

Product: EXCAVATOR

Model: 350 L EXCAVATOR 9DK

Configuration: 350, 350L TRACK-TYPE EXCAVATORS 9DK00301-UP (MACHINE) POWERED BY 3306 ENGINE

Disassembly and Assembly 350 AND 350 L EXCAVATOR MACHINE SYSTEMS

Media Number -SEN6148-04

Publication Date -01/11/2004

Date Updated -12/03/2010

SEN61480032

Final Drives

SMCS - 4050-017

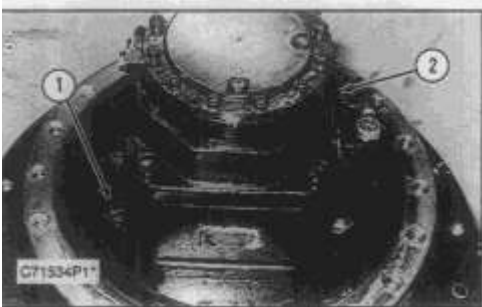
Disassemble & Assemble Final Drives

Tools Needed		A	B	C	D	E	F
1P-2420	Transmission Repair Stand	1					
6V-2156	Link Bracket		2		3		
1P-1860	Pliers			1			
6V-2157	Link Bracket					2	
8T-0531	Seal Installer						1

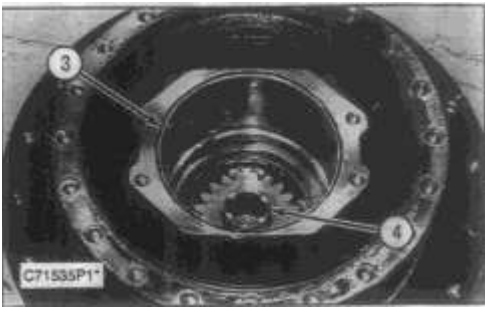
Start By:

a. remove final drives and travel motors

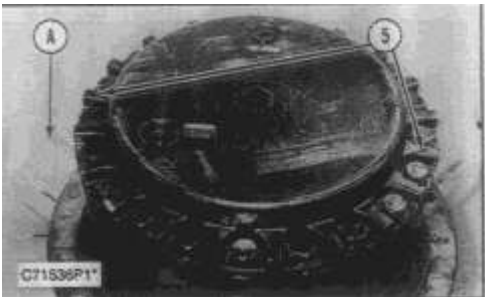
1. Thoroughly clean the outside of the final drive and travel motor prior to disassembly.



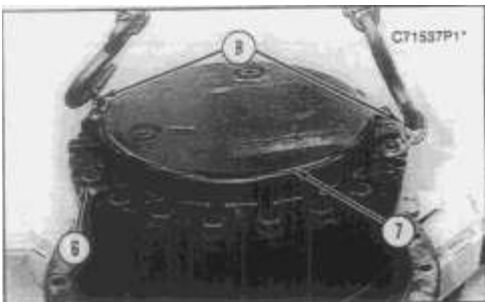
2. Remove four bolts (1) and the washers that hold travel motor (2) to the final drive. Fasten a hoist to the travel motor, and carefully remove it from the final drive. The weight of the travel motor is **125 kg (275 lb)**.



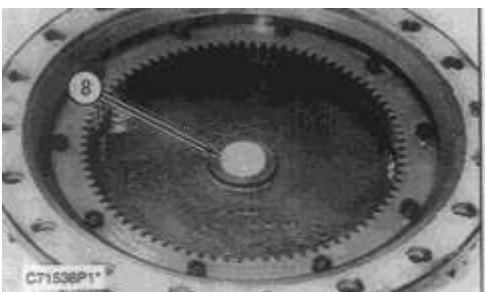
3. Remove O-ring seal (3) and coupler (4) from the final drive.
4. Fasten a hoist to the final drive, and turn it over **180 degrees**. The weight of the final drive is **469 kg (1035 lb)**.



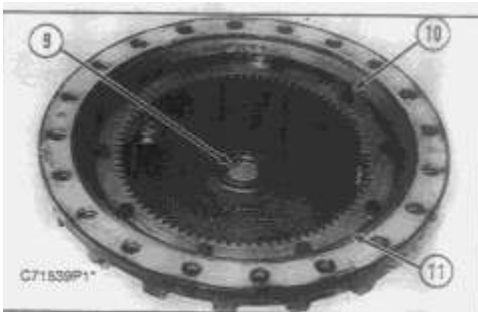
5. Fasten the final drive to Tool (A) as shown. Put an alignment mark across the sections of the final drive for assembly purposes. The parts must be reinstalled in their original locations.
6. Remove two setscrews (5) from the cover assembly of the final drive.



