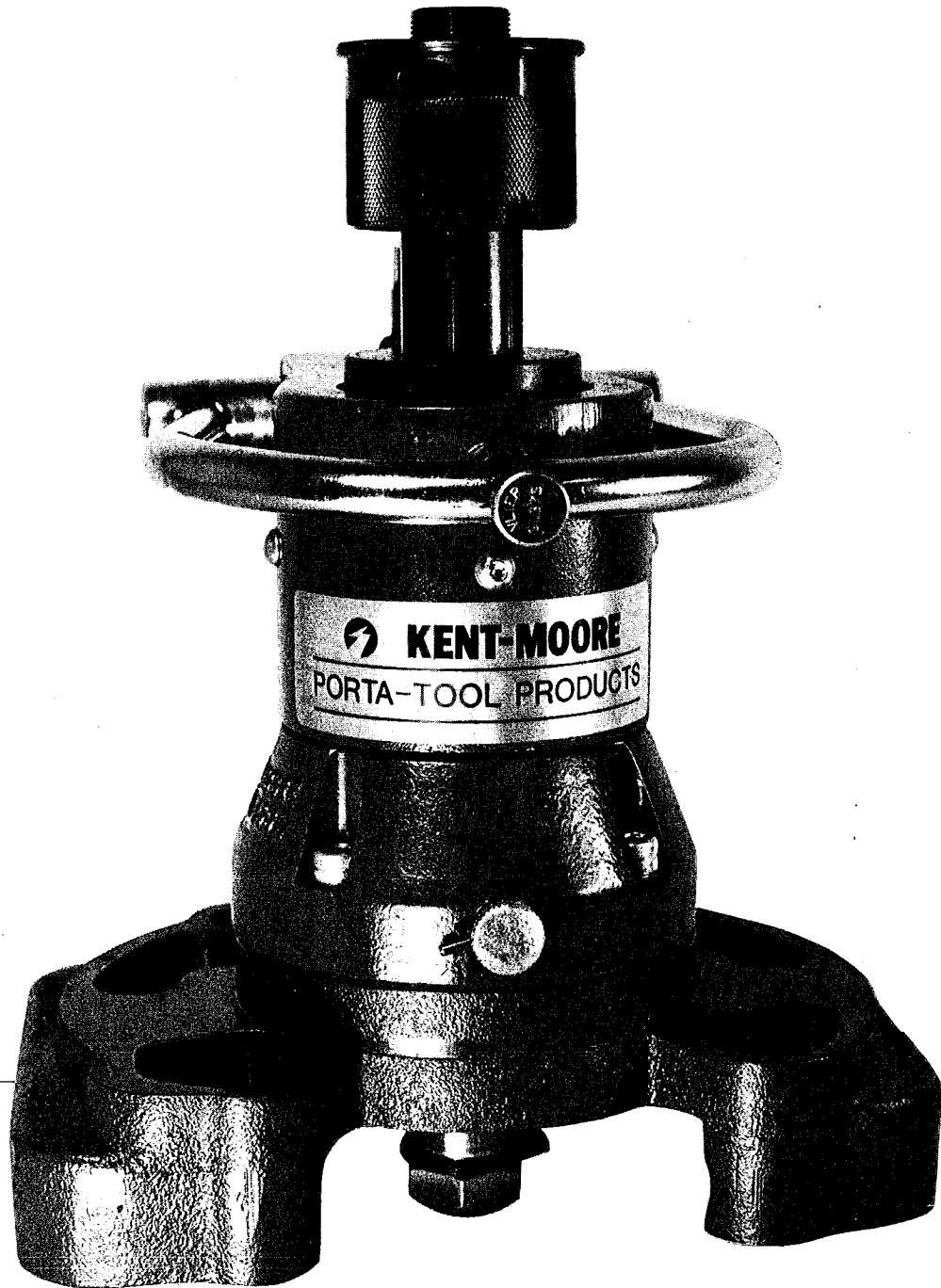

KENT-MOORE



**INSTRUCTIONS FOR
PT 2060 PORTA-MATIC
CONVERSION KIT**

PT 2060 CONVERSION KIT

APPLICATION: Cummins all K Series, KT/KTA19 and KT/KTA 38/50

PT 2060 Conversion Kit is required to adapt all PT 2000 and PT 2050 Porta-Matic Models.

FUNCTION: The conversion kit when installed onto the Porta-Matic, will provide a means to machine all K Series engine block liner counterbores.

The following cutter bits describes the engine block style each cutter must be used on. "REFER TO CUMMINS SERVICE MANUAL AND SERVICE TOPICS FOR SPECIFICATION AND PROCEDURES FOR MACHINING THE VARIOUS K STYLE ENGINE BLOCK COUNTERBORES."

