



(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: 0.080 to 0.10 mm
 - Allowable limit ... Clearance: 0.080 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 ... 1/3 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 loading

- Measure the shaft diameter with a vernier caliper.
- Measure the loading (1) with a vernier caliper.
- Calculate the clearance between the loading 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 loading length with a vernier caliper.
 - Allowable limit ... 0.050 to 0.10 mm max.

Section VII

Backhoe

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Kubota R410 Manual

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