

Product: EXCAVATOR

Model: 340F EXCAVATOR SGH

Configuration: 340F Excavator SGH00001-UP (MACHINE) POWERED BY C9.3 Engine

Disassembly and Assembly 340F Excavator Machine Systems

Media Number -UENR6797-01

Publication Date -01/09/2015

Date Updated -21/12/2016

i05393341

Swing Drive - Disassemble

SMCS - 5459-015

S/N - DKF1-UP

S/N - RBC1-UP

S/N - SGH1-UP

S/N - ZBJ1-UP

Disassembly Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	138-7573	Link Bracket	2
B	5P-5197	Retaining Ring Pliers As	1

Start By:

- a. Remove the swing drive.
 1. Position the swing drive onto suitable cribbing. The weight of the swing drive is approximately 281 kg (620 lb).
 2. Put an alignment mark on the cover and the housing of the swing drive for assembly purposes.
-

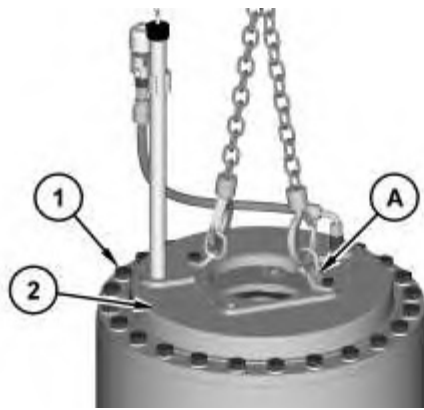


Illustration 1

g02115775

3. Attach Tooling (A) and a suitable lifting device to cover (2). The weight of cover (2) is approximately 23 kg (51 lb). Remove bolts (1) and cover (2).

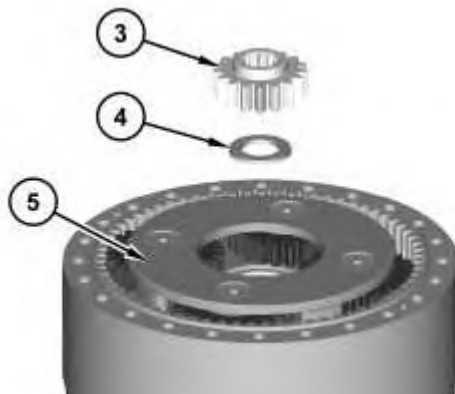


Illustration 2

g02115813

4. Remove sun gear (3) and spacer (4).
5. Use two people in order to remove carrier assembly (5). The weight of carrier assembly (5) is approximately 23 kg (50 lb).

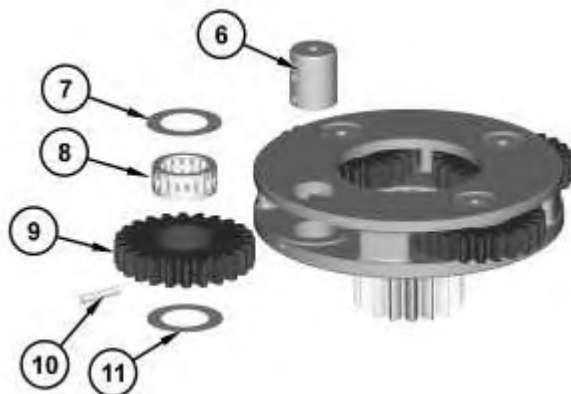


Illustration 3

g02115814

6. Drive spring pin (10) into planetary shaft (6) with a suitable hammer and a suitable punch.
7. Remove planetary shaft (6), thrust washer (7), thrust washer (11), planetary gear (9), and bearing assembly (8) from the carrier assembly.
8. Remove spring pin (10) from planetary shaft (6) with a suitable hammer and a suitable punch.
9. Repeat Step 6 through Step 8 in order to remove the other three planetary gears from the carrier assembly.



Illustration 4

g02115853

10. Remove retaining ring (12) and sun gear (14) from the carrier.
11. Remove retaining ring (13) from sun gear (14).

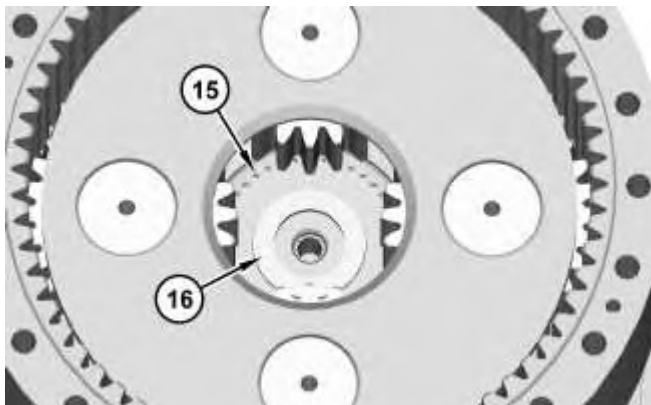


Illustration 5

g02115915

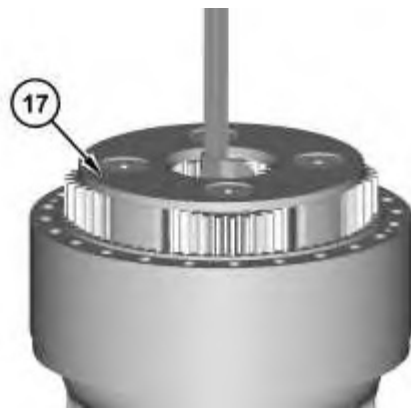


Illustration 6

g02115916

12. Remove spacer (16).
13. Remove retaining ring (15) that holds carrier assembly (17) in position.
14. Use a suitable piece of steel bar stock between the planetary gears in carrier assembly (17). Make sure that the steel bar stock is centered in carrier assembly (17). Attach a suitable lifting device to the steel bar stock. Slowly lift carrier assembly (17) from the swing drive housing. The weight of carrier assembly (17) is approximately 39 kg (86 lb).

