



Service Repair Manual

Models

527 TRACK SKIDDER

Product: TRACK SKIDDER

Model: 527 TRACK SKIDDER 3DS

Configuration: 527 TRACK-TYPE SKIDDER 3DS00001-UP (MACHINE) POWERED BY 3304 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

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Pistons and Connecting Rods - Assemble

SMCS - 1225-016

Assembly Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	7S-9470	Piston Ring Expander	1

NOTICE

Keep all parts clean from contaminants.

Contaminants may cause rapid wear and shortened component life.

1. Clean the grooves of the used pistons with an acceptable tool or **1U-8811** Cleaner .
 2. Install the connecting rod bearings. Ensure that the tabs on the back side of the connecting rod bearings are in the tab grooves of the connecting rod and the connecting rod cap.
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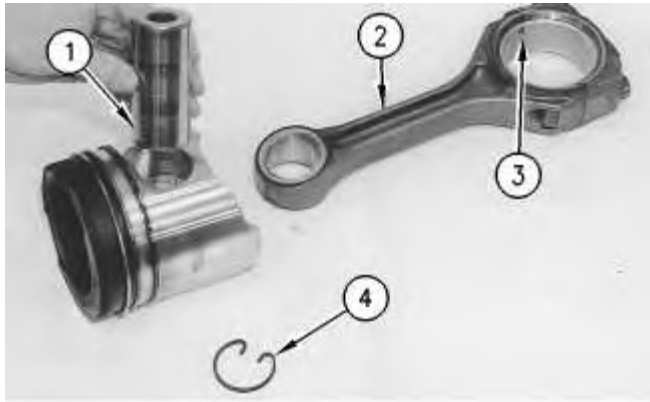


Illustration 1

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3. Install connecting rod (2) into the piston. Ensure that bearing tab slot (3) and the identification marks are on the same side as the "V" mark on the top of the piston.
4. Lubricate piston pin (1) with clean engine oil and install piston pin (1) through the piston and connecting rod. Install retaining ring (4) on the end of the piston pin.



Illustration 2

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5. Install the oil control ring on the piston with Tool (A) .
6. Use Tool (A) to install the intermediate piston ring with the side marked "UP-2" toward the top of the piston.
7. Use Tool (A) to install the top piston ring with the side marked "UP-1" toward the top of the piston.

Note: The gaps in the intermediate piston ring and the top piston ring should be separated by 120 degrees.

End By: Install the pistons and connecting rods. Refer to Disassembly and Assembly, "Pistons and Connecting Rods - Install".

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Pistons and Connecting Rods - Install

SMCS - 1225-012

Installation Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	5P-3525	Piston Ring Compressor	1

NOTICE

Keep all parts clean from contaminants.

Contaminants may cause rapid wear and shortened component life.

1. Rotate the crankshaft until the bearing journals are at the bottom center. The bearing journals that are at the bottom center are for the piston installation.
 2. Put clean engine oil on the crankshaft journals and on the inside of the cylinder liners. Put clean engine oil on the piston rings and the connecting rod bearings.
 3. Move the piston rings on the pistons until the ring openings are separated by approximately 120 degrees.
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