

7. Coat the underside of the bolt heads and the threads of bolts (3) with clean engine oil. Install the inner bolts for the main bearing cap. Remove Tooling (2) and install the outer bolts for the main bearing cap.



Illustration 20 gm70000

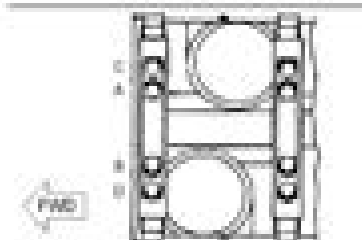


Illustration 21 gm70000
See tightening sequence for the main bearing cap.

8. Use Tooling (1) and Tooling (5) and tighten bolts (3) in sequence to a torque of 150 n·m (111 ft·lb) (140 ± 10 n·m).
9. Place an index mark on the bolts and the main bearing cap. Tighten the bolts for an additional 150 ± 5 degrees (1/2 turn).

10. Rotate the crankshaft in order to ensure that the crankshaft turns freely.

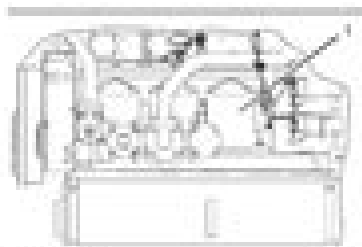


Illustration 22 gm70000

11. Install side covers (1) onto the cylinder block.

End By:

- a. Install the oil pump. Refer to Disassembly and Assembly, "Engine Oil Pump - Install".

Pistons and Connecting Rods - Remove

SMCS Code: 1325-011

Removal Procedure

Tool Kit

Required Tools			
Tool	Part Number	Part Description	Qty.
A	86-1425	Bearing Oil P.	1
B	10-1001	Retaining Ring Pliers	1
C	271-0000	Expansion Ring	1

† The oil rated Engine Torque Tool is alternative tooling.

Start By:

- a. Remove the cylinder head. Refer to Disassembly and Assembly, "Cylinder Head - Remove".
- b. Remove the piston cooling jets. Refer to Disassembly and Assembly, "Piston Cooling Jets - Remove and Install".

NOTICE

Keep all parts clean from contaminants.

Contaminants may cause rapid wear and shortened component life.



Illustration 23 gm70000

1. Use Tooling (4) to rotate the crankshaft until bolts (1) can be removed.
2. Remove the carbon ridge from the top inside surface of the cylinder liner.
3. Inspect the connecting rod and connecting rod cap for the proper identification mark. The connecting rod and the connecting rod cap should have an etched number on the side. The number should match the cylinder number. Mark the connecting rod and the connecting rod cap, if necessary.

Note: Do not strain the connecting rod assembly.

4. Remove bolts (1) and connecting rod cap (2). Push the connecting rod until the piston rings are out of the cylinder liner.
5. Remove the piston and the connecting rod from the cylinder liner.

Note: Be careful not to damage the cylinder liner or the crankshaft journal during the removal of the piston and the connecting rod.

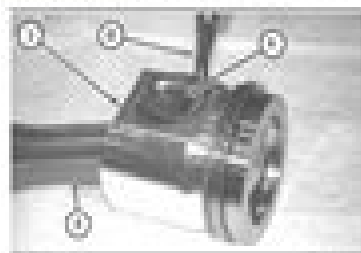


Illustration 24 gm70000

6. Use Tooling (5) to remove the retaining rings that hold piston pin (4). Remove piston pin (4). Remove piston (2) from connecting rod (3).

7. Remove the bearings from connecting rod (3) and the connecting rod cap.

Note: If necessary, separate the piston and/ or the piston crown.



Illustration 25 gm70000

8. Use Tooling (6) to remove piston rings (1) from piston (2).

Pistons and Connecting Rods - Install

SMCS Code: 1325-011

Installation Procedure

Tool Kit

Required Tools			
Tool	Part Number	Part Description	Qty.
A	86-1425	Bearing Oil P.	1
B	10-1001	Retaining Ring Pliers	1
C	271-0000	Expansion Ring	1
D	10-1010	Piston Ring Compressor	1
E	86-0015	Lubricant	1

† The oil rated Engine Torque Tool is alternative tooling.

NOTICE

Keep all parts clean from contaminants.

Contaminants may cause rapid wear and shortened component life.

Note: Install the connecting rod bearings (1) when clearance checks are performed. Refer to Disassembly and Assembly, "Bearing Clearance - Check". Apply clean engine oil on the connecting rod bearings for final assembly.

Cat Marine Engines Troubleshooting Guide

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Modern Marine Internal Combustion Engines Ievgen Bilousov, Mykola Bulgakov, Volodymyr Savchuk, 2020-06-30 This book offers a comprehensive and timely overview of internal combustion engines for use in marine environments It reviews the development of modern four stroke marine engines gas and gas diesel engines and low speed two stroke crosshead engines describing their application areas and providing readers with a useful snapshot of their technical features e g their dimensions weights cylinder arrangements cylinder capabilities rotation speeds and exhaust gas temperatures For each marine engine information is provided on the manufacturer historical background development and technical characteristics of the manufacturer s most popular models and detailed drawings of the engine depicting its main design features This book offers a unique self contained reference guide for engineers and professionals involved in shipbuilding At the same time it is intended to support students at maritime academies and university students in naval architecture marine engineering with their design projects at both master and graduate levels thus filling an important gap in the literature MotorBoating, 2000-03

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