CATERPILLAR®

Service Repair Manual

Models

323D L Excavator

Product: EXCAVATOR
Model: 323D L EXCAVATOR NDE
Configuration: 323D L Excavator NDE00001-UP (MACHINE) POWERED BY C6.4 Engine

Disassembly and Assembly
C6.4 Engine for Caterpillar Built Machines
Media Number -KENR8106-09 **Publication Date -01/10/2017** **Date Updated -18/10/2017**

i02746816

Rocker Shaft - Assemble

SMCS - 1102-016

Assembly Procedure

Table 1

Required Tools			
Tool	**Part Number**	**Part Description**	**Qty**
A	1P-1859	Retaining Ring Pliers	1
B	1P-0510	Driver Gp	1

NOTICE

Keep all parts clean from contaminants.

Contaminants may cause rapid wear and shortened component life.

Note: Cleanliness is an important factor. Before assembly, thoroughly clean all parts in cleaning fluid. Allow the parts to air dry. Do not use wiping cloths or rags to dry parts. Lint may be deposited on the parts which may cause trouble. Inspect all parts. If any parts are worn or damaged, use new parts for replacement. Dirt and other contaminants can damage the precision component. Perform assembly procedures on a clean work surface. Keep components covered and protected at all times.

Illustration 1 g01375874

1. If necessary, Use Tooling (B) in order to install bushing (10) into arm assemblies (4) and (3).

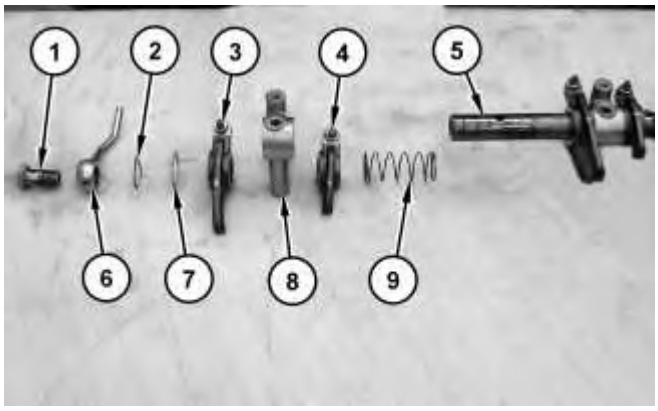

Illustration 2 g01375734

WARNING

Improper assembly of parts that are spring loaded can cause bodily injury.

To prevent possible injury, follow the established assembly procedure and wear protective equipment.

2. Install spring (9) onto shaft assembly (5).
3. Install arm assembly (4) onto shaft assembly (5).
4. Install bracket (8) onto shaft assembly (5).
5. Install arm assembly (3) onto shaft assembly (5).
6. Install washer (7) onto shaft assembly (5).

7. Use Tooling (A) in order to install retaining ring (2) onto shaft assembly (5).
8. Repeat Steps 1 through 7 for the remaining rocker shaft assembly.
9. Install pipe (6) onto shaft assembly (5).
10. Install bolt (1). Tighten bolts (1) to a torque of 74 ± 5 N·m (55 ± 4 lb ft).

End By:

a. Install the rocker shaft and the pushrods. Refer to Disassembly and Assembly, "Rocker Shaft and Pushrods - Install".

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i02746971

Rocker Shaft and Pushrod - Install

SMCS - 1102-012; 1208-012

Installation Procedure

NOTICE

Keep all parts clean from contaminants.

Contaminants may cause rapid wear and shortened component life.

