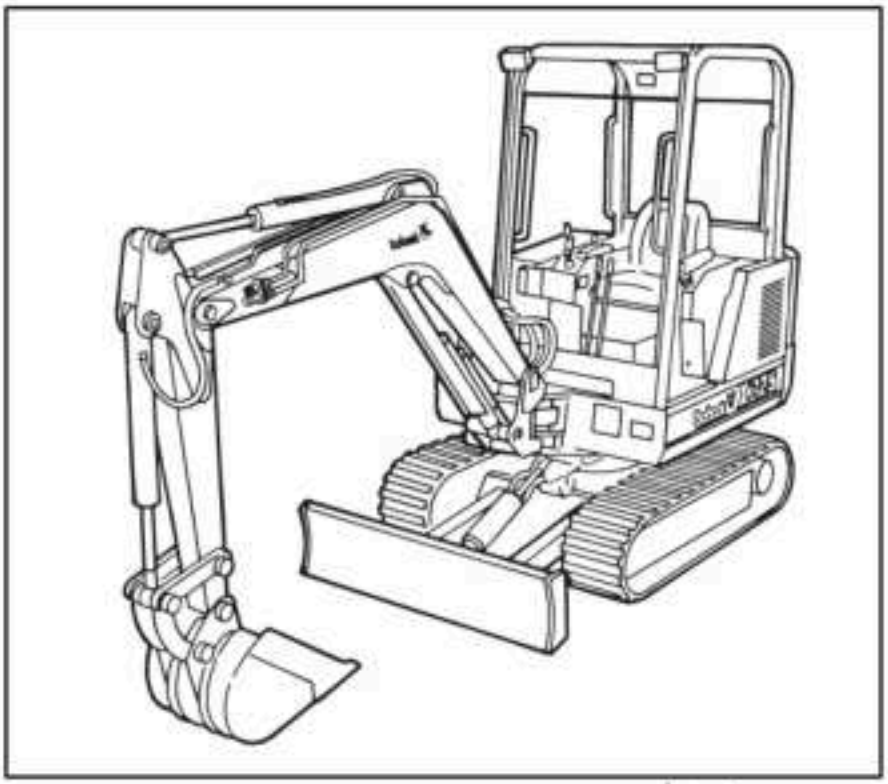
X 325
X 328

Excavator

Service Manual

325 (S/N 514013001 & Above)
328 (S/N 516611001 & Above)



MELROE
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CALIFORNIA
PROPOSITION 65 WARNING

Diesel engine exhaust and some of its constituents are known to the State of California to cause cancer, birth defects and other reproductive harm.

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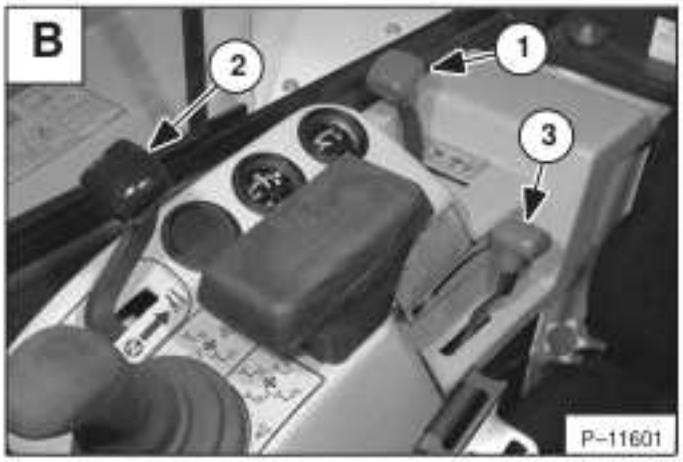
RIGHT CONSOLE COVER (325 S/N 514014900 & Above) & (328 S/N 516611001 & Above)

Removal And Installation

Remove the nine retaining bolts (Item 1) **[A]** from the console cover.

