

Product: TRACK-TYPE TRACTOR

Model: D6H TRACK-TYPE TRACTOR 3YG

Configuration: D6H, D6H LGP TRACTORS DIFFERENTIAL STEERING 3YG00001-03999 (MACHINE) POWERED BY 3306 ENGINE

Disassembly and Assembly 3304B and 3306B Engines for Caterpillar Built Machines

Media Number -SEN5598-09

Publication Date -01/01/2013

Date Updated -25/01/2013

i02107019

Gear Group (Front) - Install

SMCS - 1206-012

Installation Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	1P-0510	Driver Group	1
B	9S-3263	Thread Lock Compound	1

NOTICE

Keep all parts clean from contaminants.

Contaminants may cause rapid wear and shortened component life.

Note: Check the condition of the gaskets and the O-ring seals. If the gaskets or the O-ring seals are worn or damaged, use new parts for replacement.

1. Clean the old gasket from the contact surfaces of the timing gear plate and the cylinder block. Install a new gasket on the cylinder block. Cut the gasket even with the bottom face of the cylinder block.
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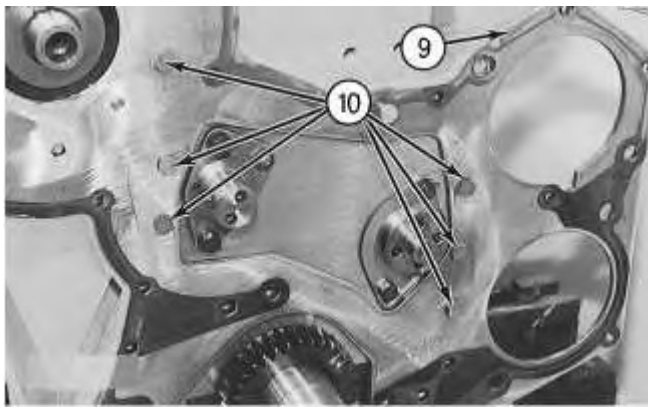


Illustration 1

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NOTICE

The bolts that hold the timing gear plate in position on the cylinder block should have a reduced bolt head thickness. The reduced bolt head thickness is needed for clearance for the gears.

2. Ensure that the O-ring seals are in position on the end of the fuel injection pump housing. Put timing gear plate (9) in position on the cylinder block. Install bolts (10) .

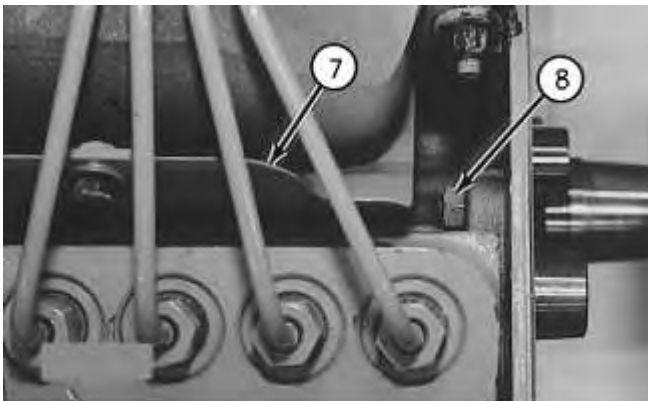


Illustration 2

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3. Install shield (7). Install nuts (8) .

Note: After the timing gear plate is installed, ensure that the rack is free to move in the fuel injection pump housing. The O-ring seal on the drive end of the fuel injection pump housing can hold the rack. This can help prevent free rack movement. Rack movement can be seen through a hole in the timing gear plate just above the mounting of the fuel pump gear. If the rack does not move freely, remove the timing gear plate and check the O-ring seal on the drive end of the fuel injection pump housing.

WARNING

If the rack does not move freely, the engine can over speed and be damaged. Serious personal injury may result.

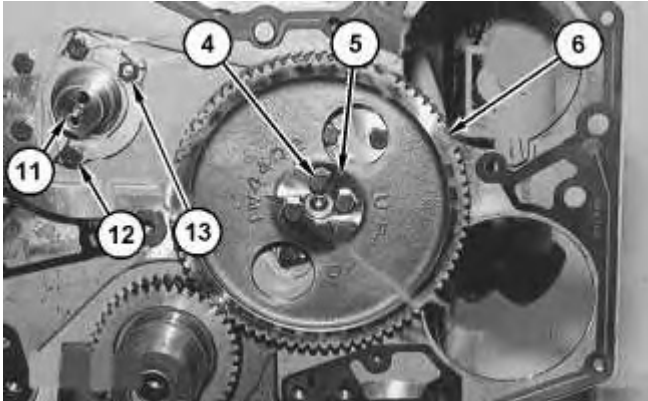


Illustration 3

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Note: If idler gear shaft (11) for the fuel pump idler gear was removed, use Tooling (B) on the threads of bolts (12) and nut (13) before reinstalling idler gear shaft (11). Tighten bolts (12) and nut (13) to a torque of $50 \pm 10 \text{ N}\cdot\text{m}$ ($37 \pm 7 \text{ lb ft}$).

- Put camshaft gear (6) and plate (5) in position on the engine. Align the Mark "C" on the camshaft gear with the Mark "C" on the crankshaft gear. Install bolts (4) and tighten bolts (4) to a torque of $55 \pm 7 \text{ N}\cdot\text{m}$ ($41 \pm 5 \text{ lb ft}$).

