318D, 319D, 320D and 323D Skid Steer Loader Repair (Manual Controls)

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TECHNICAL MANUAL

318D, 319D, 320D and 323D Skid Steer Loader Repair (Manual Controls)

TM11399 14FEB13 (ENGLISH)

For complete service information also see:

318D and 320D Skid Steer Loader Operation and Test (Manual Controls)	TM11398
319D and 323D Skid Steer Loader Operation and Test (Manual Controls)	TM11414
318D and 320D Skid Steer Loader Operation and Test (EH Controls)	TM11406
319D and 323D Skid Steer Loader Operation and Test (EH Controls)	TM11422
318D, 319D, 320D and 323D Skid Steer Loader Repair (EH Controls)	TM11407
318D and 320D Skid Steer Loader Operator's Manual	OMT253020
319D and 323D Skid Steer Loader Operator's Manual	OMT253019
PowerTech E™ 2.4L and 3.0L Diesel Engines Component Technical Manual	CTM101019
120 Series Hydraulic Cylinders	CTM114319
Specifications Manual	SP458VOL2

Worldwide Construction And Forestry Division

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Original Instructions. All information, illustrations and specifications in this manual are based on the latest information available at the time of publication. The right is reserved to make changes at any time without notice.

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Recognize Safety Information

This is the safety alert symbol. When this symbol is noticed on the machine or in this manual, be alert for the potential of personal injury.

Follow the precautions and safe operating practices highlighted by this symbol.

A signal word — DANGER, WARNING, or CAUTION — is used with the safety alert symbol. DANGER identifies the most serious hazards.

On the machine, DANGER signs are red in color, WARNING signs are orange, and CAUTION signs are yellow. DANGER and WARNING signs are located near specific hazards. General precautions are on CAUTION labels.



T133555 —UN—28AUG00

T133588 —19—28AUG00

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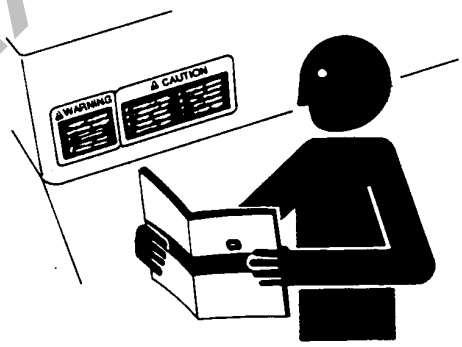
Follow Safety Instructions

Carefully read all safety messages in this manual and on your machine safety signs. Keep safety signs in good condition. Replace missing or damaged safety signs. Be sure new equipment components and repair parts include the current safety signs. Replacement safety signs are available from your John Deere dealer.

There can be additional safety information contained on parts and components sourced from suppliers that is not reproduced in this operator's manual.

Learn how to operate the machine and how to use controls properly. Do not let anyone operate without instruction.

Keep your machine in proper working condition. Unauthorized modifications to the machine may impair the function and/or safety and affect machine life.



TS201 —UN—23AUG88

If you do not understand any part of this manual and need assistance, contact your John Deere dealer.

DX,READ -19-16JUN09-1/1

Operate Only If Qualified

Do not operate this machine unless the operator's manual has been read carefully, and you have been qualified by supervised training and instruction.

Operator should be familiar with the job site and surroundings before operating. Try all controls and machine functions with the machine in an open area before starting to work.

Know and observe all safety rules that may apply to every work situation and work site.

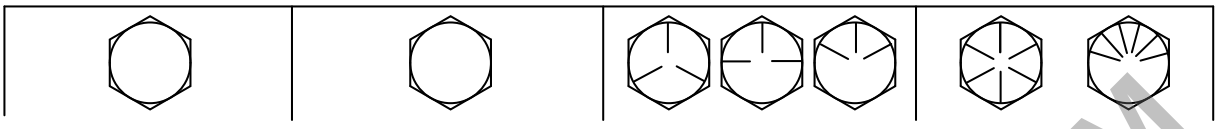
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Unified Inch Bolt and Screw Torque Values

