CATERPILLAR®

Service Repair Manual

Models

336D and 336D L Excavator

Assembly Procedure

Table 1

Required Tools			
Tool	**Part Number**	**Part Description**	**Qty**
A	439-3940	Link Bracket	3
B	439-3939	Link Bracket	2
D	8T-9206	Duo-Cone Seal Installer As	1
	169-0503	Installation Kit	1
E	1U-9895	Crossblock	1
F	-	Loctite Copper Anti Seize	-
G	-	Loctite 243	-
H	-	Loctite RTV Silicone Clear	-
J	FT-2770	Leak Down Test Tool	1
K	6V-2012	Depth Micrometer	1
L	6V-7059	Micrometer	1

1. Make sure that all parts of the final drive are thoroughly clean and free of dirt and debris prior to assembly. Check the condition of all O-ring seals that are used in the final drive. If any of the seals are damaged, use new parts for replacement.

Illustration 1 g03873123

2. Use Tooling (D) to install Duo-Cone seal (45) .

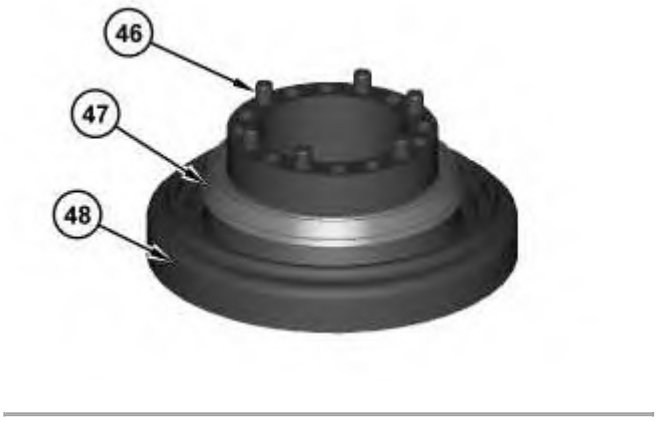

Illustration 2 g03873131

3. Apply Tooling (F) to the surface of dowels (46) . Install dowels (46) .
4. Raise the temperature of lower bearing cone (47) . Install lower bearing cone (47) on motor housing (48) .

Illustration 3 g03873115

5. Lower the temperature of bearing cups (43) . Install bearing cups (43) in sprocket housing (41) .

Illustration 4 g03873145

6. Use Tooling (D) to install Duo-Cone seal (44) .

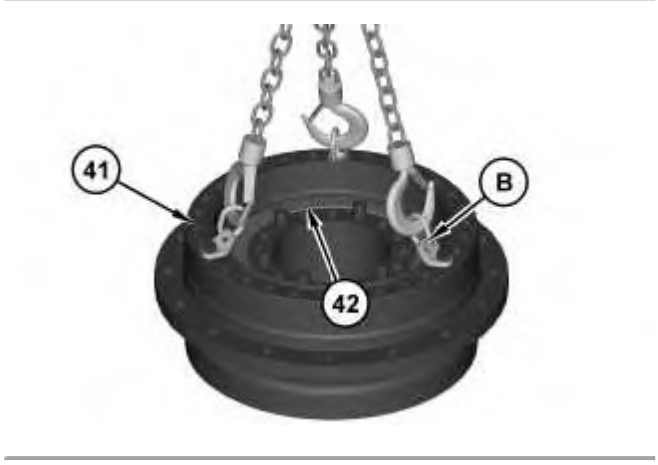

Illustration 5 g03873151

7. Attach Tooling (B) and a suitable lifting device to sprocket housing (41) . The weight of sprocket housing (41) is approximately 110 kg (243 lb). Install sprocket housing (41) .

