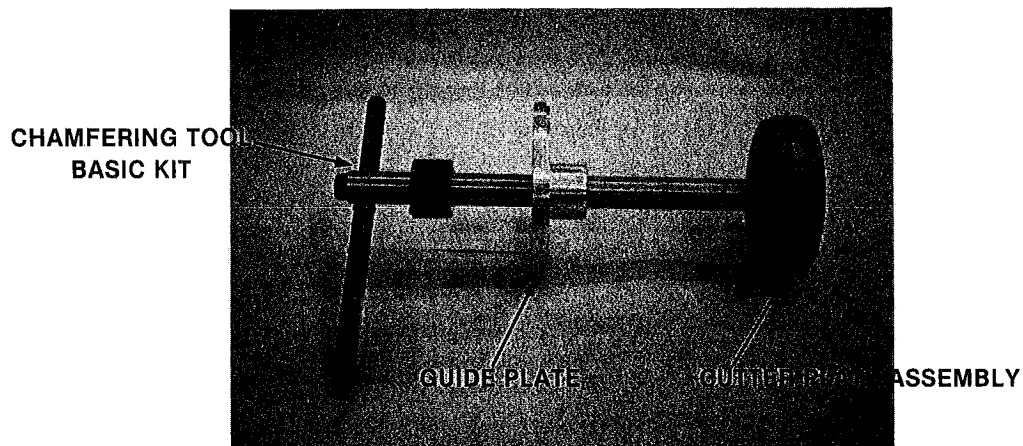


# Instructions for use of PT-3600 CHAMFERING TOOL

## READ CAREFULLY BEFORE USING

The PT-3600 Chamfering Tool is made to provide a crevice seal entry chamfer. This tool must be used to finish cut the lower bore repair bushings. The Chamfering Tool will mesh the entry chamfer of the repair bushing to block.



### PT-3600 CHAMFERING TOOL

PART #	PART DESCRIPTION	CUMMINS ENGINE
PT-3400-009	Steel Box	---
PT-3600-006	Guide Plate	5-1/2 NH
PT-3600-007	Guide Plate	5-1/8 NH
PT-3600-008	Guide Plate	4-5/8 V6/8 VAL-VALE
PT-3600-009	Guide Plate	C Series
PT-3600-010	Guide Plate	J Series
PT-3600-021	Guide Plate	5-1/2 V6/8 VIM-VINE, 903
PT-3600-027	Cutter Plate Assembly	5-1/2 NH
PT-3600-028	Cutter Plate Assembly	5-1/2 V6/8 VIM-VINE
PT-3600-029	Cutter Plate Assembly	903
PT-3600-030	Cutter Plate Assembly	5-1/8 NH
PT-3600-031	Cutter Plate Assembly	4-5/8 V6/8 VAL-VALE
PT-3600-033	Cutter Plate Assembly	C Series
PT-3600-034	Cutter Plate Assembly	J Series
PT-3600-040	Chamfering Tool Basic Kit	

PT-3600 Chamfering Tool includes all the necessary equipment needed for current Cummins engine models except KT, L, and K series.

### PT-3650 CHAMFERING TOOL BASIC KIT

PT-3650 Chamfering Tool Basic Kit is used in conjunction with the following Conversion Kit(s) to give a particular application(s).

#### Conversion Kits To Add To PT-3650 Basic Kit:

PART #	PART DESCRIPTION	CUMMINS ENGINE
PT-3600-002	Conversion Kit	5-1/8 NH
PT-3600-026	Conversion Kit	4-5/8 V6/8 VAL-VALE
PT-3600-035	Conversion Kit	4-7/16 C Series
PT-3600-036	Conversion Kit	4-1/8 J Series
PT-3600-037	Conversion Kit	5-1/2 903
PT-3600-038	Conversion Kit	5-1/2 V6/8 VIM-VINE
PT-3600-039	Conversion Kit	5-1/2 NH

Conversion Kits consist of: Guide Plate and Cutter Plate Assembly (includes Cutter)

## OPERATING INSTRUCTIONS

1. Select correct Cutter Plate Assembly (for given engine).
2. Place cutter in Cutter Plate Assembly positioning the lower edge of cutter angle slightly below the pilot diameter. Tighten button head screws to secure cutter in position (Fig 1).

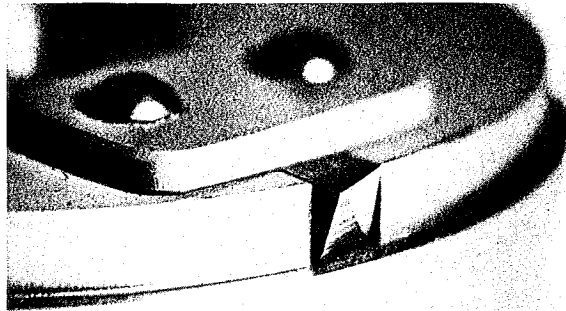


FIG 1 Cutter properly installed

3. Select correct Guide Plate (for given engine). Install Guide Plate on shaft of Chamfering Tool Basic Kit with flat surface towards handle.
4. Install preset Cutter Plate Assembly on shaft with cutter towards handle, fasten in place.
5. Place Chamfering Tool on bore to be chamfered, allowing the Guide Plate to rest in the counter-bore. Holding T-handle, loosen socket head cap screw on adjusting collar lowering Cutter Plate Assembly until cutter makes contact with the upper part of repair bushing to be chamfered.
6. Turn the T-handle clockwise and push down gently, cutting the chamfer to the desired depth. When the desired depth is reached, tighten the socket head cap screw on the adjusting collar. This establishes the depth for cutting the remainder of chamfers.
7. In the notch of the depth set collar turn 1/2-dog set screw clockwise until a 1/4" gap is between the two collars.
8. Place the Chamfering Tool into next bore to be chamfered.
9. Turn the 1/2-dog set screw counter-clockwise until the cutter touches the top of the bushing to be chamfered.
10. Gradually turn the 1/2-dog set screw counter-clockwise and continue turning T-handle until two collars meet. This is again the desired chamfer depth.
11. For remainder of block continue repeating steps 7, 8, 9, and 10.



**KENT-MOORE**

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