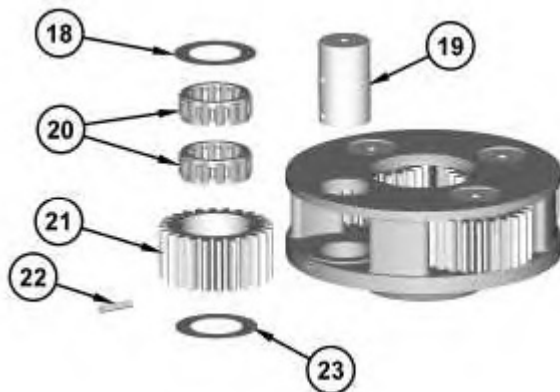


Illustration 7

g02115917

15. Drive spring pin (22) into planetary shaft (19) with a suitable hammer and a suitable punch.
 16. Remove planetary shaft (19), thrust washer (18), thrust washer (23), planetary gear (21), and bearing assemblies (20) from the carrier assembly.
 17. Remove spring pin (22) from planetary shaft (19) with a suitable hammer and a suitable punch.
 18. Repeat Step 15 through Step 17 in order to remove the other three planetary gears from the carrier assembly.
-



Illustration 8

g02115919

19. Attach Tooling (A) and a suitable lifting device to ring gear (24). The weight of ring gear (24) is approximately 39 kg (86 lb). Remove ring gear (24).



Illustration 9

g02116593

20. Use Tooling (B) in order to remove retaining ring (25).



Illustration 10

g03409949

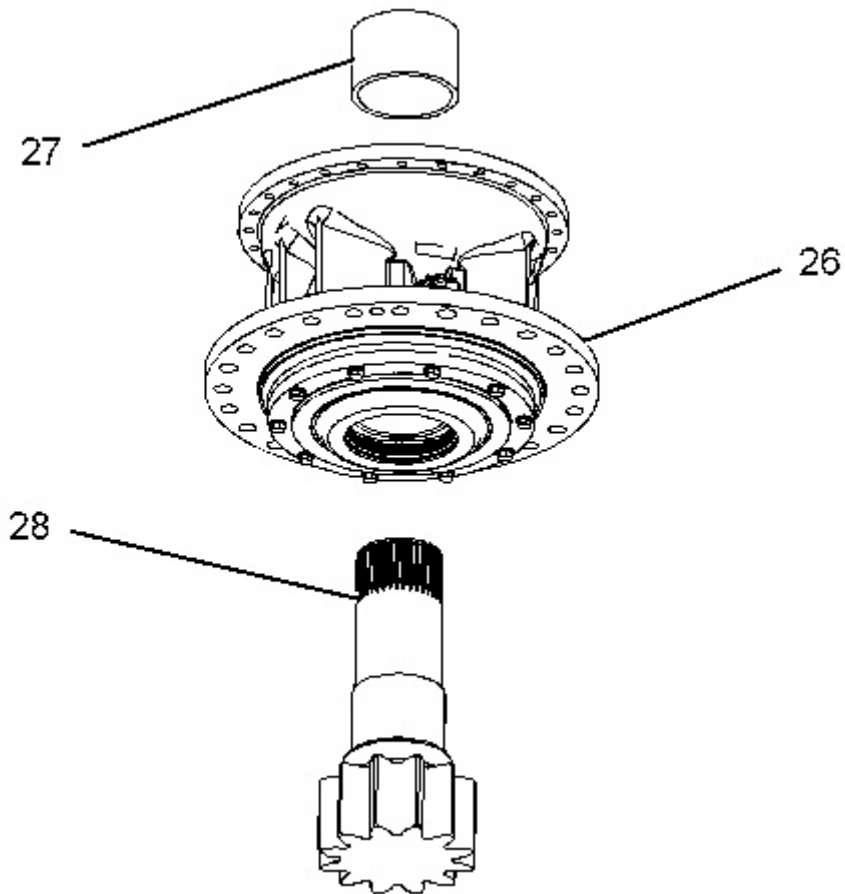


Illustration 11

g03409942

21. Attach Tooling (A) and a suitable lifting device to swing drive housing (26). Position swing drive housing (26) in a suitable press. The combined weight of swing drive housing (26), the pinion shaft, and the bearing cage is approximately 136 kg (300 lb).
 22. Position suitable cribbing directly under the pinion shaft in order to prevent the pinion shaft from falling when pressed out.
 23. Remove pinion shaft (28) and spacer (27) from swing drive housing (26).
-