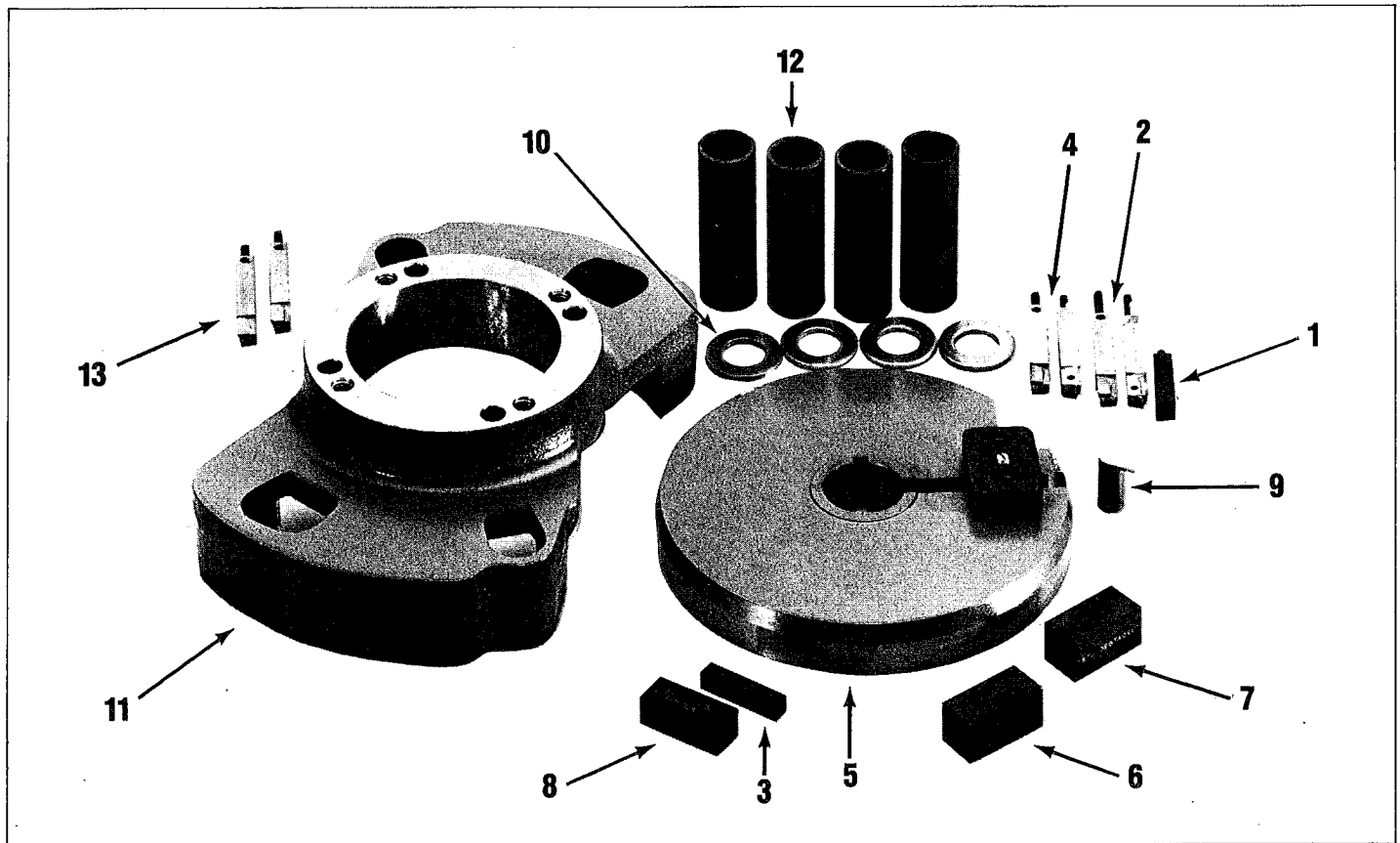
PT 2000-46 2-1/2" long cutter
 —Counterbore ring, thick flange blocks
 —K38 or K50 counterbore blocks
 —Ref 7.5" counterbore diameter

PT 2000-70 2-3/8" long cutter
 —Thick flange production blocks
 —Thin flange — factory modified to thick flange blocks.
 —Ref 7.4" counterbore blocks

PT 2000-77 2-1/2" long cutter
 —Thin flange — field modified to thick flange blocks.
 —Thin flange blocks
 —Ref 7.4K counterbore blocks

