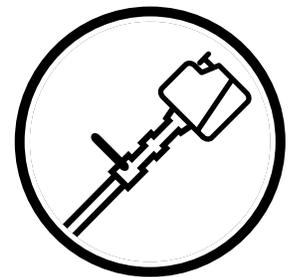


For Husqvarna Parts Call 606-678-9623 or 606-561-4983

Workshop manual  
**Husqvarna Pruning Saw  
325P4 Gearbox**



English



# Workshop Manual Pruning Saws

Supplement for model 325 P4

## Contents

5. Gearbox with oil pump \_\_\_\_\_ 5

**This supplement only takes up elements specific to the above mentioned model.**

**For complete information when servicing we recommend that the supplement is studied together with the Workshop Manual  
(Order no. 101 90 75 -26)**

**and the supplement for brushcutters, trimmers, pruners and hedge trimmers.  
(Order no. 101 90 74-26)**

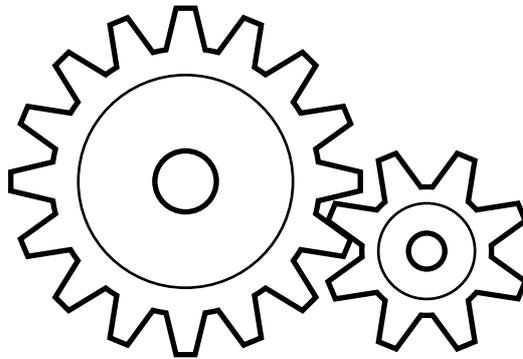


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## Gearbox with oil pump

# 5.



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**Task of the gear:**

**It shall:**

- **Transfer the motion from the engine and drive the chain saw.**
- **Be a mounting for the bar.**
- **Be the tensioning device for the chain.**
- **Supply the bar and chain with lubrication so that overheating and wear are avoided.**

General

325 P4:

See Brushcutter 325 in the Workshop Manual 101 89 22-01 and supplement 101 90 19-01 for the engine and shaft.

See the chain saw Workshop Manual for the bar and chain.

Deviations:

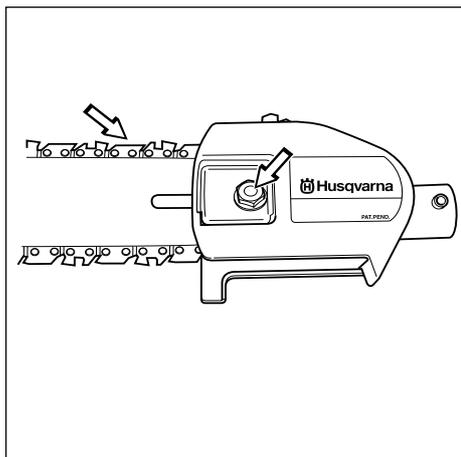
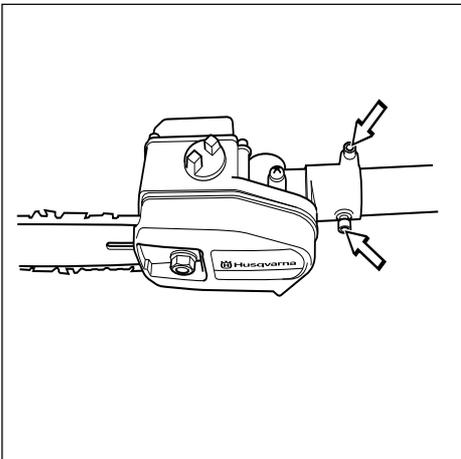
The speed is limited to 12,500 rpm.

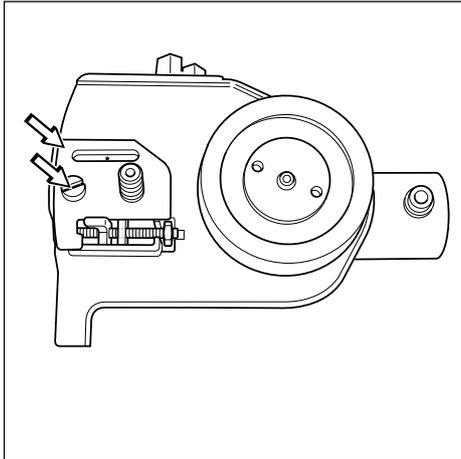
Dismantling

325 P4:

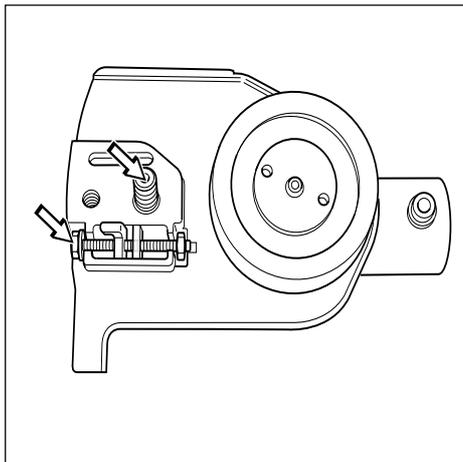
Remove the gearbox from the engine and shaft.

