



Service Repair Manual

Models

365C L Excavator

Product: EXCAVATOR

Model: 365C L EXCAVATOR MCY

Configuration: 365C L Excavator MCY00001-UP (MACHINE) POWERED BY C-15 Engine

Disassembly and Assembly 365C Excavator Machine Systems

Media Number -REN8616-03

Publication Date -01/08/2012

Date Updated -24/08/2012

i07188314

Final Drive - Assemble

SMCS - 4050-016

Assembly Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	1P-2420	Transmission Repair Stand	1
B	439-3941	Link Bracket	3
C	439-3940	Link Bracket	2
D	385-7874	Hydraulic Torque Wrench	1
	385-8479	Hydraulic Pump and Motor Gp	1
	9U-7418	Hex Bit Socket	1
F	6V-3175	Double Acting Cylinder	1
	350-7768	Electric Hydraulic Pump Gp	1
	150-1784	Crossblock	1
	1U-9889	Crossblock	1
	150-1961	Washer	2
	150-1786	Plate	2
	4C-9634	Puller Stud	1
	9U-6832	Nut	1
	2K-7468	Locknut	1

	4K-0684	Locknut	2
	6V-2078	Stud	2
	5P-4807	Cap	2
H	140-7642	Duo-Cone Seal Installer As	1
J	-	Loctite	1
K	9S-3263	Thread Lock Compound	1
L	-	Loctite	1

1. Make sure that all parts of the final drive are thoroughly clean and free of dirt and debris prior to assembly.

Note: Check the condition of all the O-ring seals that are used in the final drive. If any of the seals are worn or damaged, use new parts for replacement.

2. Reassemble the final drive on wood blocks and Tooling (A).



Illustration 1

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3. Apply Tooling (J) to the surfaces that contact the bearing cones. Install the bearing cone with a press. Raise the temperature of bearing cone (51) and install the bearing cone.
4. Apply Tooling (J) to the surfaces that contact pins (50) and install contact pins (50).



5. Apply Tooling (J) to the surfaces that contact the bearing cups. Install bearing cups (48) and (49).



Illustration 3

6. Attach Tooling (C) and a suitable lifting device to main housing (45). Install main housing (45) on motor housing (39). The weight of main housing (45) is approximately 191 kg (420 lb).



Illustration 4

7. Install bearing cone (46) and the bearing cone.
 8. Use the following procedure to determine the bearing preload and the correct number of shims.
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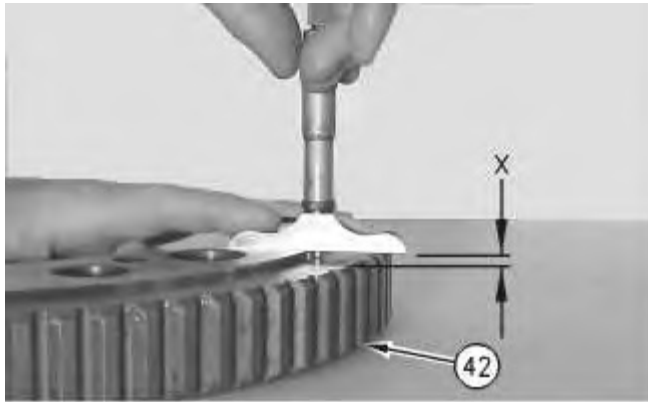


Illustration 5

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- a. Use a depth micrometer to measure the step length of the coupling gear (42). Take measurements at several different locations around the gear. Compute the average of the measured dimensions and record the number. Call this Dimension (X).

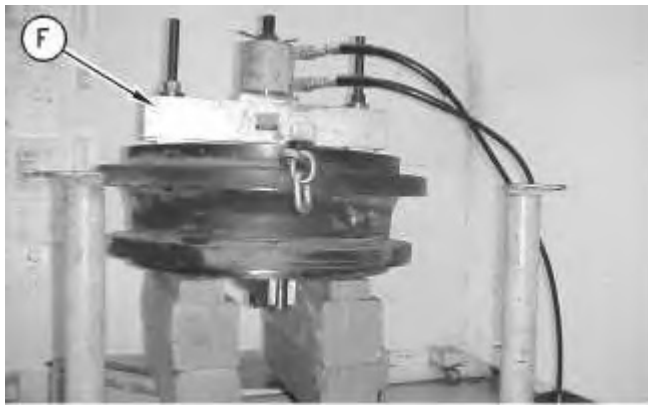


Illustration 6

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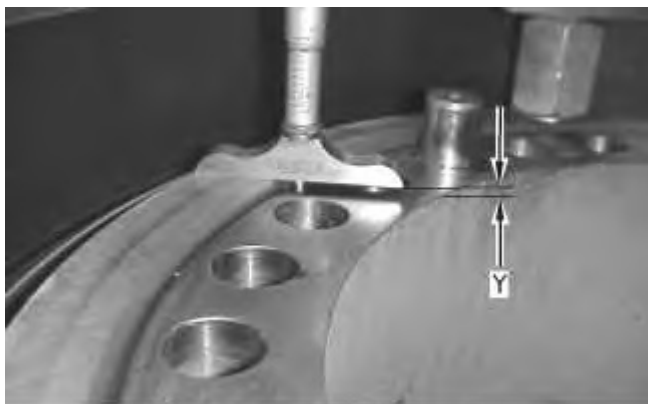


Illustration 7

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- b. Use Tooling (F) to apply a load of 10700 kPa (1550 psi) to seat the bearings. A pressure of 10700 kPa (1550 psi) is the equivalent of 10000 kg (22050 lb) on a suitable press. Rotate the housing to seat the bearing. Reduce the load to 4825 kPa (700 psi).

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