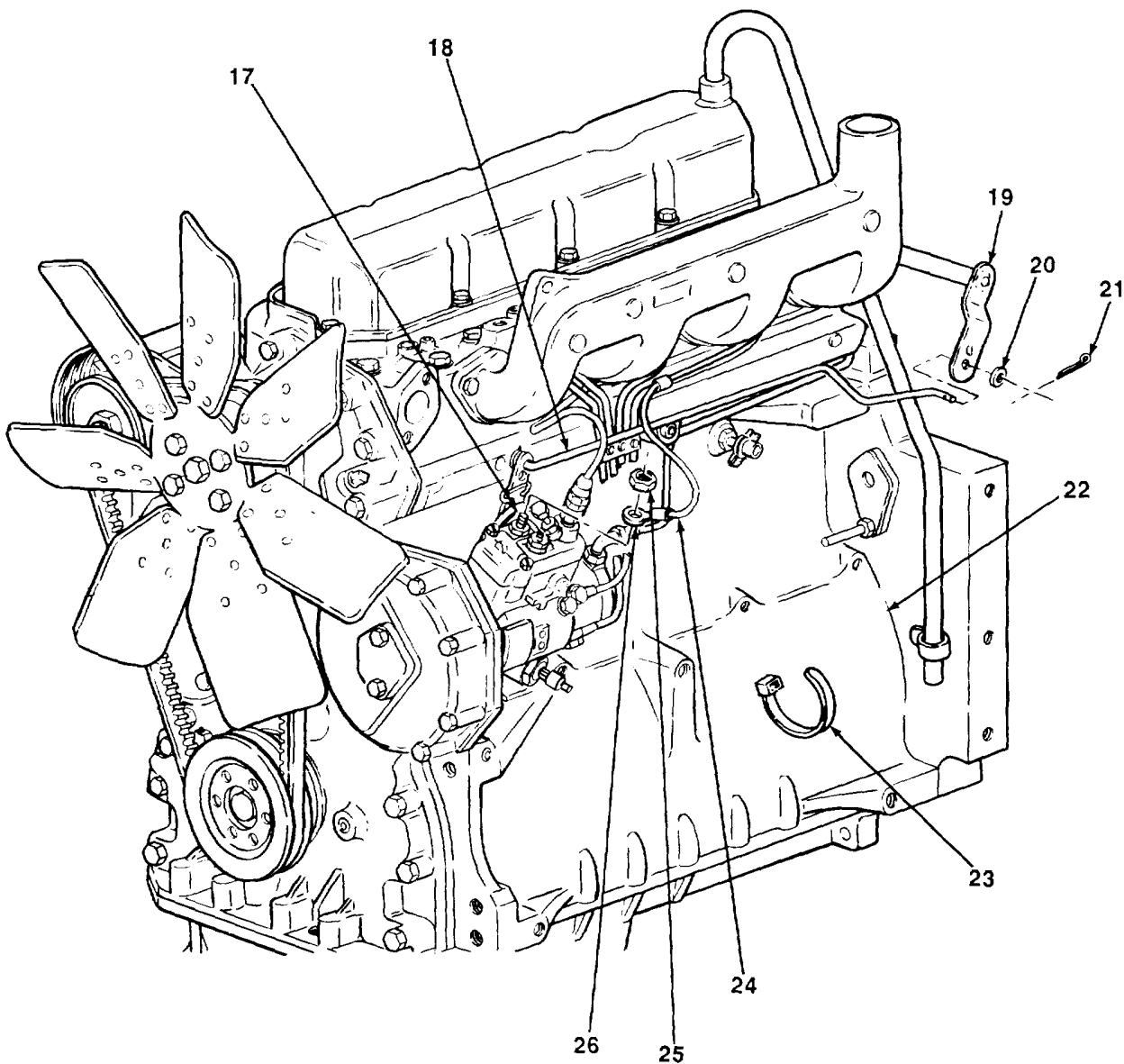


3-3. ENGINE ASSEMBLY REPLACEMENT (Con't).

16. Install main wiring harness fuel shutoff lead (24) in place on engine block (22). Install new tie-down bands (23) on main wiring harness fuel shutoff lead.
17. Position wiring harness terminal (26) in place on fuel injection pump shutoff solenoid terminal (17) and install new self-locking nut (25).
18. Remove adhesive tape from speed control rod (18) and engine block (22). Position speed control rod and washer (20) on shaft (19). Install new cotter pin (21) in shaft.

