



# Service Repair Manual

## **Models**

Caterpillar Cat 12G  
Motor Grader

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Product: MOTOR GRADER  
Model: 12G MOTOR GRADER 61M  
Configuration: 12G MOTOR GRADER 61M00001-02628 (MACHINE)

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

Media Number -SEN5598-09

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i01045029

# Spacer Plate - Remove and Install

SMCS - 1221-010

## Removal Procedure

### Start By:

- A. Remove the cylinder head. Refer to Disassembly and Assembly, "Cylinder Head - Remove".

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### NOTICE

**Keep all parts clean from contaminants.**

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

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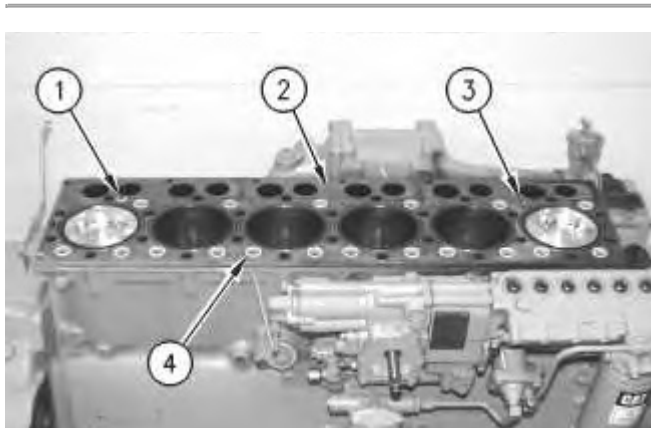


Illustration 1

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1. Remove O-ring seal (1), water seals (3) and water directors (4) from spacer plate (2) .

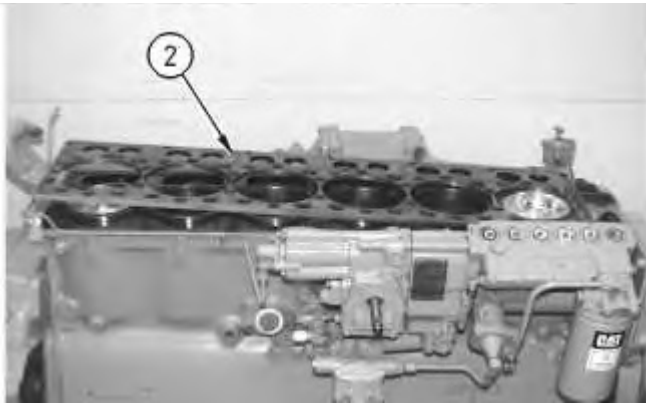


Illustration 2

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## NOTICE

**Do not damage the dowels as the spacer plate is removed.**

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2. Remove spacer plate (2) from the cylinder head.

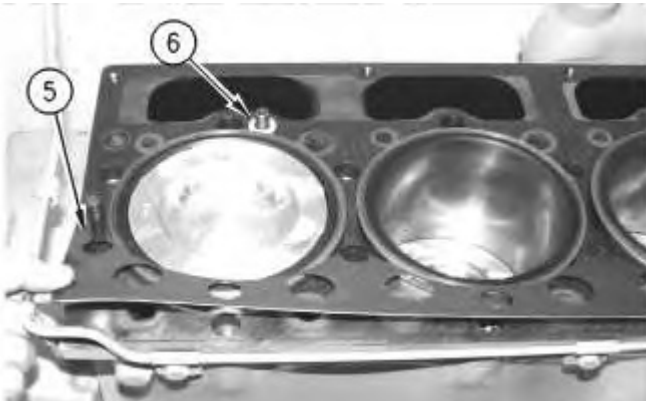


Illustration 3

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3. Remove O-ring seal (6) and spacer plate gasket (5) from the cylinder head.

## Installation Procedure

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## NOTICE

**Keep all parts clean from contaminants.**

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

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1. Thoroughly clean the mating surfaces between the spacer plate and the cylinder block.

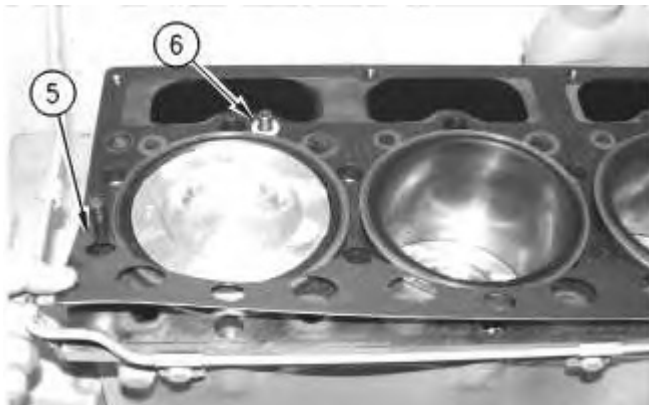


Illustration 4

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2. Install new spacer plate gasket (5) and new O-ring seal (6) .

**Note:** If the dowels in the cylinder block have been removed for any reason, the overall height of the installation is  $16.0 \pm 5.0$  mm ( $.63 \pm .20$  inch).

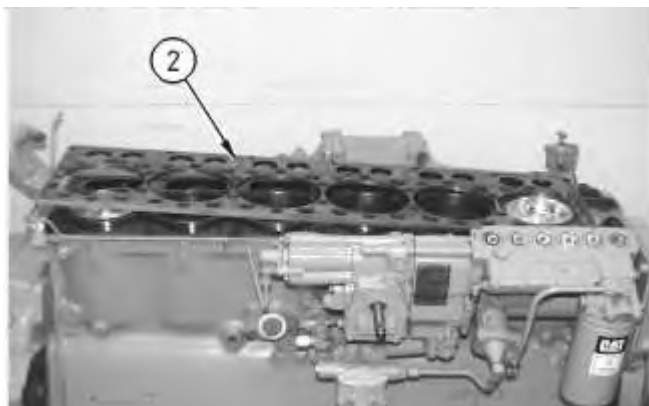


Illustration 5

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**Note:** Both surfaces of the spacer plate, spacer plate gasket and the top of the cylinder block must be clean and dry. Do not use any gasket adhesive or other substances on these surfaces.

3. Install spacer plate (2) on the cylinder head.

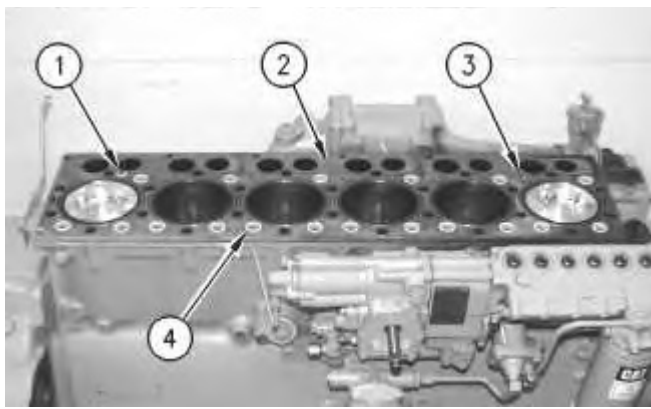


Illustration 6

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4. Install a new O-ring seal (1). Install new water seals (3). Install new water directors (4) .
5. Check the cylinder liner projection. Refer to Disassembly and Assembly, "Cylinder Liner - Install".

**End By:** Install the cylinder head. Refer to Disassembly and Assembly, "Cylinder Head - Install".

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