CATERPILLAR®

Service Repair Manual

Models

336D L Excavator

Assembly Procedure

Table 1

Required Tools			
Tool	**Part Number**	**Part Description**	**Qty**
A	1P-2420	Transmission Repair Stand	1
B	138-7573	Link Bracket	2
C	1P-1863	Retaining Ring Pliers	1
D	208-6033	Spanner Socket As	1
	208-6034	Spacer	1
E	138-7574	Link Bracket	2
H	6V-7030	Micrometer Depth Gauge Group	1
J	FT-2770	Leak Down Test Tool	1
K	1U-6396	O-Ring Assembly Compound	1
L	5P-3931	Anti-Seize Compound	1
M	1U-8846	Gasket Sealant	1
N	8T-9206	Duo-Cone Seal Installer As	1
P	5P-3931	Anti-Seize Compound	1
Q	235-4848	Drill Fixture Gp	1
R	9S-3263	Thread Lock Compound	1

Note: Cleanliness is an important factor. Before assembly, all parts should be thoroughly cleaned in cleaning fluid. Allow the parts to air dry. Wiping cloths or rags should not be used to dry parts. Lint may be deposited on the parts which may cause later trouble. Inspect all parts. If any parts are worn or damaged, use new parts for replacement. All disassembly and all assembly procedures must be performed on a clean work surface and in a clean hydraulic area. Keep cleaned parts covered and protected at all times.

Note: O-ring seals, gaskets, and seals should always be replaced. A used O-ring seal may not have the same sealing properties as a new O-ring. Use Tooling (K) during the assembly procedure.

Note: Apply a light film of hydraulic oil to all components before assembly.

Note: Some of the images that are in this procedure do not show the sprocket assembly that is attached to the final drive housing. If necessary, the weights that are given include the weight of the sprocket assembly.

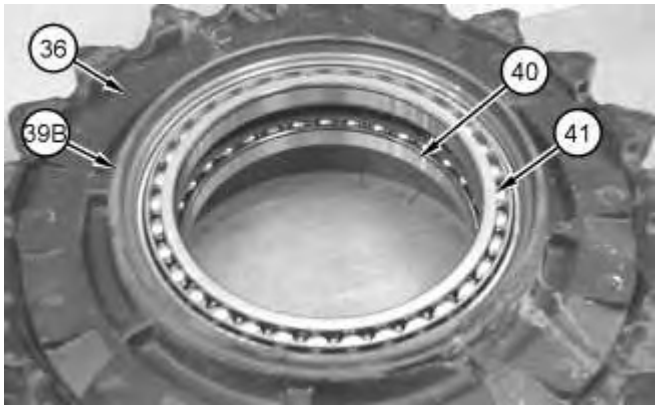

Illustration 1 g01147975

1. Apply Tooling (P) to the outer diameter of the bearings.
2. Use a suitable press to Install bearings (40) and (41). Make sure that bearing (41) and bearing (40) contact the counterbore in housing (36).
3. Use Tooling (N) to install Duo-Cone seal (39B).

Illustration 2 g01147981

4. Use Tooling (N) to install Duo-Cone seal (39A) onto housing (38).

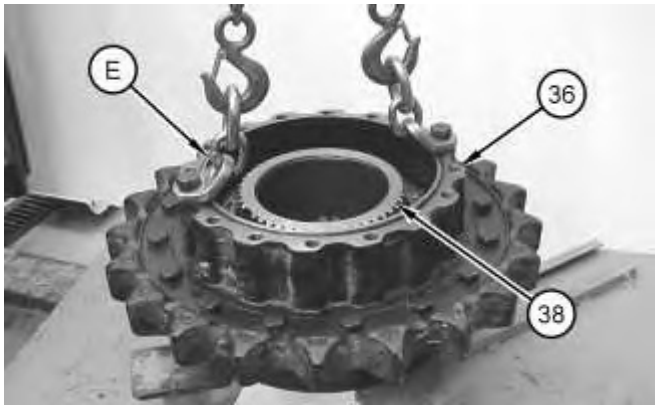

Illustration 3 g01147930

5. Use Tooling (E) and a suitable lifting device to install housing (36) onto housing (38). The weight of housing (36) is approximately 100 kg (220 lb).
6. Remove Tooling (E) from housing (36).

Illustration 4 g01147724

7. Install stopper plate (35). Do not tighten stopper plate assembly (35) at this time.

   Note: Stopper plate (35) will secure housing (36) to housing (38).
8. Install Tooling (E) and a suitable lifting device to housing (36). The combined weight of housing assembly (36) and (38) is approximately 120 kg (265 lb). Install housing assembly (36) and (38) in a suitable press.
9. Remove stopper plate (35).