Remove the cover and bar with chain.

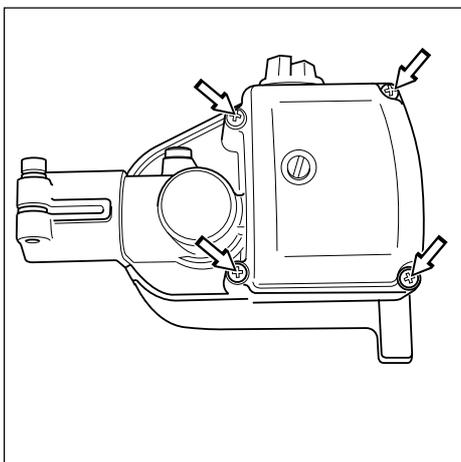




Remove the front slotted screw and plate.

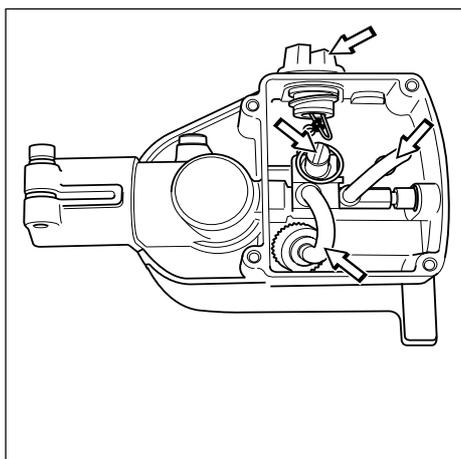


Remove the bar bolt and chain adjuster.



Remove the four screws and oil cover with gasket.

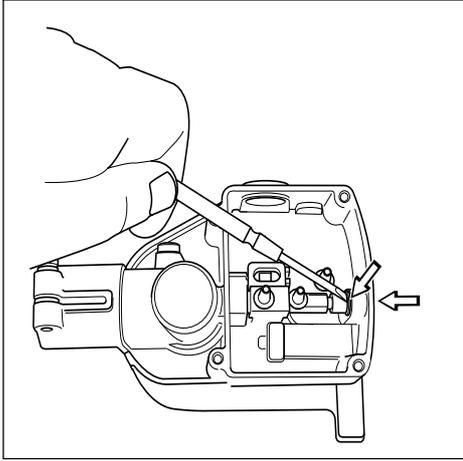
The slotted screw in the cover should not be removed.



Remove the oil filter with hose and the hose for chain lubrication.

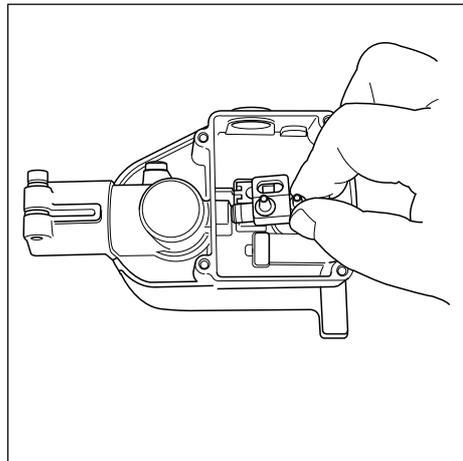
Remove the locking screw for the oil pump and oil-filling cap with chain.

# 5 Gearbox with oil pump



Remove the locking washer on the adjuster screw for the oil flow.  
Unscrew the adjuster screw for the oil flow and remove the screw.

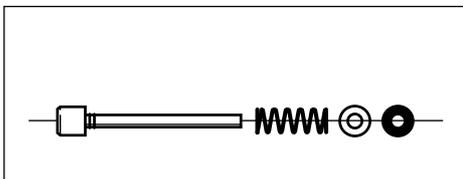
Use a screw driver.



Remove the oil pump.

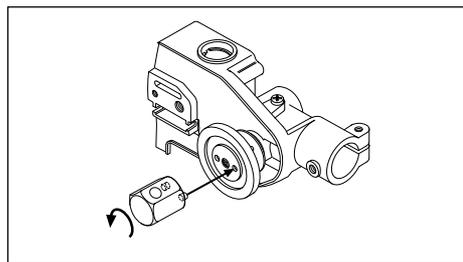
Note!

