

Product: EXCAVATOR

Model: 350 L EXCAVATOR 9DK

Configuration: 350 350L TRACK-TYPE EXCAVATORS 9DK00001-00300 (MACHINE) POWERED BY 3306 ENGINE

Disassembly and Assembly 350 AND 350 L EXCAVATOR MACHINE SYSTEMS

Media Number -SEN6148-04

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SEN61480046

Swing Pump & Pump Drive

SMCS - 3108-010; 5473-017; 5473

Remove & Install Swing Pump & Pump Drive

Tools Needed	A
1P-0510 Driver Group	1



WARNING

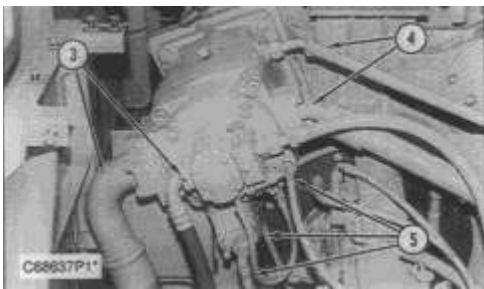
At operating temperature, the hydraulic oil tank is hot and under pressure. Hot oil can cause burns. To prevent possible personal injury, release the pressure in the implement hydraulic circuits (boom, stick and bucket) before any hydraulic lines or components are disconnected or removed.

1. Release the pressure in the hydraulic system as follows:
 - a. Fully retract the rod in the stick cylinder.
 - b. Adjust the position of the bucket so it will be flat on the ground when the boom is lowered.
 - c. Lower the boom until the bucket is flat on the ground.
 - d. Shut off the engine, and put the hydraulic activation control lever in the "Lock" position.
 - e. Move the control levers for the boom, bucket, stick and swing through their full travel strokes. This will relieve any pressure that may be present in the pilot system.

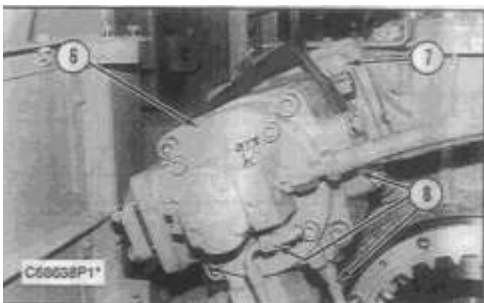
- f. Slowly loosen the air breather cap on the hydraulic oil tank to release the pressure.
 - g. Tighten the air breather cap on the hydraulic oil tank.
 - h. The pressure in the hydraulic system has now been released. Lines and components can now be removed.
2. Drain the oil from the hydraulic oil tank into a suitable container for storage or disposal. The capacity of the hydraulic oil tank is **240 liters (63.3 U.S. gal)**.



3. Open the hood assembly of the machine, and lock it in position.
4. Open two right rear access doors (2). Remove cover assembly (1).

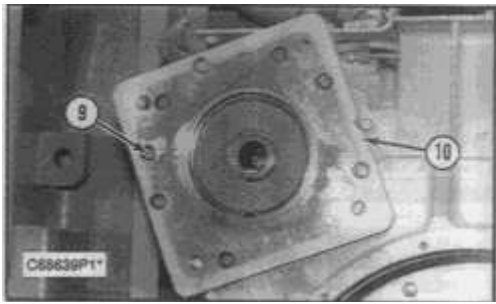


5. Put identification marks on all hose assemblies that are connected to the pilot pump and the swing pump.
6. Disconnect hose assemblies (3), (4) and (5) from the pilot pump and the swing pump. Put plugs in the hose assemblies to prevent oil loss and to keep dirt and debris out of the hydraulic system.



7. Disconnect hose assemblies (8) from the pilot pump. Put plugs in the hose assemblies to prevent oil loss and to keep dirt and debris out of the hydraulic system.
8. Fasten a lifting sling and a hoist to swing pump (6) as shown. Remove four bolts (7) that hold the swing pump to the rear of the engine. Carefully remove the swing pump from the pump drive. The combined weight of the pilot pump and swing pump is **136 kg (300 lb)**.

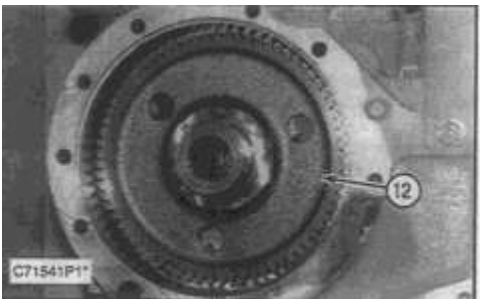
9. Remove the O-ring seal from the pump housing.



