



Service Repair Manual

Models

322C FM EXCAVATOR

Product: EXCAVATOR

Model: 322C FM EXCAVATOR LAR

Configuration: 322C Forest Swing Machines LAR00001-UP (MACHINE) POWERED BY 3126B Engine

Disassembly and Assembly 3126B Engines for Caterpillar Built Machines

Media Number -SEN9581-06

Publication Date -01/08/2018

Date Updated -17/08/2018

i01518323

Crankshaft Main Bearings - Install

SMCS - 1203-012

Installation Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	2P-5518	Main Bearing Tool	1
B	8T-5096	Dial Indicator Group	1

NOTICE

Keep all parts clean from contaminants.

Contaminants may cause rapid wear and shortened component life.

Note: Place clean engine oil on the crankshaft main bearings prior to assembly. Ensure that the tabs on the back side of the crankshaft main bearings fit in the grooves of the crankshaft main bearing caps and the cylinder block.

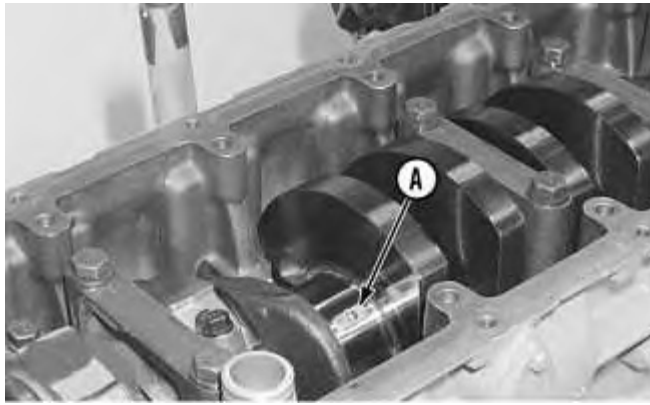


Illustration 1

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1. Use Tool (A) and install the upper halves of the crankshaft main bearings in the cylinder block. Do not put oil on the back of the crankshaft main bearing.

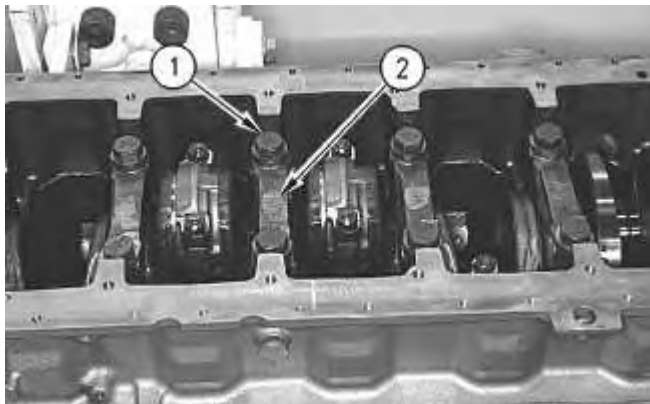


Illustration 2

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2. Install the lower halves of the crankshaft main bearings in crankshaft main bearing caps (2). Do not put oil on the back of the crankshaft main bearing.

NOTICE

Crankshaft main bearing caps should be installed with the part number toward the right side of the engine. Crankshaft main bearing caps are to be identified by stamped numbers 1 through 7 located on the bottom surface. The thrust plate is used on the number 6 crankshaft main bearing only.

3. Place crankshaft main bearing caps (2) in position on the cylinder block. Place clean engine oil or Molylube on the bolt threads and on the washer face. Install bolts (1).
 4. Tighten bolts (1) to a torque of $54 \pm 7 \text{ N}\cdot\text{m}$ ($40 \pm 5 \text{ lb ft}$). Tighten each bolt (1) for an additional 90 ± 5 degrees ($1/4$ turn).
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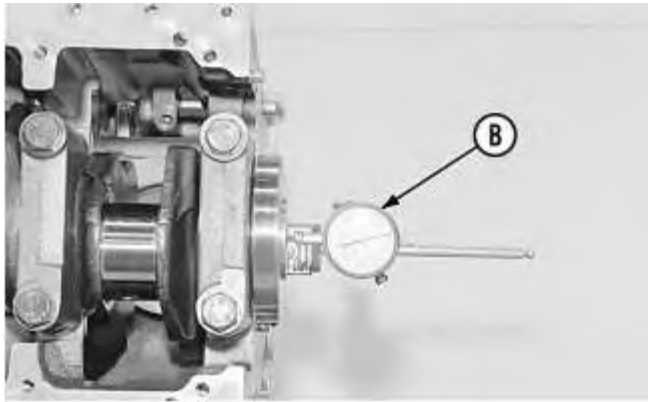


Illustration 3

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5. Check the end play of the crankshaft with Tool (B). The end play must be 0.07 mm (0.003 inch) to 0.32 mm (0.013 inch).

End By:

- a. Install the engine oil pump. Refer to Disassembly and Assembly, "Engine Oil Pump - Install".

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Crankshaft - Remove

SMCS - 1202-011

Removal Procedure

Start By:

- a. Remove the flywheel housing. Refer to Disassembly and Assembly, "Flywheel Housing - Remove and Install".
- b. Remove the engine oil pump. Refer to Disassembly and Assembly, "Engine Oil Pump - Remove".
- c. Remove the front housing. Refer to Disassembly and Assembly, "Housing (Front) - Remove".

NOTICE

Keep all parts clean from contaminants.

Contaminants may cause rapid wear and shortened component life.

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