

Product: TRACK-TYPE TRACTOR

Model: D7G TRACK-TYPE TRACTOR 91V

Configuration: D7G TRACTOR / DIRECT DRIVE / 91V01917-UP (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

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".

NOTICE

Keep all parts clean from contaminants.

Contaminants may cause rapid wear and shortened component life.

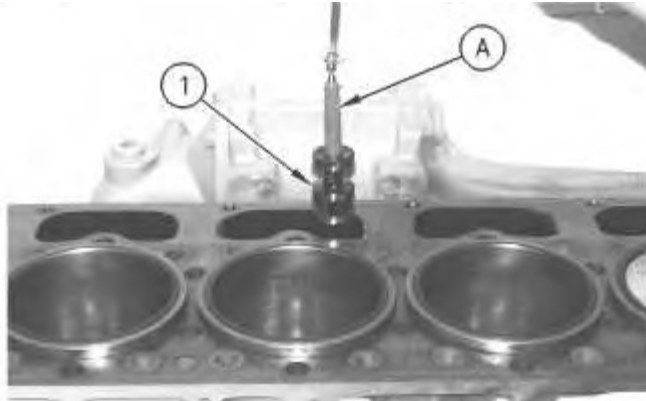


Illustration 1

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1. Use Tool (A) to remove valve lifter (1), as shown. Put identification marks on the valve lifters for installation purposes.
2. Repeat Step 1 for the remainder of the valve lifters.
3. Check the diameter of the valve lifters. The diameter of a new valve lifter must be 33.285 ± 0.015 mm (1.3105 ± 0.0005 inch). The diameter of the bore in the cylinder block for a new valve lifter must be 33.388 ± 0.050 mm (1.3145 ± 0.0020 inch). The maximum permissible clearance between the valve lifter and the valve lifter bore in the cylinder block must be 0.30 mm (0.012 inch).

Installation Procedure

Table 2

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

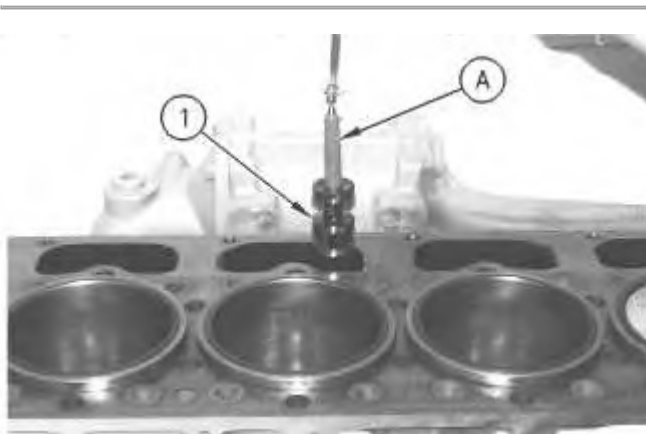


Illustration 2

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1. Put **8T-2998** Lubricant on valve lifter (1) prior to installation. Install valve lifter (1) with Tool (A) in the original location in the cylinder block.
2. Repeat Step 1 for the remainder of the valve lifters.

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

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Media Number -SEN5598-09

Publication Date -01/01/2013

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i01037991

Camshaft - Remove and Install

SMCS - 1210-010

Removal Procedure

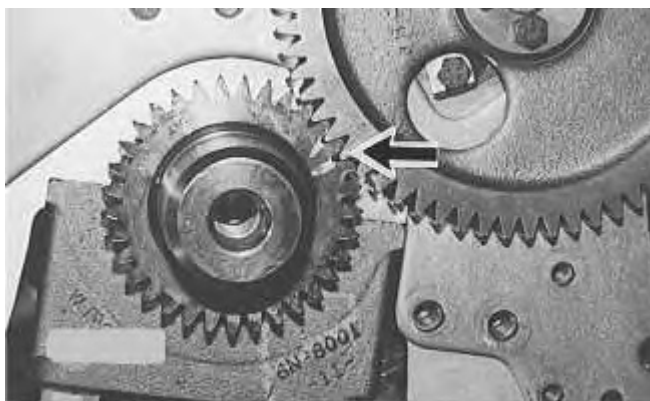
Start By:

- A. Remove the valve lifters. Refer to Disassembly and Assembly, "Lifter Group - Remove and Install".
- B. Remove the timing gear cover. Refer to Disassembly and Assembly, "Front Housing - Remove".