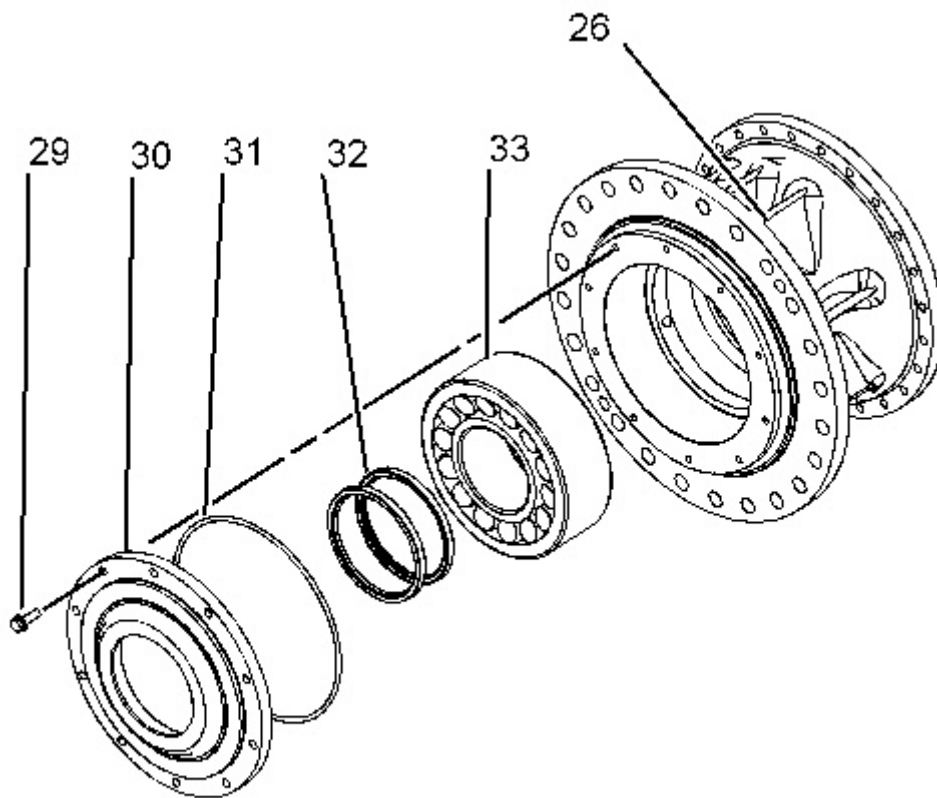


Illustration 12

g03410004

24. Put an alignment mark on cage (30) and swing drive housing (26) for assembly purposes.
25. Remove bolts (29) that secure cage (30) to the swing drive housing. Remove cage (30), O-ring seal (31), and bearing (33).
26. Remove lip seals (28) from cage (30).



Illustration 13

g03410014

27. Remove bearing (34) from swing drive housing (26).
-

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Publication Date -01/09/2015

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i06272523

Swing Drive - Disassemble

SMCS - 5459-015

S/N - EAR1-UP

S/N - SGH1-UP

S/N - YBF1-UP

Disassembly Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	439-3938	Link Bracket	2

Start By:

- a. Remove the swing drive.

Note: Cleanliness is an important factor. Before the disassembly procedure, the exterior of the component should be thoroughly cleaned. This will prevent dirt from entering the internal mechanism.

NOTICE

Keep all parts clean from contaminants.

Contamination of the hydraulic system with foreign material will reduce the service life of the hydraulic system components.

To prevent contaminants from entering the hydraulic system, always plug or cap the lines, fittings, or hoses as they are disconnected. Cover any disassembled components and clean them properly before assembly.

Clean the hydraulic system properly after any major component exchange or especially after a component failure, to remove any contamination.

1. Position the swing drive onto suitable cribbing. The weight of the swing drive is approximately 514 kg (1133 lb).
 2. Put an alignment mark on the cover and the housing of the swing drive for assembly purposes.
-

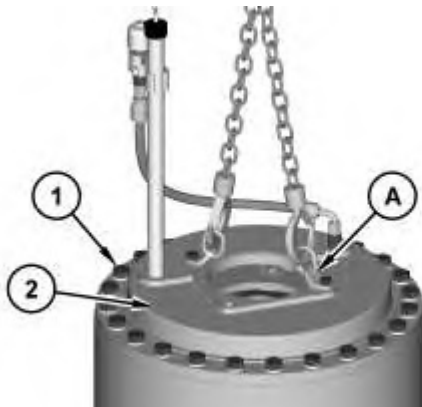


Illustration 1

g02115775

3. Attach Tooling (A) and a suitable lifting device to cover (2). The weight of cover (2) is approximately 23 kg (51 lb). Remove bolts (1) and cover (2).
-