Exercise care. The pump piston can be damaged.



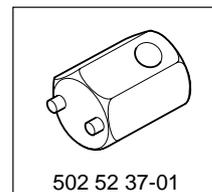
Check that the pump piston and pump housing have not been damaged.

Replace the complete oil pump if the pump is faulty

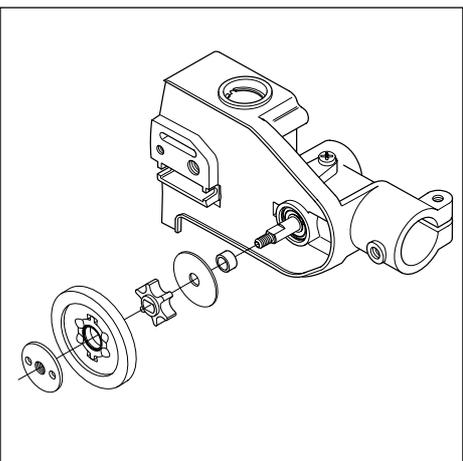


Remove the threaded disc.  
Remove the vibration damper

Use tool 502 52 37-01

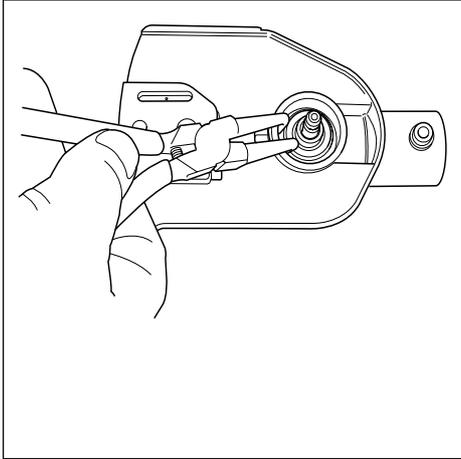


502 52 37-01



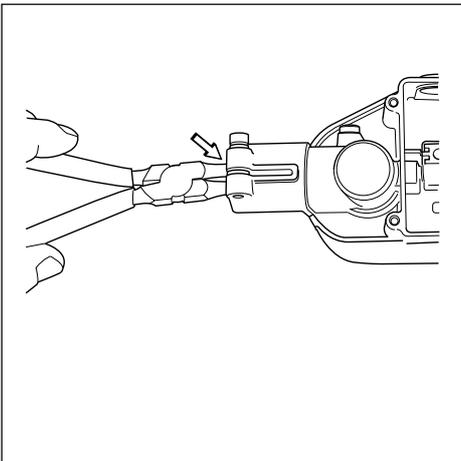
Remove the chain sprocket, washer and spacer.

Gearbox with oil pump



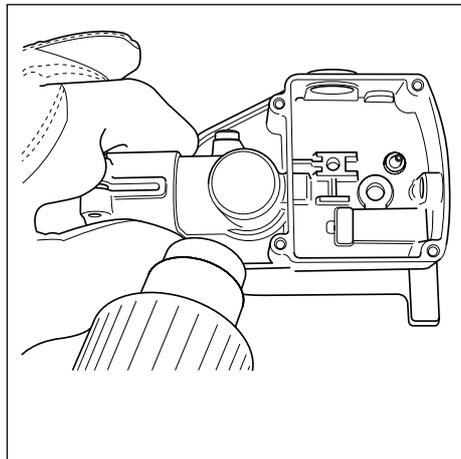
Remove the circlip for the bearing on the output axle.

Use circlip pliers.



Remove the outer circlip on the pinion bearing.

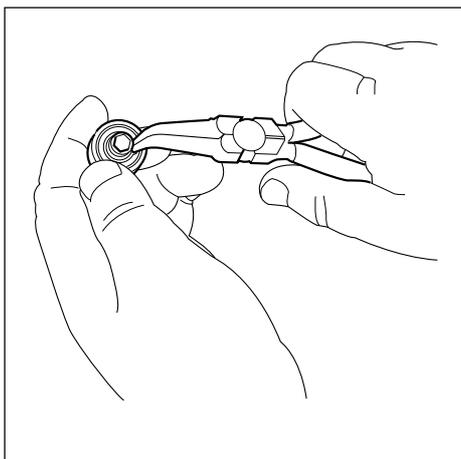
Use circlip pliers.



First remove the pinion and pinion bearing and then the output axle with the two bearings, crown wheel and eccentric cam.

