



Volvo/Mack CPD Report

Volvo/Mack CPD Report Contents

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Volvo/Mack Test Injector Update

T12 Injectors (736GB419M3)

- Bosch is limiting production to 30 a month



Volvo/Mack Part #27GB525M

“Starship” Oil Filter/Centrifuge Housing Issue

- Mack no longer makes this housing – Obsolete
- Scoured junk yards with minimal luck
 - Latest ones are what we could find used
 - Junkyards are out
- Need to move to another housing



Volvo/Mack T11/T12 Connecting Rod

Part # 367GC4267M

- Purchasing new rods made by Covert Manufacturing
- Seeing a slight offset on the center of big end causing a possible bearing crush issue.



- Rod rejection rate ~25%



Volvo/Mack T11/T12 Piston Crown Process

Part # 240GC5125M

- Currently 250+ new tighter tolerance crowns are being made
- Delivery hopefully in a few weeks
- Forgings are made in Korea
- Shipped by boat to the South Bend, IN
- 100% of the machining done at Federal Mogul Prototype Center in a 4 step process
 - 18 quality measurements are made on every piston
 - Over 100 measurements made on statistical basis to control the process
- Pistons are washed with a slightly acidic solution to clean and etch the surface to help adherence of the phosphate coating
- Pistons are sent to a local South Bend vendor to perform phosphate coating
- Returned, inspected then packaged for shipping



Volvo/Mack T11/T12 Piston Crown

Part # 240GC5125M

Crown, bowl and rough cut of the lands machined



Volvo/Mack T11/T12 Piston Crown

Part # 240GC5125M

Chuck on the bowl and machine ring belt, lands, skirt and under crown



Volvo/Mack T11/T12 Piston Crown

Part # 240GC5125M



Volvo/Mack T11/T12 Piston Crown

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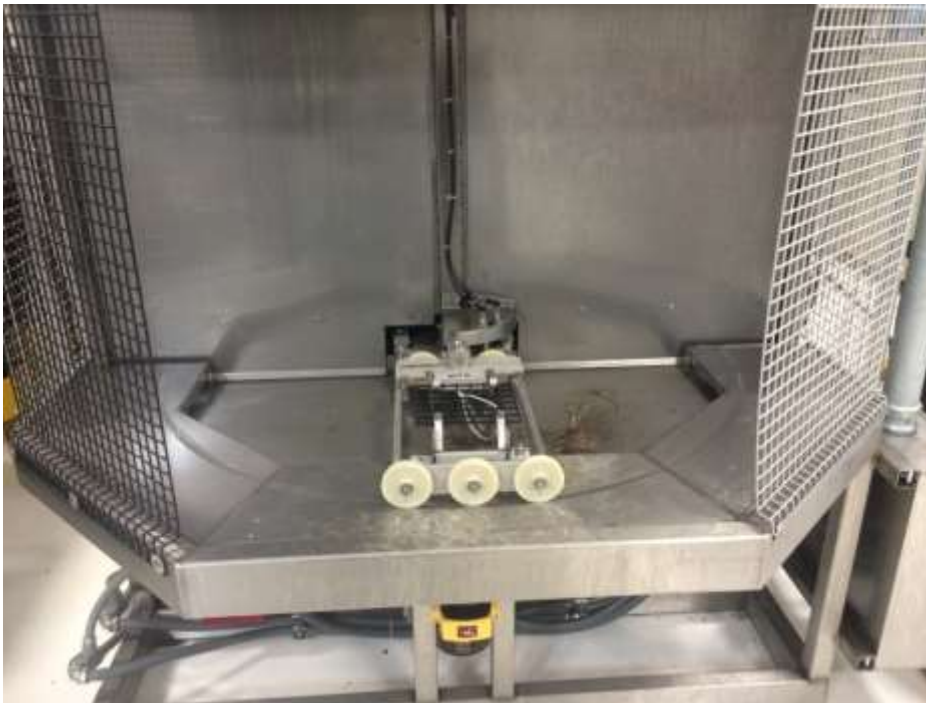
Machine pin bores



Volvo/Mack T11/T12 Piston Crown

Part # 240GC5125M

Machine valve pockets and wash



Volvo/Mack T11/T12 Piston Crown

Part # 240GC5125M

Pistons sent to local company to phosphate, returned, inspected and packaged for shipping



Volvo/Mack T11 Small Turbo Update

- 22 are supposed to be here this week



Volvo/Mack T11/T12 Cylinder Liner Part # 509GC471 (Batch "V")

- Order completed
- 3800 ordered
- 4021 received
- 3449 in stock



Volvo/Mack Kit Parts Inventory

Volvo/Mack Critical Parts Status					
Part Description	Test Type	Part Number	Batch/Date	In Stock	Rejects
Cylinder Liner	T8, T11, T12	509GC471	T	2501	*
			U	0	12
			V	3449	11
Piston Crown	T11, T12	240GC5125M	Apr-12	588	1470
			Mar-14	250*	N/A
Piston Skirt	T11, T12	240GC5119M	Apr-12	1870	656
Piston Assembly (includes crown and skirt)	T8	215SB232A	N/A	6	N/A
Top Ring	T8, T11, T12	349GC3107	T	40	20
			U	2923	65
2nd Ring	T8, T11, T12	349GC3108	S	2415	240
Oil Ring	T8, T11, T12	350GC343	S	2580	10
Piston Pin	T8, T11, T12	182GC2223	Sep-13	1812	15
Snap Ring	T8, T11, T12	97AX127	Sep-13	4907	0
Connecting Rod Bearing (sets)	T8, T11, T12	62GB2396A	X	1748	252
Main Bearing (sets)	T8, T11, T12	57GC387	O	294	35
*New Volvo part number		*25503508	P	600	*
			* Special Circumstances		



Volvo/Mack Miscellaneous Parts Inventory

Test Type	Part Description	Part Number	In Stock
T8	Injection Pump "calibrated"	313GC5212P16X	0
	Injector Nozzle	736GB343P2X	17
T11	EGR Cooler	19GBX52	15
	Injection Nozzle	736GB411M2	87
	Modine Intercooler	5424-03928031	2
	Turbo Small	631GC5145M3	*
T12	EGR Cooler	28GB519	2
	Injection Nozzle	736GB419M3	165
	Modine Intercooler	5424-1A166566D	2
	Turbo Small	631GC5176CM7	0
T11 and T12	Camshaft Kit	57GC2209A	0
	Cylinder Head - Low Swirl	732GB3499M	0
	Electronic Actuator	9MS42	2
	Engine - Bare Block	239GB5551M	0
	Engine - Basic Engine	86SB3536N	0
	Exhaust Manifold Assembly (front and rear)	M10104GC5164M	2
	Fuel Injector Line	HL69-151	88
	Fuel Injector Line	HL69-152	88
	Full Flow Oil Filter	485GB3236	4
	High Temperature Hose	3101632M	856
	Intake Manifold Assembly	M10105GCX4332/5212	1
	Lifter Assembly	72GC373A	0
	Machine Elbow	454GC5236	10
	Oil Cooler End Caps	TEI-T12OCEC	0
	Oil Filter Housing	27GB525M	0
	Oil Pump Assembly - Low Flow - 9-tooth internal gears	315GC465BM	10
	Piston Connecting Rod	367GC4243M2	250
	Short EGR Exhaust Probe	TEGR0005	1
	Turbo Gasket	TEIEX201064AM	102
	Turbo Large	3801847R	0
	Venturi	762GBX433SS	1



Questions ?

