



# Service Repair Manual

## **Model**

320C, 320C L 320CL, 320C LN  
320CLN Excavator

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Product: EXCAVATOR

Model: 320C EXCAVATOR GLA

Configuration: 320C, 320C L, 320C LN Excavators GLA00001-UP (MACHINE) POWERED BY 3066 Engine

## Disassembly and Assembly 320C Excavator Machine Systems

Media Number -REN3826-16

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i01972529

## Swing Motor - Install

SMCS - 5058-012-ZW

## Installation Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	FT-2674	Vacuum Cap	1
B	138-7573	Link Bracket	2
C	1U-8846	Gasket Sealant	

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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, "Dealer Service Tool Catalog" for tools and supplies suitable to collect and contain fluids on Cat® products.

Dispose of all fluids according to local regulations and mandates.

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1. Prior to the installation of the swing motor, make sure that the mating surfaces of the swing motor and the swing drive are thoroughly clean and dry.

2. Apply Tooling (C) on the mating surface of the swing motor and the swing drive housing.

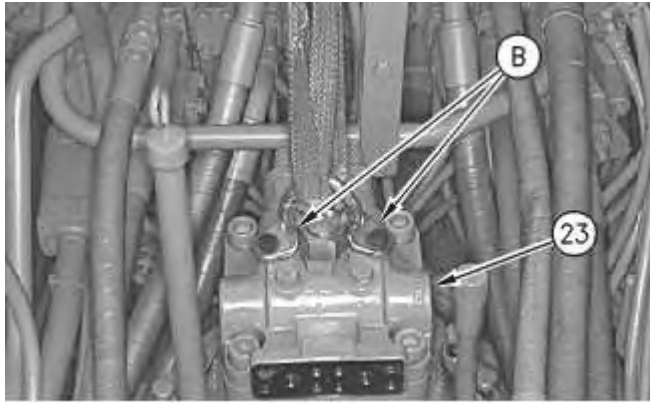


Illustration 1

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3. Attach Tooling (B) and a suitable lifting device to swing motor (23). The weight of swing motor (23) is approximately 55 kg (120 lb).

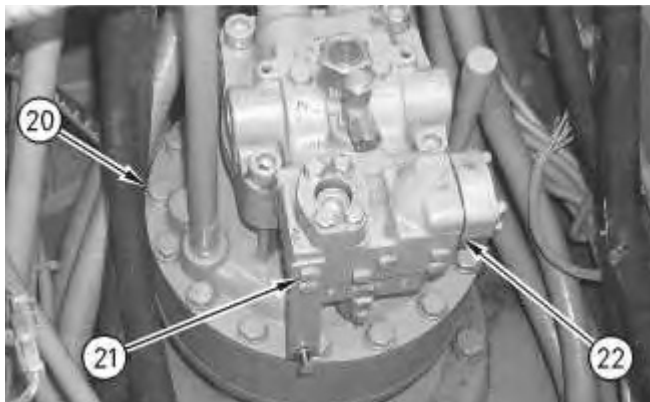


Illustration 2

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4. Install the washers and bolts (20).
5. Tighten bolts (20) to a torque of  $240 \pm 40 \text{ N}\cdot\text{m}$  ( $177 \pm 30 \text{ lb ft}$ ).
6. Install anti-reaction valve (22). Install the washers and bolts (21). Tighten bolts (21) to a torque of  $55 \pm 10 \text{ N}\cdot\text{m}$  ( $40 \pm 7 \text{ lb ft}$ ).



7. Remove the cap to the hydraulic tank. Attach Tooling (A) to the hydraulic tank.

**Note:** Hook up the air to Tooling (A) in order to create a vacuum in the hydraulic system. This will minimize the leakage from the hose assemblies.