Illustration 2

g03879823

4. Remove sun gear (3) and spacer (4).

5. Use two people to remove carrier assembly (5). The weight of carrier assembly (5) is approximately 23 kg (50 lb).
-

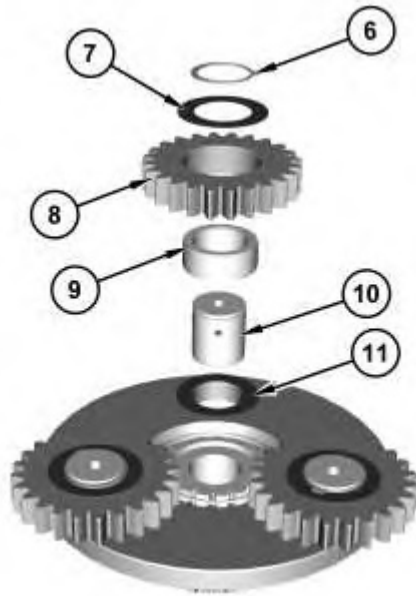


Illustration 3

g03879897

6. Remove retaining ring (6).
 7. Remove planetary shaft (10), thrust washer (7), thrust washer (11), planetary gear (8), and bearing assembly (9) from the carrier assembly.
 8. Repeat Step 4 through Step 7 to remove the other two planetary gears from the carrier assembly.
-

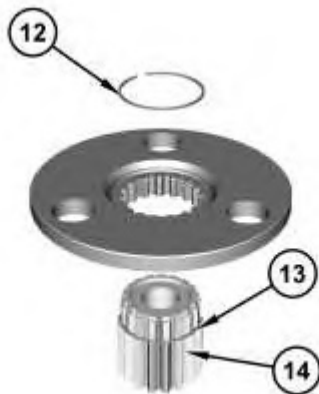


Illustration 4

g03879903

9. Remove retaining ring (12) and sun gear (14) from the carrier.
 10. Remove retaining ring (13) from sun gear (14).
-

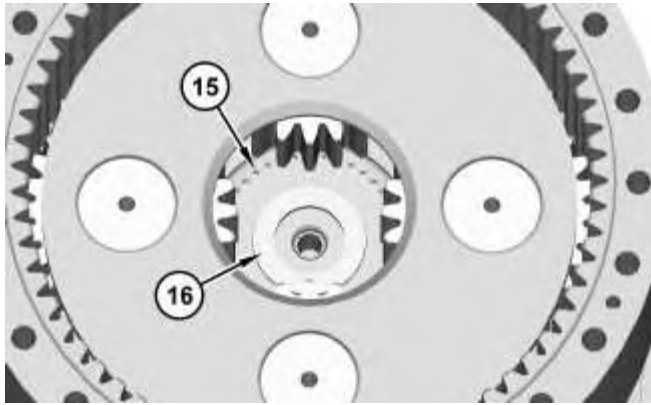


Illustration 5

g02115915



Illustration 6

g03879905

11. Remove spacer (16).
12. Remove retaining ring (15) that holds carrier assembly (17) in position.
13. Use a suitable piece of steel bar stock between the planetary gears in carrier assembly (17). Make sure that the steel bar stock is centered in carrier assembly (17). Attach a suitable lifting device to the steel bar stock. Slowly lift carrier assembly (17) from the swing drive housing. The weight of carrier assembly (17) is approximately 70 kg (154 lb).

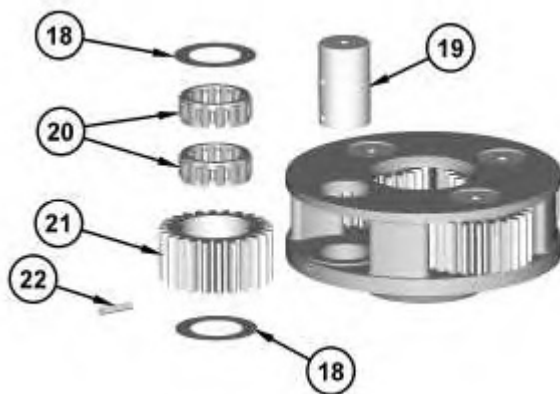


Illustration 7

g03879907

14. Drive spring pin (22) into planetary shaft (19) with a suitable hammer and a suitable punch.
15. Remove planetary shaft (19), thrust washers (18), planetary gear (21), and bearing assemblies (20) from the carrier assembly.
16. Remove spring pin (22) from planetary shaft (19) with a suitable hammer and a suitable punch.
17. Repeat Step 14 through Step 16 to remove the other three planetary gears from the carrier assembly.

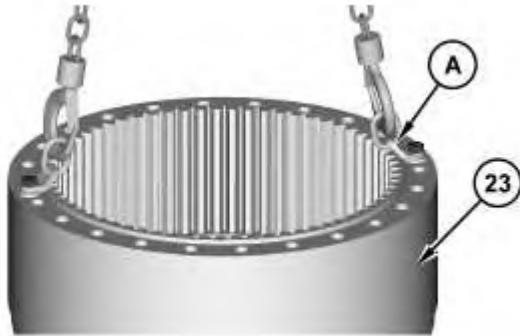


Illustration 8

g03879916



Illustration 9

g03879914

18. Attach Tooling (A) and a suitable lifting device to ring gear (23). The weight of ring gear (23) is approximately 60 kg (132 lb).
 19. Remove bolts (24) and ring gear (23).
-



