



# Service Repair Manual

## **Models**

M318 Excavator

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Product: EXCAVATOR

Model: M318 EXCAVATOR 8AL

Configuration: M318 Excavator 8AL01020-UP (MACHINE) POWERED BY 3116 Engine

## Disassembly and Assembly M318 and M320 Excavators Power Train

Media Number -SEN6258-06

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i07432296

## Transmission - Assemble

SMCS - 3150-016

## Assembly Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	1U-5750	Engine Stand	1
	1U-7510	Adapter	1
	1U-7508	Adapter	1
B	136-1452	Internal Pliers	1
C	1U-5834	Sleeve	1
D	1P-1859	Retaining Ring Pliers	1
E	8T-5096	Dial Indicator	1
F	1P-0510	Driver	1
G	1P-1855	Retaining Ring Pliers	1
H	1P-1861	Retaining Ring Pliers	1
J	1P-0520	Driver	1
K	1P-1860	Retaining Ring Pliers	1
L	9U-6048	Seal Guide	1
M	9U-6071	Jig Assembly	1
N	9U-6049	Hydraulic Adapter	1
P	439-5246	Pump	1
	5S-2403	Nipple Fitting	1
	1S-8937	Needle Valve	1
	2D-7325	Pipe Tee	1

	8T-0855	Pressure Gauge	1
	6V-3966	Fitting	1
	6V-4143	Coupler	2
	177-7860	Hose Assembly	1
	6V-3965	Fitting	1
	3J-1907	O-Ring Seal	1
	8T-5114	Adapter	1
	8T-5115	Hose Assembly	1
Q	9U-6050	Cover	1
R	6V-7030	Micrometer Depth Gauge	1
S	1U-5826	Adjusting Screw	2
T	8B-7548	Push-Puller Tool Gp	1
	8B-7554	Bearing Cup Puller	1
	8B-7549	Puller Leg	2
	8S-6586	Forcing Screw	1
	7B-1756	Locknut	1
U	1P-1863	Retaining Ring Pliers	1
V	9U-6053	Seal Installer	1
W	-	Loctite LB 8632 Silicone Lubricant <sup>(1)</sup>	-
	-	Loctite LB 8104 Silicone Lubricant <sup>(2)</sup>	-
	-	Loctite LB 8801 Silicone Lubricant <sup>(3)</sup>	-
	-	Loctite LB Superlube <sup>(4)</sup>	-

<sup>(1)</sup> North America

<sup>(2)</sup> EAME

<sup>(3)</sup> Asia Pacific Division

<sup>(4)</sup> South America

**Note:** Cleanliness is an important factor. Before assembly, all parts should be thoroughly cleaned in cleaning fluid. Allow the parts to air dry. Wiping cloths or rags should not be used to dry parts. Lint may be deposited on the parts which may cause later trouble. Inspect all parts. If any parts are worn or damaged, use new parts for replacement. Replace all seals with new seals.

1. Fasten the transmission housing to Tooling (A).
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Illustration 1

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2. Install roller bearing (98) in flange (95). The roller bearing is a slip fit. Use Tooling (B) to install retaining ring (97) in the flange.

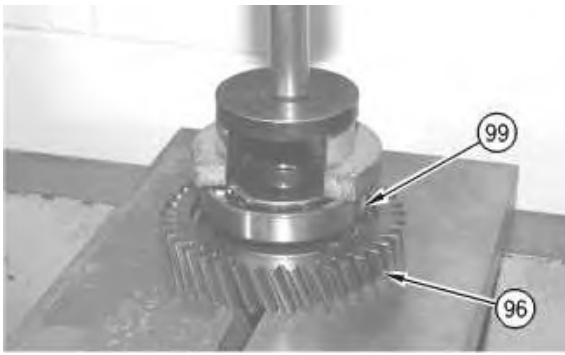


Illustration 2

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3. Use a press and a suitable sized sleeve to install bearing (99) on gear (96). Make sure that the bearing contacts with the shoulder on the gear.

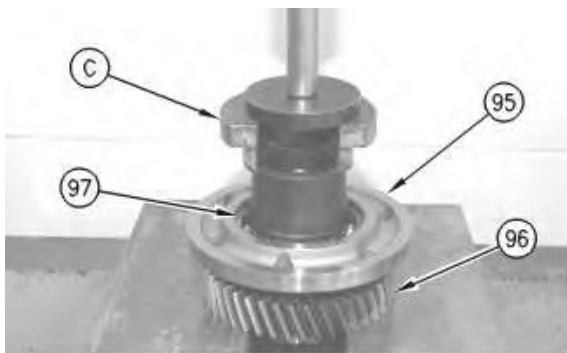


Illustration 3

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4. Use Tooling (C) and a press to install flange (95) on gear (96). Install the flange on the splined end of the gear. Install the flange with retaining ring (97) upward, as shown.



Illustration 4

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5. Install shifting collar (93) on gear (96), as shown.



Illustration 5

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**Note:** Washer (92) is available in several thicknesses. Washer (92) controls the end play of shifting collar (93).

6. Install the original washer (92) on gear (96). Use Tooling (D) to install retaining ring (91). ( )
7. Use Tooling (E) to check the end play of shifting collar (93). The end play of shifting collar (93) must not be more than 0.10 mm (.004 inch). If the end play is not correct, change the thickness of washer (92) to obtain the correct end play.



Illustration 6

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8. Use Tooling (F) and a press to install roller bearing (94) in the end of gear (96). Install the roller bearing until the roller bearing contacts with the shoulder in the gear. Install the roller bearing with the identification toward the outside of the gear.

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