



# Service Repair Manual

## **Models**

**M325D L MH EXCAVATOR**

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Product: EXCAVATOR

Model: M325D L MH EXCAVATOR KAY

Configuration: M325D L Material Handler KAY00001-01999 (MACHINE) POWERED BY C-7 Engine

## Disassembly and Assembly M325D Material Handler Machine Systems

Media Number -REN9719-02

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i02229835

# Swing Drive - Disassemble

SMCS - 5459-015

## Disassembly Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	138-7573	Link Bracket	2
B	5P-5197	Retaining Ring Pliers	1
C	1P-0510	Driver Gp	1
D	1U-6213	Sleeve	1
E	138-7574	Link Bracket	2

### Start By:

- A. Remove the swing drive. Refer to Disassembly and Assembly, "Swing Drive - Remove".

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### NOTICE

**Care must be taken to ensure that fluids are contained during performance of inspection, maintenance, testing, adjusting and repair of the product. Be prepared to collect the fluid with suitable containers before opening any compartment or disassembling any component containing fluids.**

**Refer to Special Publication, NENG2500, "Caterpillar Tools and Shop Products Guide" for tools and supplies suitable to collect and contain fluids on Caterpillar products.**

**Dispose of all fluids according to local regulations and mandates.**

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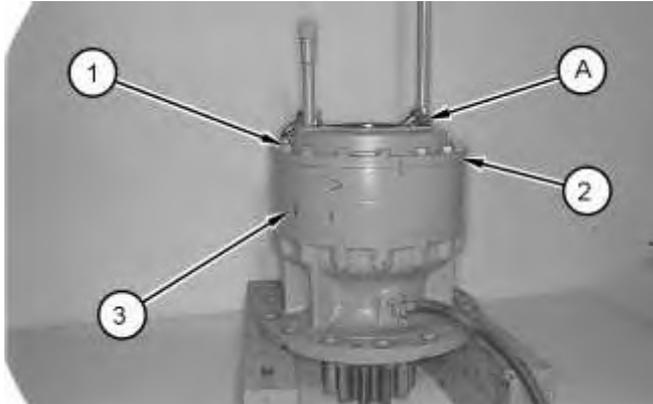


Illustration 1

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1. Position swing drive (3) on suitable blocking. The weight of swing drive (3) is approximately 310 kg (683 lb).
2. Remove bolts (1) from cover (2) .
3. Attach Tooling (A) to cover (2) .

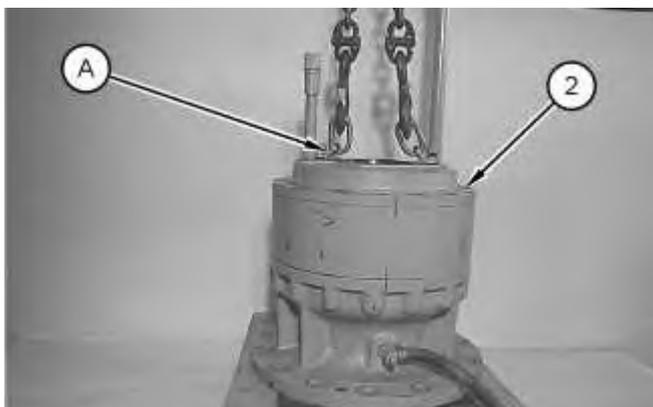


Illustration 2

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4. Use Tooling (A) and a suitable lifting device to remove cover (2) .
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Illustration 3

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5. Use a suitable lifting device or two people to remove carrier assembly (4). The weight of carrier assembly (4) is approximately 23 kg (50 lb).

