



Service Repair Manual

Models

320D2 and 320D2 L Excavator

S/N - TMF1-UP

S/N - WDJ1-UP

S/N - XAN1-UP

S/N - XBB1-UP

S/N - XCC1-UP

S/N - YEA1-UP

S/N - ZBD1-UP

S/N - ZCS1-UP

Assembly Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
B	1P-1859	Retaining Ring Pliers	1
E	1P-0510	Driver Group	1
F	1U-6396	O-Ring Assembly Compound	

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. All disassembly and all assembly procedures must be performed on a clean work surface and in a clean hydraulic area. Keep cleaned parts covered and protected at all times.

Note: O-ring seals, gaskets, and seals should always be replaced. A used O-ring seal may not have the same sealing properties as a new O-ring seal. Use Tooling (F) during the assembly procedure.

Note: Apply a light film of hydraulic oil to all components before assembly.

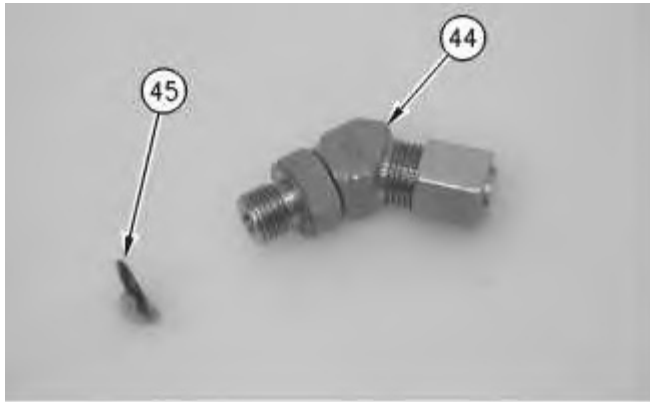


Illustration 1

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1. Install O-ring seal (45) onto the fitting (44).

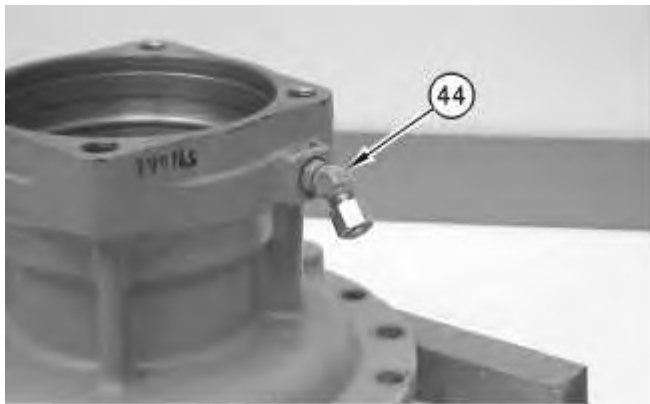


Illustration 2

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2. Install fitting (44) into the motor housing.

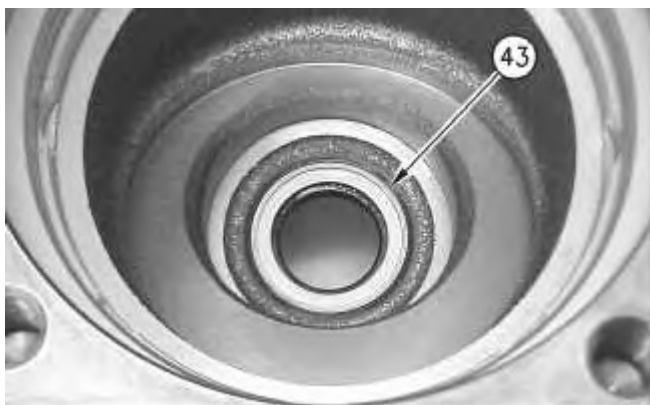


Illustration 3

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3. Lubricate the lip seal (43) with clean hydraulic oil. install lip seal (43) into the motor housing with the lip toward the inside of the motor housing.



