

Illustration 13

g01123647

3. Coat Tooling (A) with clean grease. Use Tooling (A) to cut threads into the unit injector sleeve.

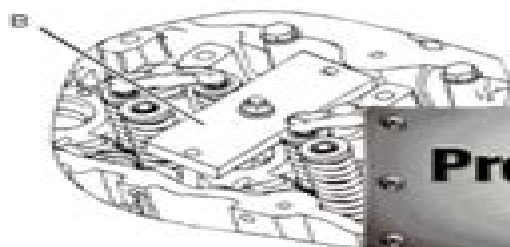


Illustration 14

g01123650

4. Use Tooling (B) to remove the unit injector sleeve.

i03145071

## Unit Injector Sleeve - Install

SMCS Code: 1713-012

### Installation Procedure

Table 6

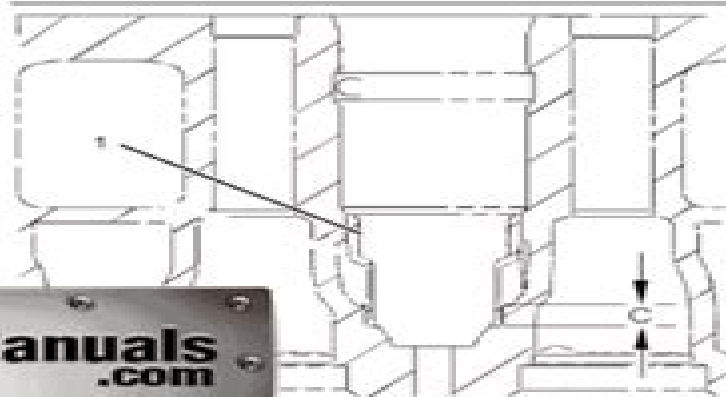
Required Tools			
Tool	Part Number	Part Description	Qty
D	221-9777	Sleeve Installer	1
E	4C-9506	Retaining Compound	1
F	4C-5552	Large Bore Brush	1
G	6V-6640	Sealant	1

#### NOTICE

Keep all parts clean from contaminants.

Contaminants may cause rapid wear and shortened component life.

1. Thoroughly clean the unit injector sleeves and the bores for the unit injectors. Tooling (F) may be used on the bores.



g01168882

2. Apply Tooling (G) to bores prior to installation.
3. Apply a thin coating of Tooling (E) around the outer circumference of unit injector sleeve (1) at Area (C).
4. Use Tooling (D) and a hammer to position the unit injector sleeve in the cylinder head.

**Note:** Allow Tooling (E) to cure for two hours at 21 °C (70 °F) before filling the engine with fuel or coolant. Longer curing time is required for lower temperatures.

5. Fill the cooling system. Refer to Operation and Maintenance Manual, "Cooling System Coolant - Change".

#### End By:

- a. Install the unit injectors. Refer to Disassembly and Assembly, "Unit Injector - Install".

# Kal Cat Engine Maintenance Manual

**Sebastian Brünink**



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