

Product: EXCAVATOR
Model: 325C EXCAVATOR BLX
Configuration: ISJ HEX COMMONALITY CHART BLX00001-UP (MACHINE)

Disassembly and Assembly 3126B Engines for Caterpillar Built Machines

Media Number -SEN9581-06

Publication Date -01/08/2018

Date Updated -17/08/2018

i02374873

Inlet and Exhaust Valves - Remove and Install

SMCS - 1105-010

Removal Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	5S-1330	Valve Spring Compressor	1

Start By:

- 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.

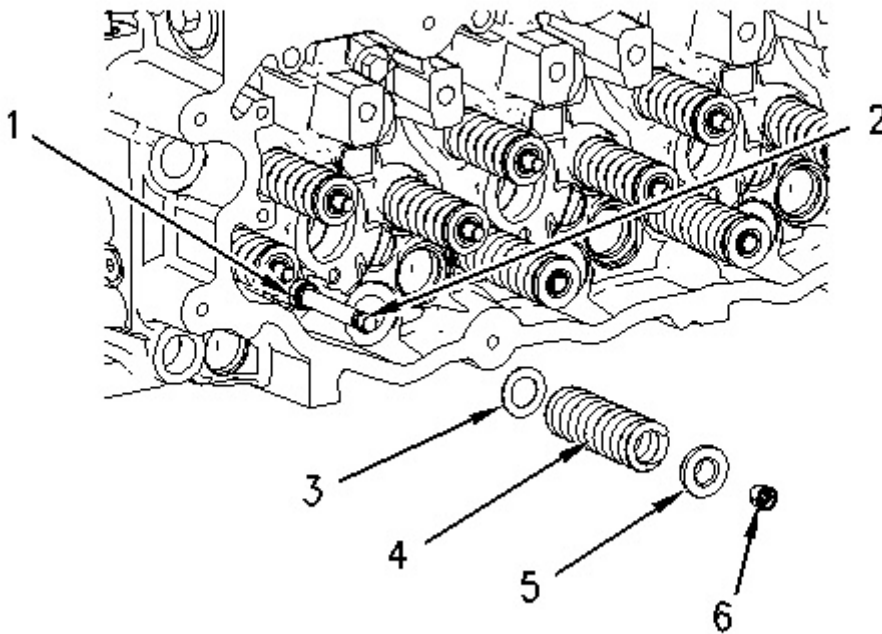


Illustration 1

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WARNING

Personal injury can result from being struck by parts propelled by a released spring force.

Make sure to wear all necessary protective equipment.

Follow the recommended procedure and use all recommended tooling to release the spring force.

1. Use Tooling (A) to compress valve spring (4). Remove retainer lock (6).
2. Remove Tooling (A). Remove spring retainer (5), valve spring (4), and washer (3).
3. Remove valve seal (1) and valve (2).
4. Repeat Steps 1 through 3 in order to remove the remaining inlet valves and exhaust valves.

Installation Procedure

Table 2

Required Tools			
Tool	Part Number	Part Description	Qty
A	5S-1330	Valve Spring Compressor	1

NOTICE

Keep all parts clean from contaminants.

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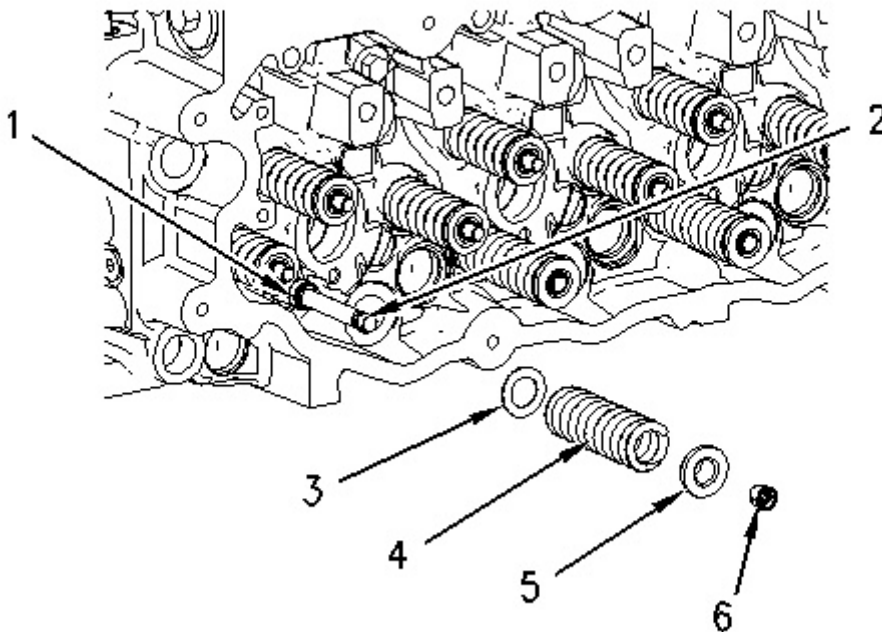