TS1671 —UN—01MAY03



Bolt or Screw Size	SAE Grade 1				SAE Grade 2[a]				SAE Grade 5, 5.1 or 5.2				SAE Grade 8 or 8.2			
	Lubricated[b]		Dry[c]		Lubricated[b]		Dry[c]		Lubricated[b]		Dry[c]		Lubricated[b]		Dry[c]	
	N·m	lb.-in.	N·m	lb.-in.	N·m	lb.-in.	N·m	lb.-in.	N·m	lb.-in.	N·m	lb.-in.	N·m	lb.-in.	N·m	lb.-in.
1/4	3.7	33	4.7	42	6	53	7.5	66	9.5	84	12	106	13.5	120	17	150
													N·m	lb.-ft.	N·m	lb.-ft.
5/16	7.7	68	9.8	86	12	106	15.5	137	19.5	172	25	221	28	20.5	35	26
									N·m	lb.-ft.	N·m	lb.-ft.				
3/8	13.5	120	17.5	155	22	194	27	240	35	26	44	32.5	49	36	63	46
			N·m	lb.-ft.	N·m	lb.-ft.	N·m	lb.-ft.								
7/16	22	194	28	20.5	35	26	44	32.5	56	41	70	52	80	59	100	74
	N·m	lb.-ft.														
1/2	34	25	42	31	53	39	67	49	85	63	110	80	120	88	155	115
9/16	48	35.5	60	45	76	56	95	70	125	92	155	115	175	130	220	165
5/8	67	49	85	63	105	77	135	100	170	125	215	160	240	175	305	225
3/4	120	88	150	110	190	140	240	175	300	220	380	280	425	315	540	400
7/8	190	140	240	175	190	140	240	175	490	360	615	455	690	510	870	640
1	285	210	360	265	285	210	360	265	730	540	920	680	1030	760	1300	960
1-1/8	400	300	510	375	400	300	510	375	910	670	1150	850	1450	1075	1850	1350
1-1/4	570	420	725	535	570	420	725	535	1280	945	1630	1200	2050	1500	2600	1920
1-3/8	750	550	950	700	750	550	950	700	1700	1250	2140	1580	2700	2000	3400	2500
1-1/2	990	730	1250	930	990	730	1250	930	2250	1650	2850	2100	3600	2650	4550	3350

Torque values listed are for general use only, based on the strength of the bolt or screw. DO NOT use these values if a different torque value or tightening procedure is given for a specific application. For plastic insert or crimped steel type lock nuts, for stainless steel fasteners, or for nuts on U-bolts, see the tightening instructions for the specific application. Shear bolts are designed to fail under predetermined loads. Always replace shear bolts with identical grade.

Replace fasteners with the same or higher grade. If higher grade fasteners are used, tighten these to the strength of the original. Make sure fastener threads are clean and that you properly start thread engagement. When possible, lubricate plain or zinc plated fasteners other than lock nuts, wheel bolts or wheel nuts, unless different instructions are given for the specific application.

[a]Grade 2 applies for hex cap screws (not hex bolts) up to 6 in. (152 mm) long. Grade 1 applies for hex cap screws over 6 in. (152 mm) long, and for all other types of bolts and screws of any length.

[b]"Lubricated" means coated with a lubricant such as engine oil, fasteners with phosphate and oil coatings, or 7/8 in. and larger fasteners with JDM F13C, F13F or F13J zinc flake coating.

[c]"Dry" means plain or zinc plated without any lubrication, or 1/4 to 3/4 in. fasteners with JDM F13B, F13E or F13H zinc flake coating.

