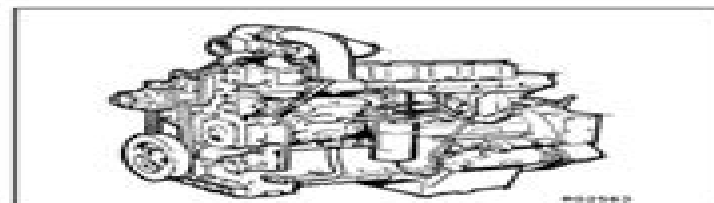


## 3306

### Engine Design

|                                   |                    |
|-----------------------------------|--------------------|
| Bore                              | 120 mm (4.75 inch) |
| Stroke                            | 152 mm (6.00 inch) |
| Number of Cylinders               | 6                  |
| Cylinder Arrangement              | Inline             |
| Firing Order (Injection Sequence) | 1, 5, 3, 6, 2, 4   |
| Direction of Rotation             | Counterclockwise   |
| Mounting (from Flywheel end)      |                    |



## Engine Assembly Procedure Spacer Plate Engines

Q - Denotes Critical Checkpoints

| Sub-Assembly Parts                                                                        | Sub-Assembly                                       | Installation Sequence | Parts Assembly Procedure                                                                                                                                                                            |
|-------------------------------------------------------------------------------------------|----------------------------------------------------|-----------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Block Covers<br>Flange Liners<br>Crankshaft Bearings                                      | Block Assembly                                     | Q - 1                 | Clean oil passages.<br>Check liner projection.                                                                                                                                                      |
|                                                                                           |                                                    | 2                     | Position block on engine.<br>Install and torque main drive bolts up.                                                                                                                                |
|                                                                                           |                                                    | 3                     | Install main bearings to block and liner.                                                                                                                                                           |
|                                                                                           |                                                    | 4                     | Oil main bearings.                                                                                                                                                                                  |
| Crankshaft Gear                                                                           | Crankshaft Assembly                                | 5                     | Install crankshaft and thrust plates.                                                                                                                                                               |
|                                                                                           |                                                    | Q - 6                 | Install and torque main bearing caps.                                                                                                                                                               |
| Connecting Rods<br>Flange<br>Pistons<br>Pin Bearings                                      | Piston & Rod Assembly                              | Q - 7                 | Slide crankshaft and check end play.                                                                                                                                                                |
|                                                                                           |                                                    | 8                     | Oil pins, rings and bearings.                                                                                                                                                                       |
|                                                                                           |                                                    | Q - 9                 | Install pistons and rod caps. Check adjustment of 10° marks on pistons and cylinder bores.                                                                                                          |
|                                                                                           |                                                    | Q - 10                | Torque rod nuts.                                                                                                                                                                                    |
|                                                                                           |                                                    | Q - 11                | Install crankshaft and flywheel end play.                                                                                                                                                           |
| Flywheel Housing Cover<br>Flange<br>Bolt<br>Sleeve                                        | Flywheel Housing Assembly                          | 12                    | Install flywheel housing.                                                                                                                                                                           |
|                                                                                           |                                                    | Q - 13                | Check flywheel housing cover and torque nut.                                                                                                                                                        |
|                                                                                           |                                                    | 14                    | Install wear sleeve and nut to crankshaft and flywheel housing.                                                                                                                                     |
|                                                                                           |                                                    | Q - 15                | Install flywheel and torque.                                                                                                                                                                        |
|                                                                                           |                                                    | Q - 16                | Check flywheel bolt and nut torque.                                                                                                                                                                 |
| Pump, Oil<br>Tube Assembly<br>Suction Bolt                                                | Oil Pump Assembly                                  | 17                    | Install oil pump timing plate.                                                                                                                                                                      |
|                                                                                           |                                                    | 18                    | Install oil pump plate.                                                                                                                                                                             |
|                                                                                           |                                                    | 19                    | Install oil pump.                                                                                                                                                                                   |
|                                                                                           |                                                    | 20                    | Install oil pan.                                                                                                                                                                                    |
|                                                                                           |                                                    | 21                    | Set engine height.                                                                                                                                                                                  |
|                                                                                           |                                                    | 22                    | Put No. 1 piston at top center. Put timing belt on flywheel.                                                                                                                                        |
| Crankshaft Gear                                                                           | Crankshaft Assembly                                | Q - 23                | Install crankshaft, thrust washers, gear & torque.                                                                                                                                                  |
|                                                                                           |                                                    | 24                    | Install fuel pump drive gear.                                                                                                                                                                       |
| Accessory Drive Assembly<br>Pump<br>Governor<br>Gear<br>Fuel Filter<br>Fuel Transfer Pump | Fuel Injection Assembly<br>Governor<br>Fuel System | Q - 25                | a. Time fuel pump camshaft on timing pin.<br>b. Install fuel injection pump housing assembly and fuel<br>c. Install fuel pump drive gear and torque.<br>d. Install fuel pump and governor assembly. |

### Crankshaft

**Note:** There are holes in the bores for the main bearings, between cylinders 1 and 2, 3 and 4, 5 and 6 for piston cooling surfaces. These holes must have proper oil flow. Install 8 in this information in Oil Lubrication in your engine manual.

