

Product: WHEEL TRACTOR

Model: 637E WHEEL TRACTOR 1FB

Configuration: 637E Series II Wheel Tractor-Scraper 1FB00532-00659 (MACHINE) POWERED BY 3408 Engine

Disassembly and Assembly 3408E and 3412E Engines for Caterpillar Built Machines

Media Number -SEN1013-11

Publication Date -01/07/2015

Date Updated -22/08/2016

i02161082

Rocker Arm and Shaft - Install

SMCS - 1102-012

Installation Procedure

NOTICE

Keep all parts clean from contaminants.

Contaminants may cause rapid wear and shortened component life.

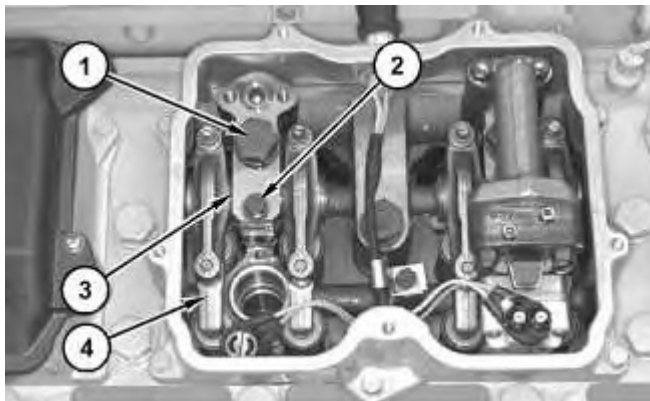


Illustration 1

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1. Lubricate the wear pad on top of valve bridges (4) with clean engine oil. Install valve bridges (4).
2. Install the pushrods.

3. Install the O-ring seal and rocker arm assembly (3).
4. Install cylinder head bolt (1) and bolt (2). Do not tighten bolt (2) at this time.
5. Tighten cylinder head bolt (1) to a torque of $270 \pm 15 \text{ N}\cdot\text{m}$ ($199 \pm 11 \text{ lb ft}$). Tighten cylinder head bolt (1) again to a torque of $450 \pm 15 \text{ N}\cdot\text{m}$ ($332 \pm 11 \text{ lb ft}$). Tighten cylinder head bolt (1) again to a torque of $450 \pm 15 \text{ N}\cdot\text{m}$ ($332 \pm 11 \text{ lb ft}$). Tighten bolt (2) to the standard torque value.

End By:

- a. Install the unit injector. Refer to Disassembly and Assembly, "Unit Injector - Install".
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i02184090

Cylinder Head - Remove

SMCS - 1100-011

Removal Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	138-7573	Link Bracket	2
B	5P-8700	Lifting Bracket	2

Start By:

- Remove the unit injector sleeves. Refer to Disassembly and Assembly, "Unit Injector Sleeve - Remove".
- Remove the exhaust manifold. Refer to Disassembly and Assembly, "Exhaust Manifold - 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 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.

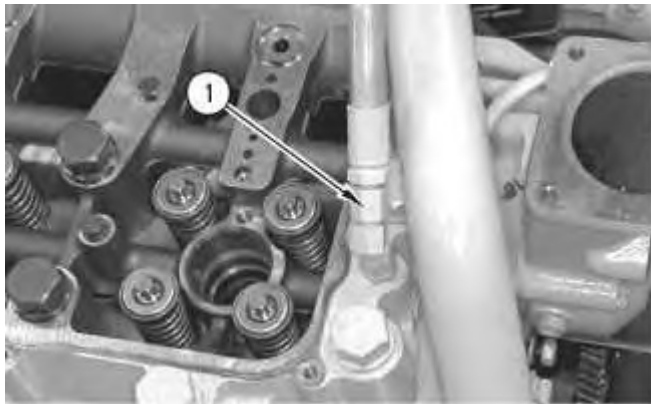


Illustration 1

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1. Remove hose assembly (1) from the front of the fuel manifold.

