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March 2019



Operation and Maintenance Manual

Cat Commercial Diesel Engine Fluids Recommendations

04B 1-UP (Engine)
66D 1-UP (Engine)
4GM 1-UP (Engine)

Special Publication For All 3500 Series, C175, and smaller Commercial Diesel Engines

Important Safety Information

Most accidents that involve product operation, maintenance and repair are caused by failure to observe basic safety rules or precautions. An accident can often be avoided by recognizing potentially hazardous situations before an accident occurs. A person must be alert to potential hazards, including human factors that can affect safety. This person should also have the necessary training, skills and tools to perform these functions properly.

Improper operation, lubrication, maintenance or repair of this product can be dangerous and could result in injury or death.

Do not operate or perform any lubrication, maintenance or repair on this product, until you verify that you are authorized to perform this work, and have read and understood the operation, lubrication, maintenance and repair information.

Safety precautions and warnings are provided in this manual and on the product. If these hazard warnings are not heeded, bodily injury or death could occur to you or to other persons.

The hazards are identified by the "Safety Alert Symbol" and followed by a "Signal Word" such as "DANGER", "WARNING" or "CAUTION". The Safety Alert "WARNING" label is shown below.



The meaning of this safety alert symbol is as follows:

Attention! Become Alert! Your Safety is Involved.

The message that appears under the warning explains the hazard and can be either written or pictorially presented.

A non-exhaustive list of operations that may cause product damage are identified by "NOTICE" labels on the product and in this publication.

Caterpillar cannot anticipate every possible circumstance that might involve a potential hazard. The warnings in this publication and on the product are, therefore, not all inclusive. You must not use this product in any manner different from that considered by this manual without first satisfying yourself that you have considered all safety rules and precautions applicable to the operation of the product in the location of use, including site-specific rules and precautions applicable to the worksite. If a tool, procedure, work method or operating technique that is not specifically recommended by Caterpillar is used, you must satisfy yourself that it is safe for you and for others. You should also ensure that you are authorized to perform this work, and that the product will not be damaged or become unsafe by the operation, lubrication, maintenance or repair procedures that you intend to use.

The information, specifications, and illustrations in this publication are on the basis of information that was available at the time that the publication was written. The specifications, torques, pressures, measurements, adjustments, illustrations, and other items can change at any time. These changes can affect the service that is given to the product. Obtain the complete and most current information before you start any job. Cat dealers have the most current information available.



When replacement parts are required for this product Caterpillar recommends using Cat replacement parts.

Failure to follow this warning may lead to premature failures, product damage, personal injury or death.

In the United States, the maintenance, replacement, or repair of the emission control devices and systems may be performed by any repair establishment or individual of the owner's choosing.

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Foreword

Fluids/Filters Recommendation

Literature Information

This manual should be stored in the literature holder or in the literature storage area on the machine. Immediately replace this manual if lost, damaged, or unreadable.

The information contained in this document is the most current information available for fluid maintenance and service products. Special maintenance and service products may be required for some machine compartments. Refer to the Operation and Maintenance Manual for your machine for the maintenance and service requirements. Read, study, and keep this manual with the product. This manual should be read carefully before using this product for the first time and before performing maintenance.

Whenever a question arises regarding your product, or this publication, consult your dealer for the latest available information.

Safety

Refer to the Operation and Maintenance Manual for your machine for all safety information. Read and understand the basic safety precautions listed in the Safety Section. In addition to safety precautions, this section identifies the text and locations of warning signs used on the machine.

Read and understand the applicable precautions listed in the Maintenance and Operation Sections before operating or performing lubrication, maintenance, and repair on this machine.

Maintenance

Refer to the Operation and Maintenance Manual for your machine to determine all maintenance requirements.

Proper maintenance and repair are essential to keep the equipment and systems operating correctly. As the owner, you are responsible for the performance of the required maintenance listed in the Owner Manual, Operation and Maintenance Manual, and Service Manual.

Maintenance Interval Schedule

Use the Maintenance Interval Schedule in the Operation and Maintenance Manual for your machine to determine servicing intervals. Use the service hour meter to determine servicing intervals. Calendar intervals shown (daily, weekly, monthly, etc.) can be used instead of service hour meter intervals if calendar intervals provide more convenient servicing schedules and approximate the indicated service hour meter reading. Recommended service should always be performed at the interval that occurs first.

Under extremely severe, dusty, or wet operating conditions, more frequent lubrication and/or filter changes than is specified in the maintenance intervals chart might be necessary.

Following the recommended maintenance intervals reduces the risk of excessive wear and potential failures of components.

Aftermarket Products and Warranty

NOTICE

When auxiliary devices, accessories or consumables (filters, oil, additives, catalysts, fuel, etc.) made by other manufacturers are used on Cat products, the Caterpillar warranty is not affected simply because of such use. Failures that result from the installation or usage of other manufacturers auxiliary devices, accessories or consumables, however, are not Caterpillar factory defects and therefore are NOT covered by Caterpillar's warranty.

Caterpillar is not in a position to evaluate the many auxiliary devices, accessories or consumables promoted by other manufacturers and their effect on Cat products. Installation or use of such items is at the discretion of the customer who assumes ALL risks for the effects that result from this usage.

Furthermore, Caterpillar does not authorize the use of its trade name, trademark, or logo in a manner which implies our endorsement of these aftermarket products.

Maintenance Section

Lubricant Specifications

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Lubricant Information

SMCS Code: 1000; 1300; 7581

NOTICE

Every attempt is made to provide accurate, up-to-date information. By the use of this document, you agree that Caterpillar Inc. is not responsible for errors or omissions.

The information that is provided is the latest recommendations for Cat diesel engines that are covered by this Special Publication. This information supersedes all previous recommendations which have been published for Cat diesel engines that are covered by this Special Publication. Special fluids are required for some engines. These fluids will still be necessary in those engines. Refer to the applicable Operation and Maintenance Manual.

This publication is a supplement to the Operation and Maintenance Manual. This publication does not replace the engine-specific Operation and Maintenance Manuals.

NOTICE

These recommendations are subject to change without notice. Consult your local Cat dealer for the most up to date recommendations.

Failure to follow the recommendations found in this Special Publication can cause engine failures, shortened engine service life, and reduced engine performance.

In order to avoid potential damage to your Cat engine, only purchase Cat fluids and Cat filters through your Cat dealer or Cat authorized outlets. For a list of authorized Cat parts outlets in your area, consult your Cat dealer.

If you purchase what appear to be Cat fluids and/or Cat filters through other outlets/sources, you are at a very high risk of purchasing counterfeit (“look-alike”) products.

Counterfeit or “look-alike” products may visually appear the same as the original Cat product. The product performance and internal quality will typically be very low.

Counterfeit or “look-alike” products have a very high likelihood of causing and/or allowing engine and/or machine compartment damage.

Many of the guidelines, recommendations, and requirements that are provided in this Special Publication are interrelated. Before using the provided information, The user is responsible to read this Special Publication and understand the information provided.

The user is responsible to follow all safety guidelines found in this Special Publication and in the engine Operation and Maintenance Manual when performing all recommended and/or required engine, engine systems, and/or machine maintenance.

For questions concerning the information presented in this Special Publication and/or in your product Operation and Maintenance Manual, and/or for additional guidelines and recommendations (including maintenance interval recommendations/requirements) consult your Cat dealer.

Commercial products that make generic claims of meeting “Cat” and/or “Cat” requirements without listing the specific Cat recommendations and/or requirements that are met may not provide acceptable performance. Reduced engine and/or machine fluid compartment life may result. Refer to this Special Publication and refer to the product Operation and Maintenance Manual for Cat fluids recommendations and/or requirements.

Use of fluids that do not meet at least the minimum performance recommendations and/or requirements may lead to lower compartment performance and/or compartment failure.

Problems/failures that are caused by using fluids that do not meet the minimum recommended and/or required performance level for the compartment are not warrantable by Caterpillar Inc.. The fluid manufacturer and customer are responsible.

When fluids made by other manufacturers are used on Cat products, the Cat warranty is not affected simply because of such use. Failures that result from the installation or usage of other manufacturer fluids, however, are not Cat factory defects and therefore are NOT covered by the Cat warranty. Cat is not in a position to evaluate the many fluids promoted by other manufacturers and the effect on Cat products. Installation or use of such items is at the discretion of the customer who assumes ALL risks for the effects that result from this usage.

Different brand oils may use different additive packages to meet the various engine performance category/specification requirements. For the best results, do not mix oil brands.

The overall performance of engine and machine compartments is dependent on the choice of the lubricants and on the maintenance and cleanliness practices. The choices include filtration products, contamination control, tank management, and general handling practices. Cat designed and produced filtration products offer optimal performance and system protection.

In order to obtain additional information on Cat designed and produced filtration products, refer to Special Publication, SEBU9208, "Caterpillar Filters Recommendations". Also refer to the "Reference Material" article, "Filters" and "Miscellaneous" topics in this Special Publication. Consult your Cat dealer for assistance with filtration recommendations for your Cat machine.

Note: In order to help ensure the maximum expected compartment performance and life, use a fluid that meets Cat highest level of fluid performance as described in this Special Publication for the compartment. Using a fluid that is considered an acceptable, but lower performing option for typical applications, will provide lower performance.

NOTICE

Faulty engine coolant temperature regulators, or operating with light loads, short operation cycles, excessive idling, or operating in applications where normal operating temperature is seldom reached can contribute to excessive water in the crankcase oil. Corrosive damage, piston deposits, increased oil consumption, and other damage can result. If a complete oil analysis program is not followed or if the results are ignored, the potential for damage increases. Follow engine warmup recommendations provided in this Special Publication and/or given in your engine Operation and Maintenance Manual.

Cat Fluids

Cat fluids have been developed and tested by Cat in order to increase the performance and the life of Cat components. The quality of finished oil is dependent on the quality of the base stock, the quality of the additives and the compatibility of the base stock and additives. Cat fluids are formulated of high-quality refined oil base stocks and additives of optimal chemistry and quantity in order to provide high performance in engines and machine components. Cat fluids are used for factory fill of Cat engines and components and are offered by Cat dealers for service fills and as aftermarket products. Consult with your Cat dealer for more information on these Cat fluids.

Cat recommends the use of the following Cat fluids:

Table 1

Cat Lubricants		Viscosity Grade
Diesel Engine Oil-Ultra Low Sulfur (API CK-4)	Cat DEO-ULS	SAE 15W-40
		SAE 10W-30
	Cat DEO-ULS SYN	SAE 5W-40
	Cat DEO Cold Weather	SAE 0W-40

(continued)

(Table 1, contd)

Cat Lubricants		Viscosity Grade
Diesel Engine Oil (API CI-4/API CI-4PLUS)	Cat DEO	SAE 15W-40
		SAE 10W-30
Multi Application Engine Oil	Cat MAEO Plus (Non-Cat mixed fleets)	SAE 10W-40
Diesel Engine Oil (API CF)	Cat DEO (3600 engines only)	SAE 40
Pre Combustion Oil	Cat PCO	SAE 40

Note: Additional Cat fluids may be available.

Note: Cat offers Special Application Engine Oil (SAEO), API CF oil of SAE 30 and SAE 40 viscosity grades. These oils are recommended for use in 3116 and 3126 marine engines.

Table 2

Cat Grease products	
Grease	Cat Utility Grease
	Cat Ball Bearing Grease
	Cat White Assembly Grease

Note: Cat fluids availability will vary by region.

This information applies to Cat machines. For more lubricant recommendations see the following Special Publications:

- Special Publication, SEBU6250, "Caterpillar Machine Fluid Recommendations"
- Special Publication, SEBU6385, "Caterpillar On-Highway Diesel Engine Fluids Recommendations"
- Special Publication, SEBU6400, "Caterpillar Gas Engine Fluids Recommendations"
- Special Publication, SEBU7003, "Caterpillar 3600 Series and C280 Series Diesel Engine Fluids Recommendations"

Always consult your Cat dealer in order to ensure that you have the current revision level of the publication.

Note: The optimal application of the lubricants is dependent on the oil quality and the maintenance practices such as contamination control, tank management, and general handling practices.

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Engine Oil

SMCS Code: 1348; 7581

Engine lubricants play multiple roles in engines. Appropriate lubricants offer the following:

- Provide lubrication to the moving components of the engine under a wide range of temperatures and pressures
- Keep the engine components clean and remove wear debris
- Remove heat from the lubricated components
- Neutralize acidic products due to combustion process
- Protect the engine from cavitation and foaming
- Protect the engine from corrosion and rust
- Control Oil Consumption
- Disperse/Solubilize Contaminants (soot)
- Support the regulated engine emissions limits

Current lubricant formulations are more advanced and complex than previous formulations. Current lubricants are developed to support advanced engine technologies that have lower emissions while supporting the performance and durability of these engines.

High-performance oils are produced and validated using industry standard tests, proprietary tests, field tests, and often prior experience with similar formulation. The American Petroleum Institute (API) categories describe the key industry standards that set the minimum acceptable performance for engine oils. Other global standard setting organizations may also develop common standards, for example the European ACEA oil specs. Cat high quality and high-performance lubricants are validated based on these factors.

In order to provide optimal engine performance and life and comply with regulated emission reduction, use the recommended engine oil as provided in this special publication. Due to the significant variations in the quality and performance of commercially available oils on a global basis, Cat recommends the use of Cat oils as detailed in this article.

Cat Diesel Engine Oils

Cat fluids have been developed and tested by Caterpillar in order to provide the full performance and service life that has been designed and built into Cat engines. The quality of finished oil is dependent on the quality of the base stock, the quality of the additives, and the compatibility of the base stock and additives. Cat fluids are formulated of high-quality refined oil base stocks and additives of optimal chemistry and quantity in order to provide high performance in engines and machine components. Cat fluids are used for factory fill of Cat engines and components and are offered by Cat dealers for service fills and as aftermarket products. Consult your Cat dealer for more information on these Cat fluids.

Cat recommends the use of the following lubricants in commercial engines covered by this Special Publication are in Table 3 below:

Table 3

Cat Lubricants ⁽¹⁾		Viscosity Grade	
Recommendations for all Cat diesel engines	Cat Diesel Engine Oil-Ultra Low Sulfur (API CK-4) ⁽²⁾	Cat DEO-ULS	SAE 15W-40
			SAE 10W-30
		Cat DEO-ULS SYN	SAE 5W-40
		Cat DEO Cold Weather	SAE 0W-40
	Cat Diesel Engine Oil (API CI-4/CI-4 PLUS and API CH-4)	Cat MAEO Plus (Non-Cat mixed fleets)	SAE 15W-40
			SAE 10W-30

(continued)

(Table 3, contd)

Cat Lubricants ⁽¹⁾			Viscosity Grade
Specialty oils for specific Cat diesel engines	Cat Multi-Application Engine Oil	Cat MAEO Plus (Non-Cat mixed fleets)	SAE 10W-40
	Cat Diesel Engine Oil	Cat DEO (3600 engines only)	SAE 40
	Cat Precombustion Chamber Oil	Cat PCO (Specific applications only)	SAE 30

⁽¹⁾ Cat engine oils exceed the performance requirements of the respective API categories

⁽²⁾ These oils have changed from API CJ-4 to API CK-4 early in 2017

Note: Cat offers Special Application Engine Oil (SAEO), API CF oil of SAE 30 and SAE 40 viscosity grades. These oils are recommended for use in 3116 and 3126 marine engines.

Note: Additional Cat fluids may be available.

This information applies to Cat commercial engines. For more lubricant recommendations see the following Special Publications:

- Special Publication, SEBU6251, "Caterpillar Commercial Diesel Engine Fluids Recommendations"
- Special Publication, SEBU6385, "Caterpillar On-Highway Diesel Engine Fluids Recommendations"
- Special Publication, SEBU6400, "Caterpillar Gas Engine Fluids Recommendations"
- Special Publication, SEBU7003, "Caterpillar 3600 Series and C280 Series Diesel Engine Fluids Recommendations"

Always consult your Cat dealer in order to ensure that you have the current revision level of the publication.

Note: The optimal application of the lubricants is dependent on the oil quality and the maintenance practices. Such practices include contamination control, oil tank management and general handling practices.

Cat Diesel Engine Oils Recommendations

Cat DEO-ULS and Cat DEO multigrade oils are the preferred oils for use in ALL Cat diesel engines that are covered by this Special Publication. Commercial alternative diesel engine oils are, as a group, second choice oils. Refer to Table 4 below for information.

Table 4

Cat Engine Lubricants Recommendations/Requirements		
	Non-Road Tier 4 Certified	Non-Road Pre Tier 4 Certified
Preferred	Cat DEO-ULS (API CK-4)	Cat DEO-ULS (API CK-4) Cat DEO (API CI-4/API CI-4 PLUS)
Commercial Lubricants	API CK-4 Cat ECF-3/API CJ-4	API CK-4 Cat ECF-3/API CJ-4, Cat ECF-2 Cat ECF-1-a

Note: API engine oil categories are backwards compatible. Cat DEO-ULS (API CK-4) oil can be used in all engines with some restrictions related to fuel sulfur level, refer to Table 6 for more details. Cat DEO (API CI-4/API CI-4 PLUS) can be used in engines that are Tier 3 emissions certified and prior, and in engines that do not use aftertreatment devices.

Note: When the recommended Cat diesel engine oils are not used, commercial oils that are API CK-4 licensed and/or meet the requirements of the Cat ECF-1-a, Cat ECF-2, and/or the Cat ECF-3 specification are acceptable, but second choice, for use in Cat diesel engine.

Refer to “The Current American Petroleum Institute (API) Oil Categories” and “Commercial Engine Oil Recommendations” sections of this chapter for information on the API categories and corresponding Cat engine oils.

API CK-4 exceeds the performance requirements of prior oil categories.

Caterpillar has released a new Cat diesel engine oil, Cat DEO-ULS that is per the new API CK-4 heavy duty engine oil category. The new Cat DEO-ULS replaces the prior Cat oil that was per API CJ-4 category, but it is of the same brand name. The new Cat DEO-ULS preserved the same level of phosphorous, 1000 ppm (parts per million) (mg/kg), to ensure achieving long hour engine durability goals.

Note: The new API FA-4 Heavy Duty Engine Oil Category is NOT allowed in Cat engines. API FA-4 is a special low High Temperature High Shear (HTHS) viscosity oil that is designed for certain 2017 On-Highway engine models.

Note: Each of the Cat ECF specifications provides increased performance over lower Cat ECF specifications. For example, Cat ECF-3 provides higher performance than Cat ECF-2 and Cat ECF-3 provides much higher performance than Cat ECF-1-a. Refer to Table 5 for details.

The engine oils recommended/required for Tier 4 certified engines are formulated with limited ash and chemical limits:

- 1 percent sulfated ash maximum
- 0.12 percent phosphorous maximum
- 0.4 percent sulfur maximum

These chemical limits were developed in order to maintain the expected aftertreatment devices life, performance, and service intervals. Use of oils other than those listed in this section of this special publication in aftertreatment equipped engines can negatively impact performance of the aftertreatment devices, can contribute to Diesel Particulate Filter (DPF) plugging and/or can cause the need for more frequent DPF ash service intervals.

Cat DEO-ULS and Cat DEO are recommended for all pre-Tier 4 engines that use Ultra Low Sulfur Diesel (ULSD) or Low Sulfur Diesel (LSD) fuels. Cat DEO is recommended for engines using fuels of sulfur levels that exceed 0.2 percent (2000 ppm). Cat DEO-ULS may be used in these applications if an oil analysis program is followed. The oil change interval may be affected by the fuel sulfur level. Refer to Table 6 in this section of this Special Publication.

Table 5 below provides details of Cat ECF specifications.

Table 5

Cat Engine Crankcase Fluids (ECF) Definitions	
Cat Minimum Performance Requirements for Commercial Oils	Cat ECF Specifications Requirements
(1)	API CK-4 Oil Category performance requirements
Cat ECF-3	API CJ-4 Oil Category performance requirements

(continued)

(Table 5, contd)

Cat Engine Crankcase Fluids (ECF) Definitions	
Cat Minimum Performance Requirements for Commercial Oils	Cat ECF Specifications Requirements
Cat ECF-2	API CI-4 / CI-4 PLUS Oil Category performance requirements and Passing standard Cat C13 engine test per API requirements and Oils of sulfated ash > 1.50 percent are not allowed
Cat ECF-1-a	API CH-4 Oil Category performance requirements and For oils that are between 1.30 percent and 1.50 percent sulfated ash, passing one additional Cat 1P SCOTE test ("ASTM D6681") is required and Oils of sulfated ash > 1.50 percent are not allowed

(1) Caterpillar did not develop an ECF external specification for API CK-4. Cat DEO-ULS API CK-4 oil is specifically developed and validated for Cat engines. The API categories define the minimum common OEM requirements for engine oils

Refer to "Commercial Engine Oil Recommendations" and "The Current American Petroleum Institute (API) Oil Categories" sections of this chapter for information on the API categories and corresponding Cat engine oils.

Cat DEO-ULS exceeds many of the performance requirements of API CK-4 standard tests and Cat ECF specifications. Cat DEO-ULS is formulated with 1000 ppm (parts per million) (mg/kg) phosphorous level to ensure achieving long hour engine durability goals.

Cat DEO exceeds the limits of API CI-4/CI-4PLUS and API CH-4. Cat DEO-ULS and Cat DEO are rigorously tested with full-scale proprietary Cat engine tests to ensure optimal protection of Cat diesel engines. The tests include the following: sticking of the piston rings, piston deposits, oil control tests, wear tests and soot tests. Proprietary tests help ensure that Cat oils provide superior performance in Cat diesel engines.

There are significant variations in the quality and performance of commercially available oils. For this reason, Cat recommends the Cat oils listed in Table 4 and the guidelines in Table 4 .

NOTICE

Do not use single grade API CF oils or multigrade API CF oils in Cat Series 3500, Series C175 and smaller Direct Injection (DI) diesel engines. Single grade API CF oils (or oils that meet all the performance requirements of API CF category) may only be used in Cat Series 3600 and Series C280 diesel engines, and older Cat engines that have precombustion chamber (PC) fuel systems. Oils that are used in Cat Series 3600 and Series C280 diesel engines must also pass a 7000 our field performance evaluation. Consult your Cat dealer for details

Cat DEO-ULS multigrade and Cat DEO multigrade oils are formulated with the correct amounts and chemistry of various additives including detergents, dispersants, antioxidants, alkalinity, antifoam, viscosity modifiers, and others in order to provide superior performance in Cat diesel engines where recommended for use.

Use appropriate lubricating oils that are compatible with the engine certification and aftertreatment system and with the fuel sulfur levels. Refer to the oil recommendations for Tier 4 certified engines in this Chapter, to "Diesel Fuel Sulfur Impacts" article of the "Fuels Specifications" section and to "Lubricants Specifications" section of this Special Publication.

Cat DEO-ULS (API CK-4) is compatible for use in engines with aftertreatment devices. Refer to the appropriate section in this article for details.

Cat DEO-ULS and Cat DEO are multigrade oils. Refer to Table 3 in this article for details. Multigrade oils provide the correct viscosity for a broad range of operating temperatures. Multigrade oils provide the appropriate oil film thickness for moving engine components such as piston, ring and liners, bearings, valve train and others.

Cat diesel engine oils exceed many of the performance requirements of the corresponding API categories and of other manufacturers of diesel engines. Therefore these oils are excellent choices for many mixed fleets. Refer to the engine manufacturer literature for the recommended categories/specifications. Compare the categories/specifications to the specifications of Cat diesel engine oils. The current industry standards for Cat diesel engine oils are listed on the product labels.

Also, refer to the datasheets for the product for technical details.

Cat DEO-ULS and Cat DEO are recommended for all pre-Tier 4 engines that use Ultra Low Sulfur Diesel (ULSD) or Low Sulfur Diesel (LSD) fuels. Cat DEO is recommended for engines using fuels of sulfur levels that exceed 0.2 percent (2000 ppm). Cat DEO-ULS may be used in these applications if an oil analysis program is followed. The oil change interval may be affected by the fuel sulfur level. Refer to Table 6 in this section of this Special Publication.

Consult your Cat dealer for part numbers and for available sizes of containers.

Note: API oil category CF is obsolete. The API (American Petroleum Institute) does not license this category effective end of 2010. API does not validate the quality of API CF oils and does not allow the display of API symbol (also called API doughnut) with CF as highest claim on the oil container. Oils that claim the requirements of API CF can be used ONLY in Cat Series 3112 and Cat Series 3126 Marine Engines. Refer to the details given in the Marine engine section in this Special Publication.

Recommendation for US EPA Tier 4 Certified Nonroad Engines

All diesel engines with aftertreatment devices are REQUIRED to use specially formulated engine oils and specific diesel fuels. The engine categories that are certified per the emissions regulations listed below commonly have aftertreatment devices:

- United States Environmental Protection Agency (EPA) Tier 4 Nonroad
- European Union Stage IIIB, IV, and V, Nonroad
- Japan 2014 (Tier 4) Nonroad
- Korea Tier 4 Nonroad
- India Bharat Stage IV for Construction Equipment Vehicles
- China Nonroad Stage IV

Engine Oils

The REQUIRED engine oils are listed below. These oils are developed with restricted ash level and chemical limits that are suitable for use in engines with aftertreatment.

- Cat DEO-ULS (preferred)
- API CK-4 engine oil category
- Oils meeting the Cat ECF-3 specification
- API CJ-4 engine oil category
- ACEA E9

Note: Note that ACEA E9 oils are validated using some but not all ECF-3 and API CJ-4 standard engine performance tests. Consult your oil supplier when considering use of an oil that is not API CK-4, Cat ECF-3 or API CJ-4 qualified.

The chemical limits are detailed in the Section titled “Cat Diesel Engine Oils Recommendations, and Cat” of this chapter

Diesel Fuels

The diesel fuels REQUIRED by regulations for use in engines that are certified to nonroad emissions standards listed above and in engines equipped with exhaust aftertreatment systems are.

- United States Ultra Low Sulfur Diesel (ULSD) fuel ≤ 15 ppm (mg/kg) (0.0015 percent) sulfur
- European ULSD ≤ 10 ppm (mg/kg) (0.0010 percent) sulfur fuel. This fuel is also called “sulfur free”
- Other fuels available around the world that are ≤ 15 ppm (mg/kg) (0.0015 percent) sulfur

Certain governments/localities and/or applications MAY require the use of ULSD fuel. Consult federal, state, and local authorities for guidance on fuel requirements for your area.

ULSD fuel or sulfur-free diesel fuel are suitable for use in all engines regardless of the engine Tier or Stage.

The fuels listed above have to meet the performance levels detailed in the Fuel Information for Diesel Engines chapter in this Publication. The Fuel Information for Diesel Engines Chapter also includes the pertinent recommendations for biodiesel fuels in the engines certified to non-road emissions standards listed above.

Diesel Exhaust Fluid (DEF)

This fluid MUST be used in engines that are equipped with Selective Catalytic Reduction (SCR) systems. DEF must meet all the requirements detailed in the Exhaust Aftertreatment Fluids Specification chapter in this Special Publication.

Aftertreatment systems may include the following:

- Diesel Particulate Filters (DPF)
- Diesel Oxidation Catalysts (DOC)
- Selective Catalytic Reduction (SCR)
- Lean NOx Traps (LNT)

Other systems may apply.

Regulations may vary around the world. Follow all the local regulations and fluids requirements in your area. Refer to your engine-specific Operation and Maintenance Manual, and refer to your aftertreatment device documentation, if available, for additional guidance.

NOTICE

Do not add new engine oil, waste engine oil or any oil product to the fuel unless the engine is designed and certified to burn diesel engine oil (for example Caterpillar ORS designed for large engines). Caterpillar experience has shown that adding oil products to Tier 4 engine fuels (U. S. EPA Tier 4 certified), to Euro IV/ Stage IV certified engine fuels, or to the fuels of engines equipped with exhaust aftertreatment devices, will generally cause the need for more frequent ash service intervals and/or cause loss of performance. Adding oil products to the fuel may raise the sulfur level of the fuel and may cause fouling of the fuel system and loss of performance.

Recommendation for Europe Stage V Certified Nonroad Engines

All the recommendations and requirements given in “Recommendation for US EPA Tier 4 Certified Nonroad Engines” section are applicable to the Europe Stage V type-approved Nonroad Engines

Additionally, for the correct operation of the engine in order to maintain the gaseous and particulate pollutant emissions of the engine within the limits of the type-approval, unless specified otherwise in the engine-specific Operation and Maintenance Manual, **EU Stage V** regulations REQUIRE the diesel fuels (also called non-road gas oil) used in engines operated within the European Union (EU) to have the characteristics below

- The sulfur content should not be greater than 10 mg/kg (20 mg/kg) at point of final distribution
- The Cetane number should not be less than 45
- The biodiesel (also called Fatty Acid Methyl Ester (FAME)) content should not be greater than 8 % volume/volume

Note: Certain Cat engines that are certified per EU Stage V can use up to B20 biodiesel blends. Refer to your engine specific Operation and Maintenance Manual.

Follow all the local regulations and fluids requirements in your area. Refer to your engine-specific Operation and Maintenance Manual, and refer to your aftertreatment device documentation, if available, for additional guidance.

Commercial Engine Oil Recommendations

Note: The engine oil recommendations given in “Commercial Engine Oil Recommendations” are applicable to all current and noncurrent Cat Diesel Engines that are covered by this Special Publication.

Note: Non-Cat commercial oils are, as a group, second choice oils. Within this grouping of second choice oils there are tiered levels of performance.

NOTICE

Cat does not warrant the quality or performance of non-Cat fluids.

Refer to “The Current American Petroleum Institute (API) Oil Categories” section of this chapter for information on the API categories and corresponding Cat engine oils.

When the recommended Cat diesel engine oils are not used, commercial oils that are API CK-4 licensed and/or meet the requirements of the Cat ECF-1-a, Cat ECF-2, and/or the Cat ECF-3 specification are acceptable, but second choice, for use in Cat diesel engine.

Oils that are API CJ-4, API CI-4/CI-4 PLUS and API CH-4, and do not meet any Cat ECF specification are, as a group, third choice.

Note: API FA-4 oils are NOT allowed for use in Cat engines. These oils are designed for use in certain 2017 On-Highway engine models.

API CK-4 oils exceed the performance requirements of prior API categories. Cat developed the Engine Crankcase Fluid (ECF) specifications to ensure the availability of acceptable performance commercial diesel engine oils. The three Cat ECF specifications: Cat ECF-1-a, Cat ECF-2 and Cat ECF-3 are described in Table 4 . These specifications require more engine tests than the corresponding API categories. As a result, oils that are API CK-4 and/or per these specifications can offer acceptable engine performance.

Each higher Cat ECF specification provides increased performance over lower Cat ECF specifications. For example, Cat ECF-3 provides higher performance than Cat ECF-2 and Cat ECF-3 provides much higher performance than Cat ECF-1-a. Refer to Table 5 for details

Oils that meet only API CI-4/CI-4 PLUS and/or API CH-4 categories and that have not met the requirements of at least one Cat ECF specification may cause reduced engine life.

Note: Cat diesel engine oils are required to pass proprietary full-scale diesel engine testing. The testing is above and beyond the testing required by the various Cat ECF specifications and by the various API oil categories that are also met. This additional proprietary testing helps ensure that Cat multigrade diesel engine oils, when used as recommended, provide superior performance in Cat diesel engines. If Cat diesel engine oils are not used, use only commercial oils that meet the recommendations and requirements stated in this section of this Special Publication.

Note: For engines that are Tier 4 EPA certified, refer to the Recommendations for Tier 4 Engines article in this Engine Oil section. Tier 4 EPA certified engines require specifically formulated oils.

For engines using fuels of sulfur levels that exceed 0.2 percent (2000 ppm), Caterpillar recommends Cat DEO engine oils. However, commercial oils that meet Cat ECF- 2 or Cat ECF-1-a specifications are acceptable but second choice. Commercial oils that meet Cat ECF- 3 specifications may be used in these applications if an oil analysis program is followed. The oil change interval is affected by the fuel sulfur level. Refer to Table 6 in this section of this Special Publication.

Note: For On-Highway engines fluids recommendations, refer to the Operation and Maintenance Manual of your engine and also refer to the most current revision level of Special Publication, SEBU6385 and “Caterpillar On-Highway Diesel Engine Fluids Recommendations” or consult your Cat dealer.

In selecting oil for any engine application, both the oil viscosity and oil performance category/specification as specified by the engine manufacturer must be defined and satisfied. Using only one of these parameters will not sufficiently define oil for an engine application.

In order to make the proper diesel engine oil viscosity grade choice, refer to the “Lubricant Viscosities for Ambient Temperatures” table in this Special Publication.

NOTICE

Failure to follow these oil recommendations can cause shortened engine service life due to deposits and/or excessive wear.

NOTICE

Do not use single grade API CF oils or multigrade API CF oils in Cat Series 3500, Series C175 and smaller Direct Injection (DI) diesel engines. Single grade API CF oils (or oils that meet all the performance requirements of API CF category) may only be used in Cat Series 3600 and Series C280 diesel engines, and older Cat engines that have precombustion chamber (PC) fuel systems. Oils that are used in Cat S Series 3600 and Series C280 diesel engines must also pass a 7000 hour field performance evaluation. Consult your Cat dealer for details.

The Current American Petroleum Institute (API) Oil Categories

The American Petroleum Institute, working closely with Original Engine Manufacturers (OEMs) including Caterpillar, has been developing engine oil categories since the 1950s. These categories define the minimum common OEM and industry requirements for engine oils. Cat oils exceed the requirements of API categories and the corresponding Cat ECF specifications (Refer to Table 5 in this Chapter).

The American Petroleum Institute (API), has developed two new Heavy Duty Diesel Engine Oil categories. The two new categories, described below, are planned for release in December of 2016.

1. API CK-4: backwards compatible oil that is based on API CJ-4 technology with additional performance improvements:
 - a. Improved oxidation stability (per ASTM D8048).
 - b. Improved air release (Per ASTM D8047).
 - c. Improved used oil shear stability per tighter specification limits.
 - d. Same chemical limits as API CJ-4 oil category, designed for use in engines with aftertreatment devices.
2. API FA-4: low High Temperature High Shear (HTHS) viscosity oil developed for certain 2017 On-Highway engine models that have to meet certain on-road emissions regulations. This category is not backwards compatible. API FA-4 is not recommended for Caterpillar engines.

Caterpillar is **NOT** recommending API FA-4 for Cat engines. These oils are designed with low HTHS viscosity for application in certain 2017 On-Highway truck engines. The level of HTHS viscosity for API FA-4 is lower than the traditional levels of HTHS for heavy duty engine oils. API FA-4 oils are not backwards compatible.

Caterpillar new diesel oil, Cat DEO-ULS, released in Dec 2016, is per API CK-4 oil category. This oil changed from API CJ-4 formulation, but is of the same brand name. Cat DEO-ULS exceeds the performance requirements of API CK-4 and has been extensively validated in Caterpillar engine tests.

Cat DEO-ULS is formulated with 1000 ppm (parts per million) (mg/kg) phosphorous level to ensure achieving long hour engine durability goals.

The API oil categories and the corresponding Caterpillar engine oils are described in Table 6 below. Refer to API 1509 document and/or ASTM D4485 for details of the API tests requirements and limits.

Table 6

API Category to Cat Oil Reference		
API Category	Corresponding Cat Oil ⁽¹⁾	Date of Release
API CK-4 ⁽²⁾	Cat DEO-ULS	December, 2016
API FA-4	Not recommended for Cat engines	December, 2016
API CJ-4 ⁽²⁾	None Replaced by DEO-ULS, CK-4	2006
API CI4/CI-4 PLUS	Cat DEO ⁽¹⁾	2002
API CH-4	Cat DEO ⁽¹⁾⁽³⁾ Available only in certain geographical regions	1998
API CF (Obsolete)	Cat DEO Restricted applications in Cat engines	1994
API CG-4, CF-4, CE, CD, and prior. (Obsolete)	No Cat oils Not allowed in Cat engines	1955 - 1990

⁽¹⁾ Cat oils exceed the requirements of API categories and the corresponding Cat ECF specifications (Refer to Table 5 in this Chapter).

⁽²⁾ Oils with Chemical limits. Compatible with emissions-reducing aftertreatment devices.

⁽³⁾ Cat DEO API CH-4 and Cat ECF-1 are available only in China, India, and Thailand. These oils are used in Tier 2 emissions certified engines.

Note: Each API category is more technically advanced than the prior categories.

Oils that meet only API CI-4/CI-4 PLUS and/or API CH-4 categories and that have not met the requirements of at least one Cat ECF specification may cause reduced engine life.

Note: Obsolete API oil categories are not licensed by the API and hence are of uncontrolled quality. These oils are technically inferior to current oils and can result in reduced engine performance and life.

Total Base Number (TBN) and Fuel Sulfur Levels for Direct Injection (DI) Diesel Engines

This article provides information for Direct Injection (DI) Diesel Engines, Precombustion Chamber (PC) Engines, and Direct Injection (DI) 3116 and 3126 Marine Diesel Engines.

The use of Cat S·O·S Services oil analysis is recommended for determining oil life.

TBN is also commonly referred to as Base Number (BN).

The minimum required Total Base Number (TBN) for oil depends on the fuel sulfur level. For commercial diesel engines that use distillate fuel, the following guidelines apply:

Maintenance Section
Engine Oil

Table 7

TBN recommendations for applications in Cat engines		
Fuel Sulfur Level percent (ppm)	Cat Engine Oils	TBN of Commercial Engine Oils
0.05 percent (500ppm)	Cat DEO-ULS Cat DEO	Min 7
>0.05-0.2 percent (>500- 2000 ppm) ⁽¹⁾	Cat DEO Cat DEO-ULS	Min 10
Above 0.2 percent (above 2000ppm) ⁽²⁾⁽³⁾	Cat DEO ⁽⁴⁾	Min 10

⁽¹⁾ Use of an oil analysis program to determine oil drain intervals is strongly recommended if fuel sulfur is between 0.05% (500 ppm) and 0.5% (5000 ppm).

⁽²⁾ Use of an oil analysis program to determine oil drain intervals is required if fuel sulfur is above 0.5% (5000 ppm).

⁽³⁾ For fuels of sulfur levels that exceed 1.0 percent (10,000 ppm), refer to TBN and engine oil guidelines given in this section.

⁽⁴⁾ Cat DEO-ULS may be used if an oil analysis program is followed. High fuel sulfur levels may reduce the oil drain intervals.

Note: For PC (Precombustion Chamber) diesel engines, which are mainly 1990 and older engines, the minimum new oil TBN must be 20 times the fuel sulfur level.

For regions in the world where fuels of high sulfur that exceed 1.0 percent (10,000 ppm (mg/kg)) are available and allowed for use by law, use the following guidelines:

- Choose multigrade oil with the highest TBN that meets one of these specifications: Cat ECF-1-a, Cat ECF-2, Cat ECF-3, and Cat API CK-4. Commercial oils are second choice oils.
- Reduce the oil change interval. Base the oil change interval on the oil analysis. Ensure that the oil analysis includes the condition of the oil and a wear metal analysis. Cat S·O·S Services oil analysis is required.

TBN testing is an optional part of the SOS Services oil analysis program. TBN testing may be done in addition to the standard SOS Services tests for oil deterioration. In most applications, the SOS Services tests for oxidation, sulfation, viscosity, and wear will identify oil deterioration.

TBN of the oil is typically measured using “ASTM D2896” and/or “ASTM D4739” test methods. Both methods can be used to measure the TBN of used oils. However, “ASTM D4739” is the preferred method for used oils.

- Consider changing the oil if the “ASTM D2896” test result reaches 4 TBN. Look for other signs of oil deterioration, or abnormal wear to verify the need to change oil.
- Consider changing the oil if the “ASTM D4739” test result reaches 3 TBN. Look for other signs of oil deterioration, or abnormal wear to verify the need to change oil.