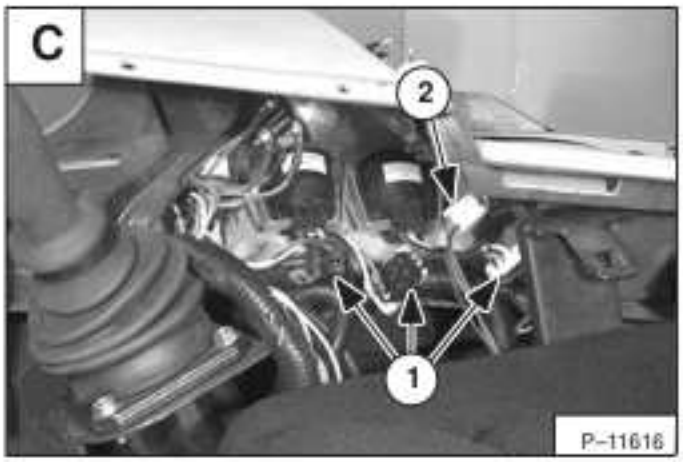


Remove the swing lock (Item 1) **[B]**, blade (Item 2) **[B]** and speed control knobs (Item 3) **[B]** by pulling up on the knobs.



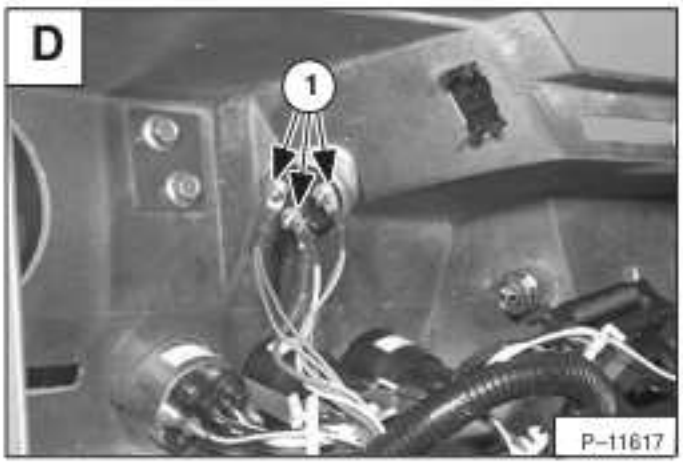
Disconnect the wiring harness (Item 1) **[C]** from the console gauges.

Disconnect the auxiliary power outlet (Item 2) **[C]** from the wire harness.



Remove the wire harness (Item 1) **[D]** from the key switch.

Mark the wires for ease of assembly.



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SWING BRACKET BUSHING

Bushing Removal

IMPORTANT

Do Not point (hammer) on the boom swing bracket. Excess pressure can cause the casting to crack.

I–2095–1195

The following parts will be needed for removal and installation of the boom swing bracket bushings:

1. Bolt – 0.625 x 4.0 inches or (15 x 101 mm) long.
2. Nut – 0.625 or (15 mm).
3. Washer – 0.750 I.D. x 2.5625 O.D. x 0.375 inch thick or (19 mm I.D. x 65 mm O.D. x 10 mm thick.
4. Washer – 0.750 I.D. x 3.125 O.D. x 0.375 inch thick or (19 mm I.D. x 79 mm O.D. x 10 mm thick).
5. Washer – 0.750 I.D. x 4.125 – 4.500 O.D. x 1.0 inch thick or (19 mm I.D. x 105 – 114 mm O.D. x 10 mm thick).
6. Spacer – 3.1875 – 3.250 I.D. x 3.750 – 4.0 O.D. x 1.0 inch thick or (81–82 mm I.D. x 95–100 mm O.D. x 25 mm thick).

Install the spacer (Item 6) **[A]** and washer (Item 5) **[A]** over the flanged end of the bushing.

The spacer (Item 6) **[A]** must be centered over the bushing to avoid contact between the bushing and the spacer during removal.

