



Service Repair Manual

Models

325D and 325D L Excavator

Assembly Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
B	1P-2420	Transmission Repair Stand	1
C	138-7575	Link Bracket	3
D	1P-0510	Driver Group	1
	1U-8605	Seal Guide	1
E	1P-1859	Retaining Ring Pliers	1
H	1U-6396	O-Ring Assembly Compound	1

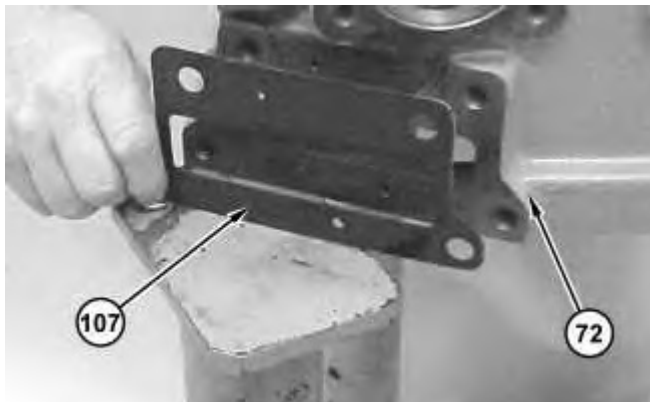


Illustration 1

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1. Install gasket (107) onto pump housing (72) .

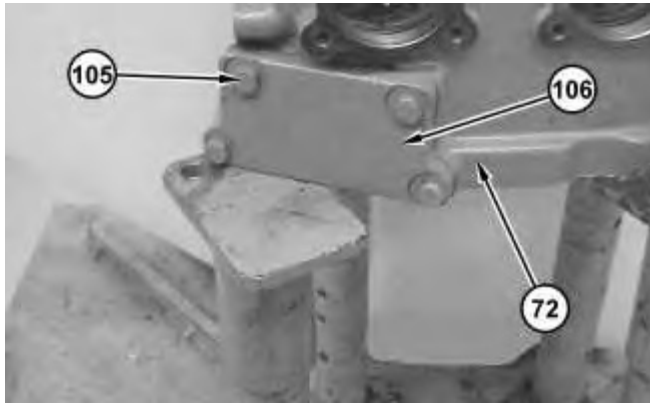


Illustration 2

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2. Install cover (106) and bolts (105) onto pump housing (72) .

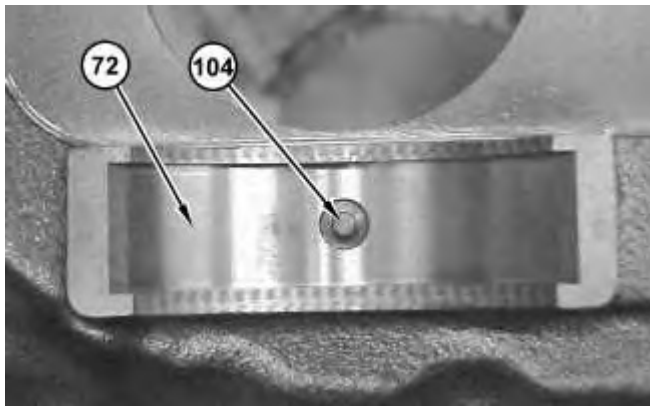


Illustration 3

g01200512

3. Install guide pins (104) onto pump housing (72) .



Illustration 4

g01200511

4. Install bearings (103) onto pump housing (72) .

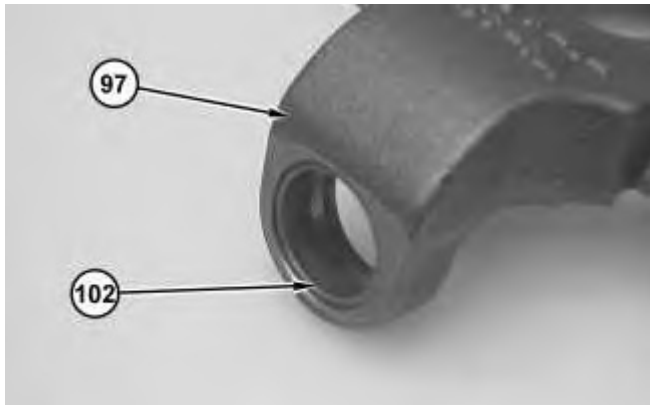


Illustration 5

g01200510

5. Install bearing (102) into swashplate (97) .



Illustration 6

g01200509

6. Install dowel pins (101) into swashplate (97) .



7. Install bearings (100) onto swashplate assembly (97) .



Illustration 8

8. Install plate (99) onto swashplate assembly (97) .
9. Repeat Step 5 through Step 8 for swashplate assembly (98) .

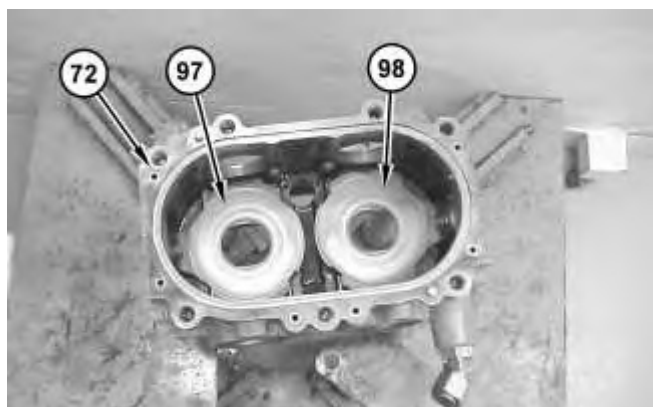


Illustration 9

10. Install swashplate assemblies (97) and (98) into pump housing (72) .

Note: The swashplate assemblies must be installed in the original position during assembly.

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