

Product: VIBRATORY COMPACTOR

Model: CB-545 VIBRATORY COMPACTOR 2FS

Configuration: CB-545 Vibratory Compactor 2FS00001-UP (MACHINE) POWERED BY 3054 Engine

Disassembly and Assembly 3054 Engine for Caterpillar Built Machines

Media Number -SEN6241-13

Publication Date -01/08/2008

Date Updated -04/08/2008

i01458210

Inlet and Exhaust Valve Springs - Remove and Install

SMCS - 1108-010

Removal Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	9U-6195	Valve Spring Compressor	1

Start By:

- A. Remove the rocker shaft. Refer to Disassembly and Assembly, "Rocker Shaft and Pushrod - Remove".

NOTICE

Keep all parts clean from contaminants.

Contaminants may cause rapid wear and shortened component life.

Note: Before you begin the removal of the valve springs, refer to the Specifications Module, "Cylinder Head Valves" topic for appropriate information on the valve springs.

1. Ensure that the piston is at the top center position.

Note: If the rocker arm assembly has not been removed, rotate the crankshaft in the normal direction of rotation until the inlet valve of the appropriate cylinder has just opened and the

exhaust valve has not fully closed. If the rocker arm assembly has been removed, go to Step 2.

NOTICE

Do not turn the crankshaft while the valve springs are removed.

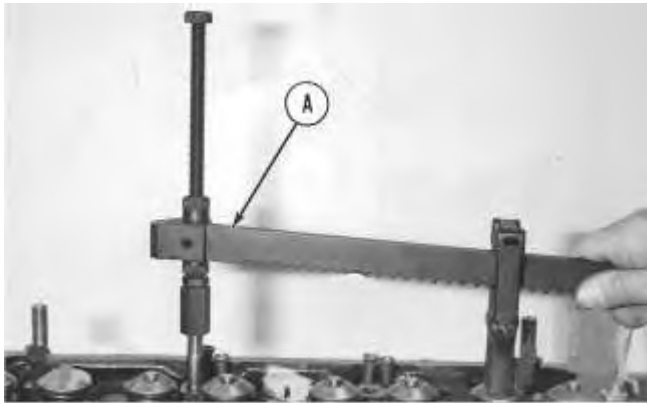


Illustration 1

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- a. Install Tool (A) .
- b. Compress the valve springs in order to open the valve.
- c. Turn the crankshaft until the piston touches the valve.
- d. Continue to turn the crankshaft and release the pressure of Tool (A) until the piston is at the top center position.

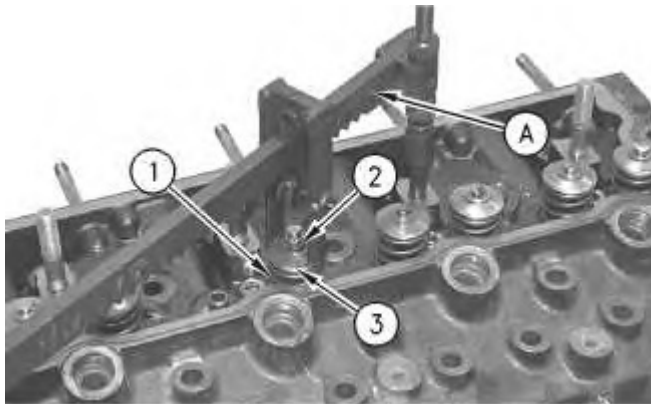


Illustration 2

g00762210

2. Install Tool (A) .

3. Compress valve springs (1). Remove two valve keepers (2) .

NOTICE

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

4. Release the pressure on Tool (A). Remove valve spring retainer (3) and valve springs (1) .

Note: If you are replacing all of the valve springs, the procedure can be done on two cylinders at the same time. The procedure can be done on cylinder 1 and cylinder 4, or on cylinder 2 and cylinder 3.

NOTICE

Do not turn the crankshaft while the valve springs are removed.

Installation Procedure

Table 2

Required Tools			
Tool	Part Number	Part Description	Qty
A	9U-6195	Valve Spring Compressor	1

NOTICE

Keep all parts clean from contaminants.

Contaminants may cause rapid wear and shortened component life.

1. Place the new valve springs into position.

Note: Ensure that the closed damper coils are toward the cylinder head if double valve springs are used.