Illustration 2

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⚠ WARNING

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

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

1. Lubricate valve (2) with clean engine oil. Install valve (2) in the cylinder head assembly. Install new valve seal (1) onto the valve guide.
2. Place the following items on the valve stem: washer (3), valve spring (4) and spring retainer (5).

Note: A small amount of grease can be used to hold the retainer locks in position during installation.

3. Use Tooling (A) to compress valve spring (4). Install retainer lock (6).
4. Repeat Steps 1 through 3 in order to install the remaining inlet valves and exhaust valves.

End By:

- a. Install the cylinder head assembly. Refer to Disassembly and Assembly, "Cylinder Head - Install".
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i01979506

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-7793	Valve Guide Driver	1
B	9U-6895	Valve Guide Driver	1

Start By:

- Remove the inlet and 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.

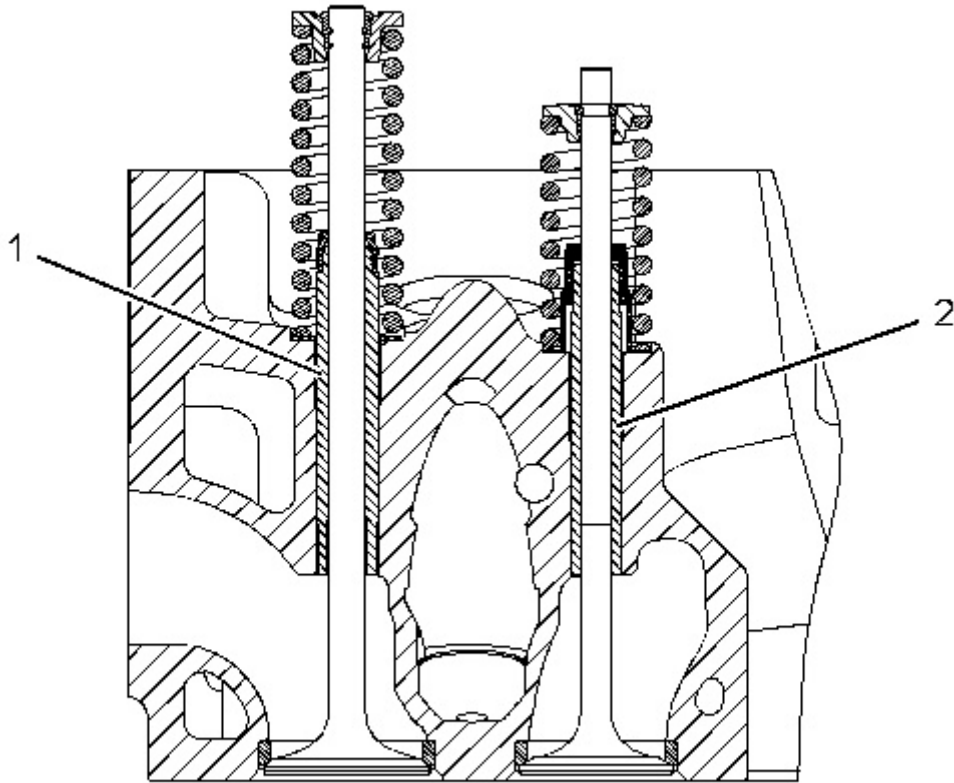


Illustration 1

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1. Use Tooling (A) to remove inlet valve guides (2) from the cylinder head assembly. Use Tooling (B) to remove exhaust valve guides (1) from the cylinder head assembly.

Installation Procedure

Table 2

Required Tools			
Tool	Part Number	Part Description	Qty
A	1U-7793	Valve Guide Driver	1
B	9U-6895	Valve Guide Driver	1
C	1U-7792	Guide Collar	1
D	149-4008	Guide Collar	1

NOTICE

Keep all parts clean from contaminants.

Contaminants may cause rapid wear and shortened component life.