**Note:** If a turbocharger is installed on engine, be sure to install oilers.

**Note:** If oiler is installed on engine, install oiler at 100°.

|                                                                                                                            |                                          |
|----------------------------------------------------------------------------------------------------------------------------|------------------------------------------|
| 1. Connecting Rod Journal Diameter                                                                                         | 76.180 ± 0.025 mm (2.9992 ± 0.0008 inch) |
| Connecting Rod Journal to Bearing Clearance                                                                                | 0.057 to 0.125 mm (0.0022 to .0051 inch) |
| 2. Main Bearing Journal Diameter                                                                                           | 88.880 ± 0.020 mm (3.4992 ± 0.0008 inch) |
| Main Bearing Journal to Bearing Clearance                                                                                  | 0.027 to 0.125 mm (0.0011 to .0051 inch) |
| 3. Do not heat gear or wear sleeve to more than 110°C (230°F) before installation.                                         |                                          |
| 4. Crankshaft End Play                                                                                                     | 0.102 to 0.576 mm (0.0040 to .0228 inch) |
| 5. Clearance between main bearing cap and cylinder block - 0.003 mm (0.00012 inch). Tight to 0.043 mm (0.0017 inch) Loose. |                                          |
| Main bearing cap to crankshaft block - 0.025 to 0.025 mm (0.001 to 0.001 inch)                                             |                                          |
| Wiper of cylinder block for 165-190-1-0-018 mm (0.5905-0.7500 inch) main bearing cap                                       |                                          |

**Note:** If the width between the shoulders of the rear main bearing (journal) is 40.411 to 40.415 mm (1.5910 to 1.5910 inch) (100-3650 Thru Shaft). If the width is 42.749 to 43.003 mm (1.683 to 1.693 inch) install 794-0543 Thrust Plate.

| Sub-Assembly Parts                                         | Sub-Assembly                                                 | Installation Sequence | Parts Assembly Procedure                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |
|------------------------------------------------------------|--------------------------------------------------------------|-----------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Pump Governor<br>Fuel Filter<br>Gear                       | Fuel Injection Assembly<br>Governor<br>Timing<br>Fuel System | Q - 26                | a. Time fuel pump camshaft on timing pin.<br>b. Install fuel injection pump housing assembly and fuel<br>c. Install fuel pump drive gear and torque.<br>d. Install valve lifters.<br>e. Install governor and spacer plate.<br>f. Install governor and cylinder head.<br>g. Install pump nuts.<br>h. Install governor arm assembly.<br>i. Torque cylinder head and rocker arm bolts.<br>j. Adjust valve lash.<br>k. Install valve cover, bracket and glow plug heads.<br>l. Install front housing. |
| Plate<br>Cylinder Head<br>Push Rods<br>Rocker Arm Assembly | Cylinder Head Assembly                                       | 27                    |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |
|                                                            |                                                              | 28                    |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |
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|                                                            |                                                              | 34                    |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |
| Housing                                                    | Front Housing Assembly                                       | 35                    |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |
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| Pump Governor<br>Block                                     | Water Pump Assembly                                          | Q - 39                |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |
|                                                            |                                                              | 40                    |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |
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### Torque Procedure

|                                                   |
|---------------------------------------------------|
| a. Put SAE 30 oil on threads and nut seat.        |
| b. Tighten both nuts to 40 ± 4 Nm (30 ± 3 ft-lb). |
| c. Mark each nut and end of bolt.                 |
| d. Tighten both nuts from mark 90° ± 5°.          |

### Main Bearing Bolt

|                                                                                  |
|----------------------------------------------------------------------------------|
| a. Put SAE 30 oil on 6V-90T6 Molybdenum Paste Lubricant on threads and nut seat. |
| b. Tighten all bolts to 40 ± 4 Nm (30 ± 3 ft-lb).                                |
| c. Mark each bolt and nut.                                                       |
| d. Tighten all bolts from mark 90° ± 5°.                                         |



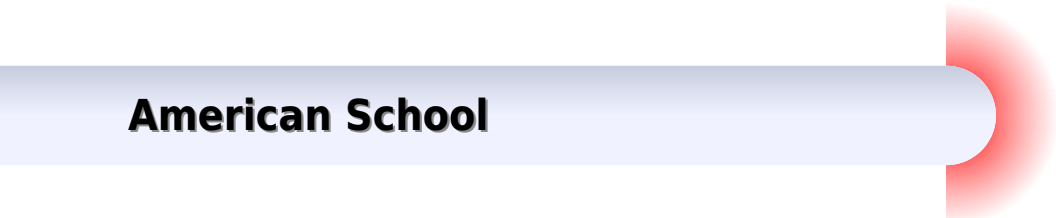
| Part No. | Year, Make and Model | Tools Required |
|----------|----------------------|----------------|
| 10-1011  | 1994-1995            | 10-1011        |
| 10-1011  | 1996-1997            | 10-1011        |
| 10-1011  | 1998-1999            | 10-1011        |



Always use the correct torque sequence for each bolt. Do not use the correct torque sequence for each bolt.

# Cat 3406e Valve Adjustment Manual

**American School**



## **Cat 3406e Valve Adjustment Manual:**

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