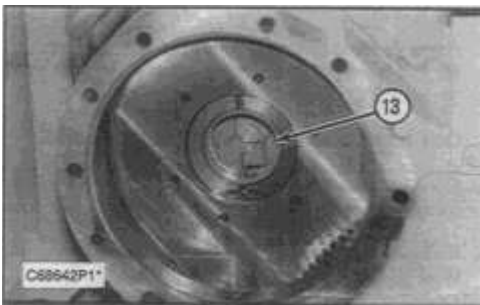
10. Remove eight bolts (9) and plate (10) from the flywheel housing.



11. Remove bushing (11) from the plate.



12. Remove gear (12) from the flywheel housing.



13. Remove bushing (13) from the flywheel housing.

NOTE: The following steps are for the installation of the swing pump and pump drive.

NOTICE

The swing pump must be filled with hydraulic oil before operation or damage to the unit will result. Add hydraulic oil through the drain port of the swing pump.

- 14.** Check the condition of the O-ring seal used between the swing pump and the pump drive. Also check the condition of the O-ring seals used in the ends of the hose assemblies that connect to the swing and pilot pumps. If any of the seals are damaged, use new parts for replacement.
- 15.** Lower the temperature of bushing (13), and install it in the flywheel housing with Tool (A). Install the bushing until it is even with the inside surface of the flywheel housing. Lubricate the bushing with clean hydraulic oil.
- 16.** Put gear (12) in position in the flywheel housing.
- 17.** Lower the temperature of bushing (11), and install it in plate (10) with Tool (A). Install the bushing until it makes contact with the counterbore in the plate. Lubricate the bushing with clean hydraulic oil.
- 18.** Put plate (10) in its original position on the flywheel housing. Install eight bolts (9) that hold it.
- 19.** Install the O-ring seal on the swing pump housing. Lubricate the O-ring seal with clean hydraulic oil.
- 20.** Fasten a lifting sling and a hoist to swing pump (6). Put the swing pump in position in the flywheel housing. Install four bolts (7) that hold it.
- 21.** Connect hose assemblies (8) to the pilot pump.
- 22.** Connect hose assemblies (3), (4) and (5) to the swing and pilot pumps.
- 23.** Fill the hydraulic oil tank with oil to the correct level. Refer to the 350 & 350 L Excavators Operation & Maintenance Manual for the correct filling procedure.
- 24.** Start the machine, and check the operation of the swing function and the implements. Also, check for oil leaks.
- 25.** Reinstall cover assembly (1). Close access doors (2) and the hood assembly.

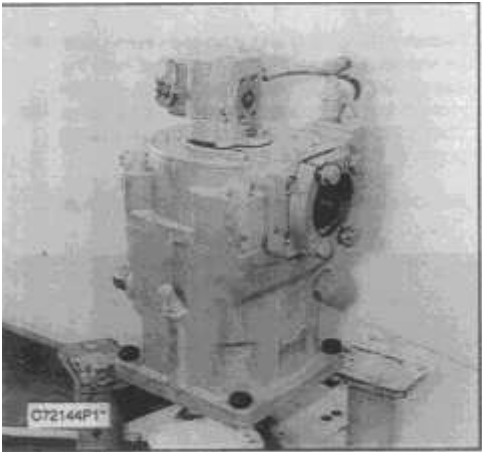
Disassemble & Assemble Swing Pump

Tools Needed		A	B	C
1P-2420	Transmission Repair Stand	1		
5P-9736	Link Bracket		2	
1P-0510	Driver Group			1

Start By:

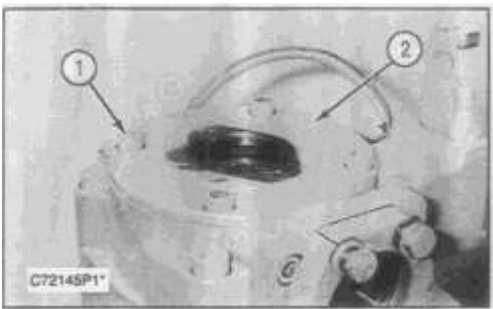
a. remove swing pump

1. Make sure the swing pump is thoroughly clean prior to disassembly.

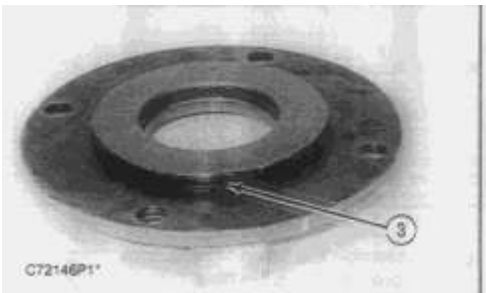


2. Fasten the swing pump to Tool (A) as shown. The combined weight of the swing pump and pilot pump is **136 kg (300 lb)**.