7. Fasten Tool (B) and a hoist to cover assembly (7) as shown.
8. Remove 20 bolts (6) and the washers that hold the cover assembly in place.
9. Using a soft faced hammer, break the seal between cover assembly (7) and the ring gear. Remove the cover assembly. The weight of the cover assembly is **52 kg (115 lb)**.

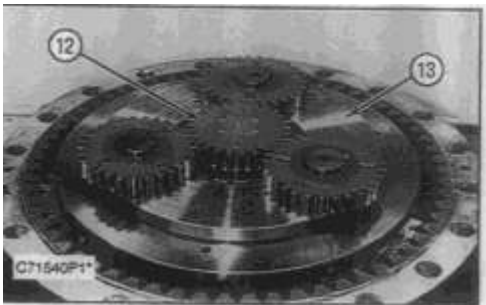


10. Remove spacer (8) from the cover.



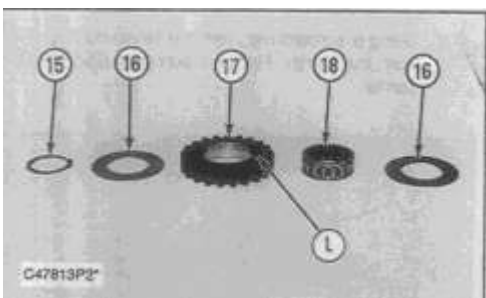
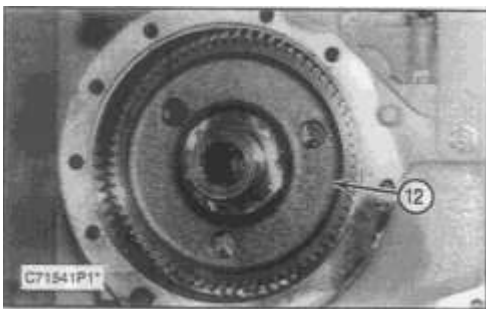
11. Remove shim(s) (9) from the cover.

12. Remove 10 socket head bolts (10) and ring gear (11) from the cover.



13. Remove sun gear (12). Remove carrier assembly (13) by lifting it straight up.

14. Disassemble carrier assembly (13) as follows:

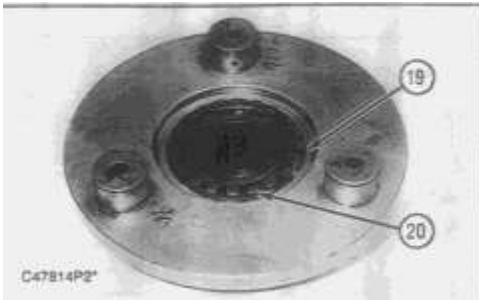


a. Remove two spacers (14). A spacer is located on each side of the sun gear in carrier assembly (13).

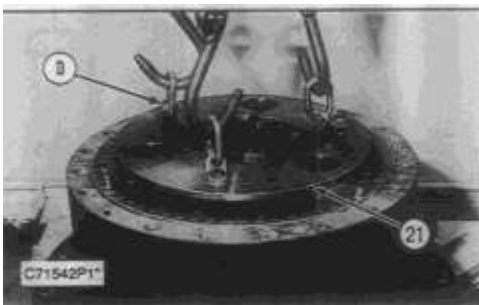
NOTE: Planetary gears (17) have identification grooves (L) on them. Note the position of the identification grooves in relation to the carrier for assembly purposes.

b. Remove retaining ring (15) with Tool (C). Remove two thrust washers (16) and planetary gear (17) from the carrier. Remove bearing (18) from the planetary gear.

c. Remove the other two planetary gears from the carrier as in Step 14b.

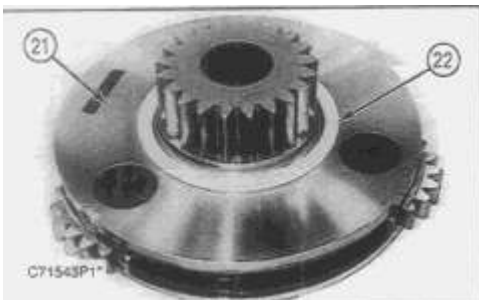


d. Using a screwdriver, remove retaining ring (19) from the carrier. Remove sun gear (20) from the carrier.