**WARNING!**  
Risk for burns.  
Wear gloves!

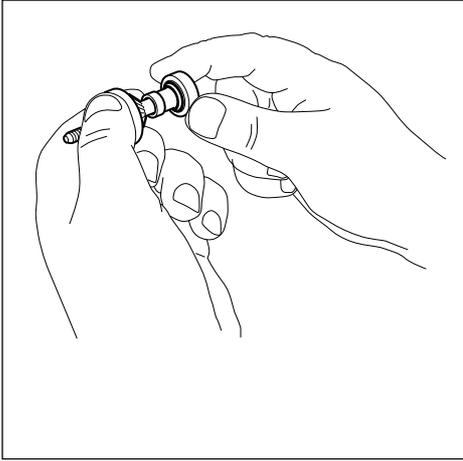
Heat using a hot air gun to approx. 125°C and knock against a wooden surface.



Remove the inner circlip from the pinion bearing and remove the bearing from the pinion.

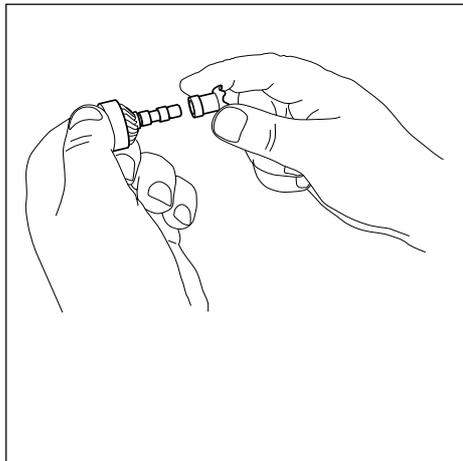
Use circlip pliers. Replace the bearing if necessary.

# 5 Gearbox with oil pump



Remove the bearings from the output axle.

Replace the bearings if necessary.



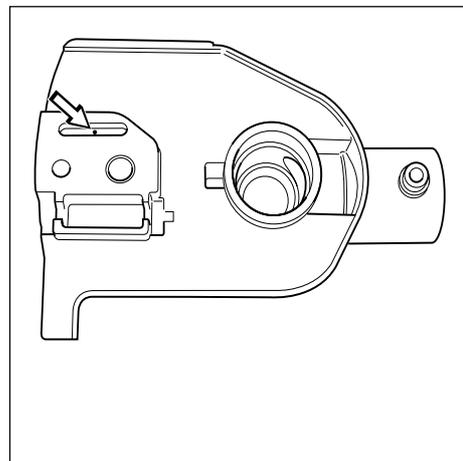
Remove the eccentric cam for the oil pump from the output axle.

Replace the eccentric cam with signs of wear.

Clean and inspect the component parts.

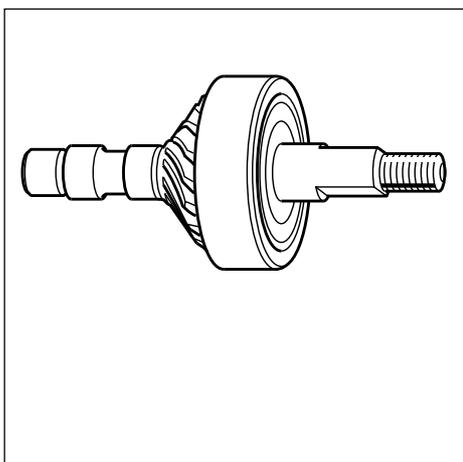
Replace the crown wheel and pinion at the same time. Wash the bearings and blow dry using compressed air. Hold the bearing so that it does not rotate when blowing clean. New bearings should not be cleaned.

Wash off all old grease so that no chips remain in the housing.



Blow out the channel for chain lubrication using compressed air and check that it is not blocked.

Blow in both directions.



## Assembling

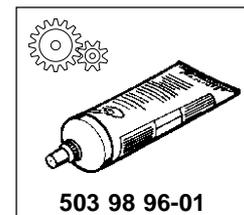
325 P4:

Use weak nut lock fluid when stated in the text during assembly.

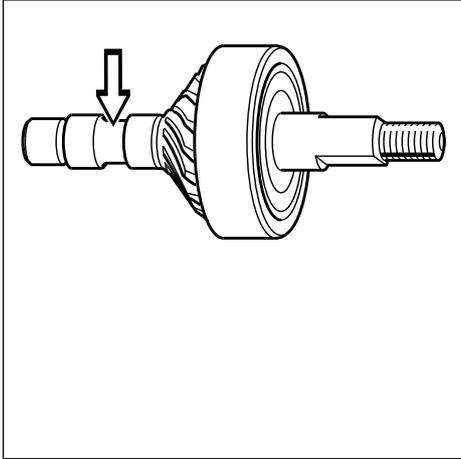
Lubricate the components with grease 503 98 96-01 when assembling.

