



Service Repair Manual

Models

329D2 and 329D2L Excavator

Product: EXCAVATOR

Model: 329D2 L EXCAVATOR RGA

Configuration: 329D2 & 329D2 L Excavators RGA00001-UP (MACHINE) POWERED BY C7.1 Engine

Disassembly and Assembly 326D2, 329D2 and 330D2 Excavators Machine Systems

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i02554256

Swing Motor - Assemble

SMCS - 5058-016

Assembly Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
D	1P-1853	Retaining Ring Pliers	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. 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-rings, gaskets, and seals should always be replaced. A used O-ring may not have the same sealing properties as a new O-ring. Use **1U-6396** O-Ring Assembly Compound during the assembly procedure.

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

Note: If a failure occurs, an accurate diagnosis of the cause can prevent a recurrence. Information is available to analyze failures for piston pumps and motors. Refer to Special Publication, SEBD0641, "Analyzing Axial Piston Pump and Motor Failures".

Note: Inspect all parts. If any parts are worn or damaged use new parts for replacement. The installation of used parts during reconditioning is acceptable. Reuse and salvage information is available on piston pumps. Refer to Guideline For Reusable Parts and Salvage Operations, SEBF8032, "Piston Pumps and Motors". During reconditioning, correct any conditions that might have caused the original failure.



Illustration 1

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1. Install seal (34) into the housing.



Illustration 2

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2. Lower the temperature of bearing (33).
3. Install bearing (33) into the housing.

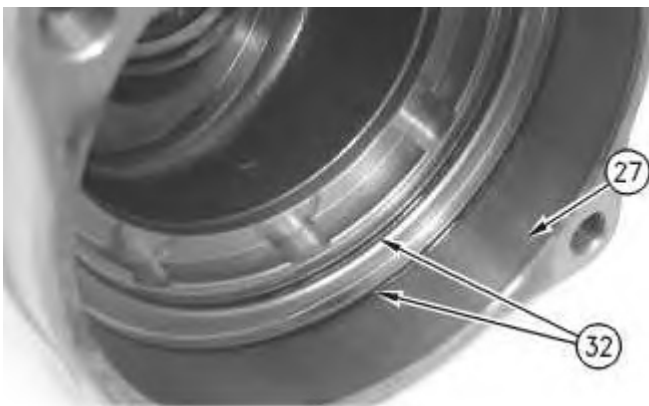


Illustration 3

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4. Install O-ring seal (32) into housing (27).
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Illustration 4

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5. Raise the temperature of bearing race (31). Install bearing (31) onto the shaft.

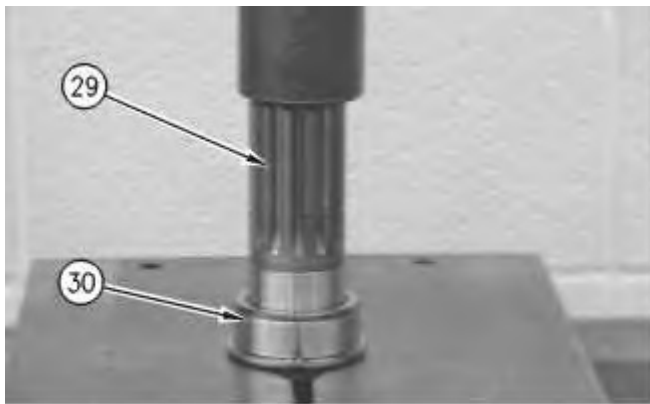


Illustration 5

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6. Raise the temperature of bearing race (30). Install bearing (30) onto shaft (29).

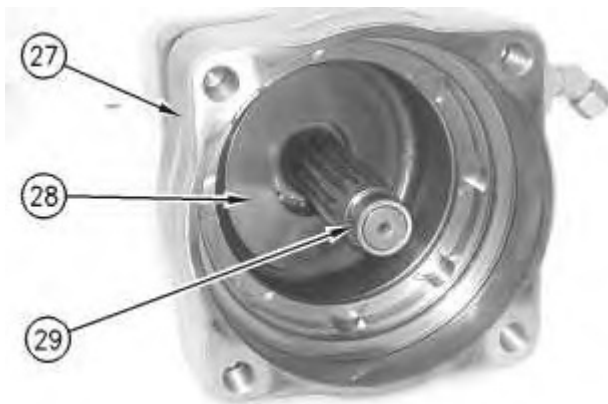


Illustration 6

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7. Install shaft (29) and plate (28) into housing (27).

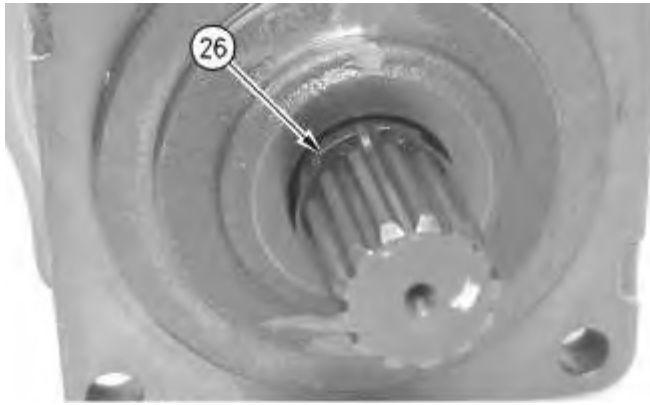


Illustration 7

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8. Use Tooling (D) in order to install retaining ring (26).

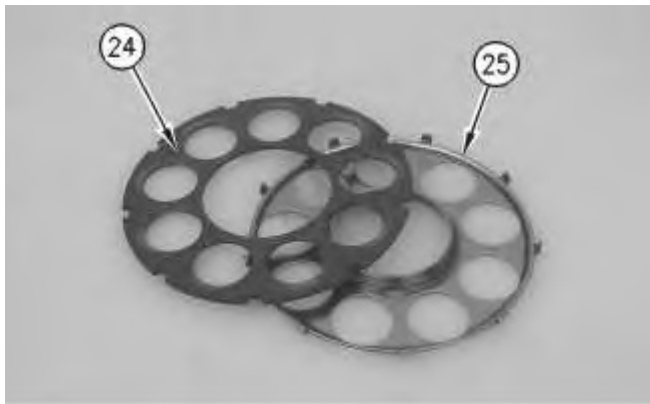


Illustration 8

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9. Reassemble plates (24) and (25).



Illustration 9

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10. Install pistons (23) into plates (24) and (25).

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