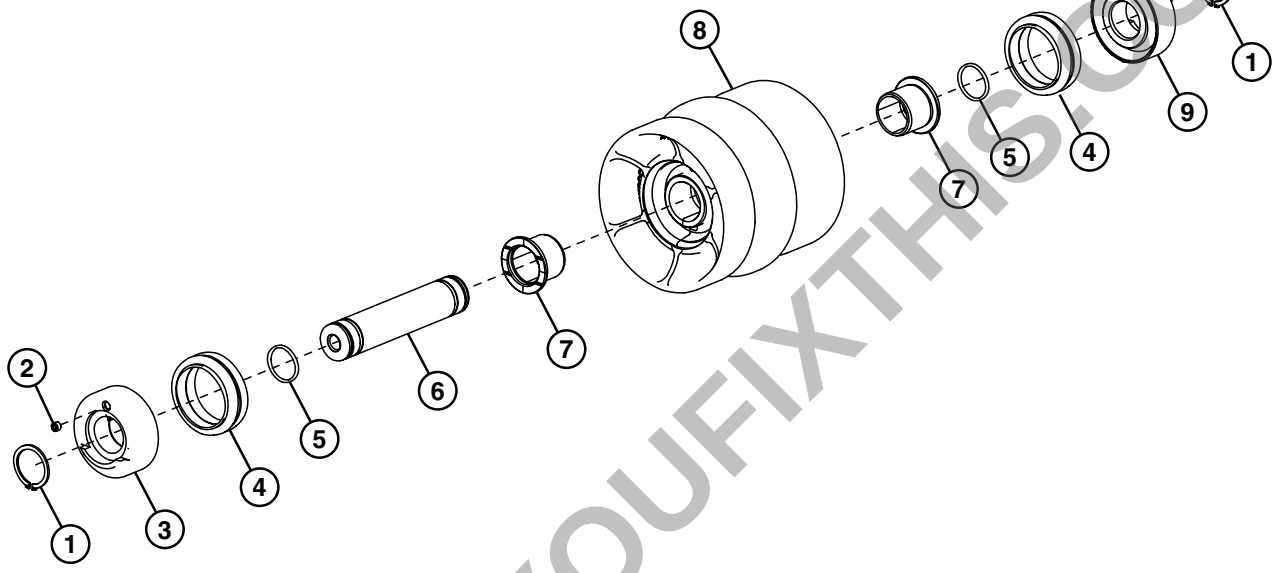
DX,TORQ1 -19-12JAN11-1/1

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Track Roller Disassemble and Assemble

This procedure is for track rollers on machines (S.N. —192141). Track rollers for machines (S.N. 192142—) are serviced as complete units only.



T210900 —UN—11AUG05

T210900

Track Roller

1— Snap Ring (2 used)
2— Plug
3— Collar (with plug hole)
4— Metal Face Seal (2 used)
5— O-Ring (2 used)
6— Axle Shaft
7— Bushing (2 used)
8— Track Roller
9— Collar (without plug hole)

⚠ CAUTION: Avoid crushing injury from heavy component. Use appropriate lifting device.

1. Remove track roller (8) from track frame. See Track Roller Remove and Install. (Group 0130.)

Specification	
Track Roller (S.N. —192141)—Weight (approximate)	26.3 kg 58 lb.

2. Remove plug (2) and drain oil from track roller.
3. Remove snap rings (1) from both ends of axle shaft (6).
4. Press axle shaft from track roller (8).
5. Press remaining collar (9) from axle shaft.

NOTE: If bushings (7) are worn or damaged complete roller must be replaced.

6. Inspect track roller bushings (7) and axle shaft. Replace track roller if bushings or axle shaft are worn or damaged.

NOTE: Metal face seals can be reused if they are not worn or damaged. Used seals **must** *be kept together as a set because of wear patterns on seal ring face.*

7. Remove metal face seals (4) from track roller. Keep seal rings together as a matched set with seal ring faces together to protect surfaces.
8. Inspect metal face seals. See Inspect Metal Face Seals. (Group 0130.)
9. Remove O-rings (5) from axle shaft.
10. Install new O-rings on axle shaft.
11. Install snap ring on one end of axle shaft.
12. Tap axle shaft into collar (9).

IMPORTANT: Prevent O-rings from slipping. Metal face seal O-rings and seat surfaces for O-rings MUST be clean, dry and oil free so O-rings do not slip when track roller is turning.

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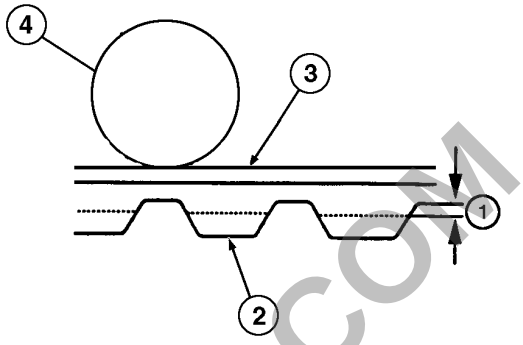
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Measure Rubber Track Height

1. Measure lug height (1) at location shown.
2. Replace rubber track (3) if measurement is less than specification.

Specification	
Rubber Track	
Lug—Height (minimum)	5 mm 0.2 in.

1— Lug Height
2— Lug
3— Rubber Track
4— Track Roller



T213966 —UN—09SEP05

Track Lug Measurement

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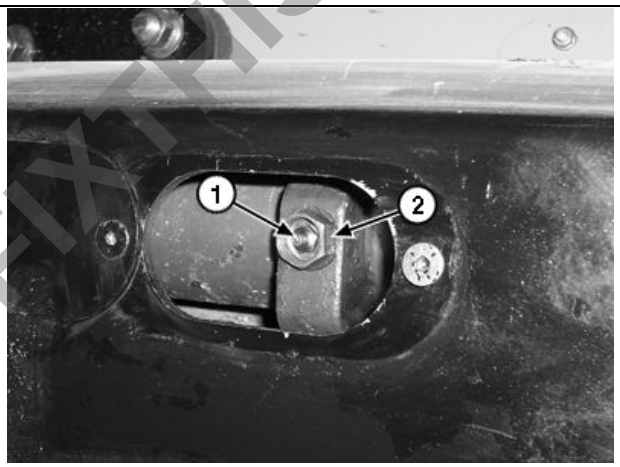
Track Remove and Install

1. Park machine on a flat level surface.
2. Raise and block machine.
3. Remove track adjuster cover plate on track frame.