**Note:** Replace the O-ring seals that are used in the ends of the hose assemblies.

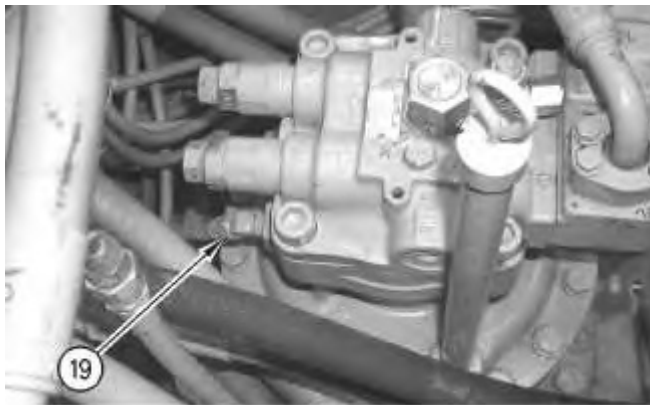


Illustration 4

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8. Connect hose assembly (19).

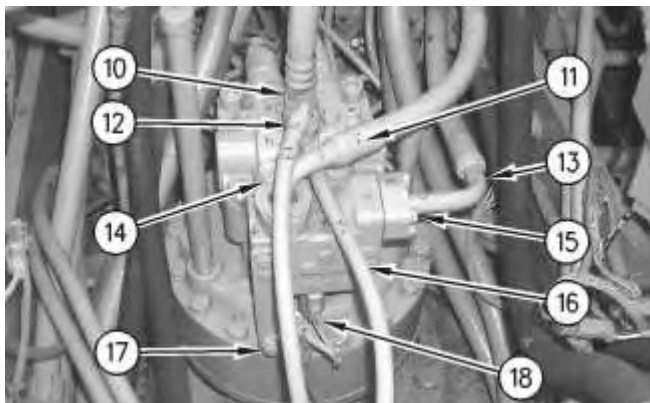


Illustration 5

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9. Connect hose assembly (13).
10. Install the split flanges, the washers and bolts (15).
11. Connect hose assembly (16).
12. Connect hose assembly (11).
13. Install the split flanges, the washers, and bolts (14).
14. Connect hose assembly (12).

15. Connect hose assembly (10).
16. Connect harness assembly (18).
17. Install the clip, the washer, and bolt (17).

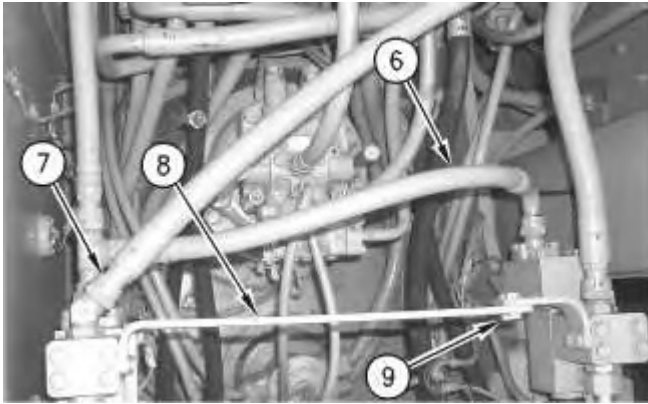


Illustration 6

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Typical example

18. Connect hose assembly (7) (If Equipped).
19. Install hose assembly (6) (If Equipped).
20. Install brace (8) with washers and bolts (9) (If Equipped).

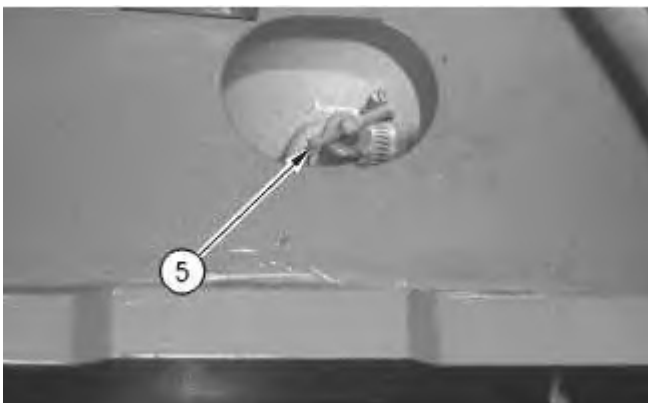


Illustration 7

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21. Make sure that the drain valve (5) is closed.
22. Remove Tooling (A) and install the cap to the hydraulic tank.

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## NOTICE

**To avoid system damage, make sure that the hydraulic motor is properly filled with hydraulic oil before start-up.**

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