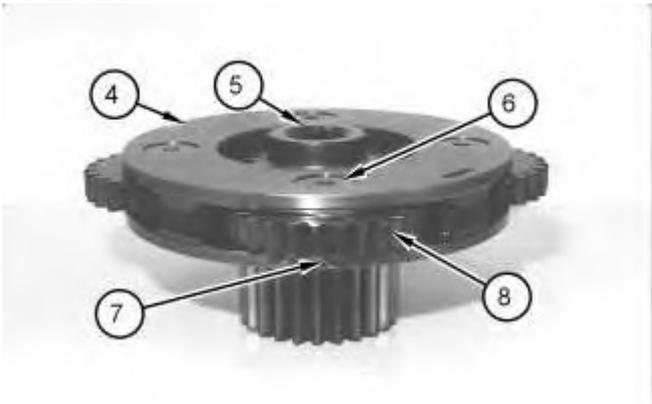


Illustration 4

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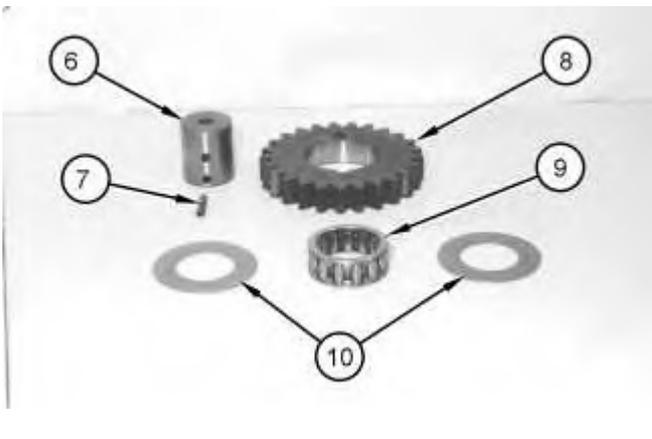


Illustration 5

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6. Remove sun gear (5) from carrier assembly (4) .

7. Drive pin (7) into shaft (6) .
8. Remove shaft (6), thrust washers (10), and gear (8) .
9. Remove bearing (9) from gear (8) .
10. Remove pin (7) from shaft (6) .
11. Repeat Steps 6 through 10 in order to remove the other three planetary gears from carrier assembly (4) .

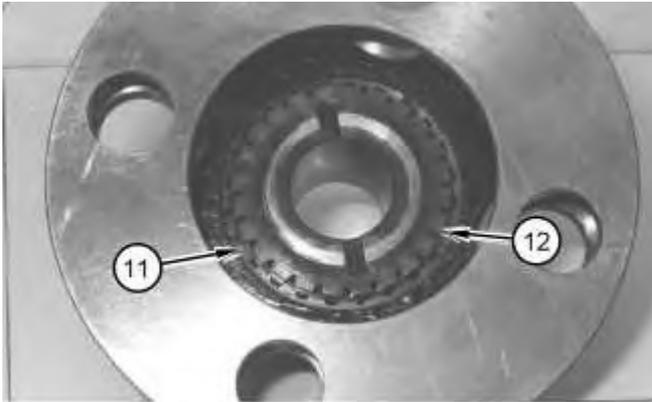


Illustration 6

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12. Remove retaining ring (11). Remove gear (12) .

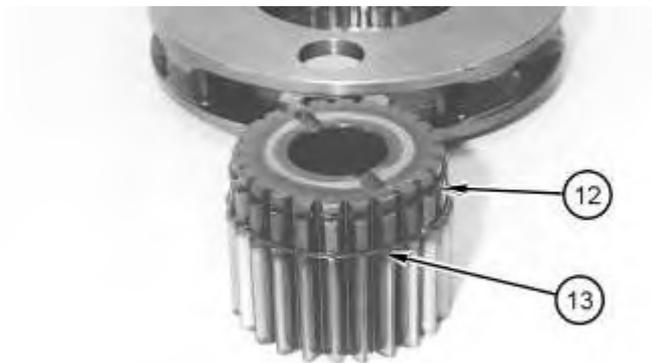


Illustration 7

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13. Remove retaining ring (13) from gear (12) .
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