8. Raise the temperature of upper bearing cone (42) . Install upper bearing cone (42) .

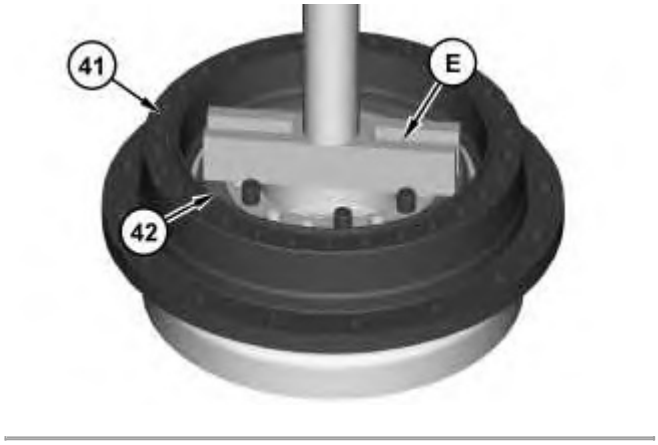

Illustration 6 g03873237

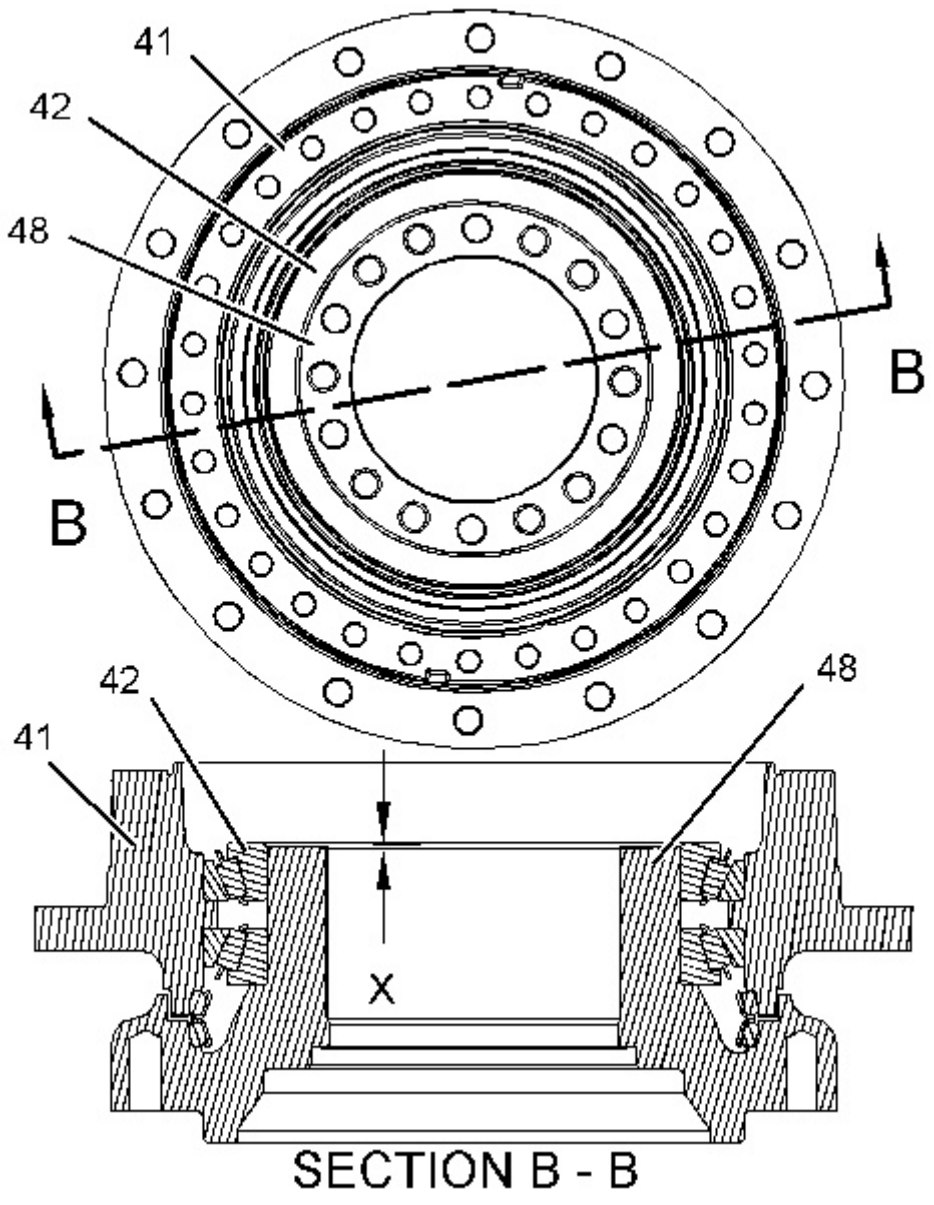

Illustration 7 g03873187

9. Use Tooling (E) and a suitable press in order to apply force to upper bearing cone (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.

