



# Service Repair Manual

## **Models**

324D and 324D L Excavator

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Product: EXCAVATOR

Model: 324D EXCAVATOR CJX

Configuration: 324D & 324D L Excavators CJX00001-UP (MACHINE) POWERED BY C7 Engine

## Disassembly and Assembly

### C7

#### Engines for Caterpillar Built Machines

Media Number -REN9218-13

Publication Date -01/06/2014

Date Updated -04/06/2014

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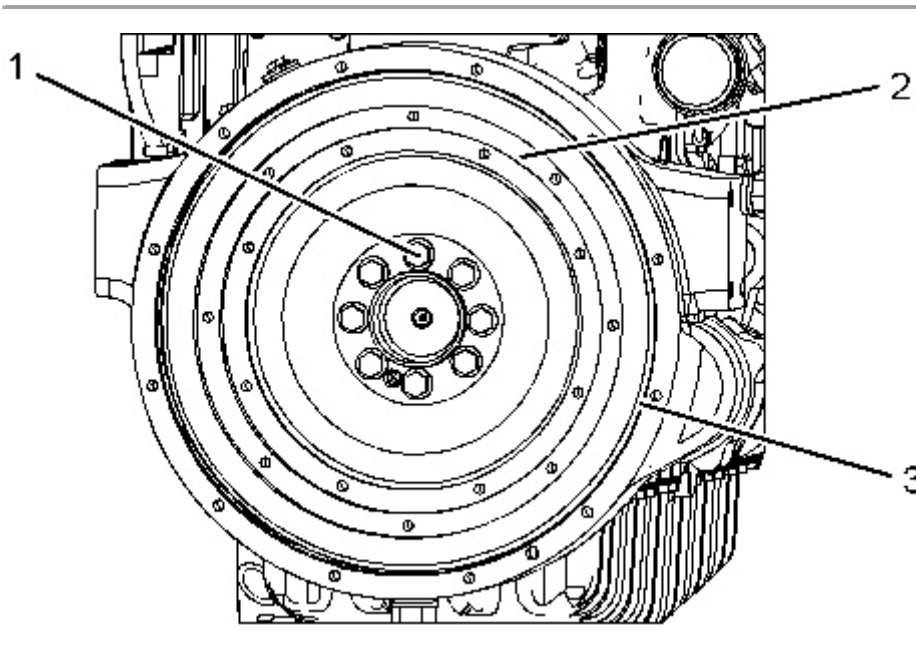
## Flywheel - Remove

SMCS - 1156-011

## Removal Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	138-7573	Link Bracket	1
B	-	Guide Bolt (M12 X 1.75 by 120 mm)	1



1. Attach Tooling (A) and a suitable lifting device to flywheel (2). The weight of flywheel (2) is approximately 27 kg (60 lb).
2. Remove top bolt (1). Install Tooling (B). Remove remaining bolts (1) .
3. Remove flywheel (2) from Tooling (B).
4. Replace ring gear (3), if necessary. Use a hammer and a punch in order to remove the flywheel ring gear.

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#### Engines for Caterpillar Built Machines

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## Flywheel - Install

SMCS - 1156-012

## Installation Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	439-3938	Link Bracket	1
B	-	Guide Bolt (M12 X 1.75 by 120 mm)	1
C	9S-3263	Thread Lock Compound	1

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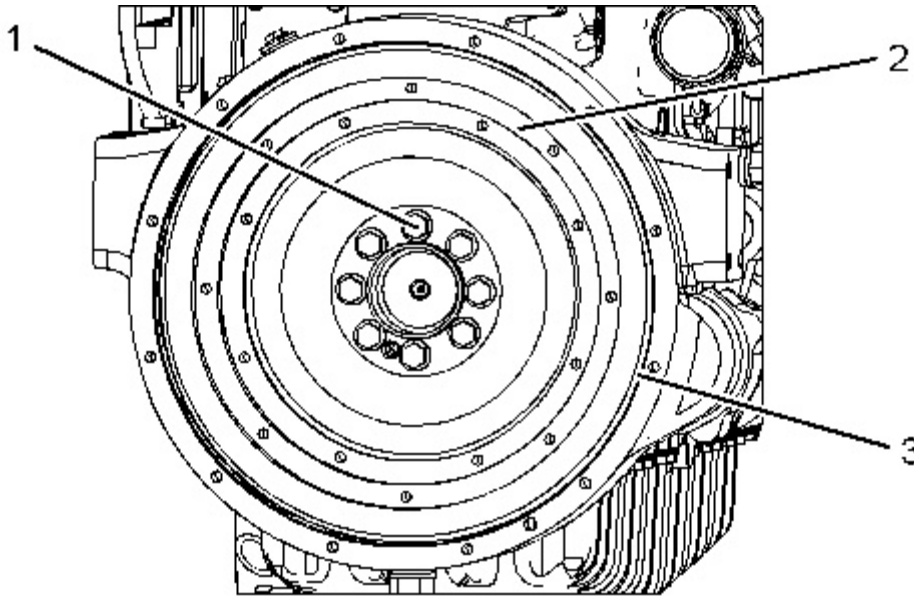


Illustration 1

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1. Raise the temperature of ring gear (3) .

**Note:** Do not use a torch to heat the ring gear.

2. Position ring gear (3) on flywheel (2) with the part number toward the crankshaft. Use a soft hammer in order to seat the ring gear against the shoulder of the flywheel. Allow the ring gear to cool.
3. Install Tooling (B) in the crankshaft.
4. Attach Tooling (A) and a suitable lifting device to flywheel (2) . The weight of flywheel (2) is approximately 27 kg (60 lb).
5. Position flywheel (2) on Tooling (B) .
6. Apply Tooling (C) to the threads of bolts (1) .
7. Install bolts (1) . Remove Tooling (B) and install remaining bolt (1) . Tighten bolts (1) to a torque of  $120 \pm 20$  N·m ( $89 \pm 15$  lb ft).
8. Check the flywheel runout. Refer to Testing and Adjusting, "Flywheel - Inspect".

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