

Disassembly and Assembly

3304B and 3306B Engines for Caterpillar Built Machines

Media Number -SENRS598-10

Publication Date -01/09/2020

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i00990466

Crankshaft Main Bearings - Remove

SMCS - 1203-011

Removal Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	2P-5518	Bearing Tool	1

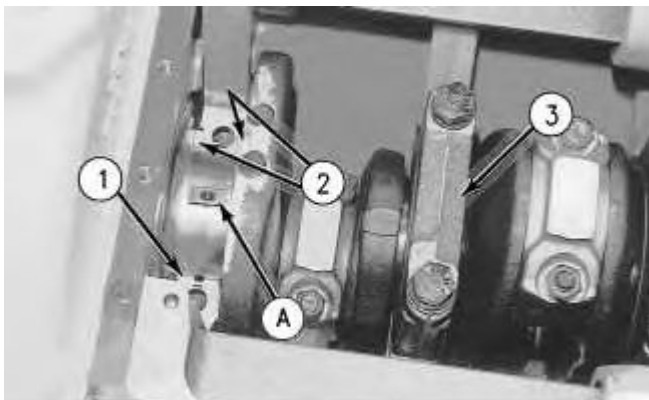
Start By:

- Remove the engine oil pump. Refer to Disassembly and Assembly, "Engine Oil Pump - Remove".
- Remove the oil pan plate. Refer to Disassembly and Assembly, "Engine Oil Pan Plate - Remove and Install".

NOTICE

Keep all parts clean from contaminants.

Contaminants may cause rapid wear and shortened component life.



1. Remove No. 1, 3, 5 and 7 main bearing caps (3). Remove the lower halves of the main bearings from the main bearing caps.

Note: If the crankshaft is turned in the wrong direction, the tab on the bearing will be pushed between the crankshaft and the bearing area in the cylinder block. This can result in damage to the cylinder block and/or the crankshaft.

2. Install Tool (A) in the oil hole in the crankshaft journal. Turn the crankshaft in order to remove the upper halves of main bearings (1).
3. Remove crankshaft thrust plates (2) from the crankshaft.
4. Install No. 1, 3, 5, and 7 main bearing caps (3). Refer to Disassembly and Assembly, "Crankshaft Main Bearings - Install".
5. Remove the remaining main bearing caps (No. 2, 4 and 6) (3). Remove the lower halves of the main bearings from the main bearing caps.

Note: If the crankshaft is turned in the wrong direction, the tab on the bearing will be pushed between the crankshaft and the bearing area in the cylinder block. This can result in damage to the cylinder block and/or the crankshaft.

6. Install Tool (A) in the hole in the crankshaft journal. Turn the crankshaft in order to remove the upper halves of main bearings (1).
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Crankshaft Main Bearings - Install

SMCS - 1203-012

Installation Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	2P-5518	Bearing Tool	1
B	-	Plastigage	-
C	8T-5096	Dial Indicator Group	1
D	-	SAE 30 Clean Engine Oil	-

NOTICE

Keep all parts clean from contaminants.

Contaminants may cause rapid wear and shortened component life.

Note: Install the main bearings dry when the clearance checks are made. Put clean engine oil on the main bearings for final assembly.

Note: Ensure that the upper halves and the lower halves of the main bearings are installed so that the bearing tabs fit into the notch in the cylinder block and in the main bearing caps.