Install the washer (Item 3) **[A]** onto the opposite end of the bushing. This washer must be centered on the bushing and must not contact the casting.

Install the bolt (Item 1) **[A]** and the nut (Item 2) **[A]** through the washers and the spacer.

Tighten the bolt and nut to remove the bushing from the casting.

Bushing Installation

Apply a film of grease to the outer diameter of the bushing and to the inner diameter of the casting.

Center the bushing on the casting hole.

NOTE: Make sure that the bushing is centered into the casting hole and that it starts in the hole evenly and square.

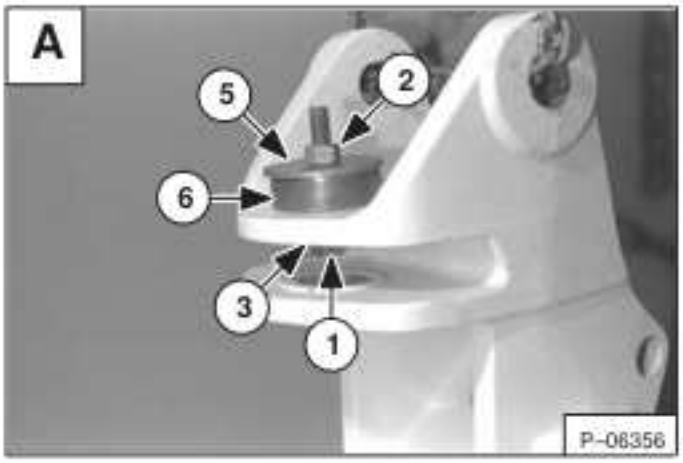
Put the washer (Item 4) **[B]** over the flanged end of the bushing.

Put the spacer (Item 6) **[B]** and the washer (Item 5) **[B]** over the bushing hole casting. Center the spacer and the washer over the bushing hole.

Install the bolt (Item1) **[B]** through the washers, the spacer and the bushing. Install the nut (Item 2) **[B]**.

Tighten the bolt and nut until the bushing is seated in the casting.

The same procedure is used to remove and install the bushings into the frame castings **[C]** & **[D]**.









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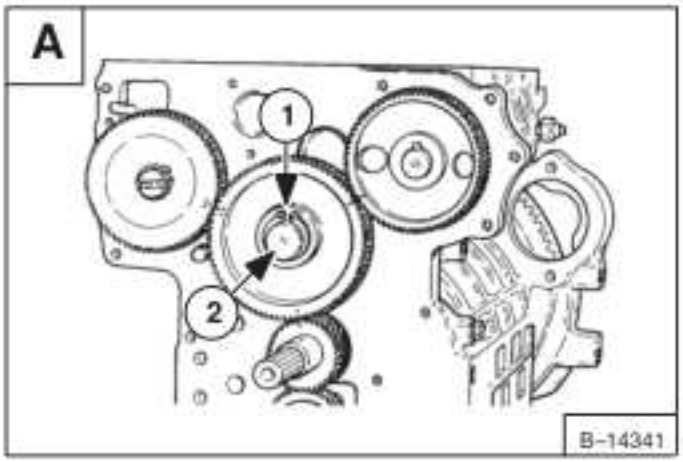
IDLER GEAR AND CAMSHAFT

Removal And Installation

Remove the cylinder head. (See Page 7–28.)

Remove the snap ring (Item 1) **[A]** from the idler gear shaft (Item 2) **[A]**.

Installation: Make sure the timing marks are in correct alignment when installing the timing gears **[A]**.



Remove the idler gear (Item 1) **[B]**.

Remove the idler gear collar (Item 2) **[B]**.