Fill all ball-bearings with grease.

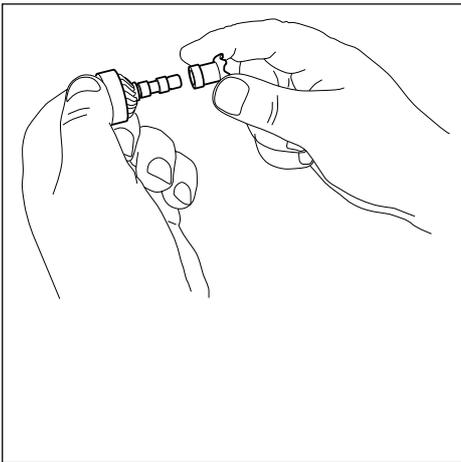
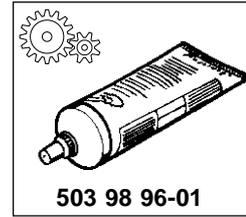
Fit the large bearing on the output axle. Punch 502 50 30-04.



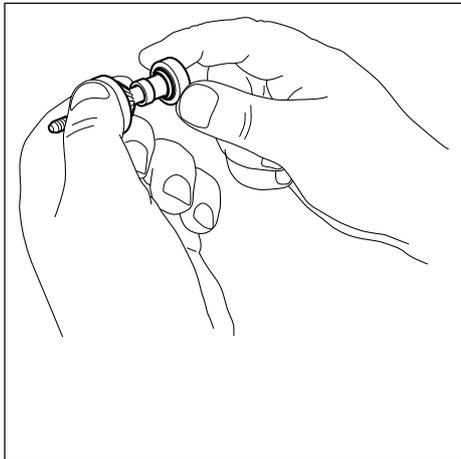
Turn the bearing with the sealed face towards the thread.



Fill the grease pocket on the output axle under the eccentric cam with grease.

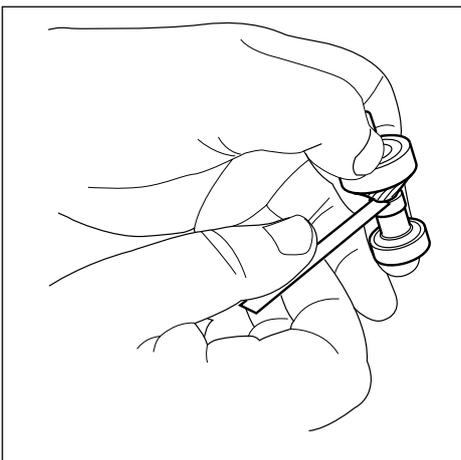


Fit the eccentric axle with the narrow end towards the crown wheel.



Fit the small bearing on the output axle. Punch 502 50 30-04.

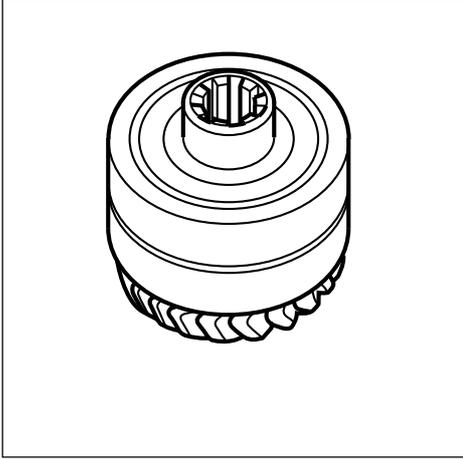
The eccentric cam shall engage with the ball holder.



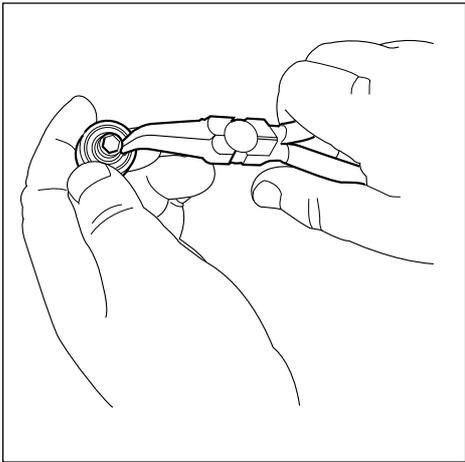
Make sure there is 0.3 mm of axial play between the eccentric cam and collar on the output axle.

Machine the eccentric cam's small end surface to get the correct play, if necessary. Make sure the bearing sits against the collar on the axle otherwise this affects the play between the pinion and crown wheel.

