



Service Repair Manual

Models

325-A, 325, 325L and
325LN EXCAVATOR

Product: EXCAVATOR

Model: 325-A EXCAVATOR 9SG

Configuration: 325, 325L, 325LN EXCAVATORS 9SG00001-UP (MACHINE) POWERED BY 3116 ENGINE

Disassembly and Assembly

446 and 446B Backhoe Loaders, Lexion 450 Combine, 3114 and 3116 Engines, IT18F Integrated Toolcarrier, D6M Track-Type Tractor and 928F, 950F and 950G Wheel Loaders

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i01928788

Exhaust Manifold - Remove and Install

SMCS - 1059-010

Removal Procedure

Start By:

- a. Remove the turbocharger. Refer to Disassembly and Assembly, "Turbocharger - Remove".

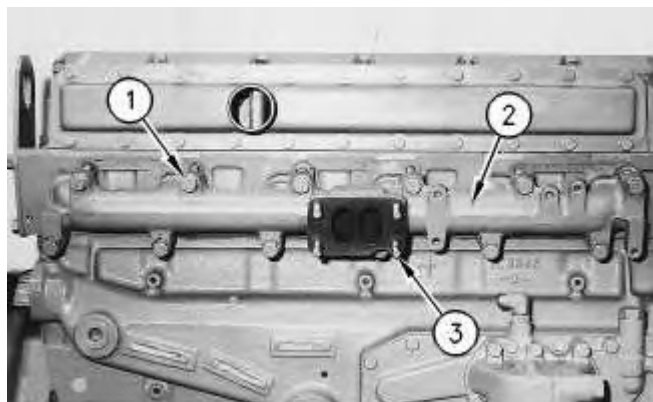


Illustration 1

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Typical example

1. Remove bolts (1), exhaust manifold (2), locks and the gaskets from the cylinder head assembly.
2. If the engine is equipped with a three-piece exhaust manifold, disassemble exhaust manifold (2) into three pieces.
3. Remove mounting studs (3) from exhaust manifold (2), if necessary.

Installation Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	5P-3931	Anti-Seize Compound	1
B	2P-2333	High Temperature Sealer	1

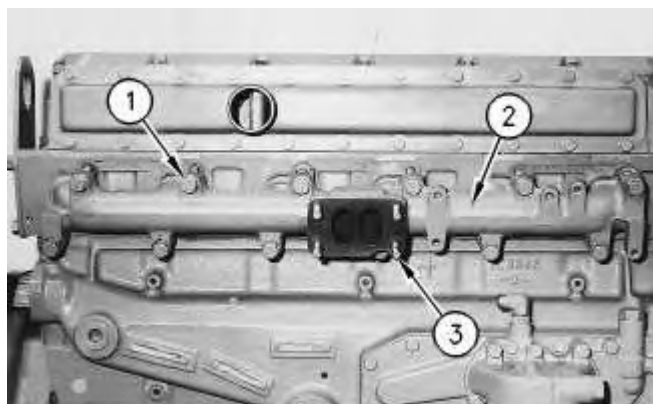


Illustration 2

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Typical example

1. Apply Tooling (A) to the threads of mounting studs (3).
2. Install mounting studs (3). Tighten mounting studs (3) to a torque of $35 \pm 5 \text{ N}\cdot\text{m}$ ($26 \pm 4 \text{ lb ft}$).
3. If the engine is equipped with a three-piece exhaust manifold, apply a thin coat of Tooling (B) to the male ends of exhaust manifold (2). Coat the inside of the female ends of exhaust manifold (2) with clean engine oil. Assemble exhaust manifold (2) and remove the excess sealant from the joints.
4. Install new exhaust manifold gaskets.
5. Apply Tooling (A) to the threads of bolts (1). Position the gaskets and exhaust manifold (2) on the cylinder head assembly. Install locks and bolts (1).

