

Product: EXCAVATOR
Model: 325C EXCAVATOR BLA
Configuration: ISJ HEX COMMONALITY CHART BLA00001-UP (MACHINE)

Disassembly and Assembly 3126B Engines for Caterpillar Built Machines

Media Number -SEN9581-06

Publication Date -01/08/2018

Date Updated -17/08/2018

i01980480

Flywheel - Remove and Install

SMCS - 1156-010

Removal Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	138-7573	Link Bracket	2
B	FT2712	Guide Stud	2

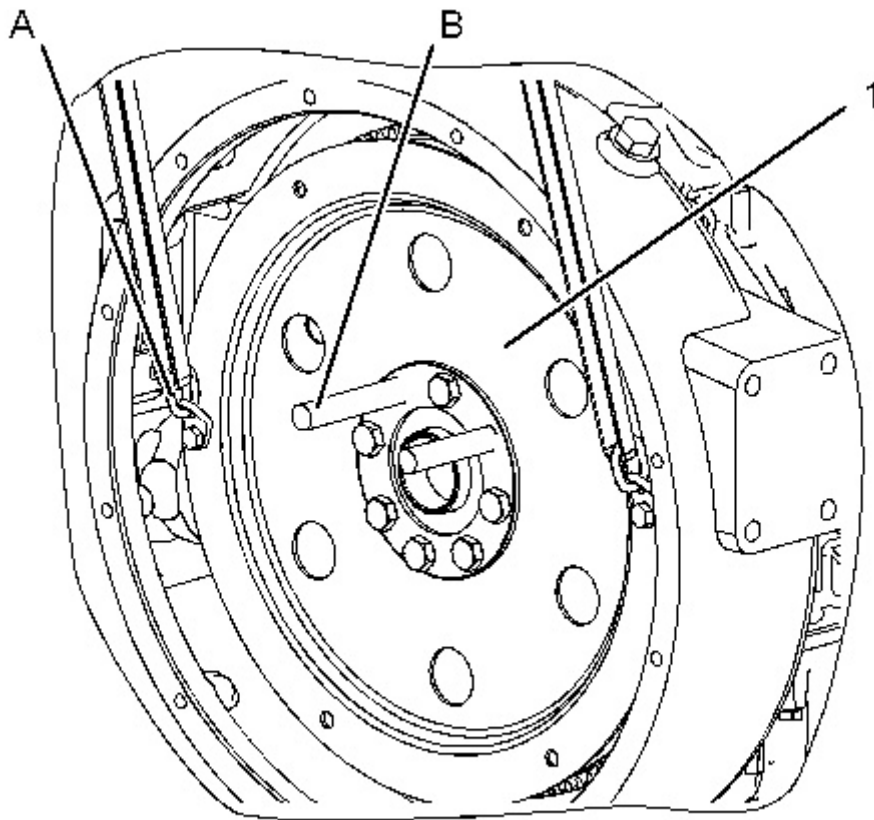


Illustration 1

g01026562

1. Install Tooling (A) on the flywheel. Fasten a suitable lifting device to the flywheel. The weight of flywheel (1) is approximately 23 kg (50 lb).
2. Remove two bolts and install Tooling (B). Remove the remaining bolts.
3. Remove flywheel (1).
4. Place the flywheel on a wood block. Use a hammer and a punch in order to remove the flywheel ring gear.

Installation Procedure

Table 2

Required Tools			
Tool	Part Number	Part Description	Qty
A	138-7573	Link Bracket	2
B	FT2712	Guide Stud	2
C	9S-3263	Thread Lock Compound	1