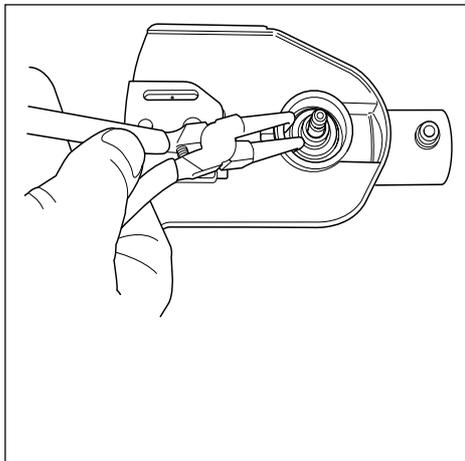
# 5 Gearbox with oil pump



Fit the bearings on the pinion. Turn the sealed face outwards (towards the shaft). Punch 502 50 30-08.

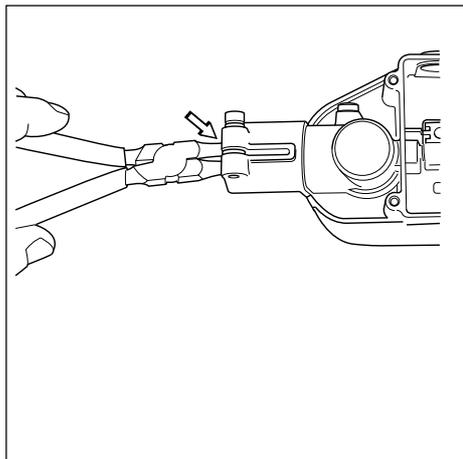


Fit the inner circlip on the pinion.

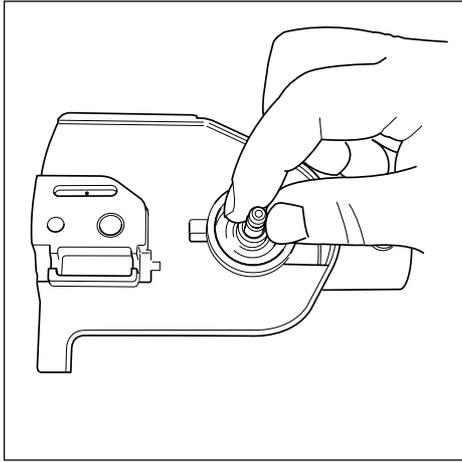


Heat using a hot air gun to approx. 125°C. Press in the output axle up until the stop and fit the circlip before the housing has cooled.

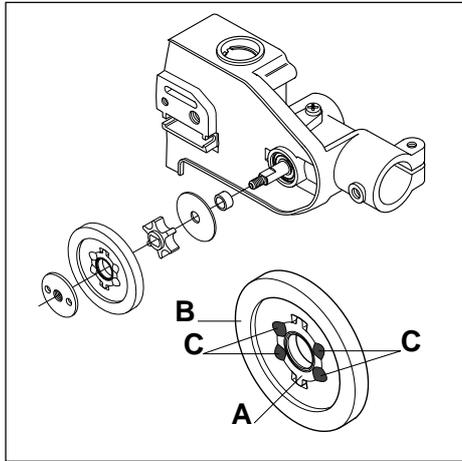
 **WARNING!**  
Risk for burns.  
Wear gloves!



Press in the pinion to the stop and fit the outer circlip before the housing has cooled.



Check that the gearbox turns easily.



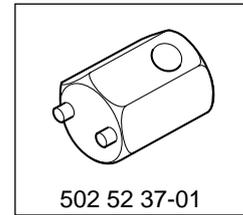
Position the spacer sleeve, washer, sprocket, vibration damper and nut on the output axle.

Check that the hub (A) and the disc (B) on the vibration damper are not worn or cracked. Replace if necessary.

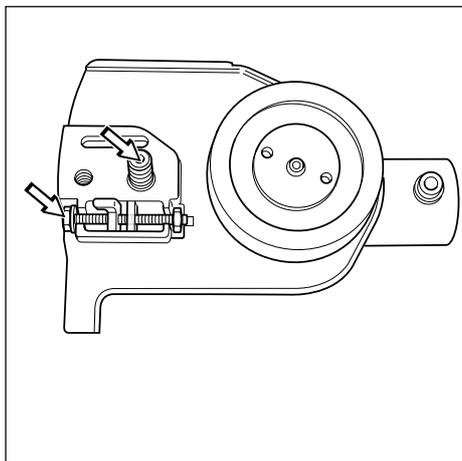
Check that the rubber element (C) is not worn or deformed. Replace if necessary. All four rubber elements should be replaced at the same time.

The threaded disc should be tightened to 16 Nm.

