

# Instructions for use of

## PM-825 PORTA-MATIC

(ST-1168)

**READ CAREFULLY BEFORE USING THIS MACHINE**

The "PM-825" PORTA-MATIC can be used to salvage a cylinder block which has a damaged or cracked counterbore ledge. The original block liner counterbore ledge is machined out and a repair bushing which forms a new counterbore is installed. The bores can be enlarged and a new bushing installed in about five minutes per bore. This time does not include checking and finish machining the counterbore ledge. Finish cutting the counterbore ledge after rebushing takes about three to five minutes a bore, with the "CBU-900" Counterbore Tool.

The counterbore salvage bushings, Parts No's. 202226 (NH, V-12, 5½ inch bore) and 203873 (V6-200, V8-265, cutting is required except cutting the counterbore ledge to depth. When installed, the bushing counterbore must be cut 0.005 inch to 0.010 inch deeper to meet Cummins specifications.

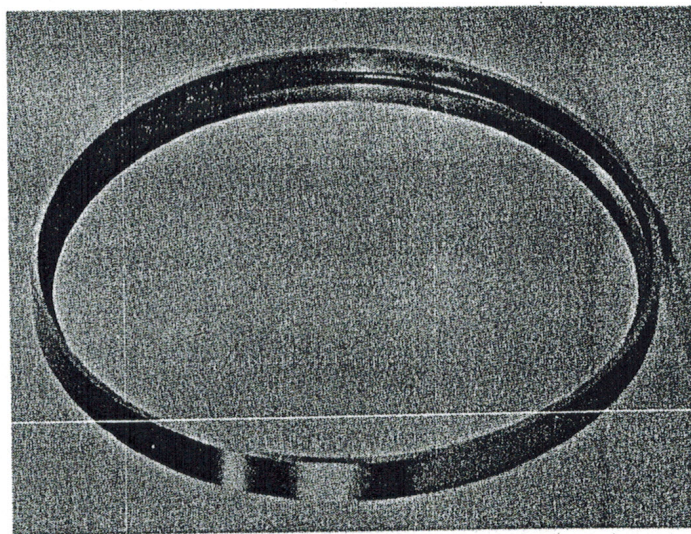


Fig. 1 Repair Bushing

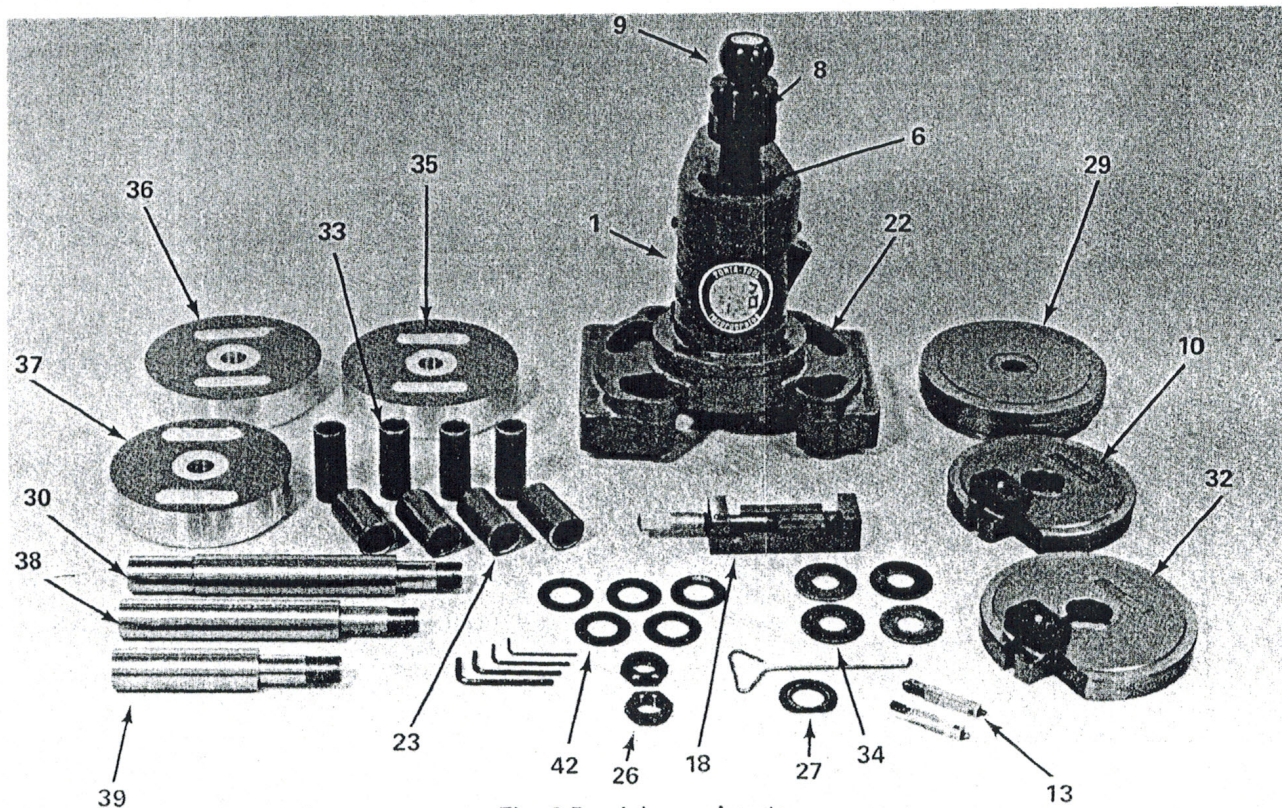


Fig. 2 Breakdown of parts.