Product: WHEEL LOADER
Model: 980G WHEEL LOADER 2SR
Configuration: 980G WHEEL LOADER 2SR00001-00650 (MACHINE) POWERED BY 3406 ENGINE

Disassembly and Assembly
980G Wheel Loader Power Train
Media Number -SENR5877-07 **Publication Date -01/09/2004** **Date Updated -23/09/2004**

i04400940

Torque Converter - Assemble - Heavy duty

SMCS - 3101-016

Assembly Procedure

Table 1

Required Tools			
Tool	**Part Number**	**Part Description**	**Qty**
A	138-7573	Link Bracket	3
B	8T-5096	Dial Indicator Test Group	1
	5P-2390	Gauge Tool Group	1
C	1P-0520	Driver Group	1

Note: Cleanliness is an important factor. Before assembly, all parts should be thoroughly cleaned in cleaning fluid. Allow the parts to air dry. Wiping cloths or rags should not be used to dry parts. Lint may be deposited on the parts which may cause later trouble. Inspect all parts. If any parts are worn or damaged, use new parts for replacement.

Note: Apply oil to all of the bearings before assembly.

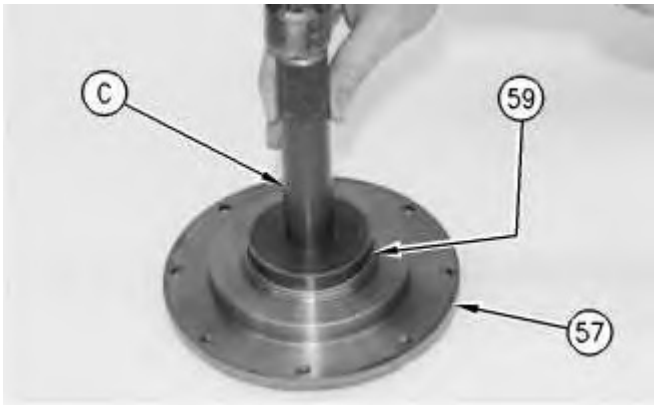

Illustration 1 g00504278

1. Use Tooling (C) to install sleeve bearing (59) in cover assembly (57). Sleeve bearing (59) must be even with the outside surface of cover assembly (57).