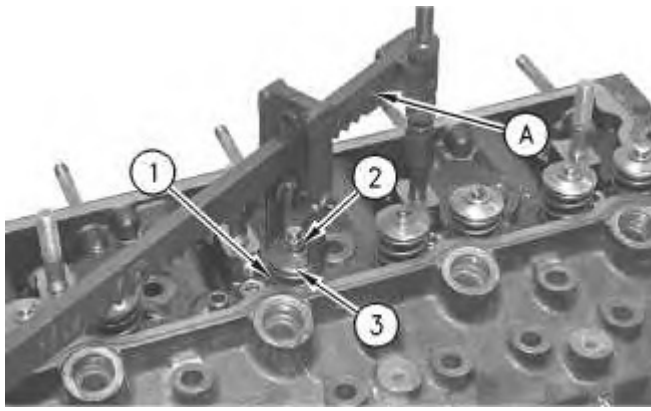


Illustration 3

g00762210

2. Install valve spring retainer (3) .
3. Install Tool (A). Compress valve springs (1) .

NOTICE

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

4. Install two valve keepers (2) .
5. Release the pressure slowly on Tool (A). Remove Tool (A). Strike the top of the valves with a soft faced hammer in order to ensure that the valve keepers are properly installed.

Note: If you are replacing all of the valve springs the procedure can be done on two cylinders at the same time. The procedure can be done on cylinder 1 and cylinder 4, or on cylinder 2 and cylinder 3.

End By: Install the rocker shaft. Refer to Disassembly and Assembly, "Rocker Shaft and Pushrod - Install".

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i01739737

Inlet and Exhaust Valves - Remove and Install

SMCS - 1105-010

Removal Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	9U-6195	Valve Spring Compressor	1

Start By:

- a. Remove the cylinder head assembly. Refer to Disassembly and Assembly, "Cylinder Head - Remove".

NOTICE

Keep all parts clean from contaminants.

Contaminants may cause rapid wear and shortened component life.

1. Clean the bottom face of the cylinder head. Use a dial indicator to check the depth of the valves below the face of the cylinder head before the valve springs are removed. Refer to Specifications, RENR2401, "Cylinder Head Valves" for the correct dimensions.
 2. Place an index mark on the heads of the inlet valves and the exhaust valves for installation purposes.
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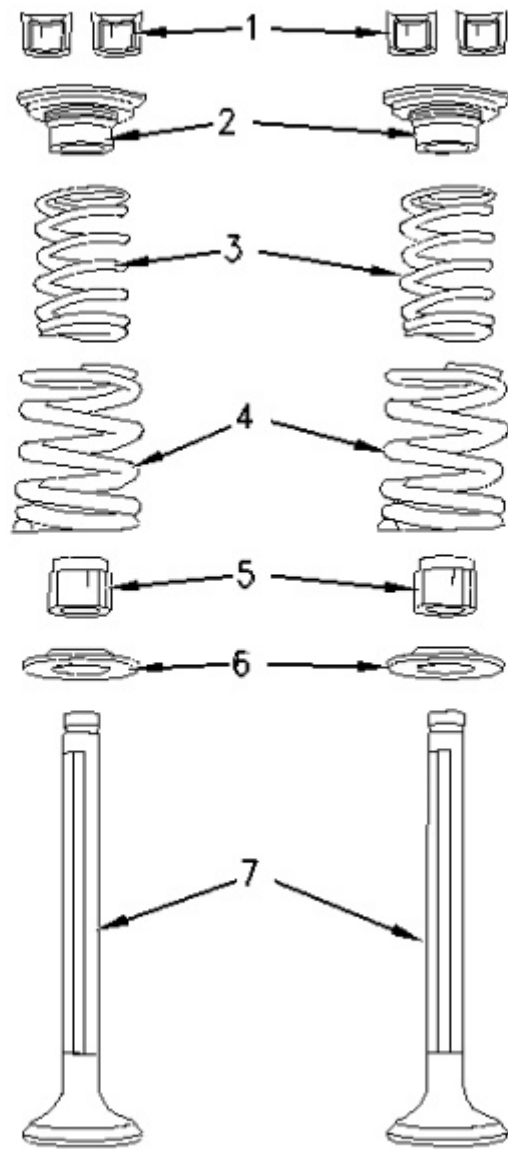


Illustration 1

g00545731

3. Use Tooling (A) to compress inner springs (3) and outer springs (4).

Note: Some engines may have only a single inlet valve spring and a single exhaust valve spring.