- Be aware that both of these test methods have variability of approximately ± 1 TBN. Care should be taken when analyzing the results of the TBN test. Consult a trained S·O·S Services analyst when making oil drain decisions based on oil sample results.

Note: The use of Cat S·O·S Services oil analysis helps environmental sustainability as the best way to optimize oil life. The service will help engines reach the expected life. Consult your Cat dealer regarding the testing required to establish a safe, optimized oil drain interval.

In order to help protect your engine, and optimize oil drain intervals for engine applications and duty cycles, use Cat S·O·S Services oil analysis as follows:

- Recommended normally
- Very strongly recommended in order to determine oil drain intervals when operating on fuel with sulfur levels between 0.05% (500 ppm) and 0.5% (5000 ppm)
- Required in order to determine oil drain intervals when operating on fuel with sulfur levels that are above 0.5% (5000 ppm)

Note: Engine operating conditions play a key role in determining the effect that fuel sulfur will have on engine deposits and on engine wear. Consult your Cat dealer for guidance when fuel sulfur levels are above 0.1% (1000 ppm).

Excessive piston deposits can be produced by oil with a high TBN and/or high ash. These deposits can lead to a loss of control of the oil consumption and to the polishing of the cylinder bore.

There are many factors that contribute to rapid TBN depletion, a not all inclusive list follows:

- High sulfur fuel (The more fuel sulfur, the more rapid the TBN depletion.)

- Faulty engine coolant regulators
- Light loads
- Short operation cycles
- Excessive idling
- Operating in applications where normal operating temperature is seldom reached
- High humidity (allowing excessive condensation)

Bullets 2 through 7 above can contribute to excessive water in the crankcase oil. The water combines with available sulfur to form sulfuric acid. Neutralizing acids that are formed contribute to rapid TBN depletion.

NOTICE

Depending on application severity and localized environmental conditions, and also depending on maintenance practices, operating Direct Injection (DI) diesel engines and operating PC (Precombustion Chamber) diesel engines on fuel with sulfur levels over 0.1 percent (1000 ppm) may require significantly shortened oil change intervals in order to help maintain adequate wear protection. Refer to this Special Publication, "Fuel Specifications" section, "Diesel Fuel Sulfur" topic for additional information.

Note: Do NOT use only this Special Publication as a basis for determining oil drain intervals.

This Special Publication does not address recommended oil drain intervals, but rather provides guidance that should be used with your specific engine/machine Operation and Maintenance Manuals in determining acceptable oil drain intervals. Consult your engine/machine Operation and Maintenance Manuals, and consult your Cat dealer for additional guidance, including but not limited to guidance on establishing optimized and/or acceptable oil drain intervals.

Severe applications

An engine which operates outside of normal conditions is operating in a severe service application.

An engine that operates in a severe service application may need more frequent maintenance intervals in order to maximize the following conditions:

- Reliability
- Service life

Severe Applications Require the Use of Higher Performing Diesel Engine Oils. Examples of severe duty applications include, but not limited to the following:

- operating at greater than 75% load factor
- operating in high humidity
- operating with fuel sulfur levels that are above 0.1% (1000 ppm)

In order to help ensure the maximum expected compartment performance and life, higher performing fluids as described in this Special Publication may be required. Fluids that meet only the minimum performance levels may be allowed for typical applications, but maintenance intervals must be reduced. For the maximum expected engine compartment performance and life and where LSD or ULSD fuels are available, oils meeting the API CK-4 or Cat ECF-3 specification must be used.

The number of individual applications cause the impossibility of identifying all of the factors which may contribute to severe service operation. Consult your Cat dealer for the unique maintenance that may be necessary for your engine.

An application is a severe service application if any of the following conditions apply:

Severe Environmental Factors

- Frequent operation in dirty air
- Frequent operation at an altitude which is above 1525 m (5000 ft)
- Frequent operation in ambient temperatures which are above 32° C (90° F)
- Frequent operation in ambient temperatures which are below 0° C (32° F)

Severe Operating Conditions

- Frequent operation with inlet air which has a corrosive content
- Operation with inlet air which has a combustible content
- Operation which is outside of the intended application
- Operation with a plugged fuel filter
- Extended operation at low idle (more than 20% of hours)
- Frequent cold starts at temperatures below 0° C (32° F)
- Frequent dry starts (starting after more than 72 hours of shutdown)

Maintenance Section
Engine Oil (3116 and 3126 Marine Engines)

- Frequent hot shutdowns (shutting down the engine without the minimum of 2 minutes to 5 minutes of cool down time)
- Operation above the engine rated speed
- Operation below the peak torque speed
- Operating with fuel which does not meet the standards for distillate diesel fuel as stated in Special Publication, SEBU6250, "Caterpillar Machine Fluids Recommendations" "Distillate Diesel Fuel"
- Operating with a blend of distillate fuel which contains more than 20 percent biodiesel

Improper Maintenance Procedures (Maintenance Procedures Which May Contribute to a Severe Service Application)

- Inadequate maintenance of fuel storage tanks from causes such as excessive water, sediment, and microorganism growth.
- Extending maintenance intervals beyond the recommended intervals
- Using fluids which are not recommended in Special Publication, SEBU6250, "Caterpillar Machine Fluids Recommendations"
- Extending maintenance intervals for changing the engine oil and engine coolant without S·O·S validation
- Extending maintenance intervals for changing air filters, oil filters, and fuel filters
- Failure to use a water separator
- Using filters which are not recommended by Special Publication, PEWJ0074, "2008 Cat Filter and Fluid Application Guide"

- Storing the engine for more than 3 months but less than 1 yr (For information about engine storage, refer to Special Publication, SEHS9031, "Storage Procedure for Caterpillar Products")

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Engine Oil (3116 and 3126 Marine Engines)

SMCS Code: 1348; 7581

Recommendations

Cat does not recommend the use of multigrade oils in the 3116 and 3126 Marine Diesel Engines that use mechanical unit injection (MUI).

Multigrade oils use high molecular weight polymers as viscosity index improvers. When the crankcase blowby flows through the turbocharger and the aftercooler, the viscosity index improvers can adhere to the turbocharger compressor and aftercooler core.

The fouling of the turbocharger and aftercooler can cause reduced air flow, loss of power, and increased black smoke. The emission of black smoke results in buildup of soot on the transom of the boat.

Note: Cat recommends the use of single grade oils that pass all API CF-4 category requirements unless crankcase blowby has been routed away from the air cleaner inlet.

Cat SAEO (Special Application Engine Oil)

Note: Cat SAEO is recommended for use in Cat 3116 and 3126 Marine Diesel Engines with mechanical unit injection. 3116 and 3126 Marine Diesel Engines that begin with the following serial number prefixes are included:

- **S/N:** 6SR
- **S/N:** 8NM
- **S/N:** 4KG
- **S/N:** 1SK
- **S/N:** 1ZJ
- **S/N:** 6MK
- **S/N:** 4EZ

The factory-fill for 3116 and 3126 Marine Engines is Cat SAE0 with the following properties:

- Meets all requirements of API CF-4 category
- Viscosity grade of SAE 30

For maximum performance in 3116 and 3126 Marine Diesel Engines with mechanical unit injection, Cat recommends the following engine oil:

- Cat SAE0 (SAE 30)
- Cat SAE0 (SAE 40)

Commercial Oils (3116 and 3126 Marine Engines)

NOTICE

Cat does not warrant the quality or performance of non-Cat fluids.

When Cat SAE0 is not used, use the following commercial oils:

- Single grade oil with a viscosity of SAE 30 or SAE 40 that meets all API CF category requirements is preferred.
- Single grade oil with a viscosity of SAE 30 or SAE 40 with an API CF additive package and no viscosity improvers is acceptable oil.

API oil category CF is obsolete. The API (American Petroleum Institute) does not license this category effective end of 2010. API does not validate the quality of API CF oils and does not allow the display of API symbol (also called API doughnut) with CF as highest claim on the oil container.

Oil products that used to be licensed as API CF oil performance category and have not changed formulation are acceptable for use in Cat 3116 and 3126 marine engines.

For an acceptable commercial single grade oil, consult your Cat dealer.

Some commercial oils that meet the requirements API CF-4 category may require reduced oil change intervals. To determine the oil change interval, closely monitor the condition of the oil and perform a wear metal analysis. Cat S·O·S Services oil analysis program is the preferred method.

NOTICE

Failure to follow these oil recommendations can cause shortened engine service life due to deposits and/or excessive wear.

Total Base Number (TBN) and Fuel Sulfur Levels for Direct Injection (DI) Diesel Engines (3116 and 3126 Marine Engines)

This article provides information for 3116 and 3126 Marine Diesel Engines.

The use of Cat S·O·S Services oil analysis program is recommended for all lubricating fluids.

TBN is also commonly referred to as Base Number (BN).

The minimum required Total Base Number (TBN) for oil depends on the fuel sulfur level. For 3116 and 3126 Marine Diesel Engines that use distillate fuel, the following guidelines apply:

- For fuel sulfur levels of up to 1.0 percent (10,000 ppm sulfur), use a recommended single grade engine oil of TBN that is double the fuel sulfur level at a minimum. Example: Minimum TBN of the engine oil = Fuel sulfur level percent x 2.
- For fuel sulfur levels of 1.0 percent (10,000 ppm sulfur) or higher, choose a recommended single grade engine oil, and follow the relevant information given in this article.

Note: The typical units used to express sulfur concentration are: parts per million (ppm), mg/kg or percent. The two units ppm and mg/kg are equivalent. In order to convert fuel sulfur level from ppm or mg/kg to percent, divide the ppm or mg/kg value by 10,000. Example:

- Fuel of sulfur level 500 ppm is 0.05 percent sulfur (500 / 10,000 = 0.05)
- Fuel of sulfur level 1000 ppm is 0.1 percent sulfur (1000 / 10,000 = 0.1)

For regions in the world where fuels of high sulfur that exceed 1.0 percent (10,000 ppm (mg/kg)) are available and allowed for use by law, use the following guidelines:

- Choose a recommended single grade oil with the highest TBN.
- Reduce the oil change interval. Base the oil change interval on the oil analysis. Ensure that the oil analysis includes the condition of the oil and a wear metal analysis. Cat S·O·S Services oil analysis is required.

Maintenance Section
Engine Oil for Precombustion Chamber (PC) Diesel Engines

TBN testing is an optional part of the SOS Services oil analysis program. TBN testing may be done in addition to the standard SOS Services tests for oil deterioration. In most applications, the SOS Services tests for oxidation, sulfation, viscosity, and wear will identify oil deterioration.

TBN of the oil is typically measured using “ASTM D2896” and/or “ASTM D4739” test methods. Both methods can be used to measure the TBN of used oils. However, “ASTM D4739” is the preferred method for used oils.

- Consider changing the oil if the “ASTM D2896” test result reaches 4 TBN. Look for other signs of oil deterioration, or abnormal wear to verify the need to change oil.
- Consider changing the oil if the “ASTM D4739” test result reaches 3 TBN. Look for other signs of oil deterioration, or abnormal wear to verify the need to change oil.
- Be aware that both of these test methods have variability of approximately ± 1 TBN. Care should be taken when analyzing the results of the TBN test. Consult a trained S·O·S Services analyst when making oil drain decisions based on oil sample results.

Note: The use of Cat S·O·S Services oil analysis helps environmental sustainability as the best way to optimize oil life. The service will help engines reach the expected life. Consult your Cat dealer regarding the testing required to establish a safe, optimized oil drain interval.

In order to help protect your engine, and optimize oil drain intervals for engine applications and duty cycles, use Cat S·O·S Services oil analysis as follows:

- Recommended as a matter of course
- Recommended in order to determine oil drain intervals when operating on fuel with sulfur levels between 0.05% (500 ppm) and 0.5% (5000 ppm)
- Required in order to determine oil drain intervals when operating on fuel with sulfur levels that are above 0.5% (5000 ppm)

Excessive piston deposits can be produced by oil with a high TBN and/or high ash. These deposits can lead to a loss of control of the oil consumption and to the polishing of the cylinder bore.

There are many factors that contribute to rapid TBN depletion, a not all inclusive list follows:

- High sulfur fuel (The more fuel sulfur, the more rapid the TBN depletion.)
- Faulty engine coolant regulators

- Light loads
- Short operation cycles
- Excessive idling
- Operating in applications where normal operating temperature is seldom reached
- High humidity (allowing excessive condensation)

Bullets 2 through 7 directly above all can contribute to excessive water in the crankcase oil. The water combines with available sulfur to form sulfuric acid. Neutralizing acids that are formed contribute to rapid TBN depletion.

Depending on application severity and localized environmental conditions, and also depending on maintenance practices, operating Direct Injection (DI) diesel engines and operating PC (Precombustion Chamber) diesel engines on fuel with sulfur levels over 0.1 percent (1000 ppm) may require shortened oil change intervals in order to help maintain adequate wear protection. Refer to this Special Publication, “Fuel Specifications” section, “Diesel Fuel Sulfur” topic for additional information.

Note: Do NOT use only this special publication as a basis for determining oil drain intervals.

This Special Publication does not address recommended oil drain intervals, but rather provides guidance that should be used with your specific Operation and Maintenance Manual in determining acceptable oil drain intervals. Refer to the Operation and Maintenance Manual, and consult your Cat dealer to determine the acceptable oil drain interval.

Note: Engine operating conditions play a key role in determining the effect that fuel sulfur will have on engine deposits and on engine wear. Consult your Cat dealer for guidance when fuel sulfur levels are above 0.1% (1000 ppm).

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Engine Oil for Precombustion Chamber (PC) Diesel Engines (Engine Crankcase Fluid Recommendations for All 3500 Series and Smaller PC Diesel Engines)

SMCS Code: 1348; 7581

Most Cat medium and heavy-duty PC diesel engines were produced before 1991.

Cat Precombustion Chamber Oil (Cat PCO) is acceptable for use in Cat PC diesel engines. Cat PCO is available in SAE 40 grade. In addition, PC diesel engines can use the multigrade oils that are recommended for DI diesel engines.

For lubricant information, refer to the “Lubricant” section of this Special Publication for engine oils.

NOTICE

Do not use single grade API CF oils or multigrade API CF oils in Cat 3500 Series, C175 Series, and smaller Direct Injection (DI) diesel engines.

API CF oils are only recommended for Cat 3600 Series and C280 Series diesel engines, and Cat engines that have precombustion chamber (PC) fuel systems. Oils that are used in Cat 3600 Series and C280 Series diesel engines must also pass a 7000 hour field performance evaluation. Contact your Cat dealer for details.

Total Base Number (TBN) and Fuel Sulfur Levels for Precombustion Chamber (PC) Diesel Engines

The use of Cat S·O·S Services oil analysis is strongly recommended for determining oil life.

Note: The following information concerning oil life relative to used oil TBN level is provided for general information only, and is not the recommended method for determining oil life. **If the one half of new oil TBN guideline that is stated below is used for determining oil life, it must only be used in conjunction with a complete S·O·S Services oil analysis program.**

Note: TBN is also commonly referred to as Base Number (BN).

Note: Oils that have not met the requirements of API CK-4 or at least one Cat ECF specification may cause reduced engine life.

Note: While API CF category single grade and multigrade oils may be acceptable for use in PC diesel engines, API CF oils and single grade oils are not acceptable for use in Cat DI engines. Excessive piston deposits will occur when oils that meet only the API CF oil category are used in Cat 3500 Series, C175 Series and smaller DI diesel engines.

The minimum required Total Base Number (TBN) for oil depends on the fuel sulfur level. For PC diesel engines that use distillate fuel, the minimum new oil TBN must be 20 times the fuel sulfur level.

Note: The typical units used to express sulfur concentration are: parts per million (ppm), mg/kg or percent. The two units ppm and mg/kg are equivalent. In order to convert fuel sulfur level from ppm or mg/kg to percent, divide the ppm or mg/kg value by 10,000.

- Fuel of sulfur level 500 ppm is 0.05 percent sulfur (500 / 10,000 = 0.05)
- Fuel of sulfur level 1000 ppm is 0.1 percent sulfur (1000 / 10,000 = 0.1)

Note: The minimum TBN of the new oil is 7 regardless of the fuel sulfur level.

TBN testing is an optional part of the SOS Services oil analysis program. TBN testing may be done in addition to the standard SOS Services tests for oil deterioration. In most applications, the SOS Services tests for oxidation, sulfation, viscosity, and wear will identify oil deterioration.

TBN of the oil is typically measured using “ASTM D2896” and/or “ASTM D4739” test methods. Both methods can be used to measure the TBN of used oils. However, “ASTM D4739” is the preferred method for used oils.

- Consider changing the oil if the “ASTM D2896” test result reaches 4 TBN. Look for other signs of oil deterioration, or abnormal wear to verify the need to change oil.
- Consider changing the oil if the “ASTM D4739” test result reaches 3 TBN. Look for other signs of oil deterioration, or abnormal wear to verify the need to change oil.
- Be aware that both of these test methods have variability of approximately ± 1 TBN. Care should be taken when analyzing the results of the TBN test. Consult a trained S·O·S Services analyst when making oil drain decisions based on oil sample results.

Note: The use of Cat S·O·S Services oil analysis helps environmental sustainability as the best way to optimize oil life. The service will help engines reach the expected life. Consult your Cat dealer regarding the testing required to establish a safe, optimized oil drain interval.

To help protect your engine, and optimize oil drain intervals for engine applications and duty cycles, use Cat S·O·S Services oil analysis as follows:

- Recommended normally
- Recommended to determine oil drain intervals when operating on fuel with sulfur levels between 0.05% (500 ppm) and 0.5% (5000 ppm)

- Required to determine oil drain intervals when operating on fuel with sulfur levels that are above 0.5% (5000 ppm)

Excessive piston deposits can be produced by oil with a high TBN and/or high ash. These deposits can lead to a loss of control of the oil consumption and to the polishing of the cylinder bore.

NOTICE

Depending on application severity and localized environmental conditions, and also depending on maintenance practices, operating Direct Injection (DI) diesel engines and operating PC (Precombustion Chamber) diesel engines on fuel with sulfur levels over 0.1 percent (1000 ppm) may require shortened oil change intervals to help maintain adequate wear protection. Refer to this Special Publication, "Fuel Specifications" section, "Diesel Fuel Sulfur" topic for additional information.

Note: For PC (Precombustion Chamber) diesel engines, which are mainly 1990 and older engines, the minimum new oil TBN must be 20 times the fuel sulfur level. The diesel engine oil types, specifications, and viscosity grades recommendations provided for DI diesel engines in this Special Publication are also applicable to PC diesel engines.

Consult with your Cat dealer regarding the testing that is required in establishing oil drain intervals that are optimized for your application.

To help protect your engine, and to help optimize oil drain intervals for engine specific applications and duty cycles, Cat S·O·S Services oil analysis is:

- Recommended normally
- Very strongly recommended to determine oil drain intervals when operating on fuel with sulfur levels between 0.05% (500 ppm) and 0.5% (5000 ppm)
- Required to determine oil drain intervals when operating on fuel with sulfur levels that are above 0.5% (5000 ppm)

Note: Engine operating conditions play a key role in determining the effect that fuel sulfur will have on engine deposits and on engine wear. Consult your Cat dealer for guidance when fuel sulfur levels are above 0.1% (1000 ppm).

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Marine Transmission Oil

SMCS Code: 3080; 3300; 7581

Cat Transmission/Drive Train Oils

Cat TDTO (Transmission/Drive Train Oil) is balanced in order to give maximum frictional material service life and performance in Cat transmissions. Cat TDTO exceeds the requirements for the Cat TO-4 oil specification which includes the frictional requirements and gear wear requirements. Cat TDTO is offered in different lubricant viscosity grades for maximum service life of components at high ambient temperatures and heavy-duty cycles.

For optimum transmission service life and performance, Cat TDTO is recommended.

Table 8

Lubricant Viscosities for Ambient Temperatures for Cat Marine Transmissions						
Oil Type and Performance Requirements	Cooling of transmission	Viscosity Grade	°C		°F	
			Min	Max	Min	Max
Cat TDTO Cat TO-4	Raw/Sea Water	SAE 30	-15	80	5	176
		SAE 50	-5	95	23	203
	Jacket Water	SAE 50	-5	95	23	203

Consult your Cat dealer for part numbers and for sizes of available containers.

Cat TDTO oil is formulated for transmissions and drive trains only, and should not be used in engines. Shortened engine life will result.

NOTICE

Cat GO is not the same as Cat TDTO, and does not meet Cat TO-4 or TO-4M oil Performance Requirements. Cat GO or commercial gear oils should not be used in compartments that specify Cat TO-4 or TO-4M oil.

Commercial Transmission Oils

If Cat TDTO (Transmission/Drive Train Oil) is not used, commercial oils (second choice oils) must meet Cat TO-4 specifications in order to be allowed for use in Cat marine transmissions. Use TO-4 specification oils that are single grade only.

Commercial Marine Transmissions

For marine transmissions which are not manufactured by Cat, refer to the lubrication recommendation of the Original Equipment Manufacturer (OEM).

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Lubricant Viscosities

SMCS Code: 1000; 7000; 7581

Selecting the Viscosity

Ambient temperature is the temperature of the air in the immediate vicinity of the engine. This temperature may differ due to the engine application from the generic ambient temperature for a geographic region. When selecting the proper oil viscosity for use, review both the regional ambient temperature and the potential ambient temperature for a given engine application. Generally, use the higher temperature as the criterion for the selection of the oil viscosity. Generally, use the highest oil viscosity that is allowed for the ambient temperature when you start the engine. Refer to the “Lubricant Viscosities for Ambient Temperatures” tables for guidance. In cold weather applications, the preferred method is to use properly sized engine compartment heaters and a higher viscosity grade oil. Thermostatically controlled heaters that circulate the oil are preferred.

The proper oil viscosity grade is determined by the minimum ambient temperature (the air in the immediate vicinity of the engine). In order to determine the proper oil viscosity grade, refer to the “Min” column in the table. This information reflects the coldest ambient temperature condition for starting a cold engine and for operating a cold engine. Refer to the “Max” column in the table in order to select the oil viscosity grade for operating the engine at the highest temperature that is anticipated. Unless specified otherwise in the tables, use the highest oil viscosity that is allowed for the ambient temperature when you start the engine.

Engines that are operated continuously should use oils that have the highest recommended viscosity. The oils that have the higher oil viscosity will maintain the highest possible oil film thickness. Refer to this Special Publication, “General Information for Lubricants” article, Lubricant Viscosities tables, and any associated footnotes. Consult your Cat dealer if additional information is needed.

Note: SAE 0W and SAE 5W oils, are not recommended for use in engines that are operated continuously and/or are heavily loaded. Refer to the “Lubricant Viscosities for Ambient Temperatures” tables for guidance. The oils that have the higher oil viscosity will maintain the highest possible oil film thickness. Consult your Cat dealer if additional information is needed.

Note: Generally, use the highest oil viscosity that is available to meet the requirement for the temperature at start-up.

Proper oil viscosity AND oil type/specification are required to maximize engine performance and life. Do NOT use only oil viscosity, or only oil type to determine the engine oil selection. Using only the oil viscosity or only the oil type to determine the engine oil selection can lead to reduced performance and engine failure. Refer to the “Lubricant Viscosities for Ambient Temperatures” tables and to ALL of the associated footnotes.

Follow the recommendations found in the “Lubricant Viscosities for Ambient Temperatures” tables and associated footnotes in order to enhance performance and reduce risk of engine failure.

In colder ambient conditions an engine warm-up procedure and/or supplemental engine fluid compartment heat may be required. Engine warm-up procedures can typically be found in the Operation and Maintenance Manual for the engine. The “Lubricant Viscosities for Ambient Temperatures” tables in this Special Publication include footnotes that address engine warm-up.

Note: Different brand oils may use different additive packages to meet the various engine performance category/specification requirements. For the best results, do not mix oil brands.

Note: The availability of the various Cat oils will vary by region.

Lubricant Viscosity Recommendations for Direct Injection (DI) and Precombustion Chamber (PC) engines

Refer to the minimum temperature in table 9 in order to determine the required oil viscosity for starting a cold engine. Refer to the maximum temperature in order to select the oil viscosity for engine operation at the highest ambient temperature that is anticipated.

Refer to this Special Publication, "General Information for Lubricants" article for important lubricant information.

Supplemental heat is recommended for cold-soaked starts below the minimum ambient temperature. Supplemental heat may be required for cold-soaked starts that are above the minimum temperature that is stated, depending on the parasitic load and other factors. Cold-soaked starts occur when the engine has not been operated for a time, allowing the oil to become more viscous in cooler ambient temperatures.

For oil recommendations for Tier 4 EPA certified engines, EU stage IIIB and IV type approved engines, and Japan Step IV approved engines refer to the Special Publication, "Engine Oil" section. Refer to this Special Publication, "Lubricant Information" section for a list of all Cat engine oils.

Note: Use the highest oil viscosity that is available to meet the requirement for the temperature at start-up.

If ambient temperature conditions at engine start-up require the use of multigrade SAE 0W oil, SAE 0W-40 viscosity grade is preferred over SAE 0W-30.

Note: Cat offers Special Application Engine Oil (SAEO), API CF oil of SAE 30 and SAE 40 viscosity grades. These oils are recommended for use in 3116 and 3126 marine engines.

Note: 10W-30 is the preferred viscosity grade for the following diesel engines when the ambient temperature is above -18°C (0°F) and below 40°C (104°F).

- C7
- C.9
- C9
- 3116
- 3126

Note: C175 Series diesel engines require the use of multigrade SAE 40 oil: SAE 0W-40, SAE 5W-40, SAE 10W-40, or SAE 15W-40. In ambient temperatures of -9.5°C (15°F) or above, SAE 15W-40 is the preferred oil viscosity grade. Refer to table 9 and associated footnotes for guidance on selecting the proper oil viscosity grade for various ambient temperatures.

Table 9

Lubricant Viscosities for Ambient Temperatures for Cat Diesel Engines ⁽¹⁾⁽²⁾						
Engine Type	Oil Type and Performance Requirements	Viscosity Grade	°C		°F	
			Min	Max	Min	Max
Direct Injection (DI) and Pre Combustion (PC)	Cat Cold-Weather DEO-ULS (API CK-4)	SAE 0W-40	-40	40	-40	104
	Cat DEO-ULS SYN (API CK-4)	SAE 5W-40	-30	50	-22	122
	Cat DEO-ULS (API CK-4) Cat DEO (API CPI-4/CPI-4 PLUS)	SAE 10W-30	-18	40	0	104
		SAE 15W-40	-10	50	14	122
Pre Combustion (PC) only	Cat SAEO API CF or equivalent	SAE 30	0	40	32	104
		SAE 40	5	50	41	122

(1) Refer to Special Publication, SEBU6251, "Engine Oil", for information on the recommended and required engine oils for Tier 4 emissions certified engines.

(2) Commercial oils of viscosity grades that are not included in this table may be used if they are per Cat ECF specifications. Refer to the "Cat Engine Crankcase Fluids (ECF) Definitions" table in this Special Publication, "Engine Oil" for more information. Commercial oils are second choice.

Commercial multi-grade oil alternatives must claim at least one of the following Cat specifications: Cat ECF-1-a, Cat ECF-2, Cat ECF-3, API CK-4. Non-Cat commercial oils are as a group second choice oils.

Use the highest oil viscosity that is allowed for the ambient temperature at start-up.

Refer to this Special Publication, "Lubricant Viscosities" and "Cold-Weather Lubricants" for additional information.

Lubricant Viscosity Recommendations (3116 and 3126 Marine Engines)

The information provided in the "Lubricant Viscosities, Selecting the Viscosity" article in the "DI and PC Engines" section is applicable to 3116 and 3126 Marine Engines.

The proper SAE viscosity grade of oil is determined by the minimum ambient temperature during cold engine start-up. The proper viscosity is also determined by the maximum ambient temperature during engine operation.

Refer to Table 10 , minimum temperature, in order to determine the required oil viscosity for starting a cold engine. Refer to maximum temperature in order to select the oil viscosity for engine operation at the highest ambient temperature that is anticipated.

Refer to the "General Information for Lubricants" article for important lubricant information.

Supplemental heat is recommended for cold-soaked starts below the minimum ambient temperature. Supplemental heat may be required for cold-soaked starts that are above the minimum temperature. Use of supplemental heat may depend on the parasitic load and other factors. Cold-soaked starts occur when the engine has not been operated for a time, allowing the oil to become more viscous in cooler ambient temperatures.

Table 10

Lubricant Viscosities for Ambient Temperatures for Cat 3116 and 3126 Marine Engines						
Engine Model	Oil Type and Performance Requirements	Viscosity Grade	°C		°F	
			Min	Max	Min	Max
3116 and 3126 Marine Diesel Engines	Cat SAEO API CF or equivalent	SAE 30	0	40	32	104
		SAE 40	5	50	41	122

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Synthetic Basestock Oils

SMCS Code: 1300; 1348; 7581

Synthetic base oils are acceptable for use in Cat engines. **These oils must meet the performance requirements that are specified by Cat for the engine compartment.**

Synthetic base oils generally perform better than conventional oils in the following two areas:

- Synthetic base oils have improved flow at low temperatures, especially in arctic conditions.
- Synthetic base oils have improved oxidation stability, especially at high operating temperatures.

Some synthetic base oils have performance characteristics that enhance the service life of the oil. However, Cat does not recommend the automatic extension of oil drain intervals for any type of oil, whether synthetic or non-synthetic.

Oil drain intervals for Cat engines can only be adjusted higher (longer interval) after an oil analysis program that contains the following data:

- Oil condition, oil contamination, and wear metal analysis (Cat S·O·S Services oil analysis)
- Trend analysis
- Fuel consumption
- Oil consumption

Refer to the “Extended Engine Oil Drains and Warranty” article in the Foreword of this Special Publication.

i04058332

Re-refined Basestock Oils

SMCS Code: 1300; 1348; 7581

Rerefined basestock oils are acceptable for use in Cat engines **IF these oils meet the performance requirements that are specified by Cat.**

Rerefined basestock oils can be used exclusively in finished oil or in a combination with new basestock oils. The US military specifications and the specifications of other heavy equipment manufacturers also allow the use of rerefined basestock oils that meet the same criteria.

The process that is used to make rerefined basestock oil should adequately remove all wear metals and all additives that are in the used oil. Vacuum distillation and the hydrotreating of the used oil are acceptable processes that are used for producing rerefined base oil.

Note: Filtering is inadequate for the production of high quality rerefined basestock oils from used oil.

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Aftermarket Oil Additives

SMCS Code: 1300; 1348; 7581

Cat does not recommend the use of aftermarket additives in oil. Aftermarket additives are not necessary in order to achieve the maximum service life of the engine or rated performance of the engine. Fully formulated, finished oils consist of base oils and of commercial additive packages. These additive packages are blended into the base oils at precise percentages in order to help provide performance characteristics that meet industry standards.

There are no industry standard tests that evaluate the performance or the compatibility of aftermarket additives in finished oil. Aftermarket additives may not be compatible with the finished oil additive package, which could lower the performance of the finished oil. The aftermarket additive could fail to mix with the finished oil and produce sludge in the crankcase. Cat discourages the use of aftermarket additives in finished oils.

To achieve the best performance from a Cat engine, conform to the following guidelines:

- Select the proper Cat oil or commercial oil that has passed the Field Performance Evaluation. Refer to the “Selecting a Commercial Oil” article in the “Lubricant Specifications” section of this Special Publication.

- Refer to the appropriate “Lubricant Viscosities for Ambient Temperatures” table in this Special Publication in order to find the correct oil viscosity grade for your engine.
- At the specified interval, service the engine compartment. Use appropriate new oil and install an appropriate new oil filter.
- Perform maintenance at the intervals that are specified in the Operation and Maintenance Manual, “Maintenance Interval Schedule”.

i04173974

Specialty Lubricants

SMCS Code: 7000; 7581

Table 11

Special-Purpose Cat Lubricants	
Item	Size
6V-4876 Lubricant ⁽¹⁾	500 g (17.6 oz)
5P-3931 Thread Compound ⁽²⁾	150 g (5.3 oz)

(1) Recommended for use on typical components such as head bolt threads and washers.

(2) Recommended for mating connectors such as exhaust manifold studs and exhaust manifold nuts.

Table 12

UV Visible Dyes for Leak Detection			
Part Number	Description	Size	Dosage
To detect oil leaks in engines, transmissions, hydraulic systems			
1U-5572	Oil Glo 22 Additive	28.4 gram (1 ounce) bottle	28.4 gram (1 ounce) per 7.58 L (2 US gal) of oil
1U-5573	Oil Glo 22 Additive	0.47 L (1 pint) bottle	28.4 gram (1 ounce) per 7.58 L (2 US gal) of oil
To detect fuel leaks or suspected fuel dilution			
1U-5574	Gas Glo 32 Additive	28.4 gram (1 ounce) bottle	28.4 gram (1 ounce) per 37.9 L (10 US gal) of gasoline or diesel fuel
1U-5575	Gas Glo 32 Additive	0.47 L (1 pint) bottle	28.4 gram (1 ounce) per 37.9 L (10 US gal) of gasoline or diesel fuel
To detect cooling system leaks			
1U-5576	Water Glo 23 Additive	28.4 gram (1 ounce) bottle	28.4 gram (1 ounce) per 151.5 L (40 US gal) of water
1U-5577	Water Glo 23 Additive	0.47 L (1 pint) bottle	28.4 gram (1 ounce) per 151.5 L (40 US gal) of water

The dyes must be used with a special Glo Gun to detect the leaks. Consult with your local Cat dealer for availability.

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Cold Weather Lubricants

SMCS Code: 1300; 1348; 7581

Engine

NOTICE

Recommended compartment warm-up procedure must be followed. Refer to the machine Operation and Maintenance Manual. Also refer to the relevant "Lubricant Viscosities for Ambient Temperatures" tables footnotes in this Special Publication and to the "Warm-up Procedures for Machines that are used in Cold Weather - (Generic)" topic in this Special Publication.

NOTICE

Excessive engine idling time can contribute to excessive water in the crankcase oil, causing corrosion, sludge, and other problems. Excessive engine idling time can also lead to injector fouling, piston and combustion chamber deposits, corrosive damage, and increased oil consumption.

For proper selection of oil type and/or specification, refer to this Special Publication, "Engine Oil" section. Also, refer to the relevant "Lubricant Viscosities for Ambient Temperatures" tables in this Special Publication.

For the proper selection of oil viscosity grade, refer to the relevant "Lubricant Viscosities for Ambient Temperatures" table in this Special Publication. Also, refer to this Special Publication, "Lubricant Viscosities" article.

NOTICE

Not following the recommendations found in the "Lubricant Viscosities for Ambient Temperatures" tables and associated footnotes can lead to reduced performance and engine failure.

NOTICE

Do NOT use only the oil viscosities when determining the recommended oil for an engine compartment. The oil type (performance requirements) MUST also be used.

For easier cold weather starting, make sure that all the components of the engine electrical system are properly maintained. All electrical wiring and connections should be free of the following: fraying, damaged insulation, and corrosion. Batteries should be kept fully charged and warm. The batteries and the battery cables need to be the proper size for the application.

Various starting aids are available to assist with cold engine starts in low temperature conditions. Follow the recommendations that are provided by the manufacturer of the starting aid. Refer to the "Aftermarket Products and Warranty" article in the "Warranty Information" section of this special publication.

Additional information on cold-weather operation is available in Special Publication, SEBU5898, "Cold Weather Recommendations For All Caterpillar Equipment". This publication is available from your Cat dealer.

Additionally, for more information on cold-weather operation, refer to this Special Publication, "Fuel Specifications" section. Also refer to this Special Publication, "Cooling System Specifications" (Maintenance Section).

Before attempting to start the engine, make sure that the oil in the engine is fluid enough to flow. Check the oil by removing the dipstick. If the oil will drip from the dipstick, then the oil should be fluid enough to allow the engine to start. Do not use oil that has been diluted with kerosene. Kerosene will evaporate in the engine. Evaporation will cause the oil to thicken. Kerosene will cause swelling and softening of the silicone seals. Kerosene will dilute the oil additives. Dilution of the oil additives will reduce the oil performance, and reduce the engine protection that the additives provide. If your machine is equipped with a gasoline starting engine (earlier machine), make sure that the oil is fluid enough to flow.

If the viscosity of the oil is changed for colder weather, also change the filter element. If the filter is not changed, the filter element and the filter housing can become a solid mass. After you change the oil, operate the engine to circulate the thinner oil.

When you start a cold-soaked engine or when you operate an engine in ambient temperatures that are below -18°C (0°F), use base oils that can flow in low temperatures. These multigrade oils have lubricant viscosity grade of SAE 0W or of SAE 5W. An example of viscosity grade is SAE 5W-40.

When you start a cold-soaked engine or when you operate an engine in ambient temperatures that are below -30°C (-22°F), use a synthetic basestock multigrade oil. The oil should have a lubricant viscosity grade of SAE 0W or SAE 5W. Use an oil with a pour point that is lower than -40°C (-40°F).

Note: Use the highest oil viscosity grade that is allowed for the ambient temperature when you start the engine. If a different oil viscosity grade is specified in "Lubricant Viscosities for Ambient Temperatures", use the viscosity grade that is specified in the table. **In arctic applications, a properly sized engine compartment heater is recommended, and use a higher viscosity grade oil.** Refer to the "Lubricant Viscosities" article in this Special Publication for further details.

Note: Cold-soaked starts occur when the engine has not been operated for a time. The oil becomes more viscous due to cooler ambient temperatures. Supplemental heat is recommended for cold-soaked starts that are below the minimum ambient temperatures listed in the “Lubricant Viscosities for Ambient Temperatures” tables. Supplemental heat may be required for cold-soaked starts that are above the minimum temperature that is stated, depending on the parasitic load and other factors.

NOTICE

Engines that use fluid or pan heaters, or heated enclosures, or are kept running under load, etc. can, and generally should use higher viscosity oil. The “Lubricant Viscosities for Ambient Temperatures” tables (Maintenance Section) **Minimum** viscosity for ambient temperature recommendations are for cold-soaked conditions. Use the highest viscosity oil that is allowed for the ambient temperature at startup. **BUT, under continuous usage (multiple shifts per day),** and/or when using **fluid or pan heaters,** use a higher viscosity oil than the minimum recommended viscosity for cold-soaked starting conditions. The higher viscosity oil will maintain the highest possible oil film thickness. Refer to the “Lubricant Viscosities for Ambient Temperatures” tables and the table footnotes for exceptions.

Example: The oil viscosity recommended for use in Cat diesel engines for cold-soaked starts at -40°C (-40°F) is multigrade oil of the SAE 0W viscosity grade (SAE 0W-30). If the diesel engine is run continuously, SAE 15W-40 viscosity grade diesel engine oil can be used and is generally the preferred oil viscosity in this situation.

NOTICE

If ambient conditions warrant, a higher viscosity oil of the recommended specification for a given compartment may need to be installed in order to provide adequate film thickness.

Non-Engine Machine Compartments

NOTICE

Recommended compartment warm-up procedure must be followed. Refer to the machine Operation and Maintenance Manual. Also refer to the relevant “Lubricant Viscosities for Ambient Temperatures” table footnotes in this Special Publication and to the “Warm-up Procedures for Machines that are used in Cold Weather - (Generic)” topic in this Special Publication.

For the proper selection of oil type and/or specification, refer to this Special Publication, “Lubricant Specifications” section. Also, refer to the relevant “Lubricant Viscosities for Ambient Temperatures” tables (Oil Type and Specification column) and table footnotes in this Special Publication.

For the proper selection of oil viscosity grade, refer to this Special Publication, “Lubricant Viscosities for Ambient Temperatures” tables. Also, refer to this Special Publication, “Lubricant Viscosities” article.

NOTICE

Not following the recommendations found in the “Lubricant Viscosities for Ambient Temperatures” tables and associated footnotes can lead to reduced performance and compartment failure.

If the viscosity of the oil is changed for colder weather, also change the filter element. If the filter is not changed, the filter element and the filter housing can become a solid mass. After you change the oil, operate the engine to circulate the thinner oil.