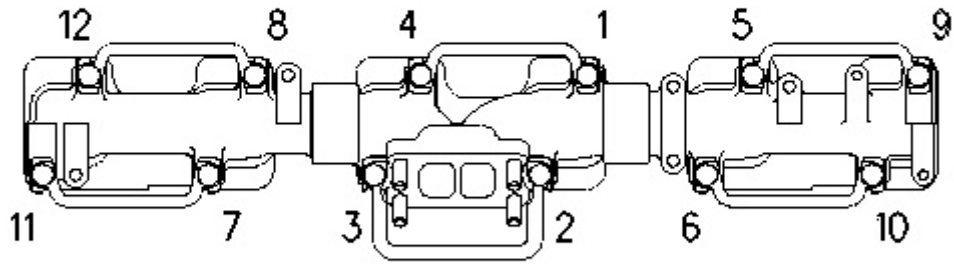


Illustration 3

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Typical example of a three-piece exhaust manifold

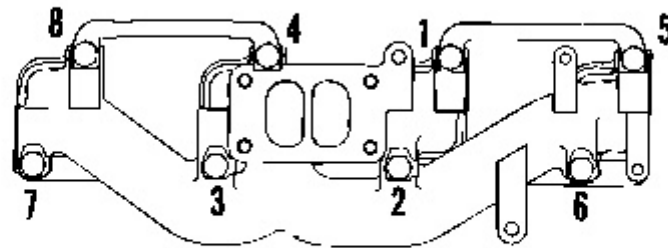


Illustration 4

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Exhaust manifold for a Four cylinder engine

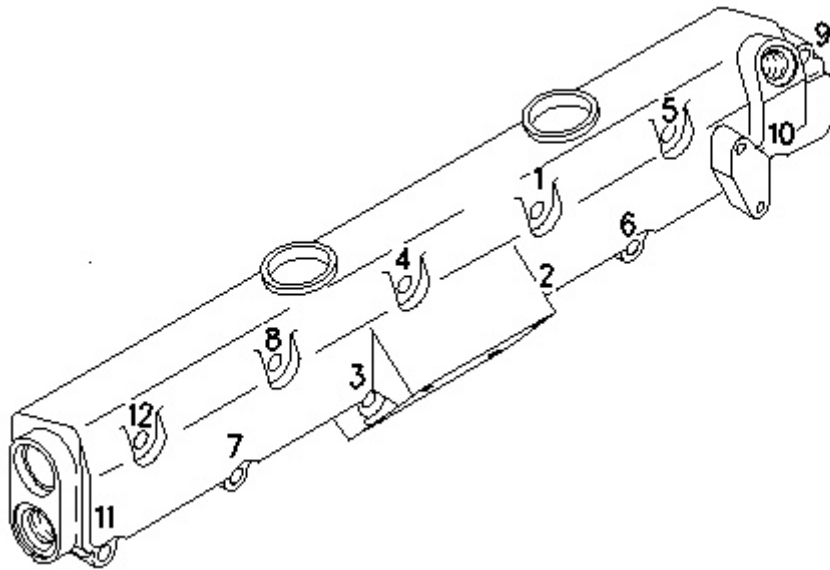


Illustration 5

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Water cooled exhaust manifold

6. Tighten bolts (1) in a numerical sequence to a torque of $4 \pm 1 \text{ N}\cdot\text{m}$ ($35 \pm 9 \text{ lb in}$).
7. Tighten bolts (1) in a numerical sequence to a torque of $45 \pm 5 \text{ N}\cdot\text{m}$ ($33 \pm 4 \text{ lb ft}$).

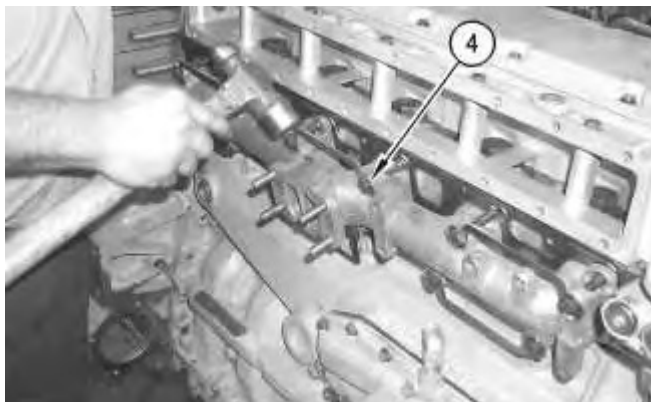


Illustration 6

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Typical example of locking tabs

8. Bend the locking tabs (4) over the flat of each bolt head.

End By:

- a. Install the turbocharger. Refer to Disassembly and Assembly, "Turbocharger - Install".

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