Illustration 2 g00504279

2. Install cover assembly (57) to rotating housing (39).

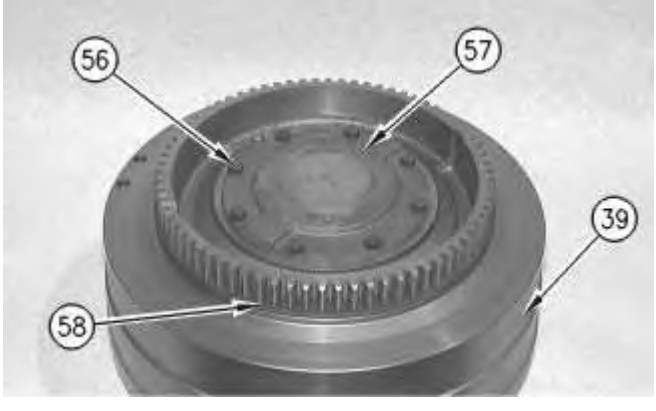

Illustration 3 g00503564

3. Install ring seal (58) to rotating housing (39).

4. Install eight bolts (56) and the washers. Tighten the bolts to a torque of 30 ± 5 N·m (22 ± 4 lb ft).

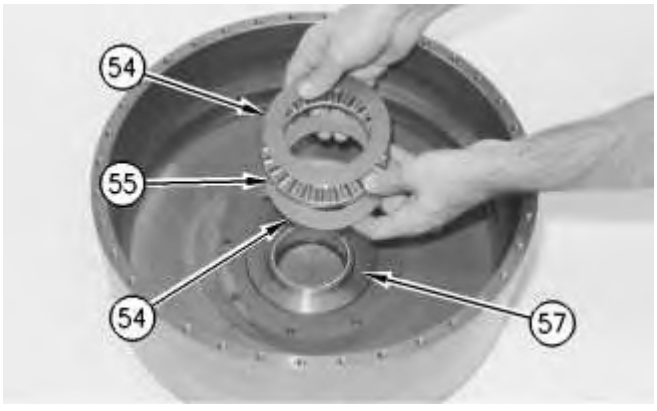

Illustration 4 g00504307

5. Install thrust bearing race (54), thrust bearing (55), and thrust bearing race (54) to cover assembly (57).

Illustration 5 g00504312

6. Install retaining ring (53) in turbine hub (51).

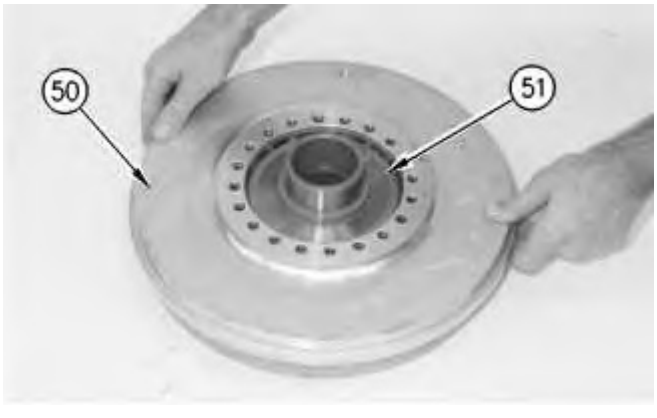

Illustration 6 g00504313

7. Install converter turbine (50) on turbine hub (51).

Illustration 7 g00504315

8. Install twenty bolts (52). Tighten the bolts to a torque of 50 ± 7 N·m (37 ± 5 lb ft).

Illustration 8 g00504382

9. Install turbine hub (51) and converter turbine (50) as a unit to rotating housing (39).

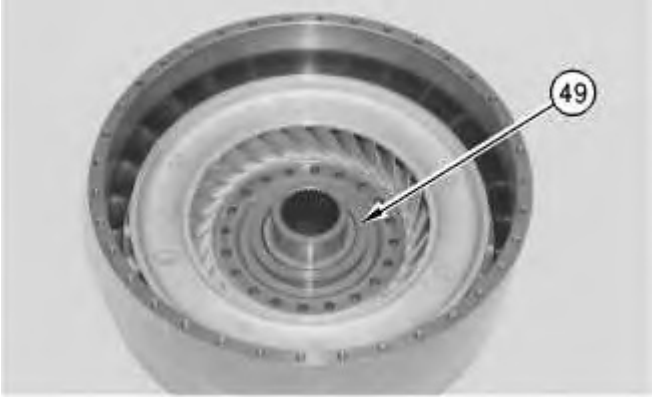

Illustration 9 g00503538

10. Install two thrust bearing races (49) and the bearing to the hub.

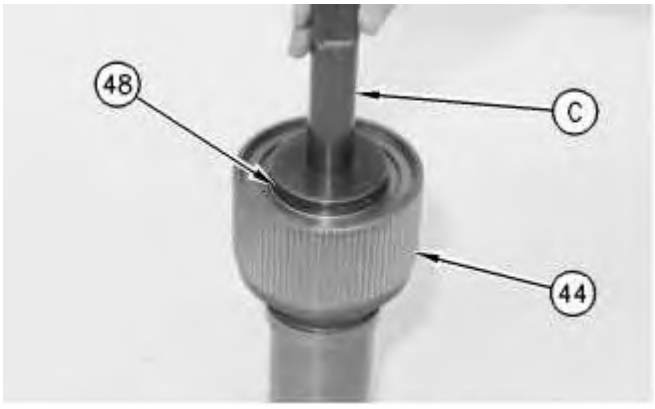

Illustration 10 g00504436

11. Use Tooling (C) to install sleeve bearing (48) to carrier assembly (44). Bearing sleeve (48) must be even with the counterbore of carrier assembly (44).