Illustration 4
Typical Example

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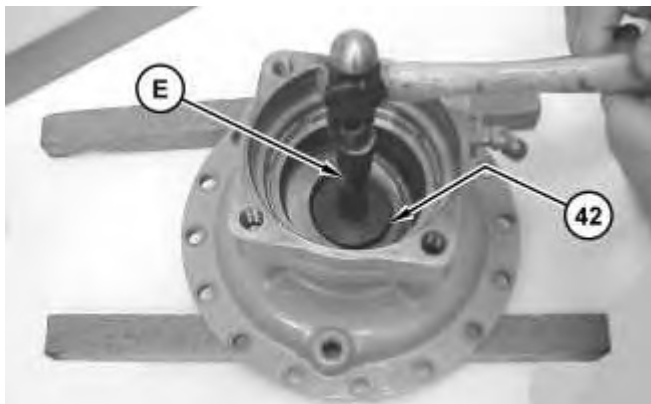


Illustration 5

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4. Use Tooling (E) to install bearing (42) into the motor housing.

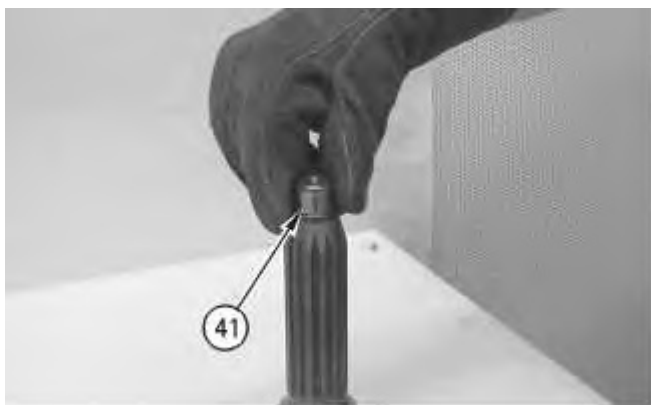


Illustration 6

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5. Raise the temperature of bearing race (41). Install the bearing race on the shaft.



Illustration 7

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6. Raise the temperature of bearing race (40). Install the bearing race on the shaft.

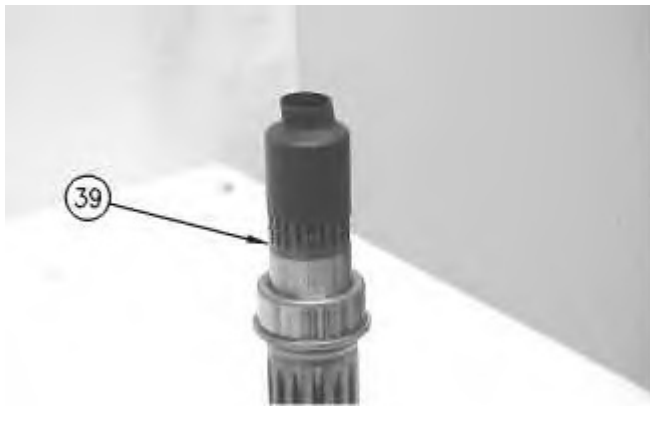


Illustration 8

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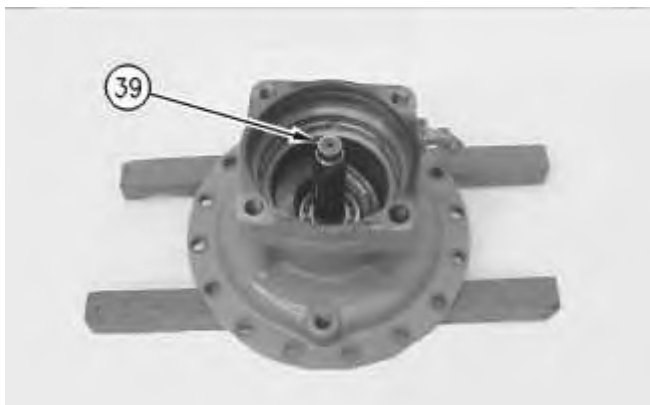


Illustration 9

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7. Install shrink wrap tubing onto shaft (39). The shrink wrap tubing will protect the seal during installation of shaft (39). Install shaft (39) into the motor housing.

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