CAUTION: Prevent personal injury from high pressure grease in track adjuster cylinder. DO NOT loosen track adjuster valve (2) quickly or too much. Never loosen grease fitting (1) to release grease.

4. Loosen track adjuster valve 1—2 turns to discharge grease from track adjuster cylinder. Allow track to sag completely.

1— Grease Fitting
2— Track Adjuster Valve



T211663A —UN—25FEB10

Track Adjuster Valve

Continued on next page

RM58335,0000719 -19-12FEB10-1/2

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R134a Refrigerant Oil Information

CAUTION: All new compressors are charged with a mixture of nitrogen, R134a refrigerant and TY22025 (R134a) Refrigerant Oil. Wear safety goggles and discharge the compressor slowly to avoid possible injury.

IMPORTANT: Do not add any more oil than required or maximum cooling will be reduced.

DO NOT leave system or R134a compressor oil containers open. Refrigerant oil easily absorbs moisture. DO NOT spill R134a compressor oil on acrylic or ABS plastic. This oil will deteriorate these materials rapidly. Identify R134a oil containers and measures to eliminate accidental mixing of different oils.

New compressor from parts depot contains new oil. Oil level visible through suction port normally is below drive shaft.

Normal operating oil level of compressor removed from operation cannot be seen through suction port of compressor.

Compressors can be divided into three categories when determining correct oil charge for system.

- New compressor from parts depot
- Used compressor removed from operation
- Compressor internally washed with flushing solvent

Determine amount of system oil charge prior to installation of compressor on machine.

When complete system, lines, and components are flushed, add correct amount of oil as described.

Specification	
Oil—Total System Volume	217 mL (7.35 fl oz)
Oil—Compressor Precharge Volume	160 mL (5.41 fl oz)
R134a—Weight	1360 g (3.00 lb)

If any section of hose is removed and flushed or replaced, measure length of hose and use formula 3 mL per 30 cm (0.1 fl oz per ft) to determine correct amount of oil to be added.

Drain compressor oil into graduated container while rotating compressor shaft and record amount.

If oil drained from compressor removed from operation is black or amount of oil is less than 6 mL (0.2 fl oz), perform the following and discard oil properly:

1. Determine if R134a leakage was detected, remove component and repair or replace component.
   - For wheeled machines, see Refrigerant Leak Testing. (Group 9031-25.)
   - For tracked machines, see Refrigerant Leak Testing. (Group 9031-25.)
2. Remove and discard receiver-dryer. See Receiver-Dryer Remove and Install. (Group 1830.)
3. Flush complete system with TY16134 Air Conditioning Flushing Solvent. See Flush and Purge Air Conditioner System. (Group 1830.)
4. Install new receiver-dryer. See Receiver-Dryer Remove and Install. (Group 1830.)
5. Pour required amount of TY22025 Refrigerant Oil in compressor.
6. Connect all components.
7. Evacuate and charge the air conditioning system. See Evacuate R134a System and see Charge R134a System. (Group 1830.)

TK40086,0000722 -19-12FEB10-1/1

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5. Lay three steel pipes (6), evenly spaced on track (4) below track frame (5).

CAUTION: Prevent personal injury. Adjust engine speed to slowest speed. Stand clear of steel pipes while moving drive sprocket.

6. Rotate drive sprocket in reverse direction until track is raised off of front idler (3) by steel pipes.

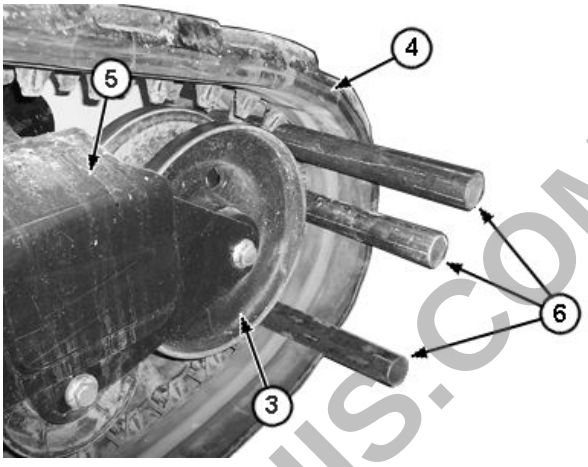
CAUTION: Prevent crushing injury from heavy component. Use appropriate lifting device.