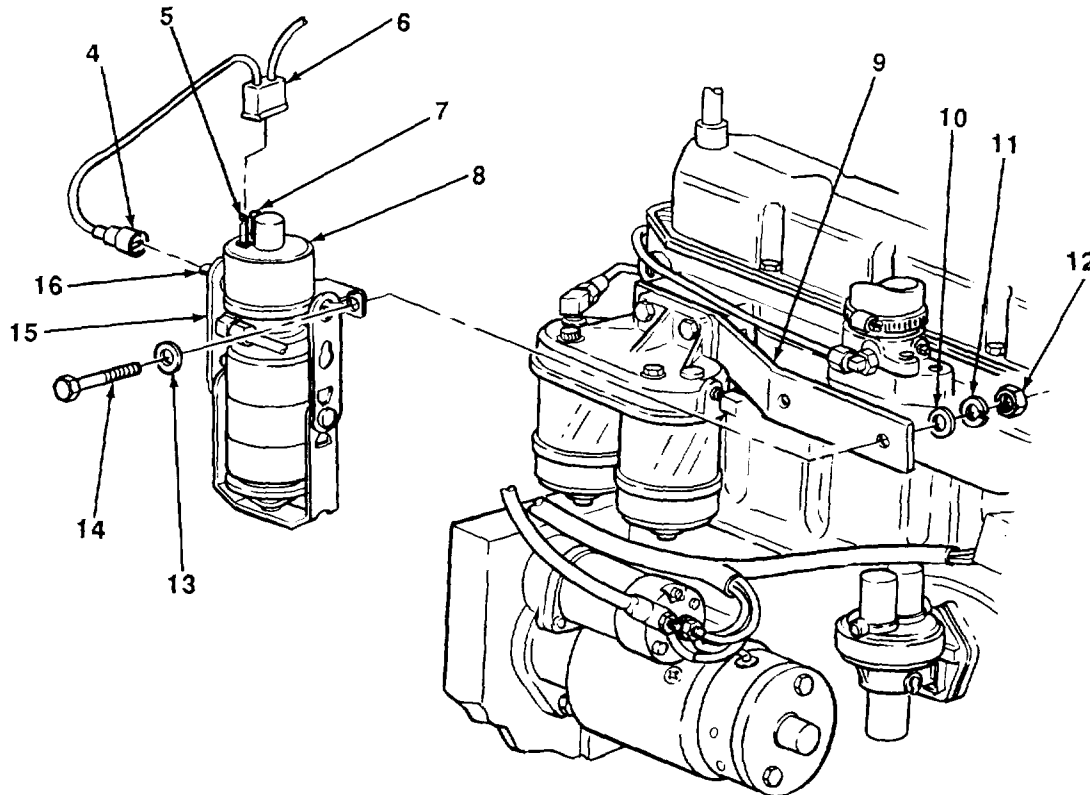


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3-3. ENGINE ASSEMBLY REPLACEMENT (Con't).**NOTE**

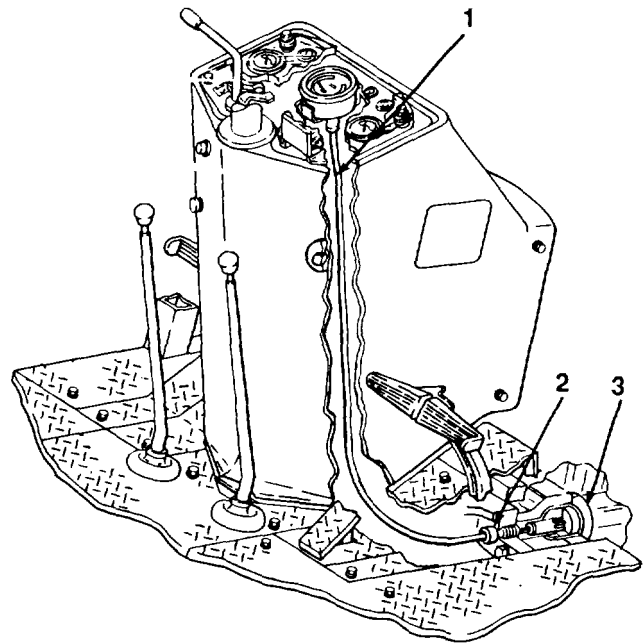
Steps 19 and 20 apply only to loader backhoes with serial numbers 235786-235999.