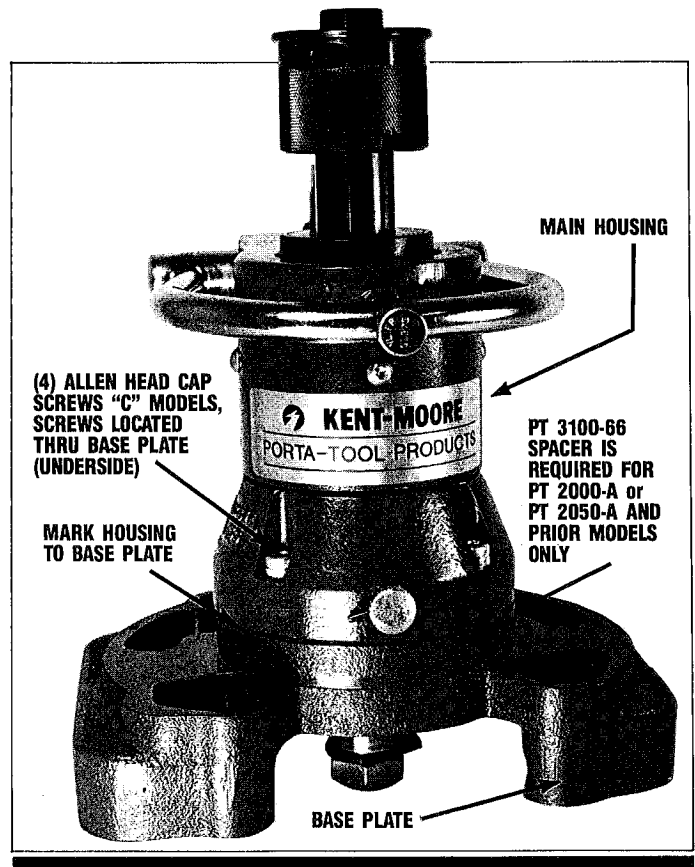
PARTS LIST

DET #	PART #	DESCRIPTION	QTY.	DET #	PART #	DESCRIPTION	QTY.
1	PT 2000-43A	Cutter Set Gauge	1	8	PT 2000-75	Depth Spacer Block	1
2	PT 2000-46	Cutter	2	13	PT 2000-77	Cutter	2
3	PT 2000-68	Depth Spacer Block	1	9	PT 2000-91	ANVIL	1
4	PT 2000-70	Cutter	2	10	PT 2100-103	Washer	4
5	PT 2000-71	Cutter Plate	1	11	PT 2300-1	Base Plate	4
6	PT 2000-72	Depth Spacer Block	1	12	PT 3000-12	Stud Adapter	4
7	PT 2000-73	Depth Spacer Block	1				



PORTA-MATIC CONVERSION INSTRUCTIONS

1. Mark Housing to base plate. Align marking when reinstalling universal base plate.
2. Remove cutter plate.
3. Remove (4) Allen head cap screws and universal base plate.
4. Clean all mating surfaces on both the main housing and "K" Base plate thoroughly. Inspect and remove any burrs or nicks.
5. Assemble K base plate in reverse order torque (4) allen head cap screws to 30 ft. lbs.
- 5a. If converting PT 2000-A or PT 2050-A and prior model, install PT 3100-66 between main housing and K base plate.
6. Install K cutter plate, washer and nut, torque to 30 ft. lbs.



CALIBRATING MICROMETER BLOCK

1. Replace button style Anvil with off-set Anvil, loosen clamp screw, remove Anvil and install off-set anvil.
- NOTE: Always clean all measuring surfaces before using micrometer, setting standard or cutter.
2. Set micrometer to 7.600 reading. Place PT 2000-43A setting standard with side stamped side "UP" between off set anvil and against micrometer spindle, hold in place.
 3. Slide anvil against setting standard and tighten anvil clamp screw.
 4. Back-off micrometer and re-tighten to fit snugly against setting standard. Micrometer reading must be 7.600. If not, reset until 7.600 reading is obtained.

