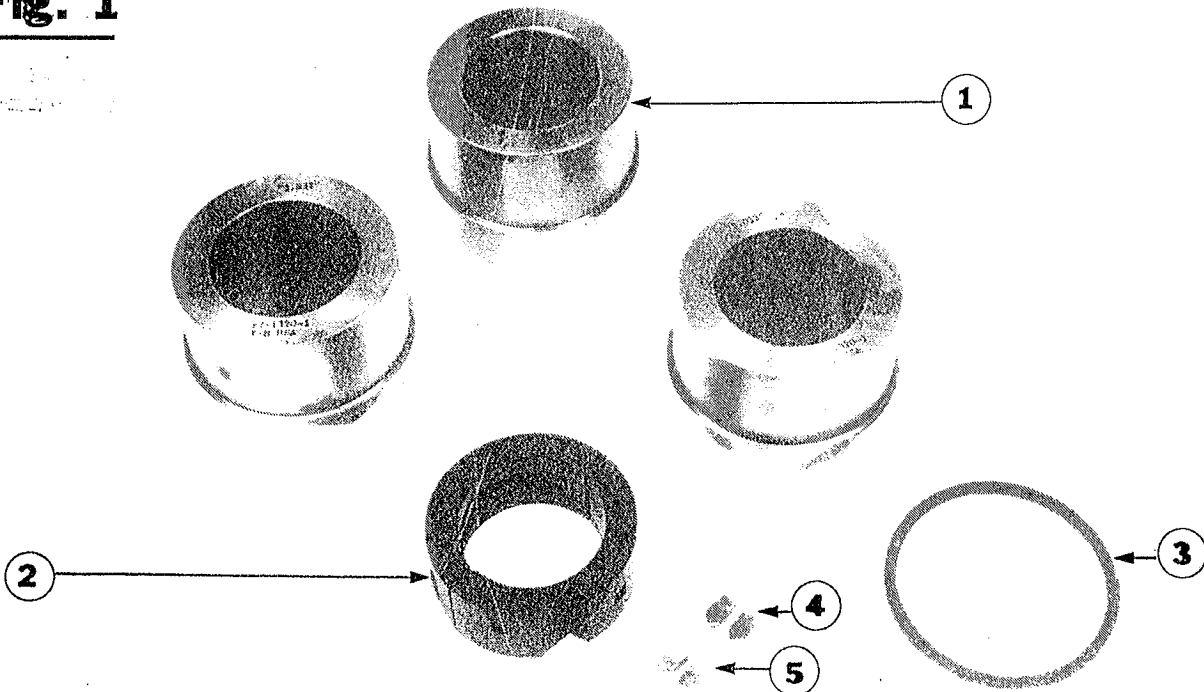
PT 1320 CAM BORING CONVERSION KIT INSTRUCTIONS

Application: Cummins L-10 engine

Tool Function: PT 1320 Conversion Kit is used with PT 1000 Series Main Saddle Line boring Tool Kits (2" diameter boring bar). When used together, they provide a means to salvage worn or damaged camshaft bearing journals. The journal(s) are machined over size and a pre-finished repair bushing, PT 8629 is installed with cambore bushing.

PT 1320 Consists of:

Fig. 1



DET.#	PART #	DESCRIPTION	QTY
1	PT 1320-1	Centering Ring	(3) req'd
2	PT 1320-2	Cutter Holder	(1) req'd
	PT 1320-3	Instruction Sheet	(1) req'd
3	PT 1320-4	Installer Ring Adapter	(1) req'd
4	PT 1000-51	Cutter (Carbide) 1/2"	(2) req'd
5	PT 1700-25	Cutter (Carbide) 9/16"	(2) req'd

1. Follow instructions for block preparation and inspection as outlined in PT 1705 Cambore Tool or engine manufacturer's instructions.
2. Follow instructions for setting micrometer and cutter as outlined in PT 1000 Line Boring Tool or engine manufacturer's instructions.
2. Lubricate inside of center rings and boring bar.
3. Slide boring bar thru rings while rotating bar. Bar must turn freely.
4. Mount cutter holder so cutter will cut in clock wise rotation. (See Fig. 2)

Original bore size 3.0310" - 3.0320" dia. Bore to size 3.2095" - 3.2105" dia.

