



Flywheel Machining Dimensions for 2008-2016 Detroit Diesel DD15 Series Engines

The AERA Technical Committee offers the following information on machining dimensions for Detroit Diesel DD15 Series engines. This information should be considered anytime flywheel removal has occurred.

Before beginning any machining work on the flywheel, check it to see if machining is even possible. If the scores or cracks are deeper than .040" (1.00 MM), replace the flywheel. If the width of the flywheel between the friction surface and the mounting flange is less than 2.690" (68.500 MM), replace the flywheel.

NOTE: Maintain all original radii during the machining process.

1. Machine the flywheel friction surface, if required, to the specifications listed within the table below while referencing the Figure 1.

Table 1.

Flywheel Specifications				
Description	Manual Transmission Flywheel Measurement Specifications		DT12 Flywheel Measurement Specifications	
	Millimeters	Inches	Millimeters	Inches
1 - Flywheel Shoulder Diameter (for ring gear mounting)	432.49 to 432.645 mm	17.0271 to 17.0333 in.	432.49 to 432.645 mm	17.0271 to 17.0333 in.
2 - Flywheel Diameter for Mounting Clutch	435.82 to 435.883 mm	17.1583 to 17.1607 in.	475.0 to 475.063 mm	18.7007 to 18.7032 in.
3 - Flywheel Width between Friction Surface and Mounting Flange New	69.2 mm	2.72 in	69.2 mm	2.72 in.
4 - Flywheel Minimum Width Between Friction Surface and Mounting Flange After Machining	68 mm	2.67 in.	68.5mm	2.69 in.
Flywheel Permissible Deviation From True (radial and lateral)	0.2 mm	.008 in	.01mm	.004 in.

2. **NOTE:** After machining, the friction surface must not have any cavities or chatter marks.
3. The surface finish (peak-to-valley height) after machining should be .0006" (.016 MM). A rougher surface finish will cause rapid clutch lining wear, while a smoother finish could cause difficulties in clutch disengagement.

4. Check the radial and lateral deviation from true of the flywheel. The deviation from true must not exceed .008" (.200 MM).

