



Service Information Bulletin

NUMBER: 7–15–13 **S.M. REF.:** Listed in Table **ENGINE:** EPA04/EPA07 Series 60 **DATE:** July 2013

SUBJECT: INSPECTION OF ASSEMBLED CONNECTING ROD

ADDITIONS, REVISIONS, OR UPDATES

Publication Number	Platform	Section Title	Change
DDC-SVC-MAN-0004	EPA04 Series 60	Inspection of Assembled Connecting Rod	New bolts require changes to the procedure.
DDC-SVC-MAN-0005	EPA07 Series 60	Inspection of Assembled Connecting Rod	New bolts require changes to the procedure.

NOTE: Page numbers are based on the most recent version of the individual publication and may be adjusted throughout the annual print cycle.

THE FOLLOWING IS USED IN DDC-SVC-MAN-0004:

INSPECTION OF ASSEMBLED CONNECTING ROD

Measure the connecting rod bearing diameter at five locations. See Figure 1.

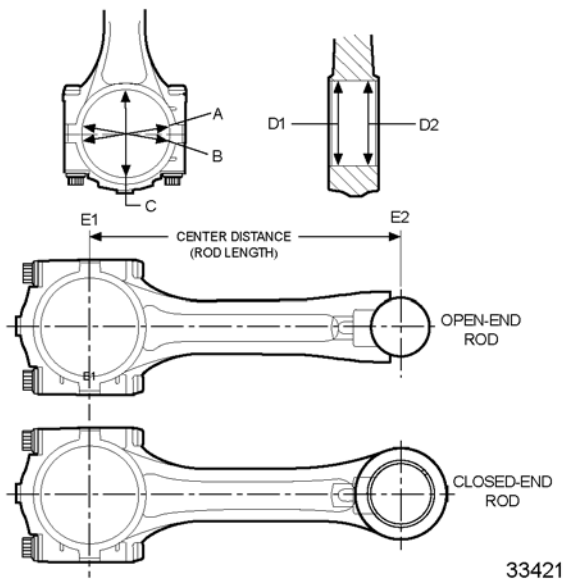


Figure 1 Dimensional Inspection of Connecting Rods

1. Calculate size of diameter at split line, W. [$W = (A+B) \div 2$]
2. Calculate the average bore out-of-round, X. [$X = W - C$] X must be between -0.012 and 0.012 mm (-0.0005 and 0.0005 in.).
3. Calculate the average connecting rod bearing bore size, Y. [$Y = (W+C) \div 2$] Y must be between:
 - [a] For 12.7 and 11.1 L; 91.288 and 91.313 mm (3.594 and 3.595 in.).
 - [b] For 14L and 12.7 EGR On-Highway; 101.288 and 101.3133 mm (3.988 and 3.989 in.).
4. Determine taper, Z. [$Z = D2 - D1$] Z must be between -0.012 and 0.012 mm (-0.0005 and 0.0005 in.).
5. Determine the rod length by finding the distance between E1 and E2. See Figure 1.
 - [a] The acceptable rod length specification for 11.1-Liter connecting rod is: 281.95 to 282.05 mm (11.1004 to 11.1043 in.).
 - [b] The acceptable rod length specification for both 12.7-Liter and 14-Liter connecting rods is: 269.25 to 269.35 mm (10.6004 to 10.6043 in.).
 - [c] The acceptable rod length specification for Series 60G Engines is: 262.90 to 263.00 mm (10.3504 to 10.3543 in.).
 - [d] If the connecting rod bore is not to specifications, the rod must be scrapped and cannot be machined.
6. If a new connecting rod is required, stamp the cylinder number on the connecting rod and cap. Refer to section .

THE FOLLOWING IS USED IN DDC-SVC-MAN-0005:

INSPECTION OF ASSEMBLED CONNECTING ROD

Measure the connecting rod bearing diameter at five locations. See Figure 2.

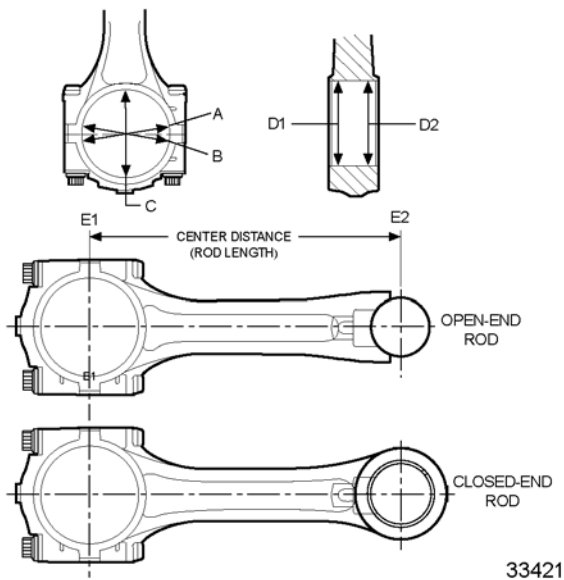


Figure 2 Dimensional Inspection of Connecting Rods

1. Calculate size of diameter at split line, W. $[W = (A+B) \div 2]$
2. Calculate the average bore out-of-round, X. $[X = W - C]$ X must be between -0.012 and 0.012 mm (-0.0005 and 0.0005 in.).
3. Calculate the average connecting rod bearing bore size, Y. $[Y = (W+C) \div 2]$ Y must be between 101.288 and 101.3133 mm (3.988 and 3.989 in.).
4. Determine taper, Z. $[Z = D2 - D1]$ Z must be between -0.012 and 0.012 mm (-0.0005 and 0.0005 in.).
5. Determine the rod length by finding the distance between E1 and E2. See Figure 2.
 - [a] The acceptable rod length specification for the 14-Liter connecting rod is: 269.25 to 269.35 mm (10.6004 to 10.6043 in.).
 - [b] If the connecting rod bore is not to specifications, the rod must be scrapped and cannot be machined.
6. If a new connecting rod is required, stamp the cylinder number on the connecting rod and cap. Refer to section .

ADDITIONAL SERVICE INFORMATION

Additional service information is available in *Power Service Literature*.



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