Illustration 10

g02116593

20. Remove retaining ring (25).



Illustration 11

g03409949

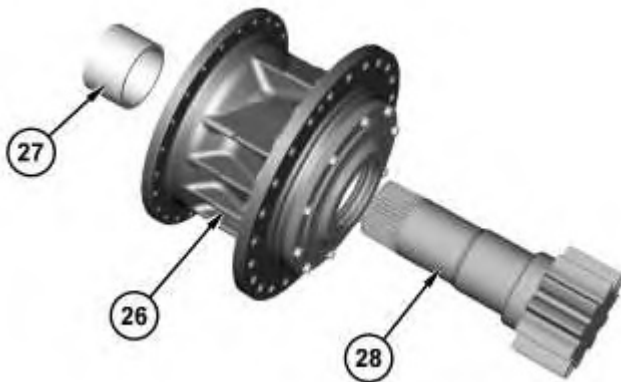


Illustration 12

g03879933

21. Attach Tooling (A) and a suitable lifting device to swing drive housing (26). Position swing drive housing (26) in a suitable press. The combined weight of swing drive housing (26), the pinion shaft, and the bearing cage is approximately 292 kg (644 lb).
22. Position suitable cribbing directly under the pinion shaft to prevent the pinion shaft from falling when pressed out.

23. Remove pinion shaft (28) and spacer (27) from swing drive housing (26).

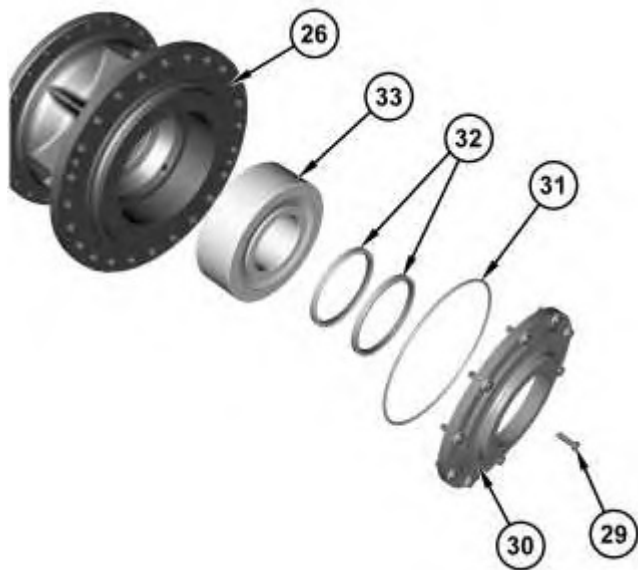


Illustration 13

g03879949

24. Put an alignment mark on cage (30) and swing drive housing (26) for assembly purposes.

25. Remove bolts (29) that secure cage (30) to the swing drive housing. Remove cage (30), O-ring seal (31), and bearing (33).

26. Remove lip seals (32) from cage (30).



Illustration 14

g03410014

27. Remove bearing (34) from swing drive housing (26).

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Disassembly and Assembly 340F Excavator Machine Systems

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Publication Date -01/09/2015

Date Updated -21/12/2016

i03873519

Swing Drive - Assemble

SMCS - 5459-016

S/N - DKF1-UP

S/N - RBC1-UP

S/N - SGH1-UP

S/N - ZBJ1-UP

Assembly Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	138-7573	Link Bracket	2
B	5P-5197	Retaining Ring Pliers As	1
C	5P-3931	Anti-Seize Compound	-
D	5P-0960	Grease Cartridge	-
E	1U-8846	Gasket Sealant	-



Illustration 1

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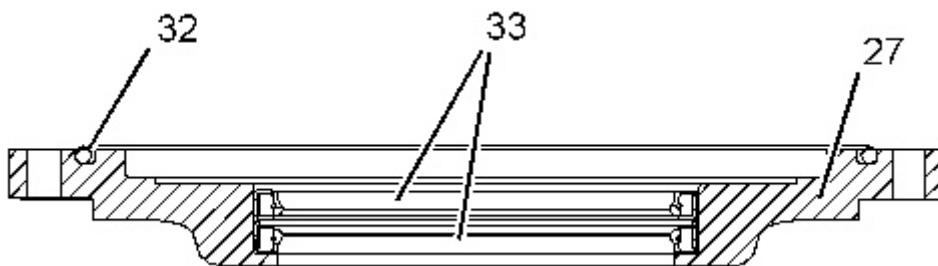


Illustration 2

g02117257

1. Install lip seals (33) in cage (27), as shown. Apply Tooling (D) to the lips of lip seals (33). Install O-ring seal (32).

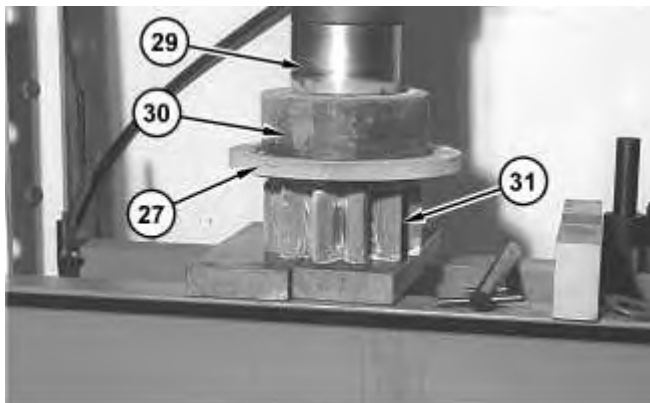


Illustration 3

g02117583

- Note:** Do not damage the lip seals when cage (27) is installed over pinion shaft (31).
2. Apply Tooling (C) to the inside diameter and the outside diameter of bearing (30).
 3. Lower the temperature of pinion shaft (31). Carefully install cage (27) over pinion shaft (31). Use a suitable press in order to install roller bearing (30) on pinion shaft (31). Install spacer (29).
-