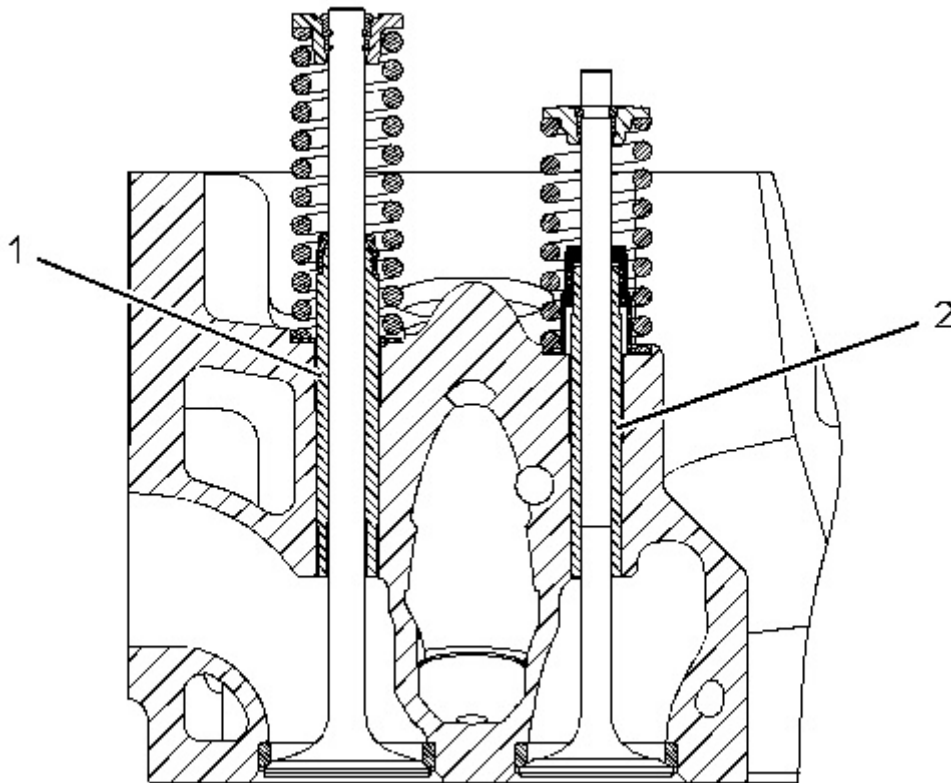


Illustration 2

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1. Position inlet valve guide (2) and tap on the top of inlet valve guide (2).
2. Use Tooling (A) and Tooling (C) to install inlet valve guide (2). Install inlet valve guides (2) until the protrusion is 23.0 ± 0.5 mm (0.90 ± 0.02 inch) above the cylinder head assembly.
3. Use Tooling (B) and Tooling (D) to install exhaust valve guide (1). Install exhaust valve guide (1) until the protrusion is 17.8 ± 0.5 mm (0.70 ± 0.02 inch) above the cylinder head assembly.

End By:

- a. Install the inlet and exhaust valves. Refer to Disassembly and Assembly, "Inlet and Exhaust Valves - Remove and Install".
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i02368759

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 ⁽¹⁾	6V-4194	Valve Seat Extractor	1
B ⁽¹⁾	165-5647	Valve Seat Extractor	1
C ⁽¹⁾	6V-4804	Handle	1
D ⁽¹⁾	6V-4192	Shaft	1
E ⁽¹⁾	6V-4199	Lifting Bracket	1

⁽¹⁾ Part of the 166-7441 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".

NOTICE

Keep all parts clean from contaminants.

Contaminants may cause rapid wear and shortened component life.

