

Product: EXCAVATOR

Model: 313D2 LGP EXCAVATOR GAJ

Configuration: 313D2 LGP Excavator GAJ00001-UP (MACHINE) POWERED BY 3054C Engine

## Disassembly and Assembly 313D2 Excavator Machine Systems

Media Number -UENR3323-06

Publication Date -01/06/2018

Date Updated -27/06/2018

i05533465

# Main Hydraulic Pump - Assemble

SMCS - 5070-016

## Assembly Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	1U-5750	Engine Stand	1
B	1P-1861	Retaining Ring Pliers	1
C	1P-1862	Pliers	1
D	-	Loctite 271	-

**Note:** If a failure occurs, an accurate diagnosis of the cause can prevent a recurrence. Information is available to analyze failures for piston pumps and motors. Refer to Special Publication, SEBD0641, "Analyzing Axial Piston Pump and Motor Failures".

**Note:** Inspect all parts. If any parts are worn or damaged use new parts for replacement. The installation of used parts during reconditioning is acceptable. Reuse and salvage information is available on piston pumps. Refer to Guideline For Reusable Parts and Salvage Operations, SEBF8032, "Piston Pumps and Motors". During reconditioning, correct any conditions that might have caused the original failure.

**Note:** Check the O-ring seals, the gaskets and the seals for wear or for damage and replace the components, if necessary.

**Note:** Cleanliness is an important factor. Before assembly, thoroughly clean all parts with cleaning fluid. Allow the parts to air dry. Do not use wiping cloths or rags to dry parts. Lint may be deposited on the parts which may cause problems. Inspect all parts. If any parts are worn or damaged, install new parts. All disassembly and all assembly procedures must be performed on a

clean work surface and in a clean hydraulic area. Keep cleaned parts covered and protected at all times.

**Note:** Apply a light film of hydraulic oil to all components before assembly.

## Assembly Of Port Block

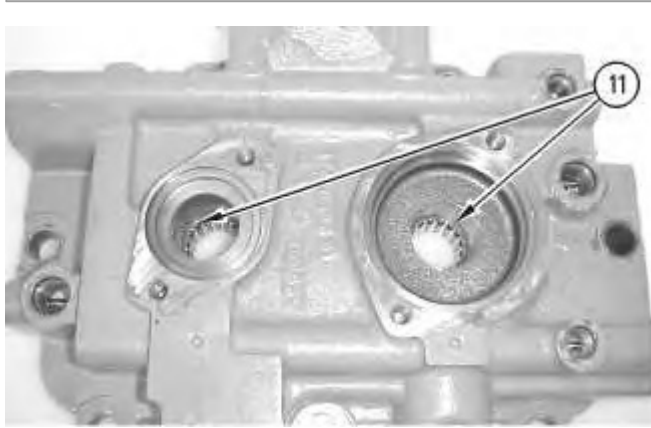


Illustration 1

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1. Install bearings (11).



Illustration 2

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2. Install plugs (10) and the O-ring seals.
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Illustration 3

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3. Install O-ring seals (9).

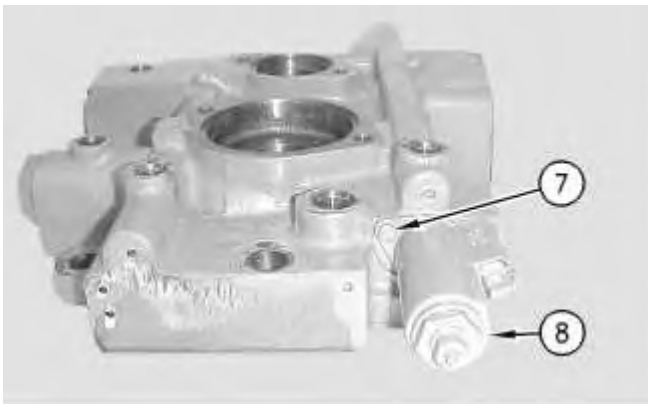


Illustration 4

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4. Install pressure reducing valve (8) and bolts (7). Tighten bolts (7) to a torque of  $9.8 \pm 0.3 \text{ N}\cdot\text{m}$  ( $87 \pm 3 \text{ lb in}$ ).

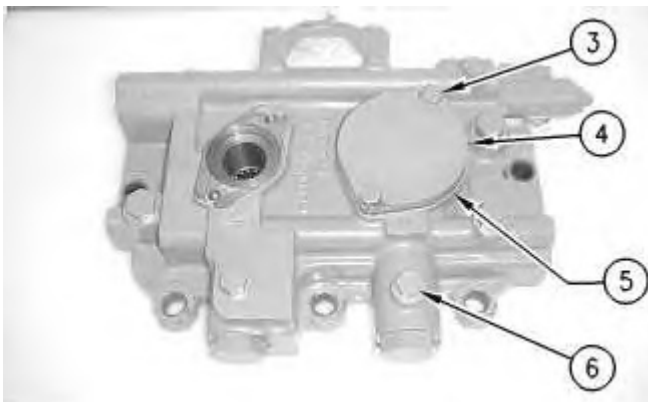


Illustration 5

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5. Install the O-ring seals and plugs (6).

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