

Product: WHEELED EXCAVATOR

Model: M322D MH WHEELED EXCAVATOR W2T

Configuration: M322D Material Handler W2T00001-UP (MACHINE) POWERED BY C6.6 Engine

Disassembly and Assembly M322D Excavator Machine Systems

Media Number -KENR6041-01

Publication Date -01/02/2009

Date Updated -19/02/2009

i06564407

Swing Gear and Bearing - Remove

SMCS - 7063-011

Removal Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	138-7574	Link Bracket	3

Start By:

- a. Separate the upper frame from the undercarriage. Refer to Disassembly and Assembly, "Upper Frame and Undercarriage Frame - Separate".



Illustration 1

g01118836

1. Attach Tooling (A) and a suitable lifting device to gear and bearing (1). The weight of gear and bearing (1) is approximately 279 kg (615 lb).

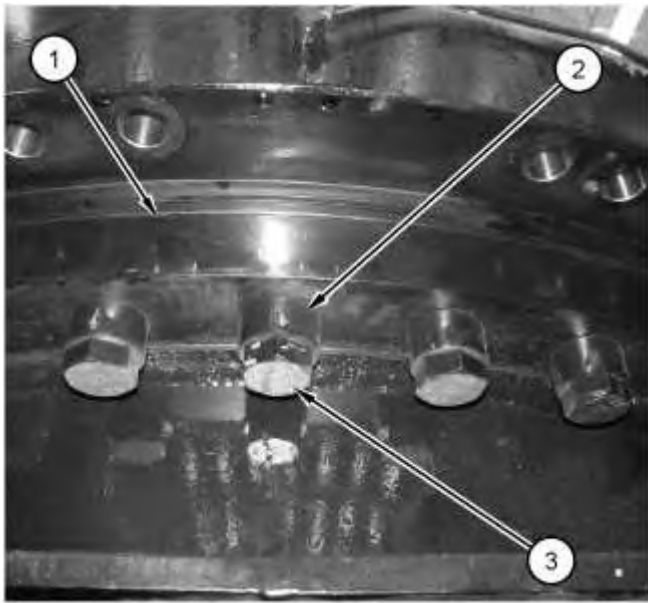


Illustration 2

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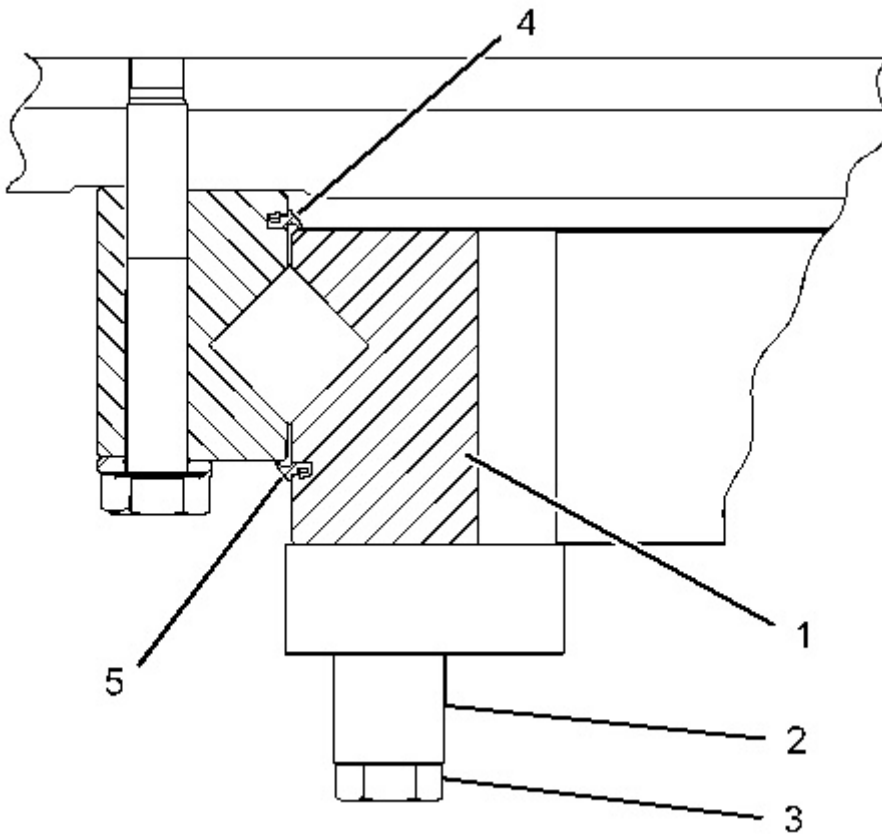


Illustration 3

g01522861

2. Remove bolts (3) and spacers (2). Remove gear and bearing (1) from the machine.
3. Remove inner dust seal (4) and outer dust seal (5).

