



#### (B) Inspection

##### 1. Gear tooth wear

- Measure the gear pump (1) at points where the gear connects 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: 0.050 to 0.10 mm
- Check to see the trace of gear gear contact (shown) 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 long enough to be felt with a fingertip are present on sides.
- Traces including foreign matter are found on the internal sliding surface and sides.

- Bottom side
- Bottom side
- Trace of gear gear contact
- Allowable limit (1, 2)

##### 2. Clearance between shaft and housing

- Measure the shaft diameter with a vernier caliper.
- Measure the housing (1) with a vernier caliper.
- 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 0.2 mm

##### 3. Shaft length

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

## Section VII

# Backhoe

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# Kubota R410 Manual

**D Keegan**



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