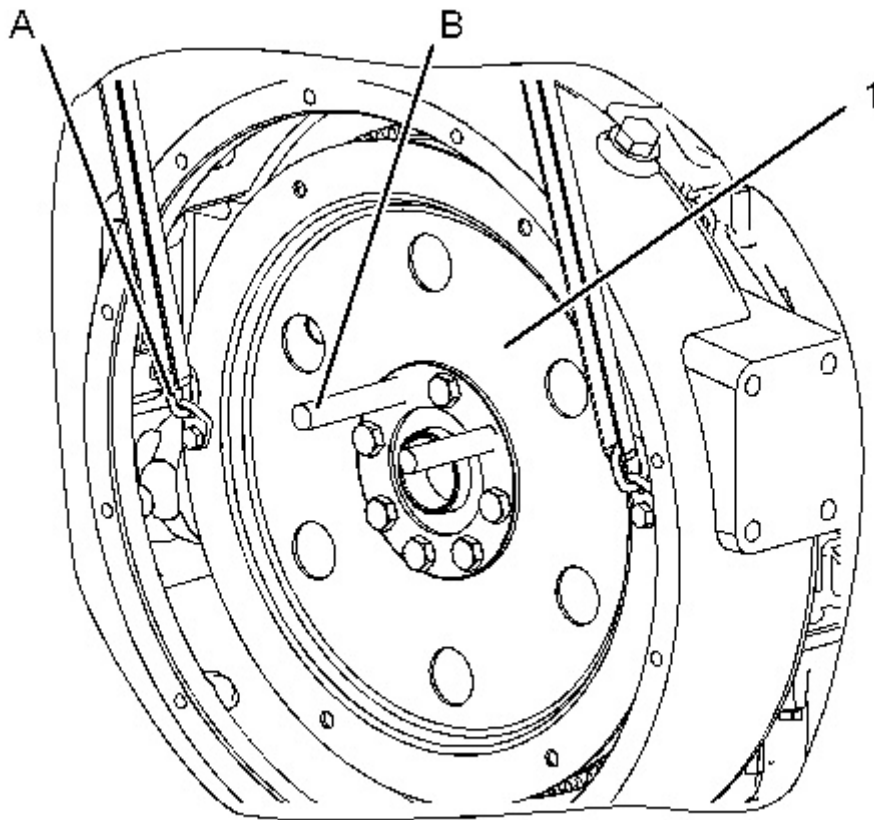


Illustration 2

g01026562

1. Raise the temperature of the flywheel ring gear. Do not use a torch to heat the flywheel ring gear. Position the flywheel ring gear on the flywheel with the part number toward the crankshaft.
 2. Use a suitable lifting device to position flywheel (1) on Tooling (B). The weight of flywheel (1) is approximately 23 kg (50 lb).
 3. Apply Tooling (C) to the threads of the bolts. Install the bolts. Remove Tooling (B) and install the remaining bolts.
 4. Tighten the bolts evenly to a torque of 120 ± 20 N·m (90 ± 15 lb ft).
 5. Check the flywheel runout. Refer to Testing and Adjusting, "Flywheel - Inspect" for the correct procedure.
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i01980554

Crankshaft Rear Seal - Remove

SMCS - 1161-011

Removal Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	1U-8145	Drill Bit	1
B	1U-7600	Slide Hammer Puller Gp	1
C	4C-4869	Distorter Ring	1
D	5P-7312	Seal Distorter	1

Start By:

- a. Remove the flywheel. Refer to Disassembly and Assembly, "Flywheel - Remove".

NOTICE

Keep all parts clean from contaminants.

Contaminants may cause rapid wear and shortened component life.