19. Position engine starting aid fluid injection solenoid (8) and bracket (15) on solenoid bracket (9) and secure with two screws (14), washers (10 and 13), new lockwashers (11), and nuts (12). Connect ground terminal (4) to terminal (16).
20. Install solenoid lead terminal (6) on engine starting aid fluid injection solenoid terminals (5 and 7).



3-3. ENGINE ASSEMBLY REPLACEMENT (Con't).

21. Install tachometer drive cable (1) and new gasket (2) in reverser housing (3).

**FOLLOW-ON TASKS:**

- Connect starter (see TM5-2420-222-20).
- Connect alternator (see TM5-2420-222-20).
- Install right inner platform ramp (see TM5-2420-222-20).
- Install accumulator tee-to-steering valve oil line (see TM5-2420-222-20).
- Install electric horn and bracket (see TM5-2420-222-20).
- Install steering valve oil lines (see TM5-2420-222-20).
- Install muffler (see TM5-2420-222-20).
- Install frame assembly front support (see paragraph 12-1).

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3-4. ENGINE BLOCK MAINTENANCE.*This Task Covers:*

- | | |
|----------------------------|-------------|
| a. Disassembly | c. Repair |
| b. Cleaning and Inspection | d. Assembly |

*Initial Setup:***Equipment Conditions:****NOTE**

Perform the following only on loader backhoes equipped with engine coolant heater.

- Engine coolant heater hoses and fittings removed (see TM5-2420-222-20).
- Engine coolant heater removed (see TM5-2420-222-20).

NOTE

Perform the following on all loader backhoes.

- Engine assembly removed (see paragraph 3-3).
- Cylinder block plate removed (see paragraph 3-7).
- Starter removed (see TM5-2420-222-20).
- Lubricating cooler (engine oil cooler) removed (see TM 5-2420-222-20).
- Flywheel housing removed (see paragraph 3-10).
- Cylinder sleeves removed (see paragraph 3-5).
- Crankshaft removed (see paragraph 3-8).
- Liquid level gage removed (see TM 5-2420-222-20).

Materials/Parts:

- Engine oil (Item 25, Appendix B)
- Rags (Item 28, Appendix B)
- Dry cleaning solvent (Item 31, Appendix B)
- Nonelectrical wire (Item 44, Appendix B)
- One crankshaft
- One rear bearing

Tools/Test Equipment:

- General mechanic's tool kit
- Field automotive shop set

Personnel Required: Two**General Safety Instructions:**

- Dry cleaning solvent is flammable and must not be used near open flame. Use only in a well ventilated area.
- Compressed air used for cleaning purposes should never exceed 30 psi (207 kPa).
- Avoid contact with live steam.

a. DISASSEMBLY

1. Remove four pipe plugs (14) from engine block (1).

NOTE

For loader backhoes equipped with engine coolant heater, skip step 2.

