



# Service Repair Manual

## **Models**

318B 318B L 318B LN Excavator

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Product: EXCAVATOR

Model: 318B EXCAVATOR 3LR

Configuration: 318B L & 318B LN Excavators 3LR00001-UP (MACHINE) POWERED BY 3046 Engine

## Disassembly and Assembly 3046 Engine For Caterpillar Built Machines

Media Number -SEN6458-05

Publication Date -01/04/2004

Date Updated -22/04/2004

i02063403

# Cylinder Head - Install

SMCS - 1100-012

## Installation Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	9U-7995	Guide Pin	2

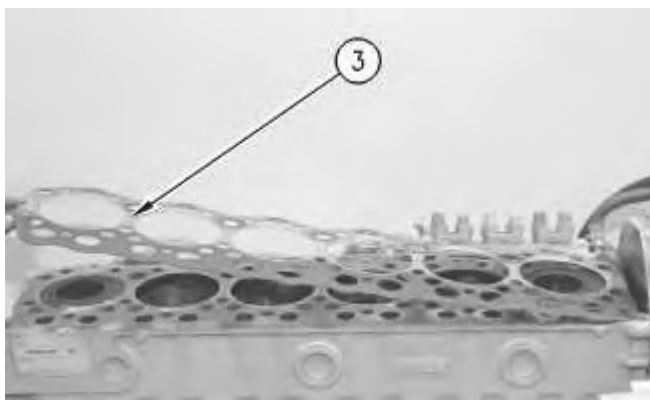
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### NOTICE

**Keep all parts clean from contaminants.**

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

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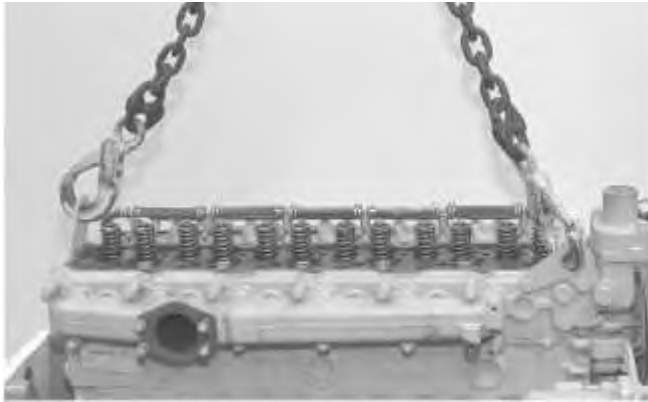
Illustration 1

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1. Clean the surfaces of the cylinder head and the cylinder block that are in contact with each other. Ensure that the surfaces are clean and dry. Install a new, dry cylinder head gasket (3) on the cylinder block.

**Note:** Do not use any sealant or gasket adhesive on the cylinder head gasket .

2. Install Tool (A) (not shown) on the cylinder block in order to install the cylinder head.

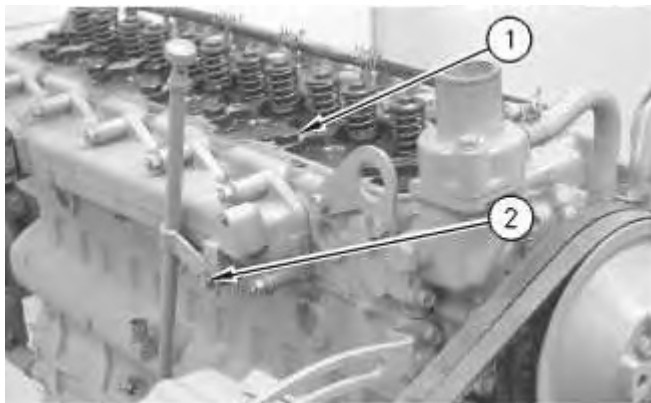


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Illustration 2

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3. Attach a hoist to the cylinder head lifting brackets and install the cylinder head in position on the cylinder block. The weight of the cylinder head assembly is 60 kg (132 lb).
4. Remove Tool (A) .
5. Apply **6V-4876** Lubricant to all of the threads and thrust faces of cylinder head bolts (1) .

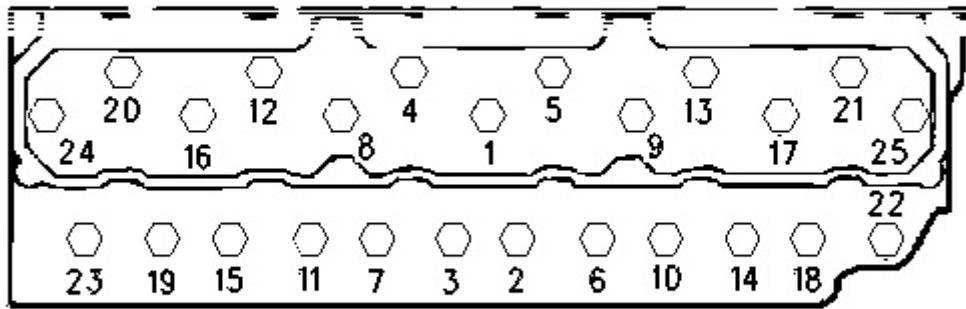


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Illustration 3

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Illustration 4

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Cylinder Head Tightening Sequence

6. Install cylinder head bolts (1) and tighten all of the bolts (1 through 25) in a numerical order according to the cylinder head tightening sequence. Tighten cylinder head bolts (1) to a torque of  $118 \pm 5 \text{ N}\cdot\text{m}$  ( $87 \pm 4 \text{ lb ft}$ ).
7. If necessary, install oil tube assembly (dipstick) and install bolt (2) .

**End By:**

- a. Install the fuel injector nozzles. Refer to Disassembly and Assembly, "Fuel Injection Nozzles - Install".
- b. Install the glow plugs. Refer to Disassembly and Assembly, "Glow Plugs - Remove and Install".
- c. Install the rocker shaft and pushrods. Refer to Disassembly and Assembly, "Rocker Shaft and Pushrods - Install".
- d. Install the turbocharger. Refer to Disassembly and Assembly, "Turbocharger - Install".

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i01033379

# Lifter Group - Remove and Install

SMCS - 1209-010

## Removal Procedure

### Start By:

- A. Remove the camshaft. Refer to Disassembly and Assembly, "Camshaft - Remove and Install".

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### NOTICE

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Illustration 1

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