



# Service Repair Manual

## **Models**

312B and 312B L Excavator

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Product: EXCAVATOR

Model: 312B EXCAVATOR 9GR

Configuration: 312B & 312B L TRACK-TYPE EXCAVATORS 9GR00001-UP (MACHINE) POWERED BY 3064 ENGINE

## Disassembly and Assembly 3064 and 3066 Engines for Caterpillar Built Machines

Media Number -SEN5553-10

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i01567208

## Flywheel - Remove

SMCS - 1156-011

## Removal Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	138-7575	Link Bracket	1
B		Forcing screws M16 X 2	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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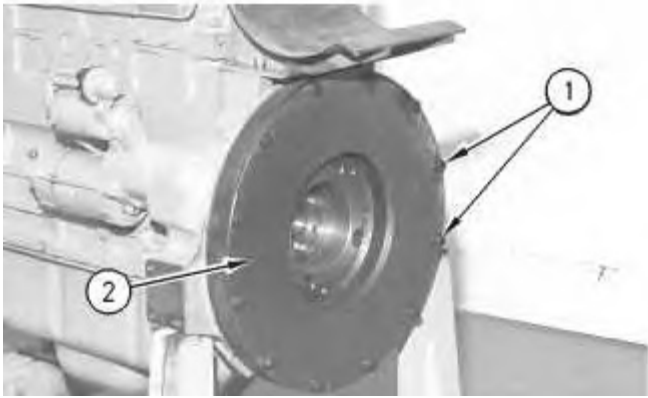


Illustration 1

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1. Remove twelve bolts (1) and washers from the adapter (2) .
2. Remove the adapter (2) from the flywheel housing.



Illustration 2

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3. Remove four socket head bolts (3) from the inner ring (4) .
4. Remove the inner ring (4) from the flywheel.



5. Remove six bolts (5) that secure flywheel (6) to the crankshaft. Check all bolts for stripped threads. Replace the bolts, if necessary.

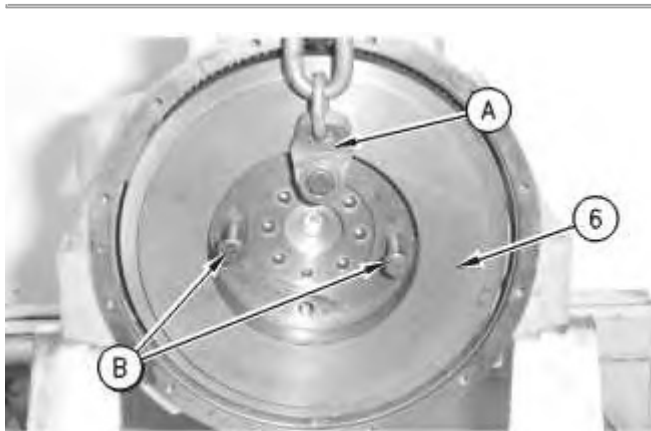


Illustration 4

6. Install Tool (A), a strap, and a suitable lifting device onto the flywheel (6).
7. Use Tool (B) in order to remove the flywheel and ring gear out of the housing. The weight of the flywheel is 50 kg (110 lb).
8. Perform the following procedure in order to remove the flywheel ring gear.

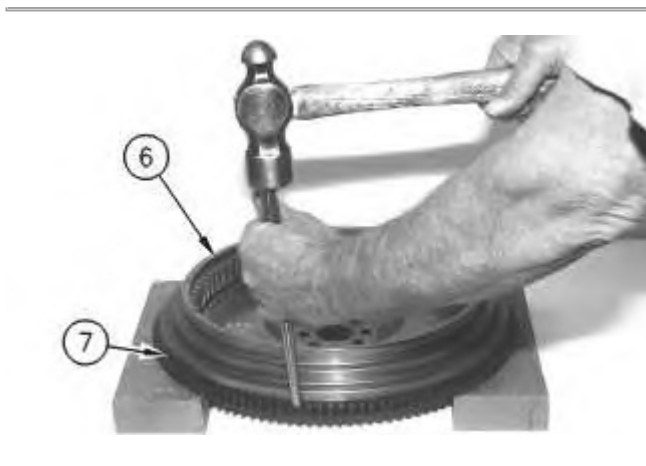


Illustration 5

- a. Place the flywheel and ring gear assembly on a suitable support.

**Note:** Check the flywheel ring gear for the following conditions: cracks, damaged dowel holes, worn ring gear and damaged ring gear.

**Note:** Identify the orientation of the old ring gear on the flywheel for proper positioning, when the new ring gear is installed.



**WARNING**

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

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- b. Heat ring gear (7) uniformly.
- c. Remove the ring gear (7) by tapping the ring gear all the way around the flywheel (6) .
- d. Reposition the flywheel in order to remove the ring gear.

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