



Service Repair Manual

Models

304E2CR Mini Hydraulic
Excavator

Product: MINI HYD EXCAVATOR

Model: 304E2 CR MINI HYD EXCAVATOR CJ2

Configuration: 304E 2CR Mini Hydraulic Excavator CJ200001-UP (MACHINE) POWERED BY C2.4 Engine

Disassembly and Assembly

C1.7, C1.8 and C2.4 Tier 4 Interim and EU Stage 3A Engines for Caterpillar Built Machines

Media Number -UENR0128-11

Publication Date -01/08/2015

Date Updated -09/06/2016

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Crankshaft Rear Seal - Install

SMCS - 1161-012

Installation Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	387-1352	Wear Sleeve Installer and Guide	1
B	1P-0520	Driver	1
C	-	Loctite 17430	1

NOTICE

Keep all parts clean from contaminants.

Contaminants may cause rapid wear and shortened component life.

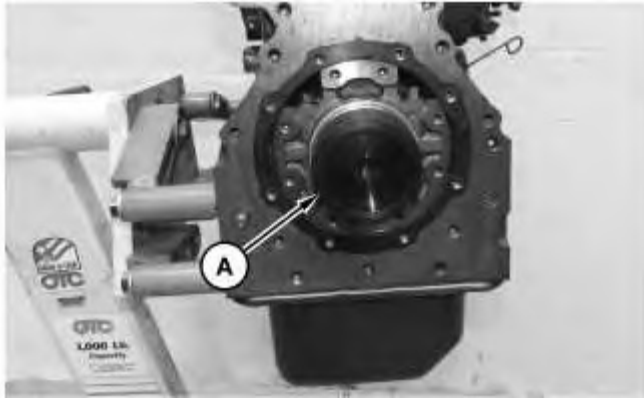


Illustration 1

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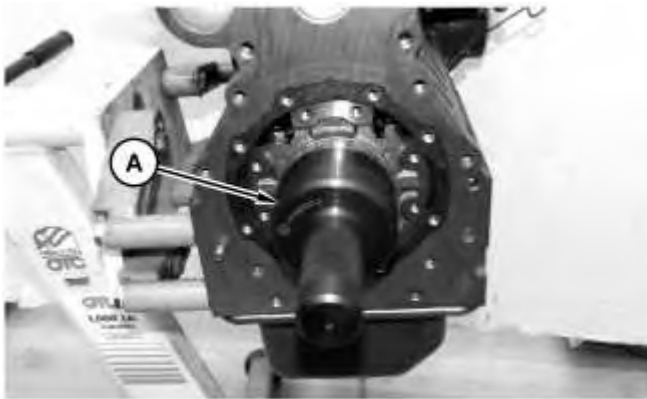


Illustration 2

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1. Position wear sleeve (4) on Tooling (A). Ensure that the crankshaft flange is clean, dry, and free from damage.
2. Apply Tooling (C) and use Tooling (A) to install the wear sleeve.

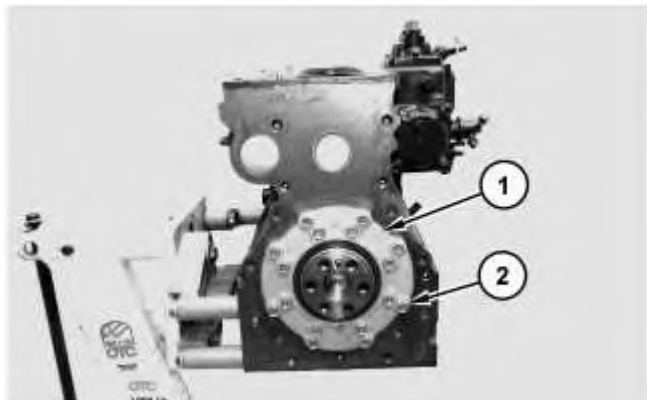


Illustration 3

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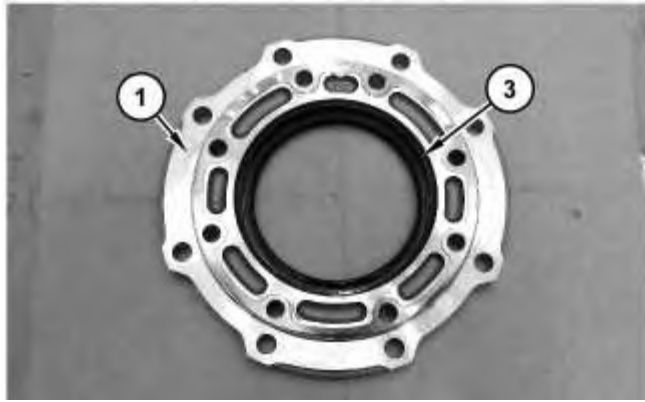


Illustration 4

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Note: Do not lubricate the crankshaft rear seal or the crankshaft flange. The crankshaft rear seal must be installed dry. Lubricate the inner rubber portion of the crankshaft rear seal.

3. Use Tooling (B) to install a new crankshaft rear seal (3) in bearing case cover (1).
4. Position the gaskets and bearing case cover (1) and install bolts (2). Position bearing case cover (1) with marking UP upward.
5. Apply engine oil to bolts (2).
6. Tighten bolts (2) to a torque of 24 to 27 N·m (18 to 20 lb ft). Tighten bolts (2) with an equal force on diagonal line.

End By:

- a. Install the flywheel.

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Flywheel Housing - Remove and Install

SMCS - 1157-010

Removal Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	-	Guide Stud M10 by 100 mm	2

Start By:

- a. Remove the flywheel.

NOTICE

Keep all parts clean from contaminants.

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