



Service Repair Manual

Models

325C EXCAVATOR

Product: EXCAVATOR
Model: 325C EXCAVATOR BLA
Configuration: ISJ HEX COMMONALITY CHART BLA00001-UP (MACHINE)

Disassembly and Assembly 3126B Engines for Caterpillar Built Machines

Media Number -SEN9581-06

Publication Date -01/08/2018

Date Updated -17/08/2018

i01980480

Flywheel - Remove and Install

SMCS - 1156-010

Removal Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	138-7573	Link Bracket	2
B	FT2712	Guide Stud	2

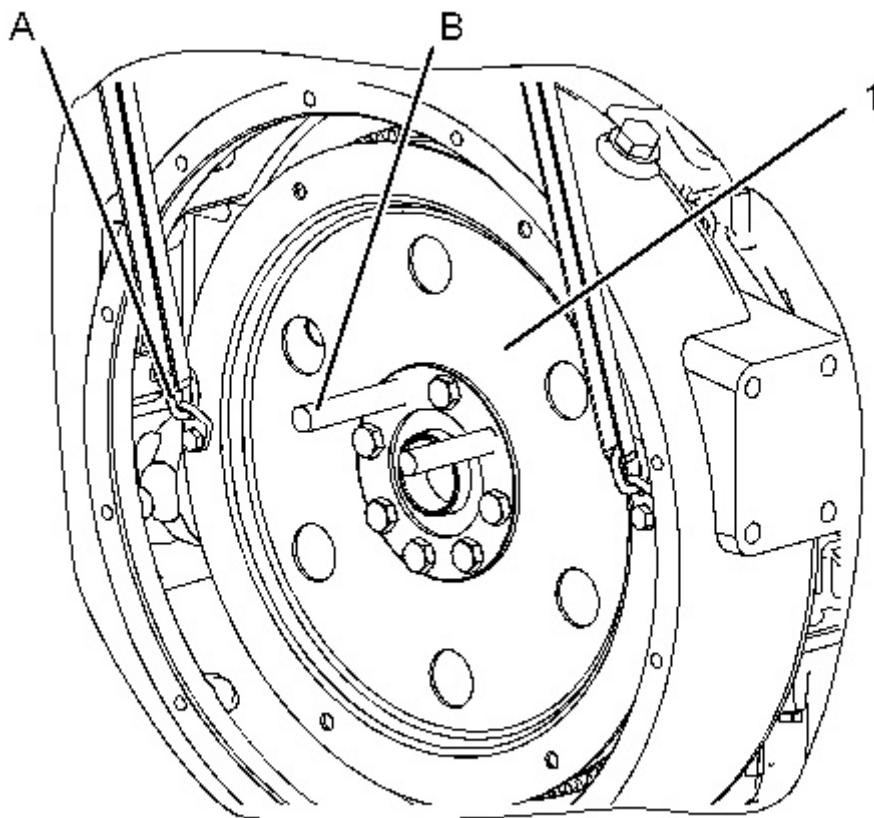


Illustration 1

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1. Install Tooling (A) on the flywheel. Fasten a suitable lifting device to the flywheel. The weight of flywheel (1) is approximately 23 kg (50 lb).
2. Remove two bolts and install Tooling (B). Remove the remaining bolts.
3. Remove flywheel (1).
4. Place the flywheel on a wood block. Use a hammer and a punch in order to remove the flywheel ring gear.

Installation Procedure

Table 2

Required Tools			
Tool	Part Number	Part Description	Qty
A	138-7573	Link Bracket	2
B	FT2712	Guide Stud	2
C	9S-3263	Thread Lock Compound	1

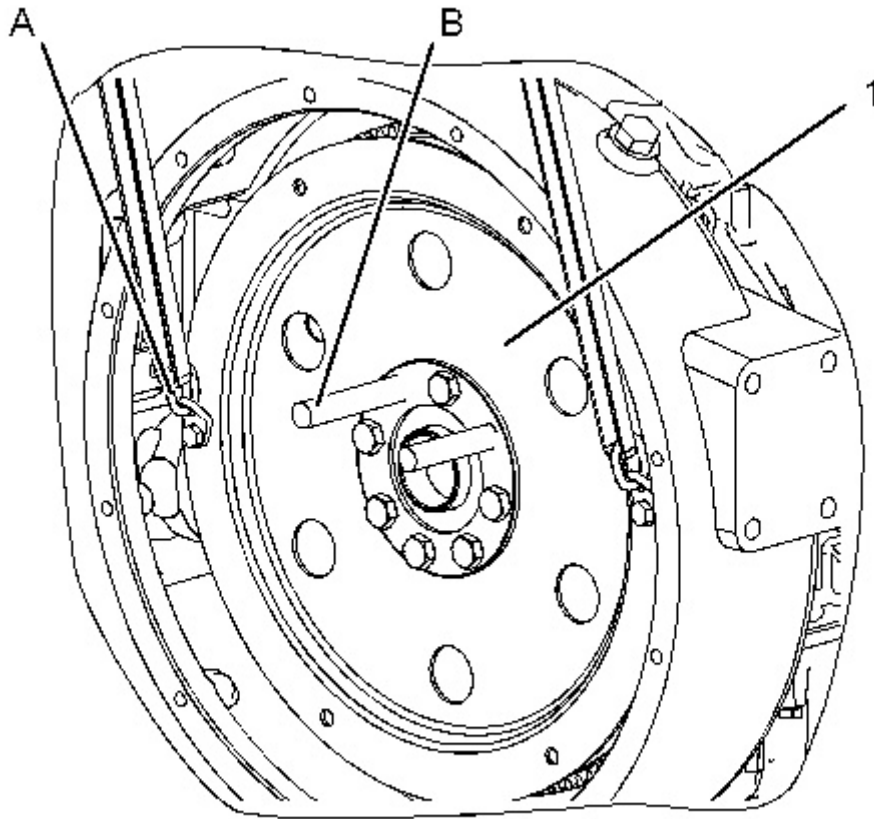


Illustration 2

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1. Raise the temperature of the flywheel ring gear. Do not use a torch to heat the flywheel ring gear. Position the flywheel ring gear on the flywheel with the part number toward the crankshaft.
2. Use a suitable lifting device to position flywheel (1) on Tooling (B). The weight of flywheel (1) is approximately 23 kg (50 lb).
3. Apply Tooling (C) to the threads of the bolts. Install the bolts. Remove Tooling (B) and install the remaining bolts.
4. Tighten the bolts evenly to a torque of $120 \pm 20 \text{ N}\cdot\text{m}$ ($90 \pm 15 \text{ lb ft}$).
5. Check the flywheel runout. Refer to Testing and Adjusting, "Flywheel - Inspect" for the correct procedure.

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Crankshaft Rear Seal - Remove

SMCS - 1161-011

Removal Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	1U-8145	Drill Bit	1
B	1U-7600	Slide Hammer Puller Gp	1
C	4C-4869	Distorter Ring	1
D	5P-7312	Seal Distorter	1

Start By:

- Remove the flywheel. Refer to Disassembly and Assembly, "Flywheel - Remove".

NOTICE

Keep all parts clean from contaminants.

Contaminants may cause rapid wear and shortened component life.

- Use Tooling (A) to drill three evenly spaced holes in the crankshaft rear seal.
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