



Service Repair Manual

Models

323D L Excavator

Product: EXCAVATOR

Model: 323D L EXCAVATOR JLG

Configuration: 323D L Excavator JLG00001-UP (MACHINE) POWERED BY C6.4 Engine

Disassembly and Assembly C6.4 Engine for Caterpillar Built Machines

Media Number -KENR8106-09

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i04625001

Inlet and Exhaust Valve Seat Inserts - Remove and Install

SMCS - 1103-010

Removal Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	166-7441	Valve Seat Extractor Tool	1
	6V-4194	Valve Seat Extractor ⁽¹⁾	1
	6V-4196	Valve Seat Extractor ⁽¹⁾	1
B	138-7573	Link Bracket	4
C	1U-9200	Lever Puller Hoist	1
D	8S-6691	Cylinder Head Repair Stand	1

⁽¹⁾ Component of the Valve Seat Extractor Tool Group.

Start By:

- A. Remove the inlet and exhaust valves. Refer to Disassembly and Assembly, "Inlet and Exhaust Valves - Remove and Install".
- B. Remove the electronic unit injectors. Refer to Disassembly and Assembly, "Electronic Unit Injectors - Remove".

NOTICE

Keep all parts clean from contaminants.

Contaminants may cause rapid wear and shortened component life.

Note: Refer to Special Instructions, SMHS7953-00, "Use of Valve Seat Insert Puller Group" to aid with the removal of the inlet and exhaust valve seats.

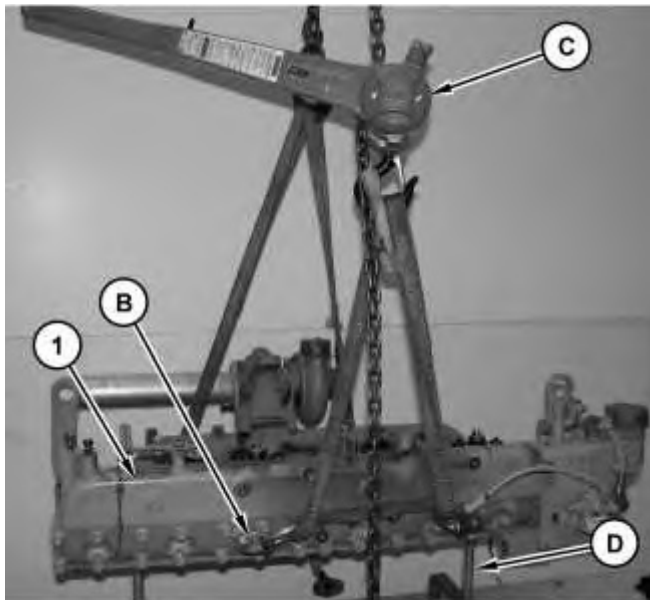
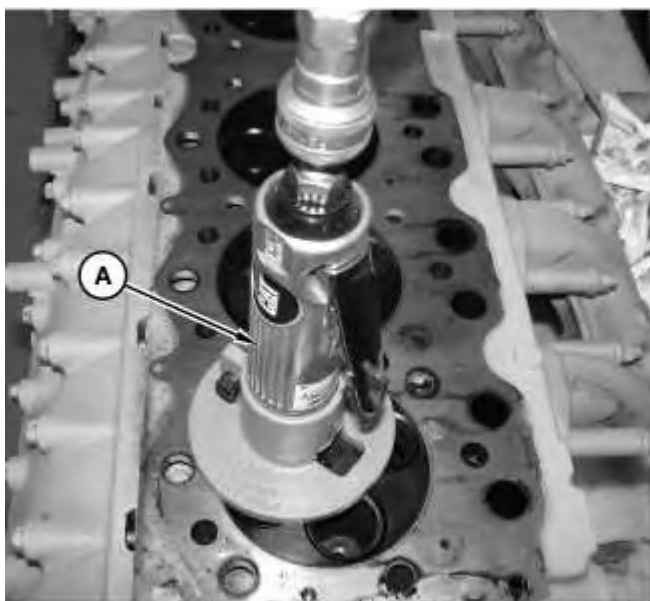


Illustration 1

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1. Attach Tooling (B) , Tooling (C) , and a suitable lifting device to cylinder head (1) . Use Tooling (B) , Tooling (C) , and the suitable lifting device in order to turn over cylinder head (1) by 180° onto Tooling (D) .



