



Service Repair Manual

Models

349E L-VG Excavator

Product: EXCAVATOR

Model: 349E L VG EXCAVATOR KCN

Configuration: 349E L-VG Excavators KCN00001-UP (MACHINE) POWERED BY C13 Engine

Disassembly and Assembly 349E Excavator Machine Systems

Media Number -KENR9848-04

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i07287647

Final Drive - Assemble

SMCS - 4050-016

Specifications

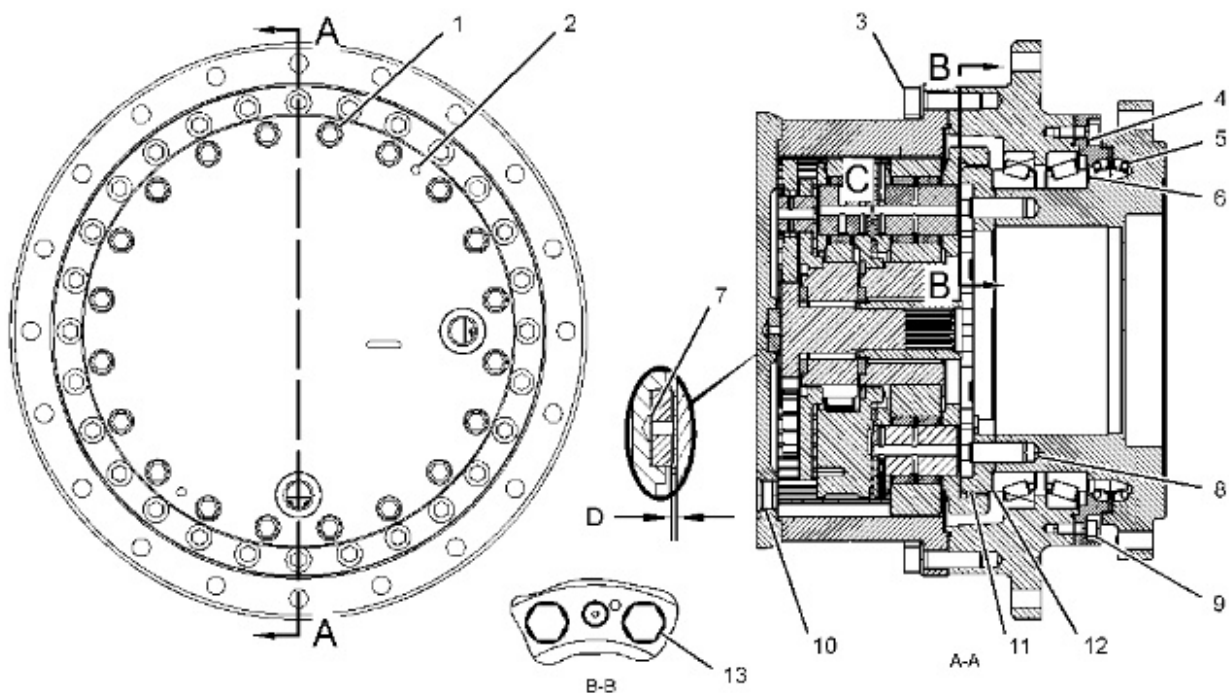


Illustration 1

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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 $120 \pm 20 \text{ N}\cdot\text{m}$ ($89 \pm 15 \text{ lb ft}$).
2	2	096-3216 Socket Setscrew	Before assembly, apply blue Loctite 243 to the threads. Torque to $105 \pm 20 \text{ N}\cdot\text{m}$ ($77 \pm 15 \text{ lb ft}$).
3	28	7Y-5217 Bolt	Torque to $530 \pm 70 \text{ N}\cdot\text{m}$ ($391 \pm 52 \text{ lb ft}$).
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 $105 \pm 20 \text{ N}\cdot\text{m}$ ($77 \pm 15 \text{ lb ft}$).
10	2	3E-2338 Pipe Plug	Torque to $80 \pm 10 \text{ N}\cdot\text{m}$ ($59 \pm 7 \text{ lb ft}$).
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 $0.15 \pm 0.03 \text{ mm}$ ($0.006 \pm 0.001 \text{ inch}$).
	1	7Y-1473 Shim	Thickness is $0.30 \pm 0.04 \text{ mm}$ ($0.012 \pm 0.002 \text{ inch}$).
	1	7Y-1474 Shim	Thickness is $0.40 \pm 0.05 \text{ mm}$ ($0.016 \pm 0.002 \text{ inch}$).
	1	7Y-1475 Shim	Thickness is $0.50 \pm 0.05 \text{ mm}$ ($0.020 \pm 0.002 \text{ inch}$).
	1	7Y-1476 Shim	Thickness is $0.60 \pm 0.06 \text{ mm}$ ($0.024 \pm 0.002 \text{ inch}$).
	1		Thickness is $0.70 \pm 0.06 \text{ mm}$ ($0.028 \pm 0.002 \text{ inch}$).

		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

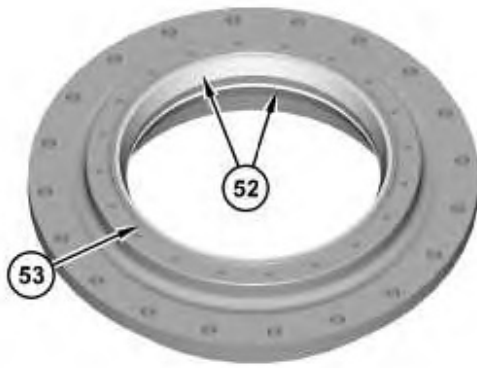


Illustration 2

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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).
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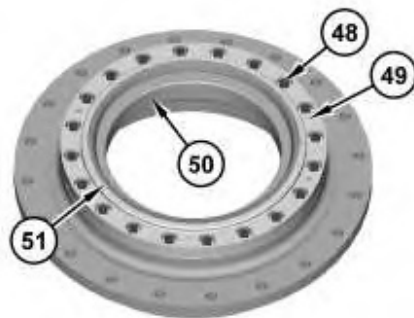
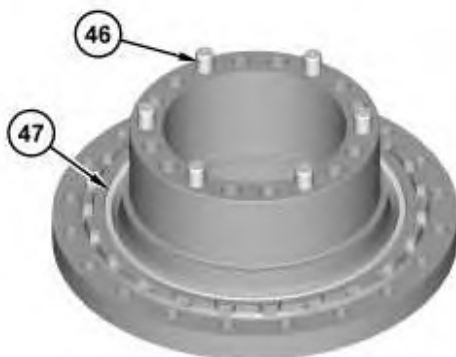


Illustration 3

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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).
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