



Service Repair Manual

Models

M322C WHEELED Excavator

Product: WHEELED EXCAVATOR

Model: M322C WHEELED EXCAVATOR BDY

Configuration: M322C Excavator BDY00001-02000 (MACHINE) POWERED BY 3056 Engine

Disassembly and Assembly M318C MH and M322C MH Excavators Power Train

Media Number -REN7011-03

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Final Drive Carriers, Hubs and Brakes - Assemble - Rear Axle

SMCS - 4054-016; 4092-016; 4253-016; 4255-016

Assembly Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
C	1P-1859	Retaining Ring Pliers	1
	1P-1853	Retaining Ring Pliers	1
	1U-8758	Retaining Ring Pliers	1
E	6V-6080	Torque Multiplier Gp	1
	4C-4661	Center Ring	1
	4C-4058	Spanner	1
F	1U-6415	Three Jaw Puller	1
H	1P-0510	Driver Gp	1
I	9S-7354	Torque Wrench Gp	1
J	9U-5006	Torque Wrench Gp	1
K	123-6707	Seal Installer	1
L	6V-7030	Micrometer Depth Gauge Group	1
M	8T-0447	Dial Caliper	1
N	188-7400	Piston Installer	1

P	123-6695	Driver	1
Q	4C-3085	Two Jaw Puller	1
R	182-1744	Bearing Puller	1
S	6V-6640	Sealant	1
T	5P-0960	Molybdenum Grease	1
U	9S-3263	Thread Lock Compound	1
V	129-1063	Rivet Tool	1

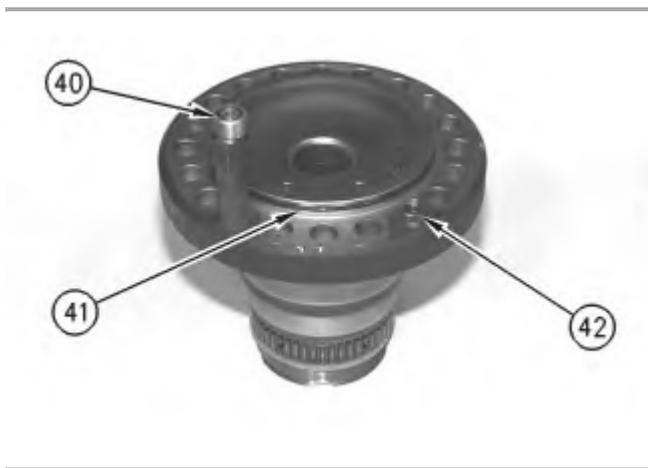
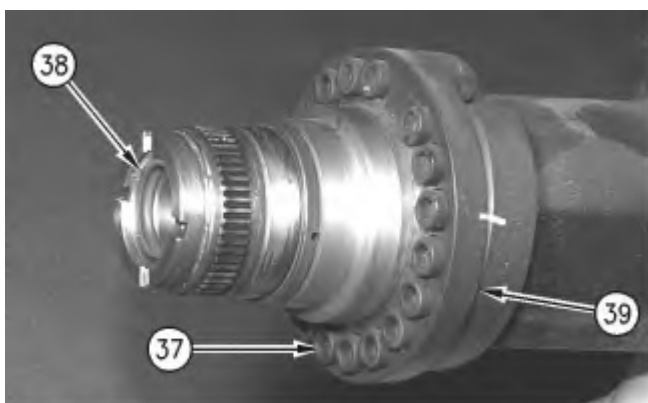


Illustration 1

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1. Install the O-ring seals on connector (40) . Install connector (40) in the spindle.
2. Install breather valve (42) in the spindle.
3. Install O-ring seal (41) in the spindle.

Note: Some spindle assemblies will have four plugs. If the plugs have been removed, use Tooling (V) to install four new plugs in each spindle assembly.



4. Install spindle (39) in the spindle's original location.
5. Install bolts (37) . Tighten the socket head bolts to a torque of 280 N·m (210 lb ft).
6. Install slotted nut (38) .



Illustration 3

7. Use Tooling (P) to install plate (36) on the spindle. Install the plate until the plate makes contact with the face of the spindle.



Illustration 4

8. Heat inner bearing cone (35) to a temperature of 135 °C (275 °F). Install inner bearing cone (35) on the spindle. Make sure that the bearing cone is seated against the shoulder on the spindle.
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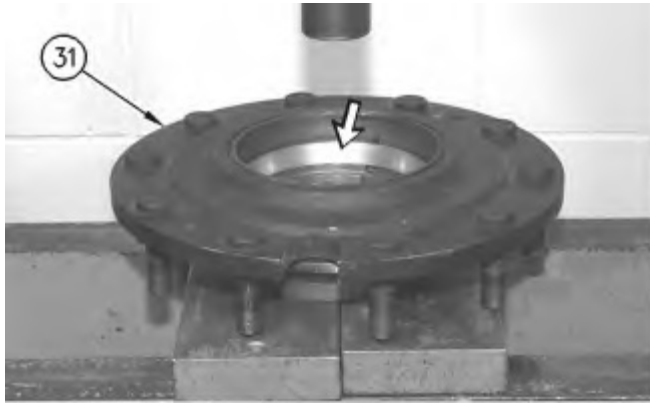


Illustration 5

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9. Lower the temperature of the inner bearing cup to a temperature of $-75\text{ }^{\circ}\text{C}$ ($-103\text{ }^{\circ}\text{F}$). Install the inner bearing cup in hub (31) . Use Tooling (G) to seat the inner bearing cup in the hub.

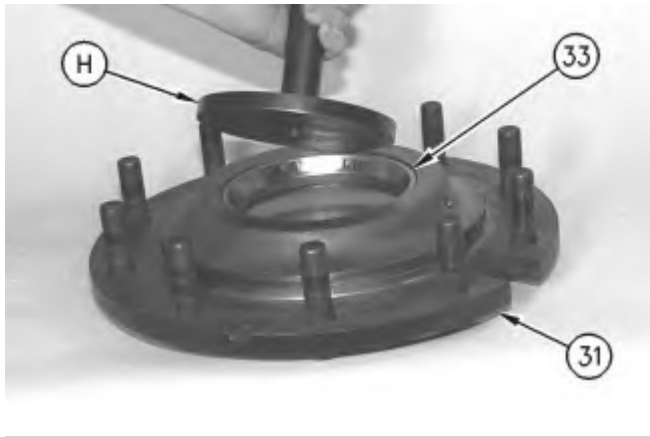


Illustration 6

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10. Invert the hub. Lower the temperature of outer bearing cup (33) to a temperature of $-75\text{ }^{\circ}\text{C}$ ($-103\text{ }^{\circ}\text{F}$). Install the outer bearing cup in hub (31) . Use Tooling (H) to seat the outer bearing cup in the hub.



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