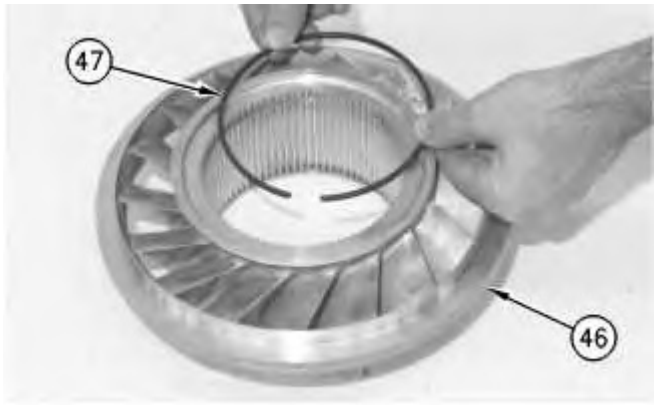

Illustration 11 g00504882

12. Install retainer ring (47) in stator (46).

Illustration 12 g00504931

13. Position carrier assembly (44) on a wood block.

14. Use proper equipment to handle stator (46). Heat stator (46) to a maximum temperature of 121°C (250°F) for one hour.

15. Install stator (46) on carrier assembly (44).

Illustration 13 g00504935

16. Install snap ring (45) in stator (46).

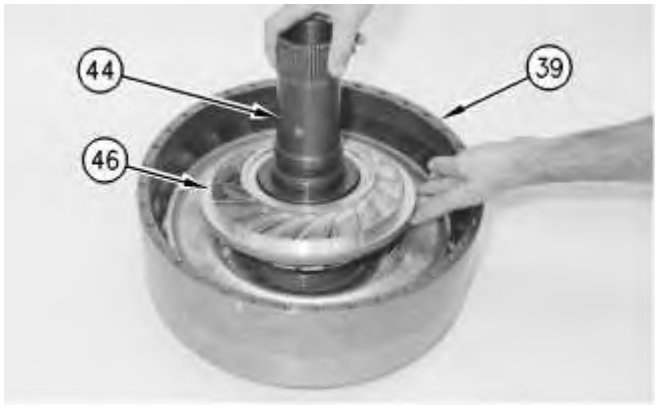

Illustration 14 g00505049

17. Install stator (46) and carrier assembly (44) in rotating housing (39).

Illustration 15 g00503352

18. Install two thrust bearing races (43) and the thrust bearing to the carrier assembly.

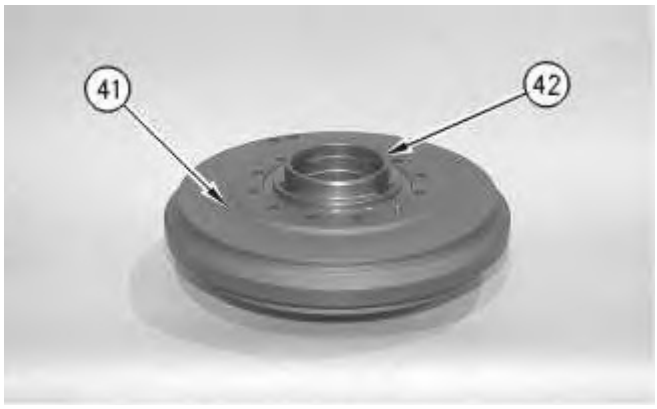

Illustration 16 g00503351

19. Position impeller hub (42) on a wood block.
20. Install converter impeller (41) on impeller hub (42).

Illustration 17 g00503350

21. Install drive flange (38) on converter impeller (41).

Illustration 18 g00503348

22. Install twelve bolts (40). Tighten the bolts to a torque of 80 ± 10 N·m (60 ± 7 lb ft).

Illustration 19 g00503345

23. Install drive flange (38) on rotating housing (39). The weight of drive flange (38) is 23 kg (51 lb).

24. Install 36 bolts (37) and the washers. Tighten the bolts to a torque of 30 ± 5 N·m (22 ± 4 lb ft).