4. Remove valve keepers (1).



The valve keepers can be thrown from the valve when the valve spring compressor is released. Ensure that the valve keepers are properly

installed on the valve stem. To help prevent personal injury, keep away from the front of the valve keepers and valve springs during the installation of the valves.

5. Slowly release the pressure on Tooling (A) and remove Tooling (A).
6. Remove valve spring retainers (2).
7. Remove inner springs (3) and outer springs (4).
8. Remove seals (5).
9. Remove valve spring seat washers (6).
10. Remove inlet valves (7) and exhaust valves (7).

Installation Procedure

Table 2

Required Tools			
Tool	Part Number	Part Description	Qty
A	9U-6195	Valve Spring Compressor	1

NOTICE

Keep all parts clean from contaminants.

Contaminants may cause rapid wear and shortened component life.

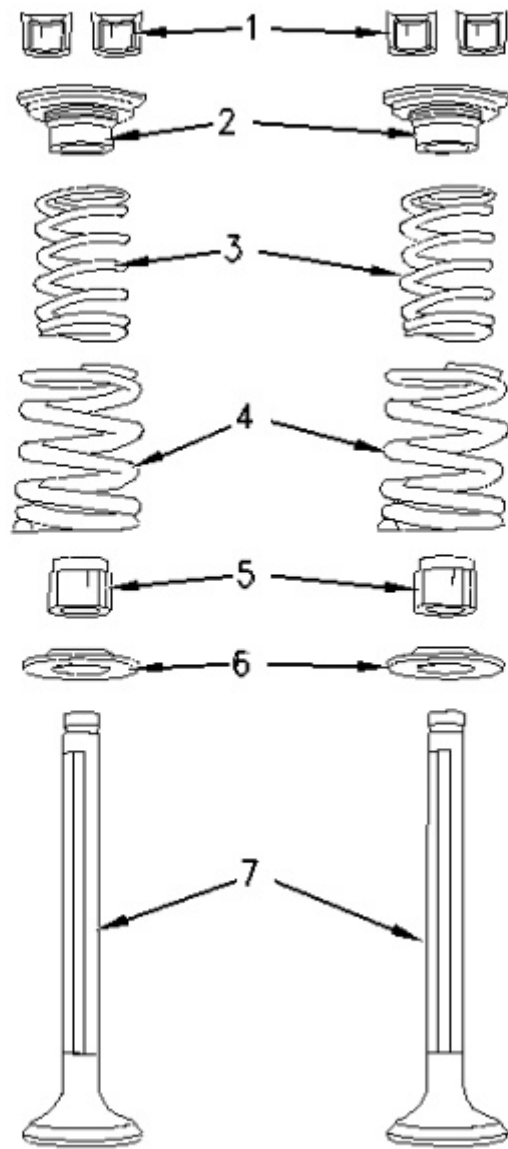


Illustration 2

g00545731

1. Lubricate the stems of inlet valves (7) and the stems of exhaust valves (7) with clean engine oil.
2. Install inlet valves (7) and exhaust valves (7) in the respective positions.
3. Install valve spring seat washers (6).
4. Install new seals (5).
5. Install inner springs (3) and outer springs (4).

Note: Install inner springs (3) and outer springs (4) on the valve spring seat washers with the damper coils toward the cylinder head. This is done with double valve springs. If single valve springs are used, the springs can be installed in either way.

6. Install valve spring retainers (2).



The valve keepers can be thrown from the valve when the valve spring compressor is released. Ensure that the valve keepers are properly installed on the valve stem. To help prevent personal injury, keep away from the front of the valve keepers and valve springs during the installation of the valves.

7. Use Tooling (A) to compress inner springs (3) and outer springs (4).

Note: Some engines may have only a single inlet valve spring and a single exhaust valve spring.

8. Install valve keepers (1).

9. Slowly release the pressure on Tooling (A) and remove Tooling (A). Strike the top of the valves with a soft hammer in order to ensure that the valve keepers are properly installed.

Note: Refer to Specifications, RENR2401, "Cylinder Head Valves" for more information on inlet valves and exhaust valves.

10. Use a dial indicator to check the depth of the new valves below the cylinder head. If the depth of the new valves is below the correct depth, the valve seat inserts must be replaced. Refer to Disassembly and Assembly, "Inlet and Exhaust Valve Seat Inserts - Remove and Install".

