

Product: EXCAVATOR

Model: 320 GC EXCAVATOR KTN

Configuration: 320 GC Excavator KTN00001-UP (MACHINE) POWERED BY C4.4 Engine

## Disassembly and Assembly C4.4 Engines for Caterpillar Built Machines

Media Number -UENR4516-11

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i05820278

## Flywheel - Install

SMCS - 1156-012

## Installation Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	-	Guide Studs 1/2 inch - UNF by 4 inch	2

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### NOTICE

**Keep all parts clean from contaminants.**

**Contaminants may cause rapid wear and shortened component life.**

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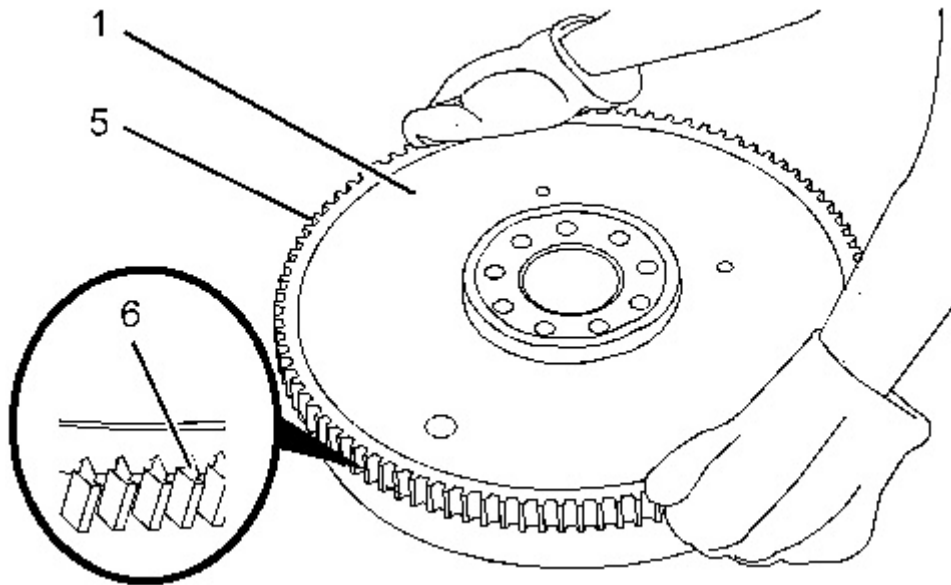


Illustration 1  
Typical example

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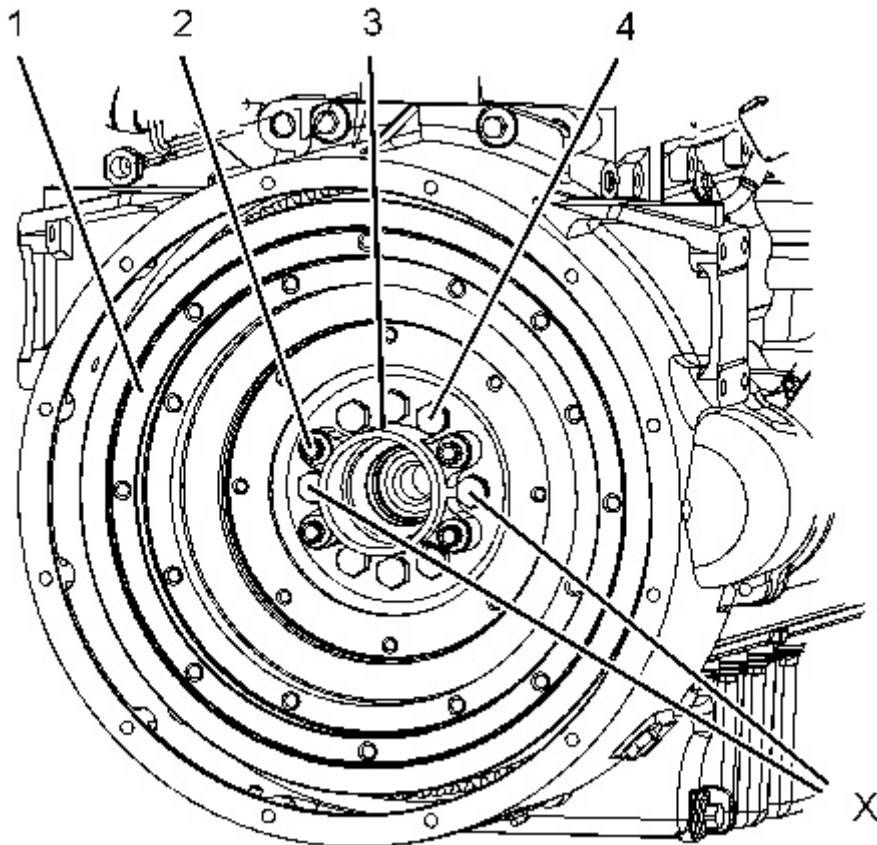
**! WARNING**

**Always wear protective gloves when handling parts that have been heated.**

1. If the flywheel ring gear was removed, follow Step 1.a through Step 1.c in order to install ring gear (5) to flywheel (1).
  - a. Identify the orientation of teeth (6) on new ring gear (5).

**Note:** The chamfered side of ring gear teeth (6) must face toward the starting motor when the flywheel is installed. The chamfered on ring gear teeth will ensure the correct engagement of the starting motor.
  - b. Heat flywheel ring gear (5) in an oven to a maximum temperature of 250 °C (482 °F) prior to installation.

**Note:** Do not use a torch to heat the ring gear.
  - c. Ensure that the orientation of ring gear (5) is correct and quickly install the ring gear onto flywheel (1).
2. Inspect the crankshaft rear seal for leaks. If there are any oil leaks, replace the crankshaft rear seal. Refer to Disassembly and Assembly, "Crankshaft Rear Seal - Remove" for the correct procedure.



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Illustration 2  
Typical example

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3. Install a suitable lifting device on flywheel (1). The flywheel can weigh 71 kg (156 lb).
4. Install Tooling (A) in Position (X) on the crankshaft.
5. Use the lifting device to position flywheel (1) onto Tooling (A).
6. If necessary, install pilot bearing (3) and bolts (2) to flywheel (1).
7. Install bolts (4) to flywheel (1).
8. Remove Tooling (A) and install remaining bolts (4) to flywheel (1).
9. Use a suitable tool to prevent the flywheel from rotating. Tighten bolts (2) and (4) to a torque of 140 N·m (103 lb ft).
10. Remove the lifting device from flywheel (1).
11. Check the run out of the flywheel. Refer to Specifications, "Flywheel" for further information.

**End By:**

- a. Install the electric starting motor. Refer to Disassembly and Assembly, "Electric Starting Motor - Remove and Install" for the correct procedure.
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