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i06564466

Swing Gear and Bearing - Install

SMCS - 7063-012

Installation Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	439-3939	Link Bracket	3
B	-	Loctite High Flex GM	-
C	-	LoctiteSuperbond 414	-
D	384-8910	Hydraulic Wrench	1
F	418-4568	Table As	1
G	1U-7234	Feeler Gauge	1

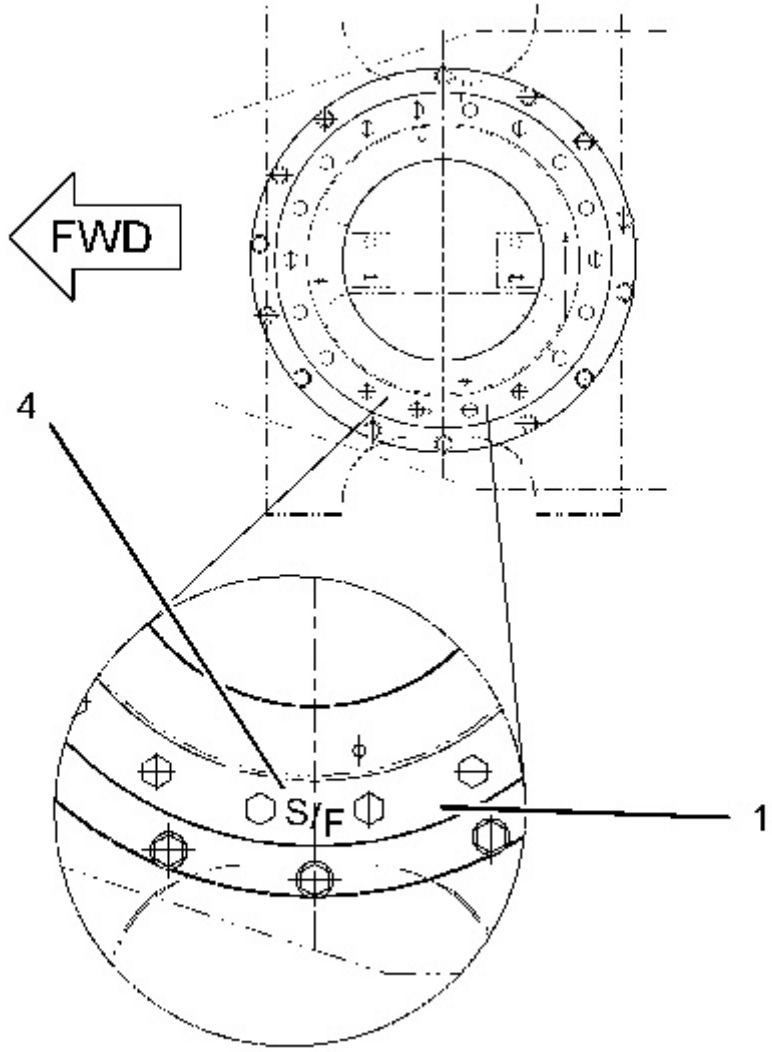


Illustration 1

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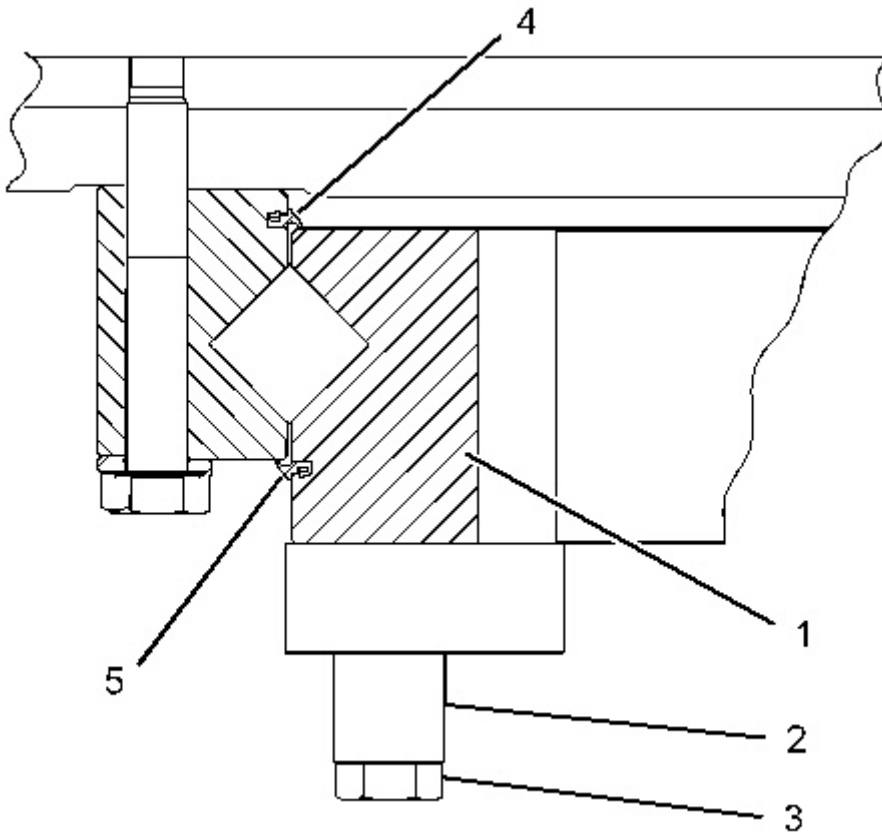


Illustration 2

g01522861

1. Install inner dust seal (4). Use Tooling (C) to fasten the ends of inner dust seal (4). Install outer dust seal (5). Use Tooling (C) to fasten the ends of outer dust seal (5).

