



Service Repair Manual

Models

323D LN and 323D S Excavator

Product: EXCAVATOR

Model: 323D S EXCAVATOR DKW

Configuration: 323D LN & 323D S Excavators DKW00001-UP (MACHINE) POWERED BY 3066 Engine

Disassembly and Assembly 3064 and 3066 Engines for Caterpillar Built Machines

Media Number -SEN5553-10

Publication Date -01/05/2012

Date Updated -15/05/2012

i01567208

Flywheel - Remove

SMCS - 1156-011

Removal Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	138-7575	Link Bracket	1
B		Forcing screws M16 X 2	2

NOTICE

Keep all parts clean from contaminants.

Contaminants may cause rapid wear and shortened component life.



Illustration 1

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1. Remove twelve bolts (1) and washers from the adapter (2) .
2. Remove the adapter (2) from the flywheel housing.

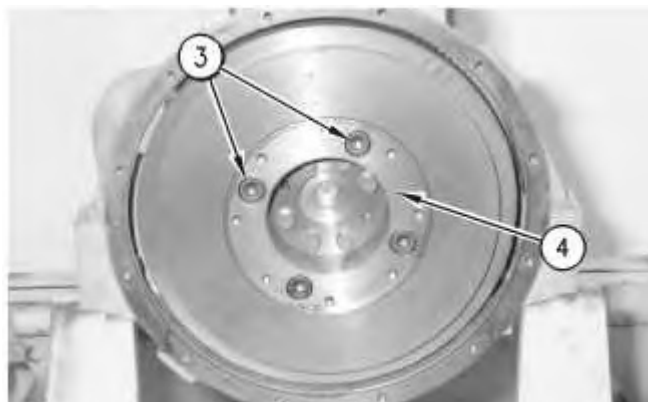
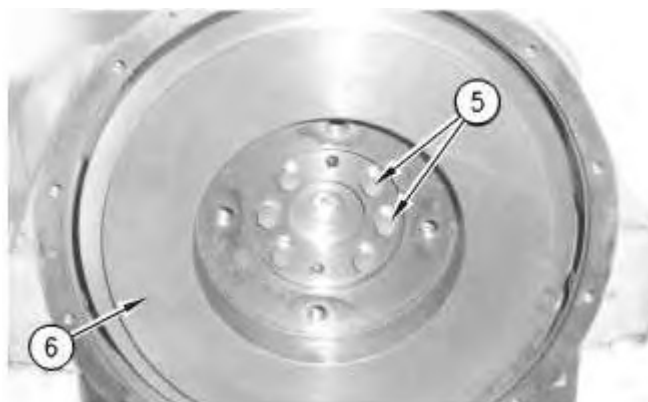


Illustration 2

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3. Remove four socket head bolts (3) from the inner ring (4) .
4. Remove the inner ring (4) from the flywheel.



5. Remove six bolts (5) that secure flywheel (6) to the crankshaft. Check all bolts for stripped threads. Replace the bolts, if necessary.

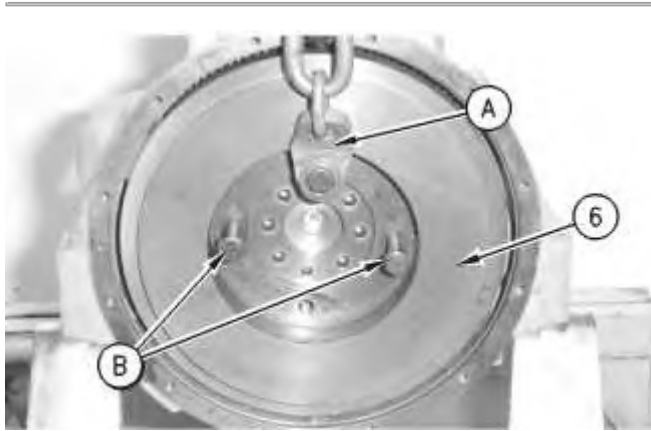


Illustration 4

6. Install Tool (A), a strap, and a suitable lifting device onto the flywheel (6).
7. Use Tool (B) in order to remove the flywheel and ring gear out of the housing. The weight of the flywheel is 50 kg (110 lb).
8. Perform the following procedure in order to remove the flywheel ring gear.