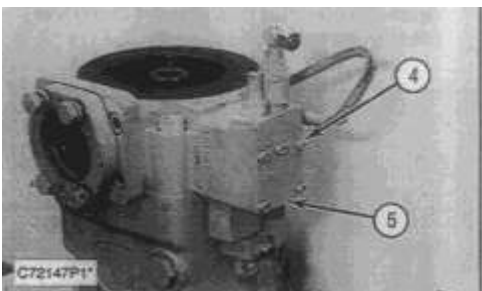
3. Remove the pilot pump from the swing pump. Refer to the topic "Remove & Install Pilot Pump" in this module.



4. Remove four socket head bolts (1) and cover (2) from the head group.

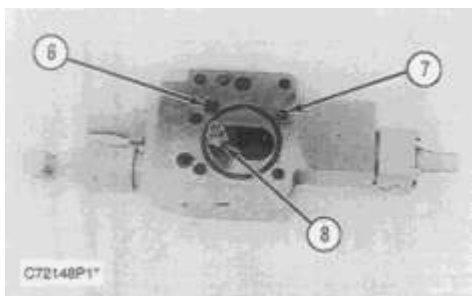


5. Remove O-ring seal (3) from the cover.

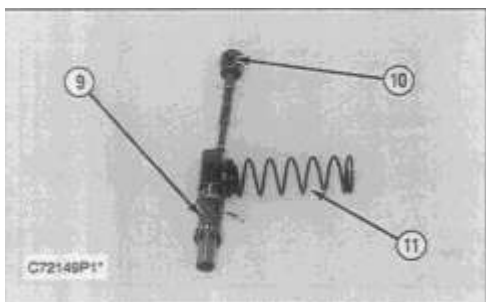


6. Remove five socket head bolts (4) and pressure and flow compensator valve group (5) from the head group.

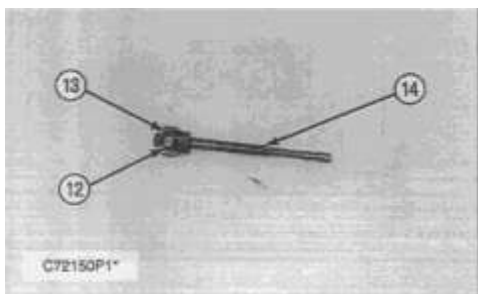
7. Disassemble pressure and flow compensator valve group (5) as follows:



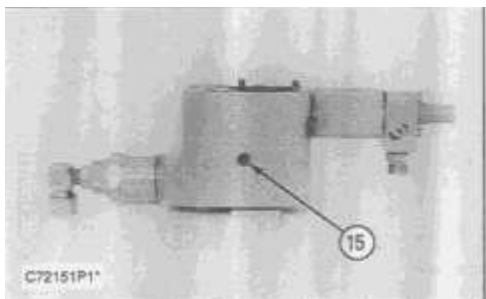
a. Remove four O-ring seals (6), two pins (7) and actuator group (8).



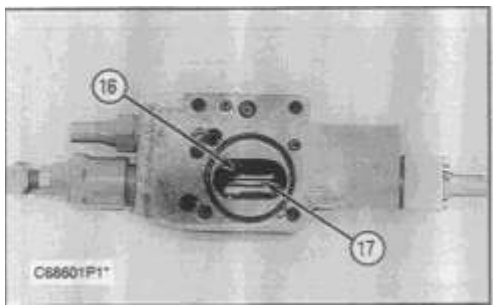
b. Disassemble the actuator group. Remove valve (9), roller assembly (10) and spring (11).



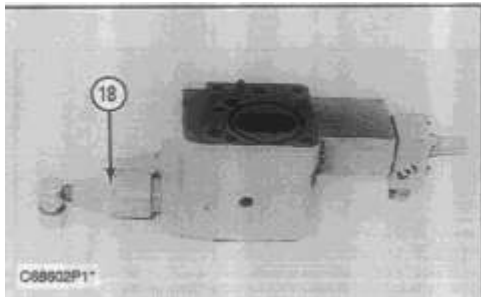
c. Remove two clips (12). Disconnect roller (13) from valve (14).



