

Product: TRACK-TYPE TRACTOR

Model: D5B TRACK-TYPE TRACTOR 46X

Configuration: D5B LGP TRACTOR / POWER SHIFT / 46X00001-00723 (MACHINE) POWERED BY 3306 ENGINE

## Disassembly and Assembly 3304B and 3306B Engines for Caterpillar Built Machines

Media Number -SEN5598-09

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i02107019

# Gear Group (Front) - Install

SMCS - 1206-012

## Installation Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	1P-0510	Driver Group	1
B	9S-3263	Thread Lock Compound	1

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### NOTICE

**Keep all parts clean from contaminants.**

**Contaminants may cause rapid wear and shortened component life.**

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**Note:** Check the condition of the gaskets and the O-ring seals. If the gaskets or the O-ring seals are worn or damaged, use new parts for replacement.

1. Clean the old gasket from the contact surfaces of the timing gear plate and the cylinder block. Install a new gasket on the cylinder block. Cut the gasket even with the bottom face of the cylinder block.
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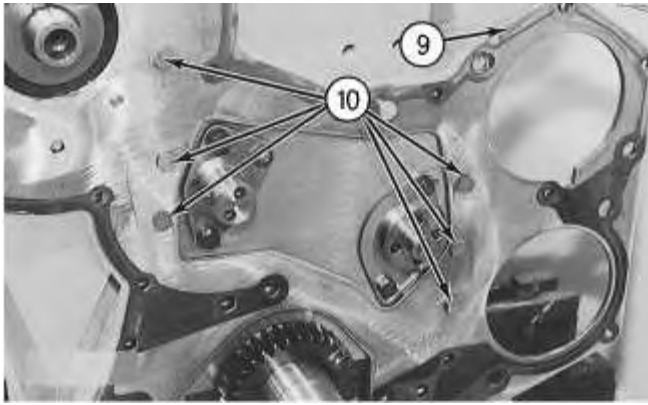


Illustration 1

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## NOTICE

**The bolts that hold the timing gear plate in position on the cylinder block should have a reduced bolt head thickness. The reduced bolt head thickness is needed for clearance for the gears.**

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2. Ensure that the O-ring seals are in position on the end of the fuel injection pump housing. Put timing gear plate (9) in position on the cylinder block. Install bolts (10) .

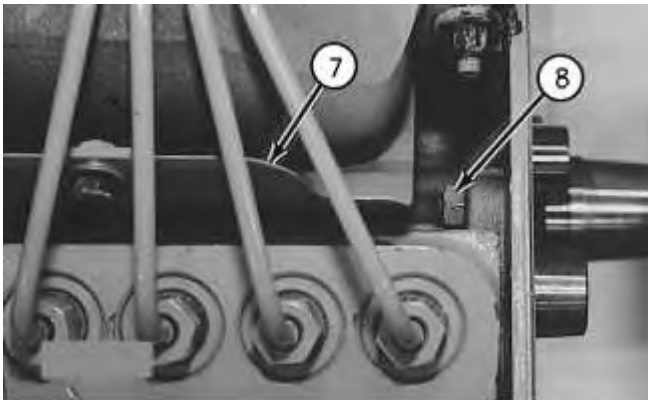


Illustration 2

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3. Install shield (7). Install nuts (8) .

**Note:** After the timing gear plate is installed, ensure that the rack is free to move in the fuel injection pump housing. The O-ring seal on the drive end of the fuel injection pump housing can hold the rack. This can help prevent free rack movement. Rack movement can be seen through a hole in the timing gear plate just above the mounting of the fuel pump gear. If the rack does not move freely, remove the timing gear plate and check the O-ring seal on the drive end of the fuel injection pump housing.

## WARNING

If the rack does not move freely, the engine can over speed and be damaged. Serious personal injury may result.

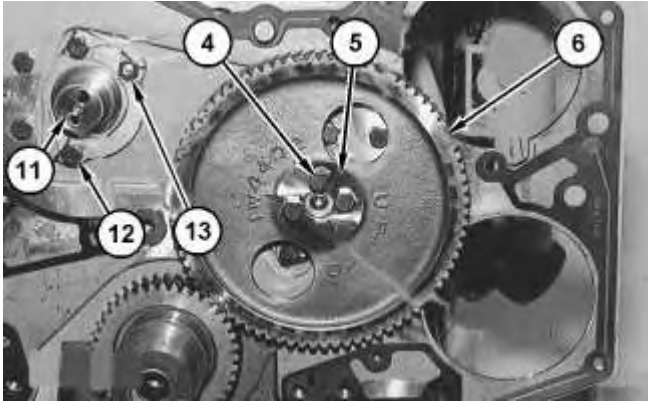


Illustration 3

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**Note:** If idler gear shaft (11) for the fuel pump idler gear was removed, use Tooling (B) on the threads of bolts (12) and nut (13) before reinstalling idler gear shaft (11). Tighten bolts (12) and nut (13) to a torque of  $50 \pm 10$  N·m ( $37 \pm 7$  lb ft).

- Put camshaft gear (6) and plate (5) in position on the engine. Align the Mark "C" on the camshaft gear with the Mark "C" on the crankshaft gear. Install bolts (4) and tighten bolts (4) to a torque of  $55 \pm 7$  N·m ( $41 \pm 5$  lb ft).

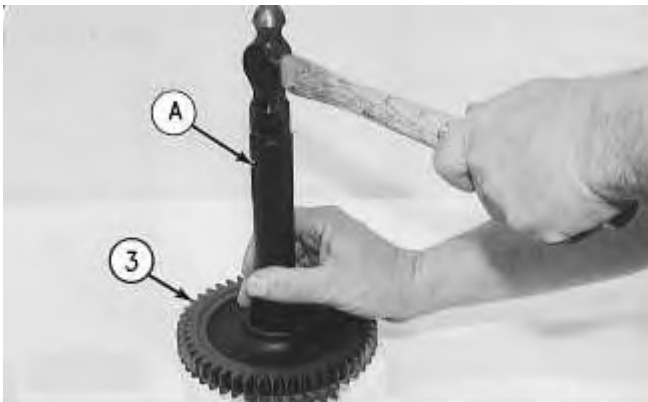


Illustration 4

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- Use Tooling (A) in order to install the bearing in fuel pump idler gear (3). The end of the bearing must be  $3.00 \pm 0.25$  mm ( $.118 \pm .010$  inch) below the face of the hub of the fuel pump idler gear.

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