

Product: TRACK-TYPE TRACTOR

Model: D7G TRACK-TYPE TRACTOR 65V

Configuration: D7G TRACK-TYPE TRACTOR / POWER SHIFT / 65V00001-03400 (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

i01045029

# Spacer Plate - Remove and Install

SMCS - 1221-010

## Removal Procedure

### Start By:

- A. Remove the cylinder head. Refer to Disassembly and Assembly, "Cylinder Head - Remove".

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### NOTICE

**Keep all parts clean from contaminants.**

**Contaminants may cause rapid wear and shortened component life.**

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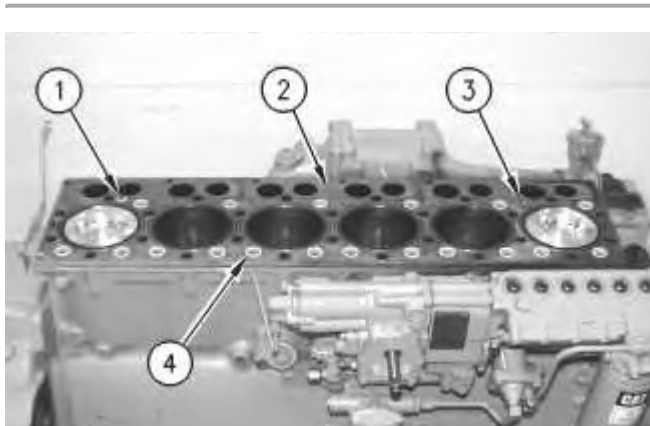


Illustration 1

g00540847

1. Remove O-ring seal (1), water seals (3) and water directors (4) from spacer plate (2) .

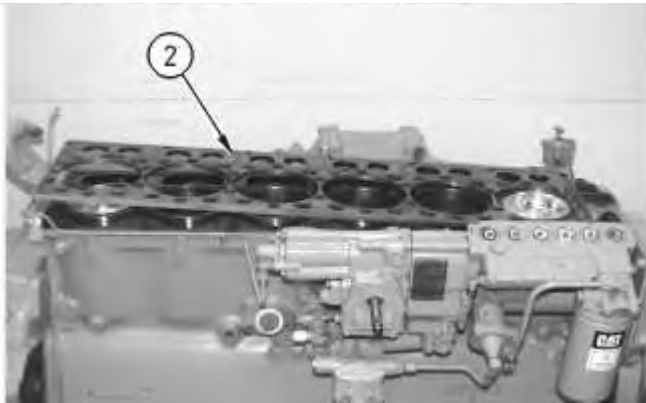


Illustration 2

g00540857

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## NOTICE

**Do not damage the dowels as the spacer plate is removed.**

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2. Remove spacer plate (2) from the cylinder head.

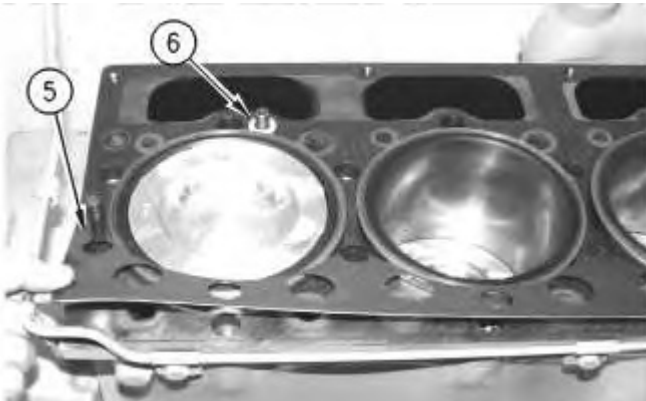


Illustration 3

g00540895

3. Remove O-ring seal (6) and spacer plate gasket (5) from the cylinder head.

## Installation Procedure

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## NOTICE

**Keep all parts clean from contaminants.**

**Contaminants may cause rapid wear and shortened component life.**

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1. Thoroughly clean the mating surfaces between the spacer plate and the cylinder block.

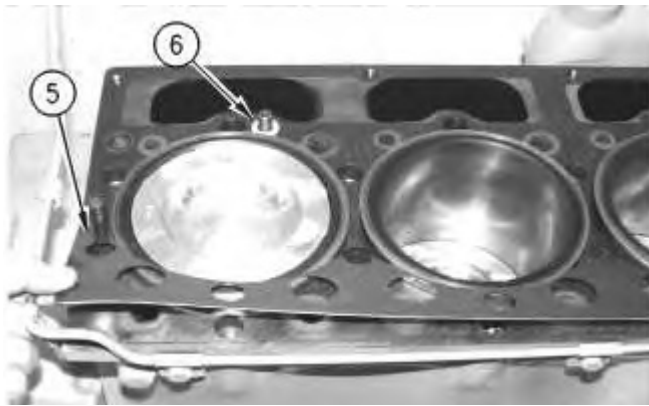


Illustration 4

g00540895

2. Install new spacer plate gasket (5) and new O-ring seal (6) .

**Note:** If the dowels in the cylinder block have been removed for any reason, the overall height of the installation is  $16.0 \pm 5.0$  mm ( $.63 \pm .20$  inch).

