

# 98-012 Alternative PACCAR Approved Counterbore Tool Availability and new Indicator Block

5/18/2021

[Edit](#) [Clone](#)

98-012

## Section

Tools - 98

## Subject

Alternative PACCAR Approved Counterbore Tool Availability and new Indicator Block

## Date

5/18/2021

## Whats New Abstract

Information Only – A new PACCAR Approved Counterbore cutting tool is available.

## Condition

The Monaco Counterbore tool has been approved for use on PACCAR MX-11/MX-13 engines.

A new indicator block that is compatible with MIRA and Monaco tools is now available. This indicator block (2203483PE) supersedes indicator block 1903047PE.

This bulletin supersedes E219.

## Chassis Affected

Chassis with PACCAR MX-11/MX-13 engines.

## Action

### Information Only

Dealers are required to have a counterbore cutting tool from either MIRA or Monaco.

#### **The counterbore tools have been elevated from Level 3 to Level 1 Required Tool.**

These are the only tools approved for cutting counterbores in PACCAR MX-13 or MX-11 engines.

The [counterbore cutting tool page](#) has been updated with information for both tools.

**An updated indicator block is also available.** To meet the revised SRT time with either tool, the new indicator block is required. The indicator block is a Level 1 Required Tool and is superseding the 1903047PE block.

If you have purchased Monaco Tool p/n 50149, it can likely be upgraded to 2203482PE. Refer to the Tool Upgrade Form in the attachments for instructions.

## Warranty

---

The SRT has been updated based on improved workflow, resulting in a time reduction of 0.6 hours.

The SRT will be updated 6-months from the publishing date of this bulletin (12/01/2021).

The SRT is applicable to either brand tool.

## Parts

---

The following new tools are available from PACCAR Parts.

Quantity	Part Number	Description
1	2203482PE	Monaco tool kit, MX-13
1	1903023PE	Upgrade kit to add MX-11 capability to 2203482PE
1	2203483PE	Dial indicator gauge block

## Background

---

PACCAR has performed extensive investigation of the Monaco counterbore cutting tool and directly compared it to the current MIRA tool. As a result of this work, the counterbore cutting procedure has been extensively modified and updated.

A new indicator block was developed as part of this process. The design of the new indicator block allows depth measurements without tool removal, resulting in a lower SRT.

## Procedure

---

**Please follow your dealership's safety procedures and precautions to ensure the vehicle can be safely repaired and maintained.**

All counterbore cutting tools have been moved to a single tool page.

RMI will be updated with improved procedures for the existing MIRA Counterbore cutting tool and using the Monaco tool. Until that update is published, refer to the Attachment for the latest procedure. The attachment also includes improved calculators.

RMI will be updated to include instructions for using the Monaco Counterbore cutting tool. A training video of the updated process is available via scanning this QR code. The RMI procedure will also provide this QR code.




To support the decreased SRT times, a new indicator block is required (2203483PE). The new design indicator block allows measurements with either counterbore cutting tool without removing the tool from the block.

If you purchased the Monaco tool part number 50149 from Monaco tools, you can work with Monaco tools to update the tool to the current model. The cost of this update, stable for 1-year from publishing date of this bulletin, is \$436. Refer to the upgrade form in the attachments section for instructions to send your tool back for an upgrade.

## Attachments

---

 [Instructions for using Monaco tool. Includes improved calculators.](#) To use this document, download the file and open with Adobe Acrobat. It will not open correctly in a browser.

 [50149 to 2203482PE Upgrade form](#)

# Alternative PACCAR Approved Counterbore Tool Availability and new Indicator Block

5/18/2021

 [Edit](#)  [Clone](#)

98-012

## Section

Tools - 98

## Subject

Alternative PACCAR Approved Counterbore Tool Availability and new Indicator Block

## Date

5/18/2021

## Whats New Abstract

Information Only – A new PACCAR Approved Counterbore cutting tool is available.

## Condition

The Monaco Counterbore tool has been approved for use on PACCAR MX-11/MX-13 engines.

A new indicator block that is compatible with MIRA and Monaco tools is now available. This indicator block (2203483PE) supersedes indicator block 1903047PE.

This bulletin supersedes E219.

## Chassis Affected

Chassis with PACCAR MX-11/MX-13 engines.

## Action

### Information Only

Dealers are required to have a counterbore cutting tool from either MIRA or Monaco.

#### **The counterbore tools have been elevated from Level 3 to Level 1 Required Tool.**

These are the only tools approved for cutting counterbores in PACCAR MX-13 or MX-11 engines.

The [counterbore cutting tool page](#) has been updated with information for both tools.

**An updated indicator block is also available.** To meet the revised SRT time with either tool, the new indicator block is required. The indicator block is a Level 1 Required Tool and is superseding the 1903047PE block.

If you have purchased Monaco Tool p/n 50149, it can likely be upgraded to 2203482PE. Refer to the Tool Upgrade Form in the attachments for instructions.

## Warranty

---

The SRT has been updated based on improved workflow, resulting in a time reduction of 0.6 hours.

The SRT will be updated 6-months from the publishing date of this bulletin (12/01/2021).

The SRT is applicable to either brand tool.

## Parts

---

The following new tools are available from PACCAR Parts.

Quantity	Part Number	Description
1	2203482PE	Monaco tool kit, MX-13
1	1903023PE	Upgrade kit to add MX-11 capability to 2203482PE
1	2203483PE	Dial indicator gauge block

## Background

---

PACCAR has performed extensive investigation of the Monaco counterbore cutting tool and directly compared it to the current MIRA tool. As a result of this work, the counterbore cutting procedure has been extensively modified and updated.

A new indicator block was developed as part of this process. The design of the new indicator block allows depth measurements without tool removal, resulting in a lower SRT.

## Procedure

---

**Please follow your dealership's safety procedures and precautions to ensure the vehicle can be safely repaired and maintained.**

All counterbore cutting tools have been moved to a single tool page.

RMI will be updated with improved procedures for the existing MIRA Counterbore cutting tool and using the Monaco tool. Until that update is published, refer to the Attachment for the latest procedure. The attachment also includes improved calculators.

RMI will be updated to include instructions for using the Monaco Counterbore cutting tool. A training video of the updated process is available via scanning this QR code. The RMI procedure will also provide this QR code.




To support the decreased SRT times, a new indicator block is required (2203483PE). The new design indicator block allows measurements with either counterbore cutting tool without removing the tool from the block.

If you purchased the Monaco tool part number 50149 from Monaco tools, you can work with Monaco tools to update the tool to the current model. The cost of this update, stable for 1-year from publishing date of this bulletin, is \$436. Refer to the upgrade form in the attachments section for instructions to send your tool back for an upgrade.

## Attachments

---

 [Instructions for using Monaco tool. Includes improved calculators.](#) To use this document, download the file and open with Adobe Acrobat. It will not open correctly in a browser.

 [50149 to 2203482PE Upgrade form](#)