



Service Repair Manual

Models

322C FM EXCAVATOR

Product: EXCAVATOR

Model: 322C FM EXCAVATOR CBY

Configuration: 322C FOREST SWING MACHINES CBY00001-UP (MACHINE) POWERED BY 3126 Engine

Disassembly and Assembly 322C Forest Machine Machine Systems

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i01755050

Main Hydraulic Pump and Pump Drive Coupling - Install

SMCS - 5070-012-MV; 5234-012-MV

Installation Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	FT-2674	Vacuum Cap	1
B	138-7573	Link Bracket	1
C	138-7575	Link Bracket	2

NOTICE

Care must be taken to ensure that fluids are contained during performance of inspection, maintenance, testing, adjusting and repair of the product. Be prepared to collect the fluid with suitable containers before opening any compartment or disassembling any component containing fluids.

Refer to Special Publication, NENG2500, "Caterpillar Tools and Shop Products Guide" for tools and supplies suitable to collect and contain fluids on Caterpillar products.

Dispose of all fluids according to local regulations and mandates.

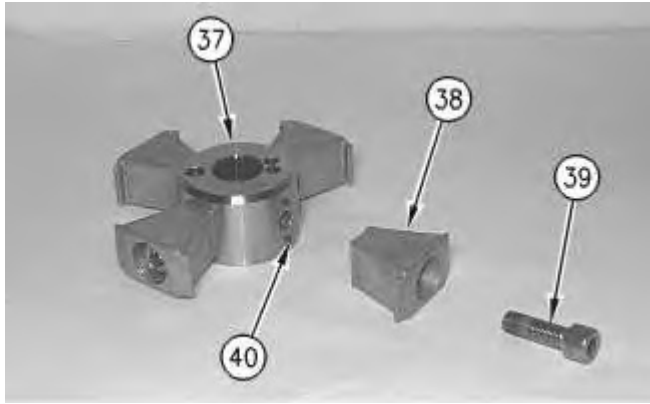


Illustration 1

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1. Install alignment pins (40) in coupling assembly (37) .
2. Install inserts (38) and socket head bolts (39) in coupling assembly (37) .
3. Tighten socket head bolts (39) to a torque of $220 \pm 10 \text{ N}\cdot\text{m}$ ($162 \pm 7 \text{ lb ft}$).

Note: Make sure that the splined shaft of the main hydraulic pump is clean. Apply **5P-0960** Molybdenum Grease on the splined shaft.

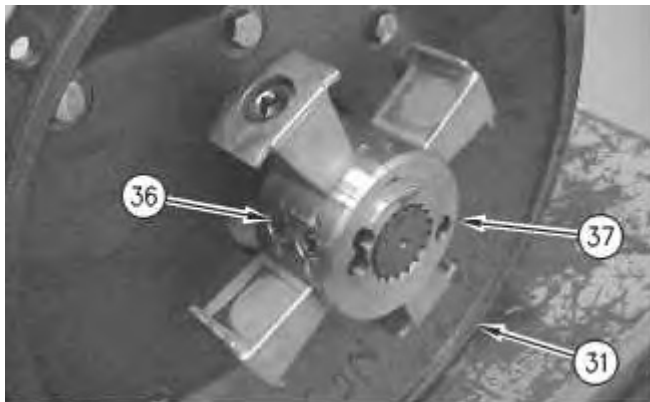


Illustration 2

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4. Install coupling assembly (37) on the splined shaft of main hydraulic pump (31) .
5. Install the coupling assembly until the coupling assembly is even with the end of the splined shaft. If necessary, use a soft faced hammer to locate the coupling assembly on the splined shaft. Use a straight edge to be sure that the end of the coupling assembly is even with the end of the splined shaft.
6. Install setscrews (36) .
7. Tighten setscrews (36) to a torque of $110 \pm 10 \text{ N}\cdot\text{m}$ ($80 \pm 7 \text{ lb ft}$).



Illustration 3

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8. Install alignment pins (35) on the flywheel.