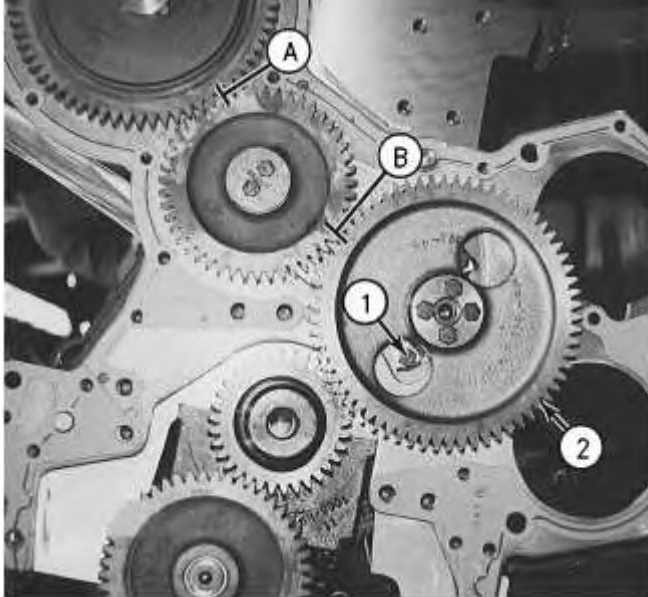
NOTICE

Keep all parts clean from contaminants.

Contaminants may cause rapid wear and shortened component life.

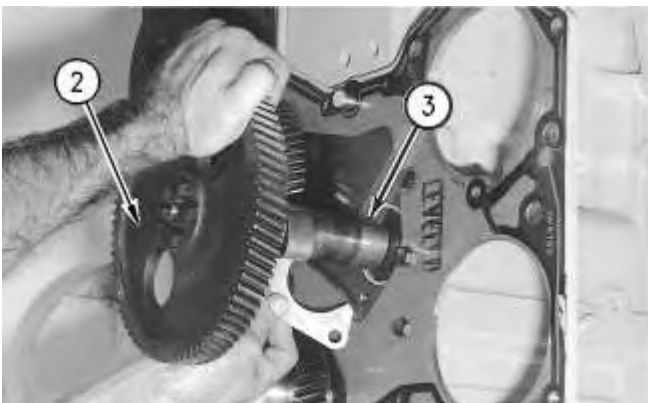


1. Turn the crankshaft to top center compression stroke for the No. 1 piston. The "C" mark on the crankshaft gear will be aligned with the "C" mark on the camshaft gear.



Note: Put a mark on the teeth of the fuel injection pump drive gear and the idler gear at location (A). This will help to keep the engine timing correct during the removal and the installation of the camshaft. Put a mark on the teeth of the idler gear and camshaft gear (2) at location (B). When the camshaft is installed, the engine timing will be correct when the mark at location (A) is aligned with the mark at location (B) and the "C" mark on the crankshaft gear is aligned with the "C" mark on the camshaft gear.

2. Remove the bolts, the lock and washer (1) .



NOTICE

Do not damage the lobes or the bearings when the camshaft is removed.

3. Carefully remove camshaft (3) from the engine.
4. If necessary, remove the bolts that hold camshaft drive gear (2) to the camshaft and remove the gear.

Installation Procedure

NOTICE

Keep all parts clean from contaminants.

Contaminants may cause rapid wear and shortened component life.

