



Service Repair Manual

Models

326D L Excavator

Product: EXCAVATOR

Model: 326D L EXCAVATOR PJM

Configuration: 326D L Excavator PJM00001-UP (MACHINE) POWERED BY C7 Engine

Disassembly and Assembly

324D, 325D, 326D and 329D Excavators and 329D MHPU Mobile Hydraulic Power Unit Machine Systems

Media Number -REN8646-22

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i07475189

Upper Frame and Undercarriage Frame - Connect

SMCS - 4150-077; 7051-077

Connect Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	-	Loctite C5A Copper Anti-Seize	-
B	228-4533	Boom Cylinder Link Gp	1
C	-	Bar Stock 48 inch by 5 inch Round	1
D	4C-6486	Stand	1
	8S-7621	Tube	2
	8S-8048	Saddle	2
	8S-7615	Pin	2
	8S-7625	Collar	2
	396-9840	Cylinder As	2
	447-0910	Electric Hydraulic Pump Gp115V	1
	447-0911	Electric Hydraulic Pump Gp230V	1
E	FT-2765	Support Beam As	1
F	-	Guide Bolt M24-3 by 250mm	4
G	9U-7536	Lift Stand	2

	447-0910	Electric Hydraulic Pump Gp115V	1
	447-0911	Electric Hydraulic Pump Gp	1
H	-	Guide Bolt M20-2.5 by 250mm	2
J	276-8831	Pin Driver	1
K	-	Loctite RTV Clear Silicone Sealant	-
L	311-1362	Vacuum Gauge Gp	1



Illustration 1

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1. Use a suitable towing device and slowly pull the undercarriage frame assembly into position under upper frame assembly (14). The weight of undercarriage frame assembly is approximately 12383 kg (27300 lb).

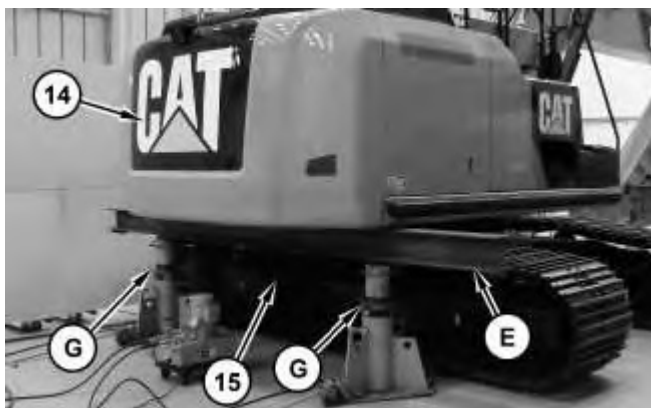


Illustration 2

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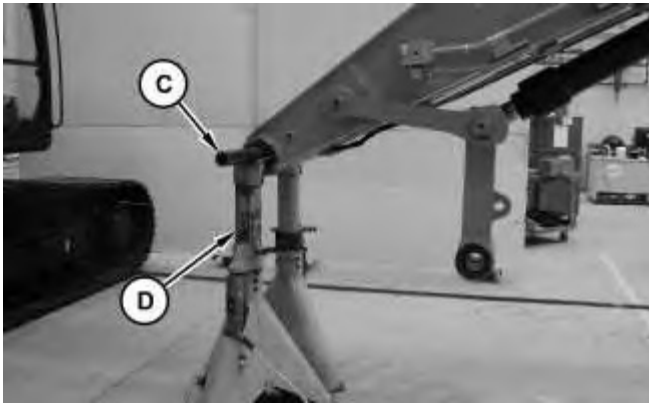


Illustration 3

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2. Use Tooling (D) and Tooling (G) to lower the upper structure onto the undercarriage in increments of 13 mm (0.5 inch). The weight of the upper structure is approximately 22217 kg (48980 lb).

Note: Lower the rear of upper structure first in designated increments to clear the pinion gear with the ring gear.