2. Use the valve seat grinder of Tooling (A) in order to notch the valve seat.

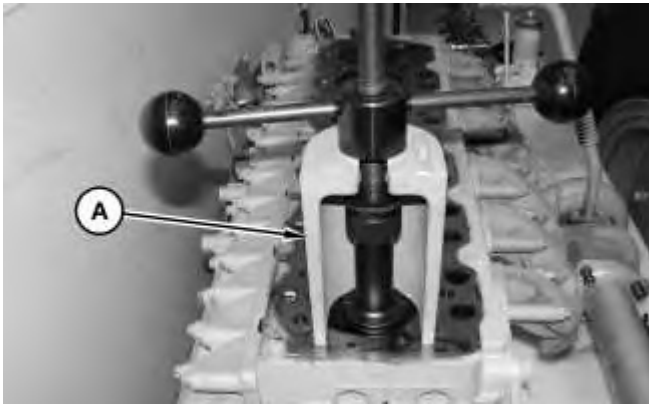


Illustration 3

3. Use the valve seat extractor of Tooling (A) to remove the inlet and exhaust valve seats.
4. Clean the valve seat in the cylinder head. Remove any rough areas from the valve seat in the cylinder head.
5. Repeat Steps 2 through 4 for the remaining inlet valve seat inserts and exhaust valve seat inserts.

Installation Procedure

Table 2

Required Tools			
Tool	Part Number	Part Description	Qty
E	384-8859	Valve Seat Installer	1
F	384-8860	Valve Seat Installer	1

NOTICE

Keep all parts clean from contaminants.

Contaminants may cause rapid wear and shortened component life.

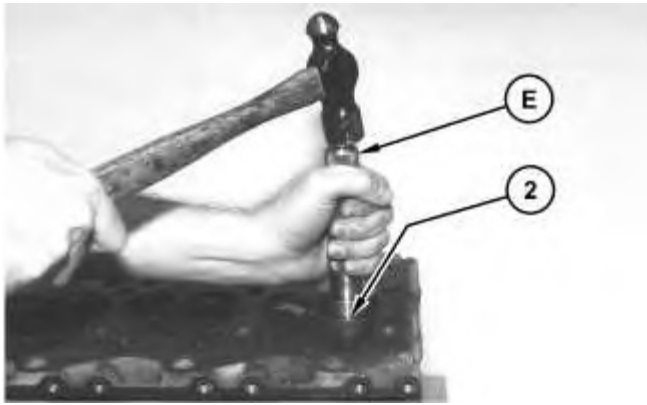


Illustration 4

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Typical Example

1. Lower the temperature of the new inlet valve seat inserts (2) . Use Tooling (E) in order to install a new inlet valve seat insert (2) (not shown) in the cylinder head.

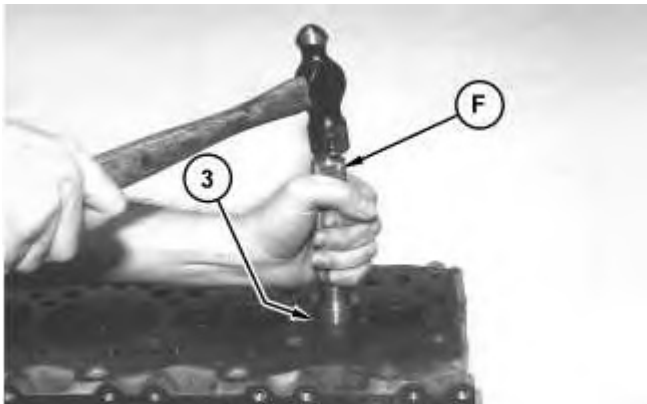


Illustration 5

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Typical Example

2. Lower the temperature of new exhaust valve seat inserts (3) . Use Tooling (E) and Tooling (F) in order to install the new exhaust valve seat insert (3) (not shown) in the cylinder head.

Note: The temperature of exhaust valve seat insert (3) is lowered in order to ease the installation of exhaust valve seat insert (3) .

3. Repeat Step 1 and 2 for the remaining inlet valve seat inserts and exhaust valve seat inserts.

End By:

- a. Install the inlet and exhaust valves. Refer to Disassembly and Assembly, "Inlet and Exhaust Valves - Remove and Install".
- b. Install the electronic unit injectors. Refer to Disassembly and Assembly, "Electronic Unit Injectors - Install".

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