Use tool 502 52 37-01

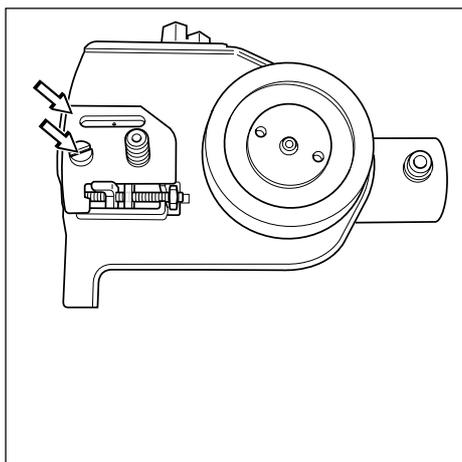


502 52 37-01



Fit the chain adjuster.

The washer should be placed under the screw head.

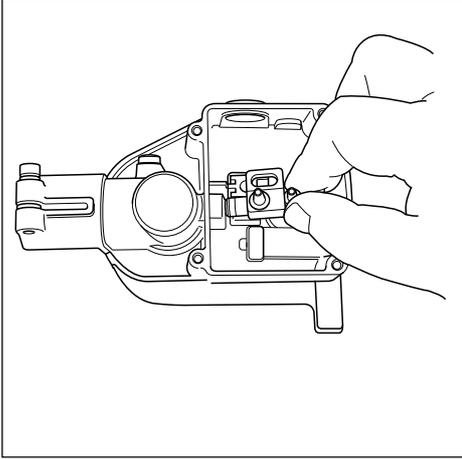


Fit the plate and front slotted screw.

Secure the screw using weak thread lock fluid.

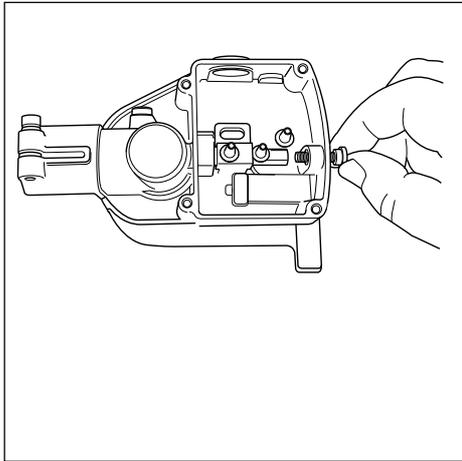
Secure using weak thread lock fluid.

# 5 Gearbox with oil pump



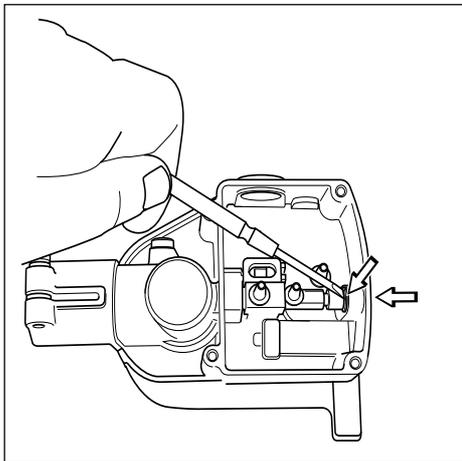
Insert the pump piston in the pump housing.  
Lubricate the pump's outer O-ring with grease. Fit the oil pump complete.

Note!  
Exercise care. The pump piston can be damaged if scratching occurs.



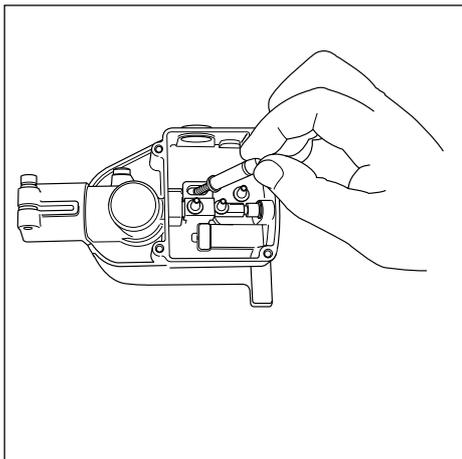
Lubricate the oil adjuster screw's O-ring with grease. Fit the adjuster screw.

Screw in the oil adjuster screw up to the stop.

