

Product: MINI HYD EXCAVATOR

Model: 305E2 CR MINI HYD EXCAVATOR R5C

Configuration: 305E2CR Mini Hydraulic Excavator R5C00001-UP (MACHINE) POWERED BY C2.4 Engine

## Disassembly and Assembly

### C2.4 Tier 4 Final Engines for Caterpillar Built Machines

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i06546123

## Flywheel - Remove and Install

SMCS - 1156-010

### Removal Procedure

Table 1

Required Tooling			
Tool	Part Number	Part Description	Qty
A	421-5660	Lifting Eye Assembly	1
B	—	Guide Stud 12 mm - 1.25 - by 100 mm	2

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### NOTICE

**Keep all parts clean from contaminants.**

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

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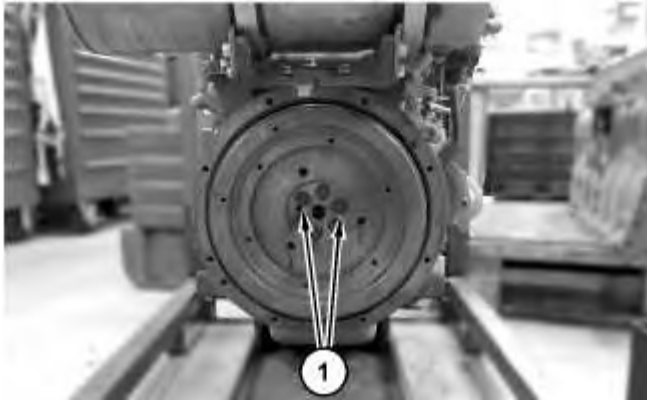


Illustration 1

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1. Insert the flywheel stopper tool.
2. Remove bolts (1).

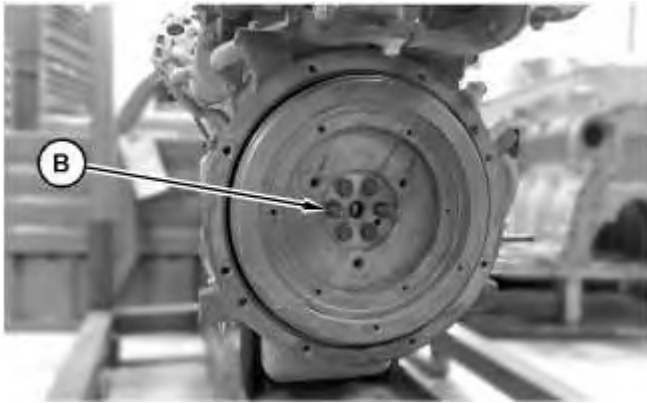


Illustration 2

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3. Insert Tooling (B).



Illustration 3

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4. Use Tooling (A) and a suitable lifting device to remove flywheel (2). The weight of flywheel (2) is approximately 25 kg (55 lb).

5. Remove remaining bolts (1) and flywheel (2).

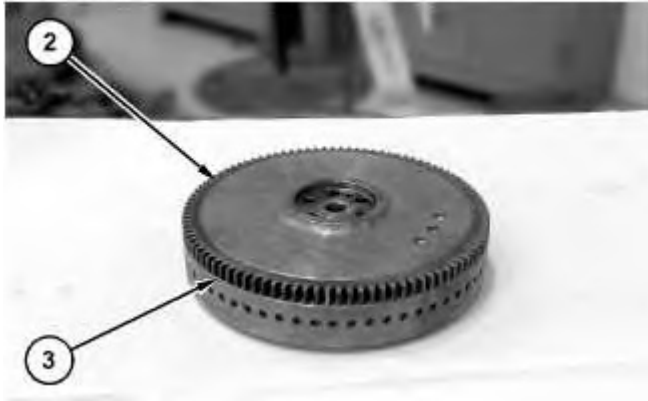


Illustration 4

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6. Inspect flywheel (2) and ring gear (3) for wear and damage. Replace any worn components or damaged components.
7. If necessary, remove flywheel gear (3), follow Step 7.a through Step 7.b
  - a. Place flywheel (2) on a suitable support.
  - b. Use a suitable hammer and a punch to remove ring gear (3) from flywheel (2). If necessary, a torch may be needed to heat ring gear (3).

**Note:** Identify the orientation of the teeth on the flywheel ring gear (3).

## Installation Procedure

1. Install flywheel (2) in the reverse order of removal.
  - a. Apply clean engine oil to the threads of bolts (1).
  - b. Tighten bolts (1) to a torque of 98 N·m to 108 N·m (72 lb ft to 80 lb ft).

**Note:** Do not use a pneumatic device, serious damage will occur.

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