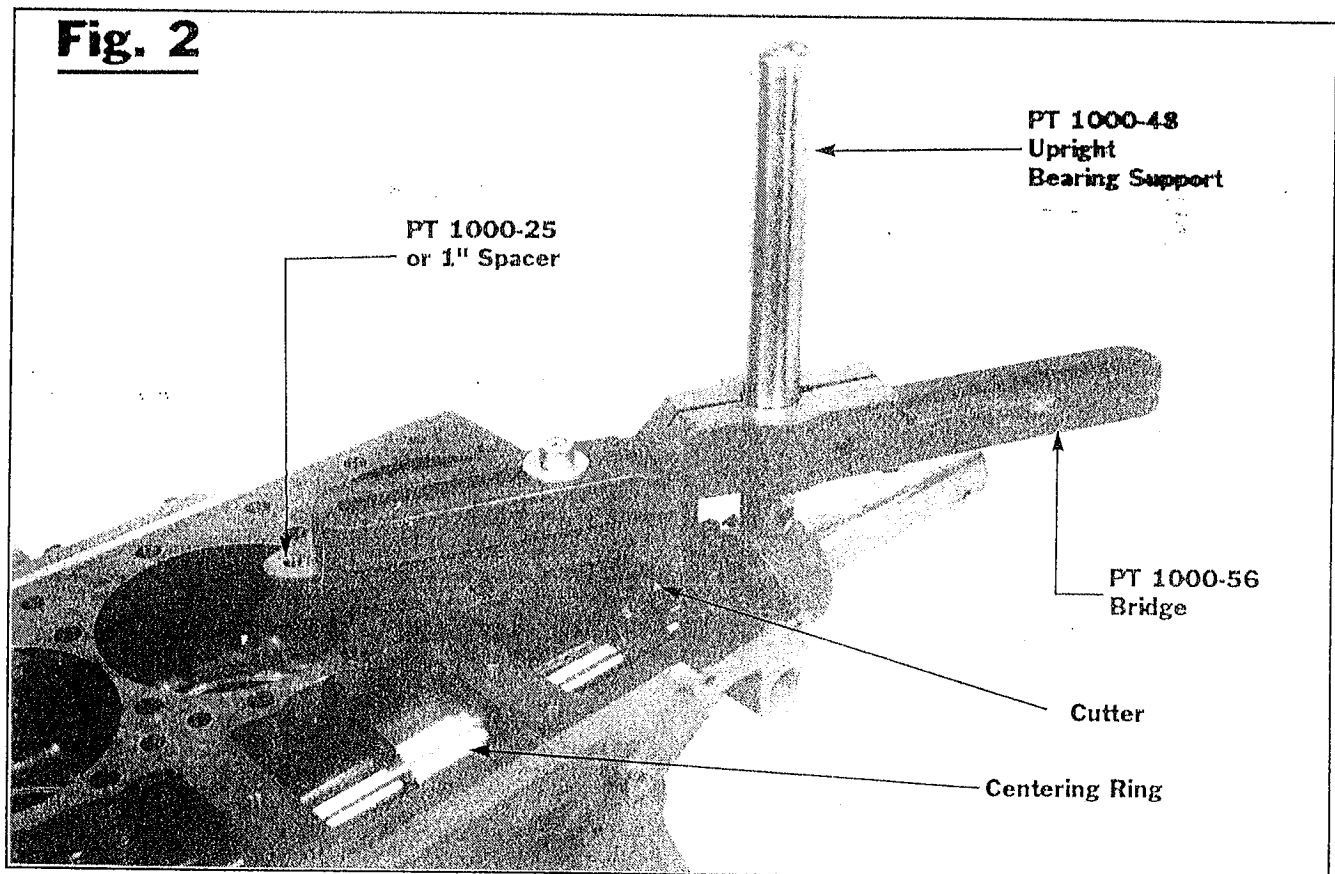
NOTE: Maximum material removal .055 per cut with .010 final cut. Use 1/2" cutter first cut.