7. Pry and slide track away from front idler and track frame to remove from machine.

Specification	
Individual Track—Weight (approximate)	173 kg (380 lb.)

8. Clean and inspect track components.
   a. Inspect lugs and area between lugs for cracks that exceed 3 mm (0.1 in.) in depth, reach steel core or exceed 30 mm (1.2 in.) in length.
   b. Inspect for any signs of exposed steel core.
   c. Inspect roller side of track for cracks that reach steel core. Inspect for separation of steel core anywhere on track.
9. Repair or replace parts as necessary.
10. Install track on drive sprocket teeth and rear idler. Slip other end over front idler.
11. Lay three steel pipes, evenly spaced on track below track frame.

CAUTION: Prevent personal injury. Adjust engine speed to slowest speed. Stand clear of steel pipes while moving drive sprocket.



T212134A —UN—14JUN05

Track Removal

3— Front Idler
4— Track
5— Track Frame
6— Steel Pipe (3 used)

IMPORTANT: Prevent track and machine damage. Ensure track is securely engaged on drive sprocket, rear idler and front idler when finished.

12. Rotate drive sprocket in reverse direction to guide track completely onto front idler.
13. Pry and slide track so that center guide lugs on track fit properly into front idler.
14. Adjust track tension. See Check and Adjust Track Tension. (Group 9020-25.)
15. Install track adjuster cover plate to track frame.
16. Raise machine and remove blocks.

RM58335,0000719 -19-12FEB10-2/2

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1— Snap Ring (2 used)
2— Pivot Bearing Block
3— Yoke with Shaft Assembly
4— Pivot Bearing Block Bushing (2 used)
5— Torsion Spring
6— Control Lever
7— Steering Arm
8— Steering Arm Bushing (2 used)
9— Hand and Foot Control Lever Assembly
10— Hands Only Control Lever Assembly

2. Remove snap rings (1), pivot bearing block (2) from yoke and shaft assembly (3).
3. Inspect pivot bearing block bushings (4) for wear and damage. Replace as needed.

NOTE: Note torsion spring position for assembly purposes.

4. Remove torsion spring (5), inspect and replace as needed.
5. Inspect control lever (6) for damage. Replace as needed.
6. Remove steering arm (7) from yoke and shaft assembly.
7. Inspect steering arm bushings (8) for wear and damage. Replace as needed.
8. Install steering arm on yoke and shaft assembly.
9. Install control lever on steering arm.
10. Install torsion spring on yoke and shaft assembly.
11. Install pivot bearing block on yoke and shaft assembly.
12. Install control lever. See Control Lever Remove and Install. (Group 0315.)

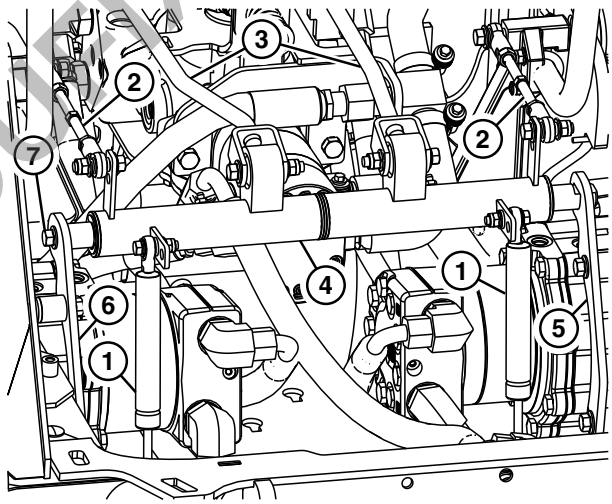
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Steering Cross Shaft Assembly Remove and Install

1. Remove front attachment and park machine on flat level surface.
2. Raise operator's station. See Raising Operator's Station. (Group 1810.)
3. Remove footwell. See Footwell Remove and Install. (Group 1910.)
4. Disconnect steering dampeners (1), link rods (2), and control rods (3) from cross shaft assembly (4).
5. Disconnect cross shaft assembly from right support bracket (6) by removing cap screw (7).
6. Lift right side of cross shaft assembly and slide assembly out from left support bracket (5).
7. Inspect bellcrank, bushings and drive shaft for damage or wear. Repair or replace as required.
8. Slide cross shaft assembly into left support bracket.
9. Fasten cross shaft assembly to right support bracket and tighten cap screw to specification.