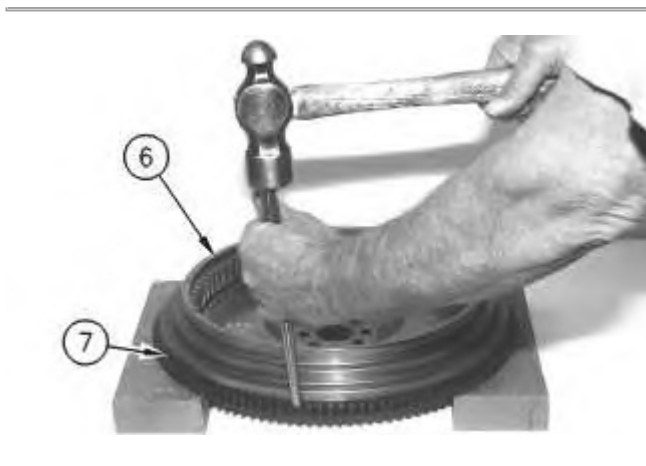


Illustration 5

- a. Place the flywheel and ring gear assembly on a suitable support.

Note: Check the flywheel ring gear for the following conditions: cracks, damaged dowel holes, worn ring gear and damaged ring gear.

Note: Identify the orientation of the old ring gear on the flywheel for proper positioning, when the new ring gear is installed.



WARNING

Always wear protective gloves when handling parts that have been heated.

- b. Heat ring gear (7) uniformly.
- c. Remove the ring gear (7) by tapping the ring gear all the way around the flywheel (6) .
- d. Reposition the flywheel in order to remove the ring gear.

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Media Number -SEN5553-10

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i01567260

Flywheel - Install

SMCS - 1156-012

Installation Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	138-7575	Link Bracket	1

NOTICE

Keep all parts clean from contaminants.

Contaminants may cause rapid wear and shortened component life.



WARNING

Always wear protective gloves when handling parts that have been heated.

1. Perform the following procedure, if the ring gear was removed from the flywheel:
 - a. Heat the ring gear to 150 °C (302 °F) in an oven.

- b. Press the ring gear onto the flywheel.

Note: Prior to the installation of the flywheel, refer to Specifications, "Flywheel" for information on checking the flywheel assembly for flatness.

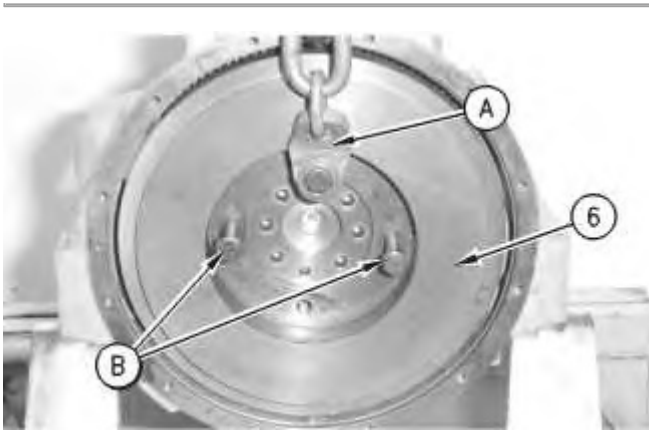


Illustration 1

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2. Install Tool (A), a strap, and a suitable lifting device onto flywheel (6) .
3. Install flywheel (6). The weight of the flywheel is 50 kg (110 lb).

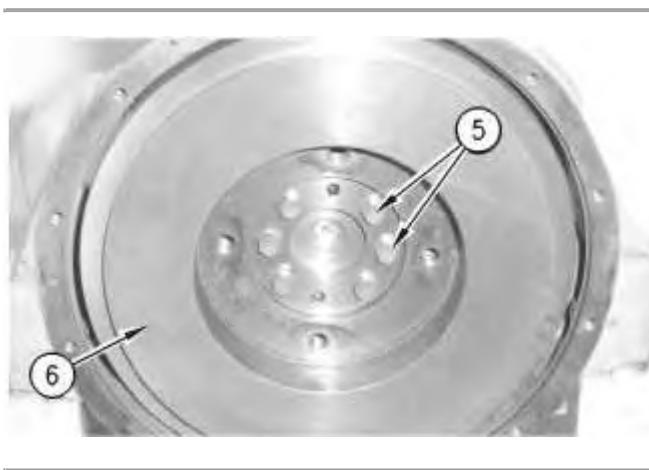


Illustration 2

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4. Install six bolts (5) in order to secure flywheel (6) onto the crankshaft. Tighten the bolts to a torque of 83 ± 5 N·m (61 ± 4 lb ft).
 5. Remove Tool (A) from the flywheel.
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