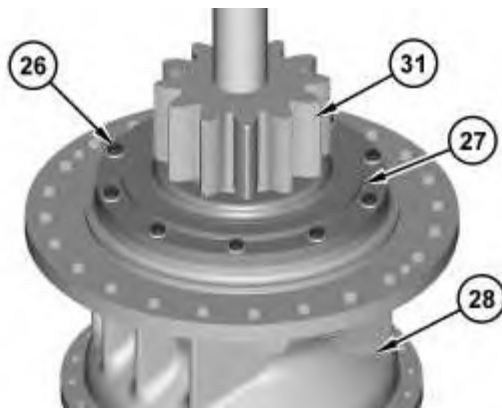


Illustration 4

g02117588

4. Attach Tooling (A) and a suitable lifting device to swing drive housing (28). The weight of swing drive housing (28) is approximately 86 kg (190 lb). Position swing drive housing (28) in a suitable press.
5. Position pinion shaft (31), cage (27), roller bearing (30), and spacer (29) as a unit in swing drive housing (28). Use the suitable press in order to install pinion shaft (31), cage (27), roller bearing (30), and spacer (29) as a unit. Make sure that the alignment marks that were made on cage (27) and on swing drive housing (28) are in alignment.
6. Install bolts (26).

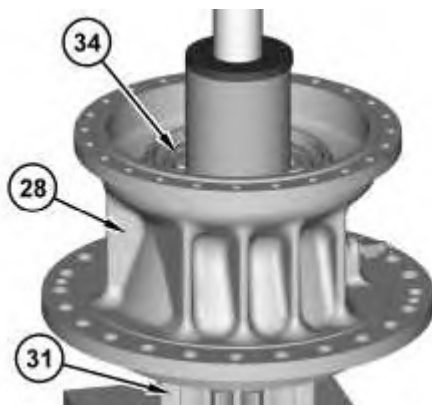


Illustration 5

g02117834

7. Reposition swing drive housing (28) with pinion shaft (31) upside-down. The combined weight of swing drive housing (28), pinion shaft (31), and the cage is approximately 136 kg (300 lb). Position the unit in a suitable press. Support the unit on the end of pinion shaft (31).
8. Apply Tooling (C) to the inside diameter and the outside diameter of roller bearing (34). Use a suitable sleeve and a suitable press in order to install roller bearing (34). Install roller bearing (34).



Illustration 6

g02116593

9. Use Tooling (B) to install retaining ring (25).



Illustration 7

g02115919

10. Attach Tooling (A) and a suitable lifting device to ring gear (24). Apply Tooling (E) to the mating surface of ring gear (24) and the swing drive housing. Install ring gear (24).

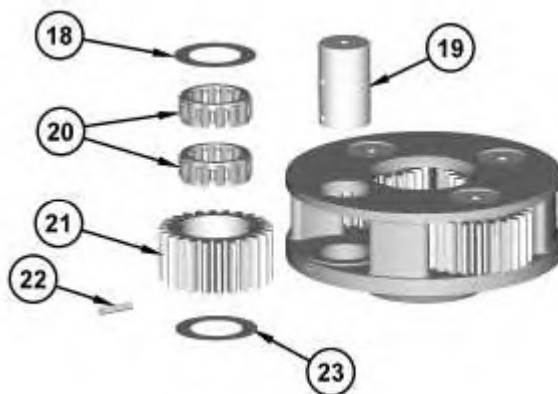


Illustration 8

g02115917

Note: Make sure that the spring pin hole in planetary shaft (19) is aligned with the spring pin hole in the carrier.

11. Install bearing assemblies (20), planetary gear (21), thrust washer (18), thrust washer (23), planetary shaft (19), and spring pin (22) into the carrier. Install spring pin (22) until spring pin (22) is even with the outside surface of the carrier. Align the split in spring pin (22) to the top or the bottom.

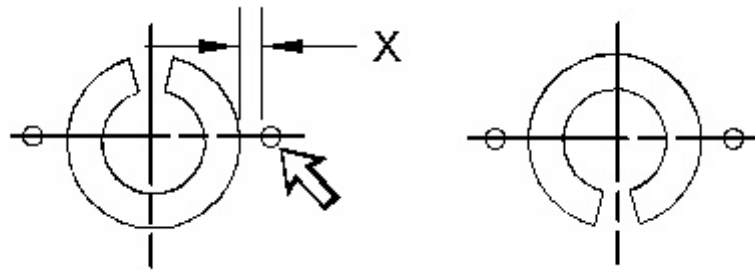


Illustration 9

g02117533

12. Make a stake mark on each side of the spring pin hole in the carrier, as shown. This will prevent the spring pin from falling out of the spring pin hole. Make a stake mark at Dimension (X). Dimension (X) is 1.5 mm (0.06 inch).
13. Repeat Step 11 through Step 12 in order to install the other three planetary gears in the carrier assembly.