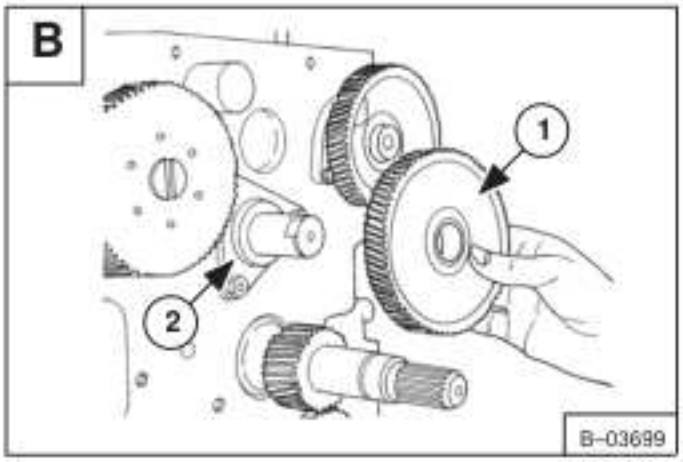
Remove the idler gear shaft mounting bolts.

Installation: Tighten the mounting bolts to 17–20 ft.–lbs. (23–27 Nm) torque.

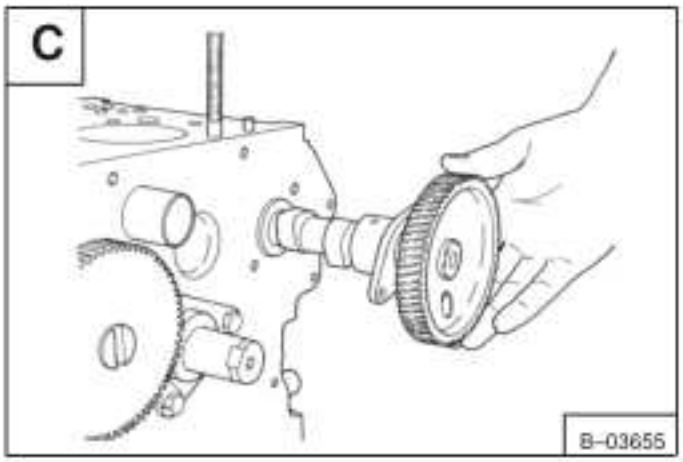
Align the holes on the camshaft gear with the camshaft retainer plate bolts.

Remove the bolts.

Installation: Tighten the camshaft retainer bolts to 17–20 ft.–lbs. (23–27 Nm) torque.

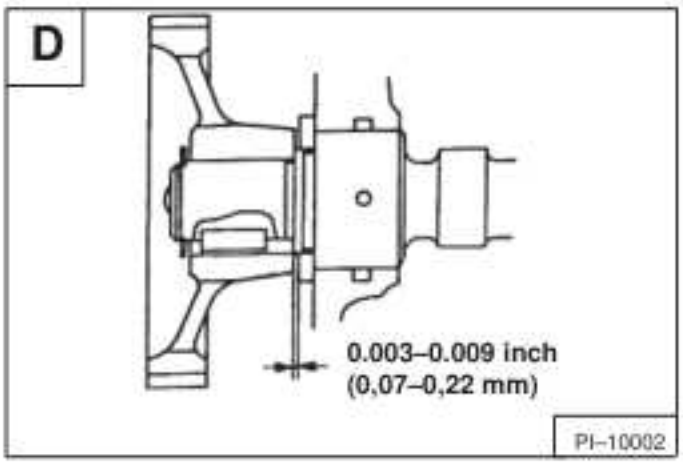


Remove the camshaft from the engine block **[C]**.



Installation: Check the camshaft end play, if the clearance exceeds the allowable limit, replace the camshaft retainer plate **[D]**.

