



No.: 04 TS - 33  
June 18, 2004

TO: All Distributors and Dealers - Worldwide  
ATTN.: Service Manager  
FROM: Bob Babridge  
SUBJECT: **Series 60 Main Bearings and Thrust Washers**

Several changes have been made to the main bearings for Series 60 engines. Production began in the mid-1980's with a four-piece thrust washer system. It was later changed to a two-piece thrust washer system for most of the engines built, and has returned to a four-piece thrust washer system in recent production. During the 2004 production year machining changes to the cylinder block and the main bearing caps were introduced. Only the current style thrust bearings will fit with any block prior to the machining change, while both the current style and the new style thrust bearings will fit with any block after the machining change.

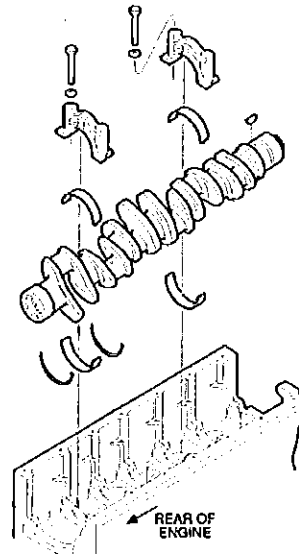
### Two thrust washers:

Engines built prior to 06R0718942  
6 - 8929670 Main Bearing Kit  
1 - 8929680 Main Bearing Thrust Kit  
2 - 8929085 Thrust Washers

New kits available in July 2004:

23535012 Thrust Kit  
Includes one upper main & one lower main for the #6 position, and two thrust washers.

23535013 Lower End Bearing Kit  
Includes six each upper & lower mains, one each upper & lower mains for the #6 position, and two thrust washers.



### Four thrust washers:

Engines built after 06R0718942 and before 06R0762048

6 - 8929670 Main Bearing Kit

1 - 8929680 Main Bearing Thrust Kit

2 - 8929085 Thrust Washers

1 - 23524154 Lower Thrust Kit -

Note: Discard lower shell from 8929680 and replace with the lower shell in 23524154. Use a total of 4-8929085 washers, 2 already come in kit 23524154.

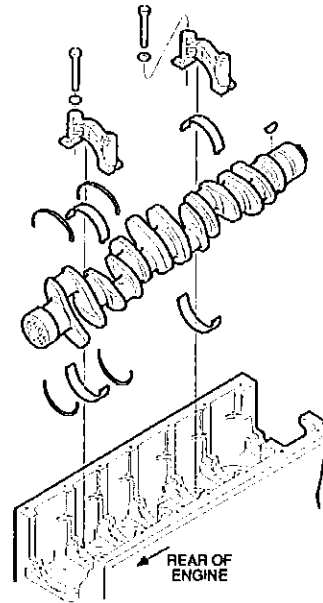
New kits available in July 2004:

23535010 Thrust Kit

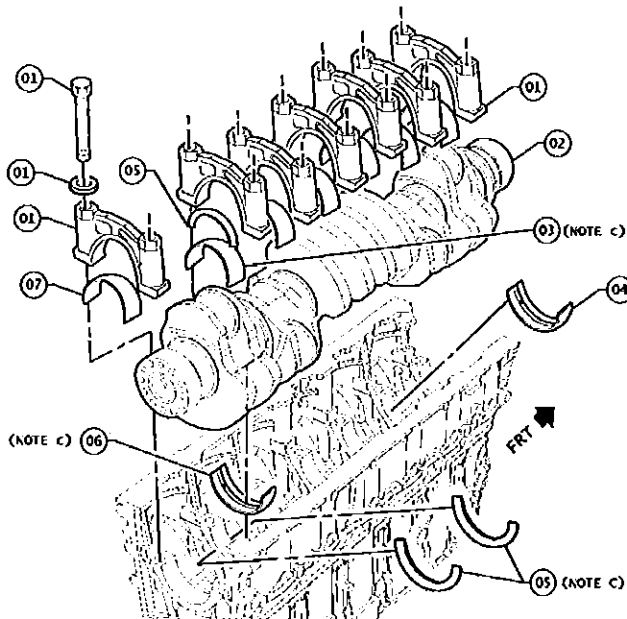
Includes one upper main & one lower main for the #6 position, and four thrust washers.

23535011 Lower End Bearing Kit

Includes six each upper & lower mains, one each upper & lower mains for the #6 position, and four thrust washers.



### Individual Part Numbers:



PART NUMBER	DESCRIPTION	QTY.
01	(REF FROM 06C01B)	
02	(REF FROM 06C01)	
03	23532926 SHELL THR	01
04	23532927 MAIN SHELL	06
05	08929085 THR WASHER	04
06	23532928 SHELL THR	01
07	23532925 LWR SHELL	06

NOTE

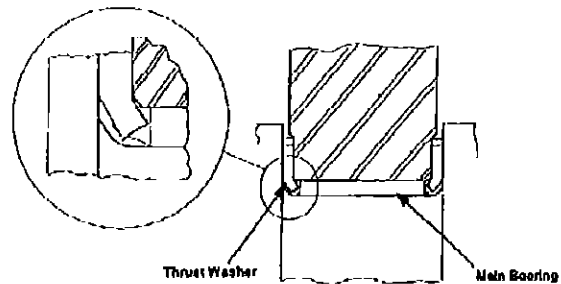
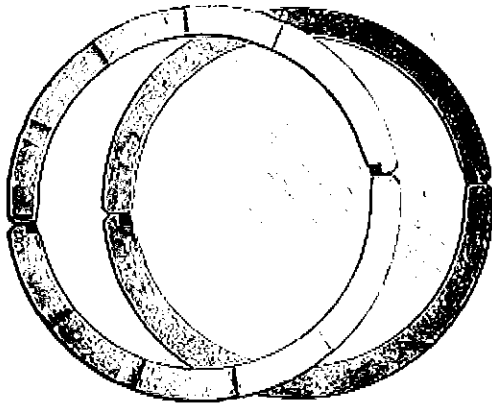
(c) INSTALL AT NO. 6 POSITION

### New Four Thrust Washers:

Engines built after 06R0762048 will accommodate the new style thrust washer as well as the current style version. Do not mix the style of thrust washer in the same engine. The new style thrust washers are marked for front and rear and are designed to directionally rotate into the upper position with the main bearing cap removed. The #6 position main bearings are the same as the other position.

23533691 Lower End Bearing Kit

Note: This kit includes seven upper main bearing, seven lower main bearing, and four thrust washers that are two front and two rear.



Block S/N Change 06R0727730



Cap S/N Change 06R0762048

Bob Babridge  
Manager Quality Support