



# Service Repair Manual

## **Models**

**M322D MH WHEELED  
EXCAVATOR**

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Product: WHEELED EXCAVATOR

Model: M322D WHEELED EXCAVATOR P2T

Configuration: M322D Wheeled Excavator P2T00001-UP (MACHINE) POWERED BY C6.6 Engine

## Disassembly and Assembly M316D, M318D and M322D Wheeled Excavators Machine Systems

Media Number -UENR0123-01

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i06875517

# Piston Pump (Main Hydraulic) - Assemble

SMCS - 5070-016-HR

## Assembly Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	1P-1861	Retaining Ring Pliers	1
C	464-4892 <sup>(1)</sup>	Test Ring	1
	128-2746 <sup>(2)(3)</sup>	Test Ring	1
	137-1329 <sup>(4)</sup>	Test Pins	3
D	129-3873	Measuring Hub	1
	129-3874 <sup>(2)(3)</sup>	Measuring Hub	1
	137-1326 <sup>(4)</sup>	Measuring Hub	1
E	128-2744	Measuring Bell	1
	129-3876 <sup>(4)</sup>	Measuring Bell	1
F	-	Vernier Height Gauge	1
G	1P-0510	Driver Gp	1
H	464-4893 <sup>(1)</sup>	Alignment Plug	1
	128-2742 <sup>(2)</sup>	Alignment Plug	1
	437-5508 <sup>(3)</sup>	Alignment Plug	1

	137-1331 <sup>(4)</sup>	Alignment Plug	1
J	-	Loctite 242	-

<sup>(1)</sup> Use for 95 cc pumps.

<sup>(2)</sup> Use for 130 cc pumps.

<sup>(3)</sup> Use for 145 cc pumps.

<sup>(4)</sup> Use for 190 cc pumps.

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## NOTICE

**Keep all parts clean from contaminants.**

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

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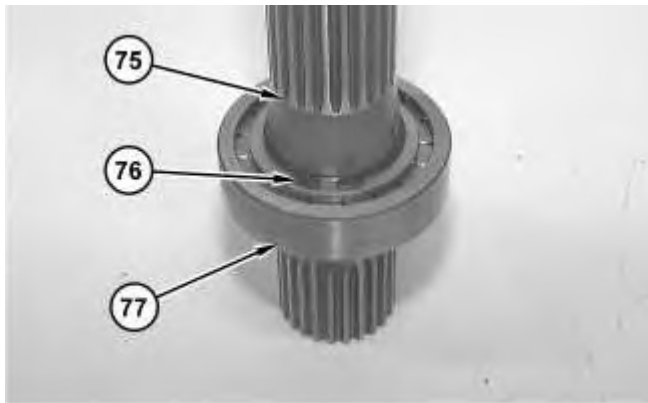


Illustration 1

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1. Use Tooling (A) to install bearing (77) to shaft (75). Raise the temperature of bearing (77). Install retaining ring (76) to shaft (75).

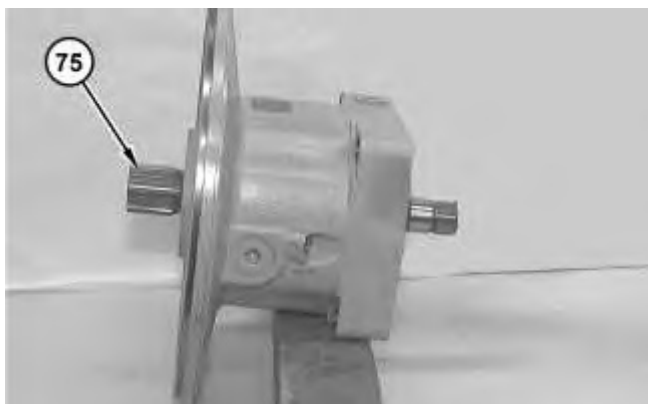


Illustration 2

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2. Install shaft (75) into the piston pump.

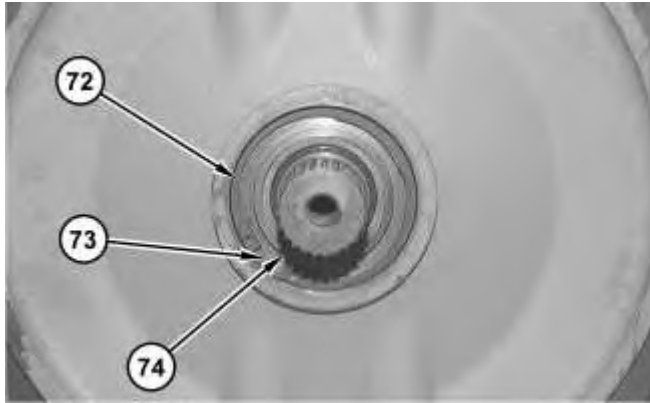


Illustration 3

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3. Use Tooling (A) to install retaining ring (74).

