



# Service Repair Manual

## **Models**

304E2CR Mini Hydraulic  
Excavator

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Product: MINI HYD EXCAVATOR

Model: 304E2 CR MINI HYD EXCAVATOR FC2

Configuration: 304E2CR Mini Hydraulic Excavator FC200001-UP (MACHINE) POWERED BY C2.4 Engine

## Disassembly and Assembly

### C2.4 Tier 4 Final Engines for Caterpillar Built Machines

Media Number -UENR7319-02

Publication Date -01/07/2018

Date Updated -01/08/2018

i06523433

## Inlet Manifold - Remove and Install

SMCS - 1058-010

### Removal Procedure

#### Start By:

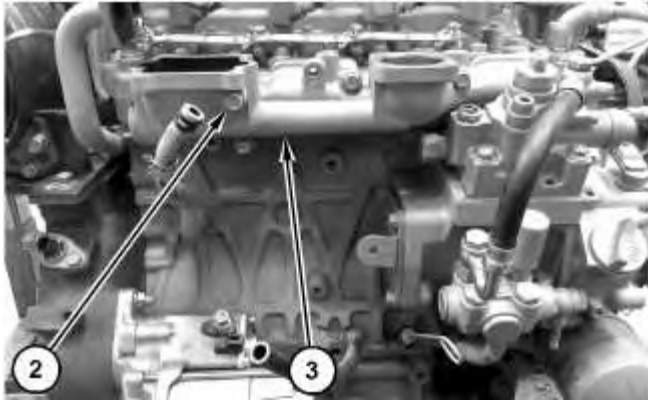
- a. Remove exhaust gas recirculation valve.
- b. Remove fuel injection lines.
- c. Remove fuel manifold (rail).



Illustration 1

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1. Remove bolt (1).



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Illustration 2

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2. Remove bolts (2) and inlet manifold (3).

## Installation Procedure

1. Install inlet manifold (3) in the reverse order of removal.

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i06539555

## Inlet and Exhaust Valves - Remove and Install

SMCS - 1105-010

### Removal Procedure

Table 1

Required Tooling			
Tool	Part Number	Part Description	Qty
A	5S-1330	Valve Spring Compressor	1

#### Start By:

- a. Remove cylinder head.

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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. Clean the bottom mating surface of the cylinder head. Check the depth of the valves below the face of the cylinder head before the valve springs are removed. Refer to Specifications, "Cylinder Head Valves" for the correct dimensions.
  2. Place a temporary identification mark on the heads of the valves to identify the correct position.
  3. Use a suitable lifting device to position the cylinder head with the valve springs upward. The weight of the cylinder head is approximately 28 kg (61 lb).
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Illustration 1

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## **WARNING**

**Personal injury can result from being struck by parts propelled by a released spring force.**

**Make sure to wear all necessary protective equipment.**

**Follow the recommended procedure and use all recommended tooling to release the spring force.**

4. Install Tooling (A) in position on the cylinder head and compress the valve spring to remove inlet and exhaust valves (1).



Illustration 2

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## **NOTICE**

**Ensure that the valve spring is compressed squarely or damage to the valve stem may occur.**

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