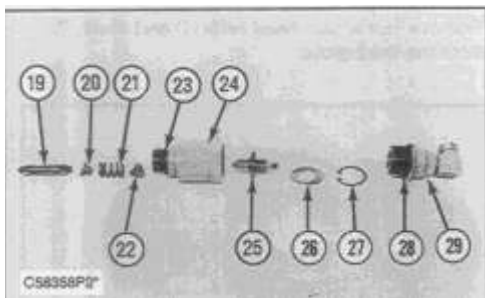
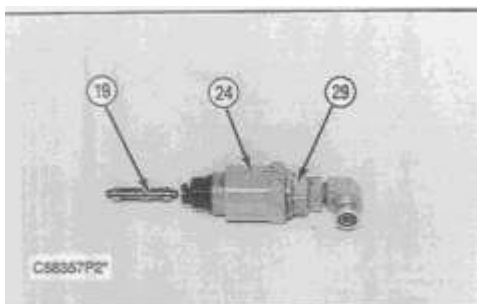
d. Remove clip (15).



e. Remove pin (16) and track assembly (17).



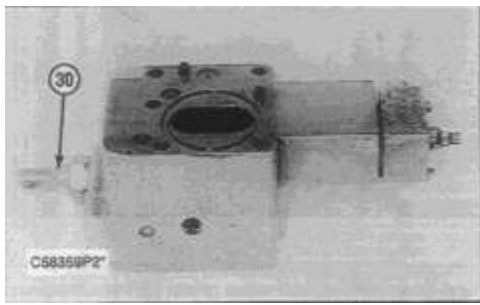
f. Remove flow compensator valve group (18).



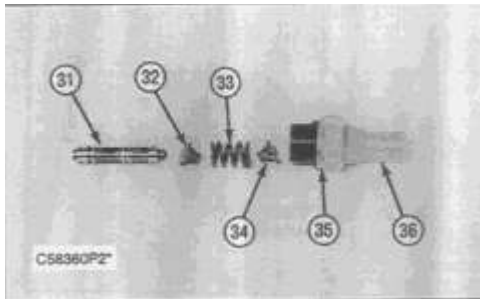
g. Disassemble the flow compensator valve group. Remove spool (19). Remove connector (29) from plug (24).

h. Remove retainer (20), spring (21) and retainer (22) from plug (24). Remove O-ring seal (23) from plug (24).

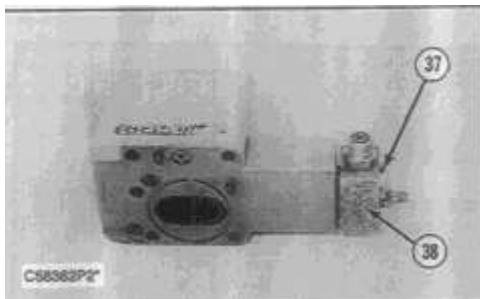
i. Remove retaining ring (27), shims (26) and piston (25) from plug (24). Remove O-ring seal (28) from connector (29).



j. Remove flow compensator valve group (30) from the valve group housing.

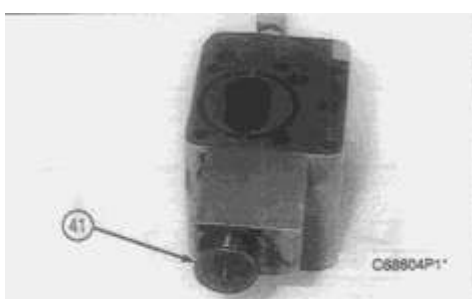
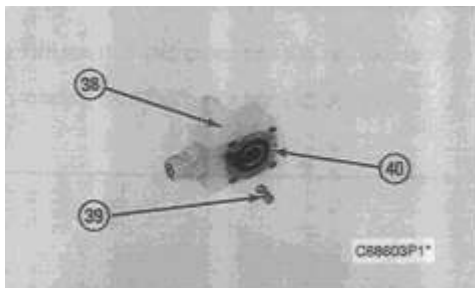


k. Disassemble flow compensator valve group (30). Remove spool (31), retainer (32), spring (33), retainer (34) and O-ring seal (35) from plug (36).



l. Remove four bolts (37) and connector (38) from the valve group housing.

m. Remove spring (39) and O-ring seal (40) from connector (38).



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