

DETROIT DIESEL



Installation Instructions

18SP310 – Series 60® Cylinder Block Plug and Dowel Locations

The customer must install the following shipped-loose parts:

- I. 8929432 Plug, Rubber Weep Hole (6 places)
- J. 8929153 Dowel, 20.0 mm (Diamond)
- K. 8929152 Dowel, 20.0 mm (Round)
- L. 8929022 Dowel, 16.0 mm (Diamond, 2 places)
- M. 8929015 Dowel, 16.0 mm (Round)

Dowels **J**, **K**, **L**, and **M** are installed to a height of 12.0 mm ± 0.5 mm (0.472" ± 0.020"). Use Kent-Moore® tool J 46224-1 to install dowels **J** and **K**. See Figure 1 for orientation of dowels **J** and **K**.

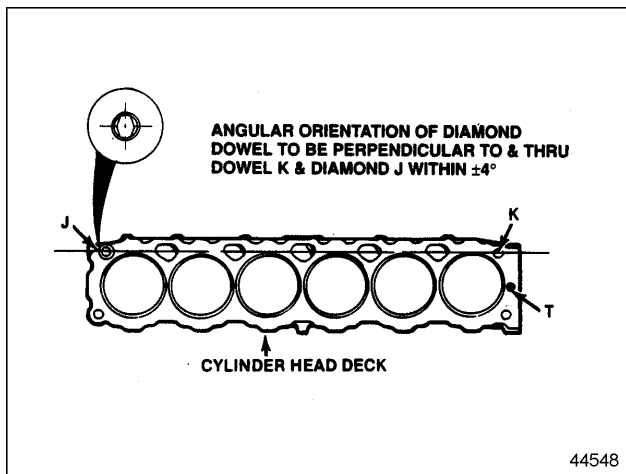


Figure 1 Orientation of Dowels J and K

Use J Tool J 36224-2 to install dowels **L** and **M**. See Figure 2 and Figure 3 for orientation of dowels **L** and **M**.

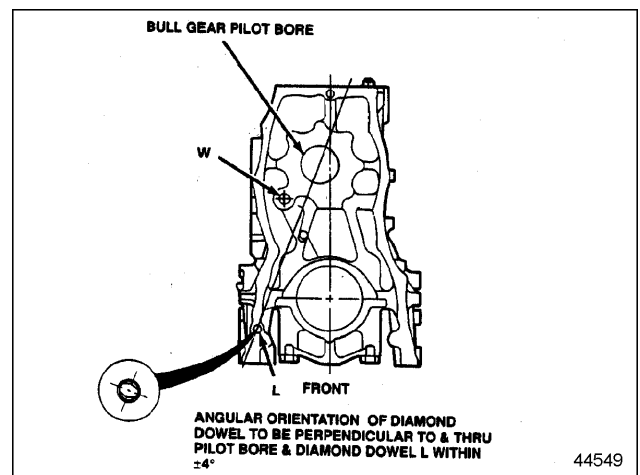


Figure 2 Orientation of Dowels L and M

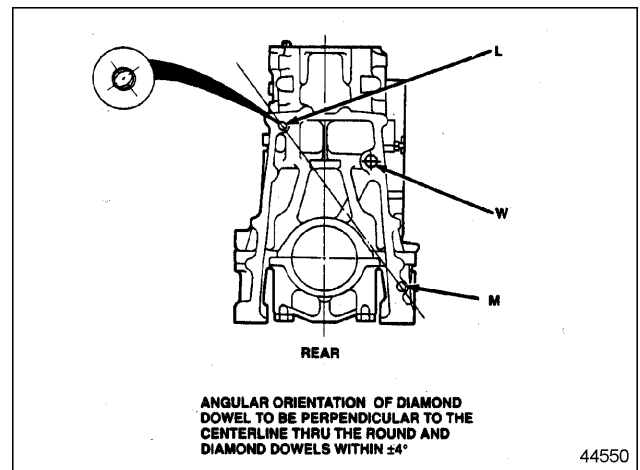


Figure 3 Orientation of Dowels L and M

The following plugs are installed in this cylinder block: (installation instructions are included in case the plugs are later removed)

- N. 5139991 Cup Plug, 1-1/2" Stainless (5 places).
See Figure 4 for cup and pipe plug locations.