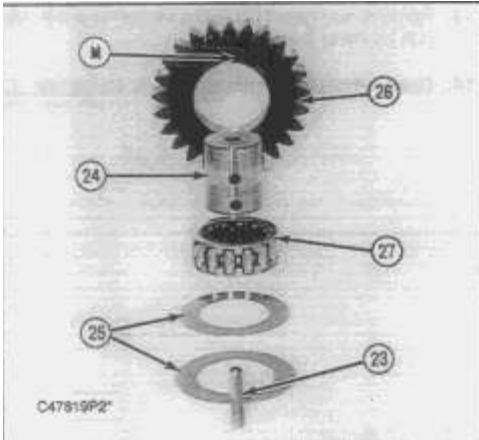
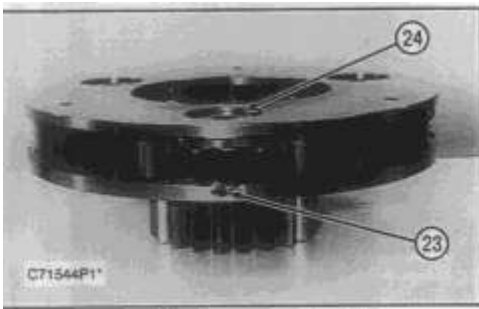
15. Fasten Tool (D) and a hoist to carrier assembly (21) as shown. Remove carrier assembly (21) by pulling it straight up. The weight of the carrier assembly is **59 kg (130 lb)**.

16. Disassemble carrier assembly (21) as follows:



NOTE: Spacer (22) may remain with carrier assembly (21), or it may remain with carrier assembly (30). See Step 17.

a. Remove spacer (22) from carrier assembly (21).

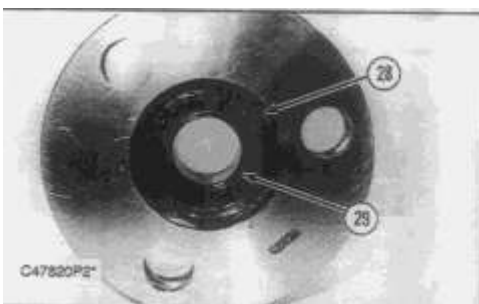


b. Drive spring pin (23) into planetary shaft (24) with a hammer and a punch.

NOTE: Planetary gears (26) have identification grooves (M) on them. Note the position of the identification grooves in relation to the carrier for assembly purposes.

c. Remove planetary shaft (24), two thrust washers (25) and planetary gear (26) from the carrier. Remove bearing (27) from the planetary gear. Remove spring pin (23) from planetary shaft (24) with a hammer and a punch.

d. Remove the other two planetary gears from the carrier as in Steps 16b and 16c.



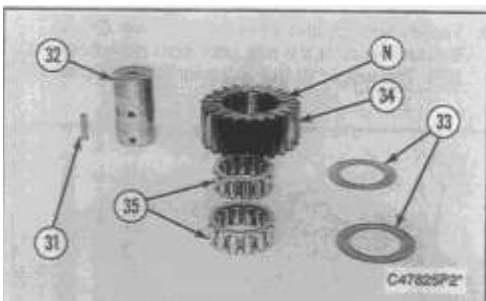
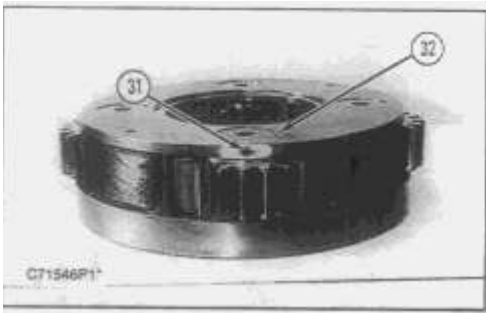
e. Using a screwdriver, remove retaining ring (28). Remove sun gear (29) from the carrier.



17. If spacer (22) was not removed in Step 16a remove it from carrier assembly (30) at this time.

18. Fasten Tool (B) and a hoist to carrier assembly (30) as shown. Remove the carrier assembly. The weight of the carrier assembly is **79 kg (175 lb)**.

