

Instructions for use of PT-1600

THRUST CUTTING TOOL ATTACHMENT KIT

READ CAREFULLY BEFORE USING

The ability to line bore the main bearing bores of diesel engines using our line bore bars is a big advantage in salvaging engine blocks. The one job required to make the line boring job complete however is a means of cutting the thrust surface. The "PT-1600" Thrust Cutter Attachment used in conjunction with parts from the Line Boring Tool provides this ability.

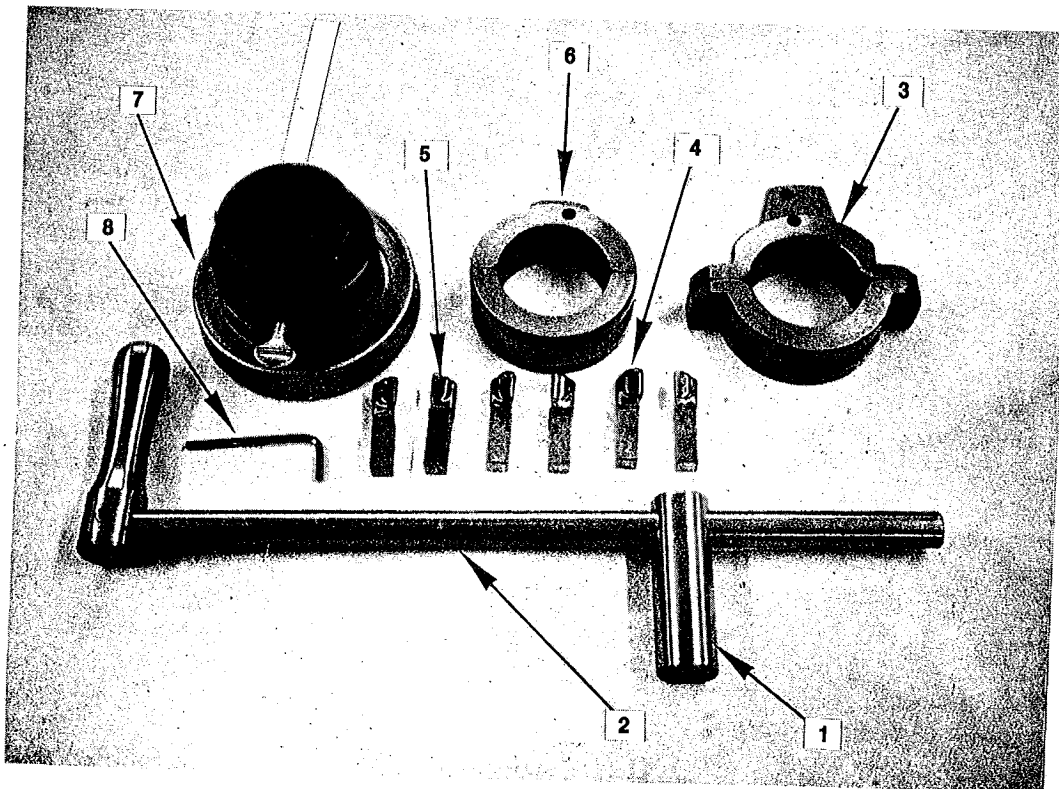


FIG. 1 THRUST SURFACE CUTTER

DET #	PART #	DESCRIPTION	AMT.
1	PT-1600-003	Crank Handle Pin	1
2	PT-1600-005	Crank Handle	1
3	PT-1600-006	Cutter Holder - LG	1
4	PT-1600-008	Cutter (AL)	1
5	PT-1600-009	Cutter (AR)	3
6	PT-1600-013	Cutter Holder - SM	1
7	PT-1600-017	Feed Collar Group	1
8	PT-1600-018	Hex Key (3/16")	1
*	PT-2800-048	Hex Key (1/8")	1

* NOT SHOWN

Available accessories to do K-Series but not included in kit:

PT-1600-019	Cutter (AL)
PT-1600-020	Cutter (AR)

Right Hand Rotation (clockwise)



Kent-Moore
TOOL DIVISION

P.O. BOX 647 ■ 827 JEFFERSON AVE.
CLOVIS, CALIFORNIA 93613
Telephone: 209/299-4351



PORTA-TOOL
PRODUCTS

CUTTING THE THRUST

1. Install the appropriate centering ring (from your Line Bore Bar) in the #1 main bearing and the thrust bearing saddle. The centering ring in the thrust saddle should be centered in the saddle such that it will clear the cutter holder when cutting the thrust bearing surface. See Fig. 2.