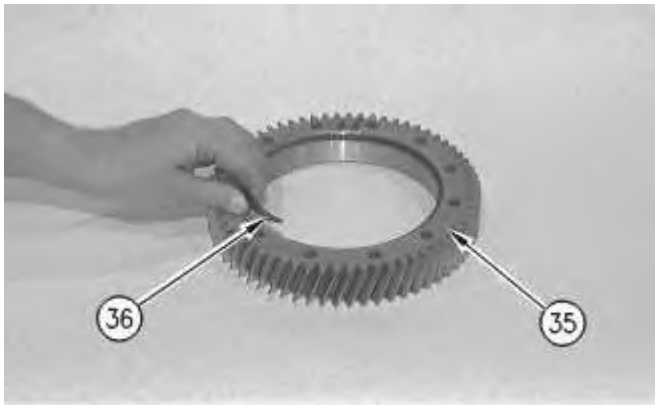

Illustration 20 g00505183

25. Install retaining ring (36) in the groove of drive gear (35).

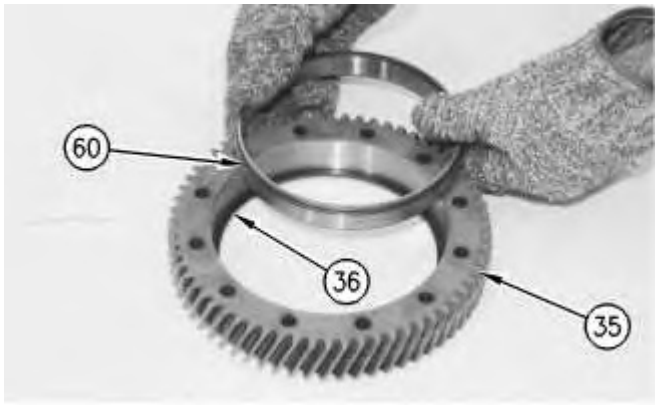

Illustration 21 g00505224

26. Use the proper equipment to handle outer bearing race (60). Lower the temperature of outer bearing race (60).

27. Install outer bearing race (60) in drive gear (35). Make sure that outer bearing race (60) makes contact with retaining ring (36).

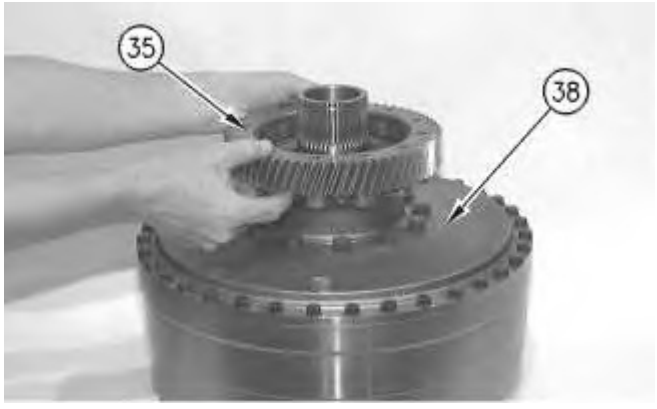

Illustration 22 g00505319

28. Install drive gear (35) on drive flange (38).

Illustration 23 g00505349

29. Install twelve bolts (34) and the washers. Tighten the bolts to a torque of 50 ± 7 N·m (37 ± 5 lb ft).

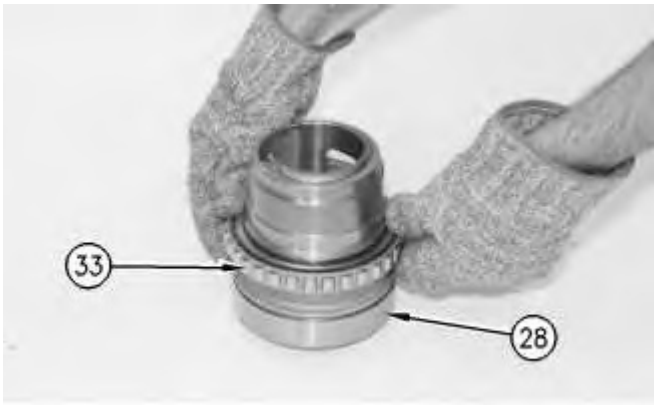

Illustration 24 g00505352

30. Use the proper equipment to handle inner bearing (33). Heat inner bearing (33) to a maximum temperature of 135°C (275°F). Install inner bearing (33) on bearing carrier (28).

Illustration 25 g00505358

31. Install retaining ring (32) in the groove of bearing carrier (28).

Illustration 26 g00505359

32. Use the proper equipment to handle ring carrier (31). Heat ring carrier (31) to a maximum temperature of 135°C (275°F). Install ring carrier (31) on bearing carrier (28).

