

**KENT-MOORE**

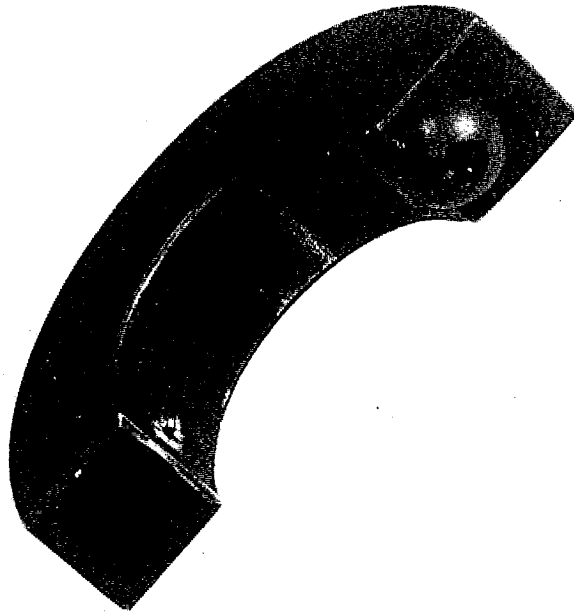
1-800-328-6657 (CANADA, USA)



*Heavy Duty Division*

## **PT 2000-215 DEPTH SET GAGE INSTRUCTIONS**

For use on PT 2000, PT 2050 Porta-Matics -B, -C and -D Versions Only



### **PT 2000-215 Depth Set Gage**

**APPLICATION:** CUMMINS 5 1/2" NH  
MACHINING FOR LOWER PRESS  
FIT LINERS.

## TOOL FUNCTION;

PT 2000-215 Depth Set Gage, when used with PT 2000-199 Gage Block (.375" side) or PT 2000-194 (.375") Gage Block, eliminates the up and down adjustment of the depth set collar when cutting Cummins 5 1/2 NH block for lower press fit liners (LPF).

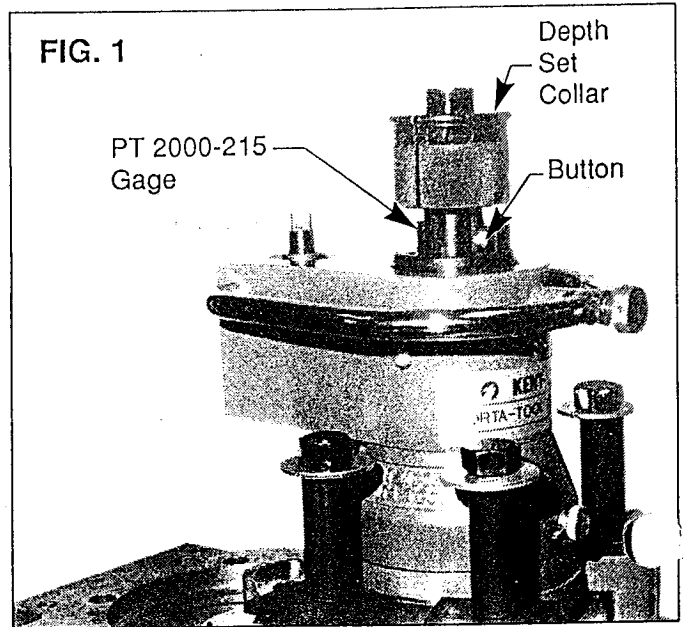
**NOTE:** You will be required to back off the depth set collar when relocating the Porta-Matic into a different cylinder liner block bore.

## INSTRUCTIONS:

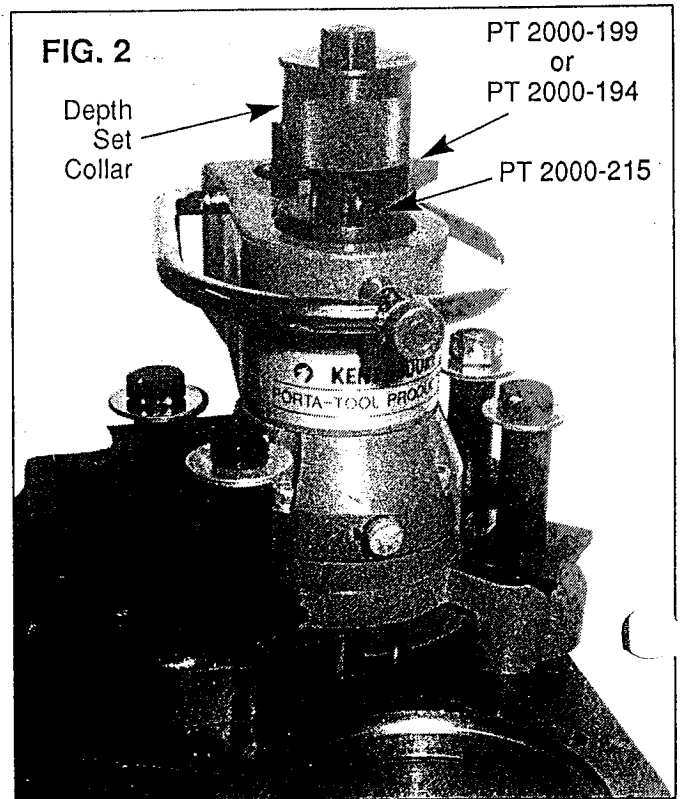
1. Prepare block for boring in the usual manner and mount the PT 2000-207 Cutter Plate to the Porta-Matic. (See PT 2000-207 and PT 2050 Boring Instructions)
2. Once boring machine is located and secured in place over first bore to be cut, lower PT 2000-207 tapered cutter plate with cutter installed onto .004" feeler gage.
3. Loosen set screw on depth set collar and adjust it up. Snap PT 2000-215 Depth Set Spacer on mainshaft of Porta-Matic between the collar and touching the housing (Fig. 1).