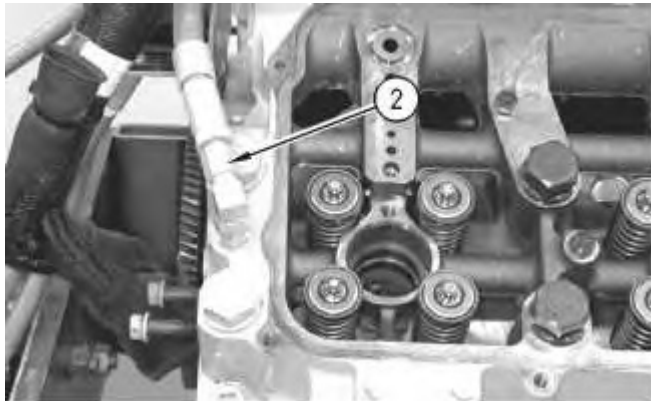


Illustration 2

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2. Remove hose assembly (2) from the rear of the fuel manifold.
-

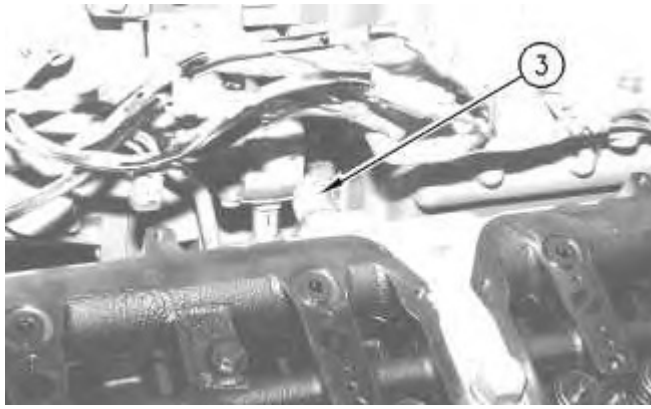


Illustration 3

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3. Remove tube assembly (3).

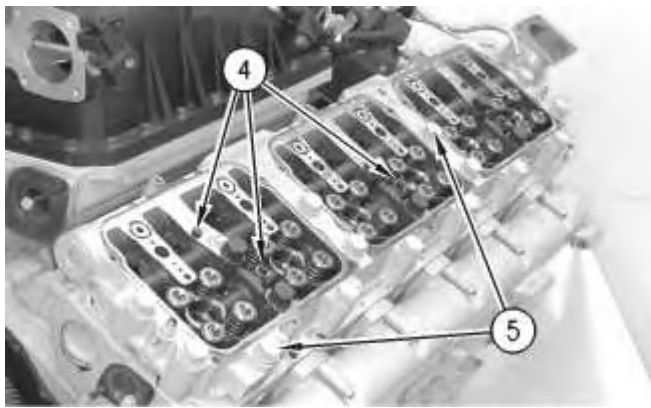


Illustration 4

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4. Remove cylinder head bolts (5). Remove bolts (4).

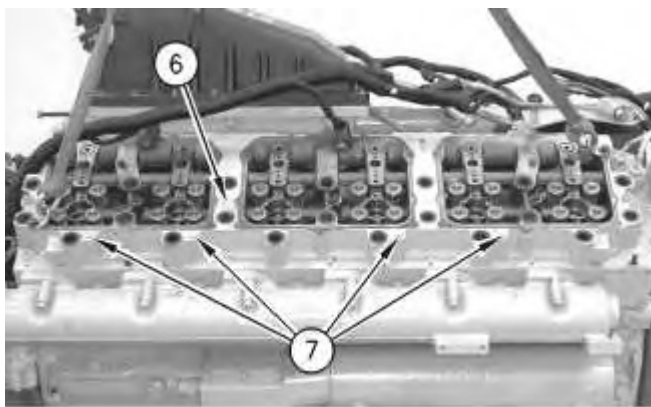


Illustration 5

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5. Attach Tooling (A) and a suitable lifting device to fuel manifold (6). The weight of the fuel manifold for the 3412E is approximately 60 kg (131 lb). The weight of the fuel manifold for the 3408E is approximately 39 kg (86 lb). Remove bolts (7). Remove fuel manifold (6).