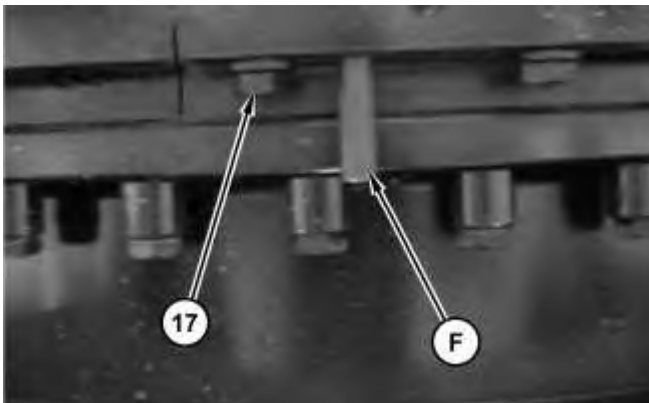


Illustration 4

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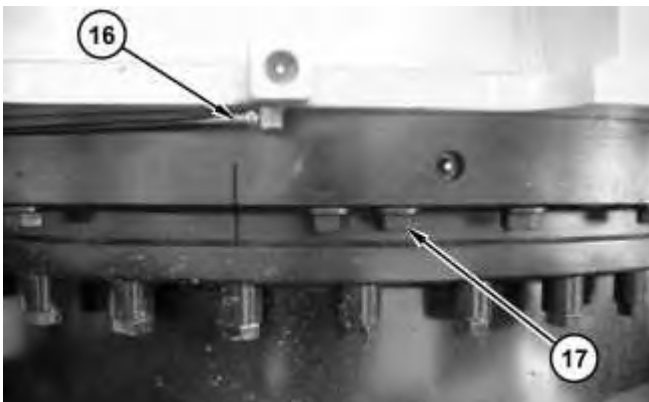


Illustration 5

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3. Remove Tooling (F). Apply Tooling (A) to the threads of bolts (17). Install two bolts (17). Install remaining bolts (17). Torque bolts (17) to a torque of $900 \pm 100 \text{ N}\cdot\text{m}$ ($665 \pm 75 \text{ lb ft}$). Install tube assembly (16).

Note: Torque for bolts (17) is $250 \pm 25 \text{ N}\cdot\text{m}$ ($184 \pm 18 \text{ lb ft}$). Turn an additional angle of 60 ± 5 degrees for 330D and 326D excavators. Refer to Service Magazine , M0083843 , "An Improved Bolt Tightening Procedure for the Critical Joints Is Now Used on all Excavators" for more detailed information.

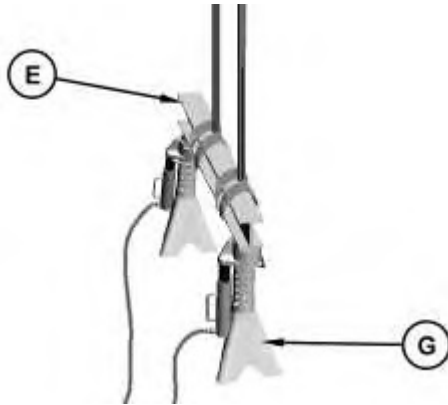


Illustration 6

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4. Attach a suitable lifting device to Tooling (E) and remove Tooling (E) from Tooling (G). The weight of Tooling (E) is approximately 249 kg (550 lb).

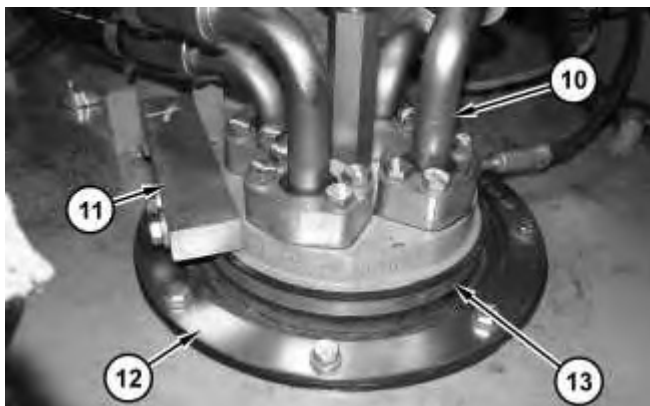


Illustration 7

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 **WARNING**

At operating temperature, the hydraulic oil is hot and under pressure. Hot oils can cause burns.

To prevent possible personal injury, release the pressure in the work tool hydraulic circuit (boom, stick, bucket, and swing), travel circuits,

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