Specification	
Cross Shaft Mounting Cap Screw—Torque	73 N·m 55 lb-ft

10. Connect steering dampeners, link rods, and control rods to cross shaft assembly.
11. Check and adjust link rods.
    - For wheeled machines, see Steering Lever Adjustment—Centering. (Group 9026-25.)
    - For tracked machines, see Steering Lever Adjustment—Centering. (Group 9026-25.)



TX1068705 —UN—12DEC09

Steering Cross Shaft

1— Steering Dampener (2 used)
2— Link Rod (2 used)
3— Control Rod (2 used)
4— Cross Shaft Assembly
5— Left Support Bracket
6— Right Support Bracket
7— Cap Screw

12. Check and adjust steering lever stops. See Tracking Adjustment. (Group 9026-25.)
13. Install footwell. See Footwell Remove and Install. (Group 1910.)
14. Lower operator's station. See Raising Operator's Station. (Group 1810.)

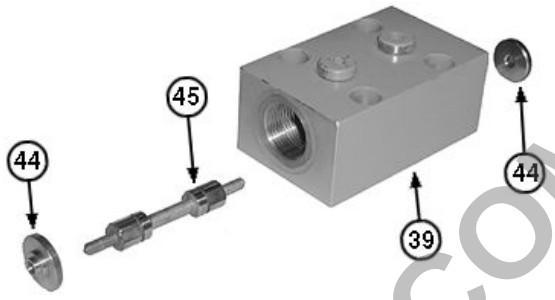
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3. Place spool (45) in shuttle valve block (39). Install disks (44) with smooth sides facing spool.

39— Shuttle Valve Block
44— Disk (2 used)
45— Spool



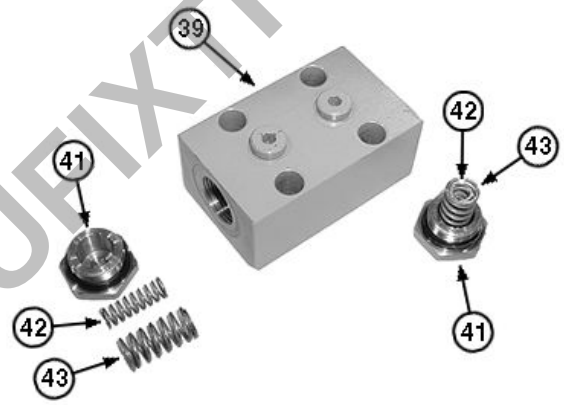
TX1088325A —UN—18FEB11

Hydrostatic Motor Assemble

KK70125,0000920 -19-30NOV12-2/27

4. Install one spring (small diameter) (42) and one spring (large diameter) (43) in each end of shuttle valve block.

39— Shuttle Valve Block
41— Plug (2 used)
42— Spring (small diameter) (2 used)
43— Spring (large diameter) (2 used)



TX1088324A —UN—18FEB11

Hydrostatic Motor Assemble

KK70125,0000920 -19-30NOV12-3/27

NOTE: Some machines (S.N. —233277) may be equipped with newer-style shuttle valve block plugs. Shuttle valve block plug (S.N. 233278—) (412) has a larger hex head that allows for a higher torque to be applied.

5. Install plugs (41) with new seals and tighten to specification.

Specification

Shuttle Valve Block Plug (S.N. —233277)—Torque	45 N·m 33 lb.-ft.
Shuttle Valve Block Plug (S.N. 233278—)—Torque	200 N·m 148 lb.-ft.



TX1127104A —UN—30NOV12

Shuttle Valve Block Plugs

411— Shuttle Valve Block Plug (S.N. —233277)
412— Shuttle Valve Block Plug (S.N. 233278—)

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KK70125,0000920 -19-30NOV12-4/27

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Hydrostatic Motor, Park Brake and Gearbox Disassemble (S.N. 192142—)

This procedure is used for tracked machines.