19. Disassemble carrier assembly (30) as follows:

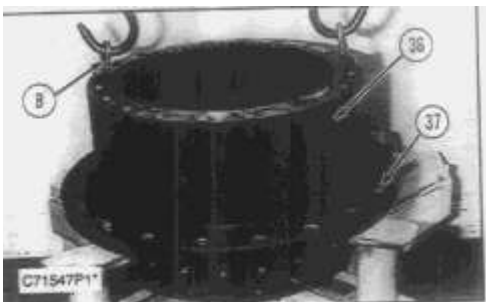


a. Drive spring pin (31) into planetary shaft (32) with a hammer and a punch.

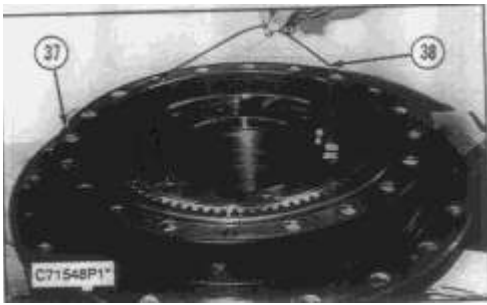
NOTE: Planetary gears (34) have identification grooves (N) on them. Note the position of the identification grooves in relation to the carrier for assembly purposes.

b. Remove planetary shaft (32), two thrust washers (33) and planetary gear (34) from the carrier. Remove two bearings (35) from the planetary gear. Drive spring pin (31) out of planetary shaft (32) with a hammer and a punch.

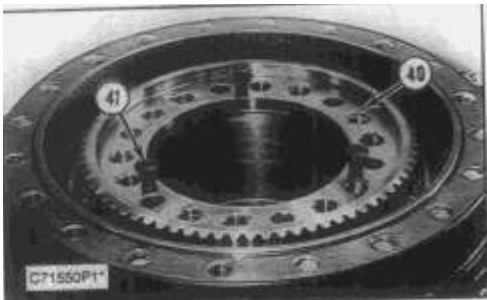
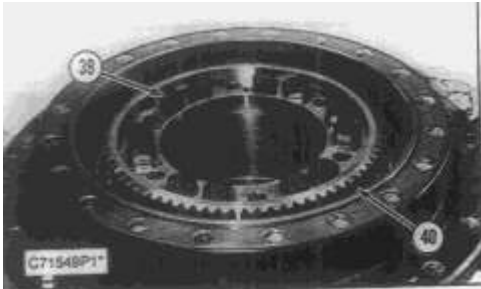
c. Remove the other three planetary gears from the carrier as in Steps 19a and 19b.



20. Fasten Tool (B) and a hoist to ring gear (36) as shown. Remove the ring gear from main housing (37). The weight of the ring gear is **91 kg (200 lb)**.



21. Remove O-ring seal (38) from main housing (37).



22. Remove 12 bolts (39) from gear (40).

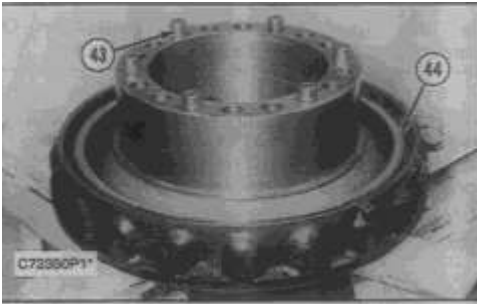
23. Install three suitable size forcing bolts (41) in gear (40) as shown. Tighten the three forcing bolts evenly to loosen gear (40). Remove the gear from the main housing.



24. Remove shims (42) from the main housing.

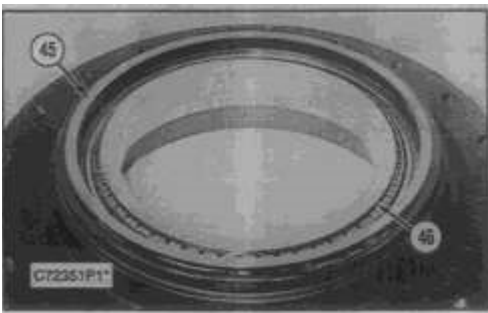


25. Fasten Tool (E) and a hoist to main housing (37) as shown. Separate the main housing from the motor housing. The weight of the main housing is **132 kg (290 lb)**.



26. If necessary, remove six locating pins (43) from the motor housing.

27. Remove Duo-Cone seal (44) from the motor housing.



28. Remove Duo-Cone seal (45) from the main housing.

29. Remove two bearings (46) from the main housing.

NOTE: The following steps are for the assembly of the final drives.

30. Make sure 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 used in the final drive. If any of the seals are damaged, use new parts for replacement. Reassemble the final drive on Tool (A).

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