End By:

- a. Install the cylinder head assembly. Refer to Disassembly and Assembly, "Cylinder Head - Install".
-

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i01739745

Inlet and Exhaust Valve Guides - Remove and Install

SMCS - 1104-010

Removal Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	1U-9169	Valve Guide Driver	1

Start By:

- Remove the inlet valves and the exhaust valves. Refer to Disassembly and Assembly, "Inlet and Exhaust Valves - Remove and Install".

NOTICE

Keep all parts clean from contaminants.

Contaminants may cause rapid wear and shortened component life.

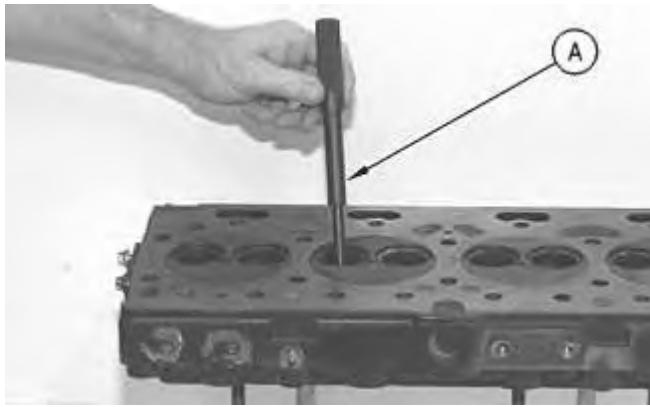


Illustration 1

g00632175

Typical example

1. Use Tooling (A) in order to remove the valve guides from the cylinder head.
2. Repeat the procedure for the remaining valve guides.

Installation Procedure

Table 2

Required Tools			
Tool	Part Number	Part Description	Qty
A	1U-9169	Valve Guide Driver	1
B	9U-6220	Stop Collar	1
C	157-3720	Valve Seat Cutter	1

NOTICE

Keep all parts clean from contaminants.

Contaminants may cause rapid wear and shortened component life.

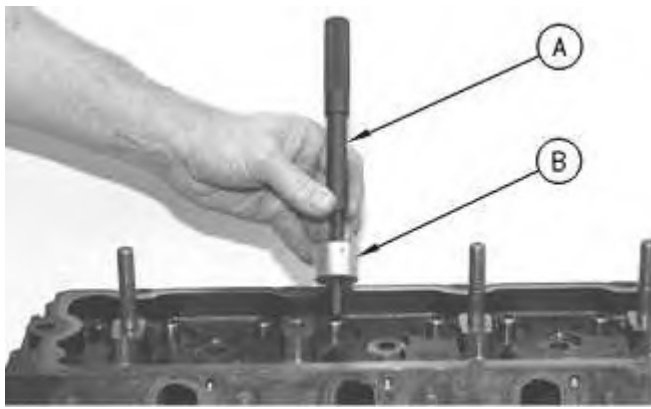


Illustration 2

g00632176

Typical example

1. Put the valve guide in position. Carefully tap the valve guide in order to start the installation. Use Tooling (A) and Tooling (B) to seat the valve guide in the cylinder head.

Note: After installing the unfinished valve guides and valve seat inserts, you must ream the valve guides and valve seat inserts to the finished diameter. The valve guides and valve seat inserts are cut and reamed in one operation. This operation is performed by using the **157-3720** Valve Seat Cutter. Refer to Specifications, RENR2401, "Cylinder Head Valves" for the finished diameter of the valve guides and valve seat inserts.

2. Check the protrusion of the valve guides. The valve guides should protrude 14.85 to 15.15 mm (0.585 to 0.597 inch) above the valve spring recess.
3. Repeat the procedure for the remaining valve guides.

End By:

- a. Install the inlet valves and the exhaust valves. Refer to Disassembly and Assembly, "Inlet and Exhaust Valves - Remove and Install".
-

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i01739794

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	9U-6396	Inlet Valve Seat Extractor	1
	9U-6397	Exhaust Valve Seat Extractor	1
	9S-3095	Puller Handle	1

Start By:

- a. Remove the inlet valves and the exhaust valves. Refer to Disassembly and Assembly, "Inlet and Exhaust Valves - Remove and Install".

NOTICE

Keep all parts clean from contaminants.

Contaminants may cause rapid wear and shortened component life.