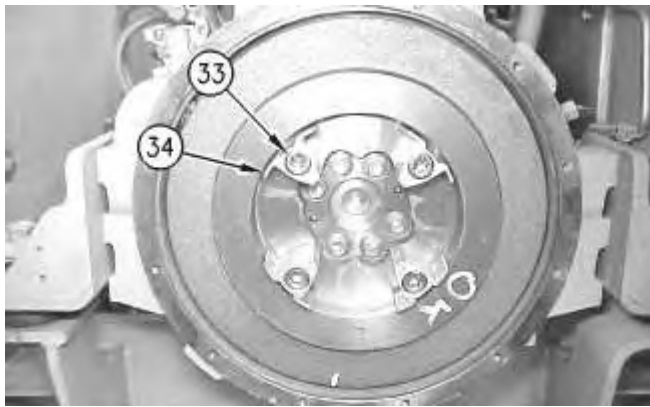


Illustration 4

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9. Install inserts (34) and socket head bolts (33) .
10. Tighten socket head bolts (33) to a torque of 220 ± 10 N·m (162 ± 7 lb ft).

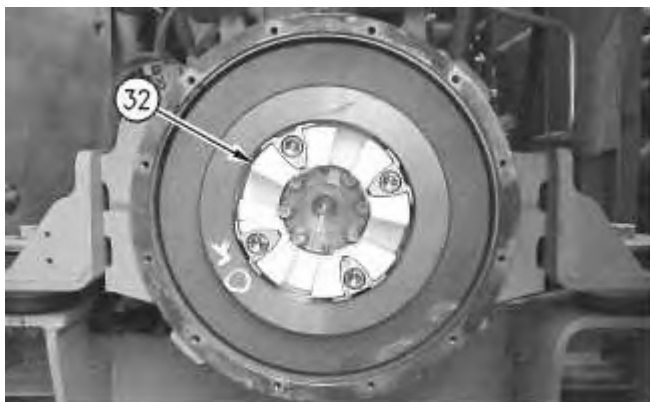


Illustration 5

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11. Install coupling element (32) .

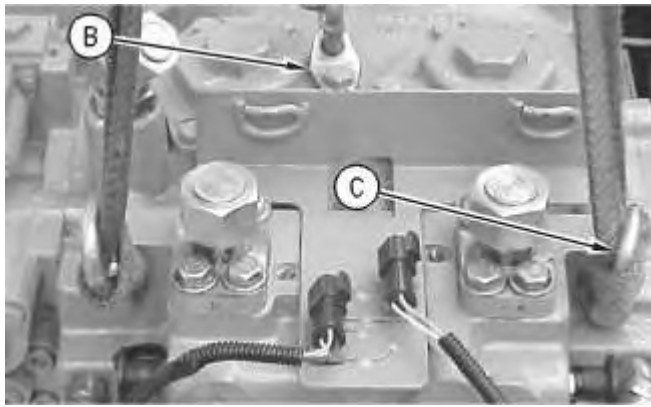


Illustration 6

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12. Attach Tooling (B), Tooling (C), and a suitable lifting device to the main pump. The combined weight of the main hydraulic pump and the pump drive coupling is approximately 213 kg (470 lb).

Note: Attach a ratchet puller to Tooling (B). This will allow you to balance the main pump.

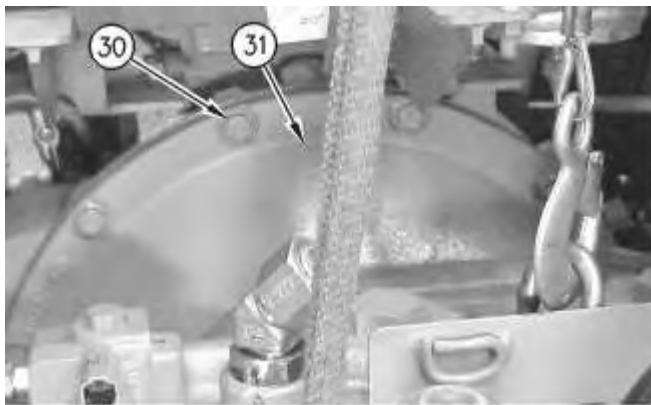


Illustration 7

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13. Carefully, install the main hydraulic pump (31) on the engine flywheel housing.
14. Make sure that the coupling assemblies are in alignment with each other. Push the main hydraulic pump against the flywheel housing.

Note: The main hydraulic pump must be kept level during installation in order to prevent the binding of the pump drive coupling in the engine flywheel.

15. Install the washers and bolts (30) that secure the main hydraulic pump to the flywheel housing.
16. Remove Tooling (B) and Tooling (C) .

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