



(B) Inspection

1. Gear tooth wear

- Measure the gear pump (B) at points where the gear contacts it and where the gear does not. Then calculate the difference between the two measurements.
- If the value exceeds the allowable limit, replace the gear pump.
 - Reference value ... Clearance: 0.050 to 0.075 mm
 - Allowable limit ... Clearance: 0.075 to 0.10 mm
- Check to see the trace of gear gear contact (drawn) with the tooth.
 - Reference value ... 1/3 tooth's circumference
 - Allowable limit ... 1/2 tooth's circumference

Remarks

- Replace the gear pump when the following conditions exist.

- Excessive contact lines that enough to be felt with a fingertip are present and the entire loading surface where it slides along the tooth.
- Many circumferential scratches deep enough to be felt with a fingertip are present on sides.
- Scratches including foreign matter are found on the internal sliding surface and sides.

- Scoring side
- Scraper side
- Trace of gear gear contact
- Allowable limit (A, B)

2. Clearance between shaft and housing

- Measure the shaft diameter with a micrometer.
- Measure the housing (D) with a micrometer.
- Calculate the clearance between the housing and shaft.
- If the value exceeds the allowable limit, replace the gear pump.
 - Reference value ... Clearance: less than 0.050 to 0.1 mm
 - Allowable limit ... Clearance: 0.050 to 0.1 mm

3. Shaft length

- Measure the entire housing length with a micrometer.
 - Allowable limit ... 0.050 to 0.10 mm max.

Section VII

Backhoe

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Kubota R410 Manual

Annelies Wilder-Smith



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