



# Service Repair Manual

## **Models**

# 651E WHEEL SCRAPER

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Product: WHEEL SCRAPER  
 Model: 651E WHEEL SCRAPER 5XR  
 Configuration: 651E Scraper 5XR00001-UP (MACHINE)

## Disassembly and Assembly 3408E and 3412E Engines for Caterpillar Built Machines

Media Number -SEN1013-11

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i03335401

## Gear Group (Rear) - Remove

SMCS - 1206-011; 1212-011

## Removal Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	1P-0483 <sup>(1)</sup>	Drive Plate	1
	1U-5839	Bearing Puller	1
B	FT-1342	Guide Bolt	2

<sup>(1)</sup> Part of the **1P-0510** Driver Group

### Start By:

- a. Remove the flywheel housing. Refer to Disassembly and Assembly, "Flywheel Housing - Remove and Install".

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### NOTICE

**Keep all parts clean from contaminants.**

**Contaminants may cause rapid wear and shortened component life.**

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**Note:** There are many possible configurations of the rear gear group and flywheel housing. The following procedure illustrates a typical example.

1. Use the following procedure for disassembly of the adapter assemblies.

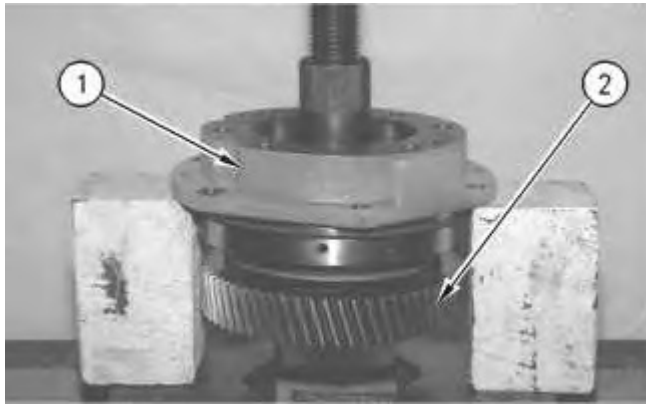


Illustration 1

g00586481

Typical example

- a. Support adapter assembly (1) so that the gear assembly can be pressed out of the adapter assembly. Press gear assembly (2) out of the adapter assembly.



Illustration 2

g00586630

Typical example

- b. Use Tooling (A) in order to remove bearing (3) from the gear assembly.

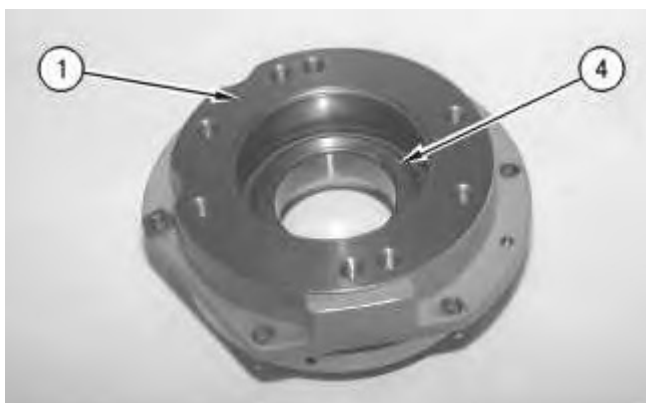


Illustration 3

g00586904

Typical example

- c. Use a press in order to remove bearing (4) from adapter assembly (1).

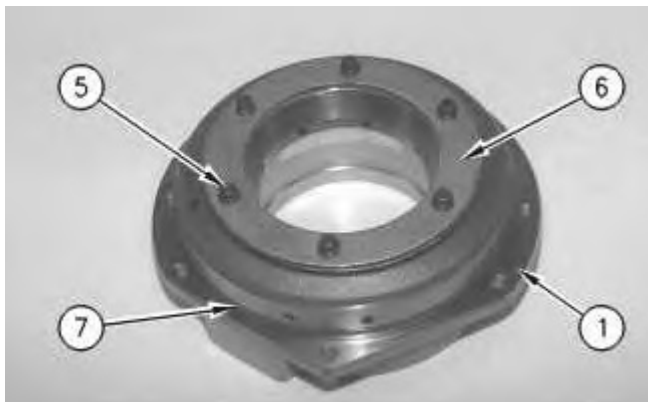


Illustration 4

g00586907

Typical example

- d. Remove bolts (5) and ring (6) from adapter assembly (1).

- e. Remove O-ring seal (7) from adapter assembly (1).



Illustration 5

g00586910

Typical example

- f. If necessary, remove race (8) from adapter assembly (1).

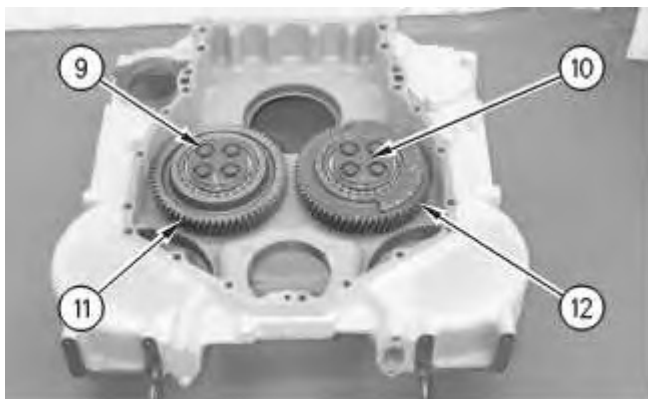


Illustration 6

g00587590

Typical example

2. With the flywheel housing in a horizontal position, remove bolts (9) from shafts (10).

**Note:** The bearings that are located toward the flywheel will fall when gear (11) and gear (12) are removed. Hold these bearings in position when the gears are removed.

3. Remove balancer gear (12) and idler gear (11).
4. Use the following procedure for disassembly of balancer gear (12).

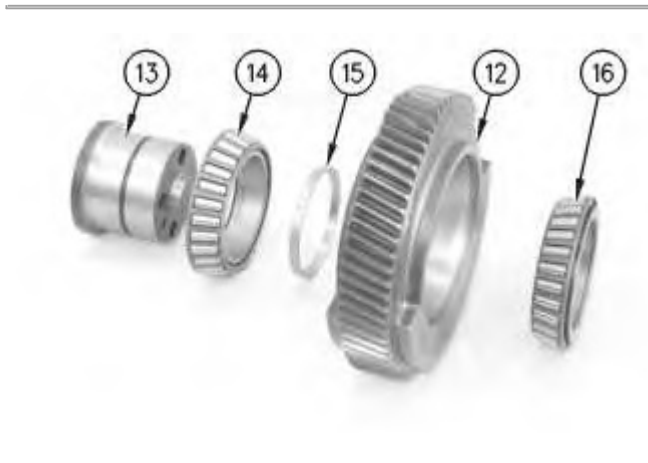


Illustration 7

g00587608

Typical example

- a. Remove shaft (13), spacer (15), bearing (14), and bearing (16) from balancer gear (12).



Illustration 8

g00587624

Typical example

- b. Remove bearing cup (17) from balancer gear (12).

**Note:** The bearing cups will be damaged from the removal. Use new parts for replacement.

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