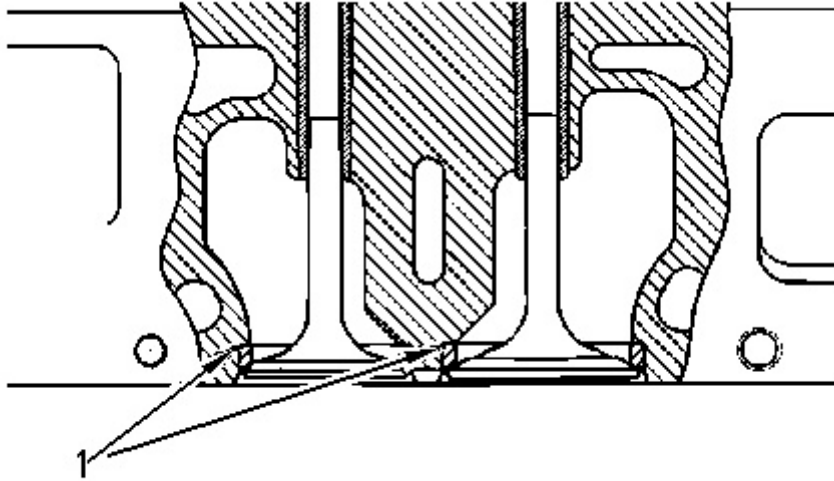


Illustration 1

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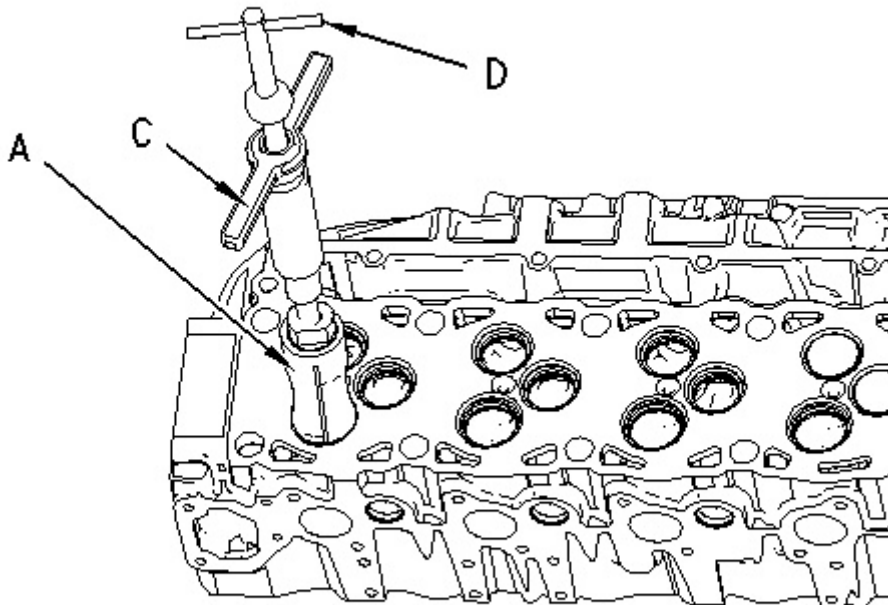


Illustration 2

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Note: Replace Tooling (A) with Tooling (B) for the removal of the inlet valve seat insert.

1. Install Tooling (A) in the exhaust valve seat insert.

2. Install Tooling (C) and Tooling (D) in Tooling (A). Hand tighten Tooling (D). Tooling (A) will expand below the edge of valve seat insert (1).
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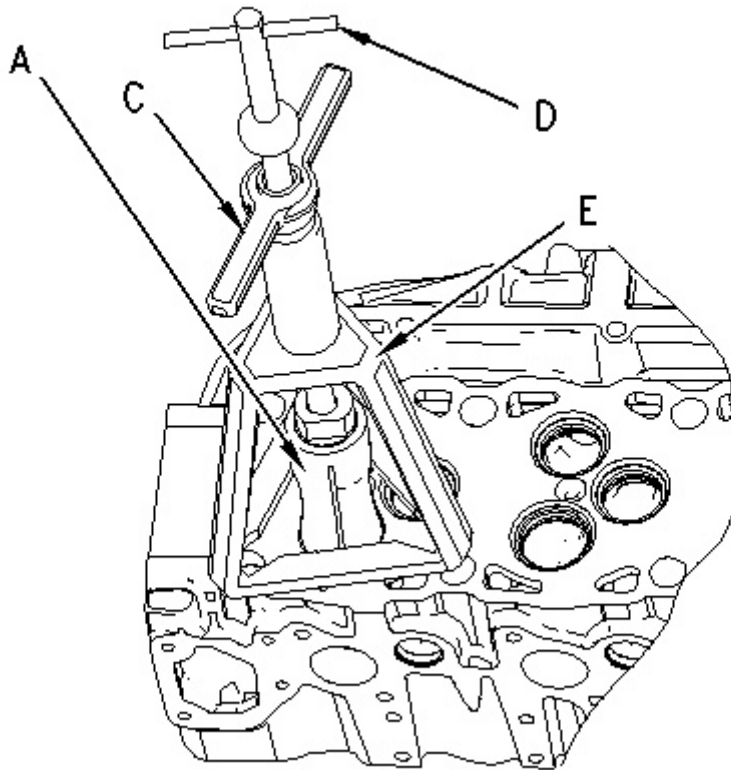


Illustration 3

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3. Install Tooling (E) on the cylinder head under Tooling (C). Hold Tooling (D) while you turn Tooling (C). Remove valve seat (1).

Installation Procedure

Table 2

Required Tools			
Tool	Part Number	Part Description	Qty
F	149-6115	Installer	1

NOTICE

Keep all parts clean from contaminants.

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