

Product: MINI HYD EXCAVATOR

Model: 307C MINI HYD EXCAVATOR BNE

Configuration: 307C & 307C SB Excavators BNE00001-UP (MACHINE) POWERED BY 4M40 Engine

Disassembly and Assembly 307C Excavator Machine Systems

Media Number -REN4029-02

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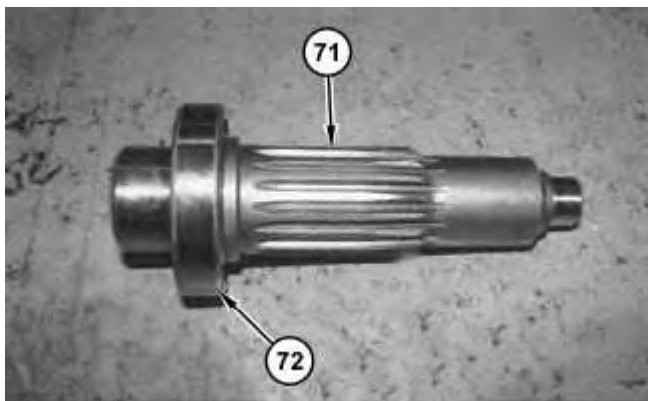
Final Drive and Travel Motor - Assemble

SMCS - 4050-016; 4351-016

Assembly Procedure

Table 1

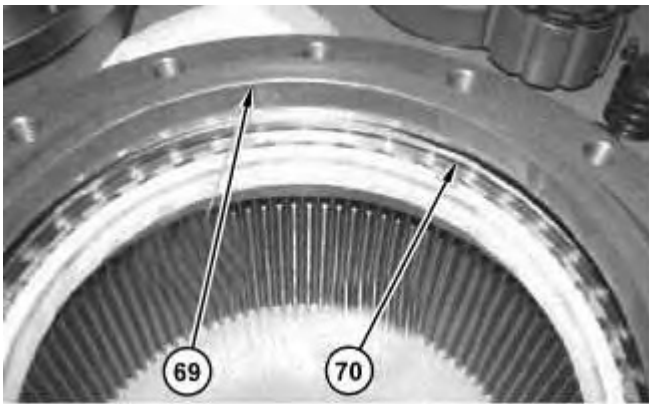
Required Tools			
Tool	Part Number	Part Description	Qty
A	-	Loctite 242	-
B	-	Loctite High Flex Film	-
C	FT3209	Retainer Nut Wrench As.	1
D	FT3208	Retainer Nut Wrench	1
E	9S-7353	Torque Wrench	1
F	6V-2055	Grease	1



1. Using a suitable press, install the bearing (72) onto the shaft (71) .



2. Install the shaft (71) and bearing (72) into the body casing. Install the floating seal (73) onto the body casing (74) . Refer to Disassembly and Assembly, "Duo Cone Seal - Install".



3. Install angular bearing (70) and floating seal (69) onto the gear casing. Refer to Disassembly and Assembly, "Duo Cone Seal - Install"
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Illustration 4

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4. Position gear casing as shown and install angular bearing (68) onto the gear casing.