Note: Use the highest oil viscosity grade that is allowed for the ambient temperature when you start the machine. If a different oil viscosity grade is specified in the “Lubricant Viscosities for Ambient Temperatures” table, use the viscosity grade that is specified in the table. **In arctic applications, a properly sized engine compartment heater is recommended, and use a higher viscosity grade oil.** Refer to the “Lubricant Viscosities” article in this Special Publication for further details.

Note: Cold-soaked starts occur when the machine has not been operated for a time. The oil becomes more viscous due to cooler ambient temperatures.

NOTICE

Machines that use fluid or pan heaters, or heated enclosures, or are kept running under load, etc. can, and generally should use higher viscosity oil. The “Lubricant Viscosities for Ambient Temperatures” tables (Maintenance Section) **“Minimum”** viscosity for ambient temperature recommendations are for cold-soaked conditions. Use the highest viscosity oil that is allowed for the ambient temperature when you start the machine **BUT, under Continuous Usage (Multiple Shifts/Day),** and/or when using **fluid or pan heaters,** etc., use a higher viscosity oil, **NOT** the oil with the minimum recommended viscosity for cold-soaked starting conditions. The higher viscosity oil will maintain the highest possible oil film thickness. Refer to the “Lubricant Viscosities for Ambient Temperatures” tables and the table footnotes for exceptions.

NOTICE

Some machine compartments do not allow the use of SAE 0W, SAE 5W or certain other viscosity grade oils. Refer to the tables for “Lubricant Viscosities for Ambient Temperatures” that are in this Special Publication.

NOTICE

If ambient conditions warrant, a higher viscosity oil of the recommended specification/category for a given compartment may need to be installed in order to provide adequate film thickness.

NOTICE

Recommended compartment warm-up procedure must be followed. Refer to the machine Operation and Maintenance Manual. Also refer to the relevant “Lubricant Viscosities for Ambient Temperatures” tables footnotes in this Special Publication and to the “Warm-up Procedures for Machines that are used in Cold Weather - (Generic)” topic in this Special Publication.

Warm-Up Procedures for Machines that are used in Cold Weather (Generic)

Note: For recommendations that are specific to your machine, refer to the Operation and Maintenance Manual for your machine.

After the engine is warm, warm up the other systems. Start with the hydraulic system. Run the engine at less than one-third throttle and slowly move the control lever to lift the attachment. Initially, lift the control lever for a few centimeters (inches). Lower the attachment slowly. Continue the following sequence: raising, lowering, extending, and retracting. Extend the travel during each cycle. This operation must be performed for all hydraulic circuits. Alternate between all the attachments.

Exercise the transmission and the power train. If you cannot move the control for the transmission, perform the following steps:

- Engage the parking brake or apply the parking brake.
- Run the engine slightly above LOW IDLE.
- Shift the transmission several times from FIRST GEAR FORWARD to FIRST REVERSE.

Release the brake. Move the equipment forward and backward for several meters (yards). Exercise the machine for several minutes.

To reduce the total warm-up time, start exercising the entire machine before you complete the hydraulic warm-up time.

Operate under a light load until the systems reach normal operating temperatures.

If the engine temperature is not high enough, enclose the engine and block the radiator. A thermostat that opens at a higher temperature will not increase the engine temperature if the engine is not under load.

To prevent seal damage and gasket damage, keep the pipe for the engine crankcase breather clear of blockage.

In extreme conditions, use a canvas over the engine compartment. Heat the engine area with a space heater. Heating will aid in starting the engine. Extending the canvas over the hydraulic components will provide initial warming of the components.
Follow all applicable safety guidelines.

Running the engine at low idle will not keep the hydraulic systems warm.

cold-weather operations require more time for completion than other operations. The extra time that is spent in properly caring for the equipment can prolong the life of the equipment. Extra care is especially helpful in extreme conditions. Longer equipment life will decrease overall cost.

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S·O·S Services Oil Analysis

SMCS Code: 1000; 1348; 3080; 4070; 4250; 4300; 5095; 7000; 7542; 7581

NOTICE

These recommendations are subject to change without notice. Consult your local Cat dealer for the most up to date recommendations.

Cat has developed a maintenance management tool that evaluates oil degradation and detects the early signs of wear on internal components. The Cat tool for oil analysis is called S·O·S oil analysis and the tool is part of the S·O·S Services program. S·O·S oil analysis divides oil analysis into four categories:

- Component wear rate
- Oil condition
- Oil contamination
- Oil identification

Component Wear Rate analysis evaluates the wear that is taking place inside the lubricated compartment. The S·O·S Services analyst uses the results of elemental analysis and particle count tests to evaluate the wear. Trend analysis and proprietary wear tables are then used to determine if wear rates are normal or abnormal.

Oil Condition analysis is used to determine if the oil has degraded. Tests are done to look at the oxidation, sulfation, and viscosity of the oil. The S·O·S Services analyst uses established guidelines or trend analysis to determine if the oil has reached the useful life limit.

Oil Contamination tests are performed to determine if anything harmful has entered the oil. This analysis relies on the results from the following tests: elemental analysis, soot, particle count, fuel dilution, water, and glycol. The S·O·S Services program has guidelines for the level of contamination that are allowed in Cat engines.

Oil Identification is another important part of the S·O·S oil analysis program. The wrong oil in an engine can severely damage major components. The S·O·S Services analyst uses elemental analysis and viscosity results to identify key characteristics of the oils.

These four types of analysis are used to monitor the condition of your equipment, and to help you identify potential problems. A properly administered S·O·S Services oil analysis program will reduce repair costs and the program will lessen the impact of downtime.

The S·O·S oil analysis program uses a wide range of tests to determine the condition of the oil and the lubricated compartment.

Guidelines that are based on experience and a correlation to failures have been established for these tests. See the following chart for the guidelines. Exceeding one or more of these guidelines could indicate serious fluid degradation or a pending component failure. A trained person at your Cat dealership should make the final analysis.

Oil analysis is one of the diagnostic tools to determine engine health. Oils that are within the limits given by the guidelines may not indicate all engine health issues. Under certain conditions, including but not limited to severe operating conditions, oils that are within the limits given by the guidelines may require changing early.

Note: Cooling system problems will also reduce the life of engines. S·O·S coolant analysis and S·O·S oil analysis provide a complete and accurate method for monitoring the health of all engine systems. Refer to the S·O·S Services coolant analysis information in this Special Publication. A properly administered S·O·S Services program will reduce repair costs and lessen the impact of downtime.

Refer to the “Contamination Control” article in this Special Publication for recommended fluid cleanliness targets.

Table 13

S·O·S Oil Analysis Guidelines	
Test Parameter	Guideline
Oxidation	(1)
Soot	(1)
Sulfation	(1)
Wear Metals	Trend Analysis and Cat Wear Table ⁽¹⁾ norms
Water	0.5% maximum
Glycol	0%
Fuel Dilution	based on viscosity ⁽¹⁾ and GC ⁽²⁾ fuel dilution in excess of 4%
Viscosity “ASTM D445” measured at 100° C (212° F)	+/-3 centistoke (cSt) change from new oil viscosity.

(1) Acceptable values for these parameters are proprietary to the S·O·S oil analysis program.

(2) Gas Chromatograph

Note: Most oil analysis programs do not detect larger particles in the oil sample. Some failure modes only produce larger particles. Oil analysis alone will not always detect an impending failure. Oil filters should be sectioned and inspected for the presence of visible particles.

The engine oil consumption must be measured and recorded. A significant increase in oil consumption can indicate a problem with cylinder pack deposits or components. Additionally, oil additions dilute wear metals and other contaminants. Oil analysis results may become inaccurate.

Consult your Cat dealer for complete information and assistance about the S·O·S oil analysis program.

Obtaining S·O·S Oil Samples

Before you obtain an S·O·S oil sample, operate the engine until the oil is warm and the oil is circulated. Then obtain the S·O·S oil sample.

In order to obtain a good oil sample, do not take the oil sample from the drain stream. The drain stream method can allow a stream of dirty oil from the bottom of the compartment to contaminate the sample. Likewise, never dip an oil sample from an oil container or pour a sample from a used filter.

There are two acceptable ways to obtain S·O·S oil samples. **The following methods are listed in the order that is preferred:**

- Use an in-line sampling valve on the pressurized oil manifold.

- Use a sampling gun (vacuum pump) that is inserted into the sump.

Use of the in-line sampling valve is the preferred method. This method provides samples that are less likely to be contaminated. Whenever you obtain the samples, obtain the samples from the same point. The samples will be more representative of the oil that is in the system.

Normally, the oil sample is taken at low idle. If the flow rate is too low, increase engine speed to HIGH IDLE in order to obtain the oil sample.

NOTICE

Do not use the same vacuum sampling pump for extracting oil samples that is used for extracting coolant samples.

A small residue of either type sample may remain in the pump and may cause a false positive analysis for the sample being taken.

Always use a separate pump for oil sampling and a separate pump for coolant sampling.

Failure to do so may cause a false analysis which could lead to customer and dealer concerns.

Oil Sampling Interval

Take the oil samples as close as possible to the standard intervals. In order to receive the full value from S·O·S oil analysis, establish a consistent trend of data. In order to establish a pertinent history of data, perform consistent oil samplings that are evenly spaced.

Recommended interval for engine oil samples is given in Table 14 . A 250 hour sampling interval can provide a timely indication of oil contamination and oil degradation.

Measure and record engine oil consumption in order to allow accurate oil analysis. Oil additions during the sampling interval dilute wear metals and other contaminants.

Table 14

S·O·S Oil Sampling Interval for Engine crankcase	
Recommended Interval ⁽¹⁾⁽²⁾	Oil Type
Every 250 Service Hours	Cat DEO Cat DEO-ULS

⁽¹⁾ Severe applications may require a more frequent oil sampling interval.

⁽²⁾ Under certain conditions, the Cat dealer or the Operation and Maintenance Manual may allow a longer interval between oil samplings.

Note: Refer to the Operation and Maintenance Manual for your engine for recommended oil drain intervals.

Consult your Cat dealer for complete information and assistance in order to establish an S·O·S Services program for your engine.

More Frequent S·O·S Sampling Improves Life Cycle Management

Traditionally, the suggested S·O·S sampling intervals for diesel engines have been at 250 hours. However in severe applications, more frequent oil sampling is recommended. Severe service for lubricated compartments occurs at high loads, in high temperatures, and in dusty conditions. If any of these conditions or other severe service indicators exist, sample the engine oil at 125 hour intervals. These additional samples will increase the chance of detecting a potential failure.

Determining Optimum Oil Change Intervals

Sampling the engine oil at every 125 hours provides information for oil condition and for oil performance. This information is used to determine the optimum usable life of a particular oil. Also, more points of data will allow closer monitoring of component wear rates. Close monitoring also allows you to obtain the maximum use of the oil. For detailed information on optimizing oil change intervals, consult your Cat dealer.

This Special Publication does not address recommended oil drain intervals. Refer to your engine Operation and Maintenance Manual, and consult your Cat dealer for additional guidance, including but not limited to guidance on establishing optimized and/or acceptable oil drain intervals.

Note: The use of Cat S·O·S Services oil analysis helps environmental sustainability as the best way to optimize oil life. S·O·S Services will help engines reach expected life. Consult your Cat dealer regarding the testing required to establish a safe, optimized oil drain interval.

Standard oil drain intervals as published in engine Operation and Maintenance Manual are for typical applications:

- Using recommended oils
- Using good fuel
- Using recommended filters
- Using industry standard good maintenance practices
- Following maintenance intervals as published in engine Operation and Maintenance Manual

More severe applications may require shortened oil drain intervals, while less severe applications may allow for longer than standard oil drain intervals. High load factors (above 75%), particularly with high sulfur fuels, can contribute significantly to reducing oil drain intervals below standard oil drain intervals.

Consult your Cat dealer regarding the testing that is required in establishing oil drain intervals that are optimized for your application.

In order to help protect your engine, and help optimize oil drain intervals for engine applications and duty cycles, use Cat S·O·S Services oil analysis as follows:

- Recommended as a standard practice
- Recommended in order to determine oil drain intervals when using fuel with sulfur levels between 0.05% (500 ppm) and 0.5% (5000 ppm)
- Required in order to determine oil drain intervals when using fuel with sulfur levels that are above 0.5% (5000 ppm)

Note: Engine operating conditions play a key role in determining the effect that fuel sulfur will have on engine deposits and on engine wear. Consult your Cat dealer for guidance when fuel sulfur levels are above 0.1% (1000 ppm).

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Lubricating Grease

SMCS Code: 0645; 1000; 7000; 7581

NOTICE

These recommendations are subject to change without notice. Consult your local Cat dealer for the most up to date recommendations.

Note: Non-Cat commercial greases are as a group second choice greases. Within this grouping of second choice greases there are tiered levels of performance.

NOTICE

Cat does not warrant the quality or performance of non-Cat fluids and greases.

Caterpillar provides a family of grease products that vary in performance from moderate to high performance. These greases service the entire line of Cat products in the wide variety of climates throughout the world. From this variety of Cat grease products, you can find a Cat grease that will meet or exceed the performance requirements for almost every machine that is produced by any Original Equipment Manufacturer (OEM), and for almost every machine application or equipment application.

Before selecting a grease product, the performance requirements must be determined. Consult the grease recommendations in your Operation and Maintenance Manual. Also, consult your Cat dealer for a list of greases that have the performance specifications and the available container sizes.

This grease chapter refers to NLGI of the grease products offered by Caterpillar. The National Lubricating Grease Institute (NLGI) classifies the greases per their consistency or hardness according to "ASTM D4950" and "SAE J310". The higher the NLGI value the more firm the grease. NLGI is an important classification for greases and it should be used along with other properties such as stability, corrosion resistance, viscosity, etc.

Note: Always choose grease that meets or exceeds the recommendations that are specified by the equipment manufacturer for the application.

Some work sites require the use of a single grease to fulfill the needs of all the equipment. Always choose a grease that meets or exceeds the requirements of the most demanding application. Remember that commercial products which barely meet the minimum performance requirements can be expected to produce the minimum life for the parts. It is not recommended to purchase grease products based on the lowest cost as the only consideration. Instead, use the grease that yields the lowest **total** operating cost. This cost should be based on an analysis that includes the improved product life, costs of parts, labor, downtime, and the cost of the amount of grease that is required.

Note: Certain Cat grease products are formulated with Molybdenum disulfide (MoS₂ or "Moly"). The Moly used in Cat greases is of a technical fine grade. This size meets the special requirements of some rolling element bearings, joints, and other moving components of tight clearances.

Note: When the grease in a joint is changed from one type of grease to another or a grease from a different supplier is to be used, the general recommendation is to purge all of the old grease from the joint. Some greases are not chemically compatible. Consult your supplier in order to determine if the greases are compatible.

If in doubt, Purge!

Note: All Cat greases are "chemically" compatible with each other. Mixing of Cat greases will not result in an adverse chemical reaction. However, mixing of Cat greases might result in reduced performance.

Cat Utility Grease

Cat Utility Grease is formulated for use in applications that have a low severity to a medium severity and moderate temperatures. Cat Utility Grease is a National Lubricating Grease Institute (NLGI) grade 2 grease. This grease is made with petroleum base oil and a lithium complex thickener.

Cat Utility Grease is formulated to offer a good service life in engine applications. Service Life refers to the percent of change after 100,000 strokes per "ASTM D217".

For more information on Cat Utility Grease, refer to the product information on the package or to the data sheet of this product.

Note: If the application calls for a utility grease and Cat Utility Grease is not available, consult the grease data sheets. Use a substitute that meets or exceeds the performance characteristics of Cat Utility Grease.

Cat Ball Bearing Grease

This grease is recommended for applications that utilize roller bearings and ball bearings at low loads to moderate loads at high speed. Typical applications for this grease are electric motors, alternators, and constant velocity (CV) joints for automotive products. Cat Ball Bearing Grease is an NLGI grade 2 grease. This grease is made with petroleum base oil and polyurea thickener.

Cat Ball Bearing Grease is formulated to offer very good service life in engine applications. Service Life refers to the percent of change after 100,000 strokes per "ASTM D217".

Cat Ball Bearing Grease offers good corrosion protection and good water washout resistance. Corrosion protection is the resistance to salt water per "ASTM B1743". Water washout resistance refers to roll stability with water and the percent of change "ASTM D1264".

For more information on Cat Ball Bearing Grease, refer to the product information on the package or to the data sheet of this product.

Cat White Assembly Grease

Cat White Assembly Grease is formulated for use in applications that have low to medium severity and moderate temperatures. This grease has been made extra tacky in order to hold gaskets, O-rings, and needle bearings to aid in the assembly of engines, transmissions, and other components. Cat White Assembly Grease is an NLGI grade 2 grease. This grease is made with a petroleum base oil and a lithium complex thickener.

Note: Cat grease products given above are applicable to marine engines. Refer to Special Publication, SEBU6250, "Caterpillar Machine Fluids Recommendations" for other Cat grease products that include extreme applications and can also be used in marine engines. Consult your Cat dealer for information and for availability.

Fuel Specifications

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General Fuel Information

SMCS Code: 1250; 1280

NOTICE

Every attempt is made to provide accurate, up-to-date information. By the use of this document, you agree that Caterpillar Inc. is not responsible for errors or omissions.

The information provided are the latest recommendations for the Caterpillar diesel engines that are covered by this Special Publication. This information supersedes all previous recommendations which have been published for the Caterpillar diesel engines that are covered by this Special Publication. Special fluids are required for some engines and continued use of these special products will be necessary. Refer to the applicable Operation and Maintenance Manual.

This publication is a supplement to the Operation and Maintenance Manual. This publication does not replace the engine-specific Operation and Maintenance Manuals.

NOTICE

These recommendations are subject to change without notice. Consult your local Cat dealer for the most up to date recommendations.

NOTICE

In order to avoid potential damage to your Cat machine and/or Cat engine, only purchase Cat fluids and Cat filters through your Cat dealer or Cat authorized outlets. For a list of authorized Cat parts outlets in your area, consult your Cat dealer.

If you purchase what appear to be Cat fluids and/or Cat filters through other outlets/sources, you are at a very high risk of purchasing counterfeit (“look-alike”) products.

Counterfeit or “look-alike” products may visually appear the same as the original Cat product, but the product performance and internal quality will typically be very low.

Counterfeit or “look-alike” products have a very high likelihood of causing and/or allowing engine and/or machine compartment damage.

NOTICE

Many of the guidelines, recommendations, and requirements that are provided in this Special Publication are interrelated. Before using the provided information, it is the responsibility of the user of this Special Publication to read and understand the information provided in its entirety.

It is the responsibility of the user of this Special Publication to follow all safety guidelines found in this Special Publication and in engine and/or machine specific Operation and Maintenance Manual when performing all recommended and/or required engine, engine systems, and/or machine maintenance.

For questions concerning the information presented in this Special Publication and/or in your product Operation and Maintenance Manual, and/or for additional guidelines and recommendations (including maintenance interval recommendations/requirements) consult your Cat dealer.

Follow all industry standard safety practices when operating engines and/or machines and when performing all recommended and/or required maintenance.

NOTICE

Commercial products that make generic claims of meeting “Cat” requirements without listing the specific Cat recommendations and requirements that are met may not provide acceptable performance. Commercial products may cause reduced engine and/or machine fluid compartment life. Refer to this Special Publication and refer to product specific Operation and Maintenance Manual for Cat fluids recommendations and requirements.

Note: Instructions for the installation of the filter are printed on the side of each Caterpillar spin-on filter. For nonCaterpillar filters, refer to the installation instructions that are provided by the supplier of the filter.

NOTICE

In order to meet expected fuel system component life, 4 micron(c) absolute or less secondary fuel filtration is required for all Cat diesel engines that are equipped with common-rail fuel systems. Also, 4 micron(c) absolute or less secondary fuel filtration is required for all Cat diesel engines that are equipped with unit injected fuel systems. For all other Cat diesel engines (mostly older engines with pump, line and nozzle type fuel systems), the use of 4 micron(c) absolute or less secondary fuel filtration is strongly recommended. Note that all current Cat diesel engines are factory equipped with Cat Advanced Efficiency 4 micron(c) absolute fuel filters.

In order to obtain additional information on Cat designed and produced filtration products, refer to the "Reference Material" article, "Filters" and "Miscellaneous" topics in this Special Publication. Consult your Cat dealer for assistance with filtration recommendations for your Cat machine.

NOTICE

Caterpillar does not warrant the quality or performance of non-Caterpillar fluids and filters.

Diesel Fuel and Injector Health

Fuel injectors are highly engineered components built with very tight clearances and designed to spray precise amounts of fuel into the combustion chamber. The accurate operation of the fuel injectors supports the performance and noise of the engine and impacts the emissions.

Fuels that are not per the characteristics described in this chapter and in the recommended specifications can lead to deposits in the injector, cold start issues, smoke, noise, low performance, increased emissions, and other issues.

Deposits in the injector can be external or internal:

- External deposits form on the tip of the injector. These deposits become carbonaceous (mainly composed of carbon) due to the high temperature of the combustion chamber. The deposits prevent the appropriate fine spray of the fuel and the proper atomization in the combustion chamber. These issues can significantly degrade the operation of the engine.
- Internal deposits form on the internal moving components of the injector. These deposits close the tight clearances in the injector and prevent the components from moving as designed. Some internal deposits can be "soaps" that form due to reaction of sodium contaminants in the fuel with certain fuel additives. Sometimes, these soaps cause injector sticking in the open or closed positions. The result is a malfunction of the injector.

Cleanliness of the injectors impact the performance, power, fuel consumption, and emissions throughout the life of modern diesel engines. To keep the injectors clean, avoid injector deposits and ensure appropriate operation and long life of the injectors:

- Ensure that the fuel has the proper chemistry. Fuels that are per the specifications given in this chapter have the appropriate cetane value, viscosity, density, distillation, stability, lubrication, and energy content.
- Ensure that the fuel has the proper quality. Fuel quality is determined by the lack of contamination and water. This quality is ensured through following the contamination control recommendations and filtering the fuel as recommended by the Operation and Maintenance Manual and as stated in this chapter.
- The use of Fuel Additives to improve detergency and overall quality of fuels may be needed sometimes. When needed, Caterpillar recommends the use of Cat Fuel Conditioner and Cat Fuel System Cleaner. Caterpillar cannot validate or recommend other additives available in the market. The fuel supplier should be consulted when using additives to enhance other properties of the fuel.

Consult with the engine or machine Operation and Maintenance Manual for any special fuel requirements.

Consult with your fuel supplier to ensure that the fuel follows all the recommendations given in this chapter.

General Recommendations and Contamination Control Guidelines for Fuels

Follow all applicable industry standards and all applicable governmental, environmental, and safety guidelines, practices, regulations, and mandates.

Note: These general recommendations and guidelines concerning maintenance and care of fuel and fuel storage systems are not intended to be all inclusive. **Discuss proper fuel safety and health, handling, and maintenance practices with your fuel supplier.** Use of these general recommendations and guidelines does not lessen the engine owners and/or fuel supplier responsibility to follow all industry standard practices for fuel storage and for fuel handling.

Note: Where recommendations for draining water and/or sediment and/or debris are stated, dispose of this waste according to all applicable regulations and mandates.

Note: Caterpillar filters are designed and built to provide optimal performance and protection of the fuel system components.

Clean fuels, as detailed below, are strongly recommended to allow optimal performance and durability of the fuel systems and to reduce power loss, failures, and related down time of engines.

Fuels of "ISO 18/16/13" cleanliness levels are particularly important for new fuel system designs such as Common Rail injection systems and unit injection systems. These new injection system designs utilize higher fuel pressures and are designed with tight clearances between moving parts to meet required stringent emissions regulations. Peak injection pressures in current fuel injection systems may exceed 30,000 psi. Clearances in these systems are less than 5 µm. As a result, particle contaminants as small as 4 µm can cause scoring and scratching of internal pump and injector surfaces and of injector nozzles.

Water in the fuel causes cavitation, corrosion of fuel system parts, and provides an environment where microbial growth in the fuel can flourish. Other sources of fuel contamination are soaps, gels, or other compounds that may result from undesirable chemical interactions in the fuels, particularly in Ultra Low Sulfur Diesel (ULSD). Gels and other compounds can also form in biodiesel fuel at low temperatures or if biodiesel is stored for extended periods. The best indication of microbial contamination, fuel additives, or cold temperature gel is very rapid filter plugging of bulk fuel filters or machine fuel filters.

To reduce downtime due to contamination, follow these fuel maintenance guidelines in addition to the recommendations given in the "Contamination Control" Chapter in this Special Publication:

- Use high-quality fuels per recommended and required specifications (refer to the "Fuel" chapter in this Special Publication).
- Use recommended Cat filtration products. Change your fuel filters per recommended service requirements or as needed. Never fill the new secondary fuel filter with fuel before installation. Use the fuel priming pump to remove air from the system.
- Follow proper practices of fuel transport and filtration from storage tank to the machine to allow the delivery of clean fuel to machine tank. Keep the fuel storage tank clean of water, debris, and sediment.
- Filter the fuel coming into the bulk storage fuel tank and at every subsequent transfer into and out of any container and prior to adding to the engine fuel tank preferably through filters with a rating of 20 microns (c) absolute or less. The use of wire mesh media (strainer-type filters) is NOT recommended except for when filters with standard media (cellulose or synthetic) are downstream of the wire mesh media filters. Wire mesh filters typically have poor filtration efficiency and can corrode with time, allowing the passing of large particles.
- Caterpillar recommends the use of properly designed and grounded bulk fuel filter / coalescer units which remove both particulate contamination and water in a single pass. These units have the ability to clean fuel to "ISO 16/13/ 11" or cleaner and remove free water to 500 ppm (mg/kg) or less. Cat offers heavy duty filter / coalescer units to accommodate fueling rates from 50 to 300 gpm (gallons per minute). Cat custom designs filter / coalescer units specifically for the conditions of fuel at the worksite if needed. Refer to Special Publication, "Cat Bulk Fuel Filtration Systems" PEHJ0156, and consult your Cat dealer for availability of bulk filtration products.
- Fill machine fuel tanks with fuels of "ISO 18/16/13" cleanliness level or cleaner, in particular for engines with common rail and unit injection systems. When you refuel the machine, filter the fuel through a 4 µm absolute filter (Beta 4 = 75 up to 200) to reach the recommended cleanliness level. This filtration should be located at the device that dispenses the fuel to the engine or machine fuel tank. In addition, filtration at the dispensing point should have the ability to remove water to ensure that fuel is dispensed at 500 ppm water or less.
- Keep the area around the fuel tank filler neck clean of debris to prevent dirt entry and contamination of the fuel tank.
- Drain your water separators daily per the Operation and Maintenance Manual of your machine.
- Install desiccant type breathers of 4 µm or less absolute efficiency with the ability to remove water on bulk storage tanks.
- Drain your fuel tanks of sediment every 500 hours or 3 months per the Operation and Maintenance Manual of your machine.

Maintenance Section
General Fuel Information

- Centrifugal filters may need to be used as a pre-filter with fuel that is severely contaminated with gross amounts of water or large particulate contaminants. Centrifugal filters can effectively remove large contaminants, but may not be able to remove the very small abrasive particles required to achieve the recommended "ISO" cleanliness level. Bulk filter / coalescers are necessary as a final filter to achieve the recommended cleanliness level.
- Cover, protect, and ensure cleanliness of all connection hoses, fittings, and dispensing nozzles.
- Test for microbial contamination regularly and take proper corrective action if contamination is present. Properly dispose of cleanup waste according to all applicable regulations and mandates.
- Every 3 months, or sooner if problems are suspected, have a complete analysis of the bulk storage fuel per the "Caterpillar Specification for Distillate Diesel Fuel for Off-Highway Diesel Engines" table in this Special Publication. Refer to Caterpillar S·O·S Services Fuel Analysis Section of this Chapter. Take corrective action if necessary. Corrective actions may include, but are not limited to, treating the fuel, cleaning of the fuel storage tank/system, and replacing the problematic fuel with fresh fuel.
- Top off fixed roof fuel tanks as often as practical to reduce tank breathing and to reduce the amount of condensation generated water.

NOTICE

In order to meet expected fuel system component life, 4 micron(c) absolute or less secondary fuel filtration is required for all Cat diesel engines that are equipped with common-rail fuel systems. Also, 4 micron(c) absolute or less secondary fuel filtration is required for all Cat diesel engines that are equipped with unit injected fuel systems. For all other Cat diesel engines (mostly older engines with pump, line and nozzle type fuel systems), the use of 4 micron(c) absolute or less secondary fuel filtration is strongly recommended. Note that all current Cat diesel engines are factory equipped with Cat Advanced Efficiency 4 micron(c) absolute fuel filters.

NOTICE

Do not add new engine oil, waste engine oil or any oil product to the fuel unless the engine is designed and certified to burn diesel engine oil (for example Caterpillar ORS designed for large engines). Caterpillar experience has shown that adding oil products to Tier 4 engine fuels (U. S. EPA Tier 4 certified), to EURO Stage IIB and IV certified engine fuels, or to the fuels of engines equipped with exhaust aftertreatment devices, will generally cause the need for more frequent ash service intervals and/or cause loss of performance.

Adding oil products to the fuel may raise the sulfur level of the fuel and may cause fouling of the fuel system and loss of performance.

Adding oil products to the fuel may raise the sulfur level of the fuel and may cause fouling of the fuel system and loss of performance.

Note: Thorough cleaning of fuel storage tanks is strongly recommended before converting to Ultra Low Sulfur Diesel (ULSD) (15 ppm or less sulfur) and/or biodiesel/biodiesel blends. Conversion to ULSD and/or biodiesel/biodiesel blends can loosen fuel system and fuel storage tank deposits. Bulk tank continuous filtration unit and dispensing point filters, and onboard engine filters change intervals may need to be shortened for an extended period of time to allow for this cleaning effect.

Note: Even when all fuel storage maintenance practices that are relevant to your application are followed, Caterpillar recommends a maximum of 1 year from production for distillate fuel storage, and the recommended storage and monitoring of biodiesel and biodiesel blends as detailed in the "Guidelines and potential impacts associated with the use of biodiesel and biodiesel blends" Table in the "Biodiesel" section of this Special publication. Storage life for biodiesel and biodiesel blends is limited.

Consult your local Cat dealer for additional information on Cat designed and produced filtration products.

Refer to the “Contamination Control” chapter in this Special Publication for more details.

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Fuel Information for Diesel Engines

SMCS Code: 1250; 1280

NOTICE

U. S. EPA regulations require the use of Ultra Low Sulfur Diesel fuel (ULSD) , ≤ 0.0015 percent (≤ 15 ppm (mg/kg)) sulfur, for nonroad and stationary Tier 4 EPA certified engines using fuel sensitive technologies such as SCR systems and particulate filters. Fuels other than ULSD can cause damage in those engines and should not be used.

Consult the U. S. EPA for fuel sulfur regulations and for the ULSD point of sales required dates for various nonroad applications.

European sulfur free fuel ≤ 0.0010 percent (≤ 10 ppm (mg/kg) sulfur) fuel is required by regulation for use in engines certified to EU nonroad Stage IIIB and newer standards and that are equipped with exhaust after-treatment systems.

Certain governments/localities and/or applications MAY require the use of ULSD fuel. Consult federal, state, and local authorities for guidance on fuel requirements for your area.

Typical aftertreatment systems include Diesel Particulate Filters (DPF), Diesel Oxidation Catalysts (DOC), Selective Catalytic Reduction (SCR) and/or Lean NOx Traps (LNT). Other systems may apply.

Low sulfur diesel (LSD) fuel (≤ 500 ppm (mg/kg) sulfur) is strongly recommended for use in engines that are pre-Tier 4 models while diesel fuel with > 500 ppm sulfur is acceptable for use in areas of the world where allowed by law. Pre-Tier 4 engines that are equipped with a Diesel Oxidation Catalyst (DOC) require the use of LSD fuel or ULSD fuel.

ULSD fuel or sulfur-free diesel fuel are acceptable in all engines regardless of the engine U.S. EPA Tier or EU Stage requirements.

Use appropriate lubricating oils that are compatible with the engine certification and aftertreatment system and with the fuel sulfur levels. Refer to the “Diesel Fuel Sulfur Impacts” article of this “Fuels Specifications” section and to the “Lubricants Specifications” section of this Special Publication.

WARNING

Ultra Low Sulfur Diesel (ULSD) poses a greater static ignition hazard than earlier diesel formulations, with a higher sulfur content, which may result in a fire or explosion. Consult with your fuel or fuel system supplier for details on proper grounding and bonding practices.

Note: The removal of sulfur and other compounds in Ultra Low Sulfur Diesel (ULSD) fuel decreases the conductivity of ULSD and increases the ability of the fuel to store static charge. Refineries may have treated the fuel with a static dissipating additive. However, there are many factors that can reduce the effectiveness of the additive over time. Static charges can build up in ULSD fuel while the fuel is flowing through fuel delivery systems. Static electricity discharge when combustible vapors are present could result in a fire or explosion. Therefore, ensuring that the entire system used to refuel your machine (fuel supply tank, transfer pump, transfer hose, nozzle, and others) is properly grounded and bonded is important. Consult with your fuel or fuel system supplier to ensure that the delivery system is in compliance with fueling standards for proper grounding and bonding practices.

The two basic types of distillate diesel fuel are No. 2 diesel fuel and No. 1 diesel fuel. No. 2 diesel fuel is the most commonly available summer grade diesel fuel. No. 1 diesel fuel is a winter grade diesel fuel. During the winter months fuel suppliers will typically blend No. 1 and No. 2 diesel fuel in various percentages to meet the historical low ambient temperature cold-flow needs for a given area or region. No. 2 diesel fuel is a heavier diesel fuel than No. 1 diesel fuel. In cold weather, heavier fuels can cause problems with fuel filters, fuel lines, fuel tanks, and fuel storage. Heavier diesel fuels such as No. 2 diesel fuel can be used in diesel engines that operate in cold temperatures with an appropriate amount of a well proven pour point depressant additive. For more information on fuels which include blends of No. 1 and No. 2 diesel fuel, consult your fuel supplier.

When you use No. 2 diesel fuel or other heavier fuels, some of the fuel characteristics may interfere with successful cold-weather operation. Additional information about the characteristics of diesel fuel is available. This information contains a discussion on the modification to the characteristics of diesel fuel. There are several possible methods that can be used to compensate for the fuel qualities that may interfere with cold-weather operation. These methods include the use of starting aids, engine coolant heaters, fuel heaters, and de-icers. In addition, the manufacturer of the fuel can add cold flow improvers and/or blend No. 1 and No. 2 diesel in various percentages.

Not all areas of the world classify diesel fuel using the No. 1 and No. 2 nomenclature described above. But, the basic principles of using additives and/or blending fuels of different densities to help compensate for the fuel qualities that may interfere with cold-weather operation are the same.

Starting Aids

The use of a starting aid is a conventional method of assistance for cold starts in low temperature conditions. Various starting aids are available for Caterpillar engines. Follow the recommendations that are provided by the manufacturer of the starting aid. Refer to the "Aftermarket Products and Warranty" article in the "Warranty Information" section of this special publication.

Engine Coolant Heaters

These heaters heat the engine coolant. The heated coolant flows through the cylinder block. The flow of heated coolant keeps the engine warm. A warm engine is easier to start in cold weather. Most coolant heaters use electrical power. A source of electricity is necessary for this type of heater. Other heaters that burn fuel are available as a source of heat. These heaters may be used in place of the electrical heaters.

With either type of heater, starting aids and/or fuels with higher cetane numbers are less important because the engine is warm. Problems with fuel cloud point can cause the plugging of fuel filters. Problems with fuel cloud point cannot be corrected by engine coolant heaters. This is especially true for fuel filters that are cooled by air flow during operation.

Fuel Heaters

The fuel cloud point is related to problems with fuel filters. The fuel heater heats the fuel above the cloud point before the fuel enters the fuel filter. This prevents wax from blocking the filter. Fuel can flow through pumps and lines at temperatures below the cloud point. The cloud point is often above the pour point of a fuel. While the fuel can flow through these lines, the wax in the fuel can still plug the fuel filter.

In some engine installations, small modifications can prevent problems that are caused by the cloud point. One of the following changes can prevent problems in many conditions: a change in the location of fuel filters and/or supply lines and the addition of insulation. In extreme temperatures, heating of the fuel may be required to prevent the filters from plugging. There are several types of fuel heaters that are available. The heaters typically use either engine coolant or exhaust gas as a heat source. These systems may prevent filter waxing problems without the use of de-icers or cold flow improvers. These systems may be ineffective when the fuel contains a large amount of dirt or of water. Use of a fuel heater can help eliminate some cold-weather problems. A fuel heater should be installed so that the fuel is heated before flowing into the fuel filter.

Note: A fuel heater is not effective for cold-soaked starts unless the fuel heater can be powered from an external power source. External fuel lines may require the use of heaters that circulate the fuel.

Note: Only use properly sized fuel heaters that are controlled by thermostats or use fuel heaters that are self-regulated. Thermostatically controlled fuel heaters generally heat fuel to 15.5° C (60° F). Do not use fuel heaters in warm temperatures.

For distillate fuel configured engines, Caterpillar recommends a fuel viscosity as delivered to rotary fuel injection pumps of between 1.4 cSt and 4.5 cSt, and between 1.4 cSt and 20 cSt for all other fuel injection pumps.

Note: If a fuel with a low viscosity is used, cooling of the fuel may be required to maintain 1.4 cSt or greater viscosity at the fuel injection pump. Fuels with a high viscosity might require fuel heaters to lower the viscosity to either 4.5 cSt or less for rotary fuel injection pumps or 20 cSt viscosity or less for all other fuel injection pumps.

NOTICE

When you use fuel heaters, do not allow the fuel temperature to reach above 52° C (125° F). Never exceed 75° C (165° F) with straight distillate fuel. The high fuel temperatures affect the fuel viscosity. When the fuel viscosity falls below 1.4 cSt, pump damage may occur.

WARNING

Overheating the fuel or the fuel filter can result in personal injury and/or damage to the engine. Use extreme care and caution for heating of the fuel and/or the fuel filter.

Select a fuel heater that is mechanically simple, yet adequate for the application. The fuel heater should also prevent overheating of the fuel. Disconnect the fuel heater or deactivate the fuel heater in warm weather. An unacceptable loss of fuel viscosity and engine power will occur if the fuel supply temperature is allowed to become too hot.

For additional information on fuel heaters, consult your Caterpillar dealer.

De-icers

De-icers lower the freezing point of the moisture in the fuel. De-icers are not generally needed when fuel heaters are used. If you experience trouble, consult your fuel supplier for recommendations of a compatible commercial de-icer.

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Characteristics of Diesel Fuel

SMCS Code: 1250; 1280

Viscosity

The viscosity of the fuel is significant because the fuel serves as a lubricant for fuel system components. Fuels need to have sufficient viscosity. The fuel must lubricate the fuel system in both extremely cold and in extremely hot temperatures.

Fuels of improper viscosity result in poor atomization and spray pattern when injected, which cause poor combustion and loss of performance. If the kinematic viscosity of the fuel is lower than 1.4 cSt as supplied to the fuel injection pump or to the unit injectors, excessive scuffing and seizure can occur. If the fuel viscosity is too high, the fuel may cause high fuel pump resistance, negatively impact the injector spray pattern, and may cause filter damage.

For distillate fuel configured engines, Caterpillar recommends a fuel viscosity as delivered to rotary fuel injection pumps of between 1.4 cSt and 4.5 cSt, and between 1.4 cSt and 20 cSt for all other fuel injection pumps.

If a fuel with a low viscosity is used, cooling of the fuel may be required to maintain 1.4 cSt or greater viscosity at the fuel injection pump. Fuels with a high viscosity might require heaters to lower the viscosity to either 4.5 cSt or less for rotary fuel injection pumps or 20 cSt or less for all other fuel injection pumps.

