CATERPILLAR®

Service Repair Manual

Models

316F L Excavator

Product: EXCAVATOR

Model: 316F L EXCAVATOR YDL

Configuration: 316F L Excavator YDL00001-UP (MACHINE) POWERED BY C4.4 Engine

Disassembly and Assembly
316F, 318F Excavator Machine Systems

Media Number -UENR5585-06   Publication Date -01/08/2015   Date Updated -12/09/2018

i07186488

Final Drive

SMCS - 4050

Specifications

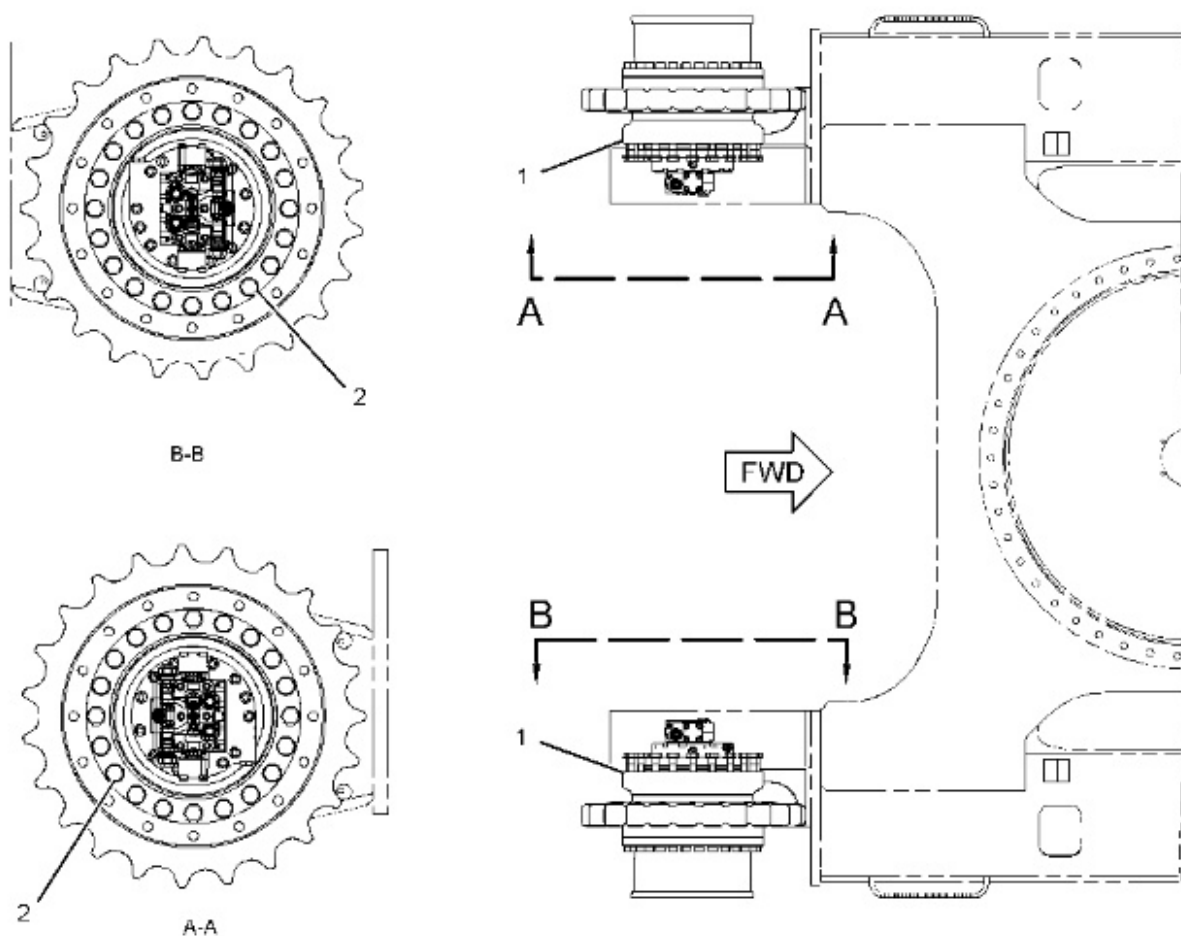**Note:** Callouts in the Specifications section do not match the callouts in the Remove and Install sections.

