



# Service Repair Manual

## **Models**

320D RR and 320D LRR  
Excavator

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Product: EXCAVATOR

Model: 320D RR EXCAVATOR GMX

Configuration: 320D RR & 320D LRR Excavators GMX00001-UP (MACHINE) POWERED BY C6.4 Engine

## Disassembly and Assembly C6.4 Engine for Caterpillar Built Machines

Media Number -KENR8106-09

Publication Date -01/10/2017

Date Updated -18/10/2017

i02743771

### 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 bolts M16 - 2 by 120 mm	2

#### Start By:

- Remove the crankshaft position sensor. Refer to Disassembly and Assembly, "Crankshaft Position Sensor - Remove and Install".
- Remove the muffler. Refer to Disassembly and Assembly, "Muffler - Remove and Install".

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### NOTICE

**Keep all parts clean from contaminants.**

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

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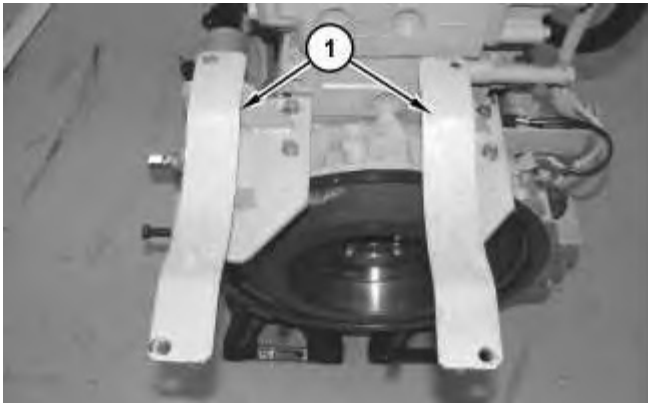


Illustration 1

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1. Remove muffer brackets (1).

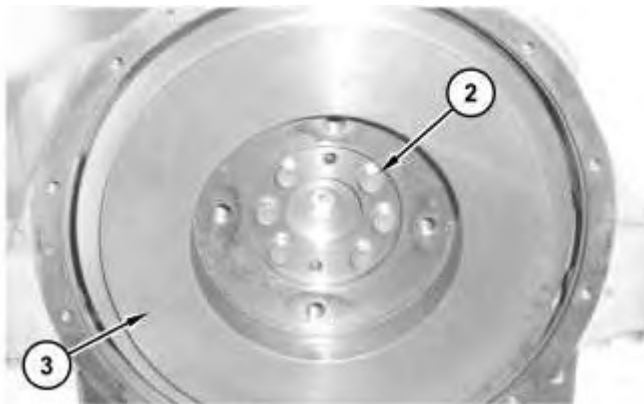


Illustration 2

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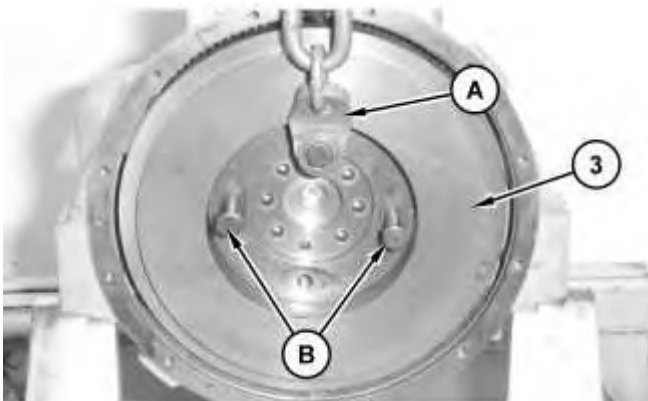


Illustration 3

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2. Remove bolts (2).
3. Install Tooling (A) and a suitable lifting device onto flywheel (3).
4. Use Tooling (B) in order to remove flywheel (3) out of the housing. The weight of flywheel (3) is approximately 50 kg (110 lb).

5. Perform the following procedure in order to remove the flywheel ring gear.

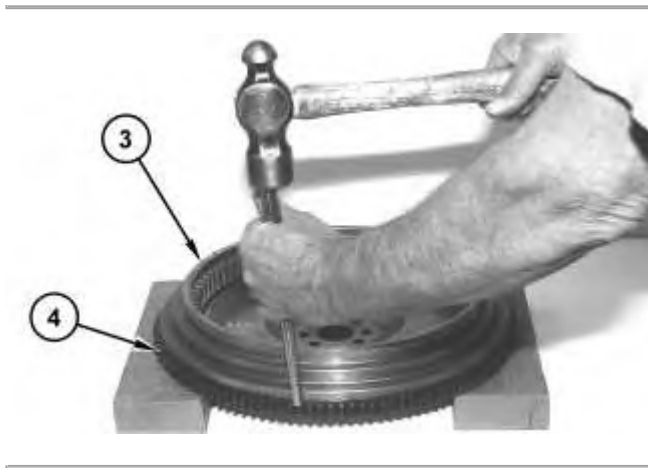


Illustration 4

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Typical Example

- a. Place flywheel (3) and ring gear (4) on suitable cribbing.

**Note:** Mark the orientation of ring gear (4) on flywheel (3) for assembly purposes.



**WARNING**

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

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- b. Raise the temperature of ring gear (4) uniformly.
- c. Remove the ring gear (4) by tapping ring gear (4) all the way around flywheel (3).
- d. Reposition flywheel (3) in order to remove ring gear (4).

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## Disassembly and Assembly C6.4 Engine for Caterpillar Built Machines

Media Number -KENR8106-09

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i02744399

## Flywheel - Install

SMCS - 1156-012

## Installation Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	138-7575	Link Bracket	1

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1. Perform the following procedure, if the ring gear was removed from the flywheel:
  - a. Raise the temperature of the ring gear 149 °C (300 °F).

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