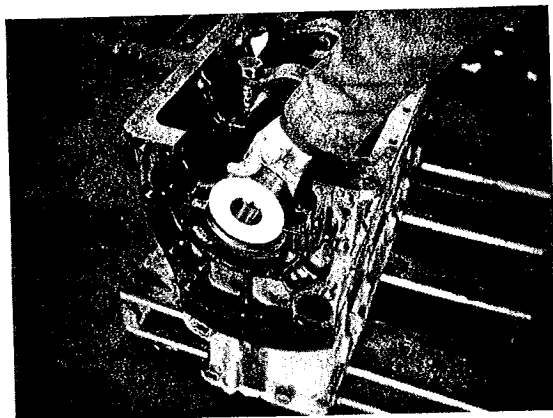


FIG. 2 INSTALLING CENTERING RING

6. Install appropriate cutter holder and adjust the cutter to cut the full thrust bearing surface. The cutter should be inserted so it cuts when the boring bar is turned in a clockwise rotation. (Note: Left-hand and right-hand cutters). See Fig 4.

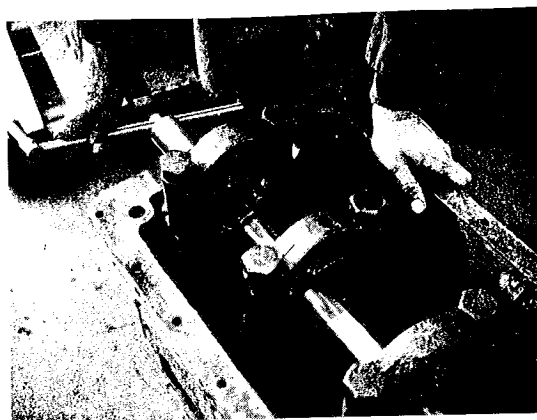


FIG. 4 INSTALLING CUTTER HOLDER

2. Reinstall the main bearing caps over the centering rings and torque to specifications. Refer to Engine Shop Manuals.

3. Lubricate the bores of the centering rings and the working area of the line boring bar.

4. Install the Feed Collar on the boring bar on the opposite side of the thrust surface to be cut. See Fig. 3.

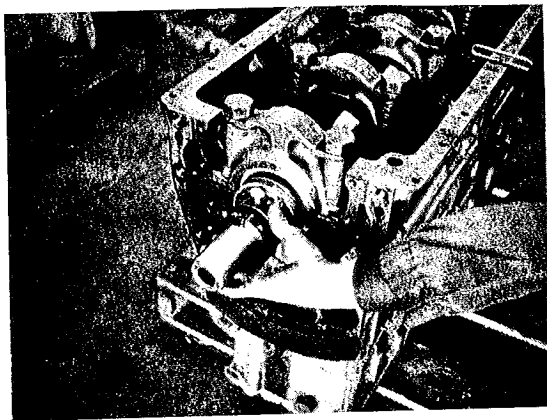


FIG. 3 INSTALLING FEED COLLAR

7. Adjust the Feed Collar (so the cutter is just making light contact with the thrust bearing surface to be cut) and tighten the socket head cap screw securely.

8. Now turn the boring bar clockwise a few revolutions to check the cutter's cutting pattern.

9. Adjust the cutter cutting depth by loosening the thumb screw and rotating the feed collar clockwise (each line represents 0.001"). See fig. 5.

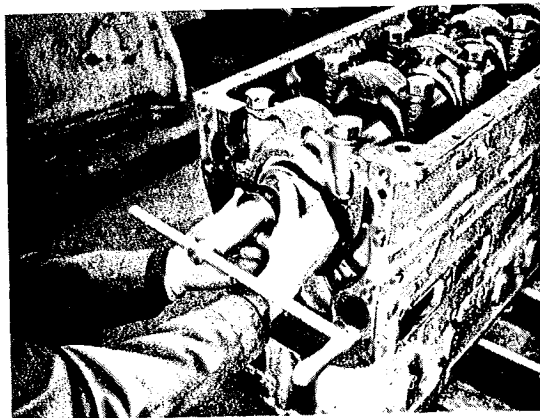


FIG. 5 ADJUSTING CUTTING DEPTH

5. Install the crank handle pin in the end of the boring bar and secure in place with the socket set screw.

10. Proceed to cut thrust bearing surface until proper finish is obtained.

CAUTION: The boring bar should be rotated very slowly during the cutting operation to avoid chatter!

