

SUBJECT: Delphi Technologies® [EX631088](#) & [EX631089](#) Injector Installation Instructions

When replacing the fuel injector for the Bobcat® D18/D24/D34 the following critical steps must be performed. Prior to commencing the injector removal process, ensure that the engine bay is free of any dirt/debris; failure to do so may result in the introduction of contaminants causing premature wear to the fuel system.

1. Before installing the new injectors, make sure that the injector bore is clean of any carbon build up. Clean out the injector hold down bolt threads in cylinder head. Any residual oil in the bottom of the bolt hole can lead to improper hold down torque.
2. Record the 20-character injector trim code number (C3i code) and note the cylinder location for injector is being installed in for ECM trim file programming.
  - a. *Note: See image down below for trim code (C3i code) location on the injector. There are no letters "i" or "o" used in the injector code. The numbers "1" and "0" are used for the code.*
3. Install injector with new sealing washer, and o-ring. Torque the injector hold down bolts to 43 nm (32 ft-lb). Reinstall cylinder head cover and torque bolts to 10 nm (7 ft-lb).
4. Install new injection lines and pre-torque to 18 nm (13 ft-lb). After completing pre-torque on both ends of the line, do a final torque to the line nuts to 30 nm (22 ft-lb).
5. Assembly of the remaining items can be completed at this time.
  - a. Line mounting brackets, injector return pipes, electrical connectors, and air filter housing.
6. Program C3i/injector trim files using suitable scan tool.
7. Complete the installation procedure by performing the injector reset procedure with the scan tool. Engine will need to be operated at full throttle for 10 minutes for the process to be completed.