4. Use Tooling (G) to install seal (73).

5. Use Tooling (A) to install retaining ring (72).

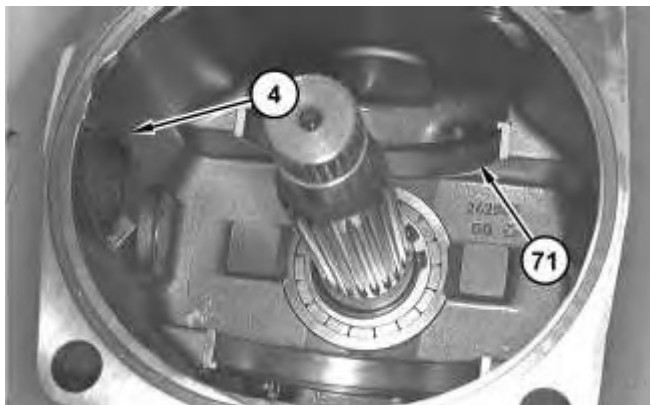
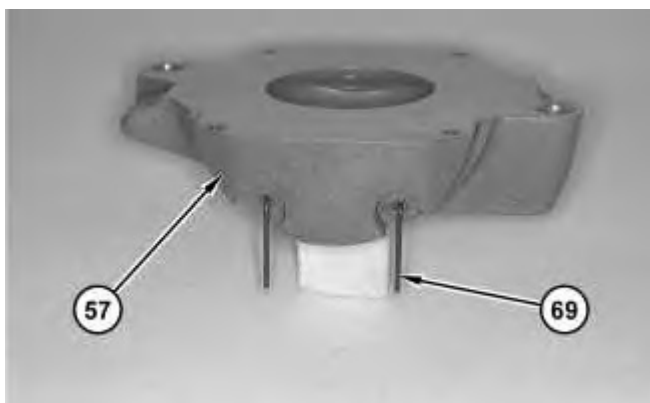


Illustration 4

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6. Install outer races (71) to piston pump (4).



7. Install rods (69) to swashplate (57).

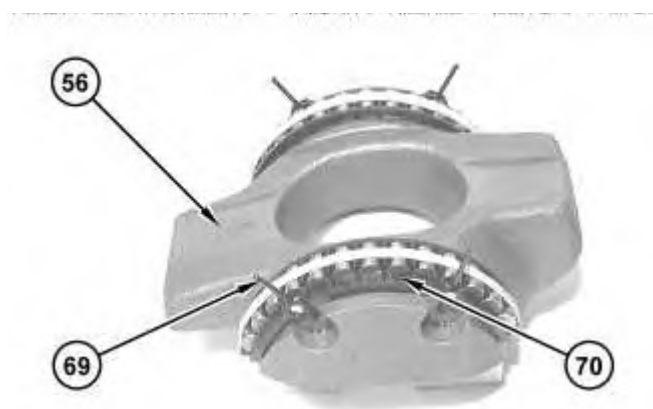


Illustration 6

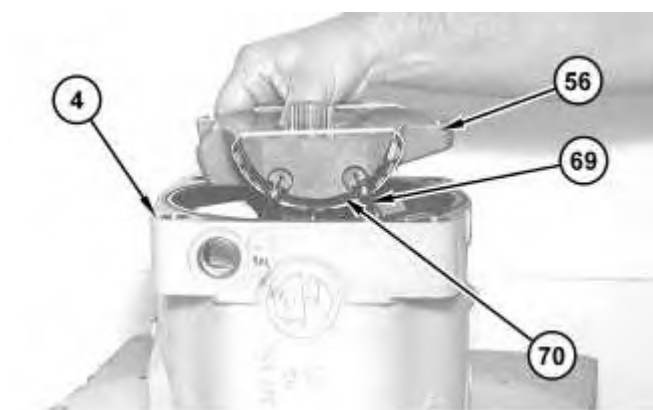


Illustration 7

8. Install bearings (70) to swashplate (56). Install a rubber band to each of bearings (70). The rubber band will hold bearings (70) to swashplate (56).
9. Carefully install swashplate (56) to piston pump (4).



Illustration 8

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