



Volvo/Mack CPD Report

T8/T11/T12/T13

Volvo/Mack CPD Report

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Volvo/Mack T11/T12 Piston Crowns

- Batch “C” piston crowns going into kits after Kit #181987
- Batch “D” piston crowns on order
 - Delay in forgings



Volvo/Mack T11/T12 Main Bearings

- Batch “P” going into kits after Kit #182107
- Reject Rate of ~75%
 - Damaged backs
 - Scratches, nicks



Volvo/Mack T11/T12 Injector Lines

- We have hit a dead end on the manufacture of the “heavy” end injector lines
 - Contacted several suppliers and the current one
 - No one wants to mess with them



Volvo/Mack T11/T12 E7 Blocks

- Reman is down to 53 E7 blocks
 - Want to only sell 7/8 “basic” engines – not blocks



Volvo/Mack T11/T12 Piston Skirts

- Received 1000 piston skirts in March 2015
 - Apparently these were made in one batch
- Reject about 50% for small pits, nicks or scratches
- Need to know what the panel wants TEI to measure on the skirts



Volvo/Mack T12/T13

Stained Rings

- Receiving stained rings in both T12 and T13
- Oronite studied the rings
- Volvo/Mack says rings are “OK to use”



Volvo/Mack T13 Rod Bearing Update

- Still seeing a wide range of rod bearing surface finishes (roughness)
- We are currently screening out the rough ones (~50% rejection rate)
- TEI has 991 “bad” sets and ~900 sets left to inspect out of original order of 3000
- Probably going to have to order another batch soon!



Volvo/Mack T13 Thrust Washers

- Rejecting approximately 50% for nicks, dings or scratches



Volvo/Mack T13 Oil Ring Update

- TEI got some oil rings with a red dot on them instead of a green dot.
- The red dot oil rings are the wrong year model ring and are not to be used.
- We believe we caught all the red dot rings but.....



Volvo/Mack T13

Piston Oil Hole Chamfer

- 2 different piston oil holes



Volvo/Mack Kit Parts Inventory

Volvo/Mack Critical Parts Inventory					
Part Description	Test Type	Part Number	Batch/Date	In Stock	~Reject %
Cylinder Liner	T8, T11, T12	509GC471	V	1703	10%
Piston Crown	T11, T12	240GC5125M	C	240	1%
			D	ordered	n/a
Piston Skirt	T8,T11, T12	240GC5119M	March 2015	275	50%
Piston Assembly	T8	215SB232A	n/a	22	50%
Top Ring	T8, T11, T12	349GC3107	U	946	30%
2nd Ring	T8, T11, T12	349GC3108	S	630	50%
Oil Ring	T8, T11, T12	350GC343	S	960	15%
Connecting Rod Bearing (sets)	T8, T11, T12	*20705743	Y	2904	40%
Main Bearing (sets)	T8, T11, T12	*25503508	P	532	75%
Cylinder Liner	T13	21334768	A	1213	1%
Piston	T13	**21330684	n/a	111	1%
Top Ring	T13	**21330684	n/a	110	40%
2nd Ring	T13	**21330684	n/a	110	50%
Oil Ring	T13	**21330684	n/a	110	20%
Connecting Rod Bearing (sets)	T13	**20580558	April 2015	1255	50%
Main Bearing (sets)	T13	**20530916	n/a	206	15%
* New Volvo part number					
** Comes as a set					



Volvo/Mack Miscellaneous Parts Inventory

TEI Mack Miscellaneous Parts Inventory			
Test Type	Part Description	Part Number	In Stock
T8	Injection Pump "calibrated"	313GC5212P16X	2
	Injector Nozzle	736GB343P2X	18
T11	EGR Cooler	19GBX52	18
	Injection Nozzle	736GB411M2	34
	Modine Intercooler	5424-03928031	2
	Turbo Small	631GC5145M3	12
T12	EGR Cooler	28GB519	0
	Injection Nozzle	736GB419M3	108
	Modine Intercooler	5424-1A166566D	4
	Turbo Small	631GC5176CM7	0
T11 and T12	Camshaft Kit	57GC2209A	0
	Cylinder Head - Low Swirl	732GB3499M	0
	Electronic Actuator	9MS42	1
	Engine - Bare Block	239GB5551M	0
	Engine - Basic Engine	86SB3536N	1/1
	Exhaust Manifold Assembly (front and rear)	M10104GC5164M	6
	Fuel Injector Line	HL69-151	93
	Fuel Injector Line	HL69-152	92
	Full Flow Oil Filter	485GB3236	4
	High Temperature Hose	3101632M	589
	Intake Manifold Assembly	M10105GCX4332/5212	0
	Lifter Assembly	72GC373A	0
	Machine Elbow	454GC5236	16
	Oil Cooler End Caps	TEI-T12OCEC	0
	Oil Filter Housing	27GB528M2	4
	Oil Pump Assembly - Low Flow - 9-tooth internal gears	315GC465BM	15
	Piston Connecting Rod	367GC4243M2	151
	Short EGR Exhaust Probe	TEGR0005	29
	Turbo Gasket	TEIEX201064AM	80
	Turbo Large	3801847R	0
Venturi	762GBX433SS	1	



Questions ?

