



# Service Repair Manual

## **Models**

320D2L Excavator

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Product: EXCAVATOR

Model: 320D2 L EXCAVATOR EKT

Configuration: 320D2 & 320D2 L Excavators EKT00001-UP (MACHINE) POWERED BY C7.1 Engine

## Disassembly and Assembly 323D2 Excavator Machine Systems

Media Number -UENR3338-02

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i07177301

# Sprocket - Remove and Install

SMCS - 4164-010

## Removal Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	439-3940	Link Bracket	1



Illustration 1

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1. Position the machine onto suitable cribbing below the first roller, as shown. Ensure that the master pin is above the center line of the sprocket.
2. Separate the track. Refer to Disassembly and Assembly, "Track - Separate".

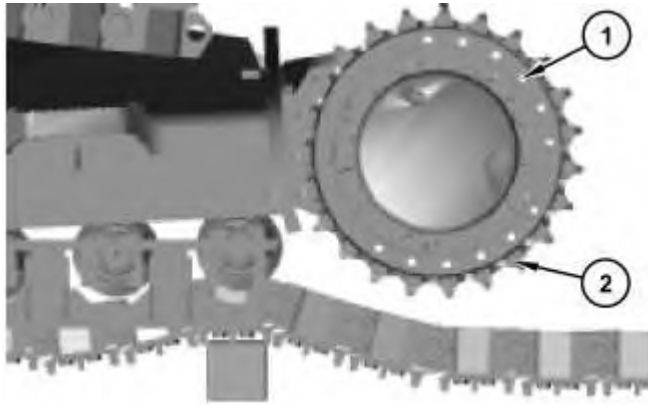


Illustration 2

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3. Remove bolts (1) that hold sprocket (2) to the final drive housing.

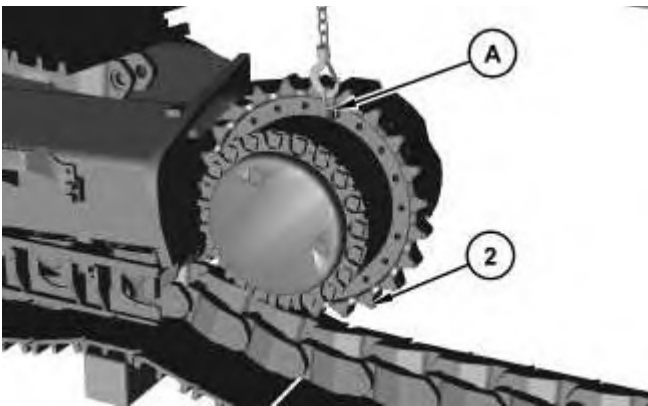


Illustration 3

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**Note:** Use several washers between Tooling (A) and sprocket (2) thus preventing damage to the sprocket.

4. Attach Tooling (A) and a suitable lifting device to sprocket (2), as shown.
5. Remove sprocket (2). The weight of sprocket (2) is approximately 40 kg (90 lb).

## Installation Procedure

Table 2

Required Tools			
Tool	Part Number	Part Description	Qty
A	439-3940	Link Bracket	1
B	-	Loctite 243	-

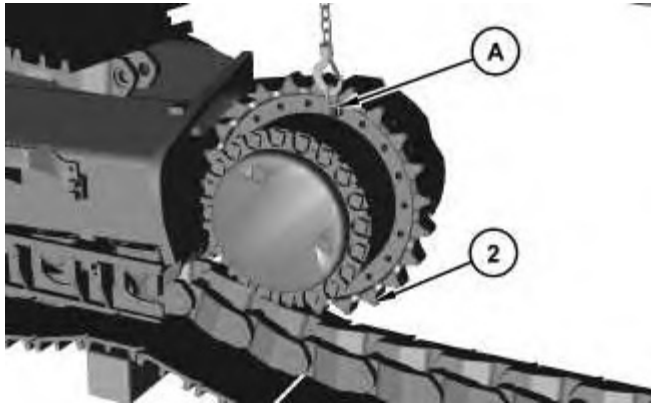


Illustration 4

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**Note:** Use several washers between Tooling (A) and sprocket (2) thus preventing damage to the sprocket.

1. Attach Tooling (A) to sprocket (2), as shown. The weight of sprocket (2) is approximately 40 kg (90 lb).
2. Position sprocket (2) onto the final drive.

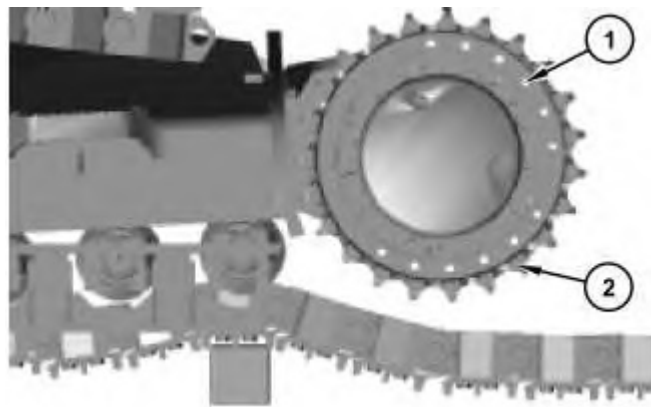


Illustration 5

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**Note:** Mounting surface of final drive housing and sprocket must be clean and free of paint and protective coating prior to assembly.

3. Apply Tooling (B) to the threads of bolts (1) Install and tighten bolts (1) in an alternating sequence to the torque specified in Table 3.

Table 3

Tightening Specifications	
Bolt Size	Torque
M20 (For field rework)	520 ± 70 N·m (384 ± 52 lb ft)
M20 (For new application)	150 ± 15 N·m (111 ± 11 lb ft) and turn an additional angle of 35 ± 5 degrees.

M24 (For field rework)	900 ± 100 N·m (664 ± 74 lb ft)
M24 (For new application)	250 ± 25 N·m (184 ± 18 lb ft) and Turn 35 degrees.

4. Refer to Service Magazine, M0083843, "An Improvement Bolt Tightening Procedure for the Critical Joints Is Now Used on All Excavators" for more detail information.
5. Remove Tooling (A).
6. Connect the Track.
7. Remove the cribbing from the front roller.

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