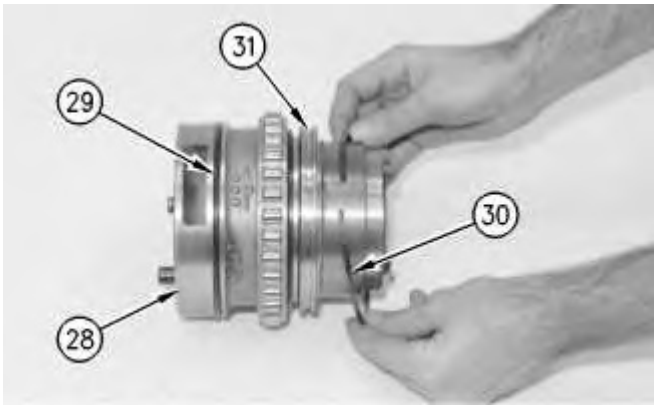

Illustration 27 g00505387

33. Install seal ring (30) on ring carrier (31).

34. Install O-ring seal (29) on bearing carrier (28).

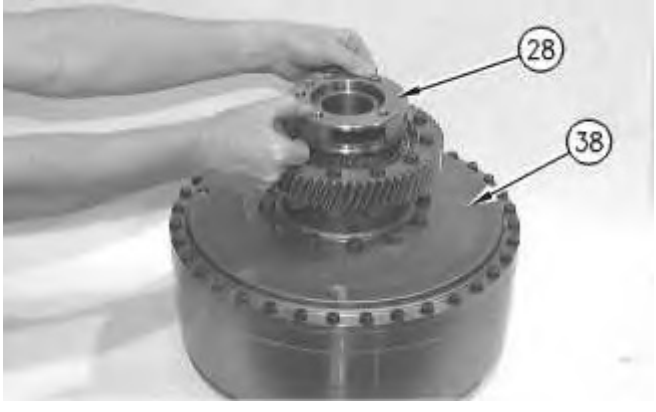

Illustration 28 g00505395

35. Install bearing carrier (28) in drive flange (38).

Illustration 29 g00505423

36. Install retaining ring (27) in carrier assembly (44) in order to hold bearing carrier (28) in place.

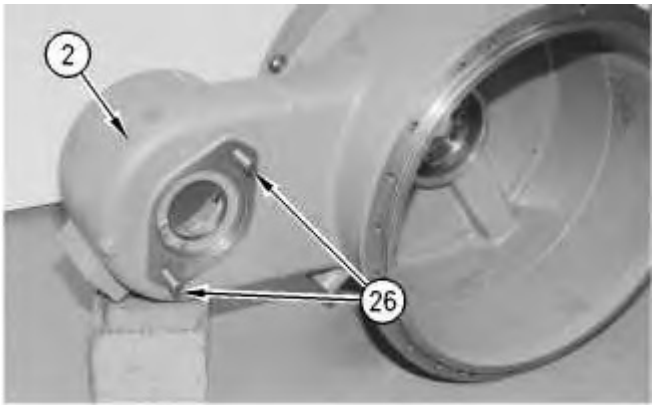

Illustration 30 g00503312

37. Install two studs (26) in torque converter housing assembly (2). Tighten the studs to a torque of 100 ± 15 N·m (74 ± 11 lb ft).

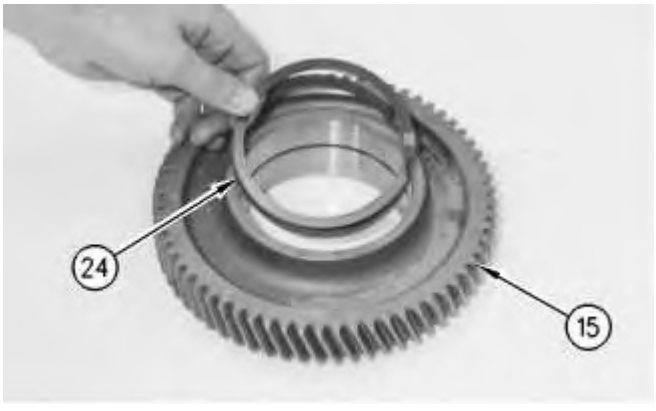

Illustration 31 g00505444

38. Install retaining ring (24) in the groove of idler gear (15).

Illustration 32 g00505465

39. Use the proper equipment to handle bearing cup (25). Lower the temperature of bearing cup (25). Install bearing cup (25) in idler gear (15).

