CATERPILLAR®

Service Repair Manual

Models

349E L Excavator

Disassembly and Assembly

349E Excavator Machine Systems

Media Number -KENR9848-04	**Publication Date -01/10/2012**	**Date Updated -23/10/2012**

i07287647

Final Drive - Assemble

SMCS - 4050-016

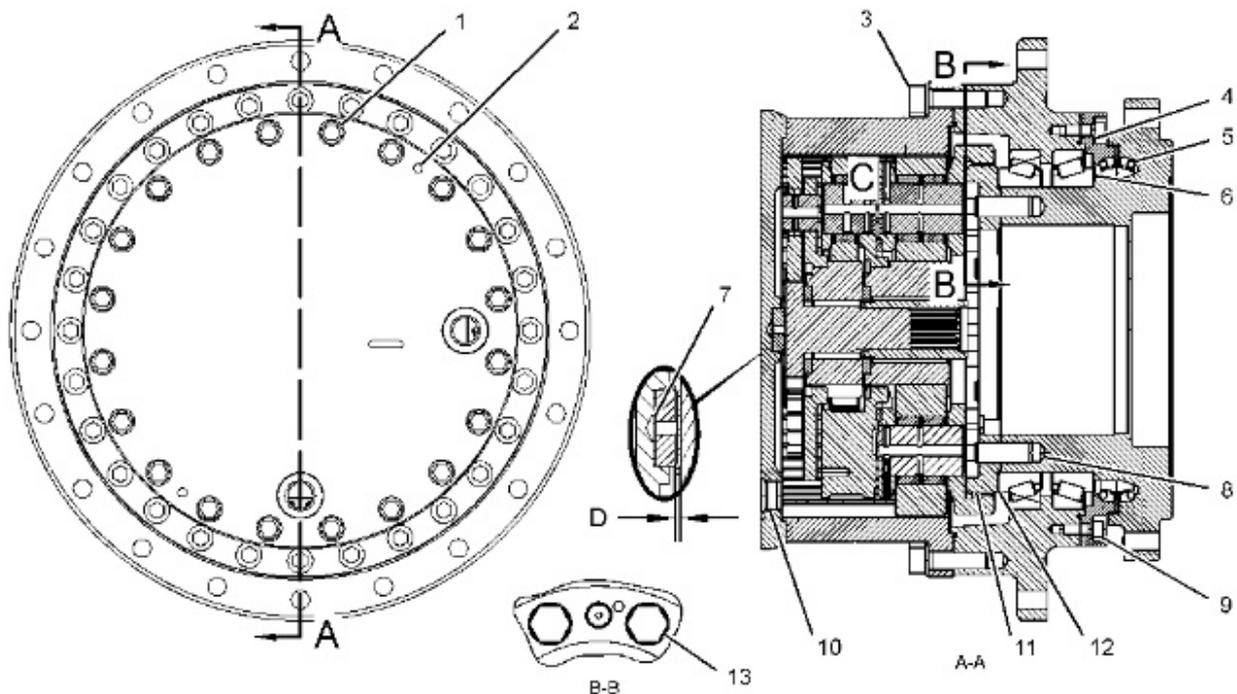# Specifications

Illustration 1   g03844910

Table 1

Specification for 480-7429 Final Drive Gp			
Item	**Qty**	**Part**	**Specification Description**
1	20		

		143-0811 Bolt	Before assembly, the contact surfaces of the bolts, the washers, and the tightened parts must be clean and free from protective coating and oil. Torque to 120 ± 20 N·m (89 ± 15 lb ft).
2	2	**096-3216** Socket Setscrew	Before assembly, apply blue Loctite 243 to the threads. Torque to 105 ± 20 N·m (77 ± 15 lb ft).
3	28	**7Y-5217** Bolt	Torque to 530 ± 70 N·m (391 ± 52 lb ft).
4	2	**2R-0525** Bearing Cup	Apply Loctite C5A Copper Anti-Seize to the inside diameter and outside diameter of the mating parts.
5	1	**255-2272** Duo-Cone Seal Gp	Rubber toric seals and all surfaces in contact with the seals must be clean and dry at assembly. Apply a thin layer of **6V-4876** Lubricant on the surfaces of the metal seals that are in contact just before installation. The metal seal must be assembled square with the bore. The rubber toric seals must not bulge. The rubber toric seals must not be twisted.
6	2	**346-5556** Bearing Cone	Apply Loctite C5A Copper Anti-Seize to the inside diameter and outside diameter of the mating parts.
7	1	**7Y-0808** Shim	As required, use the following shim to adjust the clearance (D) from 1.0 to 2.6 mm (0.04 to 0.10 inch). Thickness is 1.6 (0.06 inch).
8	6	**114-1541** Dowel Pin	Before assembly, apply Loctite C5A Copper Anti-Seize to the inside diameter and outside diameter of the mating parts.
9	20	**6V-8200** Bolt	Torque to 105 ± 20 N·m (77 ± 15 lb ft).
10	2	**3E-2338** Pipe Plug	Torque to 80 ± 10 N·m (59 ± 7 lb ft).
12			As required, use the following shims. If two shims are required, install the thinner shim next to coupling gear (11).
	1	**7Y-1472** Shim	Thickness is 0.15 ± 0.03 mm (0.006 ± 0.001 inch).
	1	**7Y-1473** Shim	Thickness is 0.30 ± 0.04 mm (0.012 ± 0.002 inch).
	1	**7Y-1474** Shim	Thickness is 0.40 ± 0.05 mm (0.016 ± 0.002 inch).
	1	**7Y-1475** Shim	Thickness is 0.50 ± 0.05 mm (0.020 ± 0.002 inch).
	1	**7Y-1476** Shim	Thickness is 0.60 ± 0.06 mm (0.024 ± 0.002 inch).
	1		Thickness is 0.70 ± 0.06 mm (0.028 ± 0.002 inch).

