Disassembly and Assembly
365B, 365B Series II, 365BL and 365BL Series II Excavators Machine Systems

i02789460

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	138-7575	Link Bracket	5
C	140-7642	Duo-Cone Seal Installer As	1
F	1P-1859	Retaining Ring Pliers	1
G	138-7576	Link Bracket	2
H	5P-3931	Anti-Seize Compound	1
J	9S-3263	Thread Lock Compound	1
K	1U-8846	Gasket Sealant	1

1. Make sure that all parts of the final drive are thoroughly clean and free of dirt and debris prior to assembly.

   Note: Check the condition of all the O-ring seals that are used in the final drive. If any of the seals are worn or damaged, use new parts for replacement.

2. Reassemble the final drive on Tooling (A) .

Illustration 1   g00599211

3. Apply Tooling (H) to the surfaces that contact the bearing cones. Install the bearing cone with a press. Raise the temperature of bearing (50) and install bearing (50) .

4. Apply Tooling (H) to the surfaces that contact pins (49) . Install pins (49) .

Illustration 2   g00599224

5. Apply Tooling (H) to the surfaces that contact bearing cups (48) and (47) . Install bearing cups (48) and (47) .

Illustration 3   g00596986

6. Install bearing (45) and the bearing cone.
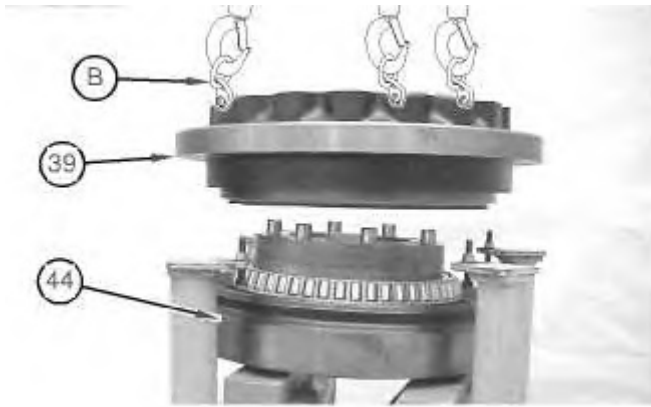

Illustration 4   g01035739

7. Attach Tooling (B) and a suitable lifting device to main housing (39) . Install the main housing on motor housing (44) , as shown.

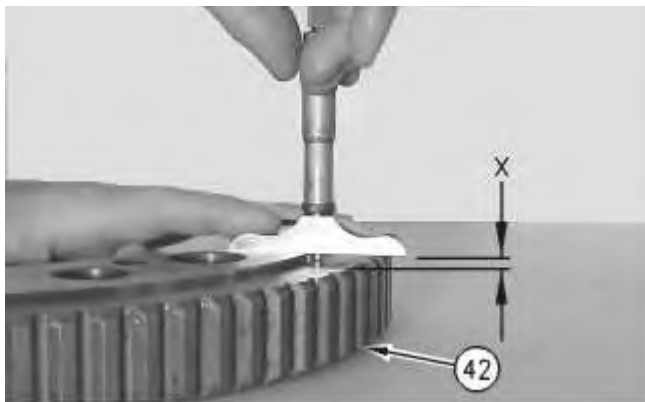8. Use the following procedure to determine the bearing preload and the correct number of shims.

Illustration 5   g00603328

   a. Use a depth micrometer in order to measure the step length of the coupling gear (42) . Take measurements at several different locations around the gear. Compute the average of the measured dimensions and record the number. Call this dimension (X) .

   b. Use a suitable press and a spacer in order to apply a load of 10000 kg (22046 lb) on the bearings.

   c. Rotate the main housing in order to seat the bearing.

   d. Reduce the load on the bearings to 3700 ± 370 kg (8157 ± 815 lb).

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