Cetane Number

The cetane number of the fuel effects the ability of the engine to start. Also, the cetane number effects the interval of time before the engine runs smoothly. Fuels of high cetane rating are easier to ignite. The starting temperature can be improved approximately 7 to 8°C (12 to 15°F) for every increase of ten in the cetane number. After the engine reaches the normal operating temperature, a change in the cetane from 40 to 50 will have a minimal effect on engine performance.

Most fuels that have a cetane number above 40 will permit acceptable engine starts in warmer outside temperatures. The engine will start satisfactorily with this fuel when the engine is kept warm. The engine can be kept warm by using either a heated enclosure or a properly sized coolant heater.

During average starting conditions, direct injection diesel engines require a minimum cetane number of 40. A higher cetane value may be required for operation in high altitudes or for cold-weather operation. The minimum fuel cetane number that is required for the precombustion chamber (PC) diesel engine is 35.

Modifying the Cetane Number

The cetane number of a fuel can be changed if the fuel is mixed with a fuel that has a different cetane number. Generally, the cetane number of the mixture will be in direct relation to the ratio of the fuels that were mixed. Your fuel supplier can provide the information about the cetane number of a particular fuel.

Additives can also be used to improve the cetane number of a fuel. Additives are evaluated through testing in special test engines. However, the characteristics of fuels with natural cetane number can be different than those characteristics of a fuel additized to reach the same cetane number. While both fuels may be rated as having the same cetane number, starting may be different.

Cloud Point

The cloud point of a fuel is different from the pour point. The cloud point is the temperature that allows some of the heavier components in the wax to solidify in the fuel. This wax is not a contaminant in the fuel. The wax is an important element of No. 2 diesel fuel. The wax has a high fuel energy content and the wax has a very high cetane value. Removal of the heavier wax lowers the cloud point of the fuel. Removal of the wax also increases the cost because less fuel can be made from the same amount of crude oil. Basically, a No. 1 diesel fuel is formulated by removing the wax from a No. 2 diesel fuel.

The cloud point of the fuel is important because the cloud point can limit the performance of the fuel filter. The wax can alter the fuel characteristics in cold weather. Solid wax can fill the fuel filters. The solidified wax will cause filter plugging. Plugged filters cannot remove contaminants from the fuel and hence cannot protect the fuel injection systems. Since fuel must flow through the filters, installing a fuel heater is the most practical way to prevent the problem. A fuel heater will keep the fuel above the cloud point as the fuel flows through the fuel system. The fuel heater will permit the wax to flow through the filters with the fuel.

Modifying the Cloud Point

You can lower the cloud point of a diesel fuel by mixing the diesel fuel with a different fuel that has a lower cloud point. No. 1 diesel fuel or kerosene may be used to lower the cloud point of a diesel fuel. The efficiency of this method is not good, because the ratio of the mixture does not have a direct relation to the improvement in cloud point. The amount of fuel with low cloud point that is required makes the process less preferable to use.

The fuel supplier must be consulted to provide the proper mix of fuels that offers the appropriate cloud point.

Another approach to modify the cloud point is to use cold flow improvement additives. The manufacturer of the fuel can add cold flow improvers to the fuel. Cold flow improvers modify the wax crystals in the fuels. The cold flow improvers do not change the cloud point of the fuel. However, the cold flow improvers keep the wax crystals small enough to pass through standard fuel filters. For mixing precautions, see the section "Pour Point".

Generally, the most practical method that is used to prevent problems that are caused by fuel cloud point at low temperatures is the use of fuel heaters. In most applications, fuel heaters can be used at a lower cost than fuel mixtures.

The common standard methods that are used to test the cloud point of diesel fuels are:

- "ASTM D2500" Test Method for Cloud Point of Petroleum Products
- "ASTM D5771" Test Method for Cloud Point of Petroleum Products (Optical Detection Stepped Cooling Method)
- "ASTM D5772" Test Method for Cloud Point of Petroleum Products (Linear Cooling Rate Method)
- "ASTM D5773" Test Method for Cloud Point of Petroleum Products (Constant Cooling Rate Method)

Pour Point

The fuel's pour point is a temperature below the cloud point of the fuel. Fuel stops flowing below the pour point. The pour point is the temperature which limits movement of the fuel inside the pumps.

To measure the pour point, the fuel temperature is lowered below the cloud point in steps of 3°C (5°F) at a time. The temperature is lowered until the fuel does not flow. The pour point is the last temperature that is shown before the flow stops. At the pour point, the wax has solidified out of the fuel. This temperature makes the fuel more solid than liquid. The pour point of the fuel can be improved. This improvement does not require the removal of important elements. This process is the same process that is used to improve the cloud point of a fuel.

A fuel's pour point should be at least 6°C (10°F) below the lowest ambient temperature that is required for engine start-up and for engine operation. To operate the engine in extremely cold weather, No. 1 fuel or No. 1-D fuel may be necessary because of these fuels' lower pour points.

Modifying the Pour Point

You can lower the fuel's pour point by using additives. You can also lower the pour point of a diesel fuel by mixing the diesel fuel with a different fuel that has a lower pour point. No. 1 diesel fuel or kerosene may be used to lower the pour point of a diesel fuel. The amount of fuel with low pour point that is required makes the process less preferable to use.

The following illustration contains a table that can be used to find the necessary mixture for two fuels with different pour points. This table is true only if the fuels do not have additives which change the pour point. This table may not apply to Ultra Low Sulfur diesel fuels and should be used only as a general guide. To use the table, you must know the exact pour point of each fuel. This specification can change from one purchase of fuel to the next purchase of fuel. This specification is normally available from personnel at the source of the fuel supply. When fuels that have a lower pour point are not available, this method cannot be used.

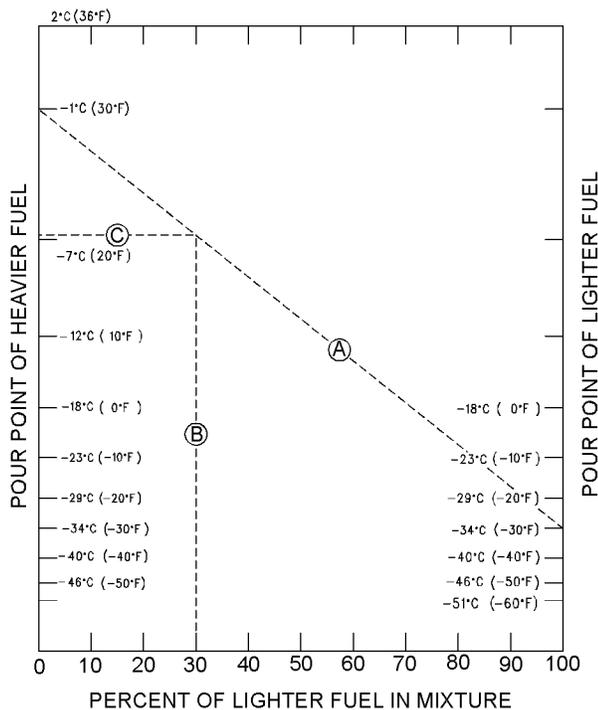


Illustration 1

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Pour point of fuel mixtures

To calculate the amount of lighter fuel that is required to be blended with the heavier fuel, perform the following steps:

1. Obtain the specification for the cloud point or the pour point of both fuels from your fuel supplier.
2. Locate the cloud point or the pour point of the heavier fuel on the left side of the table. Mark the point on the table.
3. Locate the cloud point or the pour point of the lighter fuel on the right side of the table. Mark the point on the table.
4. Draw a line between the two points that were established. Label this line "A".

5. Determine the lowest outside temperature for machine operation. Find this point on the left side of the table. Mark this point. Draw a horizontal line from this point. Stop the line at the intersection of line "A". Label this new line "C".
6. Line "C" and line "A" intersect. Mark this point. Draw a vertical line from this point. Stop the line at the bottom of the table. Label this line "B". The point at the bottom of line "B" reveals the percentage of lighter fuel that is required to modify the cloud point or the pour point.

The above example shows that the blending will require a 30 percent mixture of lighter fuel.

Additives are a good method to use to lower the pour point of a fuel. These additives are known by the following names: pour point depressants, cold flow improvers, and wax modifiers. When the additives are used in the proper concentration, the fuel will flow through pumps, lines, and hoses.

Note: These additives must be thoroughly mixed into the fuel at temperatures that are above the cloud point. The fuel supplier should be contacted to blend the fuel with the additives. The blended fuel can be delivered to your fuel tanks.

The standard methods to measure the pour point of the fuels are:

- "ASTM D4539" Test Method for Filterability of Diesel Fuels by Low-Temperature Flow Test (LTFT)
- "ASTM D6371" Test Method for Cold Filter Plugging Point of Diesel and Heating Fuels

Lubricity and Low Sulfur Diesel (LSD) and Ultra Low Sulfur Diesel (ULSD) Fuel

The lubricity of the fluid describes the ability of the fluid to reduce the friction between surfaces that are under load. This ability reduces the damage that is caused by friction. Fuel injection systems rely on the lubricating properties of the fuel.

Note: The fuel lubricity is important. The lubricity of the fuel should be considered whenever you operate the equipment in temperature extremes, whether extremely hot or extremely cold. Also, you should consider the fuel lubricity whenever you use fuels that are lower in viscosity or that have been hydro-treated. There are many aftermarket additives that are available to treat fuel. If the lubricity of the fuel is an issue, consult your fuel supplier for proper recommendations regarding fuel additives. Also, refer to this Special Publication, “Distillate Diesel Fuel” article, “Aftermarket Fuel Additives” and “Diesel Fuel Conditioner” topics.

The finished fuels as described by Caterpillar Diesel Fuel Specification, “ASTM D975” or “EN 690” are at the recommended lubricity levels. To determine the lubricity of the fuel, use the “ASTM D6079 High Frequency Reciprocating Rig (HFRR)” test. The maximum allowable wear scar is 0.52 mm (0.0205 inch) at 60° C (140° F). If the lubricity of a fuel does not meet the minimum requirements, consult your fuel supplier. Do not treat the fuel without consulting the fuel supplier. Some additives are not compatible. These additives can cause problems in the fuel system.

The process that is most commonly used to remove sulfur from fuel is called hydro-treatment. This process is also the most economical process. Each source of crude oil contains different amounts of sulfur. Crude oils typically require hydro-treatment to obtain the 0.0015 percent maximum sulfur limit. Crude oils with high sulfur require a more severe treatment.

The hydro-treatment removes the sulfur and other components from the fuel. The treatment removes nitrogen compounds, polar materials, bicyclic aromatics, polycyclic aromatics, and oxygen compounds. While the removal of sulfur has shown no detrimental effects to the engine, the removal of other compounds have lowered the lubricity of the fuel. As a result of the lowered lubricity, the fuel is less tolerant of contamination by water and dirt. The lower fuel lubricity can be seen as abrasive wear of fuel system components. Fuels that have a low lubricity may not provide adequate lubrication to plungers, to barrels, and to injectors. This problem may be compounded in areas that require winter blends of fuel. The lighter winter fuel blend has the following characteristics: lower viscosity, lower cloud point and lower pour point.

The finished fuels that are per the recommended specifications should have the correct lubricity. However, if required, the lubricity of the fuel may be enhanced with additives. Many fuel suppliers treat the fuel with these additives. Do not use a fuel lubricity additive before you consult the fuel supplier. Some aftermarket additives may not be compatible with the additives that are already in the fuel, and some may damage emission control systems. Some additive packages that are supplied by the aftermarket manufacturer may not be compatible with the seals that are used in fuel systems of some diesel engines. Other additive packages that are supplied by aftermarket manufacturers cannot provide proper performance in high temperature conditions. These additives may leave deposits because of the high temperatures that exist in the fuel systems of diesel engines.

Maximum life of the fuel system can be achieved by performing the following tasks: using a preferred distillate diesel fuel (refer to the “Fuel Recommendations” article in this Special Publication), using a reliable fuel supplier and performing proper maintenance of the fuel system. Caterpillar Advanced Efficiency fuel filters are required for diesel engines that run on diesel fuel to provide maximum life to the fuel system.

Note: Lighter fuels are frequently used in arctic temperatures. Lighter fuels may include the following fuels: Jet A, Jet A-1, JP-8, JP-5, and kerosene. The specifications that apply to these fuels do not include a minimum lubricity requirement. Do not assume that a fuel meets the minimum Caterpillar specification. Contact the fuel supplier for proper recommendations on fuel lubricity additives.

Note: The sulfur levels for Jet A, Jet A-1, JP-8, JP-5, and kerosene fuels typically far exceed 15 ppm, the U.S. ULSD fuel, and the sulfur levels for these fuels typically far exceed 50 ppm, the EU low sulfur fuel.

Note: For best results, your fuel supplier should treat the fuel when additives are required.

Refer to this Special Publication, “Distillate Diesel Fuel” article, “Aftermarket Fuel Additives”, “Diesel Fuel Conditioner”, and “Alternative Fuels - Arctic Applications” topics for guidance.

Fuel volatility

Fuel volatility is measured and controlled by the fuel distillation curve. The optimal fuel volatility required for various engines depends on the engine application, design, loads, speeds, ambient temperatures, and other factors. Low volatility fuels may have a higher energy content (heating value). On the other hand, fuels of high initial volatility may improve the startability and warm up process and reduce smoke. High-performance fuels have the right balance of volatility.

The fuel distillation curve describes the amount of fuel that evaporates at various temperatures. Of these temperatures, the heavy end is characterized by the T90, the temperature where 90 percent of the fuel evaporates. If the T90 exceeds the maximum limits given in the "Cat Specification for Distillate Fuel for Nonroad Diesel Engines" Table, in the "Distillate Diesel Fuel" section, the fuel may increase smoke, deposits, soot, and particulate matter emissions. The lower end or low distillation temperatures are not specified in the "Cat Specification for Distillate Fuel for Nonroad Diesel Engines" Table, nor in "ASTM D975" or similar specifications. However, very low distillation temperatures may cause the fuel to become volatile at low temperatures and may cause cavitation of fuel pumps or fuel system components.

Diesel Fuel Sulfur

Sulfur is a natural component of diesel fuels. High sulfur in the fuel can be reduced through refining technologies.

Sulfur levels in the fuel affect the durability of engine components and also affect engine exhaust emissions. Modern Cat diesel engines are designed to meet mandated gaseous emissions requirements. To meet these emissions requirements, the engines are tested and developed with specific sulfur levels in the diesel fuel.

The maximum allowable fuel sulfur level is controlled by various emissions laws, regulations, and mandates. Consult federal, state, and local authorities for guidance on fuel requirements for your area.

The list below provides a quick reference for acceptable sulfur levels for diesel fuel that will be used in Cat machine diesel engines but the controlling documents are the engine Operation and Maintenance Manuals, the specific aftertreatment device documentation, and the applicable emissions laws, regulations, and mandates.

- U.S. EPA regulations require the use of Ultra Low Sulfur Diesel fuel (ULSD), ≤ 0.0015 percent (≤ 15 ppm (mg/kg)) sulfur, for nonroad and stationary Tier 4 EPA certified engines using fuel sensitive technologies such as SCR systems and particulate filters. Fuels other than ULSD can cause damage in those engines and should not be used. Consult the U.S. EPA for fuel sulfur regulations and for the ULSD point of sales required dates for various nonroad applications.
- European sulfur free fuel, 0.0010 percent (= 10 mg/kg) sulfur, fuel is required by regulation for use in engines certified to EU nonroad Stage IIIB and newer standards and that are equipped with exhaust aftertreatment systems.
- Certain governments/localities and/or applications MAY require the use of ULSD fuel. Consult federal, state, and local authorities for guidance on fuel requirements for your area.
- The maximum allowable fuel sulfur level for most pre-Tier 4 engines that are equipped with DOC (Diesel Oxidation Catalyst) is 0.05 percent (500 ppm (mg/kg)). Some DOC equipped engines require the use of fuel with a maximum of 0.005% (50 ppm (mg/kg)) fuel sulfur. Refer to the engine/machine Operation and Maintenance Manual and refer to the aftertreatment device-specific documentation for guidance.
- For machine diesel engines that are retrofitted with an aftertreatment device, refer to the aftertreatment device-specific documentation.

Typical aftertreatment systems include Diesel Particulate Filters (DPF), Diesel Oxidation Catalysts (DOC), Selective Catalytic Reduction (SCR) and/or Lean NOx Traps (LNT). Other systems may apply.

In addition to the emission regulations, factors that affect maximum allowed and/or acceptable fuel sulfur level include:

- Engine model/design
- Engine application
- Overall fuel quality
- Using recommended fluids, including but not limited to engine oil quality
- Exhaust aftertreatment device type
- Environmental factors and other site-specific operating conditions
- Fuel costs versus risk of shortened engine/engine component life
- Fuel costs versus shortened oil drain intervals
- Maintenance intervals and other maintenance practices

Ultra-Low Sulfur Diesel (ULSD)

The United States (U.S.) Environmental Protection Agency (EPA) defines Ultra-Low Sulfur Diesel (ULSD - S15) as a U.S. diesel fuel with a sulfur content not to exceed 15 parts per million (ppm(mg/kg)) or 0.0015 percent by weight.

ULSD was introduced for the U.S. on-highway diesel engine market in October 2006. ULSD is available since December 2010 for nonroad diesel engines and machines. Refer to the U.S. EPA for the required ULSD point of sales dates for various nonroad applications.

Engines certified to nonroad Tier 4 standards (Stage IV in Europe) and are equipped with fuel sulfur sensitive exhaust aftertreatment systems are designed to run on ULSD only. Use of LSD or fuels higher than 15 ppm (mg/kg) sulfur in these engines will reduce engine efficiency and engine durability and will damage emissions control systems and/or shorten the service interval. Failures that result from the use of fuels are not Cat factory defects. Therefore the cost of repairs would not be covered by a Cat warranty.

ULSD fuel can be used in any engine designed to run on diesel fuel. Cat does not require the use of ULSD in nonroad and machine applications that are not Tier 4/Stage IIIB/Stage IV certified engines and are not equipped with aftertreatment devices. For Tier 4/Stage IIIB/Stage IV certified engines, always follow operating instructions and fuel tank inlet labels, if available, to insure the correct fuels are used.

Note: The removal of sulfur and other compounds in Ultra Low Sulfur Diesel (ULSD) fuel decreases the conductivity of ULSD and increases the ability of the fuel to store static charge. Refineries may have treated the fuel with a static dissipating additive. However, there are many factors that can reduce the effectiveness of the additive over time. Static charges can build up in ULSD fuel while the fuel is flowing through fuel delivery systems. Static electricity discharge when combustible vapors are present could result in a fire or explosion. Therefore, ensuring that the entire system used to refuel your machine (fuel supply tank, transfer pump, transfer hose, nozzle, and others) is properly grounded and bonded is important. Consult with your fuel or fuel system supplier to ensure that the delivery system is in compliance with fueling standards for proper grounding and bonding practices.

The standard methods for testing conductivity of diesel fuel are:

- “ASTM D2624” Test Methods for Electrical Conductivity of Aviation and Distillate Fuels
- “ASTM D4308” Test Method for Electrical Conductivity of Liquid Hydrocarbons by Precision Meter

Sulfur-free Diesel Fuel

In Europe, ultra low sulfur diesel fuel will have a maximum of 0.0010 percent (10 ppm(mg/kg)) sulfur and is typically referred to as “sulfur-free”. This sulfur level is defined in “European Standard EN 590:2004”.

Low Sulfur Diesel (LSD)

Low Sulfur Diesel (LSD - S500) is defined by the U.S. EPA as a U.S. diesel fuel with sulfur content not to exceed 500 ppm or 0.05 percent by weight.

Note: Both ULSD and LSD must meet the fuel requirements outlined in the most current revision level of “ASTM D975”.

Diesel Fuel Sulfur Impacts

Sulfur in the fuel results in the formation of sulfur dioxide (SO₂) and sulfur trioxide (SO₃) gases during the combustion process. When combined with water in the exhaust gas SO₂ and SO₃ can form acids. The acids can impact engine components and engine lubricants.

Sulfur in the exhaust gas can interfere with the operation of aftertreatment devices causing loss of passive regeneration performance, reduced gaseous emission conversion efficiency, and increased particulate matter emissions.

Typical aftertreatment systems include Diesel Particulate Filters (DPF), Diesel Oxidation Catalysts (DOC), Selective Catalytic Reduction (SCR) and/or Lean NO_x Traps (LNT). Other systems may apply.

Use of fuels with higher than recommended and/or maximum allowed fuel sulfur levels can and/or will:

- Increase wear of engine components
- Increase corrosion of engine components
- Increase deposits
- Increase soot formation
- Shorten the time period between oil drain intervals (cause the need for more frequent oil drain intervals)
- Shorten the time interval between aftertreatment device service intervals (cause the need for more frequent service intervals)
- Negatively impact the performance and life of aftertreatment devices (cause loss of performance)
- Reduce regeneration intervals of aftertreatment devices
- Lower fuel economy
- Increase overall operating costs

Depending on operating conditions, and depending on maintenance practices, the potential issues stated above may and/or will take place with fuel sulfur levels that are at or below the recommended fuel sulfur levels, and/or that are at or below the maximum allowable fuel sulfur levels.

Fuel sulfur levels above 0.1% (1000 ppm (mg/kg)) may significantly shorten the oil change interval.

When other factors do not preclude, and understanding that there may be trade-offs such as shortened oil drain intervals, certain commercial, and machine diesel engines that are covered by this Special Publication MAY be able to operate satisfactorily on fuels with up to 1 percent (10,000 ppm(mg/kg)) sulfur if the following conditions are met:

- All emissions laws, regulations, and mandates are followed
- The engine/engines are not equipped with aftertreatment device/devices
- All appropriate guidelines and maintenance practices as stated in the engine Operation and Maintenance Manual are followed
- All appropriate guidelines and maintenance practices as stated in this Special Publication are followed
- Operating in otherwise low to moderate severity applications
- Your Cat dealer is consulted and approves
- You refer to this Special Publication, and you refer to your specific Cat commercial engine and/or refer to your specific Cat machine Operation and Maintenance Manual for more guidance and exceptions

Oil Drain Intervals

Note: DO NOT USE ONLY THIS SPECIAL PUBLICATION AS A BASIS FOR DETERMINING OIL DRAIN INTERVALS.

Fuel sulfur level impacts the oil drain interval. For detailed information, refer to the "S·O·S Services Oil Analysis" section in the "Lubricants Specification" article in this Special Publication.

- Cat S·O·S Services oil analysis is recommended.
- Cat S·O·S Services oil analysis is very strongly recommended to determine oil drain intervals when using fuel with sulfur levels between 0.05% (500 ppm) and 0.5% (5000 ppm).
- Cat S·O·S Services oil analysis is required to determine oil drain intervals when using fuel with sulfur levels above 0.5% (5000 ppm).

- Consult your Cat dealer for guidance when fuel sulfur levels are above 0.1% (1000 ppm).

Moisture Content

Problems with fuel filters can occur at any time. The cause of the problem can be water in the fuel or moisture in the fuel. At low temperatures, moisture causes special problems. There are three types of moisture in fuel: dissolved moisture (moisture in solution), free and dispersed moisture in the fuel and free and settled at the bottom of the tank.

Most diesel fuels have some dissolved moisture. Just as the moisture in air, the fuel can only contain a specific maximum amount of moisture at any one temperature. The amount of moisture decreases as the temperature is lowered. For example, a fuel could contain 100 ppm (100 mg/kg or 0.010 percent) of water in solution at 18°C (65°F). This same fuel can possibly hold only 30 ppm (30 ppm or 0.003 percent) at 4°C (40°F).

After the fuel has absorbed the maximum amount of water, the additional water will be free and dispersed. Free and dispersed moisture is fine droplets of water that is suspended in the fuel. Since the water is heavier than the fuel, the water will slowly become free and settled at the bottom of the tank. In the above example, when the fuel temperature was lowered from 18°C (65°F) to 4°C (40°F), 70 ppm (mg/kg) of water became free and dispersed in the fuel.

The small drops of water cause a cloudy appearance in the fuel. If the change in temperature is slow, the small drops of water can settle to the bottom of the tank. When the fuel temperature is lowered rapidly to freezing temperature, the moisture that comes out-of-solution changes to very fine particles of ice instead of small drops of water.

The particles of ice are lighter than the fuel, and the particles of ice will not settle to the bottom of the tank. When this type of moisture is mixed in the fuel, this moisture will fill the fuel filters. The ice crystals will plug the fuel filters in the same way as wax plugs the fuel filters.

If a filter is plugged and fuel flow is stopped, perform the following procedure to determine the cause:

1. Remove the fuel filters.
2. Cut the fuel filters open.
3. Inspect the fuel filter before the filter warms. This inspection will show that the filter is filled with particles of either ice or wax.

The moisture which is free and settled at the bottom of the tank can become mixed with the fuel. The force of any pumping action will mix the moisture with the fuel whenever fuel is transferred. This moisture then becomes free and dispersed water. This moisture can cause ice in the filters. This moisture can cause other problems with filters at any temperature.

Generally, the same force that mixes the water into the fuel will also mix dirt and rust from the bottom of the tank with the water. The result is a dirty mixture of fuel and water which can also fill the filters and stop fuel flow.

Specific Gravity / API Gravity

The specific gravity of diesel fuel is the weight of a fixed volume of fuel in comparison to the weight of the same volume of water at the same temperature. A higher specific gravity correlates into a heavier fuel. Heavier fuels have more energy or power per volume for the engine to use.

Note: The settings for the fuel mixture should not be adjusted to compensate for a loss of power with fuels that are lighter. The life of fuel system components can be decreased with fuels that are very light because lubrication will be less effective as a result of the lower viscosity. This issue is compounded if the fuel does not have sufficient lubricity. Refer to the “Lubricity and Low Sulfur Fuel Diesel (LSD) and Ultra Low Sulfur Diesel (ULSD) Fuel” topic in this Special Publication, “Characteristics of Diesel Fuel” article.

The API gravity of a fuel is also a measure of the density of the fuel or the relationship of the weight to the volume. The scale for API gravity is inverse to the scale for specific gravity. The API gravity will become higher as the fuel becomes lighter.

Lighter fuels will not produce the rated power. Lighter fuels may also be a blend of ethanol or methanol with diesel fuel. Blending alcohol or gasoline with diesel fuel will create an explosive atmosphere in the fuel tank. In addition, water condensation in the tank can cause the alcohol to separate in the tank.

WARNING

Mixing alcohol or gasoline with diesel fuel can produce an explosive mixture in the engine crankcase or fuel tank.

Personal injury and damage to the engine may result. Caterpillar recommends against this practice.

NOTICE

Mixing alcohol or gasoline with diesel fuel may cause damage to the engine. Caterpillar recommends against this practice. Water condensation in the fuel tank can cause the alcohol to separate which could cause damage to the engine.

Heavier fuels tend to create more deposits from combustion. Deposits from combustion can cause abnormal cylinder liner and ring wear. This problem is most noticeable in smaller diesel engines that operate at higher speeds.

Gums and Resins

The gums and resins that occur in diesel fuel are the result of dissolved oxidation products in the fuel that do not evaporate easily. The products that are dissolved in the fuel also do not burn cleanly. Excessive gum in the fuel will coat the inside of the fuel lines, pumps, and injectors. Excessive gum will also interfere with the close tolerances of the moving parts of the fuel systems. Gum and resin in the fuel will also cause the filter to plug rapidly. Oxidation of the fuel will occur and the formation of more gums and resins will occur during fuel storage. The storage time for fuel needs to be minimized to help reduce the formation of gums and resins.

Note: Even when all fuel storage maintenance practices that are relevant to your application are followed, Caterpillar recommends a maximum of 1 year from production for distillate diesel fuel storage, and a maximum of 6 months from production for biodiesel and blended biodiesel storage. Storage life for biodiesel and biodiesel blends that are greater than B20 may be much shorter than 6 months.

The Thermal Stability and Oxidation Stability of Fuel

Diesel fuels can deteriorate rapidly for various reasons. When the fuel is stressed and stored for long intervals, degradation and oxidation can occur. Degradation and oxidation are complex chemical changes, which may include the formation of peroxides. These changes lead to deposits or sediment from certain hydrocarbons and traces of naturally occurring nitrogen and sulfur containing compounds in the fuel. Fuel composition and environmental factors influence the process.

Diesel fuel is being used as a coolant for high-pressure fuel injection systems with high temperature fuel wetted walls. This process can stress the fuel in the fuel system. The thermal stress and an increase in recirculation fuel temperature is often responsible for fuel degradation and the formation of gums, resins, sediment, and deposits, which can cause fuel flow restriction through fuel filters and fuel injection systems.

When a fuel is left in a machine or engine fuel tank for a long time, the fuel is exposed to oxygen. This exposure leads to complex chemical reactions and degradation of the fuel. As a result, sludge and deposits are formed, which lead to poor performance, filter plugging, restriction of fuel lines, and deposits in the injector.

Biodiesel and blends of biodiesel have poor thermal stability and oxidation stability compared to petroleum distillate diesel fuels. The use of these biodiesels and blends of biodiesel can accelerate the problems that are addressed in this Special Publication. Using biodiesel blends above the maximum level approved for the engine is not recommended.

Thermal and oxidative degradation of diesel fuel can result in a darkening of fuel color. Fuel color is not necessarily an indication of excessive degradation that will lead to the problems outlined in this Special Publication. But darkened fuel color can be an indicator of degradation leading to concerns about the stability of darkened fuel. Thermal oxidation and oxidative stability tests should be run to confirm actual fuel degradation.

Testing the fuels for thermal and oxidative stability as described in the "Cat Specification for Distillate Fuel for Nonroad Diesel Engines" Table, in the "Distillate Diesel Fuel" section, ensures that the fuel meets the minimum requirements for stability. Fuels that pass these tests offer the desired performance and reduce the deposit formation.

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Fuel Recommendations

SMCS Code: 1250; 1280

NOTICE

These recommendations are subject to change without notice. Consult your local Cat dealer for the most up to date recommendations.

Diesel engines may burn a wide variety of fuels. These fuels are divided into two general groups. The two groups are called the preferred fuels and the permissible fuels.

The preferred fuels provide maximum engine service life and performance. The preferred fuels are distillate fuels. These fuels are commonly called diesel fuel, furnace oil, gas oil, or kerosene. These fuels must meet the "Cat Specification for Distillate Diesel Fuel for Off-Highway Diesel Engines" found in this Special Publication, "Distillate Diesel Fuel" article.

The permissible fuels are some crude oils, some blends of crude oil with distillate fuel, and some marine diesel fuel. **These fuels are not suitable for use in all engine applications.** The acceptability of these fuels for use is determined on a case by case basis. A complete fuel analysis is required. Consult your Cat dealer for further information. Biodiesel fuel is permissible for use in Cat engines. Follow all the recommendations and guidelines given in this Special Publication, "Biodiesel" article.

Note: Except for some biodiesel, permissible fuels are not acceptable for use in on-highway applications.

NOTICE

Use of permissible fuels can result in higher maintenance costs and reduced engine service life.

Note: Use of fuels that do not meet at least the minimum performance recommendations and/or requirements may lead to lower compartment performance and/or compartment failure. Problems/failures that are caused by using fuels that do not meet the minimum recommended and/or required performance level are not Cat factory defects and therefore are NOT covered by the Cat warranty. The fuel supplier and customer are responsible.

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Distillate Diesel Fuel

SMCS Code: 1280

Note: For on-highway diesel engine fluids requirements, refer to specific engine Operation and Maintenance Manuals, and also refer to the most current revision level of Special Publication, SEBU6385, "Caterpillar On-Highway Diesel Engine Fluids Recommendations". Also consult your Cat dealer.

Caterpillar is not in the position to continuously evaluate and monitor all the many worldwide distillate diesel fuel specifications and the on-going revisions that are published by governments and technological societies.

The "Caterpillar Specification for Distillate Fuel for Off-Highway Diesel Engines" provides a known, reliable baseline to judge the expected performance of distillate diesel fuels that are derived from conventional sources (crude oil, shale oil, oil sands, etc.) when used in Cat diesel engines.

Using the Cat distillate diesel fuel specification as the baseline, it is much easier to determine any potential economic and/or performance trade-offs, and overall acceptability when using fuels of varying characteristics and quality levels.

- When required, have the diesel fuel that either is being used or is planned to be used, tested per the Cat distillate diesel fuel specification.
- Use the Cat distillate diesel fuel specification as a fuel quality baseline for comparison of distillate diesel fuel analysis results, and/or a baseline for comparison of other distillate diesel fuel specifications.

- Typical fuel characteristics can be obtained from the fuel supplier.

Fuel parameters outside of the Cat fuel specification limits have explainable consequences.

- Some fuel parameters that are outside of the specification limits can be compensated for (e.g. fuel can be cooled to address low viscosity; etc.).
- Some fuel parameters that are outside of specification limits may be able to be improved with the use of appropriate amounts of well proven fuel additives. Refer to this Special Publication, “Distillate Diesel Fuel” article, “Aftermarket Fuel Additives” and “Diesel Fuel Conditioner” topics for guidance.

To help ensure optimum engine performance, a complete fuel analysis should be obtained before engine operation. The fuel analysis should include all of the properties that are listed in the “Caterpillar Specification for Distillate Fuel for Nonroad Diesel Engines”, Table 15 .

Note: The diesel fuel has to be bright and clear. The diesel fuel cannot have any visually apparent sediment, suspended matter, or undissolved water.

Diesel Fuels that meet the specifications in table 15 will help provide maximum engine service life and performance.

In North America, diesel fuels that are identified as meeting the latest version of “ASTM D975” Grades No. 1-D or No. 2-D (all listed sulfur levels) generally meet the table 15 requirements.

In Europe, diesel fuels that are identified as meeting the latest version of “European Standard EN590” generally meet the table 15 requirements.

Table 15 is for diesel fuels that are distilled from conventional sources (crude oil, shale oil, oil sands, etc.). Diesel fuels from other sources could exhibit detrimental properties that are not defined or controlled by this specification.

NOTICE

Ultra Low Sulfur Diesel (ULSD) fuel 0.0015 percent (≤ 15 ppm (mg/kg)) sulfur is required by regulation for use in engines certified to nonroad Tier 4 standards (U.S. EPA Tier 4 certified) and that are equipped with exhaust aftertreatment systems.

European ULSD 0.0010 percent (≤ 10 ppm (mg/kg)) sulfur fuel is required by regulation for use in engines certified to European nonroad Stage IIIB and newer standards and are equipped with exhaust aftertreatment systems.

Certain governments/localities and/or applications MAY require the use of ULSD fuel. Consult federal, state, and local authorities for guidance on fuel requirements for your area.

Typical aftertreatment systems include Diesel Particulate Filters (DPF), Diesel Oxidation Catalysts (DOC), Selective Catalytic Reduction (SCR) and/or Lean NOx Traps (LNT). Other systems may apply.

Low sulfur diesel (LSD) fuel 0.05 percent (≤ 500 ppm (mg/kg) sulfur) is strongly recommended for use in engines that are pre-Tier 4 models, while diesel fuel with > 0.05 percent (500 ppm (mg/kg)) sulfur is acceptable for use in areas of the world where allowed by law. Pre-Tier 4 engines that are equipped with a Diesel Oxidation Catalyst (DOC) require the use of LSD fuel or ULSD fuel.

ULSD fuel or sulfur-free diesel fuel are applicable for use in all engines regardless of the engine Tier or Stage.

Use appropriate lubricating oils that are compatible with the engine certification and aftertreatment system and with the fuel sulfur levels. Refer to the “Diesel Fuel Sulfur Impacts” article of this “Fuels Specifications” section and to the “Lubricants Specifications” section of this Special Publication.

Recommendations for Europe Stage V Certified Nonroad Engines:

All the fuel recommendations and requirements for U S EPA Tier 4 Certified Nonroad Engines” section above are applicable to the Europe Stage V type-approved Nonroad Engines. Additionally, for the correct operation of the engine in order to maintain the gaseous and particulate pollutant emissions of the engine within the limits of the type-approval, unless specified otherwise in the engine-specific Operation and Maintenance Manual, EU Stage V regulations REQUIRE the diesel fuels (also called non-road gas oil) used in engines operated within the European Union (EU) to have the characteristics below:

- The sulfur content should be ≤ 10 mg/kg (20 mg/kg) at point of final distribution
- The Cetane number should be ≥ 45

- The biodiesel (also called Fatty Acid Methyl Ester (FAME)) content should be $\leq 7\%$ volume/volume

Follow all the local regulations and fluids requirements in your area. Refer to your engine-specific Operation and Maintenance Manual, and refer to your aftertreatment device documentation, if available, for additional guidance.

Engine operating conditions play a key role in determining the effect that fuel sulfur will have on engine deposits and on engine wear.

Note: The removal of sulfur and other compounds in Ultra Low Sulfur Diesel (ULSD) fuel decreases the conductivity of ULSD and increases the ability of the fuel to store static charge. Refineries may have treated the fuel with a static dissipating additive. However, there are many factors that can reduce the effectiveness of the additive over time. Static charges can build up in ULSD fuel while the fuel is flowing through fuel delivery systems. Static electricity discharge when combustible vapors are present could result in a fire or explosion. Therefore, ensuring that the entire system used to refuel your machine (fuel supply tank, transfer pump, transfer hose, nozzle, and others) is properly grounded and bonded is important. Consult with your fuel or fuel system supplier to ensure that the delivery system is in compliance with fueling standards for proper grounding and bonding practices.

NOTICE

Do not add new engine oil, waste engine oil or any oil product to the fuel unless the engine is designed and certified to burn diesel engine oil (for example Caterpillar ORS designed for large engines). Caterpillar experience has shown that adding oil products to Tier 4 engine fuels (U. S. EPA Tier 4 certified), to EURO Stage IIB and IV certified engine fuels, or to the fuels of engines equipped with exhaust aftertreatment devices, will generally cause the need for more frequent ash service intervals and/or cause loss of performance.

Adding oil products to the fuel may raise the sulfur level of the fuel and may cause fouling of the fuel system and loss of performance.

ULSD and any other fuel used in Cat engines have to be properly formulated and additized by the fuel supplier and have to meet Special Publication, "Caterpillar Specification for Distillate Diesel Fuel for Off-Highway Diesel Engines". Fuels that are defined as "ASTM D975" Grade No. 1-D S15 or "ASTM D975" Grade No. 2-D S15 generally meet Cat requirements for ULSD.

Refer to this Special Publication, "Characteristics of Diesel Fuel" article for additional pertinent information concerning fuel lubricity, fuel oxidative stability, fuel sulfur, and aftertreatment devices. Also refer to the latest version of "ASTM D975", the latest version of "EN 590", the specific engine Operation and Maintenance Manual, and to aftertreatment device documentation for guidance.

Note: Caterpillar strongly recommends the filtration of distillate fuel and/or biodiesel/biodiesel blends through a fuel filter with a rating of four microns(c) absolute or less. This filtration should be on the device that dispenses the fuel to the fuel tank for the engine, and also on the device that dispenses fuel from the bulk storage tank. Series filtration is recommended. Caterpillar recommends that the fuel dispensed into the machine tank meets "ISO 18/16/13" cleanliness level.

Note: The owner and the operator of the engine has the responsibility of using the correct fuel that is recommended by the manufacturer and allowed by the U.S. EPA and, as appropriate, other regulatory agencies.

NOTICE

Operating with fuels that do not meet Cat recommendations can cause the following effects: starting difficulty, reduced fuel filter service life, poor combustion, deposits in the fuel injectors, reduced service life of the fuel system, deposits in the combustion chamber and reduced service life of the engine.

NOTICE

The footnotes are a key part of the "Caterpillar Specification for Distillate Diesel Fuel" Table. Read ALL of the footnotes.

For additional guidance related to many of the fuel characteristics that are listed, refer to "Cat Specification for Distillate Fuel for Off-Highway Diesel Engines", table 15 .

