

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

Short Blocks

You will receive:

Full Core Refund

- ◆ Cylinder block is not visibly cracked, broken or welded by source other than Caterpillar®.
- ◆ Fully assembled, including spacer plates and liners when applicable.
- ◆ Crankshaft is not visibly broken.
- ◆ No nonoperational damage (mishandling, excessive rust, corrosion, pitting or fire damage).
- ◆ Acceptable engine model—Caterpillar® part.

Damaged Core Refund

- ◆ Cylinder block visibly cracked, broken, or previously welded by source other than Caterpillar (see Figure 1).
- ◆ Crankshaft is visibly broken.

No Core Refund

- ◆ Nonoperational damage (mishandling, excessive rust, corrosion, pitting or fire damage.)
- ◆ Not an acceptable engine model—Caterpillar® part.



Figure 1

Welder's Mark

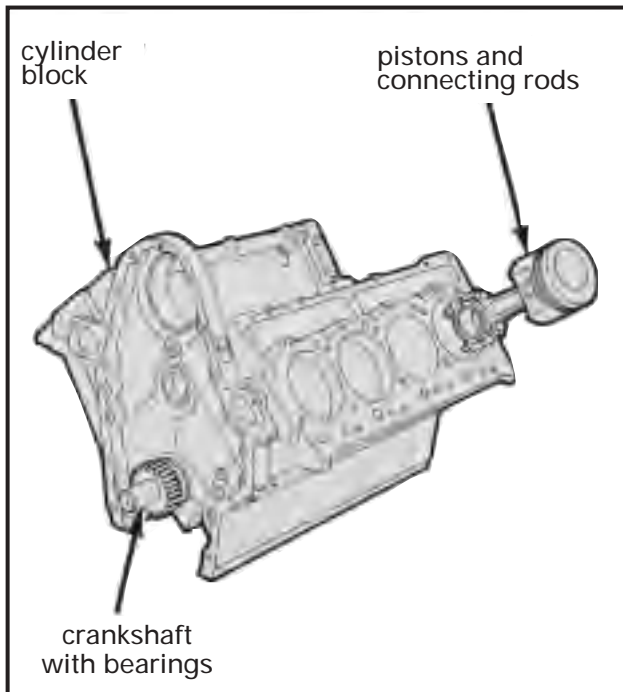
Short Blocks

CORE INSPECTION CHECKLIST

1100/3100, 3200 Series, 3116 and 3126 Short Blocks

Must be returned completely assembled with these components included:

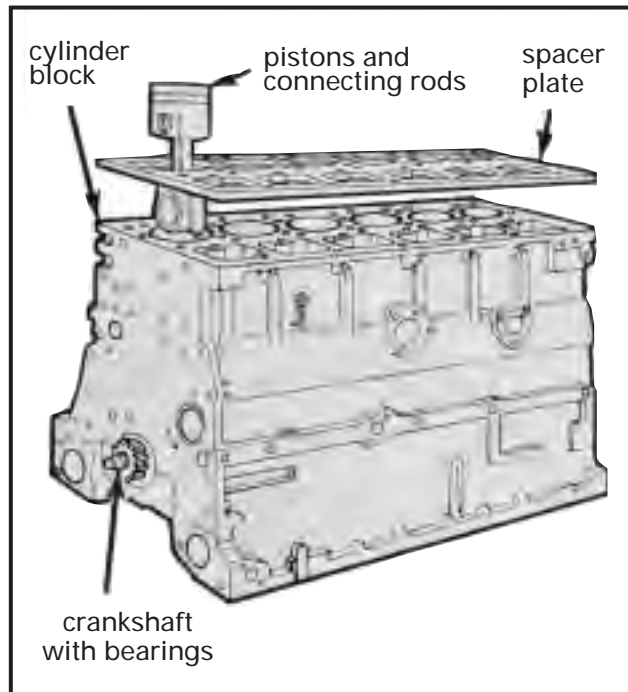
- ☐ Crankshaft with bearings.
- ☐ Pistons and connecting rods with bearings.
- ☐ Cylinder block.



3304, 3306, C-10, C-12, 3406, 3456, C-15, C-16 and 3508B/12B/16B Short Blocks

Must be returned completely assembled with these components included:

- ☐ Crankshaft with bearings.
- ☐ Pistons and connecting rods with bearings.
- ☐ Cylinder block.
- ☐ Spacer plate (when applicable).
- ☐ Liners.



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.

Damaged blocks

- Cracked, broken, or welded blocks will receive damaged core refund.

- Examine all exposed areas of the cylinder block including deck faces, pan rail, front and rear mounting faces, and cylinder bores. (NOTE: You do not have to rotate the crank to check the entire travel of the piston.) The 3500 crankshaft must be rotated one revolution.
- Short blocks with visibly broken crankshafts receive damaged core refund.
- Top deck cracks are commonly found between the water passages and bolt holes.

Short Blocks

INSPECTION TIPS (continued)

Fully assembled

- All 3304, 3306 and 3406 short blocks (except 3306 and 3500 counterbored blocks) must be returned with spacer plates or an add charge will be applied.
- Add charges will be applied for disassembled or missing main or connecting rod bearing caps.

Nonoperational damage

- If rust can be wiped away with an emery cloth, the core will be accepted for Full Core Refund.
- Blocks with fire damage receive no core refund.

IDENTIFICATION TIPS

1100 versus 3208

- Measuring the crankshaft "nose" will help you differentiate between 3208 and 1100/3100 series short block cores. The diameter of a 3208 crankshaft nose is 2 1/8" (54 mm); 1100/3100 series crankshaft nose diameter is 1 7/8" (48 mm).

3500 "B" SHORT BLOCK IDENTIFICATION

- "B" block casting part number located on front face of block number 1 cylinder.
- Rear face of block, three 5/8-11 threaded holes (idler gear shaft mounting face).
- Camshaft bearing bore—102 mm diameter.
- Correct crankshaft assembly part number stamped on front flange face diameter.

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.

