



Service Repair Manual

Models

323D LN and 323D S Excavator

Product: EXCAVATOR

Model: 323D LN EXCAVATOR RAC

Configuration: 323D LN & 323D S Excavators RAC00001-UP (MACHINE) POWERED BY C6.4 Engine

Disassembly and Assembly C6.4 Engine for Caterpillar Built Machines

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Inlet and Exhaust Valve Guides - Remove and Install

SMCS - 1104-010

Removal Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	384-8861	Valve Guide Remover	1
B	138-7573	Link Bracket	4
C	1U-9200	Lever Puller Hoist	1
D	8S-6691	Cylinder Head Repair Stand	1

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 Injector - Remove".

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 of the product. Be prepared to collect the fluid with suitable containers before opening any compartment or disassembling any component containing fluids.

Refer to Special Publication, NENG2500, "Dealer Service Tool Catalog" for tools and supplies suitable to collect and contain fluids on Cat products.

Dispose of all fluids according to local regulations and mandates.

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.

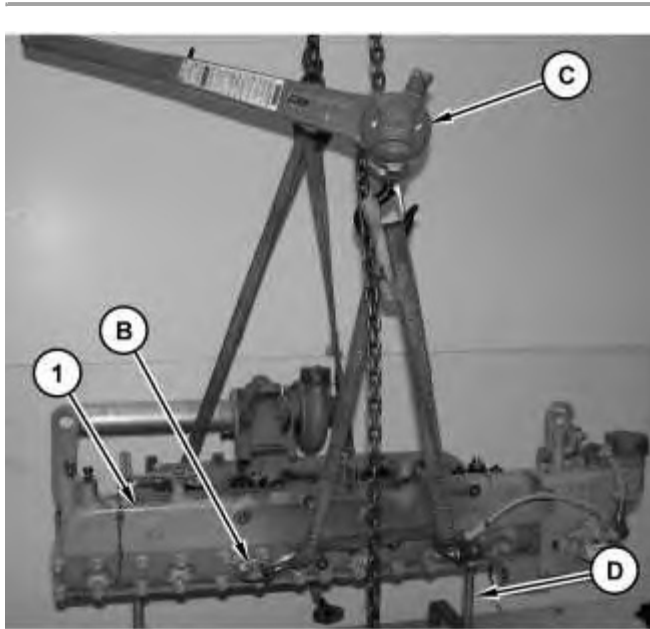


Illustration 1

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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) .
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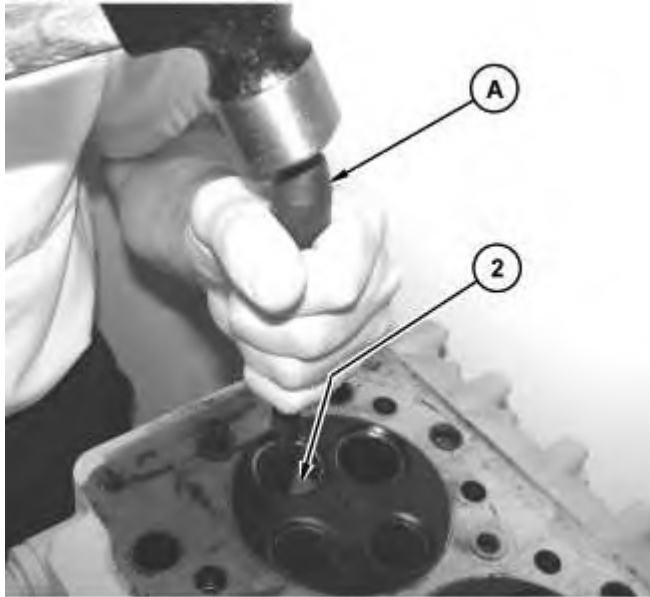


Illustration 2

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2. Use Tooling (A) in order to remove valve guides (2) (not shown).

Installation Procedure

Table 2

Required Tools			
Tool	Part Number	Part Description	Qty
E	384-8862	Valve Guide Installer	1

NOTICE

Keep all parts clean from contaminants.

Contaminants may cause rapid wear and shortened component life.

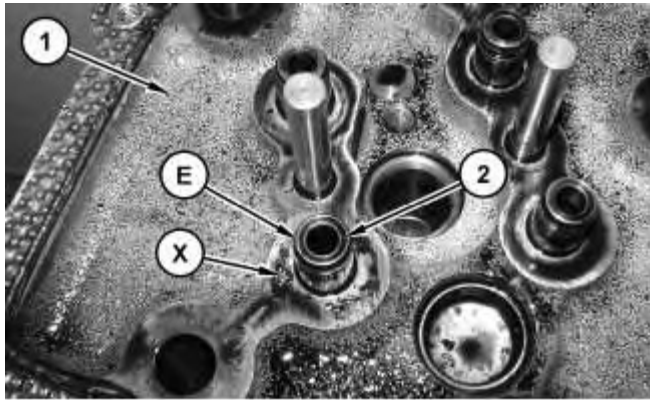


Illustration 3

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1. Lubricate the outside of valve guides (2) (not shown) with clean engine oil.
2. Use Tooling (E) in order to install new valve guides (2) . Install valve guide (2) so that valve guide (2) protrudes 16.000 mm (0.6299 inch) above Surface (X) of cylinder head (1) .

End By:

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

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