Illustration 1 g02737737

Top view

Table 1

Specification for 333-3002 Final Drive and Mounting Gp			
Item	Qty	Part	Specification Description
1	-	-	Before assembly, the surfaces must be clean and free of any protective coating.
2	40	**461-3873** Bolt	Apply Loctite C5A Copper Anti-Seize to threads. Torque to 90 ± 15 N·m (66 ± 11 lb ft). Turn an additional angle of 60 ± 5 degrees.

Illustration 2 g02737820

Table 2
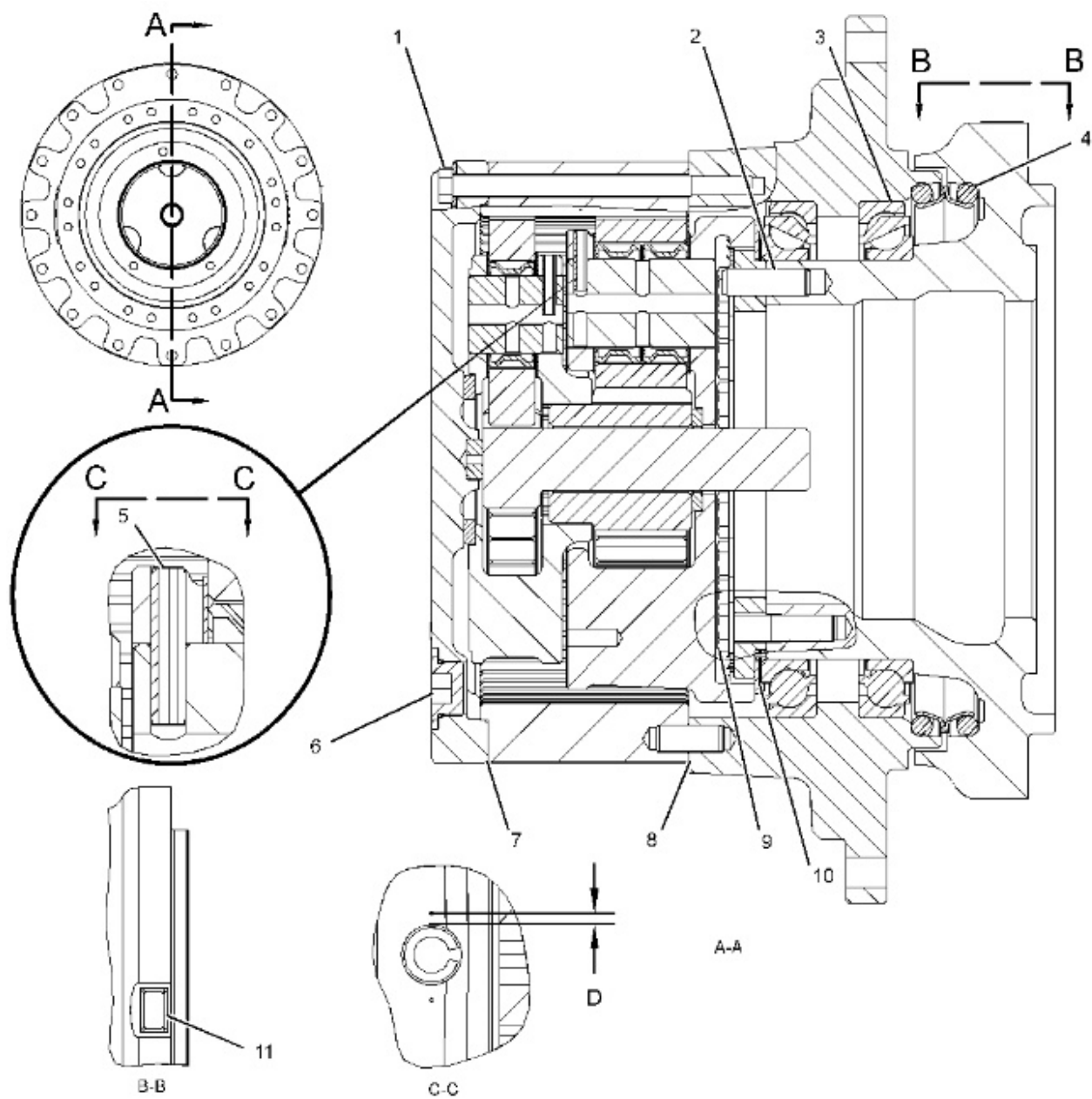
Item	Qty	Part	Specification Description
		Specification for 350-0452 Final Drive Gp	
1	16	**8T-7929** Bolt	Apply red Loctite 271 to the threads. Torque to 105 ± 20 N·m (929 ± 177 lb in).
2	4	**114-1539** Dowel Pin	Apply Loctite C5A Copper Anti-Seize to the inside diameter and outside diameter of the mating parts.
3	2	**296-6220** Ball Bearing	Apply Loctite C5A Copper Anti-Seize to the inside diameter and outside diameter of the mating parts.
4	1	**174-4874** Duo-Cone Seal Gp	Rubber toric seals and all surfaces that in contact with the seals must be clean and dry at assembly. Prior to assembly apply, a thin layer of **6V-4876** Lubricant to the surfaces that are in contact with the metal seals. The metal seal must be assembled square with the bore. The rubber toric seals must not bulge. The rubber toric seals must not be twisted.
5	6	**095-0891** Spring Pin	After installation of the spring pins (5), create two stake marks for each pin slightly near the hole of spring pins. Refer to Illustration 2 for the locations of the stake marks.
6	2	**3E-2338** Pipe Plug	Torque to 80 ± 10 N·m (59 ± 7 lb ft).
7	1	**165-5790** Cover	Before assembly, apply **8C-8422** Sealant to the mating surfaces of the cover.
