

Product: WHEEL TRACTOR

Model: 621E WHEEL TRACTOR 6AB

Configuration: 621E TRACTOR-SCRAPER / POWER SHIFT / 6AB00001-01427 (MACHINE) POWERED BY 3406 ENGINE

Disassembly and Assembly 3406C DIESEL ENGINES FOR CATERPILLAR BUILT MACHINES

Media Number -SEN6409-02

Publication Date -01/07/2006

Date Updated -19/05/2015

SEN64090027

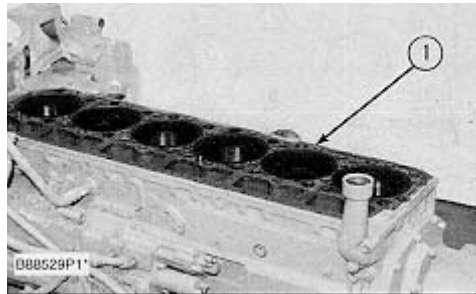
Spacer Plate

SMCS - 1221-011; 1221-012

Remove Spacer Plate

Start By:

- a. remove cylinder head assembly



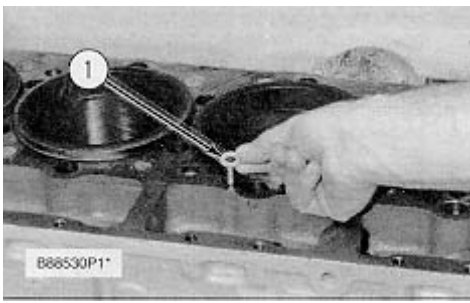
1. Remove spacer plate (1) from the cylinder block.

NOTICE

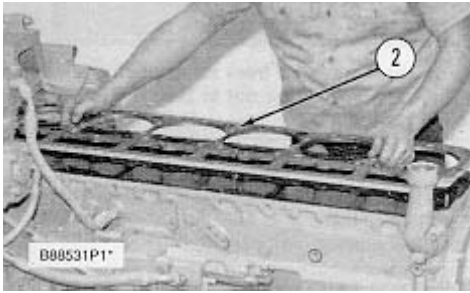
Do not cause damage to the dowels.

2. Remove the spacer plate gasket and two O-ring seals.

Install Spacer Plate



1. Thoroughly clean the spacer plate and cylinder block surface. Install two O-ring seals (1) in the cylinder block.



NOTICE

Both surfaces of the spacer plate, top of cylinder block and both sides of the spacer plate gasket must be clean and dry. Gasket adhesives or other substances must not be used on these surfaces.

2. Install a new gasket between the spacer plate and cylinder block. Put spacer plate (2) in position on the cylinder block.

3. Check cylinder liner projection. See topic, "Install Cylinder Liners".

End By:

a. install cylinder head assembly

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SEN64090028

Valves

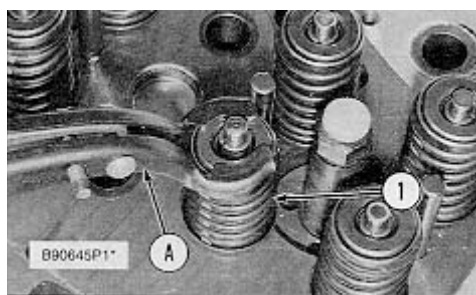
SMCS - 1105-011; 1105-012

Remove Valves

Tools Needed		A	B
5S1330	Pneumatic Valve Spring Compressor	1	
8S2263	Valve Spring Tester		1

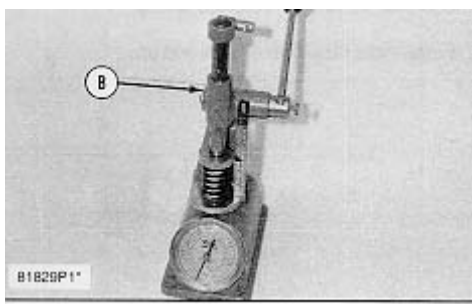
Start By:

a. remove cylinder head assembly



1. Use Tool (A) to compress springs (1).
2. Remove the locks.
3. Remove Tool (A), the valve, the rotocoil, and the spring.

NOTE: If a valve can be used again, put identification on the valve for location at installation.

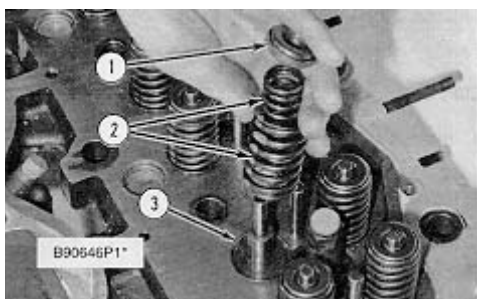


4. Use Tool (B) to check spring force. The specifications for the spring are given in Specifications Manual, SENR6470.

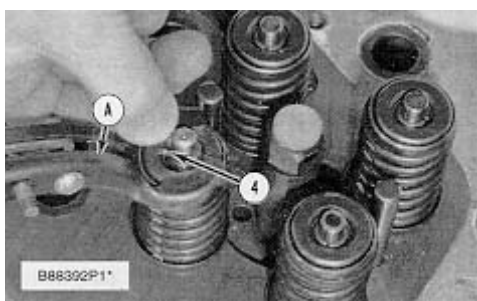
5. Do Steps 1 through 4 again for the remainder of the valves.

Install Valves

Tools Needed		A
5S1330	Pneumatic Valve Spring Compressor	1



1. Put clean engine oil on the valve stem. Install washer (3), spring (2), rotocoil (1) and the valve.




2. Use Tool (A) to compress the spring.

3. Install locks (4) with the thick end up.



WARNING

Locks can be thrown from valve when compressor is released, if they are not in their correct position on the valve stem.



4. Remove the compressor and hit the valve with a soft faced hammer to be sure locks are in their correct position on the valve.

5. Do Steps 1 through 4 again for the remainder of the valves.

End By:

a. install cylinder assembly

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SEN64090029

Valve Seat Inserts

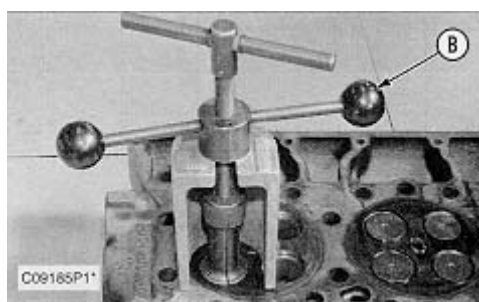
SMCS - 1103-010

Remove & Install Valve Seat Inserts

Tools Needed		A	B
6V4805	Valve Seat Extractor Tool Group*	1	
1P0510	Driver Group		1

Start By:

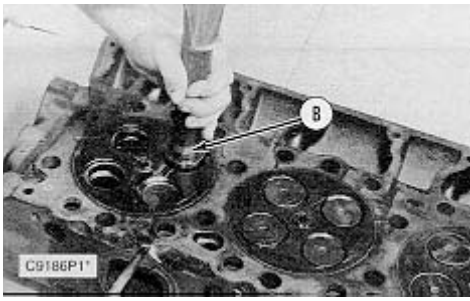
a. remove valves



1. Use Tool (A) to remove the valve seat inserts from the cylinder head.
2. Clean and remove any burrs from the valve seat bores.

NOTE: For reconditioning information of the cylinder head, see Service Training Meeting Guide, SESV1202.

NOTE: The following steps are for the installation of the valve seat inserts.



3. Lower the temperature of the new valve seat inserts. Use Tool (B) to install the new valve seat inserts in the cylinder head.

End By:

a. install valves

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