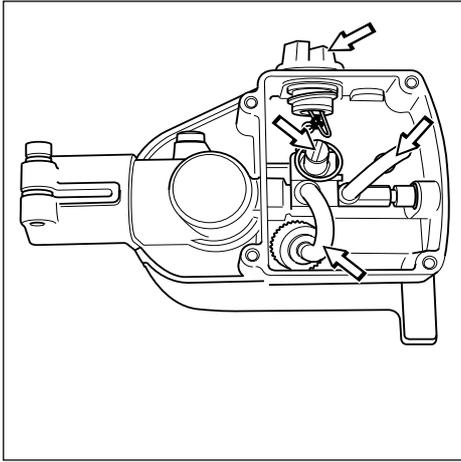


Position the oil adjuster screw's locking washer.  
Make a basic oil flow setting, open the oil adjuster screw 3 turns.

Fit a new locking washer.



Lubricate the O-ring to the oil pump's locking screw with grease.  
Fit the locking screw.



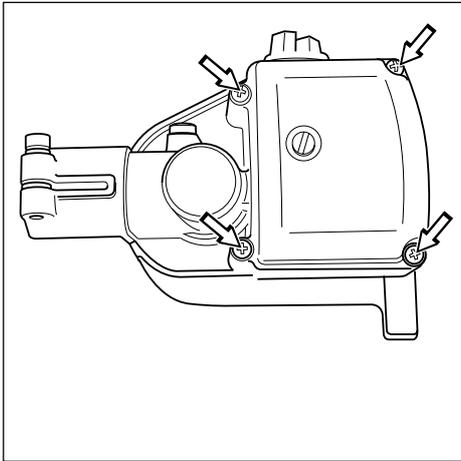
Fit the oil filter with the hose on the nipple closest to the shaft mounting.

Fit the hose for chain lubrication on the two remaining nipples.

Fit the oil-filling cap.

Replace the filter and hoses if they have aged.

Place the ring for the oil-filling cap's chain around the oil pump's locking screw.

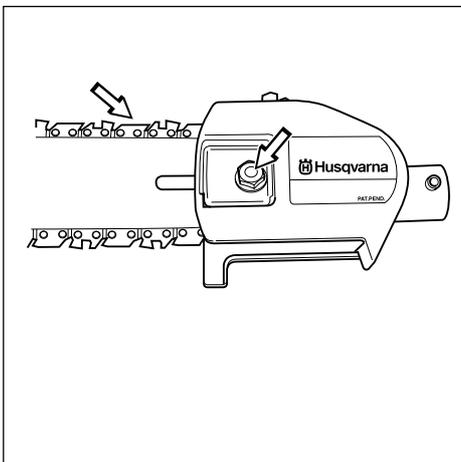


Fit the oil cover with gasket.

Make sure the sealing surfaces (even the gasket) are clean.

Secure the screws using weak thread lock fluid.

Do not tighten too tight. Tighten crosswise and only so the gasket spreads out about 1 mm.

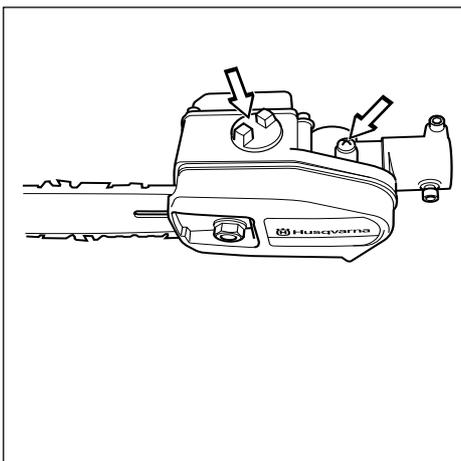


Fit the bar with chain and cover.

Adjust the chain tension and tighten the nut on the cover.

Make sure all contact surfaces are clean.

Turn the chain as illustrated.



Fill the angle gear approx. 2/3 full with grease through the grease plug.

Fill the oil tank with chain saw oil, let the gearbox stand for a few hours and check that no leakage has occurred.

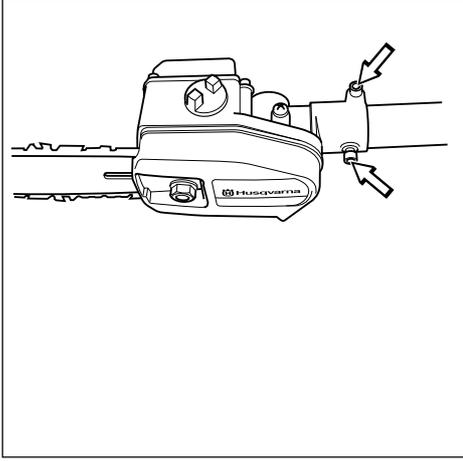
Bild 2 från kapitel 2. Visa hur kedjan är monterad.  suttern.



503 98 96-01

# 5 Gearbox with oil pump

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Fit the gearbox on the shaft.

Test run. Set the oil flow for chain lubrication.

Check and adjust the chain tension after test running.

See the Instruction Manual.



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