Illustration 5 g01147727

10. Assemble Tooling (D), as shown.

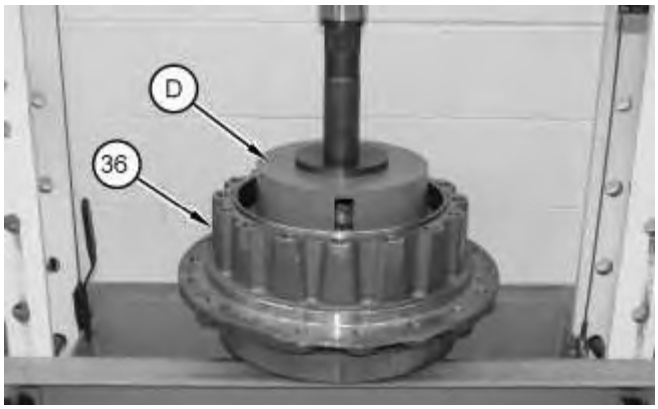

Illustration 6 g01147731

11. Install Tooling (D) into housing (36), as shown.
12. Apply a force of 4000 kg (8818 lb) to the top of Tooling (D). Rotate housing (36) to seat the bearings.
13. Reduce the force on the top of Tooling (D) to 3000 kg (6615 lb).

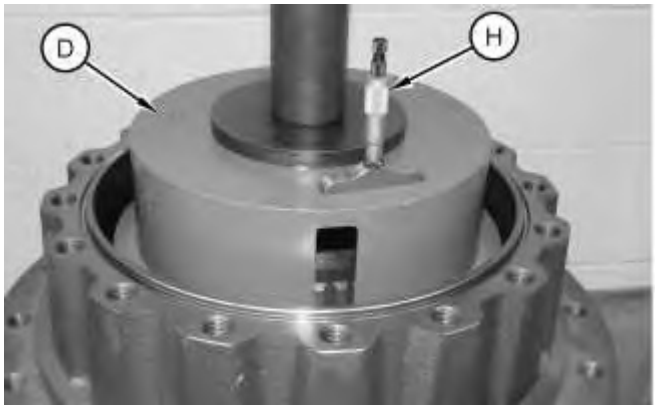

Illustration 7 g01147737

14. Use Tooling (H) to take a measurement in three locations. Average the three measurements and record the average measurement as Dimension (W).
15. Remove Tooling (D).
16. Separate Tooling (D).

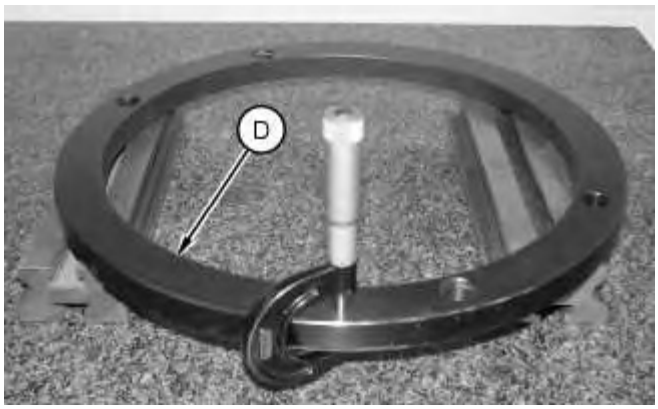

Illustration 8 g01147743

17. Use a micrometer to measure the thickness at three locations of the spacer from Tooling (D). Record the average measurement as Dimension (X).

Illustration 9 g01147742

18. Use a micrometer to measure the thickness at three locations of stopper plate (35). Record the average measurement as Dimension (Y).

19. Subtract Dimension (X) from Dimension (Y) and record this figure as Dimension (Z).

Illustration 10 g01147724

20. Install stopper plate (35) onto housing (38). Do not tighten stopper plate (35) at this time. Stopper plate (35) will secure the final drive assembly while the final drive assembly is repositioned onto Tooling (A).

21. Use Tooling (E) and a suitable lifting device to reposition the final drive assembly onto Tooling (A). The combined weight of housing assembly (36) and (38) is approximately 120 kg (265 lb).

22. Secure the final drive assembly to Tooling (A).

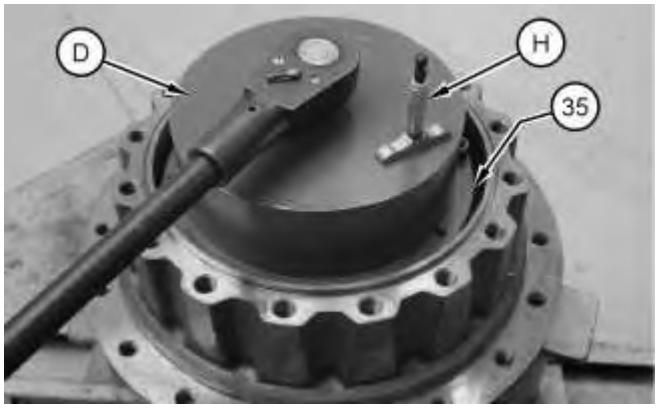

Illustration 11 g01148004

23. Secure the spanner socket from Tooling (D) to stopper plate (35).

24. to determine the final bearing preload, add Dimension (W) to Dimension (Z) and record this figure as Dimension (V).

25. Use Tooling (H) to measure the distance in three locations.

26. Tighten stopper plate (35) until the average of the measurements is equal to Dimension (V).

27. Remove Tooling (D).

Illustration 12 g01372092

28. Install Tooling (Q) and a suitable vacuum onto stopper plate (35).

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