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<b>TECHNICAL BULLETIN</b>	
	<b>June 2002</b> <b>TB 1989</b>

Cam Bearing Bore Repair For  
 Detroit Diesel 11.1 & 12.7L Diesel, 60 Series Engines

The AERA Technical Committee offers the following information regarding the possible repair of worn cam bearing bores for DDC 60 Series Engines. These engines use an overhead camshaft design with seven individual location precision bearing inserts. Over time those bearing bores may become worn oversize or out-of-round, or an insert may even spin in its bore.

To repair a cylinder head in those instances for re-use, DDC has three different oversize outside diameter (OD) bearings available. To allow use of those bearings the cylinder head must be align bored to the larger oversize bore selected. Before align boring this massive cylinder head it is imperative the cylinder head be supported during the machining operation so there is no distortion (sag) on the head deck side.

Before machining, assemble the numbered caps in their perspective locations and torque to 75-86 FT/LBS. The standard housing bore is 2.7163-2.7178" (68.994-69.031mm) for all seven locations. The additional oversizes are shown in the table below.

Bearing Size	Part Number	Housing Bore Diameter
Standard	8929690	2.7163-2.7178" (68.994-69.031 mm)
.254 mm	8929691	2.7263-2.7278" (69.248-69.285 mm)
.508 mm	8929692	2.7363-2.7378" (69.502-69.539 mm)
.762 mm	8929693	2.7473-2.7478" (69.756-69.793 mm)

The AERA Technical Committee

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