Cup Plugs **N** are installed 2.5-3.0 mm (0.098-0.118 in.) below the machined surface. [Use tool set J 35653 to install the cup plugs. Coat the outside sealing edge of the cup plugs with a good grade of non-hardening sealant such as Loctite® 620 (or equivalent) before installing.]

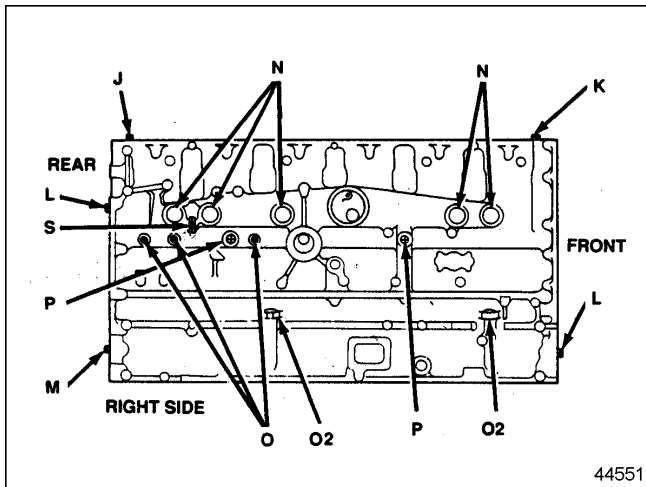


Figure 4 Location of Cup and Pipe Plugs on Right Side

- O. 8922327 1/4"-18 Pipe Plug (4 places). [Tighten to 19-24 N·m (14-18 lb-ft) torque.]
- O1. 8922327 1/4"-18 Pipe Plug (2 places). [Required only for pressure testing of cylinder block. In service, these plugs are replaced by the oil pressure sensor (OPS) and the oil temperature sensor (OTS).] See Figure 5.

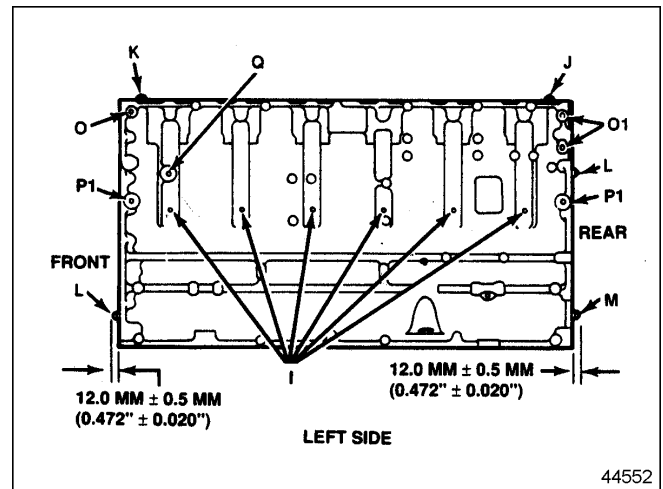


Figure 5 Location of Cup and Pipe Plugs on Left Side

- O2. 8922327 1/4"-18 Pipe Plug (1 place). Opposite oil level dipstick location. See Figure 4.
- P. 8929594 3/8"-18 Pipe Plug (1 place). [Tighten to 24-31 N·m (18-23 lb-ft) torque.]
- P1. 8924517 3/8"-18 Pipe Plug (3 places). [Tighten to 24-31 N·m (18-23 lb-ft) torque.]
- Q. 8923916 1/2"-14 Pipe Plug (1 place). [Tighten to 31-39 N·m (23-29 lb-ft) torque.]
- S. 8924140 Draincock 1/4" Pipe Brass.
- T. 5151272 Plug 11/32" Dia. [Install flush to 1.0 mm (0.040 in.) below surface.]
- W. 5139988 Cup Plug, 1" Dia. Stainless (2 places). [Cup Plugs **W** are installed 2.5-3.0 mm (0.098-0.118 in.) below the machined surface. Use tool set J 35653 to install the cup plugs. Coat the outside sealing edge of the cup plugs with a good grade on non-hardening sealant such as Loctite® 620 (or equivalent) before installing.]

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