

C O R E   A C C E P T A N C E   C R I T E R I A

## Cylinder Packs / Connecting Rods / Piston Packs

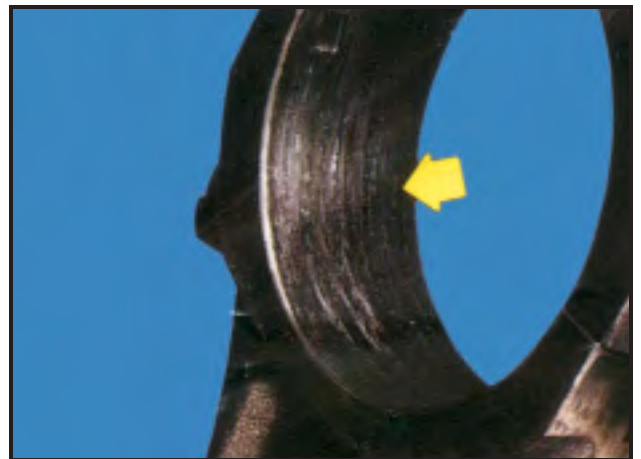
You will receive:

*Full Core Refund*

- ◆ Fully assembled and complete—rod and end cap match and are marked.
- ◆ Rod not scored and discolored due to overheating from a bearing failure.
- ◆ No pin bore damage due to failed bushing. (Does not apply to cylinder packs.)
- ◆ Rod not visibly cracked, broken, bent or twisted. (Figure 6)
- ◆ No nonoperational damage (mishandling, excessive rust, corrosion or pitting).
- ◆ Acceptable part number—Caterpillar® part.



**Figure 1** **Full Core Refund**  
fully assembled cylinder pack



**Figure 2** **No Core Refund**  
crank bore is scored and heat discolored



**Figure 3** **Full Core Refund**  
chemical/sludge discoloration



**Figure 4** **No Core Refund**  
pin bore damage

# Cylinder Packs / Connecting Rods / Piston Packs

## Core Acceptance Criteria (continued)



Figure 5 Core Refund Less Add Charge  
mismatched rod and end cap



Figure 6 No Core Refund  
visibly bent and twisted

## INSPECTION TIPS

Dealers should refer to REMAN Policies and Core management (SELD0122), Core Management Systems and Operations procedures (SELD0040), and Shipping Instructions (SELD0039) in the "Operations and Core Management Tab", and to Core Acceptance Guide Introduction (SELD0013) in the "Core Acceptance Guidelines Tab" for additional information applicable to all cores.

### Discoloration Due to Overheating From a Bearing Failure

- Rod bearing failure alone (blue-black color) will not cause core rejection. To be rejected, the crank bore must show evidence of bearing failure scoring and a rough inner diameter and be discolored from overheating, as shown in Figure 2.
- Discoloration from chemical buildup or sludge is acceptable. (See Figure 3)

### Fully Assembled and Complete (rod and end cap match and are marked)

- Rod and end cap must match and be marked. (See Figure 5)

If your cores are not already numbered, mark your rods and end caps before removal. Then reassemble them into matched sets before shipping them to Caterpillar. If the marking on the end cap does not match the marking on the rod, these rods will receive core credit, but will be assessed an add charge. If either the rod or the end cap is unmarked, No Core Refund will be issued.

**NOTE:** Some rods may be marked twice, once with the cylinder number or scribe lines etched on the side of the rod and cap as well as a number (up to four digits) on the face of the rod and cap. Both sets of numbers must match or No Core Refund will be given.

# Cylinder Packs / Connecting Rods / Piston Packs

## INSPECTION TIPS (continued)

### **Nonoperational Damage (mishandling, excessive rust, corrosion or pitting)**

- If rust can be wiped away with an emery cloth, the core will be accepted for Full Core Refund. Excessive corrosion, rust, or pitting, which are most often caused by improper storage, will result in No Core Refund.

### **Acceptable Part Number—Caterpillar Part**

- Cores with straight, narrow-taper rods are acceptable in exchange for any style Remanufactured Connecting Rod or Cylinder Pack.

### **Packaging Instructions For Returned Core**

- Rods must be assembled to pistons and inserted into liners. It is the dealer's option to return cores with or without piston rings.
- Set the liner packs vertically in the original carton with the piston end down. Do not return the plastic end cap or the inside plastic bag. Do not tuck the carton flaps down inside the carton. Carton flaps may be left loose or sealed.
- For piston packs, place the installation ring over the connecting rod of the core "piston pack" so that the ring fits around the skirt of the piston and rests on the bottom of the oil ring.  
Put the core of the piston assembly with the installation ring back in the original box.

## Direct Purchase Criteria

Please refer to the Core Management Information System (CMIS2) Parts Information Application for all Direct Purchase pricing information. Only the parts that have Direct Purchase prices with a current end date are included in the program. Parts with non-current end dates are not included in the program.

Part numbers that only have a "FULL" Direct Purchase price must meet the "FULL Core Refund" exchange core acceptance criteria to receive direct purchase value. Part numbers that have both a "FULL" and "PARTIAL" Direct Purchase price must meet the applicable "FULL Core Refund" or "Damage Core Refund" exchange core acceptance criteria to receive direct purchase value.

Add charges will apply as appropriate based on the normal exchange core acceptance criteria.

