



Service Repair Manual

Models

322B EXCAVATOR

Product: EXCAVATOR
Model: 322B EXCAVATOR 3NR
Configuration: ISJ HEX COMMONALITY CHART 3NR00001-UP (MACHINE)

Disassembly and Assembly 322B & 322B L EXCAVATORS MACHINE SYSTEMS

Media Number -SEN1647-00

Publication Date -07/01/1997

Date Updated -30/03/2004

SEN16470025

Final Drives

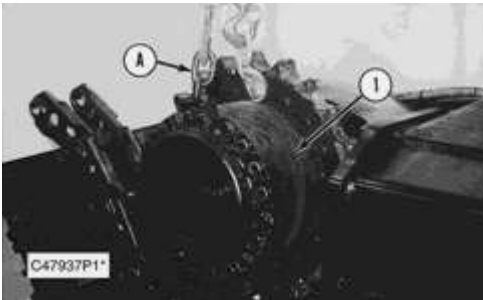
SMCS - 4050-010; 4050-017

Remove & Install Final Drives

Tools Needed	A
138-7574 Link Bracket	2

Start By:

- a. separate track assemblies
- b. remove travel brake valves



1. Fasten Tool (A) and a hoist to final drive (I). Put slight lifting tension on the final drive with the hoist.
2. Remove the 16 bolts and the washers that hold the final drive to the undercarriage frame assembly. These bolts are located on the back side of the final drive. Remove the two plugs from the threaded forcing screw holes in the undercarriage frame assembly.
3. Install suitable size forcing screws in the two threaded forcing screw holes in the undercarriage frame assembly. Tighten the forcing screws evenly to loosen the final drive from the

undercarriage frame assembly. Remove the final drive. The combined weight of the final drive, sprocket and travel motor is **379 kg (835 lb)**.

NOTE: The following steps are for the installation of the final drive.

4. Make sure the mating surfaces of the final drive and the undercarriage frame assembly are clean and free of dirt and debris.
5. Fasten Tool (A) and a hoist to final drive (1), and put it in position in the undercarriage frame assembly. Be sure all mounting bolt holes are in alignment.
6. Apply **9S-3263 Thread Lock** on threads of 16 bolts (4). Install the washers and 16 bolts that hold the final drive to the undercarriage frame assembly. Tighten the bolts to a torque of **530 ± 70 N·m (395 ± 50 lb ft)**.

End By:

- a. install travel brake valves
- b. connect track assemblies

Disassemble & Assemble Final Drives

Tools Needed	A	B	C	D	E
1P-2420 Transmission Repair Stand	1				
138-7573 Link Bracket		3			
1P-5546 Cross Block			1		
6V-3142 Puller Plate			1		
5P-8248 Washer			4		
3H-0459 Puller Bolt			1		
Spacer 63.5 mm (2.50 in) O.D. 25.4 mm (1.0 in) I.D. 6.4 mm (.25 in) Thick			4		
6B-6682 Nut			1		
138-7574 Link Bracket				2	
126-3994 Seal Installer					1

Start By:

- a. remove final drives
1. Thoroughly clean the outside of the final drive prior to disassembly.
 2. Remove the travel motor from the final drive. See the topic "Remove & Install Travel Motors" in this module.

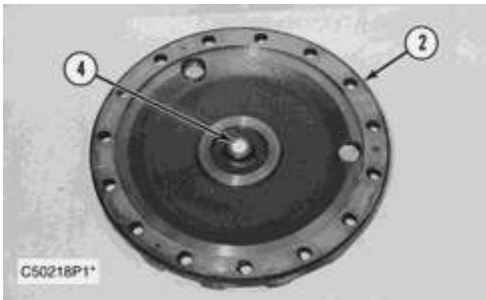
3. Put an alignment mark across the sections of the final drive for assembly purposes. The parts must be reinstalled in their original locations.