1. Use Tooling (A) to drill three evenly spaced holes in the crankshaft rear seal.
-

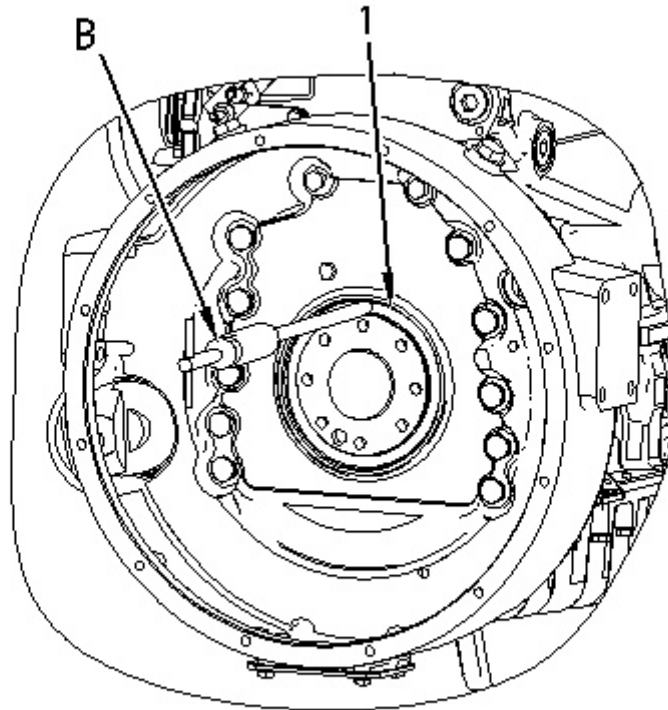


Illustration 1

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2. Carefully remove crankshaft rear seal (1) by alternating the position of Tooling (B) from hole to hole. This will allow crankshaft rear seal (1) to be removed evenly without damage to the rear flange surface of the crankshaft.

Note: New engines from the factory do not have a wear sleeve. Engines with seals that have been replaced will be equipped with a wear sleeve. If the crankshaft of the engine is equipped with a wear sleeve, refer to Disassembly and Assembly, "Crankshaft Wear Sleeve (Rear) - Remove" in order to remove the wear sleeve.

3. Use Tooling (C) and Tooling (D) to remove the wear sleeve (if equipped).
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i01980581

Crankshaft Rear Seal - Install

SMCS - 1161-012

Installation Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
E	1U-7598	Seal Installer Gp	1

NOTICE

Keep all parts clean from contaminants.

Contaminants may cause rapid wear and shortened component life.

Note: Replacement rear seals are supplied with a wear sleeve. This wear sleeve must be installed with the rear seal. New engines from the factory do not have a wear sleeve. Do not install the rear seal if any of the following conditions exist:

- The crankshaft rear seal has been separated from the wear sleeve.
- The rear seal group appears to be damaged.
- The crankshaft rear seal has been lubricated. The seal is designed to be installed dry.

1. Ensure that the rear of the crankshaft is thoroughly clean and dry prior to the installation of the crankshaft rear seal.
-

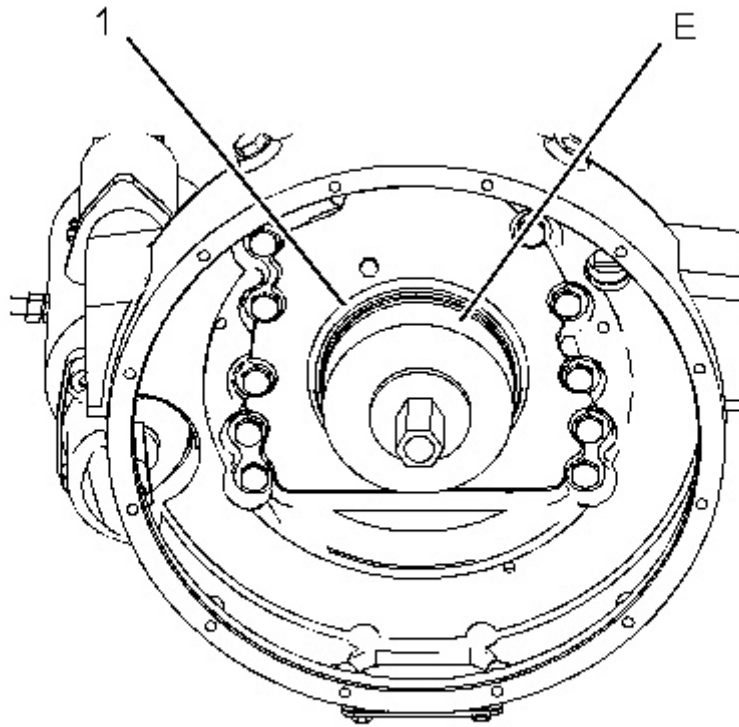


Illustration 1
Typical example

g01026625

2. Use Tooling (E) to install crankshaft rear seal (1).

End By:

- a. Install the flywheel. Refer to Disassembly and Assembly, "Flywheel - Install".
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i01987820

Crankshaft Rear Seal Carrier - Remove and Install

SMCS - 1161-010-C3

Removal Procedure

Start By:

- a. Remove the flywheel housing. Refer to Disassembly and Assembly, "Flywheel Housing - Remove and Install".

