



Service Repair Manual

Models

325D L Excavator

Product: EXCAVATOR

Model: 325D L EXCAVATOR ERK

Configuration: 325D L Excavator ERK00001-UP (MACHINE) POWERED BY C7 Engine

Disassembly and Assembly

C7

Engines for Caterpillar Built Machines

Media Number -REN9218-13

Publication Date -01/06/2014

Date Updated -04/06/2014

i06555904

Unit Injector Sleeve - Remove

SMCS - 1713-011

Removal Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	372-7975	Injector Sleeve Tool	1
B	454-6623	Tap (6 inch)	2
C	8S-4716	Bolts (1/4 - 28)	2
D	6V-2166	Slide Hammer Puller Gp	1

Start By:

- a. Remove the unit injectors.

NOTICE

Keep all parts clean from contaminants.

Contaminants may cause rapid wear and shortened component life.

1. Refer to Operation and Maintenance Manual, "Cooling System Coolant - Change" for the correct draining procedures.
-



Illustration 1

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2. Position Tooling (A) at the bottom of the unit injector sleeve.

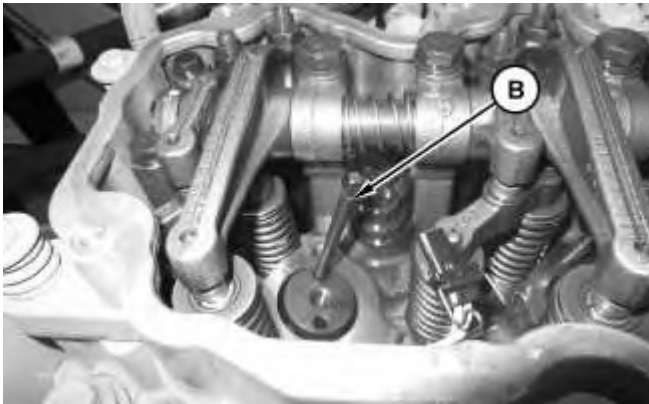


Illustration 2

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3. Install Tooling (B). Use Tooling (B) to cut threads into the side of the unit injector sleeve. Repeat for opposite side.

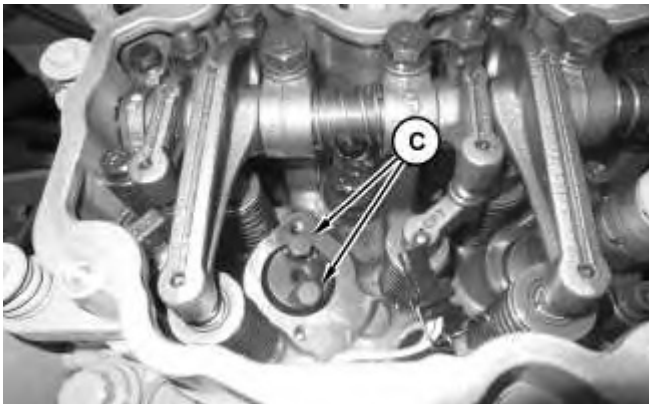


Illustration 3

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4. Install Tooling (C).

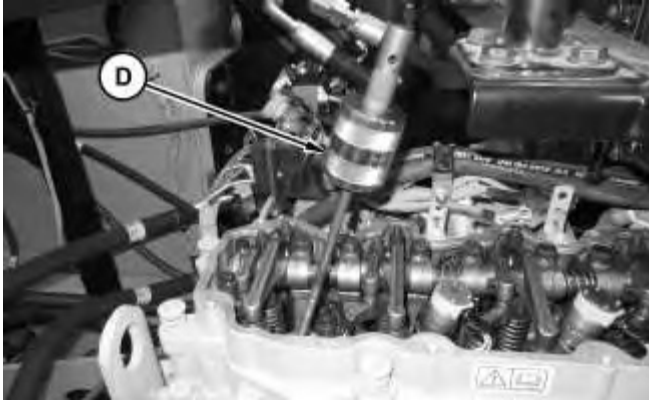


Illustration 4

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5. Thread Tooling (D) into the top of Tooling (A). Use Tooling (D) to remove the unit injector sleeve.

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i05528089

Unit Injector Sleeve - Install

SMCS - 1713-012

Installation Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	372-7975	Injector Sleeve Tool	1
E	-	Loctite 620	-
F	4C-5552	Large Bore Brush	1

NOTICE

Keep all parts clean from contaminants.

Contaminants may cause rapid wear and shortened component life.

1. Thoroughly clean the unit injector sleeves and the bores for the unit injectors. Tooling (F) may be used on the bores.
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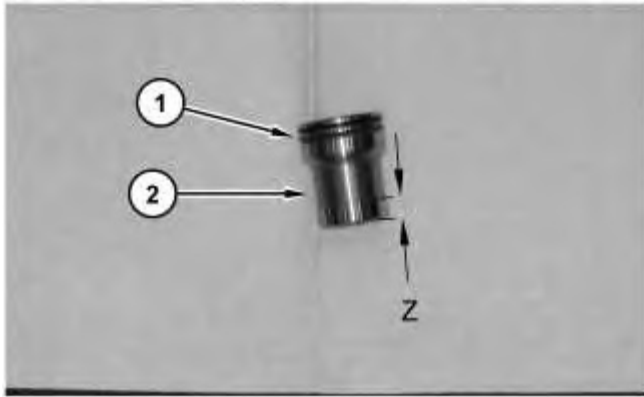


Illustration 1

g03500578

2. Apply clean engine oil to O-ring seals (1) .
3. Apply a thin coating of Tooling (E) around the outer circumference of unit injector sleeve (2) at Surface (Z) .



Illustration 2

g03500637

4. Use Tooling (A) and a hammer to position unit injector sleeve (2) in the cylinder head.
Note: Allow Tooling (E) to cure for two hours at 21 °C (70 °F) before filling the engine with fuel or coolant. Longer curing time is required for lower temperatures.
5. Refer to Operation and Maintenance Manual, "Cooling System Coolant - Change" for the correct filling procedures.

End By: Install the unit injectors.

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i05683072

Unit Injector Hydraulic Pump - Remove

SMCS - 1714-011

Removal Procedure for Non-Dual Tapered Roller Bearing HEUI Pump

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	192-5092	Removal Tool	1

NOTICE

Keep all parts clean from contaminants.

Contaminants may cause rapid wear and shortened component life.

NOTICE

Care must be taken to ensure that fluids are contained during performance of inspection, maintenance, testing, adjusting, and repair of the product. Be prepared to collect the fluid with suitable containers before opening any compartment or disassembling any component containing fluids.

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