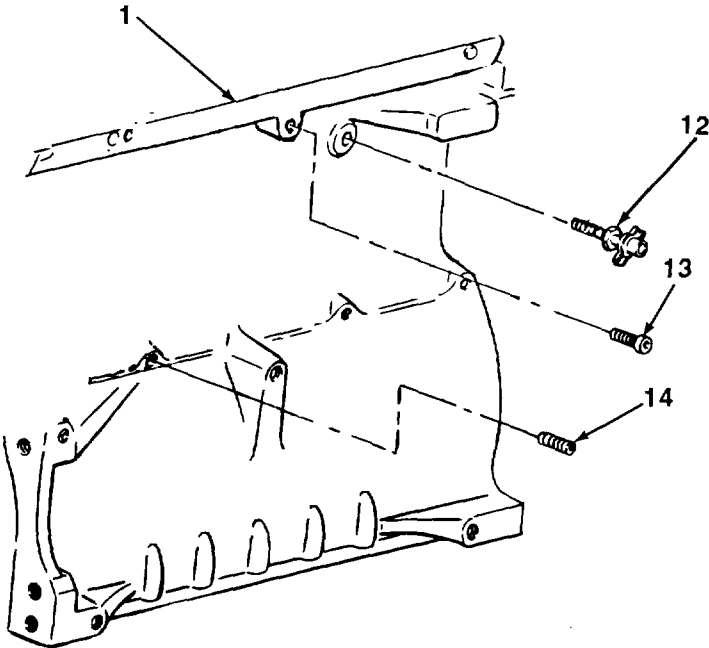
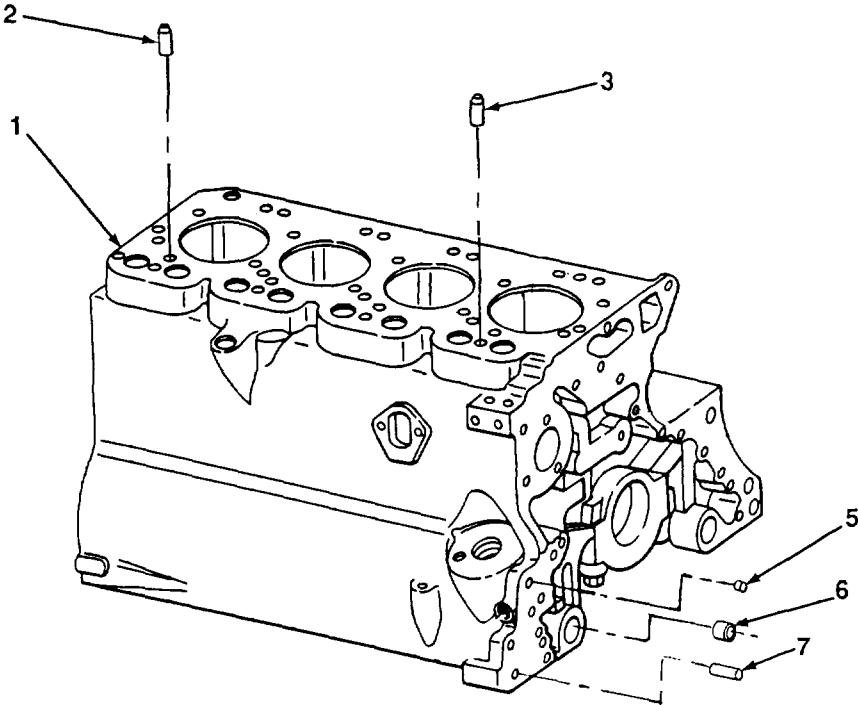
2. Remove pipe plug (13) and draincock (12) from engine block (1).

CAUTION

Do not remove pins, Studs, plugs, or sleeve bushing in steps 3 through 7 unless damaged. Removal may damage parts.

3. Remove two pins (2 and 3) from engine block (1).
4. Remove two plugs (5) from engine block (1).
5. Using gear and bearing mechanical puller, remove sleeve bushing (6) from engine block (1).
6. Remove two pins (7) from engine block (1).

3-4. ENGINE BLOCK MAINTENANCE (Con't).



3-4. ENGINE BLOCK MAINTENANCE (Con't).

7. Remove three studs (4) from engine block (1).
8. Remove side plug (8) from engine block (1).
9. Remove four fluid restrictors (11) from engine block (1).
10. Remove pipe plug (10) from engine block (1).

CAUTION

Do not remove pins unless damaged. Removal may damage parts.

11. Remove two pins (9) from engine block (1).

b. CLEANING AND INSPECTION**WARNING**

Avoid contact with live steam. Live steam can burn skin, cause blindness, and cause other serious injury. Be sure to wear protective apron, gloves, and safety goggles when using live steam.

1. Using steam cleaner, clean all internal passages and external holes and recesses of engine block free of corrosion, scaling, and foreign matter.

WARNING

Compressed air used for cleaning or drying purposes, or for clearing restrictions, should never exceed 30 psi (207 kPa). Wear protective clothing (goggles/shield, gloves, etc.) and use caution to avoid injury to personnel.

