



# Service Repair Manual

## **Models**

325D 325D L and 325D LN  
Excavator

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Tool	Part Number	Part Description	Qty
A	1P-2420	Transmission Repair Stand	1
B	138-7573	Link Bracket	2
C	1P-1863	Retaining Ring Pliers	1
D	138-7575	Link Bracket	3
E	4C-8359	Eyebolt	2
F	138-7574	Link Bracket	2
G	138-7576	Link Bracket	2

**Start By:**

- a. Start by removing the final drive. Refer to Disassembly and Assembly, "Final Drive - Remove".

**Note:** Cleanliness is an important factor. Before the disassembly procedure, the exterior of the component should be thoroughly cleaned. This will prevent dirt from entering the internal mechanism.

1. Put an alignment mark across the sections of the final drive for assembly purposes. The parts must be reinstalled to the original locations.



Illustration 1

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2. Use Tooling (G) and a suitable lifting device to position the final drive assembly onto Tooling (A). The weight of the final drive assembly is approximately 550 kg (1200 lb).
3. Remove bolts (1).

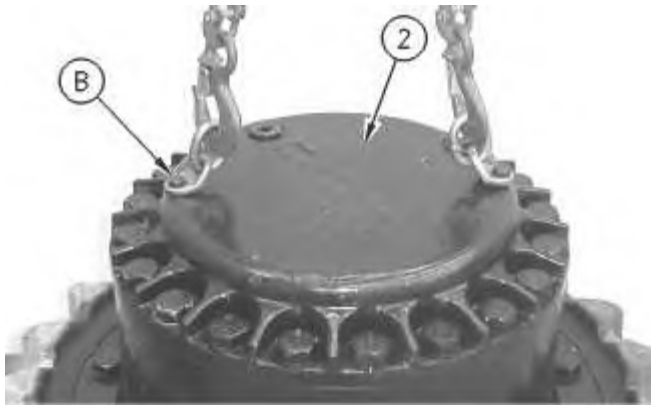


Illustration 2

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4. Use Tooling (B) and a suitable lifting device to remove cover (2). The weight of cover (2) is approximately 32 kg (70 lb).

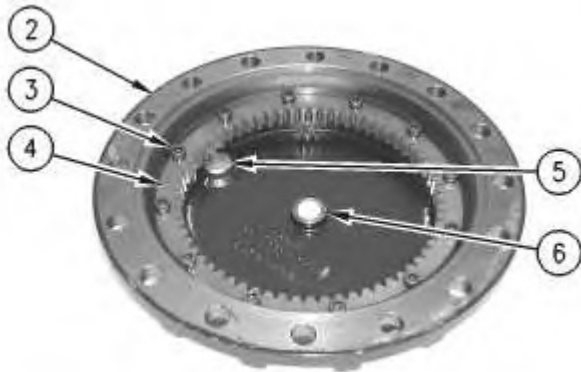


Illustration 3

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5. Remove bolts (3) and gear (4). Check plate (6). Replace plate (6) if plate (6) is worn. Remove plugs (5) from cover (2).



Illustration 4

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6. Remove O-ring seals (7) from plugs (5).



Illustration 5

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7. Remove gear (8) and spacer (9).



Illustration 6

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8. Use Tooling (C) to remove retaining ring (10). Remove washer (11) and gear (12). Remove bearing assembly (13) and washer (14).
9. Repeat Step 8 for the other two gear assemblies.

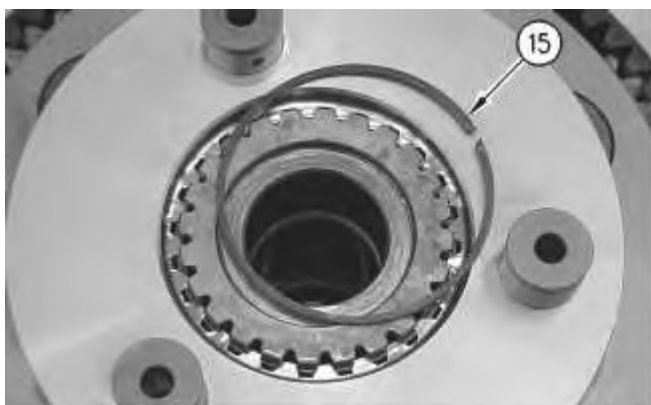


Illustration 7

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10. Remove retaining ring (15).