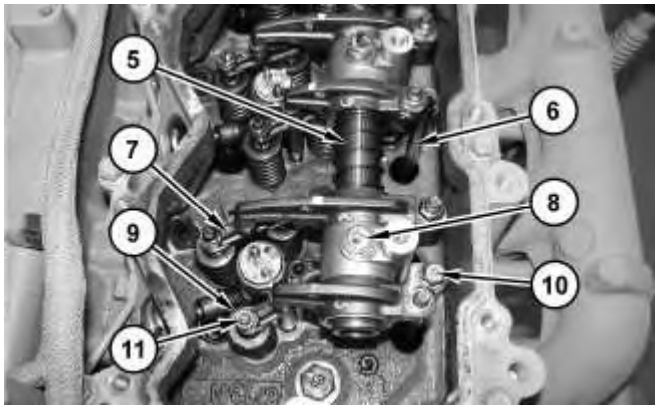

Illustration 1 g01375847

1. Install bridges (7) and the caps.
2. Install pushrods (6).
3. Position rocker shaft assembly (5).

4. Position bolts (8). **Do not tighten bolts (8) at this time.**
5. Position bolts (10). **Do not tighten bolts (10) at this time.**
6. Tighten bolts (8) to a torque of 18 ± 2 N·m (13 ± 1 lb ft).
7. Tighten bolts (10) to a torque of 18 ± 2 N·m (13 ± 1 lb ft).
8. Adjust adjusting screw (11) so that bridge (7) contacts both of the valve ends evenly. Tighten nut (9) to a torque of 4 ± 1 N·m (35 ± 9 lb in).
9. Repeat Step 8 for the remaining rocker arms.

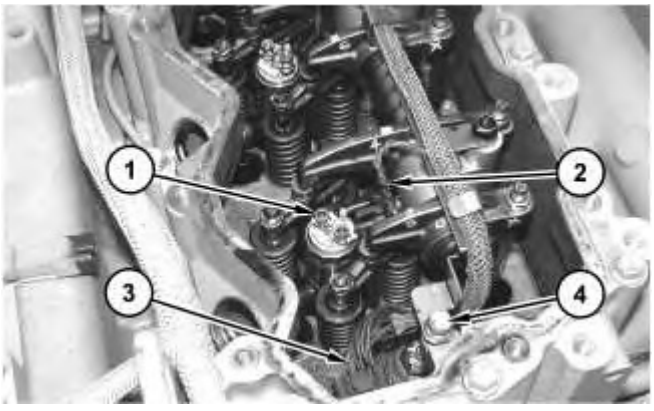

Illustration 2 g01375828

10. Position harness assembly (3) and install bolts (4).
11. Connect harness assembly (3).
12. Connect harness assembly (2) and tighten nuts (1).
13. Repeat Step 12 for the remaining electronic unit injectors.
14. Adjust the inlet valve lash to 0.250 mm (0.0098 inch). Adjust the exhaust valve lash to 0.400 mm (0.0157 inch). Refer to Testing and Adjusting, "Engine Valve Lash - Test/Adjust".

End By:

a. Install the valve mechanism cover. Refer to Disassembly and Assembly, "Valve Mechanism Cover - Remove and Install".

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i02746505

Cylinder Head - Remove

SMCS - 1100-011

Removal Procedure

Start By:

a. Remove the valve mechanism cover base. Refer to Disassembly and Assembly, "Valve Mechanism Cover Base - Remove and Install".

b. Remove the rocker shaft and pushrods. Refer to Disassembly and Assembly, "Rocker Shaft and Pushrods - Remove".

c. Remove the electronic unit injectors. Refer to Disassembly and Assembly, "Electronic Unit Injector - Remove".

d. If necessary, remove the exhaust manifold. Refer to Disassembly and Assembly, "Exhaust Manifold - Remove and Install".

e. If necessary, remove the inlet manifold. Refer to Disassembly and Assembly, "Inlet Manifold - Remove and Install".

f. If necessary, remove the water temperature regulator. Refer to Disassembly and Assembly, "Water Temperature Regulator - Remove and Install".

NOTICE

Keep all parts clean from contaminants.

Contaminants may cause rapid wear and shortened component life.

NOTICE

Care must be taken to ensure that fluids are contained during performance of inspection, maintenance, testing, adjusting, and repair

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