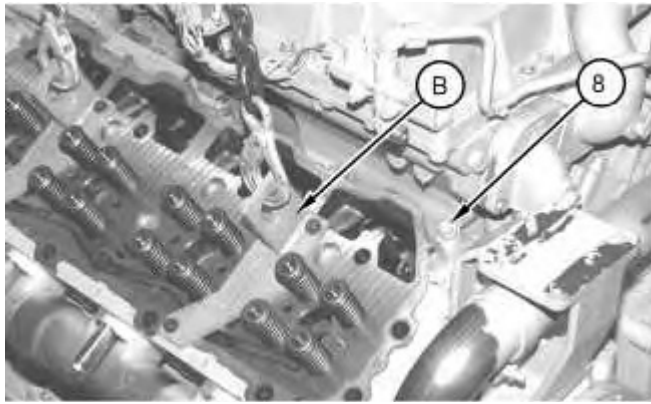


Illustration 6

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6. Attach Tooling (B) and a suitable lifting device to the cylinder head. The weight of the cylinder head for the 3412E is approximately 172 kg (380 lb). The weight of the cylinder head for the 3408E is approximately 90 kg (200 lb). Remove cylinder head nuts (8).

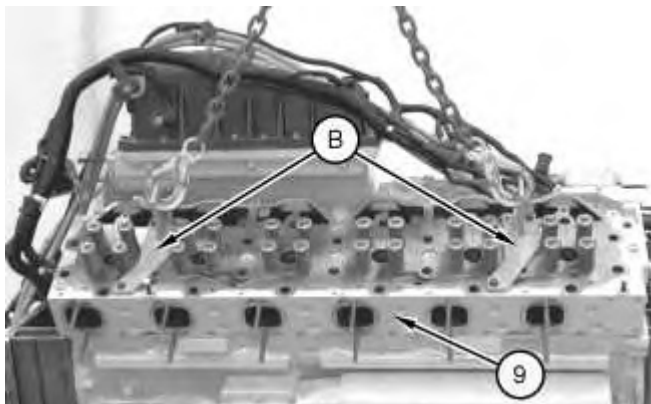


Illustration 7

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7. Remove cylinder head (9) and the gasket.

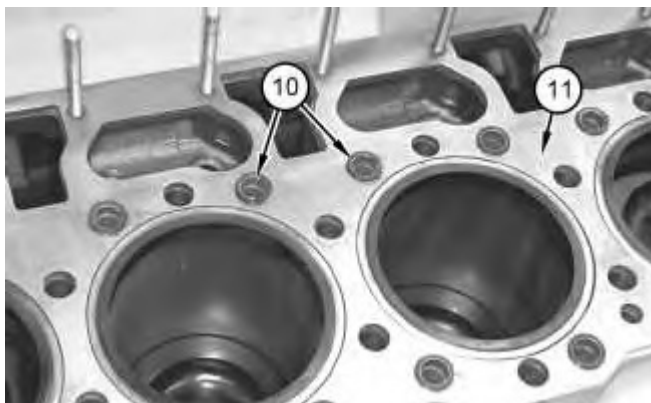


Illustration 8

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8. Remove seals (10).

9. Remove spacer plate (11).

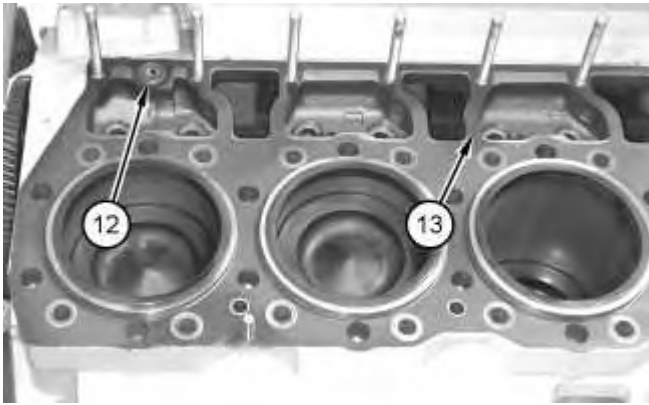


Illustration 9

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10. Remove O-ring seals (12) and gasket (13).

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