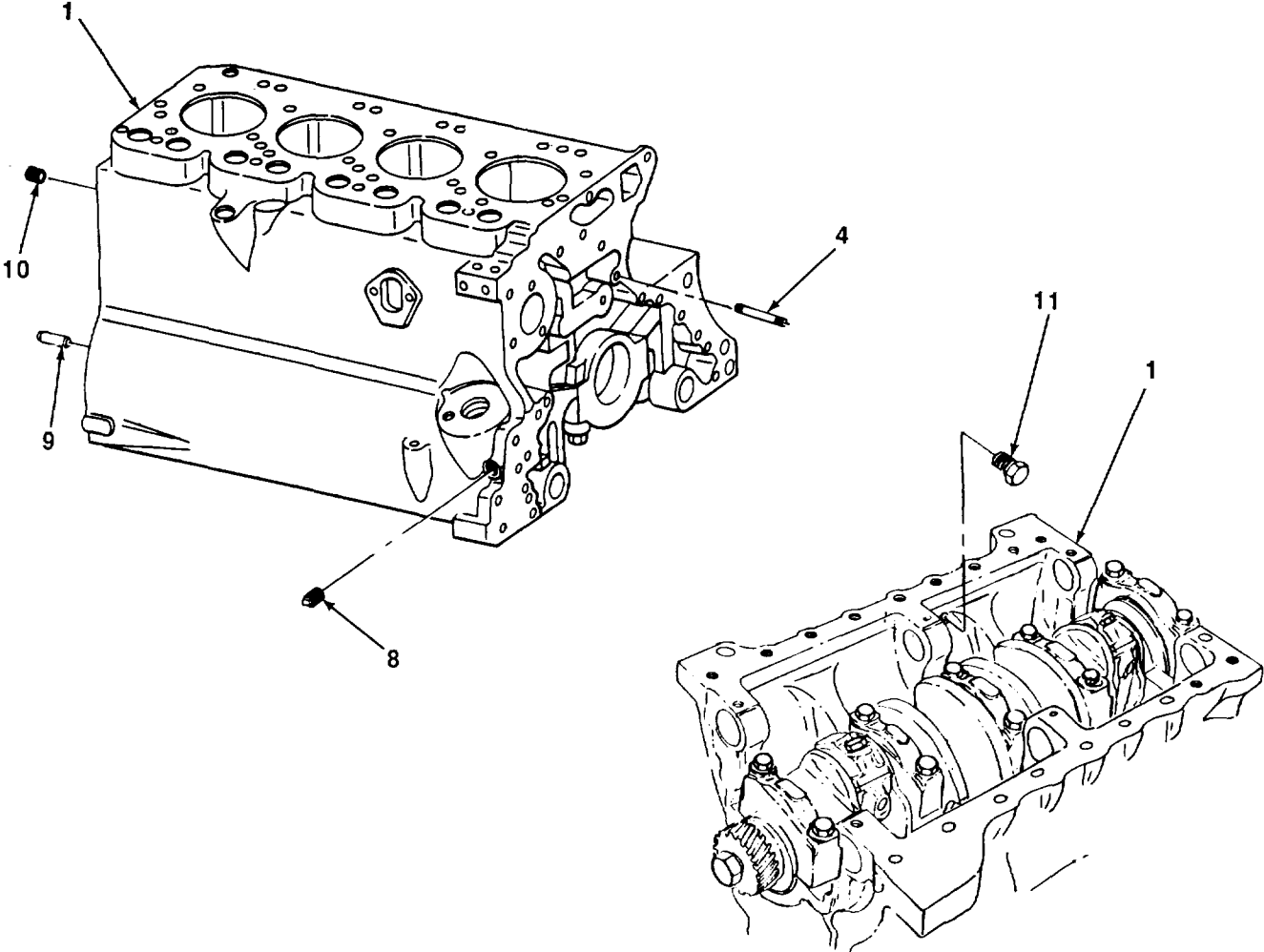
2. Turn engine block so deposits will run out. Flush internal passages and external holes and recesses with clean water. Dry engine block with compressed air.

WARNING

Dry cleaning solvent, P-D-680, is toxic and flammable. Always wear protective goggles and gloves, and use only in a well-ventilated area. Avoid contact with skin, eyes, and clothes, and DO NOT breathe vapors. DO NOT use near open flame or excessive heat. The solvent's flash point is 100°F-138°F (38°C-59°C). If you become dizzy while using cleaning solvent, immediately get fresh air and medical help. If solvent contacts eyes, immediately wash your eyes and get medical aid.

3. Remove all gasket material from gasket surfaces, then wipe clean with dry cleaning solvent and rags.
4. Clean all other metal parts with dry cleaning solvent, then dry with rags.
5. Clean four fluid restrictors with dry cleaning solvent. Clear oil passages with nonelectrical wire. Wipe dry.

3-4. ENGINE BLOCK MAINTENANCE (Con't).



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