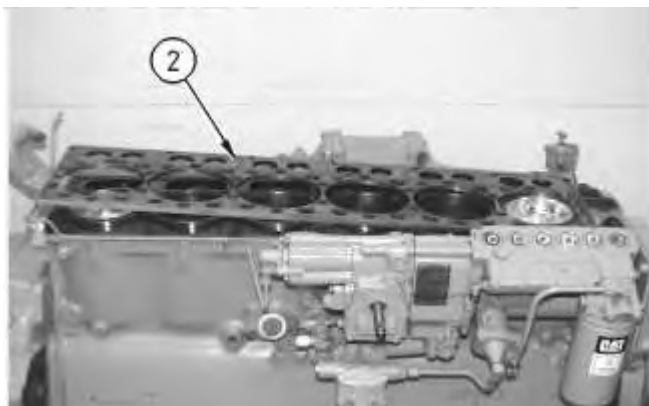


Illustration 5

g00540857

**Note:** Both surfaces of the spacer plate, spacer plate gasket and the top of the cylinder block must be clean and dry. Do not use any gasket adhesive or other substances on these surfaces.

3. Install spacer plate (2) on the cylinder head.

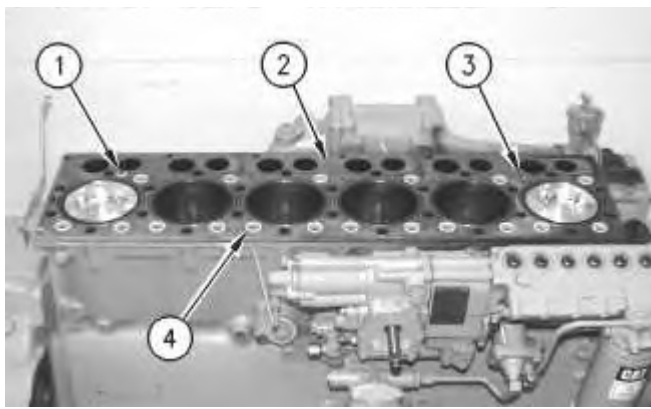


Illustration 6

g00540847

4. Install a new O-ring seal (1). Install new water seals (3). Install new water directors (4) .
5. Check the cylinder liner projection. Refer to Disassembly and Assembly, "Cylinder Liner - Install".

**End By:** Install the cylinder head. Refer to Disassembly and Assembly, "Cylinder Head - Install".

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Publication Date -01/01/2013

Date Updated -25/01/2013

i00943364

# Water Directors - Remove and Install

SMCS - 1115-010

## Removal Procedure

### Start By:

- A. Remove the spacer plate. Refer to Disassembly and Assembly, "Spacer Plate - Remove and Install".

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### NOTICE

**Keep all parts clean from contaminants.**

**Contaminants may cause rapid wear and shortened component life.**

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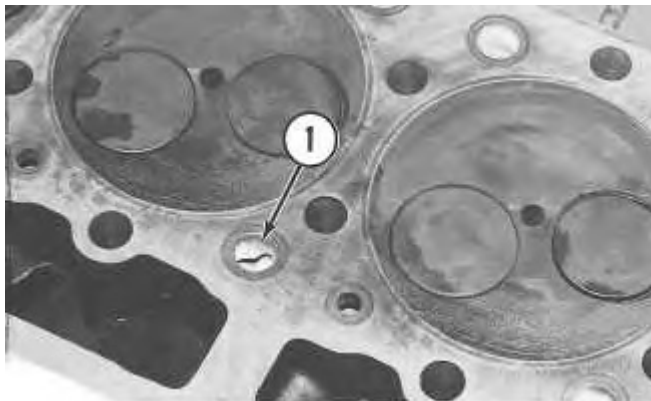


Illustration 1

g00481082

1. Remove water directors (1) from the cylinder head.

## Installation Procedure

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### NOTICE

**Keep all parts clean from contaminants.**

**Contaminants may cause rapid wear and shortened component life.**

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1. Thoroughly clean the cylinder head before assembly.

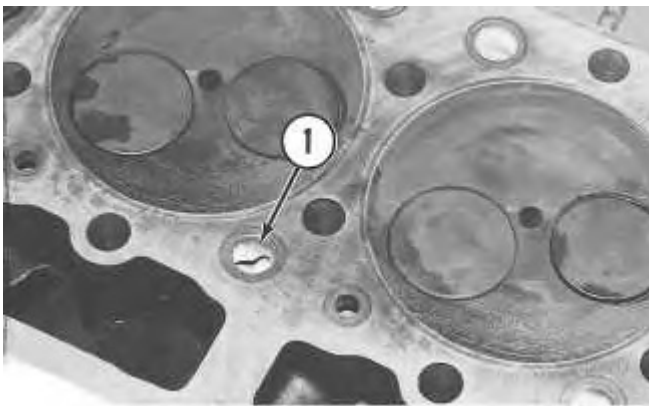


Illustration 2

g00481082

2. Install new water director (1) into the cylinder head. Align the notch in water director (1) with the "V" mark on the cylinder head.
3. Install water director (1) to a depth of  $0.8 \pm 0.6$  mm ( $0.031 \pm 0.023$  inch) below the surface of the cylinder head.

**End By:** Install the spacer plate. Refer to Disassembly and Assembly, "Spacer Plate - Remove and Install".

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i01042782

## Lifter Group - Remove and Install

SMCS - 1209-010

### Removal Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	1U-7262	Telescoping Magnet	1

**Start By:**

- A. Remove the spacer plate. Refer to Disassembly and Assembly, "Spacer Plate - Remove and Install".

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**NOTICE**

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