The values of the fuel viscosity given in table 15 are the values as the fuel is delivered to the fuel injection pumps. For ease of comparison, fuels should also meet the minimum and maximum viscosity requirements at 40° C (104° F) that are stated by the use of either the "ASTM D445" test method or the "ISO 3104" test method. If a fuel with a low viscosity is used, cooling of the fuel may be required to maintain 1.4 cSt or greater viscosity at the fuel injection pump. Fuels with a high viscosity might require fuel heaters to lower the viscosity to either 4.5 cSt or less for rotary fuel injection pumps or 20 cSt viscosity or less for all other fuel injection pumps.

Maintenance Section
Distillate Diesel Fuel

Table 15

Cat Specification for Distillate Fuel for Nonroad Diesel Engines			
Specifications	Requirements	ASTM Test	ISO Test
Aromatics	35% volume, maximum	"D1319"	"ISO 5186"
Ash	0.01% maximum (weight)	"D482"	"ISO 6245"
Density at 15° C (59° F) ⁽¹⁾⁽²⁾	800 kg/m ³ minimum 860 kg/m ³ maximum	"D4052", "D287"	"ISO 3675", "ISO 12185"
Cetane Number	40 minimum (DI engines)	"D613"	"ISO 5165"
	35 minimum (PC engines)		
Cetane Index	40, minimum	"D976"	"ISO 4264"
Flash Point	legal limit	"D93"	"ISO 2719"
Carbon Residue on 10% distillation residue - Ramsbottom, % mass	0.30% mass, maximum	"D524"	"ISO 10370"
Oxidation Stability	25 g/m ³ , maximum	"D2274"	"ISO 12205"
Thermal Stability	Minimum of 80% reflectance after aging for 180 minutes at 150° C (302° F)	"D6468", "D3241"	No equivalent test
Copper Strip Corrosion (Control temperature 50° C (122° F) minimum)	No. 3 maximum	"D130"	"ISO 2160"
Distillation, vol recovered	10%, Record	"D86"	"ISO 3405"
	90% at 360° C (680° F) maximum ⁽³⁾		
	90% at 350° C (662° F) maximum ⁽³⁾		
Lubricity (HFRR Wear Scar)	0.52 mm (0.0205 inch) maximum at 60° C (140° F)	"D6079"/"D7688"	"ISO 12156-1.3"
Pour Point	6°C (10°F) minimum below ambient temperature	"D97"	
Cloud Point	The cloud point must not exceed the lowest expected ambient temperature.	"D2500"	"ISO 3015"
Low Temperature Flow Test/Cold Filter Plugging Point Test (LTFT/CFPP)	Must not exceed the lowest expected ambient temperature.	"D4539"/"D6371"	No equivalent test
Sulfur by weight	⁽⁴⁾	"D5453", "D2622", "D129" (based on the sulfur level)	"ISO 20846", "ISO 20884"
Kinematic Viscosity at 40° C (104° F) for No. 1 diesel	1.3 cSt minimum and 2.4 cSt maximum	"D445"	"ISO 3104"
Kinematic Viscosity at 40° C (104° F) for No. 2 diesel	1.9 cSt minimum and 4.5 cSt maximum	"D445"	"ISO 3104"
Contaminants			
Solids	10 mg/l	"D6217"	"ISO 12662"
Sediment	0.05% maximum (weight)	"D473"	No Equivalent Test

(continued)

(Table 15, contd)

Cat Specification for Distillate Fuel for Nonroad Diesel Engines			
Specifications	Requirements	ASTM Test	ISO Test
Water/Sediment	0.05% maximum	"D2709"	"ISO 3734"
Water	0.02% maximum	"D1744"	"ISO 12937"
Cleanliness	(5)	"D7619"	"ISO 4406"
Appearance	Clear and Bright	"D4176"	No equivalent test

- (1) The equivalent API gravity of 875.7 kg/m³ is 30 and for 801.3 kg/m³ is 45 (per "ASTM D287" test method temperature of 15.56° C (60° F)).
- (2) The density range allowed included # 1 and # 2 diesel fuel grades. Fuel density varies depending on sulfur levels, where high sulfur fuels have higher densities. Some unblended (neat) alternative fuels have lower densities than diesel fuel. This density is acceptable if the other properties of the alternative fuel fall within this specification.
- (3) Distillation of 90% at 350° C (662° F) maximum is recommended for Tier 4 engines and preferred for all engines. Distillation of 90% at 350° C (662° F) is equivalent to 95% at 360° C (680° F). Distillation of 90% at 360° C (680° F) maximum is acceptable for Pre-Tier 4 engines.
- (4) Follow the federal, state, local, and other governing authorities for guidance concerning the fuel requirements in your area. Follow the engine Operation and Maintenance Manual and the details provided in this Fuel section. ULSD 0.0015% (<15 ppm S) is required by law for Tier 4 engines and engines with aftertreatment devices. ULSD and LSD 0.05% (≤500 ppm S) are strongly recommended for pre-Tier 4 engines. Diesel fuel with >0.05% (>500 ppm) sulfur is acceptable for use where allowed by law. Consult your Cat dealer for guidance when sulfur levels are above 0.1% (1000 ppm). Certain Cat fuel systems and engine components can operate on fuel with a maximum sulfur content of 3%. Refer to the specific engine Operation and Maintenance Manual and consult your Cat dealer.
- (5) Recommended cleanliness level for fuel as dispensed into machine or engine fuel tank is "ISO 18/16/13" or cleaner per "ISO 4406" or "ASTM D7619". Refer to the "Recommendations for Cleanliness of Fuels" in this chapter.

There are many other diesel fuel specifications that are published by governments and by technological societies. Usually, those specifications do not review all the requirements that are addressed in the "Caterpillar Specification for Distillate Fuel for Off-Highway Diesel Engines", Table 15. To help ensure optimum engine performance, a complete fuel analysis should be obtained before engine operation. The fuel analysis should include all the properties that are listed in the "Cat Specification for Distillate Fuel for Off-Highway Diesel Engines", Table 15.

NOTICE

In order to meet expected fuel system component life, 4 micron(c) absolute or less secondary fuel filtration is required for all Cat diesel engines that are equipped with common-rail fuel systems. Also, 4 micron(c) absolute or less secondary fuel filtration is required for all Cat diesel engines that are equipped with unit injected fuel systems. For all other Cat diesel engines (mostly older engines with pump, line and nozzle type fuel systems), the use of 4 micron(c) absolute or less secondary fuel filtration is strongly recommended. Note that all current Cat diesel engines are factory equipped with Cat Advanced Efficiency 4 micron(c) absolute fuel filters.

To obtain additional information on Cat designed and produced filtration products, refer to this Special Publication, "Reference Material" article, "Filters" and "Miscellaneous" topics, and then contact your Cat dealer for assistance with filtration recommendations for your Cat machine.

WARNING

Mixing alcohol or gasoline with diesel fuel can produce an explosive mixture in the engine crankcase or fuel tank.

Personal injury and damage to the engine may result. Caterpillar recommends against this practice.

Caterpillar S.O.S Services Fuel Analysis

Caterpillar has developed a maintenance management tool that evaluates fuels. The Cat tool for fuel analysis is called S.O.S Fuel Analysis and is part of the S.O.S Services Program.

Testing the diesel fuel that goes into your engine is an important tool in your equipment management toolkit. Diesel fuel testing can help identify production limiting issues such as rapid fuel filter plugging, hard starting, white smoke, deposits, accelerated wear, and low power. Diesel fuel testing can also provide extra benefits including helping to identify fuel saving steps, environmental regulation compliance in countries with higher fuel regulations, minimizing Diesel Particulate Filter (DPF) regeneration and maximizing the life of the DPF filter and Diesel Oxidation Catalyst. Some facilities with standby generators may have requirements that fuel is tested regularly. Operations without requirements will benefit from knowing that the fuel in the standby generators is going to provide the expected performance when needed.

S.O.S Services Fuel Analyses

The Cat S.O.S Fuel Analysis program provides testing of the fuel for the properties listed below. The actual analyses provided may vary depending on your requirements and reasons for testing. Consult your local Cat Dealer for complete information and assistance about the S.O.S Fuel Analysis program.

- Biodiesel content
- Sulfur content
- Water contamination
- Particle cleanliness level
- Microbial growth
- Identification of elements that can increase deposit formation
- Identification of fuel conditions that can indicate contamination or adulteration
- Identification of fuel conditions that can indicate increased abrasive wear, adhesive wear, or wear in the combustion chamber
- Identification of fuel characteristics that can indicate low power
- Indication of fuel to perform in cold weather
- Identification of fuel conditions that can increase filter plugging
- Indication of fuel condition during storage
- Indication of ability of fuel to perform at startup

The results are reported and appropriate recommendations are provided.

A properly administered S.O.S Services Program can reduce repair costs and lessen the impact of down time. S.O.S Fuel Analysis is a key component of this program and can ensure that your fuel is stored in a clean environment, meets government requirements, and can meet the expected guidelines for performance in your engine. Consult your Cat Dealer to determine your fuel testing needs and establish a regular testing interval based on those needs. Consult the “Cat Fuel Specification” and the “Contamination Control” sections of this Special Publication for related details on fuel recommendations including cleanliness.

Obtaining S.O.S Fuel Samples

Fuel sampling methods depend on the type of fuel tank to be sampled. Storage tanks may have an automatic sampling valve at different levels. Storage tanks without an automatic sampling valve require a tank sampling device (commonly known as a “Bacon Bomb” or “Sample Thief”). Refer to “Fuel Sampling Guide” PEDJ0129, for more information and instructions on proper sampling techniques. Fuel analysis sampling kits can be obtained from your local Cat Dealer. Size of fuel sample needed may be dependent upon the list of tests required.

Diesel Fuels for Marine Engines

The information and guidelines given in the “Diesel Fuel” article of this Special Publication apply to marine engines that use diesel fuels. Follow these guidelines in order to reduce the risk of engine downtime. Refer to your engine Operation and Maintenance Manual for details specific to your marine engine. Consult your Cat dealer for more information.

The International Maritime Organization (IMO) regulates the fuel sulfur level for ocean going ships. Current marine fuels at sea that are regulated by the IMO can have sulfur levels up to 3.5 percent (35,000 ppm) prior to the year 2020. As of January 1, 2020, ships operating in international waters are required to use fuels with sulfur levels below 0.5 percent (5000 ppm).

Furthermore, IMO designates certain areas as Sulfur Emissions Control Areas (SECA). Ships operating within SECA must operate on 1 percent (10,000 ppm) sulfur fuel prior to the year 2015. After January 1, 2015 ships operating within SECA must operate with 0.1 percent (1000 ppm) sulfur fuels. IMO may change areas considered SECA. Review and follow local and IMO requirements and local regulations for planned destinations. Refer to your engine Operation and Maintenance Manual for appropriate marine fuels for use in your engine.

The US Environmental Protection Agency (EPA) regulates the sulfur level of marine fuels in the US waterways and shores. For vessels operating exclusively within US waters, Ultra Low Sulfur Diesel (ULSD) is required by regulations unless local exceptions exist. Vessels traveling internationally under the US Flag are required to operate on ULSD regardless of destination and location. Refer to the regulations in your area of operation. If your destination does not have ULSD, but your engine can operate on fuel other than ULSD, exemptions can be requested by contacting the EPA at the following address:

complianceinfo@epa.gov

Refer to your engine Operation and Maintenance Manual for fuels information for your engine.

Foreign flagged vessels operating in the US are required to follow IMO rules while sailing in US waters designated as SECA. Always refer to the local regulations at ports of call to determine fuel requirements as they are subject to change.

Note: ULSD is backwards compatible and can be used in most engine technologies. Diesel fuels with > 0.0015 percent (>15 ppm) sulfur can be used in engines that do not have aftertreatment devices and where permitted by local regulations.

Heavy Fuel Oil, Residual Fuel, Blended Fuel

NOTICE

Heavy Fuel Oil (HFO), Residual fuel, or Blended fuel must **NOT** be used in Caterpillar diesel engines (except in 3600 Series HFO engines). Blended fuel is residual fuel that has been diluted with a lighter fuel (cutter stock) so that they will flow. Blended fuels are also referred to as heavy fuel oils. Severe component wear and component failures will result if HFO type fuels are used in engines that are configured to use distillate fuel.

Fuels For Cold-Weather Applications

In extreme cold ambient conditions, you may choose to use the distillate fuels that are specified in table 16. However, the fuel that is selected must meet the requirements that are specified in the "Cat Specification for Distillate Diesel Fuel for Off-Highway Diesel Engines", Table 15. These fuels are intended to be used in operating temperatures that are down to -54°C (-65°F).

Note: The fuels that are listed in table 16 may have higher sulfur levels than the 15 ppm maximum sulfur allowed for ULSD. The sulfur levels for these fuels may exceed 50 ppm maximum sulfur allowed in "EN590:2004". These fuels may not be acceptable for use in areas that restrict maximum fuel sulfur levels to 15 ppm maximum or to 50 ppm maximum.

The jet fuels described in Table 16 are of lower viscosity than #2 diesel. To meet the viscosity requirements given in Table 15, cooling of the fuel may be required to maintain 1.4 cSt or greater viscosity at the fuel injection pump. Ensure that the lubricity of these fuels is per the requirements given in Table 15. Consult the supplier for the recommended additives to maintain the proper fuel lubricity.

The fuel specifications listed in this table allow and/or recommend the use of fuel additives that have not been tested by Cat for use in Cat fuel systems. The use of these specifications allowed and/or recommended fuel additives are at the risk of the user.

Jet A is the standard fuel used by U.S. commercial airlines when operating within the U.S. Jet A-1 is the standard fuel used by commercial airlines worldwide. Per "ASTM D1655, Table 1 (Detailed Requirements of Aviation Turbine Fuels)", Jet A and Jet A-1 have identical requirements except for freezing point. Jet A has a freeze point requirement of -40°C (-40°F) versus the Jet A-1 has a freeze point requirement of -47°C (-52.6°F), but the fuel purchaser and the fuel supplier may agree on other freezing points.

Table 16

Alternative Distillate Fuels - Cold-Weather Applications	
Specification	Grade
"MIL-DTL-5624U"	JP-5
"MIL-DTL-83133F"	JP-8
"ASTM D1655-08a"	Jet A, Jet A-1

These fuels are lighter than the No. 2 grades of fuel. The cetane number of the fuels in table 16 must be at least 40. If the viscosity is below 1.4 cSt at 40°C (104°F), use the fuel only in temperatures below 0°C (32°F). Do not use any fuels with a viscosity of less than 1.2 cSt at 40°C (104°F).

Note: Fuel cooling may be required to maintain the minimum viscosity of 1.4 cSt at the fuel injection pump.

Note: These fuels may not prove acceptable for all applications.

Aftermarket Fuel Additives

There are many different types of fuel additives that are available to use. Caterpillar does not generally recommend the use of fuel additives.

In special circumstances, Caterpillar recognizes the need for fuel additives. Fuel additives need to be used with caution. The additive may not be compatible with the fuel. Some additives may precipitate. This action causes deposits in the fuel system. The deposits may cause seizure. Some additives may plug fuel filters. Some additives may be corrosive, and some additives may be harmful to the elastomers in the fuel system. Some additives may damage emission control systems. Some additives may raise fuel sulfur levels above the maximum allowed by the United States (U.S.) Environmental Protection Agency (EPA) and/or, as appropriate, other regulatory agencies. Consult your fuel supplier for those circumstances when fuel additives are required. Your fuel supplier can make recommendations for additives to use and for the proper level of treatment.

Note: Metallic fuel additives can cause fuel system/injector fouling and after treatment device fouling. Caterpillar discourages the use of metallic fuel additives in most applications. Metallic fuel additives should only be used in applications where their use is specifically recommended by Caterpillar.

Note: Diesel fuel additives/conditioners may not improve markedly poor diesel fuel properties enough to make them acceptable for use.

Note: For best results, your fuel supplier should treat the fuel when additives are needed.

Diesel Fuel Conditioner

Fuels that are per specifications detailed in this publication should not require the use of additives. In case a fuel conditioner is needed to improve certain fuel properties, consult with your fuel supplier or with a reputable provider. Refer to your Cat dealer and to Cat special publication PELJ2095 for more details.

High performance, multipurpose diesel fuel conditioners are designed to improve:

- Fuel economy (through fuel system cleanup)
- Lubricity
- Oxidative stability
- Detergency/dispersancy
- Moisture dispersancy
- Corrosion protection
- Cetane (typically 2-3 cetane numbers)

Cat Diesel Fuel System Cleaner

Note: Cat Diesel Fuel System Cleaner, part number 343-6210, is the only fuel system cleaner available to the end user that is tested and approved by Caterpillar for use in Cat diesel engines.

Cat Diesel Fuel System Cleaner is a proven high-performance detergent product specifically designed for cleaning deposits that form in the fuel system. Deposits in the fuel system reduce system performance and can increase fuel consumption. Cat Diesel Fuel System Cleaner addresses the deposits formed due to the use of degraded diesel fuel, poor quality diesel fuel, and diesel fuel containing high quantities of high molecular weight compounds. Cat Diesel Fuel System Cleaner addresses deposits formed due to the use of biodiesel, biodiesel blends, and biodiesel that does not meet the appropriate quality specifications. Continued use of Cat Diesel Fuel System Cleaner is proven to inhibit the growth of new deposits.

Cat Diesel Fuel System Cleaner can be added directly to diesel fuel, biodiesel, or biodiesel blends. Cat Diesel Fuel System Cleaner is a United States Environmental Protection Agency registered fuel additive that can be used with Ultra Low Sulfur Diesel Fuel. In addition this cleaner is appropriate for use with other ultra low, low, and higher sulfur diesel fuels around the world.

Cat Diesel Fuel System Cleaner is a proven high-performance cleaner that is designed to perform the following:

- Clean performance-robbing fuel system deposits
- Restore fuel economy losses resulting from injector deposits
- Restore power losses resulting from injector deposits
- Eliminate visible black exhaust smoke resulting from injector deposits
- Prevent the formation of new fuel-related deposits

For engines experiencing problems such as power loss, increased fuel consumption, or black smoke due to the presence of fuel-related deposits in fuel injectors, a high-strength cleaning cycle is recommended. Add one 0.946L (32 oz.) bottle of Cat Diesel Fuel System Cleaner per 250 L (65 gal) of fuel, which corresponds to a treat rate of 0.4% by volume. Prior to refueling, pour Cat Diesel Fuel System Cleaner directly into the fuel tank, then refill with fuel. The refilling process should give satisfactory mixing of the cleaner. The cleaner will begin to be effective immediately. Testing has shown most deposits are cleaned and related issues are resolved after 30 hours of operating the engine on fuel with the cleaner. For maximum results, continue to use at this treat rate for up to 80 hours.

To prevent the return of fuel-related deposits, Cat Diesel Fuel System Cleaner, add the cleaner to the fuel as previously described, but at a 0.2% treat rate. In this case, one 0.946L (32 oz.) bottle will treat 500 L (130 gallons) of fuel. Cat Diesel Fuel System Cleaner can be used on an on-going basis with no adverse impact on engine or fuel system durability.

NOTICE

Use of Cat Diesel Fuel System Cleaner or Cat Diesel Fuel System Conditioner does not lessen the responsibility of the engine owner and/or responsibility of the fuel supplier to follow all industry standard maintenance practices for fuel storage and for fuel handling. Refer to the "General Fuel Information" article in this Special Publication for additional information. Additionally, use of Cat Diesel Fuel System Cleaner or Cat Diesel Fuel System Conditioner does NOT lessen the responsibility of the owner of the engine to use appropriate diesel fuel. Refer to the "Fuel Specifications" section in this Special Publication (Maintenance Section) for guidance.

Caterpillar strongly recommends that Cat Diesel Fuel System Cleaner be used with biodiesel and biodiesel blends. Cat Diesel Fuel System Cleaner is suitable for use with biodiesel/biodiesel blends that meet Cat biodiesel recommendations and requirements. Note that not all fuel cleaners are suitable for use with biodiesel/biodiesel blends. Read and follow all applicable label usage instructions. Also, refer to this Special Publication, "Distillate Diesel Fuel", article and also refer to the "Biodiesel" article, which includes Cat biodiesel recommendations and requirements.

When used as directed, Cat Diesel Fuel System Cleaner has proven to be compatible with non-road Tier 4 U.S. EPA certified engines that are equipped with aftertreatment devices.

Note: When used as directed, Cat Diesel Fuel System Cleaner will not raise fuel sulfur levels measurably in the final fuel/additive blend. Follow all applicable national, regional, and local laws, mandates, and regulations concerning the use of diesel fuel conditioners/additives.

NOTICE

When used as directed Cat Diesel Fuel System Cleaner will not raise fuel sulfur levels measurably in the final fuel/additive blend. But, in the U.S., aftermarket fuel additives (retail consumer level versus bulk fuel additives used at the fuel supplier/distributor level) with more than 15 ppm sulfur are NOT allowed to be used in applications where ULSD usage is mandated (15 ppm or less fuel sulfur). Note that Cat Diesel Fuel System Cleaner contains less than 15 ppm of sulfur and is acceptable for use with ULSD fuel.

Renewable and Alternative Fuels

Renewable fuels are derived from renewable resources such as planted crops and crop residues (referred to as biomass), waste, algae, cellulosic material, yard and food waste, etc. Renewable fuels reduce the carbon footprint of the fuels compared to fossil fuels on a Life Cycle Analysis basis. Caterpillar, through sustainability initiatives, supports the development and use of renewable fuels.

Renewable fuels (other than biodiesel) and alternative fuels (such as but not limited to Gas-to-Liquid fuel) are typically >99% hydrocarbons (composed of carbon and hydrogen). An exception is biodiesel, which is an oxygenated renewable fuel. Biodiesel is discussed in a separate article in this Fuel section. Significant research is on going to develop renewable fuels and produce the fuels economically.

Caterpillar is not in a position to test all varieties of renewable and alternative fuels that are advertised in the market place. If a renewable or alternative fuel fulfills the performance requirements described in Cat Fuel Specification, the latest version of "ASTM D975", the latest version of "EN 590", or the latest version of the paraffinic fuel specification "CEN TS 15940" (which defines quality requirements for Gas to Liquids (GTL), Biomass to Liquids (BTL) and hydrotreated vegetable oil (HVO)), then this fuel or a blend of this fuel (blended with appropriate diesel fuel) can be used as a direct replacement of petroleum diesel in all Cat diesel engines.

Consult with the fuel supplier and with your Cat dealer to ensure that the cold-weather performance of the fuel is appropriate to the expected ambient temperatures at the operation sites and to ensure elastomer compatibility. Certain elastomers used in older engines (such as engines manufactured up to the early 1990s) may not be compatible with the new alternative fuels.

Caterpillar is following the development of renewable and alternative fuels and the respective fuel specifications to ensure successful application of these fuels in the engines. Information and guidelines will be published as the production of these fuels becomes established.

Note: If switching from distillate to biodiesel fuel, it is recommended to change all fuel filters to avoid filter plugging. Failure to do so can create low fuel pressure.

Pyrolysis Fuels

A particular family of renewable/alternative fuels, known as pyrolysis fuels, are typically NOT suitable for use in modern diesel engines. Pyrolysis fuels can be obtained from various resources including wood, used tires, plastic, etc. Pyrolysis fuels in their raw form do not meet all the requirements in Table 15, "ASTM D975" and/or "EN 590" specifications. These fuels have to be upgraded in order to produce a hydrocarbon product that meets all requirements defined in these specifications. Upgrading can include fractionation to remove volatiles, hydro-desulfurization, hydrotreating etc.

Where the pyrolysis fuel is obtained from wood, our experience has been that the liquid obtained contains high oxygen content (>10%), has high acidity (pH~1) and does not meet distillation, lubricity, and cetane requirements. Use of this fuel is likely to lead to severe impairment and wear in the fuel system. Suitable upgrading would likely involve, at a minimum, hydro-deoxygenation, fractionation and other hydrotreating.

Where the pyrolysis fuel is obtained from used tires, our experience has been that the distillation and sulfur requirements are not met. Use of this fuel is likely to lead to impaired function of the fuel and aftertreatment systems. Suitable upgrading would likely involve, at a minimum, fractionation and desulfurization.

Where the pyrolysis fuel is obtained from waste plastic, our experience has been that the distillation, lubricity, and cetane requirements are not met. Use of this fuel is likely to lead to impaired function of the fuel system. Suitable upgrading would likely involve, at a minimum, fractionation and other hydrotreating.

Upgraded pyrolysis fuels that meet Cat Diesel Fuel specification (Table XX), "ASTM D975" and/or "EN 590" specifications can be considered for use in Cat diesel engines. Refer to this special publication for guidelines and requirements for fuels acceptable in Cat engines. Refer to your Cat dealer for questions.

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Biodiesel

SMCS Code: 1280

NOTICE

These recommendations are subject to change without notice. Consult your local Cat dealer for the most up to date recommendations.

Biodiesel is a renewable fuel that can be made from vegetable oils, animal fat, and waste cooking oil. Soybean oil and rapeseed oil are typically the primary vegetable oil sources. The raw oils or animal fats are chemically processed (esterified) to form a fatty acid methyl ester (referred to as FAME). The esterified product (FAME) is biodiesel fuel that can be used in compression ignition engines. Without the chemical processing referred to as esterification, the oils or fats are not suitable for use as fuel in compression ignition engines. The oil or fat must be esterified and the water and contaminants removed.

Fuel made of 100 percent FAME is referred to as B100 biodiesel or neat biodiesel.

Biodiesel can be blended with distillate diesel fuel. The blends can be used as fuel. The most commonly available biodiesel blends are B5, which is 5 percent biodiesel and 95 percent distillate diesel fuel. Also, B20, which is 20 percent biodiesel and 80 percent distillate diesel fuel. The percentages are volume-based.

U.S. distillate diesel fuel specification "ASTM D975" includes up to B5 (5 percent) biodiesel. Any diesel fuel in the U.S. may contain up to B5 biodiesel fuel without labeling that indicates biodiesel content.

European distillate diesel fuel specification "EN 590" includes up to B5 (5 percent) biodiesel and in some regions up to B7 (7 percent) biodiesel. Any diesel fuel in Europe may contain up to B5 or in some regions up to B7 biodiesel fuel without labeling that indicates biodiesel content.

Biodiesel fuel that is per Caterpillar and Industry recommended specifications (Refer to Table 18 in this Chapter) offers the following advantages:

- Renewable fuel, nontoxic, and biodegradable
- Reduces tailpipe particulate matter (PM), hydrocarbon (HC), and carbon monoxide (CO) emissions from most modern diesel engines
- High lubricity, hence reduces friction
- High cetane number

Biodiesel at B5 blend level has the same attributes as diesel fuel. At blend levels over B5, biodiesel has the following attributes that require management:

- Energy density. At B100, biodiesel has about 8% lower energy density than diesel fuel. At B20 or lower blend levels, the energy density difference from diesel fuel is not significant.
- Oxidation stability, storage stability, cold temperature properties, and materials compatibility. Some of these attributes are controlled by the specifications.
- Tendency to dissolve and absorb water, which is higher than the tendency of diesel fuel to dissolve and absorb water.
- Metal content. Biodiesel can contain certain materials naturally or due to processing (phosphorus, sodium, calcium, potassium, and magnesium). The maximum levels of these materials are controlled by the appropriate specifications.
- Contaminants content due to incomplete esterification or purifying process. These contaminants may include glycerides, mono and di esters, sterol glucosides, and others.

Meeting specifications as detailed in this Chapter is paramount for biodiesel fuel used in engines, to avoid performance issues and engine downtime.

Refer to guidelines given in this Chapter and to Tables 18 and 20 for the biodiesel fuel requirements and specifications.

Note: The user of the engine has the responsibility of using the correct fuel that is recommended by the manufacturer. The fuel must be allowed by the U.S. EPA and other appropriate regulatory agencies.

NOTICE

In North America, the use of biodiesel from “BQ-9000” accredited producers and “BQ-9000” certified marketers is required. Refer to the “Recommendations” section for details.

NOTICE

Failures that result from the use of any fuel are not Caterpillar factory defects. Therefore, the cost of repair would NOT be covered by the Caterpillar warranty for materials and/or the warranty for workmanship.

Recommendations for the Use of Biodiesel in Caterpillar Nonroad Engines

To be acceptable for blending, the biodiesel constituent must meet the requirements that are listed in Table 20, “Caterpillar Specification for Biodiesel Fuel”, the latest edition of “ASTM D6751”, and/or the latest edition of “EN14214”.

Biodiesel blends of up to B5 must meet the requirements for the distillate diesel fuel that are listed in Table 51, “Caterpillar Specification for Distillate Diesel Fuel for Nonroad Diesel Engines”, the latest edition of “ASTM D975”, and/or the latest edition of “EN 590”.

Note: Caterpillar recommendations for most engines have been changed to B20 from historically higher blend level. This change was due to the development of “ASTM D7467” or “EN 16709” specification for B6-B20, which defines quality requirements for B6-B20 blends of biodiesel. This specification helps customers to define the fuel quality. Refer to the detailed requirements given in this Section.

Biodiesel blends of B6 to B20 must meet the requirements listed in the latest edition of “ASTM D7467” “EN 16709” (B6 to B20) **and** must be of an API gravity of 30-45.

The distillate diesel fuel acceptable for blending with biodiesel should be the “Caterpillar Specification for Distillate Diesel Fuel for Nonroad Diesel Engines” table in the “Distillate Diesel Fuel” section of this Special Publication, the latest edition of “ASTM D975”, and/or the latest edition of “EN 590”. No. 1-D and No. 2-D are examples of fuels that are acceptable for creating biodiesel fuel. Refer to “Fuel Specifications” Chapter in this Special Publication for details.

For Tier 4 applications in the U.S., the diesel fuel portion of the final blend must meet the requirements of S15 fuels (15 ppm sulfur) designations in the latest edition of “ASTM D975” specification. For Stage IIIB and later applications in EU, the diesel fuel portion of the final blend must meet the requirements for sulfur free (10 ppm sulfur) designation in the latest edition of “EN 590”. The final blend must have maximum of 15 ppm sulfur.

In North America, obtain biodiesel from BQ-9000 accredited producers and BQ-9000 certified marketers. Look for the BQ-9000 biodiesel quality accreditation program certification logo that is available to distributors that meet the requirements of BQ-9000. In other areas of the world, the use of biodiesel that is BQ-9000 accredited and certified, or that is accredited and certified by a comparable biodiesel quality body to meet similar biodiesel quality control standards, is required. For more information on the BQ-9000 program, go to:

<http://www.BQ-9000.org>

Maintenance Section
Biodiesel

Table 17

Recommendations for Biodiesel Fuel Application in Caterpillar Nonroad Engines⁽¹⁾		
Engine Models	Model Specific	Biodiesel Acceptable Blend Levels
Cat engine models: C7 through C32, CM20, CM25 and CM32, 3400 Series, 3500 Series and 3600 series	Engine models with aftertreatment devices	Up to B20
	Engine models without aftertreatment devices	Up to B20 (For use of higher blend levels up to B100, consult with your Cat dealer)
Cat engine model C175	Tier 4 and EU Stage IIIB model (Locomotive)	Up to B7
	Tier 4	Up to B7
	All other C175 engines	Up to B20 (For use of higher blend levels up to B100, consult with your Cat dealer)
Cat engine models: 3003 through 3066	All engine models	Up to B7
Cat engine models: C0.5 through C3.8	C0.5, C0.7, C1.1, C1.5, C1.6, C2.2, C3.4 engines Tier 2 / Stage II or earlier Emissions Regulation, without aftertreatment devices	Up to B7
	C2.4, C3.3B, C3.8 engines with aftertreatment devices	Up to B7
	C1.3, C1.7, C1.8, C2.4, C2.6, C3.3B, C3.4 engines without aftertreatment devices, and C3.4B engine with aftertreatment devices	Up to B20
	C0.5 through C2.2, all years except as listed above	Up to B20 (For use of higher blend levels up to B100, consult with your Cat dealer)
Cat engine model C4.4	C4.4 engines with aftertreatment devices	Up to B20 (For use of higher blend levels up to B100, consult with your Cat dealer)
	C4.4 engines S/N C4E05524-Up and 44404304 -Up	Up to B20
	Certain C4.4 (S/N 44400001-04303)	Up to B7
Cat engine models C6.4 and C6.6	C6.6 engines with aftertreatment devices	Up to B20
	C6.4, and certain C6.6 engines (S/N CE614624-Up (Machines) and 66609016-Up (Industrial))	Up to B20 (For use of higher blend levels up to B100, consult with your Cat dealer)
	Certain C6.6 engines (S/N CE600001-14623 (Machines) and S/N 66600001-09015 (Industrial))	Up to B7

⁽¹⁾ EU Regulations require the biodiesel blends used in Stage V engines operated within the European Union (EU) to contain no more than B8 (8% v/v FAME) unless specified otherwise in the engine-specific Operation and Maintenance Manual. B8 can be used where B7 is specified.

Table 18

Fuel Recommendations for Caterpillar Nonroad Engines		
Biodiesel Blend Stock	Final Blend	Distillate Diesel Fuel used for blending
Cat biodiesel specification, ⁽¹⁾ "ASTM D6751" or "EN14214"	B5 and B7; Cat distillate diesel fuel specification, ⁽²⁾ "ASTM D975" or "EN590"	Cat distillate diesel fuel specification, "ASTM D975" or "EN590"
	B20: "ASTM D7467" or "EN 16709" and "API" gravity 30-45	

⁽¹⁾ Refer to Table +=" in the Biodiesel section of this Special Publication.

⁽²⁾ Refer to "Cat Specification for Distillate Diesel Fuel for On-Highway Engines" in the Fuel section of this Special Publication.

Note: Do not change any engine settings when using biodiesel fuel. When the use of biodiesel fuel is planned, simply convert to this fuel. Follow the guidelines, recommendations, and quality specifications given in this Chapter to avoid any performance issues or downtime.

Two methods can be used for determining the volume percent biodiesel in a biodiesel blend:

- “ASTM D7371” - “Test Method for Determination of Biodiesel (Fatty Acid Methyl Esters) Content in Diesel Fuel Oil Using Mid Infrared Spectroscopy (FTIR-ATR-PLS Method)”
- “EN 14078” - “Liquid Petroleum Products - Determination of fatty acid methyl esters (FAME) in middle distillates -Infrared spectroscopy method”

For applications running biodiesel or biodiesel blends, if fuel treatments are needed, consult with your fuel supplier or with a reputable provider. :

Impact of Biodiesel on Engine Oil

Biodiesel fuel has higher density and lower volatility than diesel fuels. As a result, during engine operation, biodiesel fuel that dilutes the crankcase oil may not evaporate as effectively as diesel fuels. For this reason, fuel dilution of crankcase oils may be higher when biodiesel, in particular when higher blends of biodiesel are used.

Also, biodiesel contains oxygen molecules. These oxygen molecules cannot be differentiated from oil oxidation when using current oil analysis techniques. As a result, biodiesel fuel dilution of the crankcase oil can appear to be higher oxidation of the oil.

When using biodiesel fuel and higher fuel dilution and/or apparent oil oxidation are detected in the crankcase engine oil, consider all the other characteristics of the used oil. If these characteristics, such as wear metals, soot, viscosity or others, are per Caterpillar guidelines and have not reached condemnation limits, then the oil drain intervals should not be impacted.

To reduce any potential impact of biodiesel fuel dilution on crankcase oil, **the use of Cat S-O-S Services oil analysis is strongly recommended when up to B20 (20 percent) and lower biodiesel blends are used, and required when using biodiesel/biodiesel blends that are B20 or above.** When requesting oil analysis, be sure to note the level of biodiesel being used (B5, B20, and so on).

Use of Biodiesel fuel in Engines with Aftertreatment Emissions Control Systems

Biodiesel fuels as defined in the current ASTM specifications, may contain phosphorous, alkali and alkaline metals (sodium, potassium, calcium, and magnesium) due to processing techniques or due to the natural contents of the biodiesel feedstock. When present in biodiesel, these metals form ash upon combustion in the engine. The ash accumulates in the aftertreatment systems such as Diesel Particulate Filters (DPF), DOC or other systems. The ash can affect the life and performance of aftertreatment emissions control devices and may cause the need for more frequent ash service intervals. For these reasons, biodiesel fuels that contain ash forming metals, even at the concentration levels defined in the current specifications, are limited to B20 blend levels in the engines with aftertreatment devices.

Local and regional regulations may also restrict the blend levels allowed in engines of certain emissions levels. **EU Stage V** regulations REQUIRE the biodiesel blends used in engines operated within the European Union (EU) to be $\leq 8\%$ volume/volume unless specified otherwise in the engine-specific Operation and Maintenance Manual.

Note: Certain CAT engines that are certified per EU Stage V can use up to B20 biodiesel blends. Refer to your engine specific Operation and Maintenance Manual.

Biodiesel Fuel Stability

Biodiesel fuels key difference from diesel fuel is the ester chemical group (contains two oxygen atoms) in every biodiesel molecule. Biodiesel may also have double bonds (unsaturation) in the carbon chain that can vary based on the feedstock. Due to the ester chemical group and the unsaturation, the oxidation stability of biodiesel fuels is typically lower than that of diesel fuel. The oxidation stability of biodiesel and biodiesel blends is controlled in ASTM specifications, "D6751" for B100 and "D5467" for B20. Biodiesel fuels that do not conform to these specifications can oxidize quickly during use due to the high temperature and pressure conditions in the engine or during storage and handling practices. Oxidized biodiesel forms acids, gums, high viscosity and deposits, which can plug filters, form deposits, particularly in the fuel injector, and reduce the performance of fuel systems. **Biodiesel fuels meeting or exceeding the oxidation stability limits is critical** to avoid poor performance and downtime of engines.

To avoid the issues associated with oxidized biodiesel fuel, always purchase fuels that conform to or exceed the specifications (refer to Tables 54 and 56 in this Chapter). Also, follow all the guidelines for appropriate storage and handling of this fuel such as avoiding excessive heat and sunlight during storage, exposure to oxygen (air), contact with metals such as copper, lead, tin, zinc, and others. The use of antioxidants can improve the oxidation stability of biodiesel fuel. The antioxidants are most effective when added to new fuels. Consult with your fuel supplier to ensure the quality of the fuel and refer to the details given in this chapter for guidance.

Cat Diesel Fuel System Cleaner (Part number 343-6210). Cat , used as needed or on an on-going basis, is most effective at cleaning and preventing the formation of fuel-related deposits.

Refer to the "Diesel Fuel Conditioner" and "Cat Diesel Fuel System Cleaner" topics in the "Distillate Diesel Fuel" section in this Special Publication for additional information. Consult your Caterpillar dealer for availability of Cat Diesel Fuel System Cleaner. In case a fuel conditioner is needed to improve certain fuel properties, consult with your fuel supplier or with a reputable provider.

Biodiesel Fuel Storage

Storage tanks used for storing diesel fuel are appropriate for storing biodiesel fuels. Fuel storage tanks need to be cleaned thoroughly before converting to biodiesel/biodiesel blends. Conversion to biodiesel/biodiesel blends can loosen fuel system and fuel storage tank deposits. Loosened deposits result in filter plugging with the loosened deposits. For this reason, the change intervals of bulk tank continuous filtration unit, dispensing point filters, and onboard engine filters should be shortened for an extended period to allow for this cleaning effect. Once the systems are cleaned, the typical filter service intervals can be resumed.

Biodiesel fuel is hygroscopic, which implies that biodiesel tends to absorb and dissolve water at a higher concentration than diesel. All precautions and measures must be taken to ensure that storage tanks are protected from water ingress. Follow all the contamination control measures provided in the "Contamination Control" section of this Special Publication.

Note: If switching from biodiesel to distillate fuel, it is recommended to change all fuel filters to avoid filter plugging. Failure to do so can create low fuel pressure.

Guidelines

Information provided in this table refers to biodiesel and biodiesel blends that fully comply with the appropriate specifications as described in the "Biodiesel" section of this Special Publication and to handling and maintenance procedures that follow recommended guidelines.

