



# Service Repair Manual

## **Models**

323E L, 323E LN, 323E SA  
Excavator

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1. Install final drive (4) in the reverse order of removal.
  - a. Before assembly, remove compound, oil, and dust from female threads, then apply Tooling (B) to the threads of bolts (6).
  - b. Tighten bolts (6) in an alternating sequence to a torque of  $150 \pm 25$  N·m ( $111 \pm 18$  lb ft). Turn an additional angle of  $55 \pm 5$  degrees. Refer to Service Magazine , M0083843 , "An Improved Bolt Tightening Procedure for the Critical Joints Is Now Used on all Excavators" for more detailed information.
  - c. Tighten bolts (3) to a torque of  $80 \pm 8$  N·m ( $59 \pm 6$  lb ft).

## Disassembly Procedure

Table 3

Required Tools			
Tool	Part Number	Part Description	Qty
A	1P-2420	Transmission Repair Stand	1
B	439-3938	Link Bracket	2
C	154-6181	Forcing Bolt	1
D	439-3939	Link Bracket As	2
E	5F-7366	Forcing Bolt	1
	1P-5546	Crossblock	1
	1U-9889	Crossblock	1
	1P-0520	Driver Group	1
	6V-7888	Puller Leg	2
	1H-3112	Puller Assembly	1
	1P-5551	Adjustable Screw Assembly	1
F	1U-8846	Gasket Sealant	1

### Start By:

- a. Remove the final drive.
    1. Put an alignment mark across the sections of the final drive for assembly purposes. The parts must be reinstalled in the original locations.
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Illustration 6

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2. Fasten the final drive to Tooling (A), as shown. The combined weight of the final drive and final drive sprocket is approximately 312 kg (688 lb).
3. Remove bolts (1) and the washers that hold the cover in position.

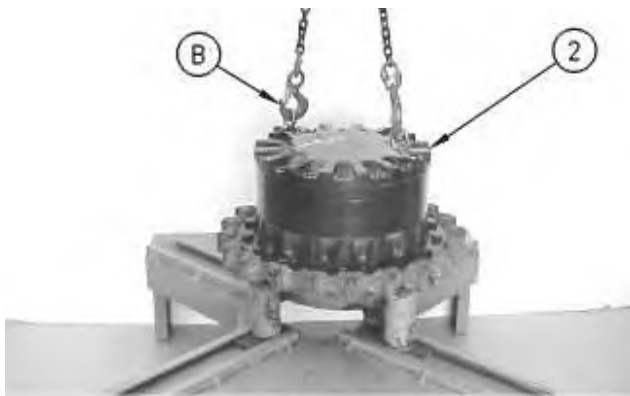


Illustration 7

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4. Remove the setscrews from the cover. Fasten Tooling (B) and a suitable lifting device to cover (2), as shown. The weight of cover (2) is approximately 32 kg (70 lb). Remove cover (2).

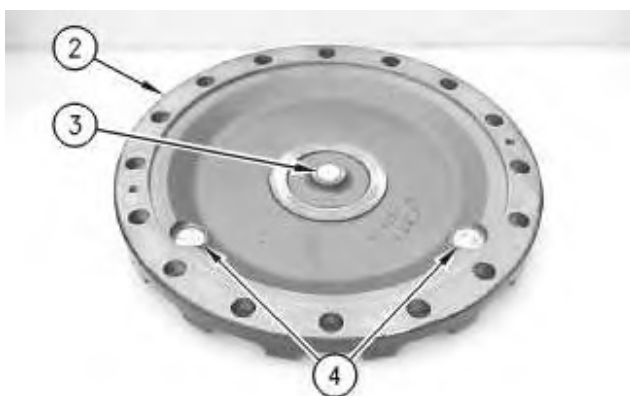


Illustration 8

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5. Remove thrust plate (3) from cover (2).