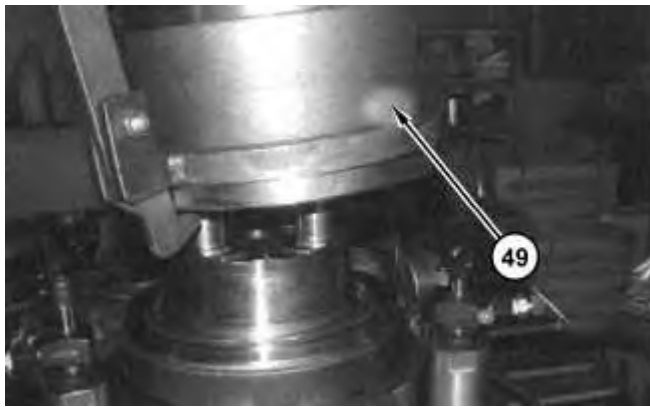


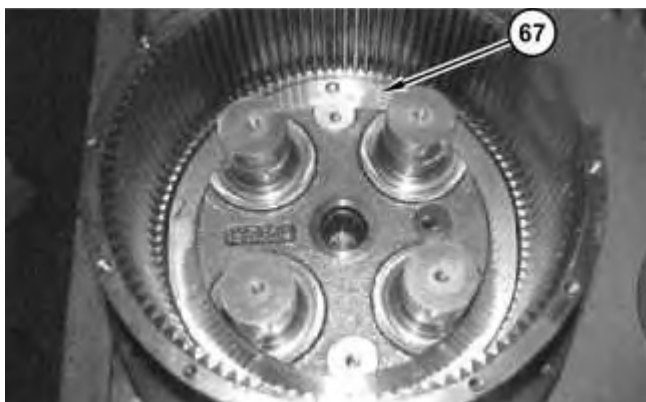
Illustration 5

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5. Using a suitable lifting device, install gear casing (49) onto the body casing.

Note: After installing the gear casing onto the body casing, there will be a gap between two components. The gap will be eliminated by installing and adjusting the ring nut (67).

6. Use the following procedure to adjust the preload of the angular bearings (68) and (70).



- a. Install ring nut (67) . Use tooling (C) and tighten the ring nut (67) until there is no gap between body casing, two bearings, gear casing, and ring nut.
- b. Rotate gear casing (49) several turns.
- c. Install and tighten one sprocket bolt into the sprocket flange on the gear casing.
- d. Using tooling (E) on the sprocket bolt, attempt to rotate the gear casing.
- e. Turn the ring nut (67) clockwise and counterclockwise until the rotating torque for the bearings measured with tooling (E) is $35 \pm 5 \text{ N}\cdot\text{m}$ ($25 \pm 3 \text{ lb ft}$)

Note: The pin location may not remain the same after rotating the ring nut to achieve the correct bearing preload in step 6. To apply the pin to the ring nut, drill a new hole opposite from the original pin position.

7. With the bearing preload set, drill the body casing (74) and the ring gear (67) and install the pin (66) . Use the following procedure to drill the new pin hole.

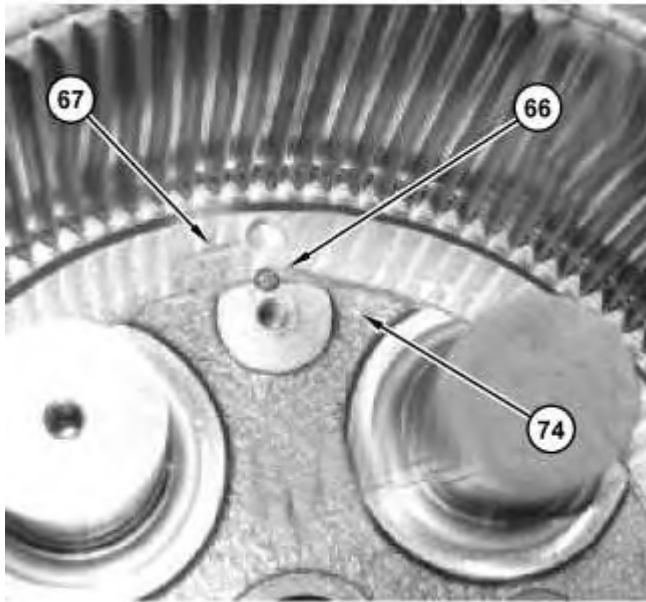


Illustration 7

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- a. Cover the threaded hole. Drill a 6 mm (0.25 inch) hole between body casing (74) and ring nut (67) . Clean the assembly of debris in order to eliminate contamination.
- b. Install pin (66) .

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