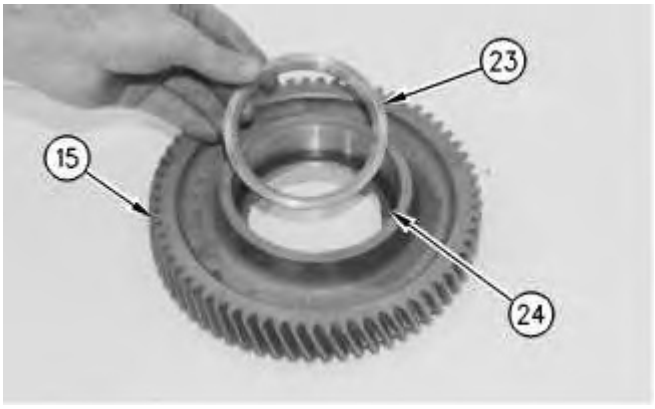

Illustration 33 g00505470

40. Flip idler gear (15) to the opposite side. Install bearing cup spacer (23) in idler gear (15). The notch in bearing cup spacer (23) must be aligned with retaining ring (24).

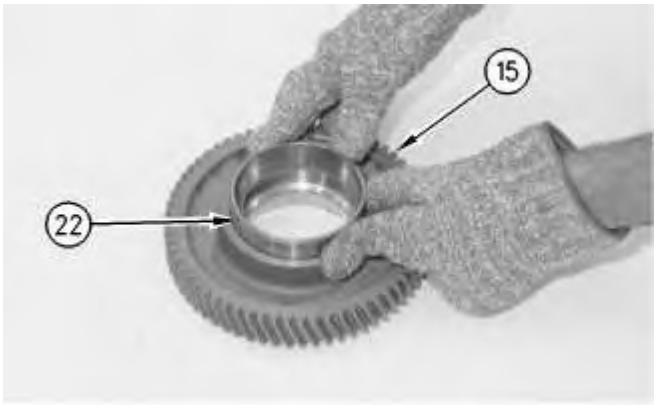

Illustration 34 g00505479

41. Use the proper equipment to handle bearing cup (22). Lower the temperature of bearing cup (22). Install bearing cup (22) in idler gear (15).

Illustration 35 g00505480

42. Install bearing cone (21), bearing cone spacer (20) and bearing cone (19) in idler gear (15).

Illustration 36 g00505482

43. Apply clean hydraulic oil on O-ring seal (17). Install O-ring seal (17) on shaft assembly (18).

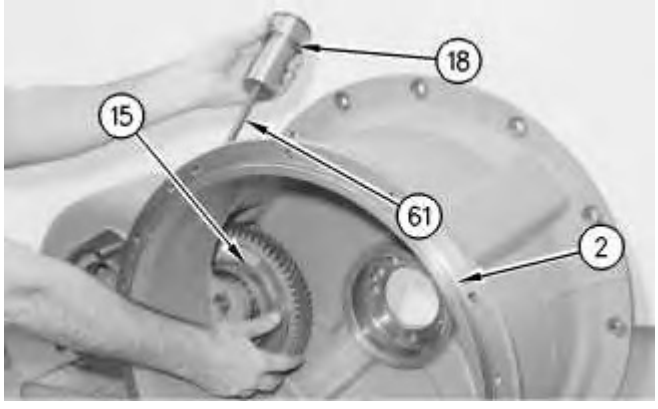

Illustration 37 g00505508

44. Install 1/2" - 13 NC guide pin (61) in shaft assembly (18).

45. Hold transfer gear (15) in position in torque converter housing assembly (2). Install shaft assembly (18).

46. Remove guide pin (61) from shaft assembly (18).

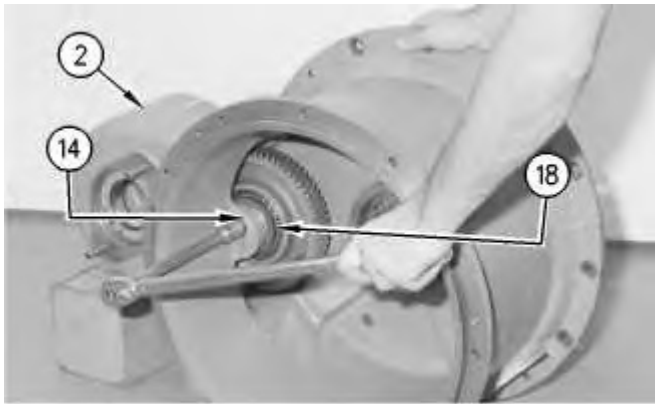

Illustration 38 g00505517

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