



**No.: 20TS-01**  
January 13, 2020

TO: Service Locations

FROM: Detroit Reman

SUBJECT: **Series 60 Cylinder Head Resurfacing/Finish**

### **ISSUE**

Detroit Diesel does not recommend third party resurfacing of Series 60 cylinder heads (outside of Detroit and Detroit Reman). Due to the complex nature of the milling operation, third party resurfacing may lead to a surface finish that does not meet Detroit Diesel requirements.

### **CAUSE**

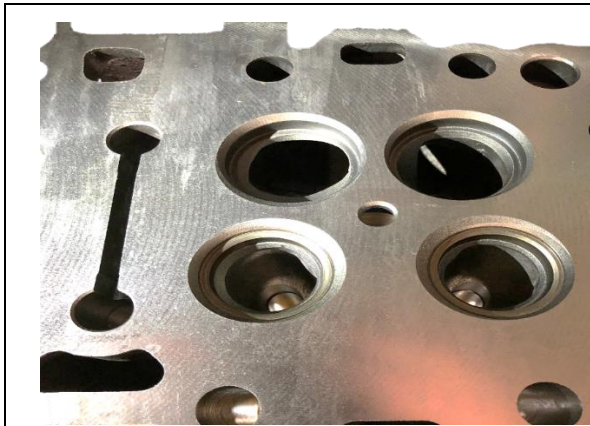
In its free state, the Series 60 cylinder head is not flat. Before performing head milling, special handling and fixtures are required to guarantee the “trueness” of the head surface. In addition, to ensure proper compression sealing, the surface finish must be controlled so that the surface is neither too rough nor too smooth.

### **NOTICE:**

Reusing a warped or improperly finished cylinder head may result in seal leakage. The subsequent loss, dilution, or contamination of engine fluids can cause severe engine damage.

Due to the variables involved in head milling and inconsistencies in the flatness and surface finish of third party milled heads, Detroit Diesel does not recommend resurfacing the Series 60 engine cylinder heads. Refer to section “Cylinder Head” in the applicable Series 60 Engine Service Manual (EPA98/04 Series 60 Workshop Manual (DDC-SVC-MAN-0004) or EPA07 Series 60 Workshop Manual (DDC-SVC-MAN-0005)) for cylinder head replacement.

The second intent of this document is to show the differences in Reman Series 60 cylinder head surface finishes. The Reman Series 60 head has either a standard machined fire deck, or a sprayed and machined fire deck. Both fire decks are acceptable.



**Figure 1 - Head Machined Only**



**Figure 2 - Sprayed and Machined**

#### **CONTACT INFORMATION**

Please contact the Detroit Diesel Customer Support Center at 800-445-1980 or email [csc@daimler.com](mailto:csc@daimler.com) if you have any questions.