

Product: EXCAVATOR

Model: 323F LN EXCAVATOR YEC

Configuration: 323F LN Excavator YEC00001-UP (MACHINE) POWERED BY C4.4 Engine

## Disassembly and Assembly 320F, 323F Excavators Machine Systems

Media Number -M0066628-06

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i06226016

## Final Drive - Assemble

SMCS - 4050-016

## Assembly Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	1P-2420	Transmission Repair Stand	1
B	138-7573	Link Bracket	2
D	138-7574	Link Bracket	2
G	126-3994	Duo-Cone Seal Installer	1
H	5P-3931	Anti-Seize Compound	
F	1U-8846	Gasket Sealant	

**Note:** Apply a light film of hydraulic oil to all components before assembly.

1. Install the final drive sprocket if the sprocket was removed from the main housing.
  2. Remove the final drive sprocket.
-

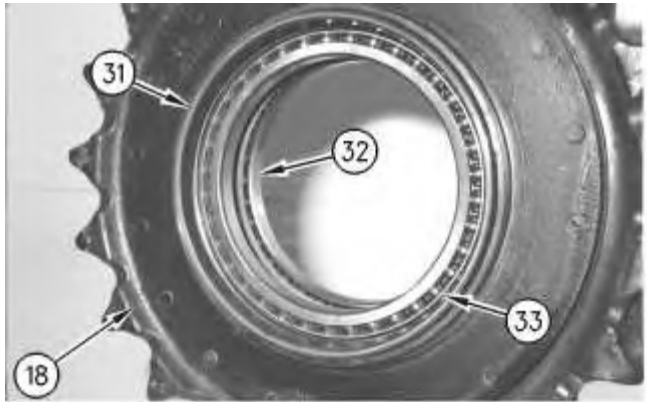


Illustration 1

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3. Apply Tooling (H) to the outer diameter of the bearings.
4. Install bearings (32) and (33) in main housing (18) with a suitable press.
5. Make sure that bearing (32) and bearing (33) contact the counterbore in the main housing.
6. Use the following procedure to preload the bearings and determine the correct thickness of shims.

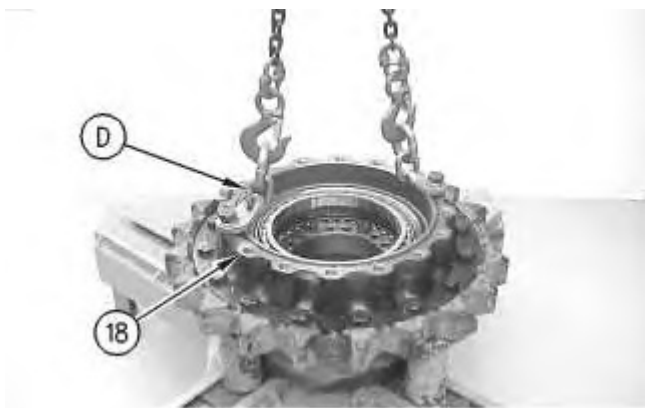


Illustration 2

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- a. Fasten Tooling (D) and a suitable lifting device to main housing (18). Install the main housing on the motor housing.
- b. Put the main housing and the motor housing in a suitable press.

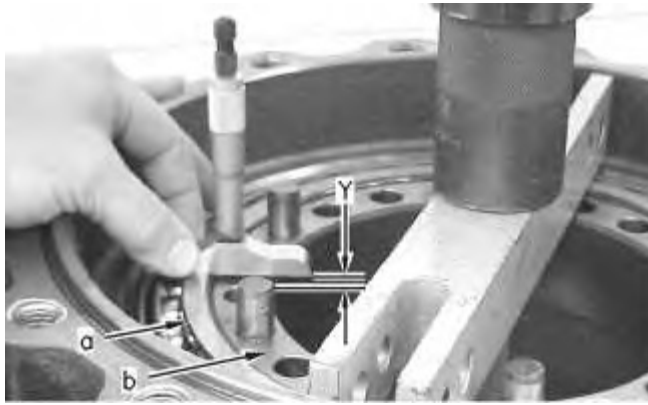


Illustration 3

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- (a) Bearing surface
- (b) Housing surface

- c. Use a suitable press and a spacer in order to apply a load of 4000 kg (8819 lb) on the bearings. Rotate the housing in order to seat the bearings.
- d. Reduce the load on the bearings to  $1000 \pm 100$  kg ( $2205 \pm 221$  lb).
- e. Use a depth micrometer in order to measure the step length between the bearing surface and the housing surface. Take measurements at several different locations around the housing. Compute the average of the measured dimensions and record the number. Call this Dimension (Y).

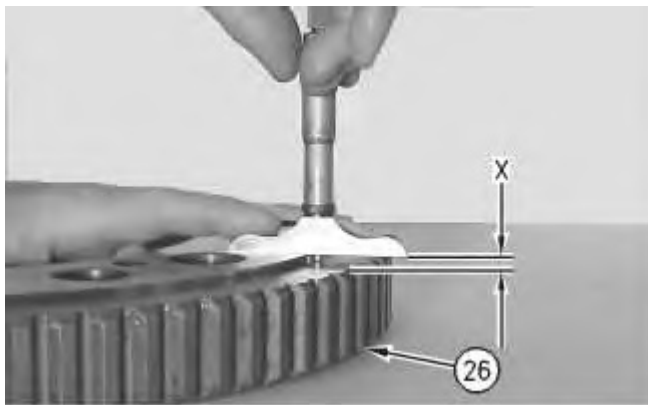


Illustration 4

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- f. Use a depth micrometer in order to measure the step length of the coupling gear (26). Take measurements at several different locations around the gear. Compute the average of the measured dimensions and record the number. Call this Dimension (X).
- g. The thickness of the shims is equal to  $(X - Y) \pm 0.05$  mm (0.002 inch).

**Note:** Use no more than two shims. If two shims are required, install the thinner shim next to the gear.

- h. Remove the main housing from the motor housing.

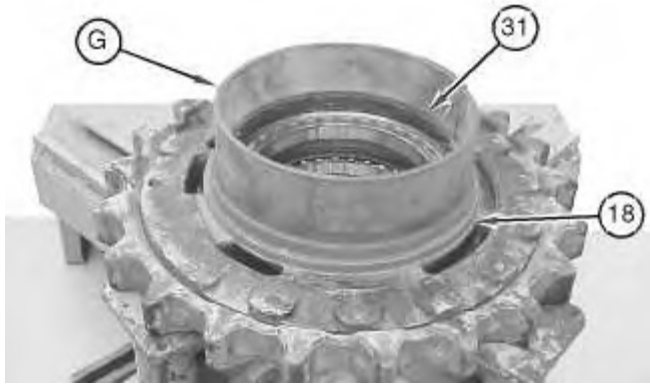


Illustration 5

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7. Use Tooling (G) in order to install Duo-Cone seal (31) in main housing (18). Refer to Disassembly and Assembly, "Duo-Cone Conventional Seals - Install".

**Note:** The rubber seals and all surfaces that contact the seals must be clean and dry. After installation of the seals, put clean SAE 30 oil on the contact surfaces of the metal seals.



Illustration 6

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8. Use Tooling (G) in order to install Duo-Cone seal (29) in motor housing (28).



Illustration 7

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