

Product: MOBILE HYD POWER UNIT

Model: 390F MOBILE HYD POWER UNIT B37

Configuration: 390F Mobile Hydraulic Power Unit B3700001-UP (MACHINE) POWERED BY C18 Engine

## Disassembly and Assembly 390F Excavator Machine Systems

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i05680270

## Travel Motor - Disassemble

SMCS - 4351-015

## Disassembly Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	138-7575	Link Bracket	2
B	1P-0074	Slide Hammer Puller Gp	1
C	123-4370	Threaded Rod M20 - 2.5	2
D	1P-1864	Pliers	1
E	1P-1858	Pliers	1
F	1P-0520	Driver Group	1
G	8T-0349	Bolt	2

### Start By:

- a. Remove the travel motor.

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### NOTICE

Care must be taken to ensure that fluids are contained during performance of inspection, maintenance, testing, adjusting, and repair of the product. Be prepared to collect the fluid with suitable containers before opening any compartment or disassembling any component containing fluids.

**Refer to Special Publication, NENG2500, "Dealer Service Tool Catalog" for tools and supplies suitable to collect and contain fluids on Cat products.**

**Dispose of all fluids according to local regulations and mandates.**

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**Note:** Cleanliness is an important factor. Before you begin the disassembly procedure, the exterior of the components should be thoroughly cleaned. This will help to prevent dirt from entering the internal mechanism. Precision components can be damaged by contaminants or by dirt. Perform disassembly procedures on a clean work surface. Keep components covered and protected at all times.

1. Place an alignment mark across all housings of the travel motor for assembly purposes.



Illustration 1

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**! WARNING**

**Personal injury can result from parts and/or covers under spring pressure.**

**Spring force will be released when covers are removed.**

**Be prepared to hold spring loaded covers as the bolts are loosened.**

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2. Remove two socket head bolts (2) from head (1) that are 180 degrees from each other. Replace these two bolts with Tooling (G). Tooling (G) will retain the brake cover when the remaining socket head bolts (2) are removed.
  3. Carefully remove the remaining socket head bolts (2) that retain head (1) in position. Remove socket head bolts (2) evenly, in a crisscross pattern.
  4. Remove Tooling (G) from head (1).
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Illustration 2

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5. Install Tooling (A) and a suitable lifting device to head (1).
6. Remove head (1) from the travel motor. The weight of head (1) is approximately 68 kg (150 lb).

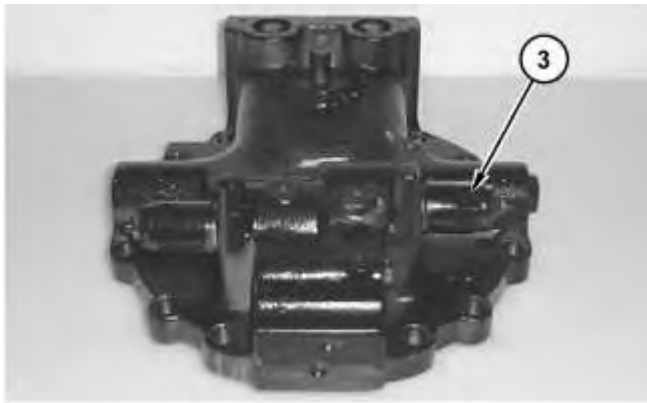


Illustration 3

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7. Remove relief valve (3).

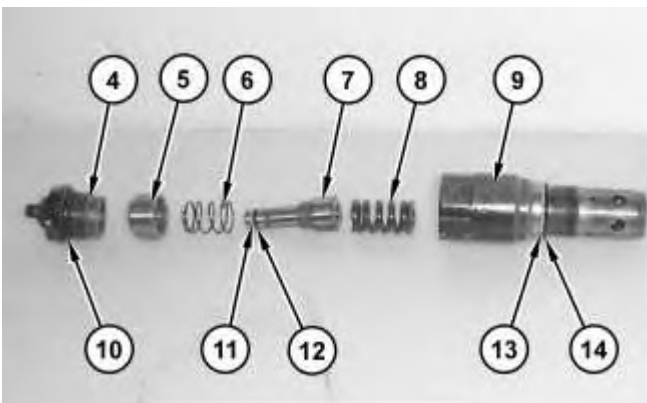


Illustration 4

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## **WARNING**

**Personal injury can result from being struck by parts propelled by a released spring force.**

**Make sure to wear all necessary protective equipment.**

**Follow the recommended procedure and use all recommended tooling to release the spring force.**

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8. Remove cap (4) from body (9). Remove piston (5), spring (6), spool (7), and spring (8) from body (9).
9. Remove O-ring seals (10), (12), and (14). Remove backup rings (11) and (13).
10. Remove the other relief valve from the other side of the head.
11. Repeat Steps 8 and 9 for the disassembly of the other relief valve.



Illustration 5

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12. Remove plug (15).

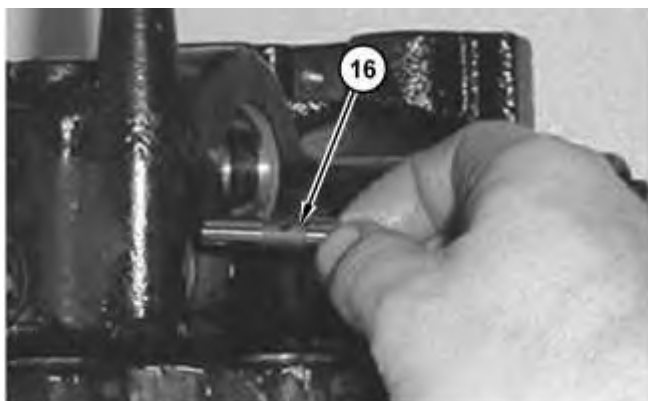


Illustration 6

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