Camshaft End Play . 0.003–0.009 inch (0,07–0,22 mm)
Allowable LImit . . . . . 0.012 inch (0,3 mm)

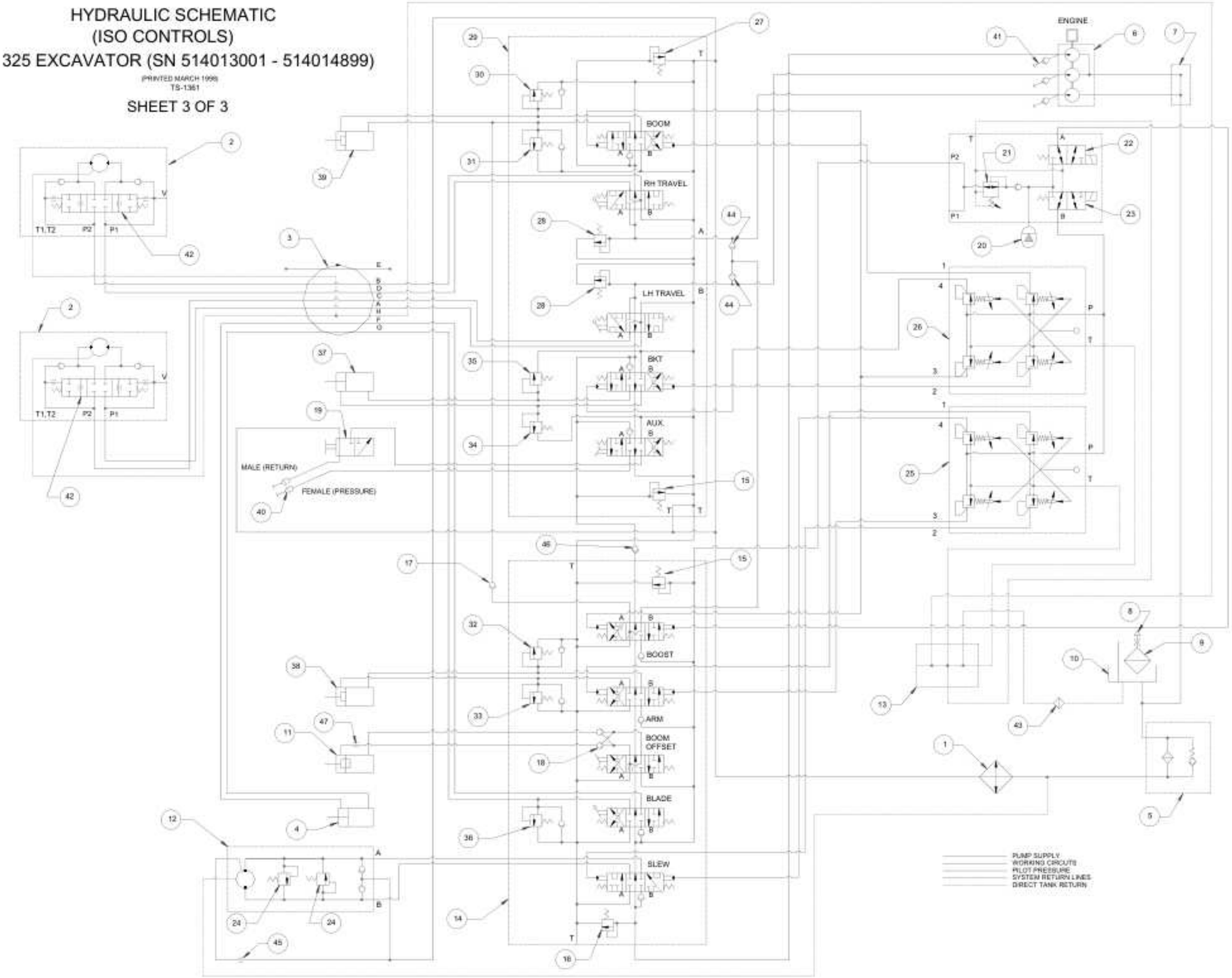


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HYDRAULIC SCHEMATIC
(ISO CONTROLS)
325 EXCAVATOR (SN 514013001 - 514014899)

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SHEET 3 OF 3



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