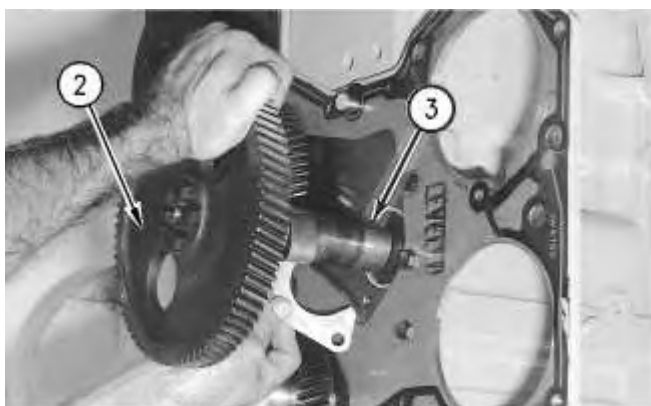


Illustration 4

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1. Put camshaft drive gear (2) in position on the end of camshaft (3). Install the bolts that hold camshaft drive gear (2) to camshaft (3). Tighten the bolts to a torque of 55 ± 7 N·m (41 ± 5 lb ft).

NOTICE

Do not damage the lobes or the bearings when the camshaft is installed.

- Put **8T-2998** Camshaft Lubricant on the camshaft lobes only and put clean engine oil on the bearing journals.

Note: During the installation of camshaft (3), rotate the camshaft in both directions in order to prevent binding in the camshaft bearing bores.

- Carefully install camshaft (3) into the engine.

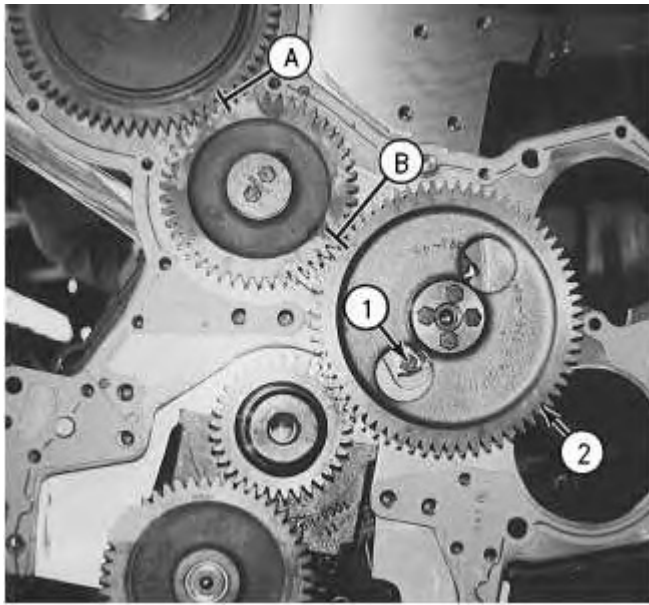


Illustration 5

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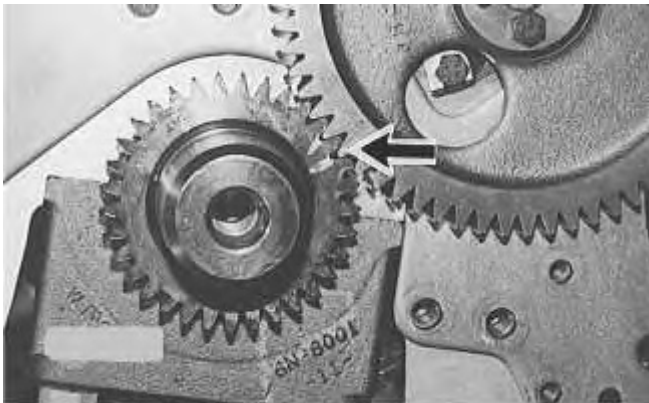


Illustration 6

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- Make sure that the mark on the teeth of the fuel injection pump drive gear and the idler gear are in alignment at location (A). Make sure that the mark on the teeth of the idler gear and camshaft gear (2) are in alignment at location (B). Align the "C" marks on the crankshaft gear and camshaft gear (2). When all of the timing marks are in alignment the engine timing is correct.

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