



# Service Repair Manual

## **Models**

**M325D L MH EXCAVATOR**

---

Product: EXCAVATOR

Model: M325D L MH EXCAVATOR KAY

Configuration: M325D L Material Handler KAY02000-UP (MACHINE) POWERED BY C7 Engine

## Disassembly and Assembly M325D Material Handler Machine Systems

Media Number -REN9719-02

Publication Date -01/03/2011

Date Updated -16/03/2011

i02233131

### Swing Drive - Assemble

SMCS - 5459-016

### Assembly Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	138-7573	Link Bracket	2
B	5P-5197	Pliers	1
E	138-7574	Link Bracket	2
F	138-7575	Link Bracket	3
G	5P-3931	Anti-Seize Compound	1
H	1U-8846	Gasket Sealant	1
J	9S-3263	Thread Lock Compound	1
K	1P-0520	Driver Gp	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.

---



Illustration 1

g01126093

1. Use Tooling (K) to install lip seals (28) and O-ring seal (29) in bearing cage (27) .

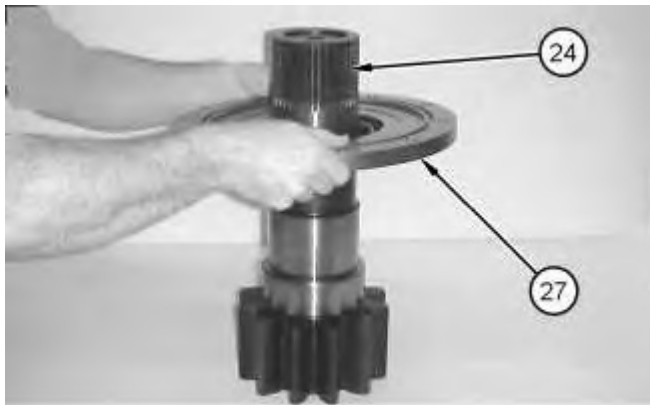
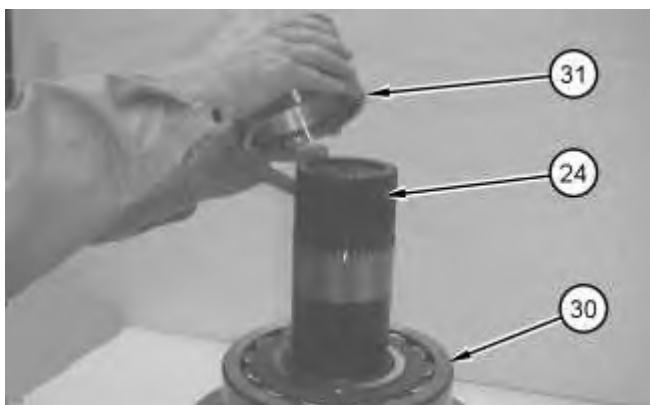


Illustration 2

g01126367

**Note:** Lubricate the seals and the seal surface of the shaft with the lubricant that is being sealed prior to installation of bearing cage (27) .

2. Install bearing cage (27) on pinion shaft (24) .



3. Raise the temperature of bearing (30). Install bearing (30) on pinion shaft (24) .
4. Install spacer (31) .



Illustration 4

5. Raise the temperature of bearing (32). Install bearing (32) on pinion shaft (24) .



Illustration 5

6. Use Tooling (B ) to install retaining ring (23) on pinion shaft (24) and against bearing (32) .
-

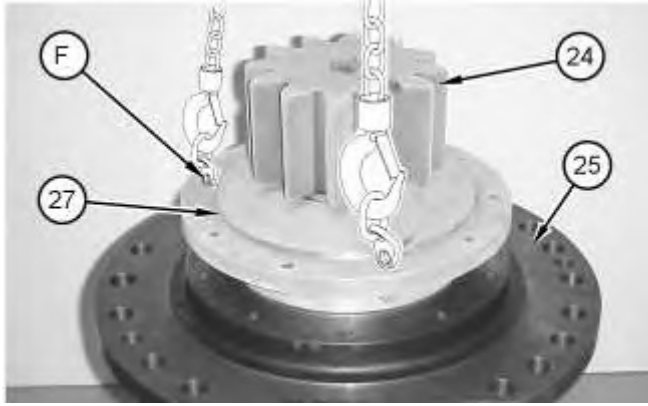


Illustration 6

g01126507

**Note:** Ensure that bearings (30) and (32) are aligned while pinion shaft (24) is positioned.

7. Apply Tooling (G) to the inside diameter of swing drive housing (25) .
8. Attach Tooling (F) and a suitable lifting device to pinion shaft (24) .
9. Lower the temperature of pinion shaft (24) .
10. Install pinion shaft (24) in swing drive housing (25). The weight of pinion shaft (24) is approximately 50 kg (110 lb).
11. Remove Tooling (F) and the lifting device from pinion shaft (24). Attach Tooling (E) and a suitable lifting device to swing drive housing (25). The combined weight of swing drive housing (25), pinion shaft (24), and bearing cage (27) is approximately 151 kg (333 lb).
12. Lift the swing drive vertically. Use a hammer and a drift to align bearing (30) in the lower bore of swing drive housing (25). When the bearing is properly aligned in the bore, pinion shaft (24) will drop into the proper position within swing drive housing (25) .

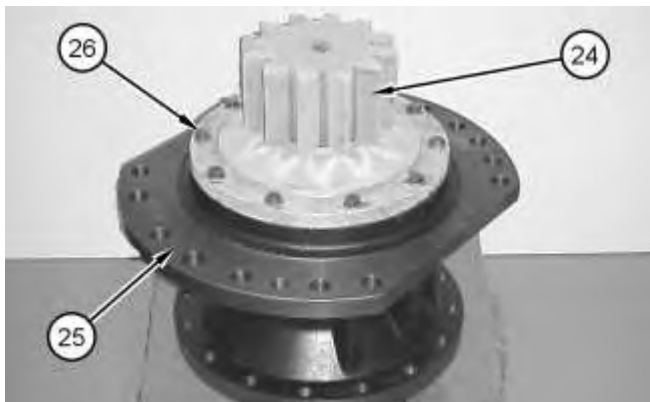


Illustration 7

g01126601

13. Apply Tooling (H) on the threads of bolts (26) .
14. Install bolts (26) .

Thank you so much for reading.  
Please click the “Buy Now!”  
button below to download the  
complete manual.



After you pay.

You can download the most  
perfect and complete manual in  
the world immediately.

Our support email:

[ebooklibonline@outlook.com](mailto:ebooklibonline@outlook.com)