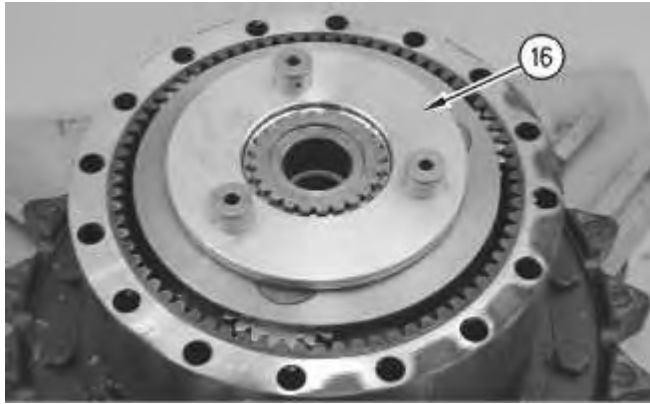


Illustration 8

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11. Remove carrier assembly (16).

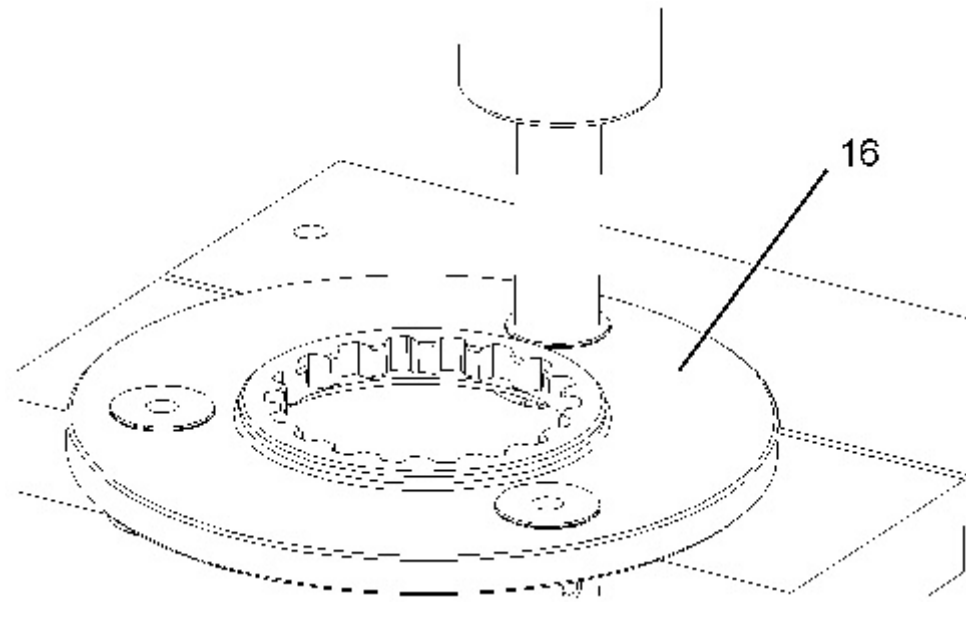


Illustration 9

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12. Use a suitable press to remove the shafts from carrier assembly (16).

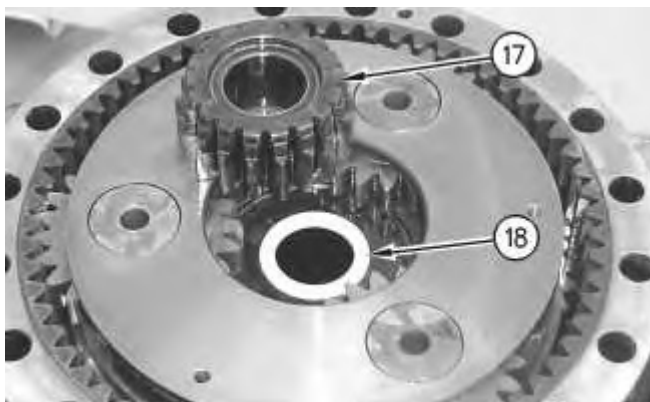


Illustration 10

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