Illustration 10

g02115916

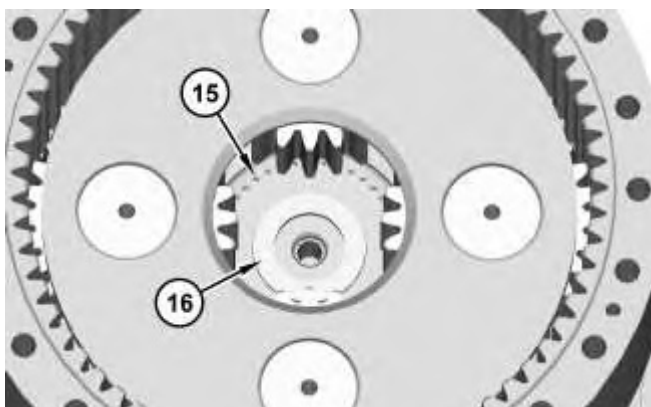


Illustration 11

g02115915

14. Use a suitable piece of steel bar stock between the planetary gears in carrier assembly (17). Make sure that the steel bar stock is centered in carrier assembly (17). Attach a suitable lifting device to the suitable steel bar stock. The weight of carrier assembly (17) is approximately 39 kg (86 lb). Carefully, lower carrier assembly (17) into position in the ring gear.
15. Install retaining ring (15) that secures carrier assembly (17) in position.
16. Install spacer (16).



Illustration 12

g02115853

17. Install retaining ring (13) in sun gear (14).
18. Position sun gear (14) in the carrier and install retaining ring (12).

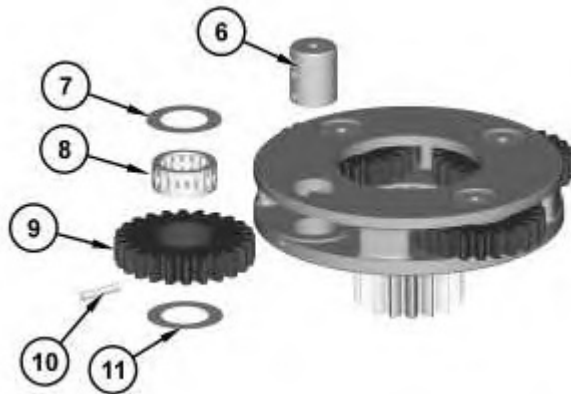


Illustration 13

g02115814

19. Install bearing assembly (8), planetary gear (9), thrust washer (7), thrust washer (11), planetary shaft (6), and spring pin (10) in the carrier. Install spring pin (10) until spring pin (10) is even with the outside surface of the carrier. Align the split in spring pin (10) to the top or the bottom.
-

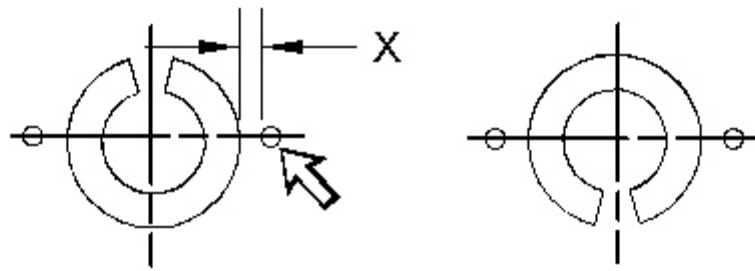


Illustration 14

g02117533

20. Make a stake mark on each side of the spring pin hole in the carrier, as shown. This will prevent the spring pin from falling out of the spring pin hole. Make a stake mark at Dimension (X). Dimension (X) is 1.5 mm (0.06 inch).
21. Repeat Step 19 through Step 20 in order to install the other three planetary gears in the carrier assembly.

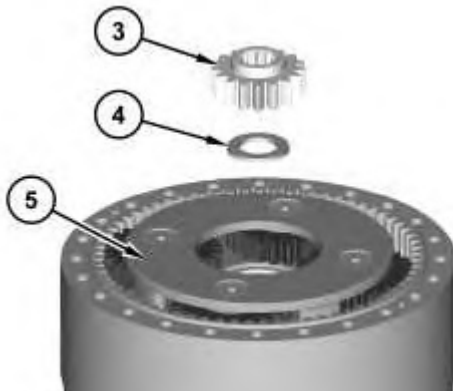


Illustration 15

g02115813

22. Use two people in order to install carrier assembly (5). The weight of carrier assembly (5) is approximately 23 kg (50 lb).
23. Install spacer (4) and sun gear (3).

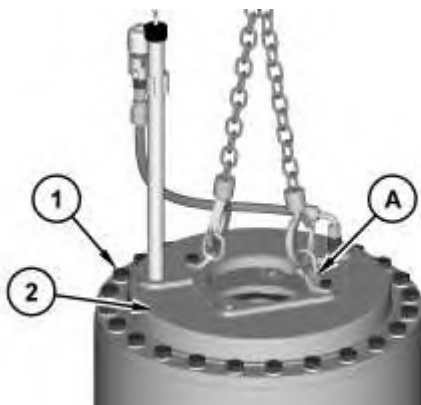


Illustration 16

g02115775

24. Apply Tooling (E) on the mating surfaces of the ring gear and cover (2). Attach Tooling (A) and a suitable lifting device to cover (2). The weight of cover (2) is approximately 23 kg (51 lb). Install cover (2).
25. Install bolts (1). Tighten bolts (1) to a torque of 270 ± 40 N·m (200 ± 30 lb ft).