Table 19

Guidelines and Potential Impacts Associated with the Use of Biodiesel and Biodiesel Blends ⁽¹⁾			
Paragraph reference	Risk/Recommendation	B6-B20	B21-B100
1	Risk of reduction of oil change interval	Low	Medium
2	Fuel filters compatibility risk	Low	Medium
3	Loosening of fuel systems deposits upon conversion to biodiesel	Medium	High
4	Bulk filtration of biodiesel	≤4 microns absolute	≤4 microns absolute

(continued)

(Table 19, contd)

Guidelines and Potential Impacts Associated with the Use of Biodiesel and Biodiesel Blends ⁽¹⁾			
5	Energy content of biodiesel	Minor loss of 1-2 percent	Detectable loss of 5-8 percent
6	Risk of elastomers compatibility	Low	Medium
7	Low ambient temperature issues for both storage and operation	Low-Medium	Medium-High
8	Oxidation stability-Injector deposits risk	Low-Medium	Medium-High
9	Oxidation stability-Duration of storage ⁽²⁾	8 months ⁽³⁾	4 months ⁽⁴⁾
10	Use in engines with limited operational time	Unacceptable ⁽⁵⁾	Unacceptable
11	Microbial contamination and growth-Risk	Medium-High	High
12	Need for water removal	High	High
13	Metal incompatibility	Medium	High

- (1) Information provided in this Table refers to biodiesel and biodiesel blends that fully comply with the appropriate specifications as described in the "Biodiesel section" of this Special Publication and to handling and maintenance procedures that follow recommended guidelines.
- (2) Testing of biodiesel or biodiesel blend during storage is strongly recommended. Tests should include oxidation, acid number, viscosity and sediments. Tests should be conducted periodically to ensure biodiesel is per specification. Antioxidants are recommended to improve stability of biodiesel. Consult with your fuel supplier for more information.
- (3) Testing of B20 blends is recommended at 4 months of storage and on a monthly basis thereafter. Tests should include oxidation, acid number, viscosity, and sediments.
- (4) B100 stored for over 2 months should be tested every 2 weeks to ensure that the fuel is not degraded. Tests should include oxidation, acid number, viscosity, and sediments. The use of appropriate additives is required if B100 is stored more than 4 months. Consult your fuel supplier for more information. B100 should be stored at temperatures of 3 degrees C to 6 degrees C (5 degrees F to 10 degrees F) above the cloud point.
- (5) If B20 is used in engines of limited operational time, it is recommended that a stabilizer additive is added at the beginning of the storage period. Testing is recommended periodically to ensure the fuel has not oxidized.

The following are details of the Risks and Guidelines listed in Table 19 . Refer to the paragraph reference numbers:

1. When using biodiesel fuel, dilution of oil by the fuel may increase. Use S·O·S Services oil analysis to monitor the condition of the engine oil. S·O·S Services oil analysis will also help determine the oil change interval that is optimum. Details are given earlier in this Chapter.
2. Confirm with the filter manufacturer that the fuel filter/filters to be used are compatible with biodiesel. Fuel water separators are preferred when biodiesel is used.

Note: Cat fuel filters and Cat fuel water separators are compatible with biodiesel fuel.

3. Conversion to biodiesel can loosen fuel tanks and fuel system deposits. During the conversion period fuel filter change intervals should be shortened to allow for this cleaning effect. Once the deposits are removed, convert back to the regular filter service intervals. Filter change interval of 50 hours or less may be expected during initial conversion to B20 biodiesel blend.

4. Filter biodiesel and biodiesel blends through a fuel filter with a rating of 4 microns (c) absolute or less. Filters should be on the device that dispenses the fuel from the bulk storage tank to the fuel tank for the engine. Bulk filtration with fuel water separators is recommended. Series filtration is recommended.
5. Neat biodiesel (B100) typically provides less energy per gallon compared to diesel fuels. The energy content of B100 is 5 percent to 8 percent lower than No. 2 diesel fuel. The energy content of B20 is 1 percent to 2 percent lower than No. 2 diesel fuel, which is not significant. Do NOT attempt to change the engine rating to compensate for the power loss. Any adjustments to the engine in service may result in violation of emissions regulations such as the U.S. EPA anti-tampering provisions. Also, if any tempering with the engine ratings occurs, problems may occur when the engine is converted back to 100 percent distillate diesel fuel.

6. Compatibility of the elastomers with biodiesel is being monitored. Prolonged exposure of certain elastomers, hoses, seals, and gaskets to B100 may cause some degradation and softening of these materials. The condition of gaskets, seals, and hoses should be monitored regularly. The risk of degradation increases with the increase of biodiesel blend level.
 - a. In general, Cat engines built early to mid-90s use Viton seals and Viton O-rings in the fuel system. Viton is compatible with biodiesel and degradation upon exposure to this fuel is not expected.
 - b. Nitrile hoses typically used in some fuel transfer lines are not compatible with biodiesel. Monitor the condition of the hoses and confirm with the hose manufacturer that the hoses are compatible with the biodiesel blend used. If necessary, replace with hoses of compatible materials.
7. Biodiesel fuels may gel or freeze at low temperatures due to the nature of this fuel. Ensure that the biodiesel pour point is appropriate for the climate of the application. In general the risk of low temperature gelling of biodiesel increases with the increase of blend levels and may depend on the biodiesel feedstock (soy, used cooking oil, animal fats, and others). If the pour point of the biodiesel is not appropriate for the climate of the application, the fuel can gel and plug filters, hoses and transfer lines. At low ambient temperatures, biodiesel fuel may need to be stored in a heated building or a heated storage tank. Consult your biodiesel supplier for assistance in the blending and attaining of the proper cloud point for the fuel. Refer to "Modifying the Cloud Point" in the "Diesel Fuel" Section of this Special Publication.

Note: The performance of cold flow improvers may be less effective in biodiesel fuel compared to diesel fuel. Consult the fuel supplier for appropriate cold flow improvers if needed.
8. Biodiesel oxidation stability is in general lower than that of diesel fuel, as detailed earlier in this Chapter. The use of biodiesel fuels that are not per specifications can accelerate fuel oxidation in the fuel system. Also, engines with an electronic fuel system operate at higher temperatures and pressures can also accelerate fuel oxidation. Oxidized fuel can form deposits in fuel injection systems and in fuel systems in general. Always use biodiesel fuel that meets or exceeds the stability limits defined in biodiesel specifications as given in this Chapter to avoid fuel oxidation and degradation. The use of appropriate antioxidants can enhance oxidation stability of biodiesel. Refer to "Biodiesel Fuel Stability" section of this chapter for details and guidelines.
9. Due to the chemical nature of biodiesel fuel, biodiesel can age and degrade during long-term storage. Fuel aging and fuel oxidation upon long-term storage may cause the formation of gels, acids and/or deposits. For these reasons, biodiesel should be used within a limited time from production. To ensure appropriate storage duration, testing of the stored biodiesel is recommended. Tests should include oxidation, acid number, viscosity, and sediments. Tests should be conducted periodically to ensure that biodiesel is per specification. Antioxidants are recommended to improve stability of biodiesel and increase the storage time limits. In case a fuel conditioner is needed to improve certain fuel properties, consult with your fuel supplier or with a reputable provider.
 - a. B20 biodiesel blend can generally be stored up to 8 months. Testing of B20 blends is recommended at 4 months of storage and on a monthly basis thereafter to ensure that the fuel has not degraded.
 - b. B100 biodiesel can generally be stored up to 4 months. Testing of B100 is recommended at 2 months of storage and every two weeks thereafter to ensure that the fuel has not degraded. The use of appropriate additives is required if B100 is stored for more than 4 months. Consult your fuel supplier for more information.
 - c. B100 should be stored at temperatures of 3° C to 6° C (5° F to 10° F) above the cloud point. Other storage conditions such as avoiding direct sunlight or heat should be followed.

10. Due to limited oxidation stability and other potential issues, engines with limited operational time (such as seasonal use including school buses, farm machinery, or standby power generation) should either not use biodiesel/ biodiesel blends or, while accepting some risk, limit biodiesel to a maximum of B5. Examples of applications that should limit the use of biodiesel are the following: Standby Generator sets and certain emergency vehicles. For more information, refer to the “Seasonal Operation” section.

a. A high-performance fuel conditioner is recommended for standby generator sets and emergency vehicles using biodiesel/biodiesel blends. The conditioner should be added when the engine is fueled or as early as possible when the fuel is delivered and stored. Preferably, the conditioner or additive should be added as soon as possible after the fuel is produced.

b. For standby generator sets and emergency vehicles that use biodiesel, sample the fuel in the engine tank monthly. Test the fuel for acid number and oxidation stability. If the test results show that the fuel is degraded and not in specification (provided in Table 20 in this “Biodiesel” section), drain the tank, and flush the engine by running with high-quality fuel.

Repeat the process until the system is clean. Refill with high-quality fuel following the recommendations provided in this “Fuel” section. For standby generator sets and emergency vehicles that use biodiesel, use fuel with oxidation stability 10 hours or more per “EN 14112” test method.

11. Biodiesel is prone to microbial contamination and growth due to the chemical nature. Microbial contamination and growth can cause corrosion in the fuel system and premature plugging of the fuel filter. Consult your supplier of fuel and additive for assistance in selecting appropriate anti-microbial additives.

12. Biodiesel can absorb and dissolve more water than diesel due to the chemical nature. Care must be taken to prevent water from contaminating the fuel and to remove water from fuel tanks. Water accelerates microbial contamination and growth.

13. Biodiesel is not compatible with some metals. Biodiesel, in particular at blends higher than B20, will oxidize and form sediments upon long-term contact with lead, zinc, tin, copper, and copper alloys such as brass and bronze. These materials are typically not used in the fuels systems. Consult your dealer for more information.

Note: The use of biodiesel at a B2 level improves the lubricity of the final blend by an estimated 66 percent. Increasing the blend level higher than B2 does not improve the lubricity any further.

Note: Use of biodiesel that is per or preferably exceeds the specifications can avoid the issues listed above and reduce the risks listed above.

Seasonal Operation

Seasonally operated engines should have the fuel systems, including fuel tanks, flushed with conventional diesel fuel before prolonged shutdown periods. Applications that should seasonally flush the fuel system include school buses (U.S.) and farm machinery.

Perform the following process before shutting down the engine for prolonged periods:

1. Operate the engine until the fuel level in the tank is low.
2. Refill the fuel tank with high-quality conventional distillate diesel fuel.
3. Repeat steps 1 and 2 a minimum of two times before the engine is shut down for prolonged periods.

If distillate fuel is not available to operate the engine as described above, while accepting some risk, limit biodiesel to a maximum of B5. The use of biodiesel fuel of high oxidation stability can reduce the risks associated with prolonged storage. Follow the recommendations provided in this section and the guidelines given below to reduce the risk:

- Addition of a high-performance diesel fuel conditioner is recommended prior to engine shutdown for prolonged periods. The conditioner should be added when the engine is fueled. Preferably, the conditioner is added to the fuel as soon as possible after the fuel production.
- Addition of Cat Diesel Fuel System Cleaner, part number 343-6210, is recommended when the engine is first operated after the prolonged shutdown period and preferably for a total of two tanks of fuel. Follow the recommendations provided in the Cat Diesel Fuel System Cleaner section in the “Fuel” article in this Special Publication.

Consult your Caterpillar dealer for the availability of Cat Diesel Fuel System Cleaner. In case a fuel conditioner is needed to improve certain fuel properties, consult with your fuel supplier or with a reputable provider

Biodiesel Specification

Biodiesel fuel used that is used for blending must meet the requirements in the following table, the requirements of ASTM "D5761" and/or "EN14214".

The final blend of biodiesel as used in the engine must meet the requirements that are stated in table 20 this "Biodiesel" article.

B100 intended for blending into diesel fuel that is expected to give satisfactory vehicle performance at fuel temperatures at or below -12°C (10.4°F) shall comply with a cold soak filterability limit of 200 seconds maximum. Passing "ASTM D6751" 200 seconds Cold Soak Filterability test limit does not guarantee cold performance for all biodiesel blends at all possible fuel temperatures, but biodiesel that fails this Cold Soak Filterability test requirement will produce biodiesel blends that will likely plug fuel filters when fuel temperatures are below -12°C (10.4°F).

Table 20

Cat Specification for Biodiesel Fuel				
Property	Test Method	Test Method	Units	Limits
	United States	International	Specific Properties of Fuel	
Density at 15°C	"ASTM D1298"	"ISO 3675"	g/cm ³	0.86-0.90
Viscosity at 40°C	"ASTM D445"	"ISO 3104"	mm ² /s (cSt)	1.9-6.0
Flash Point	"ASTM D93"	"ISO 3679"	°C	93 minimum
Pour Point - Summer - Winter	"ASTM D97"	"ISO 3016"	°C	6 °C (10 °F) minimum below ambient temperature
Cloud Point	"ASTM D2500"		°C	Report
Sulfur Content	"ASTM D5453"	"ISO 20846" "ISO 20884"	percent weight	0.0015 maximum
Distillation 10 percent Evaporation	"ASTM D86"	"ISO 3405"	°C	To Be Determined
Distillation 90 percent Evaporation	"ASTM D86"	"ISO 3924"	°C	360
Carbon Residue, Conradson (CCR)	"ASTM D4530"	"ISO 10370"	percent weight	0.05 maximum
Cetane Number	"ASTM D613"	"ISO 5165"		45 minimum
Sulfated Ash	"ASTM D874"	"ISO 3987"	percent weight	0.02 maximum
Water/Sediment Content	"ASTM D2709"	"ISO 12937"	percent volume	0.05 maximum

(continued)

(Table 20, contd)

Cat Specification for Biodiesel Fuel				
Property	Test Method	Test Method	Units	Limits
	United States	International	Specific Properties of Fuel	
Copper Corrosion	"ASTM D130"	"ISO 2160"		No. 1
Oxidation Stability	"EN 14112"	"EN 14112"	hours	3 minimum
Esterification	"EN 14103"	"EN 14103"	percent volume	97.5 minimum
Acid Value	"ASTM D664"	"EN 14104"	mg KOH/g	0.5 maximum
Methanol Content	"EN 14110"	"EN 14110"	percent weight	0.2 maximum
Monoglycerides	"ASTM D6584"	"EN 14105"	percent weight	0.8 maximum
Diglycerides	"ASTM D6584"	"EN 14105"	percent weight	0.2 maximum
Triglycerides	"ASTM D6584"	"EN 14105"	percent weight	0.2 maximum
Free Glycerin	"ASTM D6584"	"EN 14105"	percent weight	0.02 maximum
Total Glycerin	"ASTM D6584"	"EN 14105"	percent weight	0.240 maximum
Phosphorus Content	"ASTM D4951"	"EN 14107"	percent weight	0.001
Calcium and Magnesium combined	"EN 14538"	"EN 14538"	ppm	5 maximum
Sodium and Potassium combined	"EN 14538"	"EN 14538"	ppm	5 maximum
Cold Soak Filterability	"ASTM D7501"	–	seconds	360 maximum
Cleanliness	"ASTM D7619"	"ISO 4406"	–	(1)

(1) Recommended cleanliness level for fuel as dispensed into machine or engine fuel tank is "ISO 18/16/13" or cleaner per "ISO 4406" or "ASTM D7619". Refer to the "Contamination Control" section in this Special Publication.

Note: Fuels that meet the most current revision level of "ASTM D6751" or "EN 14214" may be used for blending with an acceptable distillate fuel. The conditions, recommendations, and limits that are noted in this Biodiesel section apply.

Referenced Documents

Refer to the "Reference Material - Fuel" section of this Special Publication for the reference material for the information in this section.

Cooling System Specifications

i06703088

General Coolant Information

SMCS Code: 1350; 1395

WARNING

The cooling system operates under pressure which is controlled by the radiator pressure cap. Removing the cap while the system is hot may allow the escape of hot coolant and steam, causing serious burns.

Before you remove the radiator cap, allow the system to cool. Use a thick cloth and turn the radiator cap slowly to the first stop to allow pressure to escape before fully removing the cap.

Avoid contact with coolant.

NOTICE

Every attempt is made to provide accurate, up-to-date information. By the use of this document, you agree that Caterpillar Inc. is not responsible for errors or omissions.

The information that is provided is the latest recommendations for the Cat diesel engines that are covered by this Special Publication. This information supersedes all previous recommendations which have been published for the Cat diesel engines that are covered by this Special Publication. Special fluids may be required for some engines. Continue to use these special products. Refer to the applicable Operation and Maintenance Manual.

This publication is a supplement to the Operation and Maintenance Manual. This publication does not replace the engine Operation and Maintenance Manual.

NOTICE

These recommendations are subject to change without notice. Consult your local Cat dealer for the most up to date recommendations.

NOTICE

In order to avoid potential damage to your Cat machine and/or Cat engine, only purchase Cat fluids and Cat filters through your Cat dealer or Cat authorized outlets. For a list of authorized Cat parts outlets in your area, consult your Cat dealer.

If you purchase what appear to be Cat fluids and/or Cat filters through other outlets/sources, you are at a very high risk of purchasing counterfeit (“look-alike”) products.

Counterfeit or “look-alike” products may visually appear the same as the original Cat product, but the product performance and internal quality will typically be very low.

Counterfeit or “look-alike” products have a very high likelihood of causing and/or allowing engine and/or machine compartment damage.

NOTICE

Commercial products that make generic claims of meeting “Cat” requirements without listing the specific Cat recommendations and requirements that are met may not provide acceptable performance. Commercial products may cause reduced engine and/or machine fluid compartment life. Refer to this Special Publication and refer to product specific Operation and Maintenance Manual for Cat fluids recommendations and requirements.

NOTICE

Never add coolant to an overheated engine. Engine damage could result. Allow the engine to cool first.

NOTICE

If the engine is to be stored in, or shipped to an area with below freezing temperatures, the cooling system must be either protected to the lowest outside temperature or drained completely in order to prevent damage caused by freezing coolant.

NOTICE

Never operate an engine without water temperature regulators in the cooling system. Water temperature regulators help to maintain the engine coolant at the proper operating temperature. Cooling system problems can develop without water temperature regulators.

If you operate the engine without the regulator, some coolant bypasses the radiator. This may cause overheating.

Note: Refer to the specific engine Operation and Maintenance Manual, “Maintenance Interval Schedule” for the correct interval for the replacement of the thermostat.

Refer to Special Instruction, SEBD0518, "Know Your Cooling System" for more detailed information.

Many engine failures are related to the cooling system. The following problems are related to cooling system failures:

- Overheating
- Leakage of the water pump
- Plugged radiators or heat exchangers
- Pitting of the cylinder liners

These failures can be avoided with proper cooling system maintenance. Cooling system maintenance is as important as maintenance of the fuel system and the lubrication system. Quality of the coolant is as important as the quality of the fuel and the lubricating oil.

A coolant that is ready to use in the engine can also be referred to as "finished coolant". A finished coolant is a coolant that has been diluted with appropriate amount of acceptable quality water.

Coolant is normally composed of the following elements:

- water
- additives
- glycol
- Embitterment: in coolants containing ethylene glycol to make the coolant taste bad.

Technical information for each of the coolant elements is provided in this Special Publication.

Water

NOTICE

Never use water alone as a coolant. Water alone is corrosive at engine operating temperatures. In addition, water alone does not provide adequate protection against boiling or freezing.

Note: In glycol-based coolants, Cat strongly recommends a minimum of 30 percent glycol in diesel engine cooling systems, with a minimum of 50 percent glycol recommended. Use only glycol-based coolants that meet one or more of the coolant specifications that are defined as preferred or acceptable in this Special Publication and that also comply with any additional requirements that are stated in this Special Publication (that is, chemical composition, the use of SCA, the use of Extender). Refer to the Operation and Maintenance Manual for your engine for any exceptions, and refer to Table 21 for marine engine exceptions.

NOTICE

All Cat engines that are equipped with a Cat NOx Reduction System require a minimum of 50 percent glycol to help prevent cavitation damage and boiling of the engine coolant. These engines include Tier 4 engines.

Maintenance Section
General Coolant Information

Table 21

Special Requirements ⁽¹⁾	
Cat diesel engines equipped with air-to-air aftercooling (ATAAC)	Minimum of 30% glycol is required. 50% Glycol is recommended. Water alone or water with SCA or with ELI is NOT allowed.
Cat C7-C32 marine engines with engine mounted heat exchangers and raw water aftercoolers (SWAC ⁽²⁾)	
Cat 3618 engine model	Water based ELI is recommended. Water based SCA is acceptable. Glycol-based coolants are NOT allowed.
Cat C18 SCAC ⁽³⁾ , Cat C32 SCAC, and Cat 3500C Tier 3 certified marine engines	Maximum of 20% glycol is allowed in the aftercooler circuit. ⁽⁴⁾ (not applicable to the jacket water circuit, which is capable of 50% glycol)

⁽¹⁾ Water based ELI and SCA are not recommended for use in applications that require freeze protection.

⁽²⁾ SWAC: seawater aftercoolers

⁽³⁾ SCAC: Separate Circuit Aftercooler

⁽⁴⁾ For freezing protection of -5°C (23°F) temperatures and lower, consult your Cat dealer for guidance.

C7-C32 heat exchanger cooled marine engines require a minimum of 30 percent glycol to prevent cavitation of cooling system components, with a minimum of 50 percent glycol recommended.

Note: For engines that require a maximum of 20% glycol, make sure that the amount of additive in the final mix is appropriate. Example of mixing a 20% glycol solution is given in Table 22 .

Table 22

Example of Mixing Up a 20% Glycol Coolant ⁽¹⁾			
Total Volume of the Cooling System	Add the Following:		
	ELC Concentrate	ELI Concentrate	Water
10 Gallons	2 Gallons	0.5 Gallons	7.5 Gallons

⁽¹⁾ Volumes can also be in liters as long as all the volume units are consistent

Water in the water/glycol coolants is more effective than glycol alone in transferring heat.

Distilled water or deionized water is recommended to add to glycol or to water based coolants in engine cooling systems.

DO NOT use the following types of water in cooling systems: hard water, softened water that has been conditioned with salt and sea water.

If distilled water or deionized water is not available, use water that meets or exceeds the minimum acceptable water requirements that are listed in Table 23 .

Table 23

Cat Minimum Acceptable Water Requirements		
Property	Maximum Limit	ASTM Test
Chloride (Cl)	40 mg/L (2.4 grains/US gal)	"D512", "D4327"
Sulfate (SO ₄)	100 mg/L (5.9 grains/US gal)	"D516" "D4327"
Total Hardness	170 mg/L (10 grains/US gal)	"D1126"
Total Solids	340 mg/L (20 grains/US gal)	"D1888" "Federal Method 2504B" ⁽¹⁾
Acidity	pH of 5.5 to 9.0	"D1293"

⁽¹⁾ Total dissolved solids dried at 103°C (217°F) - 105°C (221°F), "Standard Method for the Examination of Water and Wastewater", "American Public Health Association", "www.apha.org", "www.aphabookstore.org", (888) 320-APHA.

For a water analysis, consult one of the following sources:

- Cat dealer
- Local water utility company
- Agricultural agent
- Independent laboratory

Periodic analysis of water that is used to add to the coolant is recommended. Water quality can be affected by various factors including malfunctioning purification equipment, earthquakes, and droughts.

Additives

Additives help to protect the metal surfaces of the cooling system and can improve coolant performance. A lack of coolant additives, insufficient amounts of additives, or improper additives for the application can cause the following conditions to occur:

- Corrosion
- Formation of mineral deposits
- Rust
- Scale
- Pitting and erosion from cavitation of the cylinder liner
- Foaming of the coolant

Many additives are depleted during engine operation. These additives must be replaced periodically. Additives that can be added:

- ELC Extender to Cat ELC (Extended Life Coolant)
- ELC Extender to Cat ELI (Extended Life Inhibitor)
- Cat SCA (Supplemental Coolant Additive) to Cat DEAC (Diesel Engine Antifreeze/Coolant)
- Cat SCA to Cat SCA in water finished coolant

Additives must be added at the proper concentration. Overconcentration of additives can cause the inhibitors to drop out-of-solution. The deposits can enable the following problems to occur:

- Formation of gel compounds
- Reduction of heat transfer
- Leakage of the water pump seal
- Plugging of radiators, coolers, and small passages

Glycol

Glycol in the coolant helps to provide protection against the following conditions:

- Boiling
- Freezing
- Water pump cavitation (ATAAC equipped engines)

For optimum performance, Cat recommends a 50 percent by volume of glycol in the finished coolant (also referred to as 1:1 mixture).

Note: Use a mixture that will provide protection against the lowest ambient temperature.

Most conventional heavy-duty coolant/antifreezes use ethylene glycol. Propylene glycol may also be used. In a 50 percent by volume of glycol in the finished coolant, ethylene and propylene glycol provide similar protection against freezing and boiling. Refer to tables 24 and 25 .

Table 24

Ethylene Glycol Concentration		
Concentration	Freeze Protection	Boil Protection (1)
20 Percent	-8° C (18° F)	102° C (216° F)
50 Percent	-37° C (-34° F)	106° C (223° F)
60 Percent	-52° C (-62° F)	111° C (232° F)

(1) Boiling protection is increased with the use of a pressurized radiator.

Do not use propylene glycol in concentrations that exceed 50 percent glycol because of the reduced heat transfer capability. Use ethylene glycol in conditions that require additional protection against boiling or freezing. Do not use ethylene glycol in concentrations that exceed 60 percent glycol.

Table 25

Propylene Glycol Concentration		
Concentration	Freeze Protection	Boil Protection (1)
50 Percent	-32° C (-26° F)	106° C (223° F)

(1) Boiling protection is increased with the use of a pressurized radiator.

Propylene glycol coolant that is used in the cooling systems for Cat diesel engines must meet ASTM D6210-06, "Fully-Formulated Glycol-Based Engine Coolant for Heavy-Duty Engines". When propylene glycol coolant is used in heavy-duty diesel engines, a regular addition of SCA is required for protection against liner cavitation. Consult your Cat dealer for additional information.

Ethylene or propylene glycols used in cooling systems for Cat diesel engines must meet ASTM E1177-06, "Standard Specification for Engine Coolant Grade Glycol".

Testing the Concentration of Glycol

To check the concentration of glycol, use the 245 - 5829 Coolant/Battery Tester/Refractometer or 360-0774 refractometer. The tester can be used with ethylene or propylene glycol.

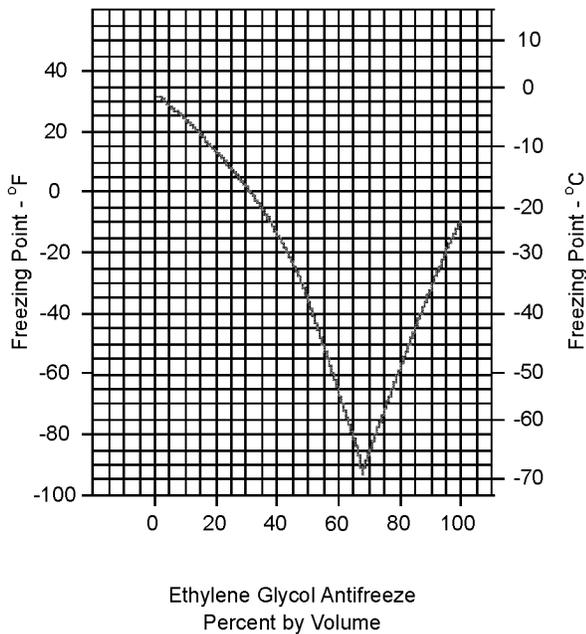


Illustration 2

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Approximate curve of the freezing point for a typical ethylene glycol solution.

Table 26

Freeze Protection for Antifreeze Concentrations ⁽¹⁾	
Protection to:	Concentration
-8° C (18° F)	20% glycol 80% water
-15° C (5° F)	30% glycol 70% water
-24° C (-12° F)	40% glycol 60% water
-37° C (-34° F)	50% glycol 50% water
-52° C (-62° F)	60% glycol 40% water

⁽¹⁾ Ethylene glycol-based antifreeze.

Alternative products that are used to protect from boiling or freezing of the engine coolant include:

- “1,3 propandiol” (PDO)
- glycerin
- mixtures of these alternative products with glycol

At the time of publication of this document, there currently exists no ASTM, “specifications” for coolants using these chemicals. **Until specifications are published and then evaluated by Cat, use of PDO and glycerin or glycerin/glycol coolants are not recommended in Cat cooling systems.**

Embitterment

Ethylene glycol is a toxic chemical with a naturally sweet taste. In order to avoid accidental excessive ingestion by humans or animals, coolants may contain embittering agents that make the coolant taste bad. **All Cat glycol containing coolants (Cat ELC, Cat DEAC, and Cat NGEC) are embittered.** Embittering agents have no beneficial or detrimental effect on coolant performance or characteristics.

Coolant Terminology

Extended Life Coolant (ELC) – A coolant that relies largely on organic inhibitors for corrosion and cavitation protection. Carboxylate is an example of organic corrosion and cavitation inhibitors. Cat ELC and Cat ELI in water are extended life coolants that also include nitrites and molybdates for increased cavitation protection.

- Commercial extended life coolants containing silicate do not meet the additional requirements set in this Special Publication for coolants claiming to meet Cat EC-1 specification.
- Do not use commercial extended life coolants with more than 125 ppm silicon (present in the coolant in the form of silicate)
- Extended life coolants that meet “ASTM D4985-05” or “ASTM D6210-06” may be used at the recommended maximum coolant service life intervals stated in this Special Publication for coolants that meet the ASTM specifications.

Conventional coolant – A coolant that relies largely on inorganic inhibitors for corrosion and cavitation protection. Silicates and nitrites are examples of inorganic inhibitors. Conventional coolants are also referred to as heavy-duty coolants, heavy-duty fully formulated coolants, or traditional coolants. In order to be used in most Cat cooling systems, conventional coolants must meet “ASTM D4985-05” or “ASTM D6210-06”. Cat DEAC and Cat SCA in water (also referred to as SCA/Water coolant) are conventional coolants

Supplemental Coolant Additive (SCA) – SCA is a general term for a concentrated inorganic inhibitor package. SCA is used for three different purposes:

- to precharge a new conventional coolant that is not fully Formulated. Cat DEAC is fully formulated and does not require SCA

- to provide corrosion protection in water/SCA cooling systems
- to recharge an in service conventional coolant on a maintenance basis to maintain proper inhibitor levels

Extender – An inhibitor package that is added to extended life coolants, to recharge an in-service coolant. Extenders, typically, only should be added at one half the service life of the coolant.

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Coolant Recommendations (General Maintenance)

SMCS Code: 1350; 1352; 1395

The finished coolants that are recommended or acceptable for use in Cat diesel engines are given in Table 27 below:

Table 27

Recommendations for Finished Coolants for use in Cat engines				
Coolant Type	Recommendations	Product	Service hours ⁽¹⁾⁽²⁾	Required Maintenance ⁽³⁾
Cat ELC, Cat ELI, or commercial coolant that meets Cat EC-1	Preferred	Cat ELC	12000 hours or 6 years	Add Cat ELC Extender at 6000 service hours or one half of service life
		Cat ELI (water based) ⁽⁴⁾	12000 hours or 6 years	Add Cat ELC Extender at 6000 service hours or one half of service life
	Min requirements	Cat EC-1 specification and "ASTM D6210" and Organic Additive Technology (OAT) based on a combination of a monocarboxylic acid and a dicarboxylic acid Phosphate, borate, and silicate free Tolyltriazole: minimum typical concentration of 900 ppm Nitrite: minimum typical concentration of 500 ppm in new coolants	6000 hours or 6 years	Add Extender at 3000 service hours or one half of service life
Cat DEAC, Cat SCA, conventional coolants and commercial extended life coolants that do not meet EC-1	Acceptable	Cat DEAC	3000 hours or 3 years	SCA at maintenance intervals
		Cat SCA (water based) ⁽⁴⁾	3000 hours or 2 years	SCA at maintenance intervals

(continued)

Maintenance Section
General Maintenance

(Table 27, contd)

Recommendations for Finished Coolants for use in Cat engines				
	Min requirements for fully formulated Heavy Duty Commercial coolants	"ASTM D6210" and Nitrite (as NO ₂) concentration: Minimum of 1200 ppm (70 grains/US gal) and maximum of 2400 ppm (140 grains/US gal) Silicon concentration: minimum of 100 ppm and maximum of 275 ppm	3000 hours or 2 years	SCA at maintenance intervals
	Min requirements for Commercial coolants requiring SCA precharge	"ASTM D4985" and Nitrite (as NO ₂) concentration: Minimum of 1200 ppm (70 grains/US gal) and maximum of 2400 ppm (140 grains/US gal) Silicon concentration: minimum of 100 ppm and maximum of 275 ppm	3000 hours or 1 year	SCA at initial fill and SCA at maintenance intervals
	Min requirements for SCA and water ⁽⁵⁾	Commercial supplemental coolant additive and water having Nitrite (as NO ₂) concentration: Minimum of 1200 ppm (70 grains/US gal) and maximum of 2400 ppm (140 grains/US gal) Silicon concentration: minimum of 100 ppm and maximum of 275 ppm	3000 hours or 1 year	Per manufacturer recommendations

- (1) New Coolants at 50 volume percent diluted. Coolants that are prediluted at the coolant manufacturer must be diluted with water that meets Reagent 4 "ASTM D1193" requirements.
- (2) Maintain the in-service coolant at the given limits.
- (3) For appropriate maintenance procedures, refer to the details given in this Chapter. For applications that allow the use of Cat ELI in water, a minimum of 7.5 percent of Cat ELI is recommended. For applications that allow the use of SCA and water, a minimum of 6 percent to a maximum of 8 percent concentration of Cat SCA are recommended.
- (4) Water-based coolants are not allowed for use in machines that have NO_x reduction aftertreatment devices, in engines that have AATAC, and in marine engines that have SWAC.
- (5) There are currently no industry standards to define the quality of water-based conventional coolants. In order to control the quality of SCA and water coolants, the commercial SCA additive package should pass ASTM D6210 and/or ASTM D4985 when this package is used in a glycol based coolant. Do not use a commercial SCA additive package that only meets the ASTM D3306 or equivalent specification when used in a glycol based coolant.

Table 28

Special Requirements⁽¹⁾	
Cat diesel engines equipped with air-to-air aftercooling (ATAAC)	Minimum of 30% glycol is required. 50% Glycol is recommended. Water alone or water with SCA or with ELI is NOT allowed.
Cat C7-C32 marine engines with engine mounted heat exchangers and raw water aftercoolers (SWAC ⁽²⁾)	
Cat 3618 engine model	Water based ELI is recommended. Water based SCA is acceptable. Glycol-based coolants are NOT allowed.
Cat C18 SCAC ⁽³⁾ , Cat C32 SCAC, and Cat 3500C Tier 3 certified marine engines	Maximum of 20% glycol is allowed in the aftercooler circuit. ⁽⁴⁾ (not applicable to the jacket water circuit, which is capable of 50% glycol)

- (1) Water based ELI and SCA are not recommended for use in applications that require freeze protection.
- (2) SWAC: seawater aftercoolers
- (3) SCAC: Separate Circuit Aftercooler
- (4) For freezing protection of -5° C (23° F) temperatures and lower, consult your Cat dealer for guidance.

When referring to the Service Life in table 27 , use the interval that occurs first. These coolant change intervals are only achievable with annual S·O·S Services Level 2 coolant sampling analysis.

Refer to the engine Operation and Maintenance Manual for the correct interval for replacement of the cooling system water temperature regulator.

Note: For engines that require a maximum of 20% glycol, make sure that the amount of additive in the final mix is appropriate. Example of mixing a 20% glycol solution is given in Table 29 .

Table 29

Example of Mixing Up a 20% Glycol Coolant ⁽¹⁾			
Total Volume of the Cooling System	Add the Following:		
	ELC Concentrate	ELI Concentrate	Water
10 Gallons	2 Gallons	0.5 Gallons	7.5 Gallons

⁽¹⁾ Volumes can also be in liters as long as all the volume units are consistent

Extended life coolants require the one time maintenance addition of an extender at coolant service mid-life. For commercial coolants, do NOT use an extender with a coolant unless the extender has been approved by the coolant manufacturer for use with the coolant. The coolant manufacturer is responsible to ensure compatibility and acceptable performance. Failure to follow these recommendations can result in shortened cooling system component life.

Conventional coolants require the maintenance addition of SCA throughout the expected life. For commercial coolants, do NOT use an SCA unless approved by the coolant supplier for use with the coolant. The coolant manufacturer is responsible to ensure compatibility and acceptable performance.

“ASTM D4985” and “ASTM D6210” require coolants that are properly dosed with SCA and that are in a properly maintained cooling system in normal service to be suitable for use for a maximum of 1 year (“ASTM D4985”) and 2 years (“ASTM D6210”). **The suitability for use requirement is the direct responsibility of the coolant manufacturer and SCA manufacturer.** Consult with the coolant and/or SCA manufacturer concerning the suitability of the products for use in a given application.

Cat DEAC does not require a treatment with an SCA at the initial fill.

A commercial heavy-duty coolant/antifreeze that meets the “ASTM D6210” specification does not require a treatment with an SCA at the initial fill.

A commercial heavy-duty coolant/antifreeze that only meets “ASTM D4985”, WILL require a treatment with an SCA at the initial fill and has to fulfill all the requirements listed in the “Technical Requirements for Commercial Extended Life Coolants” table. The user and the coolant manufacturer are responsible to ensure the SCA is compatible. Compatibility is based on the recommendations provided by the coolant manufacturer and SCA manufacturer. For example, an extended life coolant that meets the “ASTM D4985” specification may not be compatible with an SCA designed for use with conventional coolants. The coolant manufacturer is responsible to provide sources of compatible SCAs. The coolant manufacturer and SCA manufacturer are responsible to demonstrate a positive influence on reducing cavitation corrosion in an operating diesel engine.

Read the label or the instructions that are provided by the manufacturer of the commercial heavy-duty coolant/antifreeze.

When adding SCA at initial fill to a coolant/antifreeze that only meets “ASTM D4985”, the user and the coolant manufacturer must ensure the SCA is compatible with the antifreeze/coolant. The addition must be based on the recommendations provided by the coolant manufacturer and SCA manufacturer. One of the test methods required to be used to help ensure SCA compatibility with the antifreeze/coolant concentrate is “ASTM D5828-97”. Follow the test procedure using the antifreeze/coolant of interest to compare the SCA of interest with the reference SCA. The ratio of insoluble for SCA to reference SCA must be < 1. Total insoluble should not exceed 4.0 mL for a 6% SCA mixture. The SCA manufacturer is responsible for ensuring the SCA is compatible with water meeting the “Caterpillar Minimum Acceptable Water Quality Requirements” as found in this Special Publication, and is found in “ASTM D6210”, Table X1.1.

The coolant manufacturer and the SCA manufacturer are responsible to ensure that the products will not cause cooling system harm.

Cat ELC can be recycled into conventional coolants.

Cat ELC, Cat ELI, Cat DEAC, Cat Extender, and Cat SCA are available in several container sizes. The availability of part numbers will vary by the region. Consult your Cat dealer.

In stationary and marine engine applications that do not require protection from boiling or freezing, except as noted in Table 28 , Cat ELI in water or SCA and water are acceptable. **Caterpillar recommends a minimum of 7.5 percent concentration of Cat ELI in those cooling systems using Cat ELI. Caterpillar recommends a minimum of 6 percent to a maximum of 8 percent concentration of Cat SCA in those cooling systems using Cat SCA.** Distilled water or deionized water is preferred in those systems. If distilled or deionized water is not available, use water that meets or exceeds the minimum acceptable water requirements that are listed in this Special Publication, “General Coolant Information” article.

After the addition of water and proper mixing, the concentration of Cat ELI can be determined using the 360-0744 digital Brix refractometer. Refer to the tool operating manual for that refractometer for more information. The concentration of a sample of in-use Cat ELI taken from the cooling system can also be determined using this refractometer

NOTICE

All Cat engines that are equipped with a Cat NOx Reduction System require a minimum of 50 percent glycol to help prevent cavitation damage and boiling of the engine coolant. These engines include Tier 4 engines.