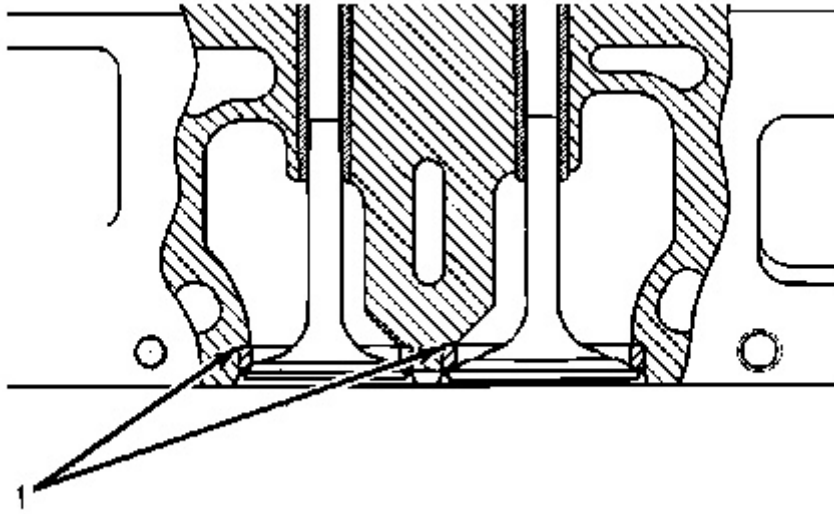


Illustration 1

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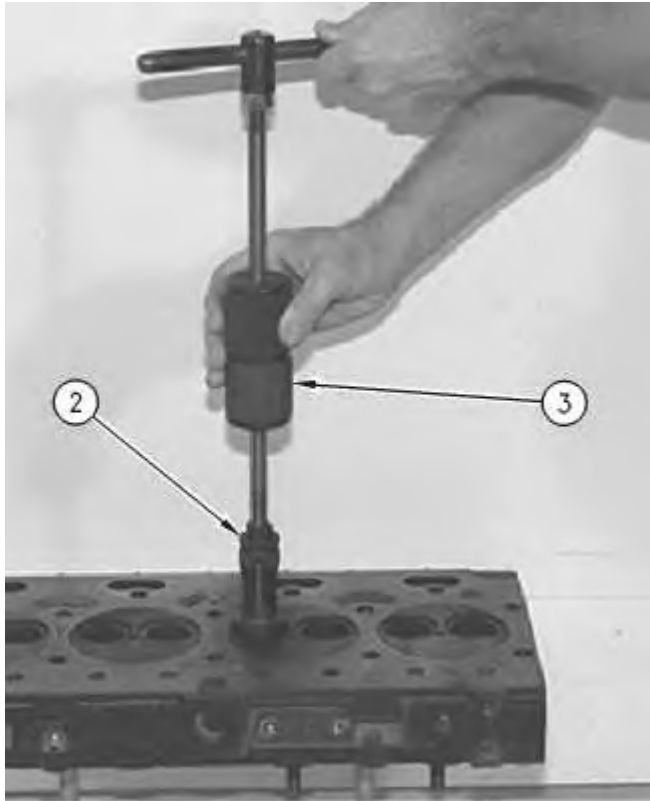


Illustration 2

g00632297

1. Use Tooling (A) with appropriate extractor (2) and channel (3) in order to remove valve seat inserts (1).
2. Remove valve seat inserts (1) from the cylinder head.
3. Repeat the procedure for the remaining valve seat inserts.

Installation Procedure

Table 2

Required Tools			
Tool	Part Number	Part Description	Qty
A	9U-6183	Valve Seat Driver	1
	9U-6184	Valve Seat Driver	1
	9U-6185	Valve Seat Driver	1
	157-3716	Valve Seat Driver ⁽¹⁾	1
	157-3717	Valve Seat Driver ⁽¹⁾	1

⁽¹⁾ This tool is used for valve guides and valve seats that are not finished.

NOTICE

Keep all parts clean from contaminants.