6. Remove plugs (4) from cover (2).

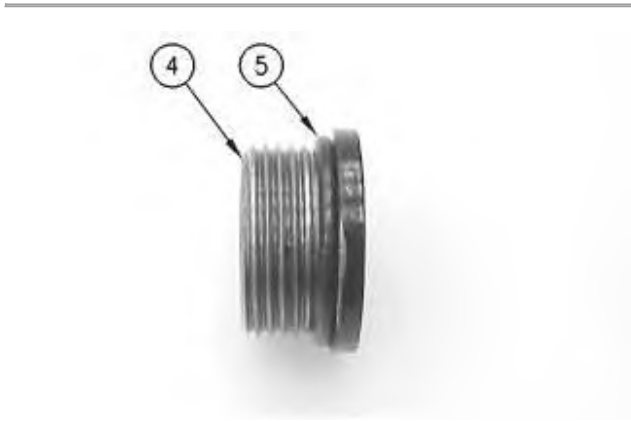


Illustration 9

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7. Remove O-ring seals (5) from both plugs (4) that were in the cover.

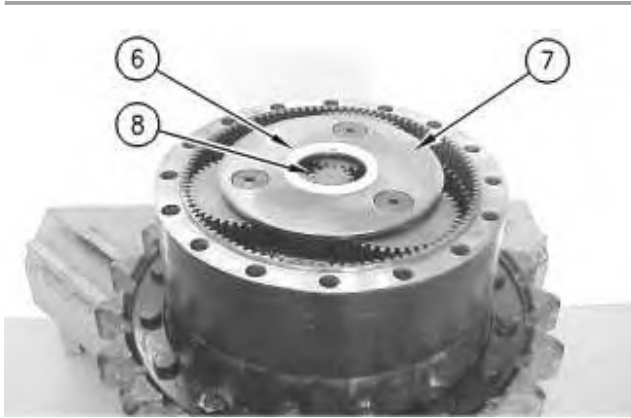


Illustration 10

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8. Remove spacer (6) from carrier assembly (7).

9. Remove sun gear (8) from carrier assembly (7).

10. Remove carrier assembly (7) by lifting the carrier assembly straight up. The weight of carrier assembly (7) is approximately 14 kg (30 lb).

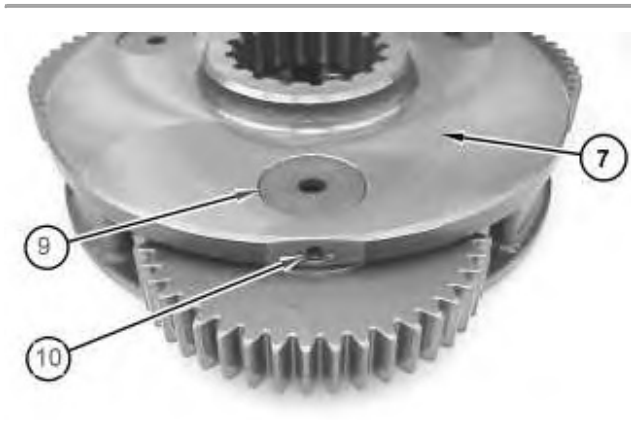


Illustration 11

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11. Disassemble carrier assembly (7), as follows.

- a. Drive spring pin (10) into planetary shaft (9) with a hammer and a punch.



Illustration 12

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- b. Remove planetary shaft (9) with spring pin (10) from the carrier assembly.
- c. Remove spring pin (10) from planetary shaft (9) with a hammer and a punch.

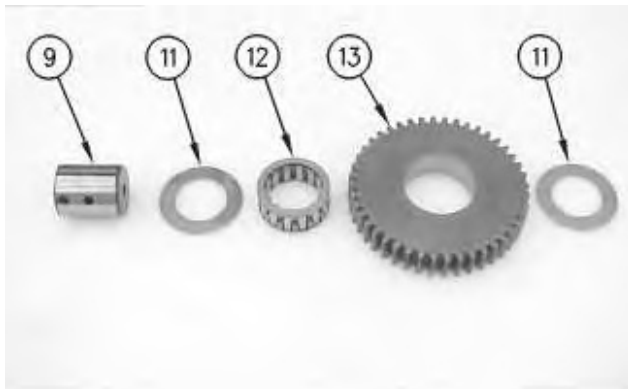


Illustration 13

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- d. Remove thrust washers (11) and planetary gear (13) from the carrier assembly.
  - e. Remove bearing (12) from planetary gear (13).
12. Repeat Steps 11.a through 11.e to remove the remaining planetary gears from the carrier assembly.
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