10. Reduce the force on top of Tooling (E) to 3000 ± 300 kg (6614 ± 661 lb). Use Tooling (K) in order to measure Dimension (X) . Record Dimension (X) .

Illustration 8 g03873199

11. Remove Tooling (E) .

12. Use Tooling (K) in order to measure Dimension (W) on coupling gear (39) . Record Dimension (W) .

Illustration 9 g03873204

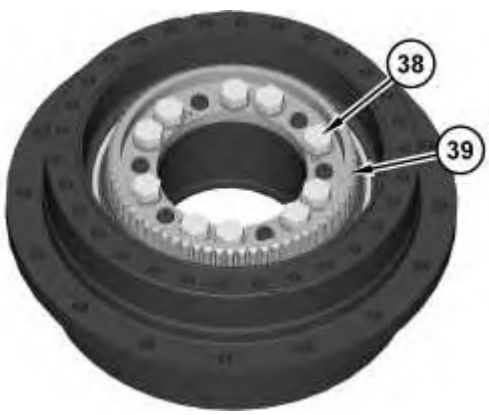

Illustration 10 g03873207

13. Subtract Dimension (X) from Dimension (W) and record the difference as Dimension (V) . The correct shim thickness is Dimension (V) . Use Tooling (L) in order to measure the correct thickness of shims (40) . The tolerance of Dimension (V) is 0 ± 0.05 mm (0.0 ± 0.002 inch).

    Note: Use a maximum of two shims (40) . If two shims (40) are used to achieve the proper dimension, install the thinner of the two shims toward coupling gear (39) .

14. Install shims (40) .

15. Apply Tooling (G) to the threads of bolts (38) . Install coupling gear (39) and bolts (38) . Tighten bolts (38) to a torque of 900 ± 100 N·m (665 ± 75 lb ft).

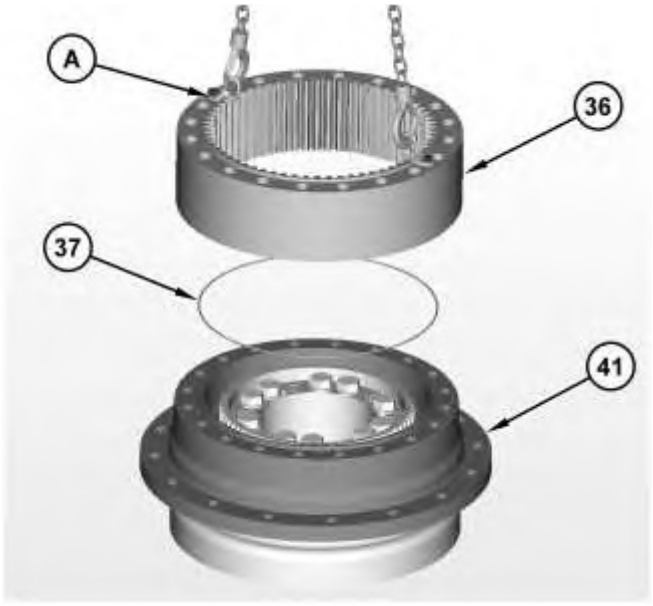

Illustration 11 g03873246

16. Install O-ring seal (37) in sprocket housing (41) .

17. Thoroughly clean the mating surface of sprocket housing (41) that makes contact with ring gear (36) .

18. Attach Tooling (A) and a suitable lifting device to ring gear (36) . Put ring gear (36) in position on sprocket housing (41) . The weight of ring gear (36) is approximately 65 kg (143 lb). Make sure that the alignment marks on sprocket housing (38) and ring gear (36) are lined up with each other.

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