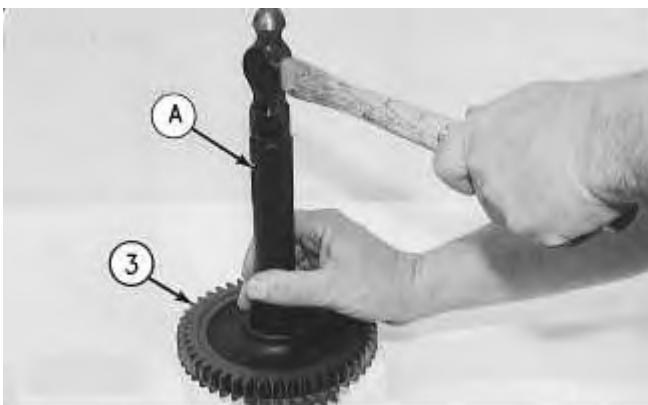


Illustration 4

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- Use Tooling (A) in order to install the bearing in fuel pump idler gear (3). The end of the bearing must be $3.00 \pm 0.25 \text{ mm}$ ($.118 \pm .010 \text{ inch}$) below the face of the hub of the fuel pump idler gear.



Illustration 5

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6. Ensure that the oil hole in the shaft for fuel pump idler gear (3) is open. Install fuel pump idler gear (3). Put plate (2) in position with the finished side facing toward fuel pump idler gear (3). Apply Tooling (B) on bolts (1). Install bolts (1) that hold fuel pump idler gear (3) in position.

Note: Remove excess Tooling (B) on plate (2). Excess Tooling (B) on plate (2) may flow into the gear bearings. This condition can affect lubrication. Bearing life can also be affected.

End By: Install the automatic timing advance unit. Refer to Disassembly and Assembly, "Automatic Timing Advance - Install".

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i02107163

Housing (Front) - Remove

SMCS - 1151-011

Removal Procedure

Start By:

- A. Remove the water pump. Refer to Disassembly and Assembly, "Water Pump - Remove".
- B. Remove the crankshaft front seal. Refer to Disassembly and Assembly, "Crankshaft Front Seal - 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, "Caterpillar Tools and Shop Products Guide" for tools and supplies suitable to collect and contain fluids on Caterpillar products.

Dispose of all fluids according to local regulations and mandates.

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1. Remove the bolts that hold the oil pan and the oil pan plate to the front housing. Loosen the remaining bolts that hold the oil pan in position. Put spacers between the cylinder block and the oil pan plate. This must be done in order to prevent damage to the gasket for the oil pan plate.

Note: If the gasket for the oil pan plate is damaged, the oil pan plate must be removed. Refer to Disassembly and Assembly, "Engine Oil Pan Plate - Remove and Install".

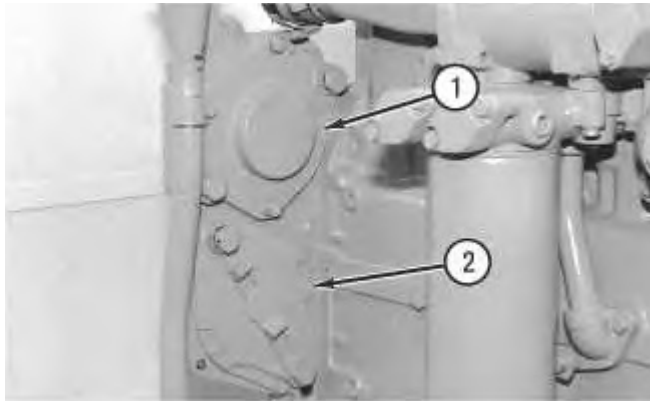


Illustration 1

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2. Remove covers (1) and (2) from the back of the front plate.

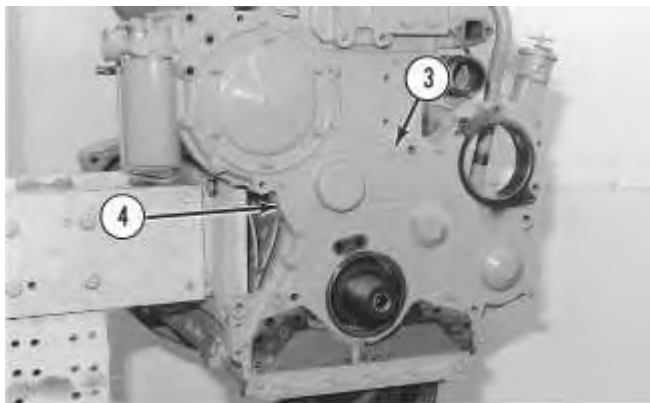


Illustration 2

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3. Remove all bolts (3) that hold front housing (4) in position on the engine. Remove front housing (4) and the gasket from the engine.

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i02107191

Housing (Front) - Install

SMCS - 1151-012

Installation Procedure

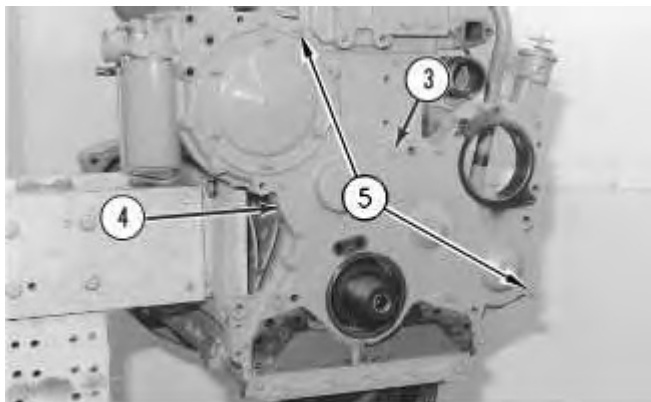
Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	3S-6252	Sealant	1

NOTICE

Keep all parts clean from contaminants.

Contaminants may cause rapid wear and shortened component life.



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