End By:

- a. Install the swing drive.
-

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Publication Date -01/09/2015

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i06273870

Swing Drive - Assemble

SMCS - 5459-016

S/N - EAR1-UP

S/N - SGH1-UP

S/N - YBF1-UP

Assembly Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	439-3938	Link Bracket	2
B	-	Loctite C5A Copper Anti-Seize	-
C	452-6006	Grease	-
D	-	Loctite 5188	-



Illustration 1

g02116597

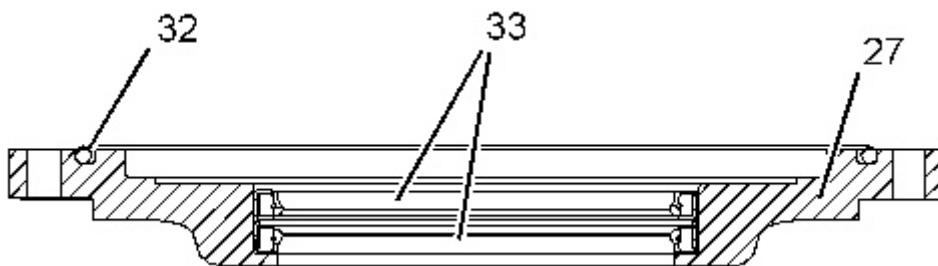


Illustration 2

g02117257

1. Install lip seals (33) in cage (27), as shown. Apply Tooling (C) to the lips of lip seals (33). Install O-ring seal (32).

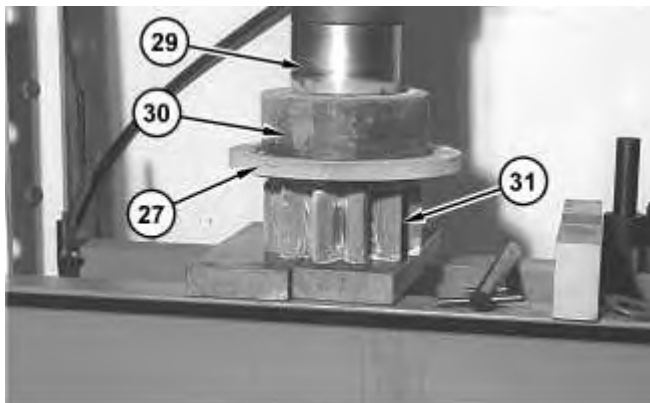


Illustration 3

g02117583

- Note:** Do not damage the lip seals when cage (27) is installed over pinion shaft (31).
2. Apply Tooling (B) to the inside diameter and the outside diameter of bearing (30).
 3. Lower the temperature of pinion shaft (31). Carefully install cage (27) over pinion shaft (31). Use a suitable press to install roller bearing (30) on pinion shaft (31). Install spacer (29).
-

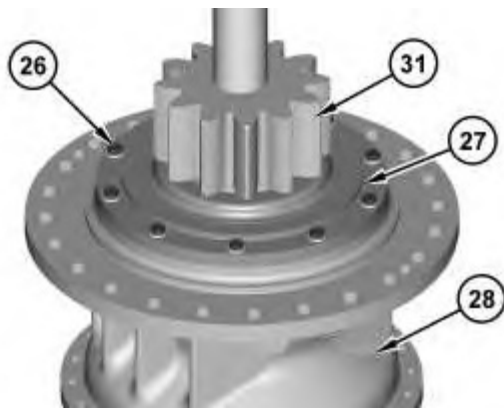


Illustration 4

g02117588

4. Attach Tooling (A) and a suitable lifting device to swing drive housing (28). The weight of swing drive housing (28) is approximately 148 kg (326 lb). Position swing drive housing (28) in a suitable press.
5. Position pinion shaft (31), cage (27), roller bearing (30), and spacer (29) as a unit in swing drive housing (28). Use the suitable press to install pinion shaft (31), cage (27), roller bearing (30), and spacer (29) as a unit. Make sure that the alignment marks that were made on cage (27) and swing drive housing (28) during the disassembly.
6. Install bolts (26).

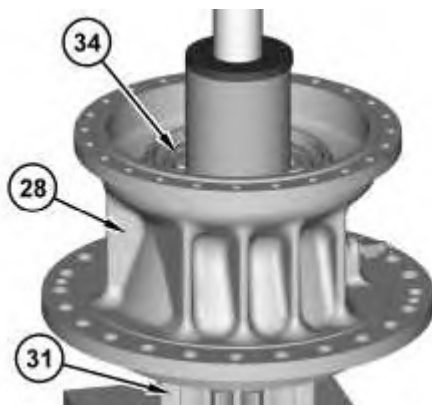


Illustration 5

g02117834

7. Reposition swing drive housing (28) with pinion shaft (31) upside-down. The combined weight of swing drive housing (28), pinion shaft (31), and the cage is approximately 292 kg (644 lb). Position the unit in a suitable press. Support the unit on the end of pinion shaft (31).
 8. Apply Tooling (B) to the inside diameter and the outside diameter of roller bearing (34). Use a suitable sleeve and a suitable press to install roller bearing (34). Install roller bearing (34).
-



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