



# Service Repair Manual

## **Models**

326F and 326F L Excavator

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Product: EXCAVATOR

Model: 326F EXCAVATOR FBR

Configuration: 326F L Excavators FBR00001-UP (MACHINE) POWERED BY C7.1 Engine

## Disassembly and Assembly 326F, 329F and 330F Excavators Machine Systems

Media Number -UENR3313-07

Publication Date -01/09/2015

Date Updated -12/09/2018

i05435999

## Travel Motor - Assemble

SMCS - 4351-016

## Assembly Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	1U-7506	Adapter	1
	8T-4244	Nut	6
	8T-4223	Hard Washer	6
	-	M12 x 1.75 X 250 mm (10 inch) Threaded Rod	1
C	3E-3882	Eyebolt	1
D	1P-1859	Retaining Ring Pliers	1
E	1P-0510	Driver Gp	1
	9S-9152	Bearing Puller Gp	1
F	1P-1861	Retaining Ring Pliers	1
G	-	Loctite 242	-



Illustration 1

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1. Install O-ring seal (35) onto the housing of the travel motor.



Illustration 2

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2. Install seal (34) and piston actuator (33). Lubricate the surfaces of piston actuator (33) with lubricant that is being sealed.

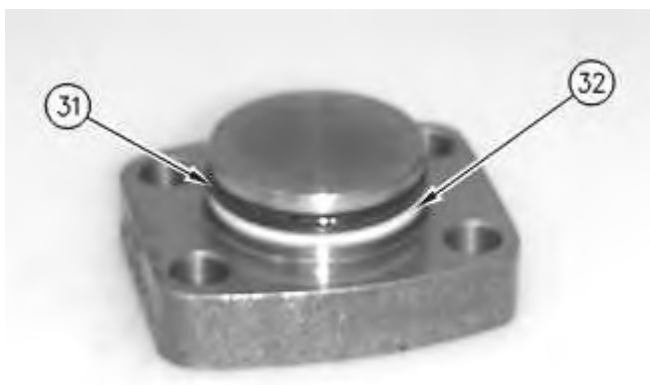


Illustration 3

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3. Install backup ring (32) and seal (31).

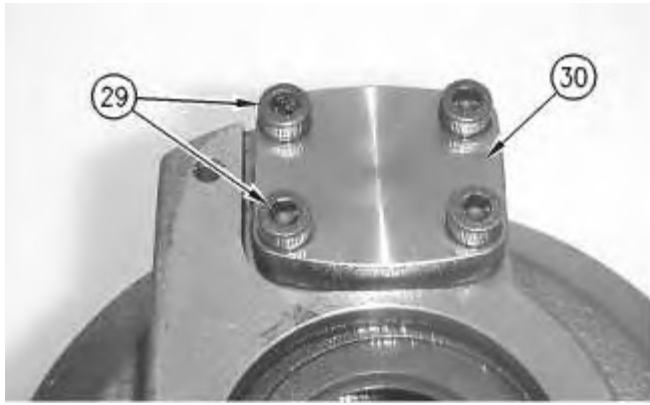


Illustration 4

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4. Install cover (30) and bolts (29). Tighten bolts (29) to a torque of  $28 \pm 7$  N·m ( $21 \pm 5$  lb ft).



Illustration 5

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5. Apply Tooling (G) to the mating surface of lip seal (28). Use Tooling (E) in order to install lip seal (28). Lubricate the sealing lip of lip seal (28) with lubricant that is being sealed.
6. Use Tooling (F) in order to install retaining ring (27).

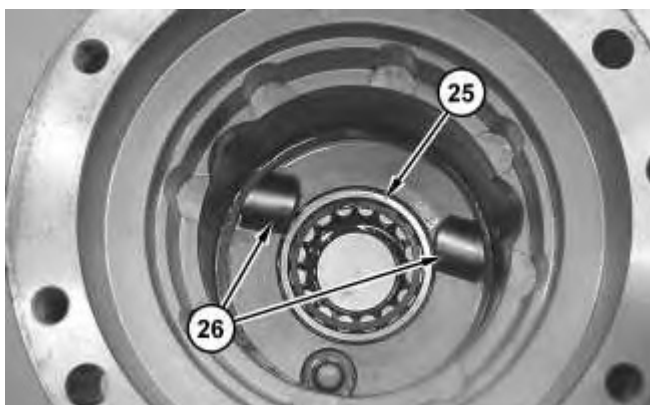


Illustration 6

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7. Rotate the housing.

8. Install keys (26) and locating pins (not shown) into the body of the travel motor.
9. Install bearing (25).



Illustration 7

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## WARNING

**Improper assembly of parts that are spring loaded can cause bodily injury.**

**To prevent possible injury, follow the established assembly procedure and wear protective equipment.**

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10. Install springs (24) into the barrel assembly. Install ball (23) onto springs (24). Lubricate ball (23) with lubricant that is being sealed.

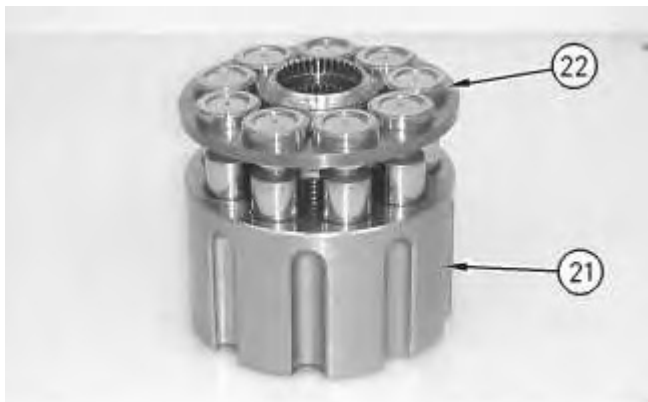


Illustration 8

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11. Lubricate the piston assemblies with lubricant that is being sealed. Install piston assemblies and retainer plate (22) into barrel assembly (21).

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