



# Service Repair Manual

## **Models**

336 GC Excavator

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Product: EXCAVATOR

Model: 336 GC EXCAVATOR EBJ

Configuration: 336 GC Excavator EBJ00001-UP (MACHINE) POWERED BY C7.1 Engine

## Disassembly and Assembly 336 Excavator Machine Systems

Media Number -M0087649-02

Publication Date -01/10/2018

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i05103849

## Final Drive - Assemble

SMCS - 4050-016

## Assembly Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	138-7575	Link Brackets	3
B	154-6183	Forcing Bolts	3
C	138-7576	Link Brackets	3
D	5P-3931	Anti-Seize Compound	-
E	1U-9895	Crossblock	1
F	6V-2012	Depth Micrometer	1
G	6V-7059	Micrometer ( )	1
H	-	Loctite 242	-
J	6V-2055	Grease	-
K	-	Loctite 17430	-
L	8T-9206	Seal Installer	1

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Illustration 1

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1. Apply Tooling (D) to the surface of dowels (46) . Install dowels (46) .
2. Raise the temperature of roller bearing (47) . Install the roller bearing (47) on motor housing (48) .
3. Install Duo-Cone seal (45) .

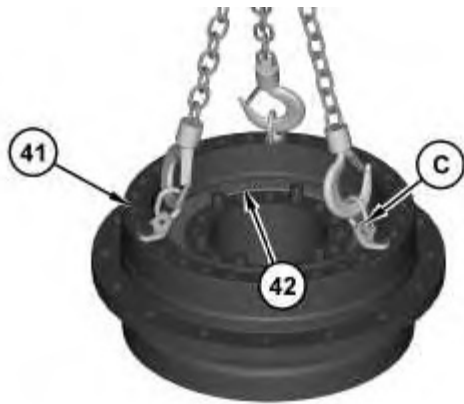


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Illustration 2

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4. Lower the temperature of bearing races (43) . Install bearing races (43) in sprocket housing (41) .
  5. Install Duo-Cone seal (44) .
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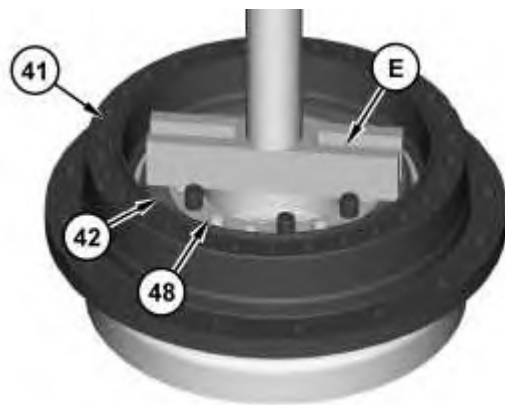


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Illustration 3

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6. Attach Tooling (C) and a suitable lifting device to sprocket housing (41) . The weight of sprocket housing (41) is approximately 107 kg (235 lb). Install sprocket housing (41) .
7. Raise the temperature of roller bearing (42) . Install the roller bearing (42) .

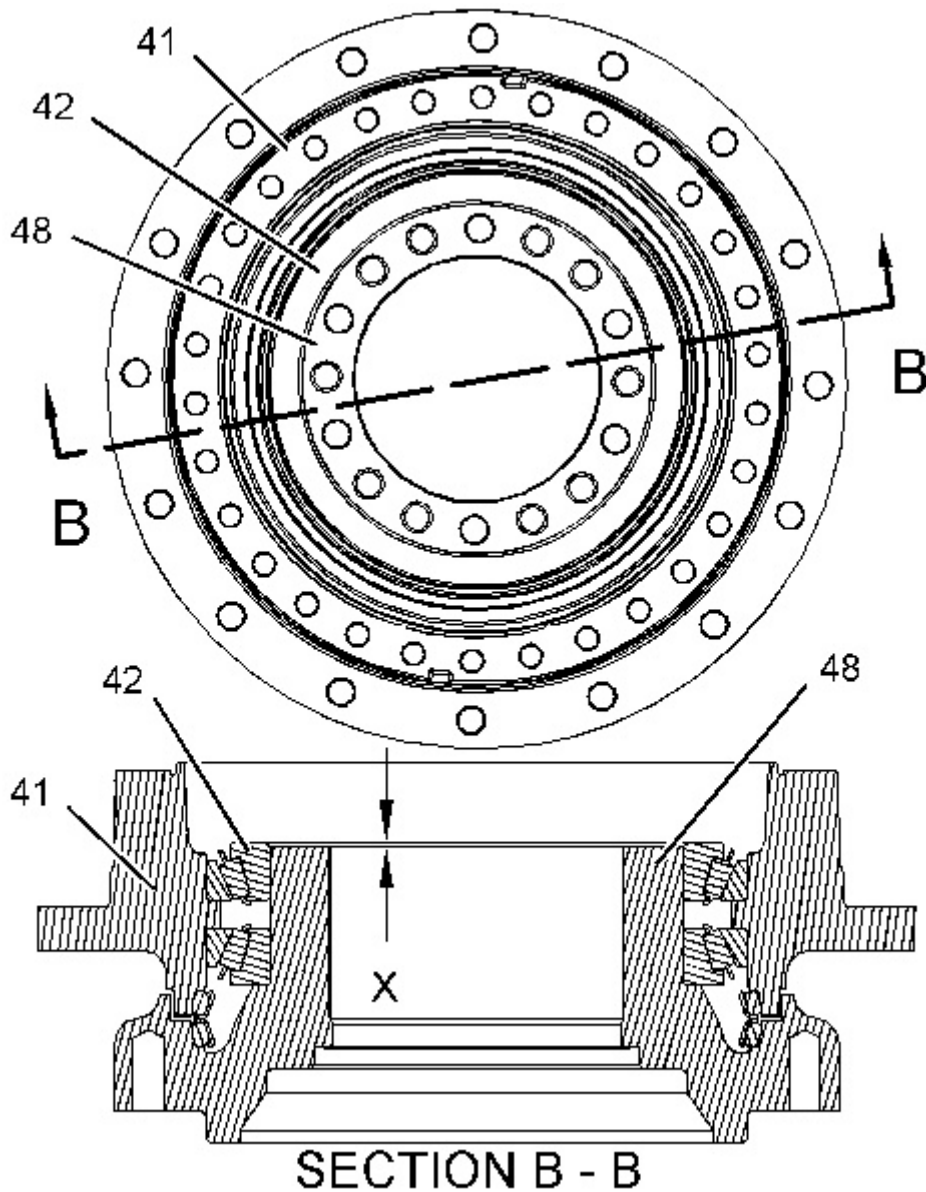


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Illustration 4

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Illustration 5

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8. Use Tooling (E) and a suitable press in order to apply force to roller bearing (42) . Apply a force of 4000 kg (8818 lb) to the top of Tooling (E) . Rotate sprocket housing (41) in order to seat the roller bearings.
  9. Reduce the force on top of Tooling (E) to  $3000 \pm 300$  kg ( $6614 \pm 661$  lb). Use Tooling (F) in order to measure Dimension (X) . Record Dimension (X) .
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