NOTICE

Keep all parts clean from contaminants.

Contaminants may cause rapid wear and shortened component life.

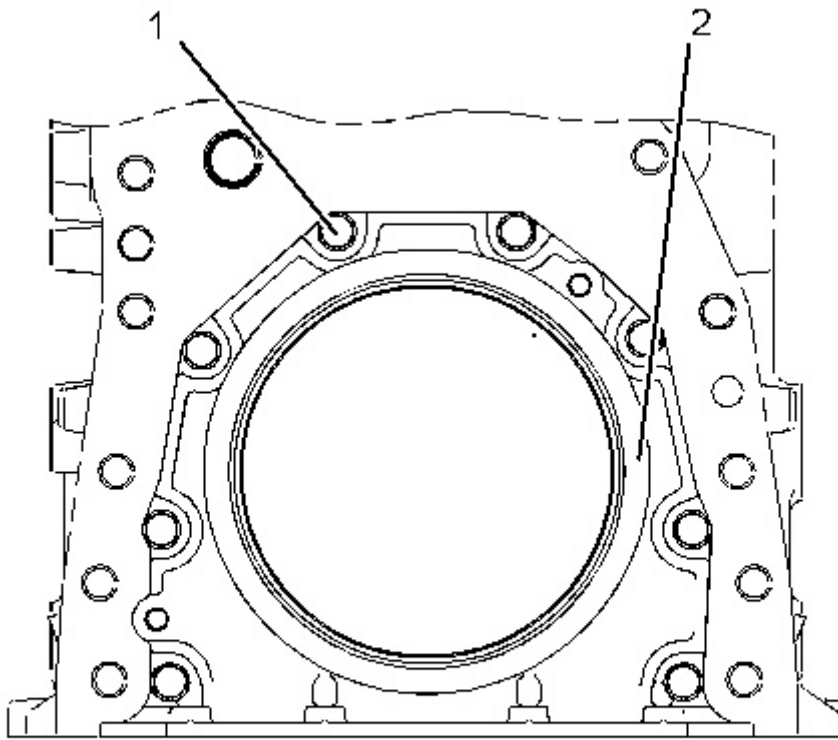


Illustration 1

g01027007

1. Remove bolts (1).
2. Remove rear seal carrier (2).

Installation Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	138-8440	Component Cleaner	
B	169-5464	Quick Cure Primer	
C	1U-8846	Gasket Sealant	
D	9S-3263	Thread Lock Compound	

NOTICE

Keep all parts clean from contaminants.

Contaminants may cause rapid wear and shortened component life.