		7Y-1477 Shim	
	1	**7Y-1478** Shim	Thickness is 0.80 ± 0.07 mm (0.031 ± 0.003 inch).
	1	**7Y-1479** Shim	Thickness is 1.00 ± 0.08 mm (0.039 ± 0.003 inch).
	1	**7Y-1480** Shim	Thickness is 1.60 ± 0.10 mm (0.063 ± 0.004 inch).
13	12	**6V-8133** Bolt	Before assembly, the contact surfaces of the bolts, the washers, and the tightened parts must be clean and free from protective coating and oil. Apply blue Loctite 243 to the threads. Torque to 900 ± 100 N·m (664 ± 74 lb ft).

Assembly Procedure

Table 2

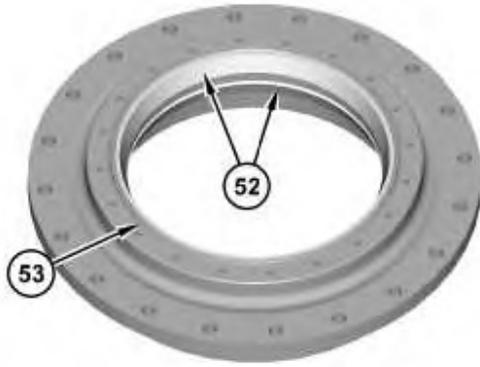| Required Tools			
Tool	**Part Number**	**Part Description**	**Qty**
A	1P-2420	Transmission Repair Stand	1
B	138-7575	Link Brackets	2
C	4C-8359	Eyebolt	3
D	138-7574	Link Brackets	2
E	8T-9206	Duo-Cone Seal Installer As	1
F	5P-3931	Anti-Seize Compound	-
G	-	Loctite 242	-
H	-	Loctite High Flex GM	-
J	6V-2012	Depth Micrometer	1
K	-	Bar Stock 2 inch x 2 inch by 17 inch	1
L	6V-7059	Micrometer	1

Illustration 2   g02431679

1. Apply Tooling (F) to the outside surface of bearing cups (52). Install bearing cups (52). Make sure that bearing cups (52) are properly seated.
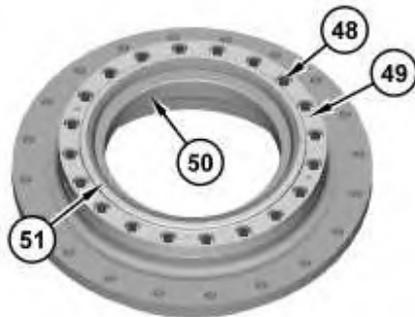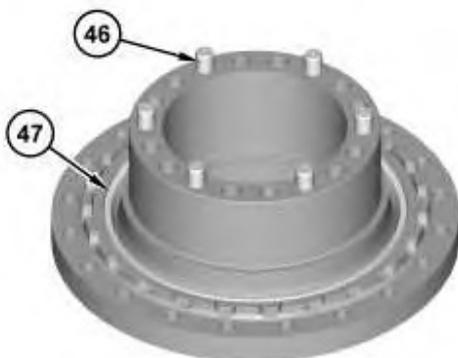
2. Install O-ring seal (53).

Illustration 3   g02431696

3. Apply Tooling (F) to the inside surface of bearing cone (50). Install bearing cone (50).

   Note: Make sure the contact surfaces of bolts (48) and plate (49) are free of oil and debris.

4. Install plate (49) and bolts (48).

5. Use Tooling (E) to install Duo-Cone seal (51). Install Duo-Cone seal (51).

Thank you so much for reading.

Please click the "Buy Now!" button below to download the complete manual.

After you pay.

You can download the most perfect and complete manual in the world immediately.

Our support email:

ebooklibonline@outlook.com