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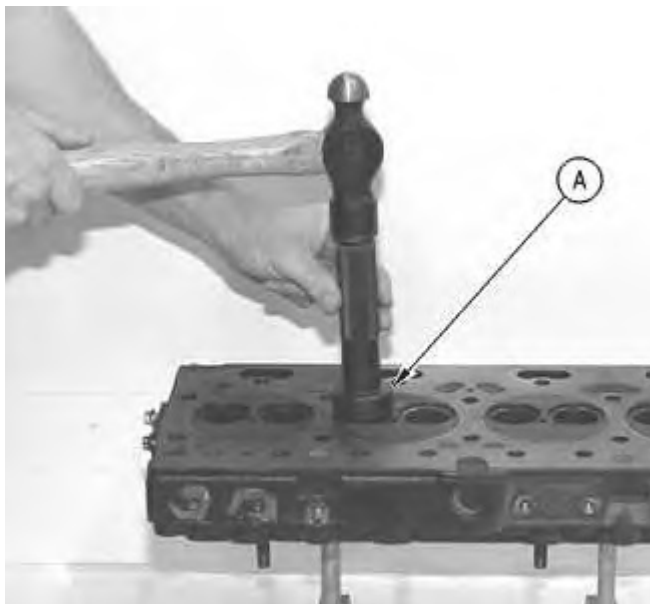


Illustration 3

g00803886

1. Use the appropriate parts of Tooling (A) in order to install the valve seat insert into the cylinder head assembly.
2. Repeat the procedure for the remaining valve seat inserts.

Note: Refer to the Specifications Module for more information on the valve seat inserts.

End By:

- a. Install the inlet valves and the exhaust valves. Refer to Disassembly and Assembly, "Inlet and Exhaust Valves - Remove and Install".
-

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i01064329

Engine Oil Filter Base - Remove

SMCS - 1306-011

Removal Procedure

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.

Refer to Special Publication, NENG2500, "Caterpillar Tools and Shop Products Guide" for tools and supplies suitable to collect and contain fluids on Caterpillar products.

Dispose of all fluids according to local regulations and mandates.

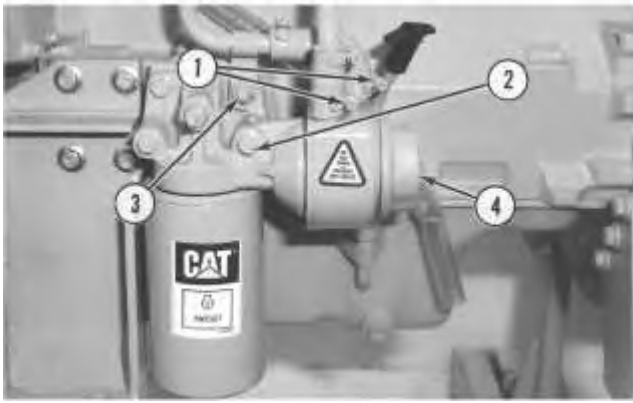


Illustration 1

g00554000

Typical example

1. Loosen two hose clamps (1) and disconnect the hoses.
 2. Remove three bolts (2) .
 3. Remove nut (3) that holds the hose clamp and move the hose clamp.
 4. Remove engine oil filter base (4) from the engine block. Plug all openings immediately.
-

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i01064521

Engine Oil Filter Base - Disassemble

SMCS - 1306-015

Disassembly Procedure

Start By:

- A. Remove the engine oil filter base. Refer to Disassembly and Assembly, "Engine Oil Filter Base - Remove".

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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Dispose of all fluids according to local regulations and mandates.

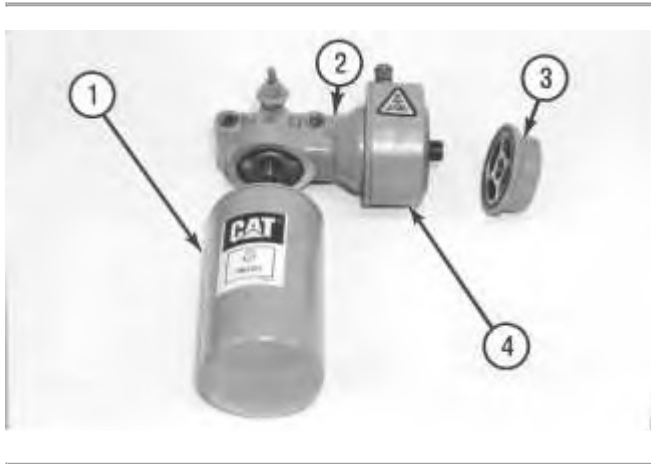


Illustration 1

g00554208

Typical example

1. Remove engine oil filter (1) from engine oil filter base (2) .
 2. Remove cap (3) from engine oil cooler (4) (if equipped).
 3. Remove engine oil cooler (4) from engine oil filter base (2), if necessary.
-

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