NOTICE

Do not use a commercial coolant/antifreeze that only meets the ASTM "D3306" or equivalent specification. This type of coolant/antifreeze is made for light duty automotive applications.

Use only the coolant/antifreeze that is recommended.

Caterpillar recommends a 50 volume percent glycol and water of proper quality. This mixture will provide optimum heavy-duty performance as a coolant/antifreeze. Some marine engines are an exception as indicated in Table 28 .

Maintain a concentration level of nitrites in the cooling system that is between 1200 ppm (70grains/US gal) and 2400 ppm (140 grains/US gal). S·O·S coolant analysis is the preferred method to check SCA concentration. Alternatively, nitrite levels can be tested with the following tools:

- 4C-9301 nitrite level test strips, English instructions only, use with glycol-based coolants such as Cat DEAC
- 286-2578 nitrite level test strips, English, French, and Spanish instructions, use with glycol-based coolants such as Cat DEAC
- 298-5311 nitrite level titration kit, subject to regional availability, use only with mixtures of water and SCA. Not for use with glycol-based coolants.

Frequently check the concentration of glycol in glycol-based coolant. Use a coolant/battery tester. Two products are available from Cat dealers. 245-5829 is an analogue refractometer that shows the freeze protection level of the coolant in both degrees Celsius and degrees Fahrenheit. 360-0774 is a digital Brix refractometer.

Maintain the proper concentrations of glycol and additives in the coolant. Lowering the concentration of glycol or additives will lower the ability of the coolant to protect the system from pitting, from cavitation, from erosion, and from deposits.

Do not top off the cooling system with water unless there is a specific need to adjust the water/glycol ratio. Compatible 50/50 (water/glycol) coolant is typically used and recommended when cooling system top off is required.

Clean the cooling system for the following reasons:

- Contamination of the cooling system
- Overheating of the engine
- Foaming of the coolant
- Changing from conventional heavy-duty coolant/antifreeze to Cat ELC or ELC-1 coolant

Note: Air pockets can form in the cooling system if the cooling system is filled at a rate that is greater than 20 L (5 US gal) per minute. The maximum recommended cooling system fill rate for some smaller engine models will be less. Refer to the engine Operation and Maintenance Manual for exceptions.

After you drain the cooling system and after you refill the cooling system, operate the engine. Operate the engine without the filler cap until the coolant level stabilizes. Ensure that the coolant is maintained to the proper level.

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Extended Life Coolant

SMCS Code: 1350; 1352; 1395

Cat ELC

Caterpillar provides Cat ELC (Extended Life Coolant) for use in the following applications:

- Heavy-duty diesel engines
- Automotive applications

When Cat ELC is compared to conventional coolants, the Cat ELC anti-corrosion package is based on a different additive system. Cat ELC has been formulated with the correct amounts of additives. Superior corrosion protection is provided for all metals that are in engine cooling systems.

Cat ELC extends the service life of the coolant to 12000 service hours or 6 years. Cat ELC does not require the frequent addition of the Cat ELC Extender additive. An Extender is the only additional maintenance that is needed at 6000 service hours or one half of the Cat ELC service life.

Cat ELC is available in a 1:1 premixed cooling solution with distilled water. The premixed Cat ELC provides freeze protection to $-37\text{ }^{\circ}\text{C}$ ($-34\text{ }^{\circ}\text{F}$). The premixed Cat ELC is recommended for the initial fill of the cooling system. The premixed Cat ELC is also recommended for topping off the cooling system.

Cat ELC Concentrate is also available. Cat ELC Concentrate can be used to lower the freezing point to $-52\text{ }^{\circ}\text{C}$ ($-62\text{ }^{\circ}\text{F}$) for arctic conditions.

Containers of several sizes are available. Refer to this Special Publication, "Coolant Recommendations" article for available quantities and part numbers.

Note: Cat ELC can be used in most diesel and gasoline OEM engines. Cat ELC meets the performance requirements of "ASTM D6210" for heavy-duty low silicate antifreeze/coolants. Cat ELC also meets the performance requirements of "ASTM D3306" for automotive applications.

Commercial Extended Life Coolant

NOTICE

Cat does not warrant the quality or performance of non-Cat fluids.

In order to be used in Cat diesel engine cooling systems at the published service intervals, select a commercial extended life coolant that meets all the requirements given in Table 30 in this Special Publication.

Table 30

Technical Requirements for Commercial Extended Life Coolants	
Specifications	Cat EC-1 and "ASTM D6210"
Additional Requirements	Organic Additive Technology (OAT) based on a combination of a monocarboxylic acid and a dicarboxylic acid
	Phosphate, borate, and silicate free
	Minimum typical tolyltriazole level of 900 ppm for new coolants
	Minimum typical nitrite level of 500 ppm in new coolants"
Maintenance	One time addition of an extender at the mid-life of the coolant in order to maintain the coolant nitrite level between 300 - 600 ppm

Note: The Cat EC-1 specification describes the minimum requirements for extended life coolants.

Use an extender that is recommended by the EC-1 coolant supplier at mid-life of the coolant.

Commercial coolants that do not meet the minimum requirements defined in this Special Publication are not allowed for use in Cat engines.

Commercial extended life coolant used in Cat engines must meet all requirements given in Table 30. If the ELC does meet the requirements, the service interval listed in this Special Publication may not be used. Follow the maintenance guidelines for the coolant from the supplier of the commercial extended life coolant. Follow the Cat guidelines for the quality of water and the specified coolant change interval.

Note: Coolants must be tested against the Cat EC-1 specification requirements. Coolants that only claim to meet the performance requirements of the Cat EC-1 specification may not meet all the minimum requirements.

Maintenance Section
Extended Life Coolant Cooling System Maintenance

In order to be marketed as a product that meets Cat EC-1, all Cat EC-1 specification requirements must be met. Requirements include, but are not limited to the following:

- Physical and Chemical Properties
- Compatibility Characteristics
- Bench Testing
- Field Testing

The field test includes the use of the following requirements:

- Radiator types
- Minimum field test duration
- Minimum number of diesel engines
- Cat diesel engine models of the required minimum power rating

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Extended Life Coolant Cooling System Maintenance

SMCS Code: 1350; 1352; 1395

Proper Additions to the Cat ELC (Extended Life Coolant)

NOTICE

Use only Cat products or commercial products that have passed Cat EC-1 specification for pre-mixed or concentrated coolants.

Use only Cat ELC Extender with Cat ELC.

Do NOT use conventional SCA with Cat ELC. Mixing Cat ELC with conventional coolants and/or conventional SCA reduces the Cat ELC service life.

Do NOT mix brands or types of coolant. Do NOT mix brands or types of SCA and/or brands or types of extenders. Different brands or types may use different additive packages to meet the cooling system requirements. Different brands or types may not be compatible.

Failure to follow the recommendations can reduce cooling system component life unless appropriate corrective action is performed.

In order to maintain the correct balance between the antifreeze and the additives, maintain the recommended concentration of Cat ELC. Lowering the proportion of antifreeze lowers the proportion of additive. The coolant will not be able to protect the system from pitting, cavitation, erosion, and deposits.

During daily maintenance, use the premixed Cat ELC as a cooling system top-off. Check the specific gravity of the coolant system with the 245 - 5829 Coolant/Battery Tester/Refractometer. This tester gives readings that are immediate and accurate in both degrees Celsius and degrees Fahrenheit. Use Cat ELC Concentrate to restore the proper glycol concentration in the coolant system. Add the concentrate before the engine is exposed to freezing temperatures.

NOTICE

Do not use a conventional coolant to top-off a cooling system that is filled with Cat ELC.

Do not use conventional SCA. Only use Cat ELC Extender in cooling systems that are filled with Cat ELC.

Cat ELC Extender

Cat ELC Extender is added to the cooling system halfway through the Cat ELC service life. Treat the cooling system with Cat ELC Extender at 6000 hours or one half of the coolant service life. Refer to your machine Operation and Maintenance Manual for exceptions. Refer to the "Part Number of Coolant" table in this Special Publication, "Coolant Recommendations" article for available quantities and part numbers.

Use the formula in Table 32 to determine the proper amount of Cat ELC Extender for your cooling system. Refer to Operation and Maintenance Manual, "Refill Capacities and Recommendations" in order to determine the capacity of the cooling system.

Table 31

Formula For Adding Cat ELC Extender To Cat ELC	
$V \times 0.02 = X$	
V is the total capacity of the cooling system.	
X is the amount of Cat ELC Extender that is required.	

Table 32 is an example for using the formula that is in Table 31 . This example is based on the typical capacity of a D8R Track-Type Tractor.

Table 32

Example Of The Equation For Adding Cat ELC Extender To Cat ELC		
Total Volume of the Cooling System (V)	Multiplication Factor	Amount of Cat ELC Extender that is Required (X)
94.6 L (25.0 US gal)	× 0.02	1.9 L (0.5 US gal)

NOTICE

When using Cat ELC, do not use conventional SCAs, or, if equipped, SCA maintenance elements. In order to avoid SCA contamination of an ELC system, remove the SCA element base and plug off or bypass the coolant lines.

Cat ELC Cooling System Cleaning

Note: If the cooling system is already using Cat ELC, cleaning agents are not required at the specified coolant change interval. Cleaning agents are only required if the system has been contaminated by the addition of some other type of coolant or by cooling system damage.

Clean water is the only cleaning agent that is required when Cat ELC is drained from a properly maintained cooling system.

After the cooling system is drained and after the cooling system is refilled, operate the engine while the cooling system filler cap is removed. Operate the engine until the coolant level reaches the normal operating temperature and until the coolant level stabilizes. As needed, add the coolant mixture in order to fill the system to the proper level.

Recycling Cat ELC

Cat ELC can be recycled into conventional coolants. The drained coolant mixture can be distilled in order to remove the ethylene glycol and the water. The ethylene glycol and the water can be reused. The distilled material does not contain the additives that are classified as either Cat ELC or Cat DEAC. Consult your Cat dealer for more information. Recycled coolants should meet the most current revision level of "ASTM D6210".

Changing to Cat ELC

To change from heavy-duty coolant/antifreeze to the Cat ELC, perform the following steps:

NOTICE

Care must be taken to ensure that fluids are contained during performance of inspection, maintenance, testing, adjusting and repair of the product. Be prepared to collect the fluid with suitable containers before opening any compartment or disassembling any component containing fluids.

Refer to Special Publication, NENG2500, "Caterpillar Dealer Service Tool Catalog" and to Special Publication, PECJ0003, "Cat Shop Supplies and Tools" for tools and supplies suitable to collect and contain fluids on Cat products.

Dispose of all fluids according to applicable regulations and mandates.

1. Drain the coolant into a suitable container.
2. Dispose of the coolant according to local regulations.
3. If equipped, remove the empty SCA maintenance element and remove the element base. Plug the coolant lines or bypass the coolant lines.

NOTICE

Do not leave an empty SCA maintenance element on a system that is filled with Cat ELC.

The element housing may corrode and leak causing an engine failure.

Remove the SCA element base and plug off or bypass the coolant lines.

4. Flush the system with clean water in order to remove any debris.
 5. Use Cat Quick Flush Cooling System Cleaner for cooling systems in order to clean the system. Cat Quick Flush Cooling System Cleaner is available in various sizes. Part numbers are 4C-4609 (0.5 L (0.125 US gal)) through 4C-4613 (208.2 L (55 US gal)). Follow the instructions on the label using a 6-10% concentration of cleaner in water.
 6. Drain the cleaner into a suitable container. Flush the cooling system with clean water.
- Note:** Deposits that remain in the system may be loosened and removed by the Cat ELC.
7. In systems with heavy deposits, disconnect the hoses. Clean the deposits and debris from the hoses and the fittings. Install the hoses and tighten the hose fittings. Refer to Specifications, SENR3130, "Torque Specifications" for the proper torques. Pipe threads may also need to be cleaned and sealed. Seal the threads with 5P-3413 Pipe Sealant.

Note: Replace hoses that are cracked, soft, or that have other signs of damage. Tighten all hose clamps and fittings.

8. Fill the cooling system with clean water and operate the engine until the engine is warmed to 49 °C to 66 °C (120 °F to 151 °F).

NOTICE

Improper or incomplete rinsing of the cooling system can result in damage to copper and other metal components.

To avoid damage to the cooling system, make sure to completely flush the cooling system with clear water. Continue to flush the system until all signs of the cleaning agent are gone.

9. Drain the cooling system into a suitable container and flush the cooling system with clean water.
-

NOTICE

The cooling system cleaner must be thoroughly flushed from the cooling system. Cooling system cleaner that is left in the system will contaminate the coolant. The cleaner may also corrode the cooling system.

10. Repeat Steps 8 and 9 until the system is clean.
11. Fill the cooling system with the Cat ELC.
12. Operate the engine until the engine is warmed. While the engine is running, inspect the engine for leaks. Tighten hose clamps and connections in order to stop any leaks.
13. Attach the Special Publication, P MEP5027, "Label" to the cooling system filler for the engine in order to indicate the use of Cat ELC.

Note: Clean water is the only flushing agent that is required when Cat ELC is drained from a properly maintained cooling system.

Cat ELC Cooling System Contamination

NOTICE

Mixing Cat ELC with other products reduces the effectiveness of the Cat ELC and shortens the Cat ELC service life. Use only Cat products or commercial products that have passed the Cat EC-1 specification for premixed or concentrate coolants. Use only Cat ELC Extender with Cat ELC. Do NOT mix brands or types of coolants. Failure to follow these recommendations can result in shortened cooling system component life.

Cat ELC cooling systems can withstand contamination to a maximum of 10 percent of conventional heavy-duty coolant/antifreeze and/or SCA. The advantages of Cat ELC are reduced above 10 percent. If the contamination exceeds 10 percent of the total system capacity, perform ONE of the following procedures:

- If the cooling system contamination is caused by cooling system damage, follow the procedures under the "Changing to Cat ELC" heading. Also, follow the procedures under the "Changing to Cat ELC" heading if the engine has been operated since being contaminated with more than 10 percent conventional heavy-duty coolant/antifreeze and/or SCA. Certain types of cooling system contamination may require disassembly of the cooling system and manual cleaning of system components.
- If the cooling system is contaminated with more than 10 percent conventional heavy-duty coolant/antifreeze and/or SCA, but the engine has not been operated, drain the cooling system into a suitable container. Dispose of the coolant according to local regulations. Thoroughly flush the system with clean water. Fill the system with the Cat ELC.
- Maintain the system as a conventional DEAC (Diesel Engine Antifreeze/Coolant) or other conventional coolant. Submit a coolant sample for Level 2 S·O·S Coolant Analysis to determine the coolant condition. Maintain a 3 to 6 percent SCA concentration in the coolant. Change the coolant at the interval that is recommended for Cat DEAC or at the interval that is recommended for the conventional commercial coolants.

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Extended Life Inhibitor (ELI)

SMCS Code: 1350; 1352; 1395

Cat Extended Life Inhibitor (ELI) is water-based coolant that does not contain glycol. Cat ELI is for applications that do not require freeze protection. Exceptions are listed here. Failure to follow these recommendations can or will result in failures.

Cat ELI is a corrosion inhibitor concentrate that is mixed to approximately 7.5 % by volume with water. Cat ELI has the following characteristics:

- Based on the same organic additive technology that is used in Cat Extended Life Coolant (ELC)
- Does not contain glycol. Designed for use in applications that do not require freeze protection.
- Provides superior corrosion and cavitation protection compared to SCA mixed with water.
- Provides an extended drain interval of up to 6 years or 12,000 hours. The drain interval may be longer as determined by using Cat S·O·S coolant analysis.
- Requires little maintenance compared to conventional SCA mixed with water.

Cat ELI can replace SCA/Water coolant in engine applications that do not require freeze protection.

Exceptions for use of water-based ELI or SCA coolants are listed in this Special Publication, "Coolant Recommendations - Special Requirements Table".

Additional information is available from your Cat Dealer. Refer to Information Release Memo, PELJ1212, "Cat ELI – PERFORMANCE LIKE Cat ELC FOR APPLICATIONS NOT REQUIRING FREEZE PROTECTION". Refer to Table 33 for information about Cat ELI.

Table 33

Part Number	Container Size	Volume of Finished Coolant Produced
351-9431	3.8 L (1 US gal)	50.5 L (13.3 US gal)
351-9432	20 L (5.3 US gal)	267 L (70.5 US gal)
351-9433	208 L (55 US gal)	2773 L (733 US gal)
366-2753 ⁽¹⁾	1000 L (264 US gal)	13333 L (3523 US gal)

⁽¹⁾ NACD and LACD only

Mixing Cat ELI

The recommended water for mixing with Cat ELI concentrate is distilled or deionized water. Water must meet requirements of ASTM 1193, "Type IV Reagent Water Specification". If distilled or deionized water is not available, water should meet the "Caterpillar Minimum Acceptable Water Requirements" provided in this Special Publication.

To ensure a proper concentration, the preferred method is to mix Cat ELI concentrate with water. Then, add the mixed coolant to the engine cooling system. Add the proper amounts of water and Cat ELI into a clean container and mix thoroughly by manual stirring or mechanical agitation.

If the preferred method cannot be performed, a Cat ELI mixture can be made by adding Cat ELI concentrate directly into engine cooling system. Add good quality water until the dilution level is approximately 7.5%. Adequate mixing is attained by operating the engine for at least 30 minutes.

Appropriate mixing rates for available ELI container sizes are provided in Table 33.

After the addition of water and proper mixing, the concentration of Cat ELI can be determined using the 360-0744 digital Brix refractometer.

Changing to Cat ELI

For cooling systems previously running Cat ELC or an extended life coolant that meets Cat EC-1 requirements, drain the cooling system and flush with water. Then refill the cooling system with a mixture of 7.5% Cat ELI in water that meets the "Caterpillar Minimum Acceptable Water Requirements".

For cooling systems previously running a conventional heavy-duty coolant or a water/SCA mixture, follow the steps listed in this Special Publication, "Changing to Cat ELC". Then refill the cooling system with a mixture of 7.5% Cat ELI in water that meets the "Caterpillar Minimum Acceptable Water Requirements".

Cat ELI Maintenance

Maintenance of Cat ELI is similar to Cat ELC. A coolant sample should be submitted for S·O·S Level 2 Coolant Analysis after the first 500 hours of operation and then annually thereafter.

Cat ELC Extender should be added at the midpoint of service life (typically 6,000 hours), or as recommended by S·O·S Coolant Analysis results.

Analysis and interpretation of Cat ELI S·O·S results is similar to the analysis and interpretation of Cat ELC. There will be no glycol and glycol oxidation products, which do not apply to Cat ELI.

The concentration of a sample of in-use Cat ELI taken from the cooling system can also be determined using the 360-0744 digital Brix Refractometer.

Note: Clean water is the only flushing agent that is required when Cat ELI is drained from a properly maintained cooling system.

Mixing Cat ELI and Cat ELC

Since Cat ELI and Cat ELC are based on the same corrosion inhibitor technology, Cat ELI can be mixed with Cat ELC. Mixing may be desired when only low level of freeze protection is required. Consult your local Cat dealer to ensure proper mixing of the products to provide adequate freeze protection and corrosion protection.

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Diesel Engine Antifreeze/ Coolant (DEAC)

SMCS Code: 1350; 1352; 1395

Follow the maintenance information provided in this Special Publication, "Coolant and General Maintenance Recommendations" section.

Cat recommends using Cat DEAC (Diesel Engine Antifreeze/Coolant) for cooling systems that require a high performance conventional heavy-duty coolant/antifreeze. Cat DEAC is alkaline single-phase ethylene glycol type antifreeze that contains corrosion inhibitors and antifoam agents.

Cat DEAC is formulated with the correct amount of Cat SCA (Supplemental Coolant Additive). Do not use Cat SCA at the initial fill when Cat DEAC is used at the recommended 50 percent by volume glycol or higher concentration with recommended water.

Containers of several sizes are available. Consult your Cat dealer for the part numbers.

If concentrated Cat DEAC is used, Caterpillar recommends mixing the concentrate with distilled water or with deionized water. If distilled water or deionized water is not available, use water which has the required properties. For the water properties, see this publication, "General Coolant Information".

Note: Mix the concentrated Cat DEAC and water thoroughly prior to filling the cooling system.

SCA is added to cooling systems that use conventional coolants for one of three reasons:

- to precharge a new conventional coolant that is not fully Formulated. Cat DEAC is fully formulated and does not require SCA
- to provide corrosion protection in water/SCA cooling systems

- to recharge an in service conventional coolant on a maintenance basis to maintain proper inhibitor levels

Conventional coolants typically require SCA additions at approximately 250-300 service hours. The use of SCA helps to prevent the following conditions from occurring:

- Corrosion
- Formation of mineral deposits
- Cavitation erosion of the cylinder liners
- Foaming of the coolant

Containers of Cat SCA are available in several sizes. Refer to this Special Publication, "Conventional Coolant/Antifreeze Cooling System Maintenance" article for available quantities and part numbers.

Note: Do not exceed a 6 percent maximum concentration of SCA. Maintain a 3 to 6 percent SCA concentration in the coolant.

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Supplemental Coolant Additive

SMCS Code: 1350; 1352; 1395

Supplemental Coolant Additive (SCA) – SCA is a general term for an inhibitor package that is added to a cooling system. SCA is added for one of three reasons:

- to precharge a new coolant that is not fully formulated
- to provide corrosion protection in water/SCA cooling systems
- to recharge an in service conventional coolant on a maintenance basis to maintain proper inhibitor levels

Conventional coolants typically require SCA additions at approximately 250-300 service hours.

The use of SCA (supplemental coolant additive) helps to prevent the following conditions from occurring:

- Corrosion
- Formation of mineral deposits
- Cavitation erosion of the cylinder liners
- Foaming of the coolant

Cat DEAC (Diesel Engine Antifreeze/Coolant) is formulated with the correct level of Cat SCA. When the cooling system is initially filled with Cat DEAC, adding more Cat SCA is not necessary. To ensure that the correct amount of Cat SCA is in the cooling system, test the concentration on a scheduled basis. Testing the concentration of nitrites and silicates through the S·O·S analysis is the best indicator of the amount of SCA in the coolant.

Maintain a concentration level of nitrites in the cooling system that is between 1200 ppm (70grains/US gal) and 2400 ppm (140 grains/US gal). S·O·S coolant analysis is the preferred method to check SCA concentration. Alternatively, nitrite levels can be tested with the following tools:

- 4C-9301 nitrite level test strips, English instructions only, use with glycol-based coolants such as Cat DEAC
- 286-2578 nitrite level test strips, English, French, and Spanish instructions, use with glycol-based coolants such as Cat DEAC

For the maintenance schedule, refer to the Operation and Maintenance Manual, “Maintenance Interval Schedule” (Maintenance Section) of the specific engine.

Containers of Cat SCA are available in several sizes. Refer to this Special Publication, “Conventional Coolant/Antifreeze Cooling System Maintenance” article for available quantities and part numbers.

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Conventional Coolant/ Antifreeze Cooling System Maintenance

SMCS Code: 1350; 1352; 1395

NOTICE

Cat does not warrant the quality or performance of non-Cat fluids.

NOTICE

Use Only Approved SCAs. Conventional coolants require the maintenance addition of SCA throughout their expected life. Do NOT use an SCA with a coolant unless specifically approved by the coolant supplier for use with their coolant. It is the responsibility of the coolant manufacturer to ensure compatibility and acceptable performance.

Failure to follow the recommendations can result in shortened cooling system component life.

Cat SCA is compatible with Cat DEAC. If you use non-Cat brand conventional coolants, consult with the coolant manufacturer for information on a compatible SCA.

NOTICE

Do NOT mix brands or types of coolant. Do NOT mix brands or types of SCA and/or brands or types of extenders. Different brands or types may use different additive packages to meet the cooling system requirements. Different brands or types may not be compatible.

Failure to follow the recommendations can reduce cooling system component life unless appropriate corrective action is performed.

If non-Cat conventional coolants that meet Cat minimum published requirements are used, confirm with the coolant manufacturer before using Cat SCA that Cat SCA is acceptable for use with the coolant. Do not exceed the 6 percent maximum concentration. Check the concentration of SCA with a SCA test kit, or check the concentration of SCA with Cat S·O·S coolant analysis.

Cat engine cooling systems should be tested at 250 hour intervals or at the PM Level 1 intervals for the concentration of SCA (Supplemental Coolant Additive).

Note: Acceptable conventional heavy-duty coolant/antifreeze of all types REQUIRE periodic additions of SCA.

Follow the maintenance information provided in this Special Publication, “Coolant and General Maintenance Recommendations” section.

Note: Specific engine applications may require maintenance practices to be periodically evaluated to maintain the engine cooling system properly.

The availability of part numbers will vary from one region to another region.

Do not exceed the 6 percent maximum concentration. Check the concentration of SCA with a SCA test kit, or check the concentration of SCA with Cat S·O·S coolant analysis.

Adding the SCA to Pure Water or a Pure Water/Glycol Mixture at Initial Fill

For initial fill, Cat SCA added to pure water provides corrosion protection of the system. Ensure that the water meets quality requirements detailed in the Table “Cat Minimum Acceptable Water Requirements”, found in this Special Publication, “General Coolant Information”. Also, ensure that the water or water/glycol mixture have not had additives previously added. Use the equation in Table 34 to determine the volume of the Cat SCA that is needed. The initial concentration of the SCA is recommended to be 7 percent. Once the coolant has been in service, maintain the SCA to a 3 to 6 percent range. Refer to the maintenance section for details.

Maintenance Section
Conventional Coolant/Antifreeze Cooling System Maintenance

Table 34

Equation For Adding The Cat SCA To Water At The Initial Fill
$V \times 0.07 = X$
V is the total volume of the cooling system.
X is the amount of Cat SCA that is required.

Table 35 is an example for using the equation that is in Table 34 .

Table 35

Example Of The Equation For Adding The Cat SCA To Water At The Initial Fill		
Total Volume of the Cooling System (V)	Multiplication Factor	Amount of Cat SCA that is Required (X)
946 L (250 US gal)	× 0.07	66 L (18 US gal)

Adding the SCA to Conventional Coolant/Antifreeze For Maintenance

Conventional heavy-duty coolant/antifreeze of all types REQUIRE periodic additions of a supplemental coolant additive.

Test the coolant/antifreeze periodically for the concentration of SCA. For the interval, see the Operation and Maintenance Manual, "Maintenance Interval Schedule", for your engine. SCA test kits are available from your Cat dealer. Test the concentration of SCA or submit a coolant sample to your Cat dealer. Refer to this Special Publication, "S·O·S Services Coolant Analysis", article.

Additions of SCA are based on the results of the test or based on the results of the coolant analysis. The size of the cooling system determines the amount of SCA that is needed.

Table 36

Equation for the Addition of Cat SCA To Water For Maintenance
$V \times 0.023 = X$
V is the total volume of the cooling system.
X is the amount of Cat SCA that is required.

Table 37 is an example for using the equation that is in Table 36 .

Table 37

Example of the Equation for the Addition of Cat SCA To Water For Maintenance		
Total Volume of the Cooling System (V)	Multiplication Factor	Amount of Cat SCA that is Required (X)
946 L (250 US gal)	× 0.023	22 L (6 US gal)

Note: Specific engine applications may require maintenance practices to be periodically evaluated to maintain the engine cooling system properly.

Cleaning the System of Heavy-Duty Coolant/Antifreeze

Before Cat SCA can be effective, the cooling system must be free from rust, scale, and other deposits. Preventive cleaning helps avoid downtime caused by expensive out-of-service cleaning required for extremely dirty and neglected cooling systems.

Cat Cooling System Cleaners

- Dissolves or depresses mineral scales, corrosion products, light oil contaminations, and sludges
- Cleans the cooling system after used coolant is drained or before the cooling system is filled with new coolant
- Cleans the cooling system whenever the coolant is contaminated or whenever the coolant is foaming
- The "Standard" version of the Cat Cooling System Cleaners clean the cooling system while still in service.
- Reduces downtime and cleaning costs
- Helps avoid costly repairs from pitting and other internal problems caused by improper cooling system maintenance
- Can be used with glycol-based antifreeze
- For the recommended service interval, refer to the Operation and Maintenance Manual, "Maintenance Interval Schedule" for your engine.

Cat Standard Cooling System Cleaners are designed to clean the cooling system of harmful scale and corrosion without removing the engine from service. The cleaners, both "Standard" and "Quick Flush" can be used in all Cat engine cooling systems. Consult your Cat dealer for part numbers.

Note: These cleaners must not be used in systems that have been neglected or that have heavy scale buildup. These systems require a stronger commercial solvent that is available from local distributors.

Prior to performing a cleaning of the cooling system, take a 1-liter (1-quart) sample of coolant from the engine while in operation into a clear container. Take the sample shortly after start-up while the coolant is not yet hot. The coolant should be adequately mixed by the water pump. Allow the sample to sit for 2 hours. If a visible oil layer is present, neither the Standard cleaners nor Quick Flush cleaner will be fully effective. First, drain the coolant and then perform the procedure given below (using non-foaming dish detergent), followed by the procedure for the Quick Flush cleaner.

Procedure for Cleaning an Oil Contaminated Cooling System

1. Drain the cooling system.
2. Fill the cooling system with acceptable quality water.

Note: Refer to the “Caterpillar Minimum Acceptable Water Quality Requirements” in this Special Publication.

3. Start the engine and run the engine until the thermostat opens.
4. Add a non-foaming detergent to equal approximately 2-3% cooling system capacity.

Note: Pre-dissolve the detergent in approximately 19 L (5 US gallons) of acceptable quality water. Add this mixture directly to the cooling system and top off the cooling system with water.

5. Run the engine for at least 30 minutes. Drain the cooling system.
6. Remove a small sample of the detergent solution from the cooling system. Allow the solution to sit for at least 30 minutes and check for signs of a visible oil layer on top. If oil is still present, repeat the procedure.

Note: Corrosion of the metal can occur if the detergent solution is left in the cooling system for longer than 1 hour.

7. Flush the cooling system, if there is no visible oil layer in the solution. Fill the cooling system with acceptable quality water. Run the engine for 20 minutes and then drain the water.

8. Perform the cleaning procedure found in this Special Publication for “Cat Cooling System Cleaner - Quick Flush”, if additional removal of scale, rust, and inhibitor deposits from the previous coolant is needed.

9. If additional cleaning is not needed, refill the cooling system with new coolant.

Table 38

Cat Cooling System Cleaner for use with Quick Flush Method	
Cleaner part number	Size of Container
4C-4609	0.5 L (0.125 US gal)
4C-4610	1 L (0.25 US gal)
4C-4611	3.8 L (1 US gal)
4C-4612	19 L (5 US gal)
4C-4613	208 L (55 US gal)

Procedure for using Cat Cooling System Cleaner - Quick Flush

1. Drain the cooling system.
2. Refill the cooling system to 90-94% capacity with acceptable quality water.

Note: Refer to the “Caterpillar Minimum Acceptable Water Quality Requirements” as found in this Special Publication.

3. Top off the cooling system with Cat Cooling System Cleaner - Quick Flush cleaner so that the solution is 6-10% cleaner.
4. Run the engine for 1.5 hours.
5. After allowing adequate time for the system to cool, drain the cooling system.

Note: Corrosion of the metals can occur if the Quick Flush cleaning solution is in the cooling system for longer than 2 hours.

6. Flush the cooling system.
 - a. Fill the cooling system with acceptable quality water.
 - b. Run the engine for 20 minutes.
 - c. Drain the water.

7. Refill the cooling system with new coolant.

Table 39

Cat Cooling System Cleaner - Standard		
Part Number	Volume	Availability
6V-4511	1.89 L (0.5 US gal)	North and South America

Procedure for using Cat Cooling System Cleaner - Standard

1. If necessary, drain off coolant from the cooling system for the amount of the cleaner.
2. Add 1 bottle (1.89 L (0.5 US gal)) of Cat Cooling System Cleaner - Standard for each 30 L of cooling system capacity. Add the cleaner directly to the coolant.
3. Run the engine as usual.
4. After 30 days, drain the cooling system.
5. Flush the cooling system.
 - a. Fill the cooling system with acceptable quality water.
 - b. Run the engine for 20 minutes.
 - c. Drain the water.
6. Refill the cooling system with new coolant.

Recycling Cat DEAC

Cat DEAC can be recycled. The drained coolant mixture can be distilled to separate the ethylene glycol and water. The ethylene glycol and the water can be reused. The distilled material does not contain the additives that are classified as either Cat ELC or Cat DEAC. Consult your Cat dealer for more information.

When recycled coolants are used, use only coolants that have been recycled from extended life, heavy-duty, or automotive coolants. Use coolants that were originally manufactured from virgin ethylene or propylene glycol.

Recycled coolants should meet the latest revision of "ASTM D6210".

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Commercial Heavy-Duty Coolant/Antifreeze and SCA (Supplemental Coolant Additive)

SMCS Code: 1350; 1352; 1395

NOTICE

Cat does not warrant the quality or performance of non-Cat fluids.

NOTICE

Do NOT mix brands or types of SCA. Do NOT mix SCAs and extenders.

Failure to follow the recommendations can result in shortened cooling system component life.

NOTICE

Use Only Approved SCAs. Conventional coolants require the maintenance addition of SCA throughout their expected life. Do NOT use an SCA with a coolant unless specifically approved by the coolant supplier for use with their coolant. It is the responsibility of the coolant manufacturer to ensure compatibility and acceptable performance.

Failure to follow the recommendations can result in shortened cooling system component life.

Follow the maintenance information provided in the "Coolant and General Maintenance Recommendations" section in this Special Publication.

Select a commercial diesel engine antifreeze coolant that meets all the requirements given in Table 40. The table contains the requirements for coolant to meet the published service intervals.

The provided requirements are applicable to finished coolants and not for the concentrates. When concentrated coolant/antifreeze is mixed, Cat recommends mixing the concentrate with distilled water or with deionized water. If distilled water or deionized water is not available, water which has the required properties may be used. For the water properties, refer to this Special Publication, "General Coolant Information" article.

Coolant/antifreezes for heavy-duty applications that meet “ASTM D6210” do not require treatment with SCA at the initial fill. Use the recommended 1:1 or higher concentration with recommended water. Treatment with SCA is required on a maintenance basis.

The SCA manufacturer is responsible for ensuring the SCA is compatible with water meeting the “Caterpillar Minimum Acceptable Water Quality Requirements” as found in this Special Publication, and “ASTM D6210-08, Table X1.1”. The coolant manufacturer and the SCA manufacturer are responsible to ensure that the products will not cause cooling system harm.

Do not mix brands or types of coolants with different brands or types of SCA or extender.

If using non Cat coolants, refer to the coolant manufacturer for information on a compatible SCA.

Treat the compatible commercial coolant with 3 to 6 percent Cat SCA by volume. Maintain a 3 to 6 percent concentration level of SCA in the cooling system. For more information, refer to this Special Publication, “Conventional Coolant/Antifreeze Cooling System Maintenance” article.

Table 40

Technical Requirements for Commercial Diesel Engine Antifreeze Coolants	
Specifications	ASTM D6210-08
Additional Requirements	Silicon: 100 ppm minimum to 275 ppm maximum Nitrites: maintained at 1200ppm (70 grains/US gal) minimum to 2400 ppm (140 grains/US gal) maximum Cat SCA at 3 to 6 percent (if Cat SCA is added)
Maintenance	ASTM D6210-08 Add compatible SCA at maintenance intervals Clean and flush the cooling system at drain intervals

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Water/SCA (Supplemental Coolant Additive)

SMCS Code: 1350; 1352; 1395

Cat SCA can be added to water of the recommended quality to form a Water/SCA finished coolant. SCA/Water finished coolant is glycol free. SCA/Water finished coolant is for engine applications that do not require freeze protection.

Exceptions are listed in this Special Publication, “Coolant Recommendations - Special Requirements”. Failure to follow these recommendations can or will result in failures.

NOTICE

Never use water alone as a coolant. Water alone is corrosive at engine operating temperatures. In addition, water alone does not provide adequate protection against boiling or freezing.

In engine cooling systems that use water alone, Caterpillar recommends the use of Cat SCA. Cat SCA helps to prevent the following conditions from occurring:

- Corrosion
- Formation of mineral deposits
- Cavitation erosion of the cylinder liner
- Foaming of the coolant

If Cat SCA is not used, select a fully formulated commercial SCA. The commercial SCA must provide a minimum of 2400 mg/L or 2400 ppm (140 grains/US gal) of nitrites in the final coolant mixture.

The quality of the water is an important factor in this type of cooling system. Distilled water or deionized water is recommended for use in cooling systems. If distilled water or deionized water is not available, use water that meets or exceeds the minimum requirements that are listed in the table for recommended water properties in this Special Publication, "General Coolant Information" topic.

A cooling system that uses a mixture of SCA and water only needs more SCA. The SCA concentration in a cooling system that uses SCA and water should be 6 to 8 percent by volume.

Maintain the Cat SCA in the same way as you would maintain a cooling system that uses heavy-duty coolant/antifreeze. Adjust the maintenance for the amount of Cat SCA additions.

Adding the Cat SCA to Water at the Initial Fill

Use the equation that is in this Special Publication, "Conventional Coolant/Antifreeze Cooling System Maintenance" to determine the amount of Cat SCA that is required at the initial fill. This equation is for a mixture of only Cat SCA and water.

Adding the Cat SCA to Water for Maintenance

For the recommended service interval, refer to the Operation and Maintenance Manual, "Maintenance Interval Schedule" for your engine.

Submit a coolant sample to your Cat dealer. See this Special Publication, "S·O·S Services Coolant Analysis" topic.

Additions of Cat SCA are based on the results of the coolant analysis. The size of the cooling system determines the amount of Cat SCA that is required.

Use the equation that is in this Special Publication, "Conventional Coolant/Antifreeze Cooling System Maintenance" to determine the amount of Cat SCA that is required for maintenance, if necessary:

Note: Specific engine applications may require maintenance practices to be periodically evaluated in order to maintain properly the engine cooling system.

SCA and part numbers are available from your Cat dealer.

i03601599

S·O·S Services Coolant Analysis

SMCS Code: 1350; 1395; 7542

Testing the engine coolant is important to ensure that the engine is protected from internal cavitation and corrosion. The analysis also tests the ability of the coolant to protect the engine from boiling and freezing. S·O·S coolant analysis can be done at your Caterpillar dealer. Caterpillar S·O·S coolant analysis is the best way to monitor the condition of your coolant and your cooling system. S·O·S coolant analysis is a program that is based on periodic samples.

NOTICE

Do not use the same vacuum sampling pump for extracting oil samples that is used for extracting coolant samples.

A small residue of either type sample may remain in the pump and may cause a false positive analysis for the sample being taken.

Always use a separate pump for oil sampling and a separate pump for coolant sampling.

Failure to do so may cause a false analysis which could lead to customer and dealer concerns.

New Systems, Refilled Systems, and Converted Systems

Perform an S·O·S coolant analysis (Level 2) at the following maintenance intervals.

- Every Year
- Initial 500 service hours

Perform this analysis at the interval that occurs first for new systems, for refilled systems, or for converted systems that use Cat ELC (Extended Life Coolant) or use Cat DEAC (Diesel Engine Antifreeze/Coolant). This 500 hour check will also check for any residual cleaner that may have contaminated the system.

Recommended Interval for S·O·S Services Coolant Sample

The following table contains the recommended sampling interval for all coolants that meet Cat EC-1 (Engine Coolant specification - 1). This is also the recommended sampling interval for all conventional heavy-duty coolant/antifreeze.

The Level 2 Coolant Analysis should be performed if a problem is suspected or identified.