**NOTE:** Button on gage must be facing clockwise rotation and engaged into shaft spline opening before snapping tool in position. (Fig. 1)

4. Place PT 2000-199 (.375" side) of depth set block or PT 2000-194 Gage Block between PT 2000-215 Gage and the Porta-Matic depth set collar. (This is the depth of cut for LPF Counterbore, 1st cut). Then adjust the depth set collar down mainshaft so that it rests squarely on the PT 2000-199 (.375" side) Gage Block and securely tighten the Depth Set Collar set screw (Fig. 2).



PT 2000-215 Gage Depth Set Collar



.375 Gage Block PT 2000-199

5. Pull mainshaft to the full upright position and lock feed valve in closed position. Remove PT 2000-199 (.375") Gage block.

Your Porta-Matic is now set up for machining the .375" depth of cut for counterbore (1st cut) and .930" depth of cut for LPF area. (2nd cut) when PT 2000-215 Depth Set Gage is removed.

6. Follow procedure for LPF Boring as outlined in instruction for PT 2000-207 Cutter Plate and PT 2050-D Porta-Matic.

7. Use the following as step by step reference.

- Set both counter bore and LPF depth of cut's as outlined.
- Machine counterbore (1st cut)
- Retract cutter plate
- Install cutter bit for LPF cut (2nd cut)
- Remove PT 2000-215 Depth Set Gage (2nd cut .930" deep)
- Machine LPF area.
- Retract cutter plate
- Remove cutter bit
- Reposition Porta-Matic over next bore
- Center and torque in place.

**IMPORTANT:** Due to the design of PT 2000-207 Cutter Plate and the length of travel of the Porta-Matic, it will be necessary to back off the Porta-Matic depth set collar two complete turns before centering the Porta-Matic into a different cylinder liner block bore. Failure to do so will result in a non-centering condition of the Porta-Matic and machine the bores off center.

- Reinstall PT 2000-215 Depth Set Gage.

**IMPORTANT:** Failure to replace Depth Spacer on mainshaft will cause Porta-Matic to bore too deep. Always double check to insure PT 2000-215 is in place before proceeding with boring counterbore (1st cut).

- Reinstall counterbore cutter bit (1st cut)
- Follow step 2 thru 7 to machine new bore.

# **NEW TIME SAVING TOOL**

## **PT 2200-83 SPACER BLOCK**

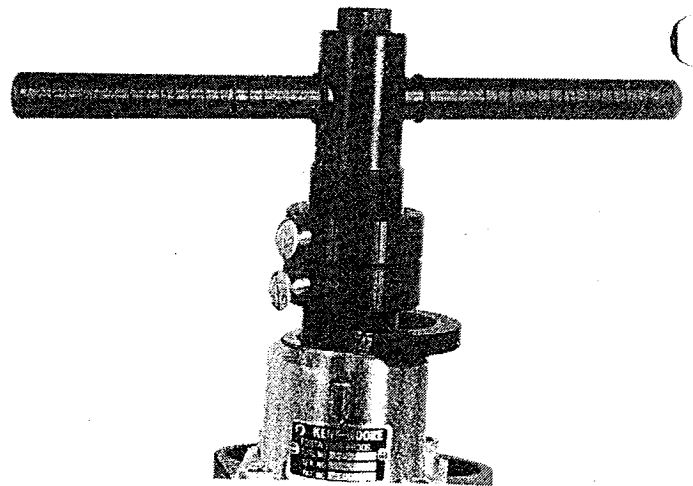
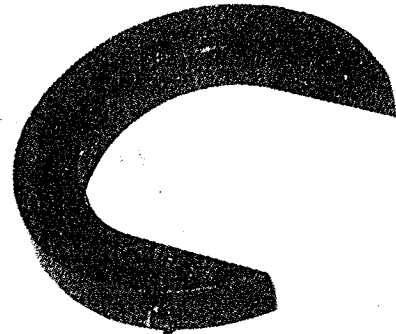
**Application:** Taper Locating cutter plates;  
PT 2200-72A, PT 2205-25A, PT 2210-3A,  
PT 2210-4A and PT 2210-5A

PT 2200-83 saves you set-up time when machining more than one counterbore per engine. You set the depth set collars for the first bore and the remaining bores will be cut to the same depth.

Used with counterbore ledge tools:

- PT 2250-A Universal
- PT 2205 NH, Cummins
- PT 2210 L-10, C, Cummins  
E-7 & Mack

**NOTE:** PT 2200-83 Spacer block is part of  
PT 2210 Counterbore Tool.



**SPX**

*Exponent of Excellence*

**KENT-MOORE**

*Kent-Moore  
Heavy Duty Division  
SPX Corporation*

*29784 Little Mack  
Roseville, MI 48066-2298*

*1-800-328-6657 (USA, Canada)  
Telex 244040 KMTR UR  
Fax 313-774-9870*

PT 2000-218