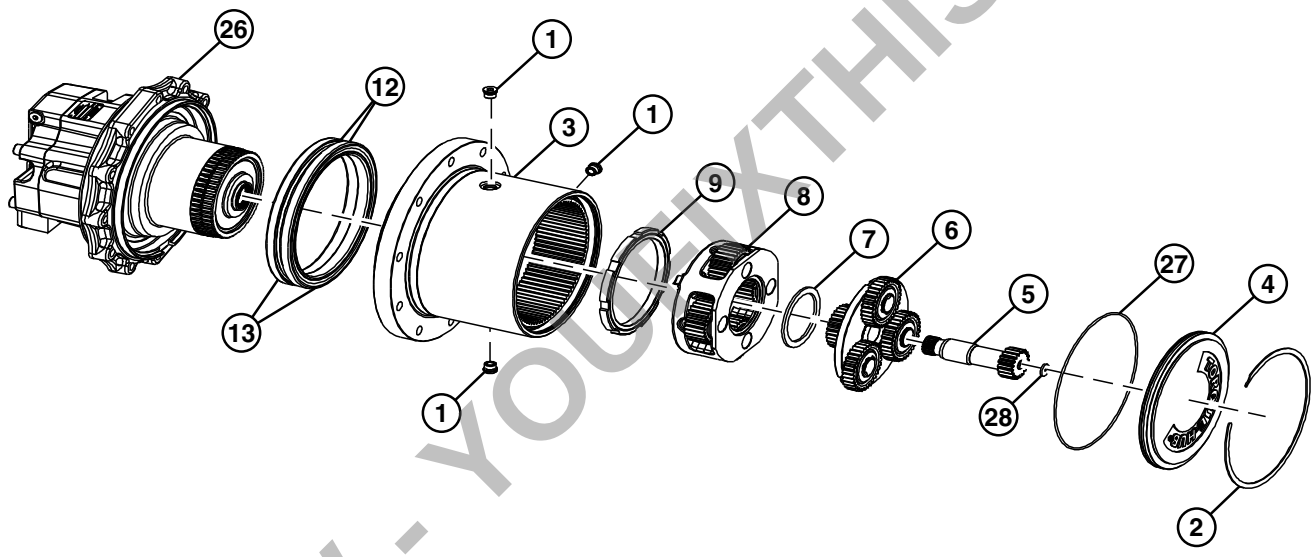
Gearbox Disassemble

⚠ CAUTION: Prevent possible crushing injury from heavy component. Use appropriate lifting device.

1. Remove hydrostatic motor, park brake and gearbox from machine. See Hydrostatic Motor, Park Brake and Gearbox Remove and Install (S.N. 192142—). (Group 0360.)

Specification

Hydrostatic Motor, Park Brake and Gearbox Assembly—Weight (approximate)	98 kg 215 lb



TX1082027 —UN—20SEP10

TX1082027

Gearbox Components

1— Plug (3 used)
2— Snap Ring
3— Gearbox Housing
4— End Cover
5— Input Shaft
6— Input Carrier Assembly
7— Thrust Washer
8— Output Carrier Assembly
9— Lock Nut
12— Seal Ring (2 used)
13— O-Ring (2 used)
26— Motor Spindle Assembly
27— O-Ring
28— Thrust Washer

2. Clean exterior of hydrostatic motor, park brake and gearbox housing before disassembling.

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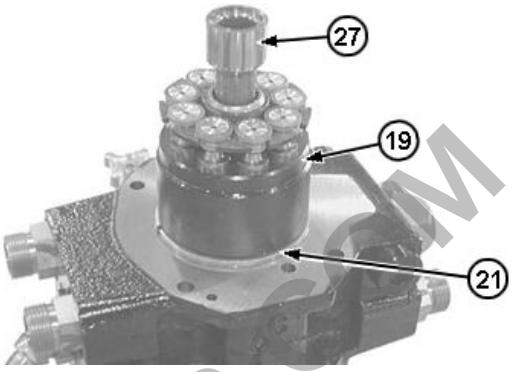
KK70125,0000768 -19-25OCT10-1/20

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23. Install rotating assembly (19) onto valve plate (21).
24. Align splines on drive shaft (27) with rotating assembly (19) and install into center manifold.

19— Rotating Assembly
21— Valve Plate
27— Drive Shaft



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Rotating Assembly and Valve Plate

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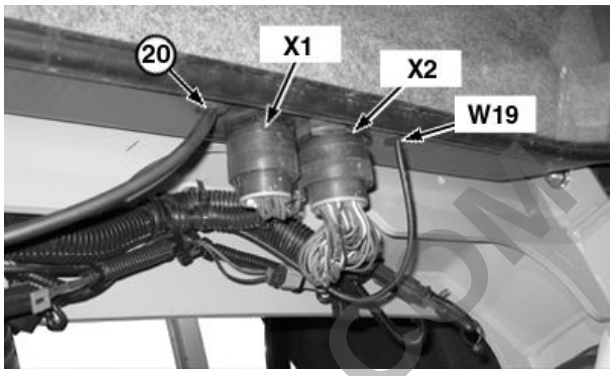
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Operator's Station Remove and Install

NOTE: Operator's station remove and install procedure is similar for either enclosed cab or ROPS. Procedure for enclosed cab shown.

1. Remove front attachment and park machine on flat level surface.
2. Disconnect cab harness electrical connectors (X1 and X2) from main harness.

