

bore in the block for new valve lifters must be  $33.388 \pm 0.025$  mm (.0010 in.). The maximum permissible clearance between the lifter and the bore for the valve lifter (worn) is 0.30 mm (.012 in.).

3. Put 2P2506 Thread Lubricant on the valve lifters and camshaft lobes. Install the valve lifters in original positions in the cylinder block.

End By:

- a. install cylinder head assembly and spacer plate

**Disassembly and Assembly**  
**3304 VEHICULAR ENGINE FOR 950B WHEEL LOADER**

Media Number -SENK3254-011

Publication Date -01/08/1997

Date Updated -11/19/2008

**Valves**

SMCS - 1105-010

**Remove and Install**

Tools Needed		A	B	C
5S1330	Valve Spring Compressor Assembly	1		
8S2263	Valve Spring Tester		1	
5S1322	Valve Keeper Insertor			1

Start By:

- a. remove fuel injection nozzles
- b. remove cylinder head assembly and spacer plate

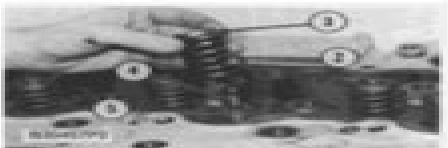


1. Put compression on valve spring (2) with tool (A), and remove locks (1).
2. Remove tool (A), rotocoil, spring, valve stem oil shield and valve. Put identification marks on valves with respect to their location in the cylinder head.



3. Check the spring force with tool (B). The spring force is  $257 \pm 25$  N ( $57.8 \pm 5.6$  lb.). The length of spring under test force is 44.86 mm (1.766 in.). The free length after test is 52.07 mm (2.050 in.).
4. Do Steps 1 through 3 again for the remainder of the valves.

**NOTE:** The following steps are for the installation of the valves.



# Caterpillar 950b 950e Wheel Loader Service Manual

**Caterpillar Inc. Peoria, Ill..**



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