8	1	**165-3892** Ring Gear	Before assembly, apply **8C-8422** Sealant to the mating surfaces of the ring gear.
9	16	**227-6034** Bolt	Torque to 270 ± 40 N·m (199 ± 30 lb ft).
10	As required, use the following shims to achieve the correct clearance between the ball bearing and the coupling gear. If two shims (10) are required, install the thinnest shim next to the coupling gear:		
	1	**096-1773** Shim	Thickness is 0.15 mm (0.006 inch).
	1	**096-1774** Shim	Thickness is 0.30 mm (0.012 inch).
	1	**096-1775** Shim	Thickness is 0.40 mm (0.016 inch).
	1	**096-1776** Shim	Thickness is 0.50 mm (0.020 inch).
	1	**096-1777** Shim	Thickness is 0.60 mm (0.024 inch).
	1	**096-1778** Shim	Thickness is 0.70 mm (0.028 inch).

	1	**096-1779** Shim	Thickness is 0.80 mm (0.031 inch).
	1	**096-1780** Shim	Thickness is 1.00 mm (0.039 inch).
	1	**096-1781** Shim	Thickness is 1.60 mm (0.063 inch).
D	-	-	The distance from the edge of the spring pin hole to the stake mark is 1.5 mm (0.06 inch).
11	1	**354-4318** Nameplate	Apply Loctite 330 or activator 738 to the surface of the nameplate.

Removal Procedure

Table 3

Required Tools			
Tool	**Part Number**	**Part Description**	**Qty**
A	8S-7640	Stand	2
	8S-7611	Tube	2
	8S-7615	Pin	2
B	439-3939	Link Bracket As	2
C	154-6184	Forcing Bolt (M 20)	2

Start By:

a. Separate the track assembly. Refer to Disassembly and Assembly, "Track - Separate".

b. Remove the travel motor. Refer to Disassembly and Assembly, "Travel Motor - Remove".

Illustration 3   g00489826

Note: Adjust the height of Tooling (A) so that there is sufficient clearance between the sprocket and the track for the removal of the final drive.

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