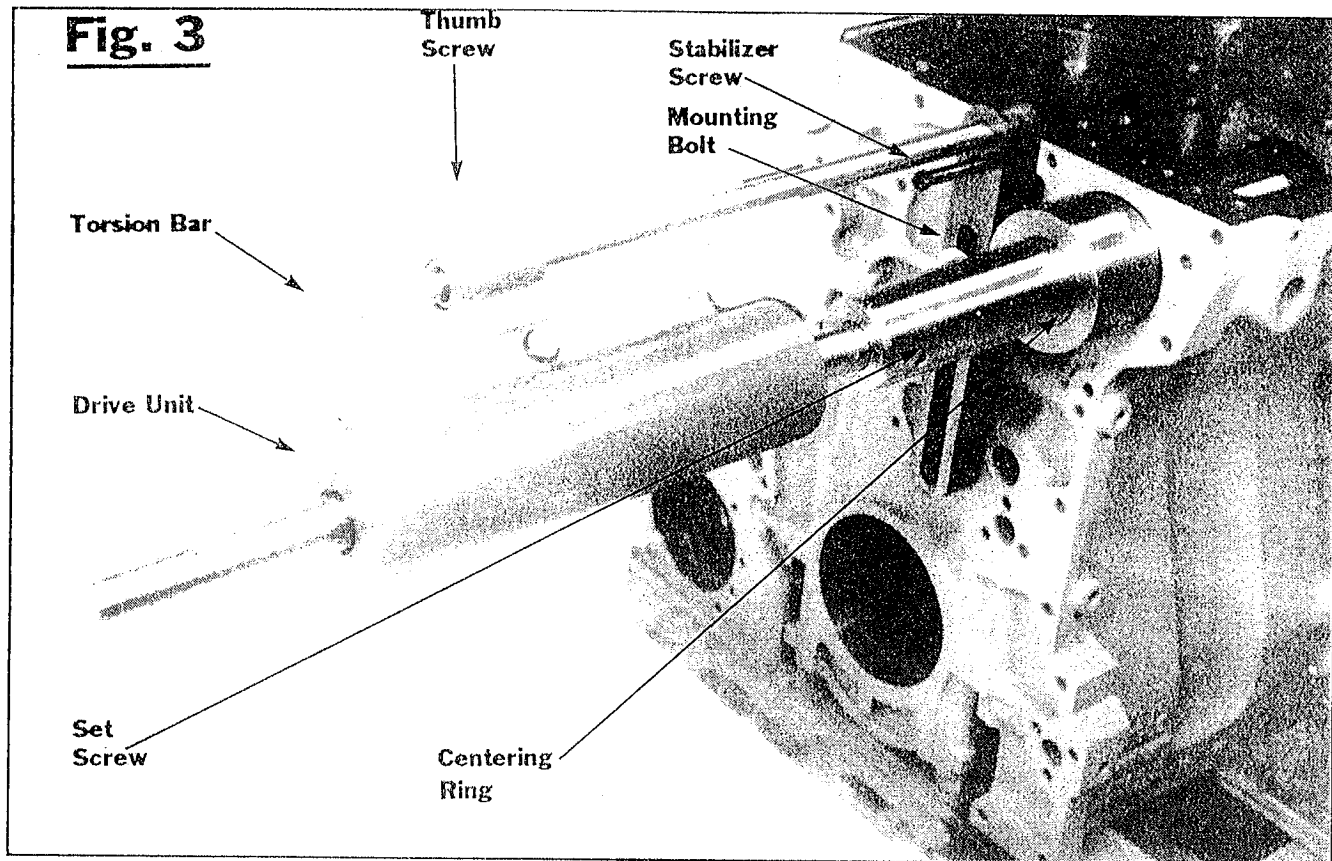
Tool Assembly

1. Install centering ring into the camshaft bushing bores on either side of bore to be salvaged. Install third ring into the end bore closest to drive unit. Seat rings by tapping lightly with mallet. (See Fig. 2 and 3)

5. To cut end camshaft bores: the bracket bridge, upright bearing support and a 1" thick spacer are needed for additional support. These items are included in some of the PT 1000 series line boring kits. (See fig. 2)
6. Loosely attach torsion bar to block. Assemble drive unit to boring bar. Tighten set screw, mounting bolt and stabilizer screw. (See fig. 3)