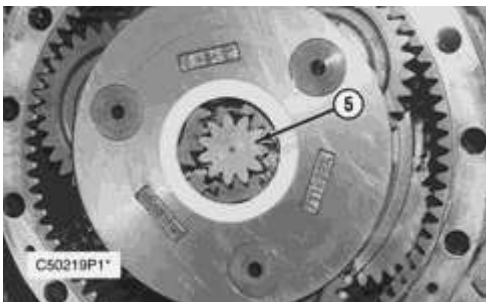
4. Fasten the final drive to Tool (A). The combined weight of the final drive and the sprocket is **272 kg (600 lb)**.

5. Remove 16 bolts (1) and the washers that hold cover (2) in place.

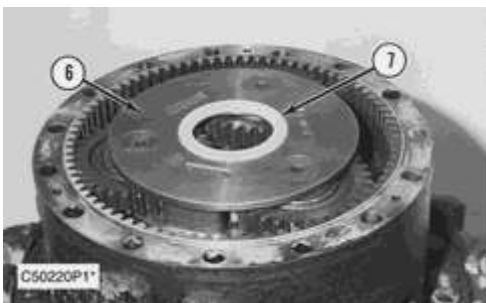
6. Using a soft faced hammer, break the seal between cover (2) and ring gear (3). Remove the cover.



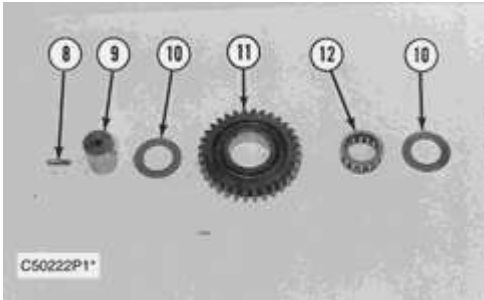
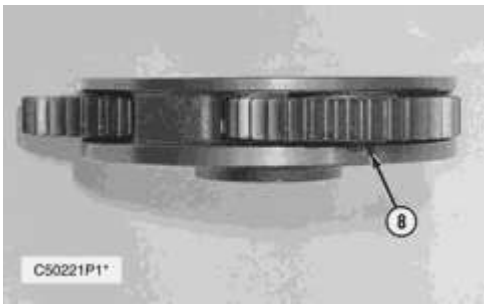
7. Remove thrust plate (4) from cover (2).



8. Remove sun gear (5) from the carrier assembly.

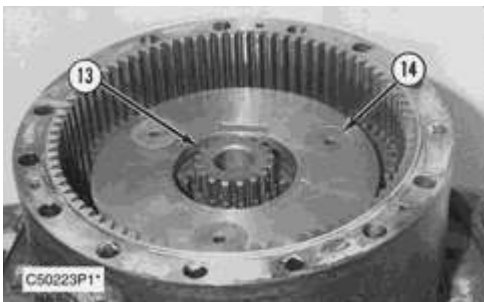


9. Remove spacer (7) from carrier assembly (6). Remove carrier assembly (6) by lifting it straight up.

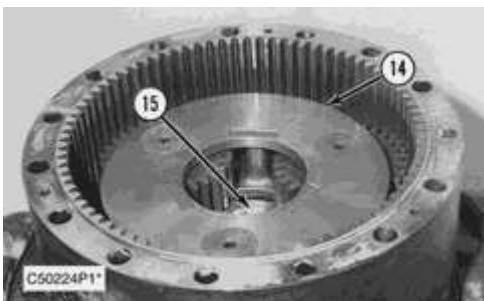


10. Disassemble carrier assembly (6) as follows:

- a. Drive spring pin (8) into planetary shaft (9) with a hammer and punch.
- b. Remove planetary shaft (9), two thrust washers (10) and planetary gear (11) from the carrier. Remove bearing (12) from the planetary gear.
- c. Remove spring pin (8) from planetary shaft (9) with a hammer and punch.
- d. Remove the other two planetary gears from the carrier as in Steps 10a through 10c.



11. Remove sun gear (13) from carrier assembly (14).



12. Remove carrier assembly (14). Remove spacer (15) from the carrier assembly.

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