Table 41

Recommended Interval		
Type of Coolant	Level 1	Level 2
Cat DEAC and Conventional Heavy-Duty Coolants	Every 250 hours	Yearly
Cat ELC and Commercial EC-1 coolants	Optional	Yearly

Note: Check the SCA (Supplemental Coolant Additive) of the conventional coolant at every oil change or at every 250 hours. Perform this check at the interval that occurs first.

S·O·S Services Coolant Analysis (Level 1)

A coolant analysis (Level 1) is a test of the properties of the coolant.

The following properties of the coolant are tested:

- Glycol concentration for freeze protection and boil protection
- Ability to protect from erosion and corrosion
- pH
- Conductivity
- Visual analysis
- Odor analysis

The results are reported, and appropriate recommendations are made.

S·O·S Services Coolant Analysis (Level 2)

A coolant analysis (Level 2) is a comprehensive chemical evaluation of the coolant. This analysis is also a check of the overall condition of the cooling system.

The S·O·S coolant analysis (Level 2) has the following features:

- Full coolant analysis (Level 1)
- Identification of metal corrosion and of contaminants

- Identification of buildup of the impurities that cause corrosion
- Identification of buildup of the impurities that cause scaling
- Determination of the possibility of electrolysis within the cooling system of the engine

The results are reported, and appropriate recommendations are made.

For more information on S·O·S coolant analysis, consult your Caterpillar dealer.

Exhaust Aftertreatment Fluids Specifications

i07560821

Diesel Exhaust Fluid (DEF) (For Use in SCR-equipped engines)

SMCS Code: 108K

General Information

Diesel Exhaust Fluid (DEF) is a liquid that is injected into the exhaust system of engines equipped with Selective Catalytic Reduction (SCR) systems. SCR reduces emissions of nitrogen oxides (NOx) in diesel engine exhaust.

Diesel Exhaust Fluid (DEF) is available in many brands, including those brands that carry the AdBlue or API certification. DEF is also generically referred to as urea.

In engines equipped with SCR emissions reduction system, DEF is injected in controlled amounts into the engine exhaust stream. At the elevated exhaust temperature, urea in DEF is converted to ammonia. The ammonia chemically reacts with NOx in diesel exhaust in the presence of the SCR catalyst. The reaction converts NOx into harmless nitrogen (N₂) gas and water vapor (H₂O).

Note: Follow all applicable industry standards and all applicable governmental, environmental, safety guidelines, practices, regulations, and mandates.

Note: These general recommendations and guidelines concerning maintenance and care of DEF and DEF storage systems are not intended to be all inclusive. Discuss proper DEF safety, health, handling, and maintenance practices with your DEF supplier. Use of these general recommendations and guidelines does not lessen the responsibility of the engine owner and/or DEF supplier to follow all industry standard practices for DEF storage and for DEF handling.

DEF Recommendations for SCR Aftertreatment Systems

For use in Cat engines, DEF must meet all the requirements defined by the "ISO 22241-1" standard.

The caps of DEF tanks are typically blue as recommended by the "ISO 22241-4" Standard. Fill DEF only in clearly marked DEF tanks that have the blue cap.

Caterpillar recommends the use of DEF available through the Cat parts ordering system for use in Cat engines equipped with SCR systems. Refer to Table 42 for part number information:

Table 42

Cat Part Number (32.5% Urea)	Container Size
350-8733	2.5 gal bottle
350-8734	1000-L tote

In North America, commercial DEF that is API approved and meets all the requirements defined in "ISO 22241-1" may be used in Cat engines that are equipped with SCR systems.

Outside of North America, commercial DEF that meets all requirements defined in "ISO 22241-1" may be used in Cat engines that are equipped with SCR systems.

The supplier should provide documentation to prove that the DEF is compliant with the requirements of "ISO 22241-1".

NOTICE

Cat does not warrant the quality or performance of non-Cat fluids.

NOTICE

Do not use agriculture grade urea solutions. Do not use any fluids that do not meet "ISO 22241-1" Requirements in SCR emissions reduction systems. Use of these fluids can result in numerous problems including damage to SCR equipment and a reduction in NOx conversion efficiency.

DEF is a solution of solid urea that is dissolved in deionized water to produce a final concentration of 32.5% urea. Most SCR systems are designed to operate only on DEF concentration of 32.5 percent. DEF solution of 32.5% urea has the lowest attainable freeze point of -11.5° C (11.3° F). DEF concentrations that are higher or lower than 32.5% have higher freeze points. DEF dosing systems and "ISO 22241-1" specifications are designed for a solution that is approximately 32.5%.

Cat offers refractometers that can be used to measure DEF concentration. Refer to Table 43 for the part numbers. Follow the instructions provided with the instruments.

Table 43

Cat DEF Refractometers		
Refractometer Part Numbers	360-0774	Digital display, easy to use, and multifunctional (DEF, coolant, battery fluid, and more)

(continued)

(Table 43, contd)

	431-7087	Analog, specific to DEF, and requires a multi-step test procedure
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DEF Guidelines

DEF solution is typically colorless and clear. Changes to color or clarity are indicators of quality issues. Quality of DEF can degrade when stored and handled inappropriately or if DEF is not protected from contamination. Details are provided below.

If quality issues are suspected, testing of DEF should focus on urea percentage, alkalinity as NH₃ and biuret content. DEF that does not pass all these tests or that is no longer clear should not be used.

Note: Caterpillar strongly recommends that customers purchase the pre-mixed DEF urea solution from a reputable supplier. The DEF must satisfy all the specifications of quality given in this chapter of this Special Publication. Urea solutions that are not made of urea and water of the appropriate quality and cleanliness may damage the SCR system. Poor or questionable quality DEF can lead to additional repair and maintenance costs to the customer. Cat warranties do not cover failures caused by or related to use of out of specification urea solutions in Tier 4 Stage IIIB MLIT Step 4 products equipped with SCR systems.

Materials compatibility

DEF is corrosive. Due to the corrosion caused, DEF must be stored in tanks constructed of approved materials. Recommended storage materials:

Stainless Steels:

- 304 (S30400)
- 304L (S30403)
- 316 (S31600)
- 316L (S31603)

Alloys and metals:

- Chromium Nickel (CrNi)
- Chromium Nickel Molybdenum (CrNiMo)
- Titanium

Non-metallic materials:

- Polyethylene
- Polypropylene
- Polyisobutylene

- Teflon (PFA)
- Polyfluoroethylene (PFE)
- Polyvinylidene fluoride (PVDF)
- Polytetrafluoroethylene (PTFE)

Materials NOT compatible with DEF solutions include aluminum, copper, copper alloys, magnesium, zinc, nickel coatings, silver, and carbon steel and solders containing any of the above. Unexpected reactions may occur if DEF solutions come in contact with any non-compatible material or unknown materials.

Bulk storage

Follow all local regulations covering bulk storage tanks. Follow proper tank construction guidelines. Tank volume typically should be 110% of planned capacity. Appropriately vent indoor tanks. Plan for control of overflow of the tank. Heat tanks that dispense DEF in cold climates.

Bulk tank breathers should be fitted with filtration to keep airborne debris from entering the tank. Desiccant breathers should not be used because water will be absorbed, which potentially can alter DEF concentration.

Handling

Follow all local regulations covering transport and handling. DEF transport temperature is recommended to be -5° C (23° F) to 25° C (77° F). All transfer equipment and intermediate containers should be used exclusively for DEF. Containers should not be reused for any other fluids. Ensure that transfer equipment is made from DEF-compatible materials. Recommended material for hoses and other non-metallic transfer equipment include:

- Nitrile Rubber (NBR)
- Fluoroelastomer (FKM)
- Ethylene Propylene Diene Monomer (EPDM)

The condition of hoses and other nonmetallic items that are used with DEF should be monitored for signs of degradation. DEF leaks are easily recognizable by white urea crystals that accumulate at the site of the leak. Solid urea can be corrosive to galvanized or unalloyed steel, aluminum, copper, and brass. Leaks should be repaired immediately to avoid damage to surrounding hardware.

Cleanliness

Contaminants can degrade the quality and life of DEF. The recommended DEF cleanliness target as dispensed into the machine or engine fill tank is ISO 18/16/13. Refer to the Contamination Control Chapter in this Special Publication.

Maintenance Section
For Use in SCR-equipped engines

Filtering DEF is recommended when dispensed into the DEF tank to achieve the recommended cleanliness targets. DEF filters should be compatible with DEF and should be used exclusively with DEF. Check with the filter supplier to confirm compatibility with DEF before using. Mesh type filters using compatible metals, such as stainless steel, can be used. Paper (cellulose) media and some synthetic filter media are not recommended because of degradation during use. The filter size must be appropriate for the DEF pump design, flow rate, expected pressures and required filter life. Refer to Table 44 below for filtration requirements for Cat engines.

For large machine engines including 3500 series and C175 engine models, filtration of DEF as it is dispensed from bulk tank is recommended to support the durability designed into the SCR system. Filters should be located between the bulk DEF tank and the ground level DEF receiver nozzle.

Note that Cat Diesel Exhaust Fluid Filter group 491-6779, 40 microns efficiency and Beta value 75 can be used to filter DEF when applicable. Refer to your local Cat dealer for availability.

Care should be taken when dispensing DEF. Spills should be cleaned immediately. Machine or engine surfaces should be wiped clean and rinsed with water. Caution should be used when dispensing DEF near an engine that has recently been running.

Note: Spilling DEF onto hot components may cause the release of ammonia vapors. Do not breathe ammonia vapors. Do not clean up any spills with bleach.

Table 44

DEF Filtration Requirements For Bulk Tanks in Specific Applications		
DEF System	Filter Requirements ⁽¹⁾	Filter location
All Cat engines except those given below in this Table.	Recommended: ≤ 5 microns (µm), Beta value ≥ 1000 Required: ≤ 10 microns (µm), Beta value ≥ 1000	Inlet to DEF Pump Electronic Tank Unit (PETU)
Airless 3500 series and C175 engine models Machine engines (Fast or conventional fill)		
Airless Marine applications		
Air Assisted, Marine applications	≤ 40 microns (µm), Beta value ≥ 1000	Inlet to DEF Dosing Cabinet
Air Assisted, Locomotive and Electric Power Generation applications		

⁽¹⁾ Refer to Caterpillar publication PELJ0133, "Filters, Use of Micron Ratings in the Filter Industry" for clarification of Beta values and filter efficiency

Stability

DEF fluid is stable when stored and handled properly. The quality of DEF rapidly degrades when stored at high temperatures. The ideal storage temperature for DEF is between -9°C (15.8°F) and 25°C (77°F). DEF that is stored above 35°C (95°F) for longer than 1 month must be tested before use. Testing should evaluate Urea Percentage, Alkalinity as NH_3 and Biuret content.

The length of storage of DEF is listed in the following table:

Table 45

Storage Temperature	Expected DEF Life
Below 25°C (77°F)	18 months
25°C (77°F) to 30°C (86°F)	12 months
30°C (86°F) to 35°C (95°F)	6 months
Above 35°C (95°F)	test quality before use

Refer to "ISO 22241" document series for more information about DEF quality control.

Note: Dispose of all fluids according to applicable regulations and mandates.

DEF/Urea Solution Recommendations for Marine Engines

The US has adopted/approved NOx Emissions Control Area (ECA) regulations. Per ECAs, vessels that are 2016 and later models, or vessels that are modified to 2016 models, are required to meet Tier III NOx standards. These engines may require the use of Diesel Exhaust Fluid (DEF) and other urea solutions for engines equipped with Selective Catalytic Reduction (SCR) systems. If required, Cat marine engines are designed to operate on DEF of urea concentrations of 32.5 percent (by weight) or 40 percent (by weight). The crystallization temperature of 40 percent urea solution is 0°C (32°F). If urea solution ambient temperatures are routinely below 5°C (41°F) and supplemental heat is not applied to urea storage, then 32.5 percent solution should be used and maintained at a temperature above -0°C (14°F). Urea solutions should be maintained above the specified freezing temperature. Consult the urea supplier and follow the guidelines provided in this article for handling and recommendations.

Table 46

Characteristics for Urea Solutions			
Property	Unit	DEF 32.5 percent	Urea Solution 40 percent ⁽¹⁾
Urea content		32.5 percent ⁽²⁾	40 percent ⁽³⁾
Alkalinity as NH_3	Percent	0.2	0.2

Vessels that are traveling internationally and have on/off NOx controls that allow the vessels to meet ECA regulations must enable NOx controls prior to entering the ECA. For US flagged vessels, the SCR must be activated and deactivated automatically based on input from the Global Positioning System. For US flagged vessels, on/off NOx controls are allowed on engines > 30 liters/cylinder and are not allowed on engines < 30 liters/cylinder unless installed on a vessel with propulsion engines > 30 liters/cylinder. Otherwise the NOx control systems on Category 1 and 2 engines must always be on. Foreign destinations should be reviewed for supply of ULSD fuel and DEF prior to departure. Exemptions for ULSD or DEF use due to fluid unavailability per 40 CFR part 1042.650(a) by US flagged vessels operating outside of US waters may be requested from the US Environmental Protection Agency (EPA). The EPA can be contacted at the following address:

complianceinfo@epa.gov

When used in marine engines, DEF of 32.5 percent urea concentration must meet all the guidelines and quality recommendations given in this Chapter.

When used in marine engines, urea solution of 40 percent urea concentration must follow all the DEF guidelines and quality recommendations given in this chapter and must meet the characteristics listed in Table 46 for 40 percent concentration. The supplier should provide documentation to prove that the urea solution is compliant with the characteristics published in Table 46 .

Refer to your engine Operation and Maintenance Manual to determine the concentration of urea solution allowed in your engine.

NOTICE

Cat does not warrant the quality or performance of non-Cat fluids and greases.

General Characteristics of DEF

For detailed information on the requirements and characteristics of DEF, refer "ISO 22241". For a quick reference, typical characteristics of DEF are given in Table 46 .

(continued)

Maintenance Section
For Use in SCR-equipped engines

(Table 46, contd)

Characteristics for Urea Solutions			
Density at 20° C (68° F)	g/L	1.087 - 1.093 ⁽⁴⁾	1.108 - 1.114 ⁽⁵⁾
Refractive Index at 25° C (77° F)		1.381 - 1.384 ⁽⁶⁾	1.394-1.397 ⁽⁷⁾
Biuret	Percent	0.3 max	
Aldehydes	mg/kg	5 max	
Insoluble Matter	mg/kg	20 max	
Aluminum	mg/kg	0.5 max	
Calcium	mg/kg	0.5 max	
Chromium	mg/kg	0.2 max	
Copper	mg/kg	0.2 max	
Iron	mg/kg	0.5 max	
Magnesium	mg/kg	0.5 max	
Nickel	mg/kg	0.2 max	
Phosphate (PO ₄)	mg/kg	0.5 max	
Potassium	mg/kg	0.5 max	
Sodium	mg/kg	0.5 max	
Zinc	mg/kg	0.2 max	

(1) For use in marine engines only

(2) Acceptable range is 31.8 - 33.2 percent

(3) Acceptable range is 39-41 percent

(4) Target value is 1.090 g/L

(5) Target value is 1.112

(6) Target value is 1.382

(7) Target value is 1.3956

Contamination Control

i06969844

Contamination Control

SMCS Code: 1280; 1348; 3080; 5095; 7581

Defining Contamination

Contamination is defined as the presence of unwanted foreign substances in fluid systems or fluid wetted parts. Contamination alters the properties of fluids, causes damage of fluid systems, and prevents systems and components from attaining the desired reliability and durability. Contamination is the primary cause of fluid system failures.

Contaminants include a wide variety of unwanted substances including but not limited to the following:

- Foreign and abrasive substances such as wear particles, fibers, dirt, and dust
- Chemical substances such as products of combustion that are suspended in the fluids
- Cross contamination of water, coolant, oil, and fuel
- Biological micro-organisms such as algae or fungi
- Physical/chemical contaminants such as products of oxidation and heat

Some contaminants are generated within the fluid system due to the normal operation of the system. Contaminants may be drawn into the system from the outside environment or contaminated fill fluids or improper maintenance and repair practices.

Particle contaminants are visible to the naked eye if the particles are approximately 40 μm (microns) and larger while smaller particles are not visible. Particle contaminants can cause damage even if the particles are not visible to the naked eye. The critical particle size for wear particles in a modern diesel engine fuel system is 4 μm .

Contaminants of all types can be controlled by following contamination control practices and using appropriate filtration. Refer to your Operation and Maintenance Manual and to your local Cat dealer for recommendations.

Controlling contamination is especially important for current machine systems. Current machine systems such as hydraulic systems and fuel injection systems are designed with close tolerances and operate at high pressures for enhanced performance. These design improvements emphasize the importance of higher performing fluids, enhanced fluid filtration, and greatly improved fluid cleanliness levels.

Measuring Cleanliness

Fluid cleanliness can be measured by taking fluid samples from various machine compartments. Your Cat dealer can analyze the samples. Particle contaminants are typically measured by particle counters. Chemical contaminants can be measured by specific analysis techniques such as oxidation, water, or soot tests. Some chemical contaminants, such as water in fuel, can interfere with the particle counters and can be counted as particles. Refer to your Cat S·O·S lab or to your Cat dealer for more information.

The number of particles in fluids is expressed in "ISO (International Organization for Standardization)" ratings. "ISO 4406" Standard classifies fluid cleanliness by the number and size of particles in 1 milliliter of fluid. "ISO 4406" Standard measures particle size in μm (microns) and reports the resulting count in three code ranges X, Y & Z. The three code range defines the size and distribution of particles in 1 milliliter of fluid:

- The first code range, X represents the number of particles equal to or larger than 4 μm per milliliter of fluid.
- The second code range, Y represents the number of particles equal to or larger than 6 μm per milliliter of fluid.
- The third code range, Z represents the number of particles equal to or larger than 14 μm per milliliter of fluid.

An example of an "ISO 4406" particle count is 18/16/13. Cat "ISO" cleanliness recommendations are expressed as two or three codes, depending on the machine system. The three code range follows "ISO 4406" definitions and is used for liquid fuels such as diesel and gasoline. The two code system, example "ISO -/16/13", is used for certain lubricant systems. In the two code system, the first number is the number of particles equal to or larger than 4 μm per milliliter of fluid. This number is not required and may be represented by a dash (-). The second number (Y) and the third number (Z) follow "ISO 4406" definitions. Cat reports the Y and Z codes for lubricating oils to keep consistency with older data and reports.

An example of the particle size and distribution of the "ISO 4406" codes is given in Table 47 .

Table 47

ISO 4406 Code	Number of particles in 1 milliliter of fluid		
	4µm and up	6µm and up	14µm and up
"ISO 18/16/13"	1300 - 2500	320 - 640	40 - 80
"ISO 21/19/17"	10000 - 20000	2500 - 5000	80 - 160

Note: Several factors affect the results of particle counts. The factors include the cleanliness of the equipment used to obtain the sample, sample techniques, the cleanliness, and type of sample container, particle counter accuracy (calibration, maintenance, and process), and the environment where the sample is procured. Samples should be taken at representative locations in the fluid circulation system or the fluid distribution system when possible. The sample should be protected adequately from contamination during transport to the lab for analysis.

In addition, particle counters may count water droplets and air bubbles as particulate contamination.

Note: American Society for Testing and Measurement has developed "ASTM D7619" "Standard Test Method for Sizing and Counting Particles in Light and Middle Distillate Fuels, by Automatic Particle Counter". This test procedure was developed in 2010 to count and measure the size of dispersed dirt particles, water droplets, and other particles in 1-D and 2-D diesel fuels when the specified particle counter is used. "ASTM D7619" is also applicable to biodiesel fuels.

Cleanliness Standards for Machine Systems

Cat recommends that machine systems be maintained at the factory defined fluid cleanliness targets.

Cat has established minimum fluid cleanliness targets for fuels and fill oils and for machine roll-off. Fluids filled into the machine or engine fill tanks are recommended to be at the target levels provided in Table 48 or cleaner. Cleanliness targets for applicable machine component systems are referred to as "Roll-off". Roll-off is defined as the cleanliness specification of the fluid that is to be obtained before the machine returns to work after maintenance and or system invasion repair. When system fill fluids and Roll-off are maintained at or cleaner than the "ISO" cleanliness targets, contamination-related effects will be reduced.

Table 48

Cat Recommended Fluid Cleanliness Targets ⁽¹⁾		
Cat Recommended Cleanliness Targets for Fluids Dispensed into Machine or Engine Fill tanks	Fill oils ⁽²⁾⁽³⁾	ISO -/16/13
	Dispensed fuels	ISO 18/16/13
	Dispensed DEF	ISO 18/16/13
Cat Recommended Machine Roll-off Cleanliness Targets	Hydraulic systems (Implement & Steering)	ISO -/18/15
	Electronic Transmissions	ISO -/18/15
	Mechanical Transmissions	ISO -/21/17
	Differentials, Wheels, and Axles ⁽⁴⁾	ISO -/18/15

- (1) The fluids should meet or exceed the cleanliness requirements of the listed ISO levels.
- (2) For engine oils optical particle counters may not be effective. Instead filter the oil prior to dispensing into the engine tank, use engine oil filters of 12 micron absolute efficiency and ensure that the oil temperature is 20° C (68° F) or higher. Refer to the details given in this article.
- (3) For transmission, gear, differential and axle oils, additives and the viscosity of the oil may interfere with particle counting. An alternative is to use adequate filtration to ensure clean oils prior to filling in the machine compartment.
- (4) This cleanliness standard applies only to the Series 700 family of rigid frame trucks, 777 size and larger.

The "fill" fluids cleanliness target is not a fluid "delivery" target. The level of cleanliness for delivered fluids is not specified by Cat. Customers can work with the distributors or carriers to determine the cleanliness level of delivered fluids. However, a more effective and economic means to achieve the fill cleanliness targets is to filter the fluids prior to filling into machine tanks as compared with specifying delivery fluid cleanliness level. Follow the guidelines provided in this Contamination Control article.

Although older technology machines may not be able to maintain the recommended cleanliness targets of advanced models, the same contamination control intervention measures such as filtration and subsequent service procedures should be used on all Cat products.

The viscosity and additives of powertrain oils including transmission, gear, differential, and axle oils can interfere with particle counting. An alternative option is to filter the oils using adequate filtration to ensure clean oils prior to filling in the machine compartments.

Note: Particle counting of new multi-viscosity engine oils may not be effective to assess their cleanliness level. Optical particle counters cannot distinguish between particulate contaminants and additives. Instead, filter the new engine oils as described below. Additionally do not use optical particle count for the evaluation of used engine oils because soot levels render oil too dark for optical particle counters. Soot levels in used engine oils should be evaluated by using S·O·S Services Oil Analysis.

When filtering engine oil before dispensing into the engine tank or when engine oil kidney looping filtration is done, follow these recommendations:

- Use engine oil filters of 12 microns absolute efficiency. Cat Ultra High Efficiency Lube filter is recommended. Consult your Cat dealer for the most current part number.
- Ensure that the temperature of engine oil is 20° C (68° F) or higher.

Consult your Cat dealer for information and solutions to your oil and fuel analysis needs.

General Contamination Control Recommendations or Practices

Maintaining a low contamination level can reduce down time and can control the maintenance cost of the machine. The productive life as well as the reliability of components and fluid systems is often increased as a result of proper contamination control practices.

The following are general guidelines for controlling contaminants.

- Refer to the Recommendations for Fuel Systems in this chapter for recommended fuel cleanliness levels and guidelines.
- Refer to the machine Operation and Maintenance Manual for the required maintenance for all machine compartments.
- When you add oil to a machine, use adequate filtration in order to clean the oil to meet the targets provided in Table 48 .
- Perform scheduled S·O·S Services Oil Analysis for contamination in order to maintain the recommended ISO cleanliness level of fill and machine fluids. Refer to the S·O·S Oil Analysis section in this Special Publication. The particle count analysis can be performed by your Cat dealer. Particle count can be conducted during the scheduled S·O·S Services Oil Analysis for the compartment. Extra oil samples are not required for the particle count sampling.
- Use only coolants that are recommended by Cat for your machine. Follow the recommended maintenance procedure for the cooling system in the Operation and Maintenance Manual for your machine.
- Maintain the engine air filters and air intake system to avoid unwanted contaminant ingress.
- Follow contamination control practices for the shop area, component/machine disassembly areas, parts, shop tools, test setups, test areas, storage areas and waste collection areas. Keep components clean during inspection, assembly, testing, and filling machines with clean fluids. Good practices will enhance component life and reduce downtime associated with contaminants. Your Cat dealer can provide details on proper contamination processes and practices.
- Follow contamination control practices for the workplace and for the worksite. Maintaining clean oil fill fluids saves time and effort and ensures that fill fluids are at the proper cleanliness levels.
- Use properly designed and maintained bulk storage fluids tanks.
- Protect the fluids storage tanks from dirt and water entry by using 4 µm or less absolute efficiency breathers with the ability to remove water.
- Keep the areas around the tanks filler necks clean of debris and water.
- Drain the storage tanks from water and sediments frequently. The draining schedule depends on use of proper inlet and outlet filters, the use of 4 µm breathers with the ability to remove water, and following recommended contamination control practices. Based on the contamination control program followed, and/or on the fuel supplier recommendations, the storage tank draining schedule may be as frequent as daily until no water is present, and then can be extended to longer periods.
- Install and maintain a properly designed and grounded filtration system. Filtration should include at the entry and at the dispensing point. Continuous bulk filtration may be required to ensure that dispensed oils meet the cleanliness target.
- Cover, protect, and ensure cleanliness of all connection hoses, fittings, and dispensing nozzles.

Note: Bulk fuel filtration units are available through your Cat dealer. Proper maintenance practices of the bulk filtration systems are available through your Cat dealer.

Contamination Control Recommendations for Fuels

Fuels of “ISO 18/16/13” cleanliness level or cleaner as dispensed into the engine or machine fuel tank should be used. Reduce power loss, failures, and related down time of engines will result. This cleanliness level is important for new fuel system designs such as Common Rail injection systems and unit injection systems. Injection system designs utilize higher fuel pressures and tight clearances between moving parts in order to meet required stringent emissions regulations. Peak injection pressures in current fuel injection systems may exceed 30,000 psi. Clearances in these systems are less than 5 μm . As a result, particle contaminants as small as 4 μm can cause scoring and scratching of internal pump and injector surfaces and of injector nozzles.

Water in the fuel causes cavitation, corrosion of fuel system parts, and provides an environment where microbial growth in the fuel can flourish. Other sources of fuel contamination are soaps, gels, or other compounds that may result from undesirable chemical interactions in the fuels, particularly in Ultra Low Sulfur Diesel (ULSD). Gels and other compounds can also form in biodiesel fuel at low temperatures or if biodiesel is stored for extended periods. The best indication of microbial contamination, fuel additives, or cold temperature gel is rapid filter plugging of bulk fuel filters or machine fuel filters.

In order to reduce downtime due to contamination, follow these fuel maintenance guidelines. Also, follow the General Contamination Control Recommendations or Practices given above in this Chapter:

- Use high-quality fuels per recommended and required specifications (refer to the Fuel Chapter in this Special Publication)
- Fill machine fuel tanks with fuels of “ISO 18/16/13” cleanliness level or cleaner, in particular for engines with common rail and unit injection systems. When you refuel the machine, filter the fuel through a 4 μm absolute filter (Beta 4 = 75 up to 200) in order to reach the recommended cleanliness level. This filtration should be located at the device that dispenses the fuel to the engine or machine fuel tank. In addition, filtration at the dispensing point should remove water to ensure that fuel is dispensed at 500 ppm water or less.
- Cat recommends the use of bulk fuel filter / coalescer units which clean the fuel of both particulate contamination and water in a single pass. Cat offers heavy-duty filter / coalescer units to accommodate fueling rates from 50 to 300 gpm (gallons per minute).
- Ensure that you use Cat Advanced Efficiency Fuel Filters. Change your fuel filters per recommended service requirements or as needed.
- Drain your water separators daily per the Operation and Maintenance Manual of your machine.
- Drain your fuel tanks of sediment and water per the Operation and Maintenance Manual of your machine or sooner as fuel condition indicates.
- Install and maintain a properly designed bulk filter / coalescer filtration system. Continuous bulk filtration systems may be required to ensure that dispensed fuel meets the cleanliness target. Consult your Cat dealer for availability of bulk filtration products.
- Centrifugal filters may need to be used as a pre-filter with fuel that is severely contaminated with gross amounts of water and/or large particulate contaminants. Centrifugal filters can effectively remove large contaminants, but may not be able to remove the small abrasive particles required to achieve the recommended “ISO” cleanliness level. Bulk filter / coalescers are necessary as a final filter in order to achieve the recommended cleanliness level.
- Install desiccant type breathers of 4 μm or less absolute efficiency with the ability to remove water on bulk storage tanks.
- Follow proper practices of fuel transportation. Filtration from the storage tank to the machine promotes the delivery of clean fuel to machine tank. Fuel filtration can be installed at each transport stage in order to keep the fuel clean.
- Cover, protect, and ensure cleanliness of all connection hoses, fittings, and dispensing nozzles.

NOTICE

In order to meet expected fuel system component life, 4 micron(c) absolute or less secondary fuel filtration is required for all Cat diesel engines that are equipped with common-rail fuel systems. Also, 4 micron(c) absolute or less secondary fuel filtration is required for all Cat diesel engines that are equipped with unit injected fuel systems. For all other Cat diesel engines (mostly older engines with pump, line and nozzle type fuel systems), the use of 4 micron(c) absolute or less secondary fuel filtration is strongly recommended. Note that all current Cat diesel engines are factory equipped with Cat Advanced Efficiency 4 micron(c) absolute fuel filters.

Consult your local Cat dealer for additional information on Cat designed and produced filtration products.

Reference Information Section

Reference Materials

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Reference Material

SMCS Code: 1000; 7000**S/N:** 04B1–Up**S/N:** 66D1–Up

The following literature can be obtained through any Caterpillar dealer.

Coolants

- Special Publication, SEBD0970, "Coolant and Your Engine"
- Data Sheet, PEHJ0067, "Cat ELC (Extended Life Coolant)"
- Special Publication, SEBD0518, "Know Your Cooling System"
- Special Publication, PEEP5027, "Label - ELC Radiator Label"
- Data Sheet, PEHP7057, "S·O·S Coolant Analysis"

Fuels

- Special Publication, SEBD0717, "Diesel Fuels and Your Engine"

Lubricants

- Data Sheet, PEHJ0059, "Cat DEO (SAE 10W-30 and SAE 15W-40)" Canada, Mexico, and the United States
- Data Sheet, PEHJ0021, "Cat DEO (SAE 10W-30 and SAE 15W-40)" Worldwide except North America, Egypt, Saudi Arabia, and Brazil
- Data Sheet, PEHJ0072, "Cat DEO (SAE 10W-30 and SAE 15W-40)" Brazil
- Data Sheet, PEHJ0091, "Cat DEO (SAE 10W-30 and SAE 15W-40)" Egypt and Saudi Arabia
- Special Publication, PEHP9516, "Product Data Sheet for Special Application Engine Oil For Caterpillar 3116 and 3126 Marine Diesel Engines with Mechanical Unit Injectors"

- Special Publication, PEWP3014, "Cat Fluids Selector Dial (International)"
- Special Publication, PEWP9733, "Cat Fluids Selector Dial (North America)"
- Data Sheet, PEHJ0088, "Cat Multipurpose Grease"
- Data Sheet, PEHP0002, "Cat Advanced 3Moly Grease" NLGI grade 2
- Data Sheet, NEHP6015, "Cat High Speed Ball Bearing Grease" NLGI grade 2
- Special Publication, PEGJ0035, "Grease Selection Guide"
- Special Publication, PEHP6001, "How To Take A Good Oil Sample"
- Special Publication, SEBD0640, "Oil and Your Engine"
- Special Publications, PEDP7036, "S·O·S Fluids Analysis Cornerstone"

Miscellaneous

Special Publication, PECP6026, "One Safe Source" English language for use in NACD

Special Publication, PECP6027, "One Safe Source" English language for use in COSA

Special Publication, PECP6028, "One Safe Source" English language for use in non NACD and non COSA

- Service Manual, SENR9595, "C-9 Industrial Engine Service Manual"
- Special Publication, SEBU6251, "Caterpillar Commercial Diesel Engine Fluids Recommendations For Lubricants, Diesel Fuel, and Coolants"
- Service Manual, SENR9595, "C-9 Industrial Engine Service Manual"
- Special Publication, SEBU6251, "Caterpillar Commercial Diesel Engine Fluids Recommendations For Lubricants, Diesel Fuel, and Coolants"
- Special Publication, PECP9067, "One Safe Source"
- Special Instruction, SMHS7001, "Assembly of Fan Drive Pulley Assemblies"
- Special Instruction, SEHS7633, "Battery Test Procedure"

- Special Publication, SEBF8062, "Guideline for Reusable Parts - Procedure to Inspect and Clean Air Filters"
- Special Publication, SEBF8029, "Index to Guidelines for Reusable Parts and Salvage Operations"
- Special Publication, PEDP0026, "Power Analysis Report"
- Special Publication, NEHS0526, "Service Technology Application Guide"
- Special Instruction, SEHS9031, "Storage Procedure for Caterpillar Products"
- Specifications, SENR3130, "Torque Specifications Module"
- Special Instruction, SEHS8742, "Using the 8T-8697 Electronic Control Analyzer Programmer (ECAP)"
- Special Instruction, SEHS8622, "Using the FT-1984 Air-To-Air Aftercooler Leak Test Group"
- Special Instruction, SEHS7332, "Warning Tag - Danger Do Not Operate"
- Special Instruction, REHS0871, "Electronic Installation Guide"

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Reference Material

SMCS Code: 1000; 7000

The following publications are available for order through your Caterpillar dealer.

Note: The information that is contained in the listed publications is subject to change without notice. Consult your local Caterpillar dealer for the most current recommendations.

Note: Refer to this Special Publication, the respective product data sheet, and to the appropriate Operation and Maintenance Manual for product application recommendations.

Lubricants, Coolants, and Greases

- Data sheets, specifications, and recommendations for Cat lubricants, coolants, and greases are available through your Cat dealer and at the following website:

<http://parts.cat.com/parts/machine-fluids>

- Special Publication, PEWJ0074, "Filters and Fluids Application Guide"

- Special Publication, PEHJ0149, "Cat Filters and Fluids Toolbox Update - Datasheet Set"
- Special Publication, REHS1063, "Know Your Track-Type Tractor Cooling System"
- Special Publication, SEBD0518, "Know Your Cooling System"
- Special Publication, PEGJ0035, "Grease Selection Guide"

Fuel

- Special Publication, PEHP7046, "Fuel Contamination Control Data Sheet"
- Special Publication, SENR9620, "Improving Fuel System Durability"
- Special Publication, SEBD0717, "Diesel Fuels and Your Engine"
- "ASTM D6751 Standard Specification for Biodiesel Fuel Blend Stock (B100) for Middle Distillate Fuels"
- "EN 14214 Automotive fuels - Fatty acid methyl esters (FAME) for diesel engines - Requirements and test methods"
- "ASTM D7467 Standard Specification for Diesel Fuel Oil, Biodiesel Blend (B6 to B20)"
- "ASTM D975 Standard Specification for Diesel Fuel Oils" (includes requirements for B5 and lower biodiesel blends)
- "EN 590 Automotive fuels - Diesel - Requirements and test methods" (includes requirements for B5 and lower biodiesel blends)
- "EN 14078 Liquid petroleum products - Determination of fatty acid methyl esters (FAME) in middle distillates - Infrared spectroscopy method"
- "EN 14104 Fat and oil derivatives - Fatty Acid Methyl Esters (FAME) - Determination of Acid Value"
- "ASTM D664 Standard Test Method for Acid Number of Petroleum Products by Potentiometric Titration"
- "ASTM D6469 Standard Guide for Microbial Contamination in Fuels and Fuel Systems"
- "Facts You Should Know About Renewable Fuels, EMA (Engine Manufacturer Association)"

- “EMA Technical Position on Use of Biodiesel Position Statement, EMA (Engine Manufacturer Association)”

<http://www.truckandenginemanufacturers.org/articles>

Filters

- For general Cat filtration products, refer to the following website:

<https://commerce.cat.com/en/catcorp/filters>

- Special Publication, PEWJ0074, “Filters and Fluids Application Guide”
- Special Publication, PEHP7046, “Fuel Contamination Control”

S·O·S Services

- Special Publication, PEHJ0191, “S·O·S Services Data Sheet”
- Special Publication, PEHP7052, “Making the Most of S·O·S Services”
- Special Publication, PEGJ0046, “Understanding S·O·S Reports”
- Special Publication, PEGJ0047, “How to Take a Good S·O·S Sample”
- Special Publication, PEGJ0045, “Reporting Particle Count by ISO Code”
- Special Publication, PEDJ0129, “Fuel Sampling Guide”
- Special Publication, PEDP7036, “S·O·S Fluids Analysis Cornerstone”
- Special Publication, PEHP7076, “Understanding S·O·S Service Tests”

Miscellaneous

- Special Publication, PEBJ0002, “Caterpillar Dealer Contamination Control Compliance Guide”
- Special Publication, PEBJ0007, “Caterpillar Customer Contamination Control Compliance Guide”
- Special Publication, SEBU5898, “Cold Weather Recommendations”
- Special Publication, PEDP9131, “Fluid Contamination - The Silent Thief”
- Special Publication, AECQ1043, “Caterpillar Product Line Brochure”

- Special Publication, PEWJ0074, “Cat Filter and Fluid Application Guide”
- Special Publication, PECP9067, “One Safe Source”
- Special Publication, NENG2500, “Caterpillar Dealer Service Tool Catalog”
- Special Publication, PECJ0003, “Cat Shop Supplies and Tools” catalog
- Special Publication, SENR3130, “Torque Specifications”
- Special Publication, SENR9620, “Improving Component Durability - Fuel Systems” (Package of 10)
- Special Publication, SEBF1018, “Improving Component Durability - Engines” (Package of 10)
- Special Publication, SEBF1020, “Improving Component Durability - Managing Fluid Cleanliness” (Package of 10)
- Special Publication, SEBF1015, “Improving Component Durability - Final Drives and Differentials” (Package of 10)
- Special Publication, SEBF1016, “Improving Component Durability - Powershift Transmissions” (Package of 10)
- Special Publication, SEBF1017, “Improving Component Durability - Component Removal and Installation” (Package of 10)
- Special Publication, SEBF1019, “Improving Component Durability - Hydraulics” (Package of 10)
- Special Publication, SEBF1021, “Improving Component Durability” Boxed set (Includes one each of the 7 “Improving Component Durability” series.)
- Special Publication, SEBD0348, “Caterpillar Performance Handbook”
- ASTM D6469, “Standard Guide for Microbial Contamination in Fuels and Fuel Systems”

Additional Reference Material

SAE J183, “Classification” This document can normally be found in the SAE handbook.

SAE J313, “Diesel Fuels” This document can be found in the SAE handbook. Also, this publication can be obtained from your local technological society, from your local library, or from your local college.

SAE J754, "Nomenclature" This document can normally be found in the SAE handbook.

Engine Manufacturers Association, " Engine Fluids Data Book"

Engine Manufacturers Association
Two North LaSalle Street, Suite 2200
Chicago, Illinois USA 60602
<http://www.truckandenginemanufacturers.org/articles>

For information on the American Petroleum Institute (API) engine oil categories, contact the API at:

1220 L Street, NW
Washington, DC USA 20005-4070
<http://www.api.org>

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Product and Dealer Information

Note: For product identification plate locations, see the section "Product Identification Information" in the Operation and Maintenance Manual.

Delivery Date: _____

Product Information

Model: _____

Product Identification Number: _____

Engine Serial Number: _____

Transmission Serial Number: _____

Generator Serial Number: _____

Attachment Serial Numbers: _____

Attachment Information: _____

Customer Equipment Number: _____

Dealer Equipment Number: _____

Dealer Information

Name: _____ Branch: _____

Address: _____

Dealer Contact

Phone Number

Hours

Sales: _____

Parts: _____

Service: _____



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