Fig. 2





Boring Camshaft Journals

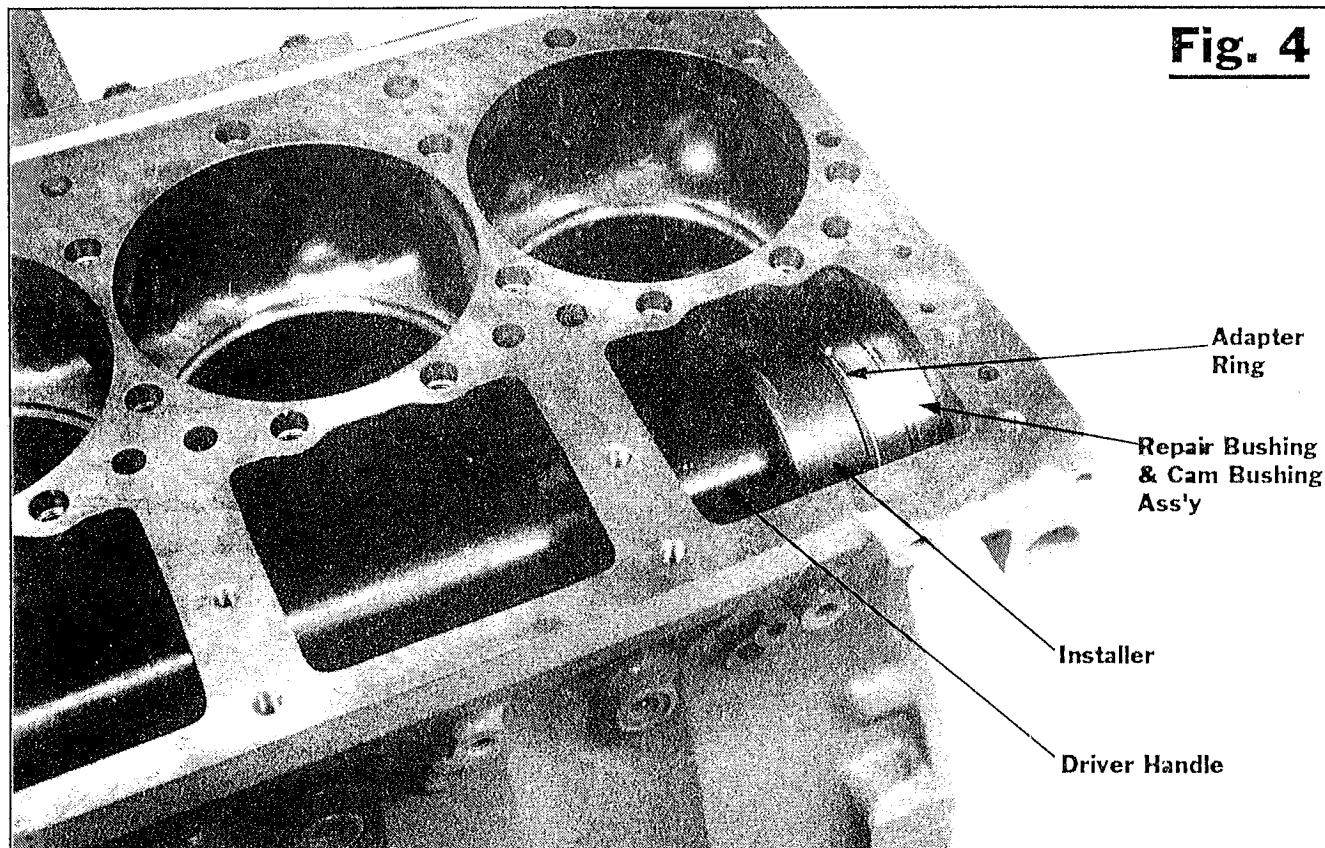
1. Open feed unit valve, hold unit and pull boring bar back to feed unit, close valve.
2. Move feed unit, boring bar and cutter assembly until cutter assembly is within 1/4" away from bore to be cut. Tighten set screw.
3. Lubricate boring bar and centering rings.
4. Mount drive adapter into 1/2" drill (300-500 rpm) and attach to feed unit.
5. Cut camshaft bore completely thru. Do not force cut, feed unit will control feed speed.
6. After cut, remove cutter holder and reset cutter for next cut. Repeat boring procedure until final size bore is obtained.

NOTE: Final cut .010" material.

7. Remove tooling, deburr bore, clean block and inspect bore.

Repair Bushing and Camshaft Bushing Assembly & Installation

1. Follow instructions as outlined in PT 1705 Cambore Tool or engine manufacturer's instructions to assemble the repair and camshaft bushing, use PT 6555-40 Cam Bushing Installer with PT 1320-4 Adapter Ring when pressing bushing together.
2. To install bushing assemblies into block: align oil passages, install the repair and cam bushing assembly as an assembly.



Use PT 6555 Driver Handles and PT 6555-40 L-10 Adapter Kit with PT 1320-4 Installer Ring Adapter. (See fig. 4)

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