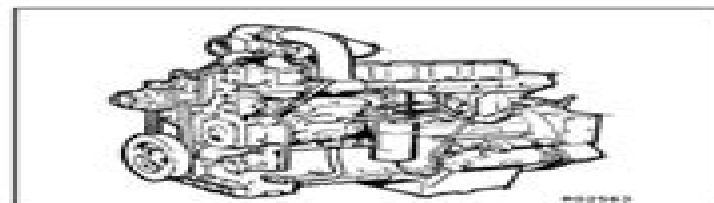


3306

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 Flange Links Crankshaft Bearings	Block Assembly	Q - 1	Clean oil passages. Check liner projection.
		2	Position block on engine. Install and torque drive side up.
		3	Install main bearings to side and drive.
		4	Oil main bearings.
Crankshaft Gear	Crankshaft Assembly	5	Install crankshaft and thrust plates.
		Q - 6	Install and torque main bearing caps.
Connecting Rods Flange Pins Pin Bearings	Piston & Rod Assembly	Q - 7	Slide crankshaft and check end play.
		8	Oil pins, flange and bearings.
		Q - 9	Install pistons and rod caps. Check alignment of 1st pin on pistons and cylinder bore.
		Q - 10	Torque rod nuts.
		Q - 11	Install crankshaft and flywheel end play.
Flywheel Housing Cover Flange Pin Bolt	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 Tube Assembly Bushing Bolt	Oil Pump Assembly	17	Install oil pump timing plate.
		18	Install oil pump plate.
		19	Install oil pump.
		20	Install oil pin.
		21	Set engine height.
		22	Put No. 1 pin on 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 Pump Governor Gear Fuel Filter Fuel Transfer Pump	Fuel Injection Assembly Governor Fuel System	Q - 25	a. Time fuel pump camshaft on timing pin. b. Install fuel injection pump housing assembly and fuel c. Install fuel pump drive gear and torque. 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 oiler tubes installed. Refer this information in Oil Lube in the parts book for your engine arrangement.

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

Note: If oiler tubes installed on engine, install oiler at 1000.

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 185-180 1-0-018 mm (0.0069 to 0.0069 inch) main bearing cap	

Note: If the width between the shoulders of the rear main bearing (journal is 82.411 to 88.415 mm (3.2445 to 3.4807 inch) 100-3650 Thru Shaft). If the width is 82.749 to 83.003 mm (3.2578 to 3.2680 inch) install 794-0543 Thrust Plate.

Sub-Assembly Parts	Sub-Assembly	Installation Sequence	Parts Assembly Procedure
Pump Governor Fuel Filter Gear	Fuel Injection Assembly Governor Timing Fuel System	Q - 26	a. Time fuel pump camshaft on timing pin. b. Install fuel injection pump housing assembly and fuel c. Install fuel pump drive gear and torque. d. Install valve lifters. e. Install governor and spacer plate. f. Install governor and cylinder head. g. Install pump nuts. h. Install governor arm assembly. i. Torque cylinder head and rocker arm bolts. j. Adjust valve lash. k. Install valve cover, bracket and glow plug heads. l. Install front housing.
Plate Cylinder Head Push Rods Rocker Arm Assembly	Cylinder Head Assembly	27	
		28	
		29	
		30	
		31	
		Q - 32	
		Q - 33	
		34	
Housing	Front Housing Assembly	35	
		36	
		37	
		38	
Pump Regulator Bolt	Water Pump Assembly	Q - 39	
		40	
		41	
		42	
		43	
		44	
		45	
		46	
		47	
		48	
		49	
		50	

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 Information	Tools Required
1-1000	1-1000	1-1000
1-1000	1-1000	1-1000
1-1000	1-1000	1-1000



Cat 3406e Valve Adjustment Manual

Tao Wei



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