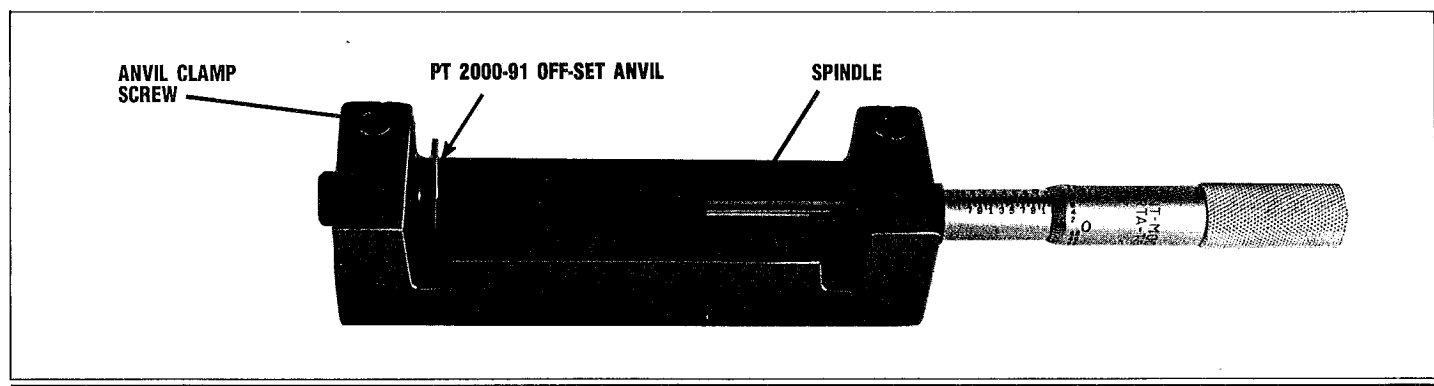
TESTING YOUR CONVERSION

Before machining any customer's engine block, the accuracy of your K conversion must be tested.

It is recommended you use a scrap block. If one is not available, machine a size smaller than required.

Machine block and check the accuracy of cut. Make final adjustments before machining to specifications.

Refer to Cummins service manual and service topics for specification and procedures for machining the various K style engine block counterbores.



7.5 COUNTERBORE INSERTS AND BUSHINGS

FUNCTION: "L" Bushing salvage liner counterbore top and secondary press diameters.

Insert salvage block top counterbore area.

APPLICATION: K-38 (12V) K-50 (16V)

Part #	Description	± .0005 Bore to Diameter	Top Deck to Bottom of Bore
PT 8081 3326222	Insert Oversize (+ .100 O.D. + .010 Depth)	7.6995	.550
PT 8083 3376449	Insert Standard	7.5995	.541
PT 8082	"L" Bushing Oversize (+ .100 O.D. + .010 Depth)	7.7095	.875
PT 8084	"L" Bushing Standard	7.6095	.865

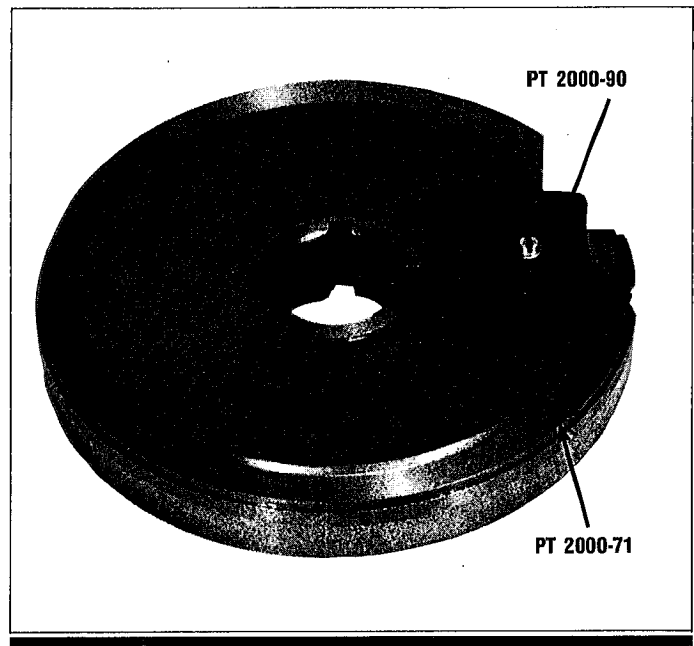
The following are required for installation of the above insert and bushings. They are used in conjunction with PT 2060 K conversion kit and are not part of the kit.

PT 2000-88	Cutter
PT 2000-90	Cutter Holder (U/W PT 2000-71 Plate)
PT 2000-92	Guide Plate Shaft (U/W PT 2000-19 Driver Handle)
PT 2000-93	Driver Plate
PT 2000-94	Guide Plate

CUTTER PLATE CONVERSION

The cutter bit used to machine the counterbore for inserts and bushings, require a special cutter bit PT 2000-88. The cutter hold down block PT 2000-90 must be installed onto the PT 2000-71 Cutter Plate.

Follow the procedure for machining the engine block as outlined in your Porta-Matic instructions. Also, reference engine manufacturers service manual and service topics.



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