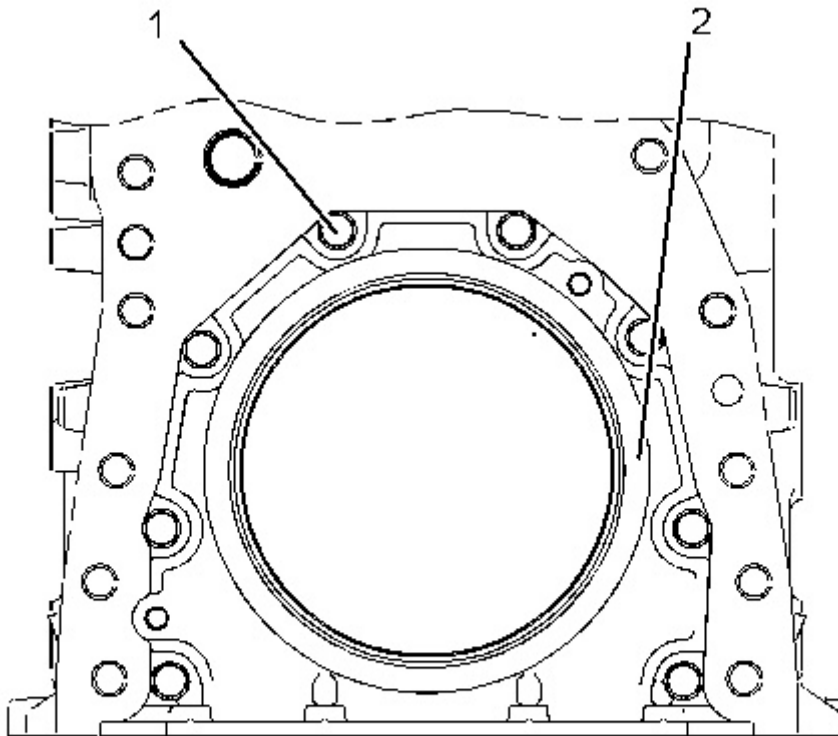


Illustration 2

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1. Clean the joint face of rear seal carrier (2) and the cylinder block with Tooling (A).
2. Apply Tooling (B) to the joint face of rear seal carrier (2). Allow the primer to air dry for three to five minutes.

Note: Tooling (C) is used on the joint face of rear seal carrier (2). Do not allow the sealant to get into the oil passage in the mounting face of the cylinder block.

3. Apply Tooling (C) to the joint face of rear seal carrier (2). Spread the sealant uniformly. Rear seal carrier (2) must be installed within ten minutes of application of the sealant.
4. Position rear seal carrier (2) on the dowels in the rear of the cylinder block.
5. Apply Tooling (D) on the threads of bolts (1). Install bolts (1) that hold rear seal carrier (2) to the cylinder block.

End By:

- a. Install the flywheel housing. Refer to Disassembly and Assembly, "Flywheel Housing - Remove and Install".

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i04855211

Flywheel Housing - Remove and Install

SMCS - 1157-010

Removal Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	138-7573	Link Bracket	2

Start By:

- Remove the flywheel. Refer to Disassembly and Assembly, "Flywheel - Remove".

NOTICE

Keep all parts clean from contaminants.

Contaminants may cause rapid wear and shortened component life.

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, "Dealer Service Tool Catalog" for tools and supplies suitable to collect and contain fluids on Cat products.

Dispose of all fluids according to local regulations and mandates.

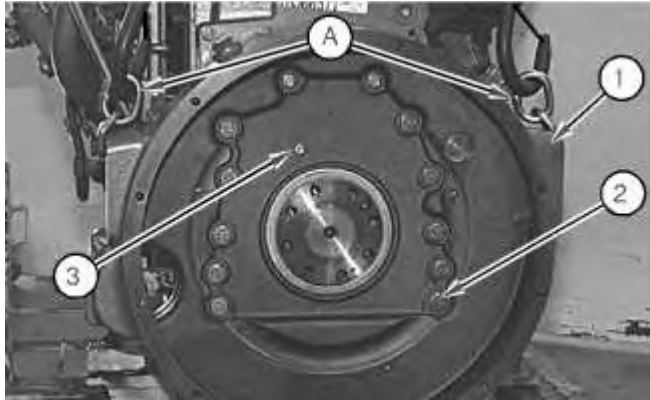


Illustration 1

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1. Fasten Tooling (A) and a suitable lifting device to flywheel housing (1).
2. Remove bolts (2) and bolt (3) that fastens flywheel housing (1) to the cylinder block.
3. Remove flywheel housing (1). The weight of flywheel housing (1) is approximately 32 kg (70 lb).

Installation Procedure

Table 2

Required Tools			
Tool	Part Number	Part Description	Qty
A	138-7573	Link Bracket	2
B	1U-8846	Gasket Sealant	1

NOTICE

Keep all parts clean from contaminants.

Contaminants may cause rapid wear and shortened component life.



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