20— Washer Fluid Line
W19—Antenna
X1— Cab Harness-to-Main Harness 14-Pin Connector
X2— Cab Harness-to-Main Harness 47-Pin Connector



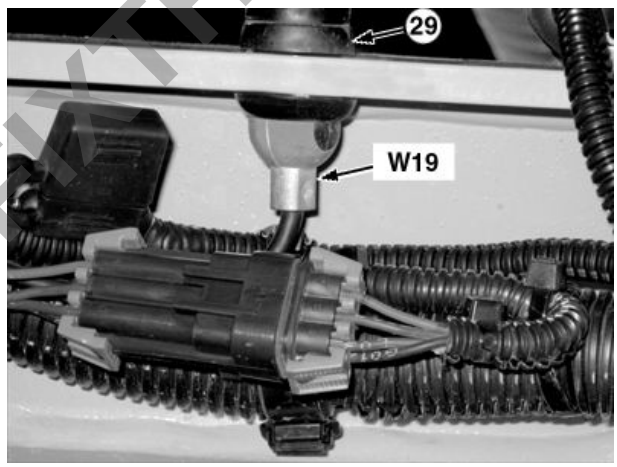
TX1070437A —UN—01FEB10

Cab Harness Connectors

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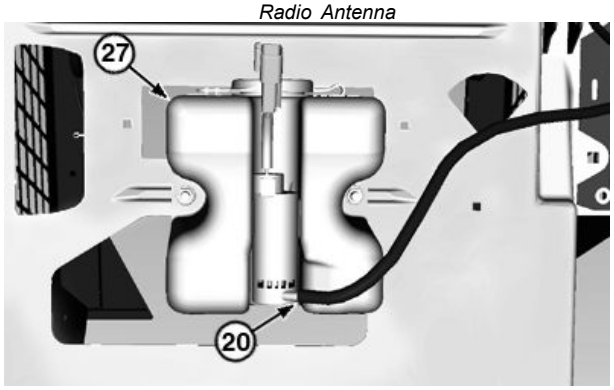
3. Disconnect antenna (W19) from antenna base (29).
4. Disconnect washer fluid line (20) from washer fluid tank (27).
5. Disconnect and remove horn.
   - For wheeled machines, see Cab Harness (W2) Component Location. (Group 9015-10.)
   - For tracked machines, see Cab Harness (W2) Component Location. (Group 9015-10.)

20— Washer Fluid Line
27— Washer Fluid Tank
29— Antenna Base
W19—Antenna



TX1070452A —UN—01FEB10

Radio Antenna



TX1070445A —UN—29JAN10

Windshield Washer Fluid Tank

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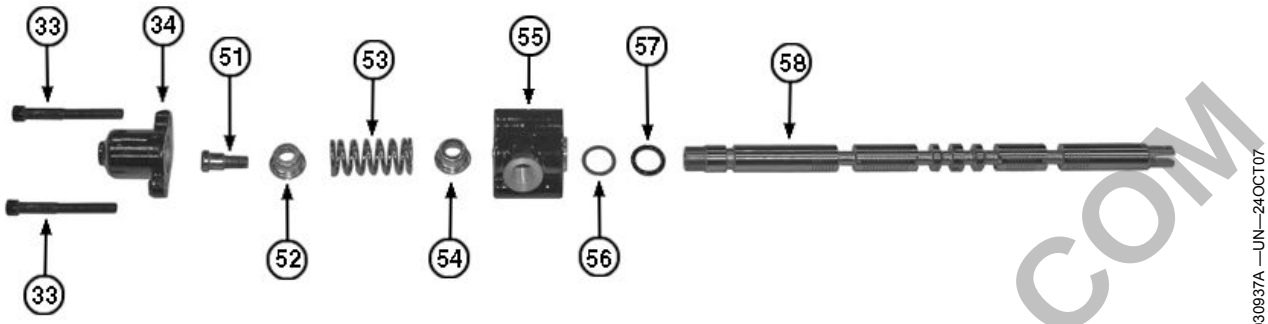
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TX1030937A —UN—24OCT07

Bucket Spool Assembly

33— Socket Head Cap Screw (2 used)
34— Spool Cap
51— Spool End
52— Spring Seat (outer)
53— Spring
54— Spring Seat (inner)
55— Spool Housing
56— Washer
57— O-Ring
58— Spool

25. For bucket spool, remove spool end (51) and disassemble parts (52—57). Discard O-ring.
26. Remove auxiliary spool from control valve.

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RM58335,0000645 -19-25FEB10-13/27

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