



# Service Repair Manual

## **Models**

325-A FM L 325 325L  
EXCAVATOR

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Product: EXCAVATOR

Model: 325-A FM L EXCAVATOR 7LM

Configuration: 325, 325L EXCAVATOR 7LM00001-UP (MACHINE) POWERED BY 3116 ENGINE

## **Disassembly and Assembly 325, 325B and 325L Excavators**

Media Number -REN1178-03

Publication Date -01/09/2000

Date Updated -09/10/2001

i01765040

### **Travel Motor - Disassemble**

SMCS - 4351-015

## **Disassembly Procedure For The Travel Motor On CIPI Undercarriage Arrangements Which Are Based On 325 Track Type Excavators**

### **Start By:**

- A. Remove the travel motor. Refer to Disassembly and Assembly, "Travel Motor - Remove" in this manual.

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### **NOTICE**

**Care must be taken to ensure that fluids are contained during performance of inspection, maintenance, testing, adjusting and repair of the product. Be prepared to collect the fluid with suitable containers before opening any compartment or disassembling any component containing fluids.**

**Refer to Special Publication, NENG2500, "Caterpillar Tools and Shop Products Guide" for tools and supplies suitable to collect and contain fluids on Caterpillar products.**

**Dispose of all fluids according to local regulations and mandates.**

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1. Thoroughly clean the outside of the travel motor prior to disassembly. Fasten the travel motor to a suitable holding fixture in a vertical position. The weight of the travel motor is approximately 71 kg (157 lb).

- Put an alignment mark across the head and the body of the travel motor for assembly purposes. The head must be reinstalled in the head's original position on the travel motor body.

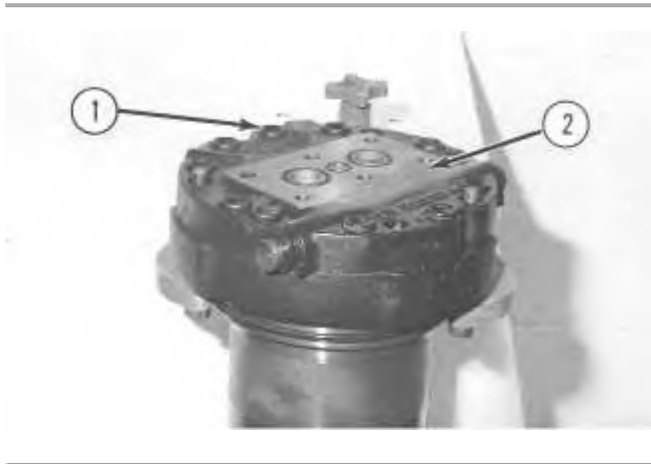


Illustration 1

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- Remove nine socket head bolts (1) and head (2) from the travel motor body.

**Note:** During the removal of head (2) from the travel motor body, be careful not to damage the mating surfaces of the components.

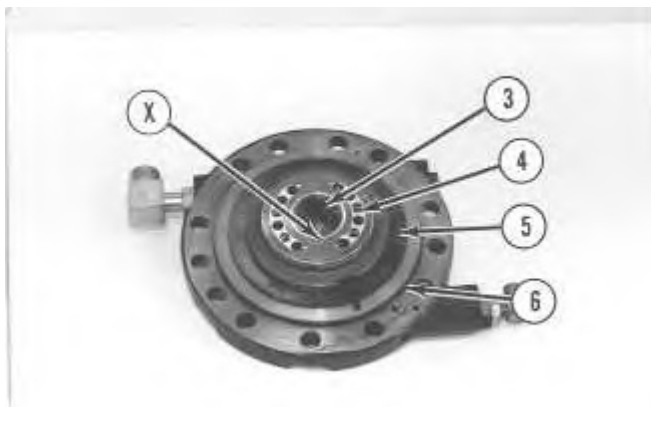


Illustration 2

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Illustration 3

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4. Turn over head (2). Remove O-ring seal (6), shims (5), port plate (4), and bearing (3) from the head. Remove the two check valve assemblies from the head.

**Note:** There is a retainer that is located under spring (9). This retainer is a press fit in head (2). Do not remove the retainer.

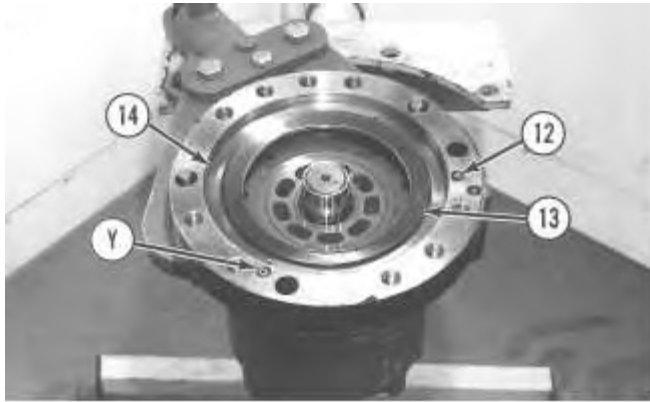
5. Insert a dowel rod with a small diameter into hole "X". Tap the dowel rod with a plastic hammer in order to remove spring (9), poppet (8) and seat (7) from the head.



Illustration 4

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6. Remove three fittings (10) and four plugs (11) from the head. Remove the O-ring seal from each fitting.
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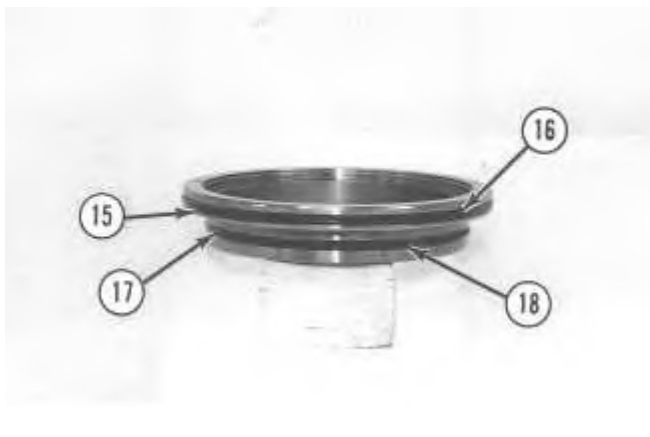


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Illustration 5

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7. Remove three O-ring seals (12) and washer set (13) from the body of the travel motor.
8. Place a shop towel over brake piston (14). Retain brake piston (14) by hand, and apply approximately 525 kPa (75 psi) of shop air pressure to brake release port "Y". Make sure that the shop air pressure is free of water. Brake piston (14) will move up the piston guide, and out of the piston guide. Remove brake piston (14) from the travel motor body.



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Illustration 6

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9. Remove O-ring seals (15) and (17), and backup rings (16) and (18) from the brake piston.
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