

Product: EXCAVATOR

Model: 320D L EXCAVATOR TDH

Configuration: 320D & 320D L Excavators TDH00001-UP (MACHINE) POWERED BY C6.4 Engine

## Disassembly and Assembly C6.4 Engine for Caterpillar Built Machines

Media Number -KENR8106-09

Publication Date -01/10/2017

Date Updated -18/10/2017

i04625001

# Inlet and Exhaust Valve Seat Inserts - Remove and Install

SMCS - 1103-010

## Removal Procedure

Table 1

| Required Tools |             |                                     |     |
|----------------|-------------|-------------------------------------|-----|
| Tool           | Part Number | Part Description                    | Qty |
| A              | 166-7441    | Valve Seat Extractor Tool           | 1   |
|                | 6V-4194     | Valve Seat Extractor <sup>(1)</sup> | 1   |
|                | 6V-4196     | Valve Seat Extractor <sup>(1)</sup> | 1   |
| B              | 138-7573    | Link Bracket                        | 4   |
| C              | 1U-9200     | Lever Puller Hoist                  | 1   |
| D              | 8S-6691     | Cylinder Head Repair Stand          | 1   |

<sup>(1)</sup> Component of the Valve Seat Extractor Tool Group.

### Start By:

- A. Remove the inlet and exhaust valves. Refer to Disassembly and Assembly, "Inlet and Exhaust Valves - Remove and Install".
- B. Remove the electronic unit injectors. Refer to Disassembly and Assembly, "Electronic Unit Injectors - 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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**Note:** Refer to Special Instructions, SMHS7953-00, "Use of Valve Seat Insert Puller Group" to aid with the removal of the inlet and exhaust valve seats.

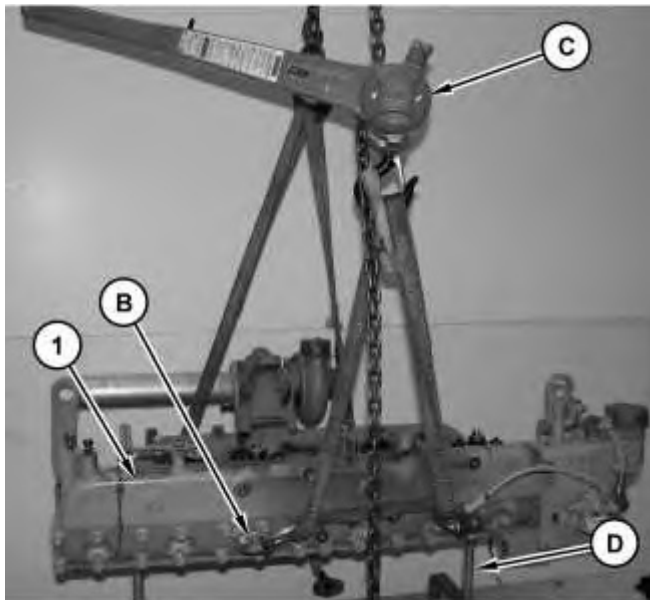
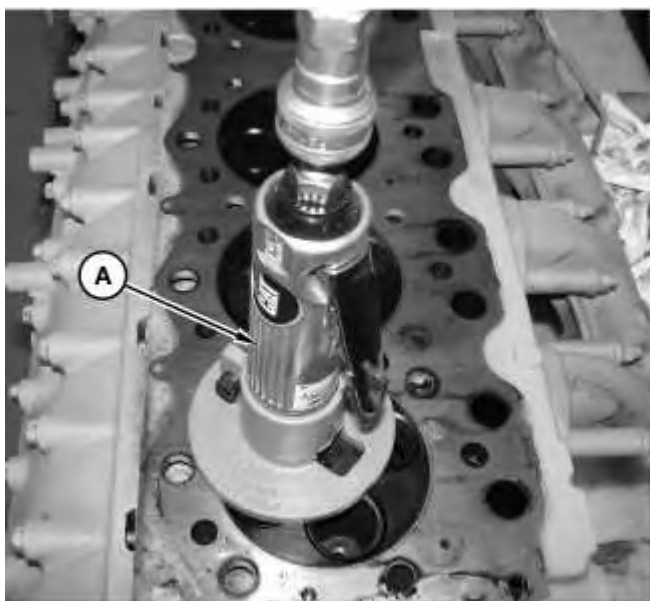


Illustration 1

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1. Attach Tooling (B) , Tooling (C) , and a suitable lifting device to cylinder head (1) . Use Tooling (B) , Tooling (C) , and the suitable lifting device in order to turn over cylinder head (1) by 180° onto Tooling (D) .



2. Use the valve seat grinder of Tooling (A) in order to notch the valve seat.

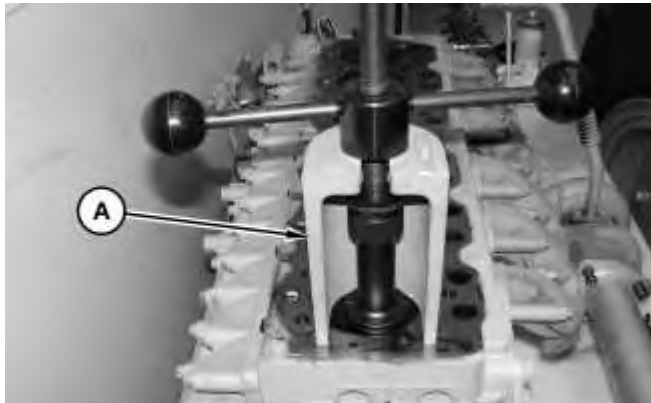


Illustration 3

3. Use the valve seat extractor of Tooling (A) to remove the inlet and exhaust valve seats.
4. Clean the valve seat in the cylinder head. Remove any rough areas from the valve seat in the cylinder head.
5. Repeat Steps 2 through 4 for the remaining inlet valve seat inserts and exhaust valve seat inserts.

## Installation Procedure

Table 2

| Required Tools |             |                      |     |
|----------------|-------------|----------------------|-----|
| Tool           | Part Number | Part Description     | Qty |
| E              | 384-8859    | Valve Seat Installer | 1   |
| F              | 384-8860    | Valve Seat Installer | 1   |

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