Note: Position the "S" or the "F" that is stamped on gear and bearing (1) toward the left side of the frame.

2. Apply Tooling (B) to the top face of gear and bearing (1). Use Tooling (A) and a suitable lifting device to position gear and bearing (1) on to Tooling (F). The weight of gear and bearing (1) is approximately 279 kg (615 lb).



Illustration 3

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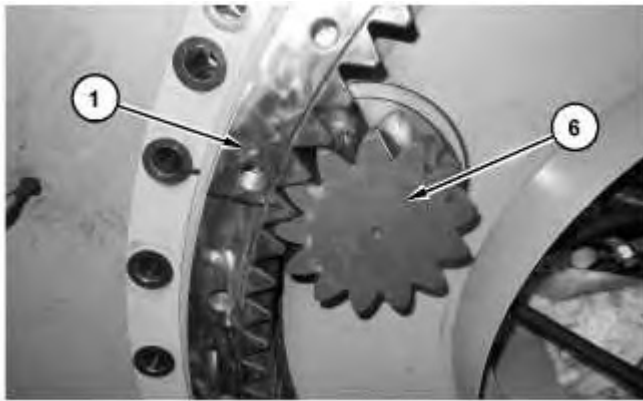


Illustration 4

g06024842

3. Use Tooling (F) to position swing gear and bearing (1) underneath the upper frame.
4. Ensure that the teeth of swing gear and bearing (1) and swing drive gear (6) are meshed evenly.
5. Install bolts (3) hand tight.
6. Remove Tooling (F).

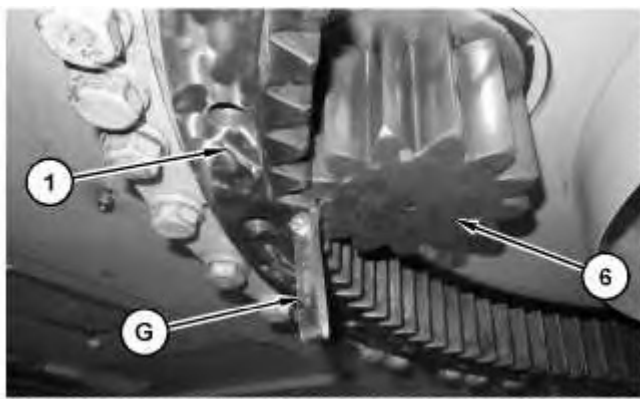


Illustration 5

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7. Use Tooling (G) to measure the clearance between pinion (6) and swing gear (1). The clearance should be between 0.3 mm to 0.7 mm (0.01181 inch to 0.02756 inch).
8. Use Tooling (D) to tighten bolts (3). Refer to table 2 for the correct torque.

Table 2

Torque Table	
M20mm bolts	600 ± 50 N·m (443 ± 37 lb ft)
M24mm bolts	900 ± 100 N·m (664 ± 74 lb ft)

End By:

- a. Connect the upper frame to the undercarriage.

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i02970023

Hydraulic Tank - Remove

SMCS - 5056-011

Removal Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	138-7573	Link Bracket	2

Start By:

- A. Remove the hydraulic oil cooler. Refer to Disassembly and Assembly, "Hydraulic Oil Cooler - Remove".

NOTICE

Care must be taken to ensure that fluids are contained during performance of inspection, maintenance, testing, adjusting and repair of the product. Be prepared to collect the fluid with suitable containers before opening any compartment or disassembling any component containing fluids.

Refer to Special Publication, NENG2500, "Caterpillar Dealer Service Tool Catalog" for tools and supplies suitable to collect and contain fluids on Caterpillar products.

Dispose of all fluids according to local regulations and mandates.

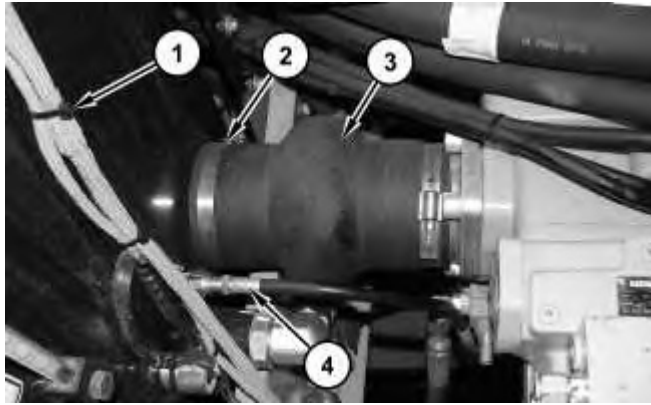


Illustration 1

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1. Remove clips (1). Disconnect hose assembly (4). Loosen clamps (2) and remove hose (3) .

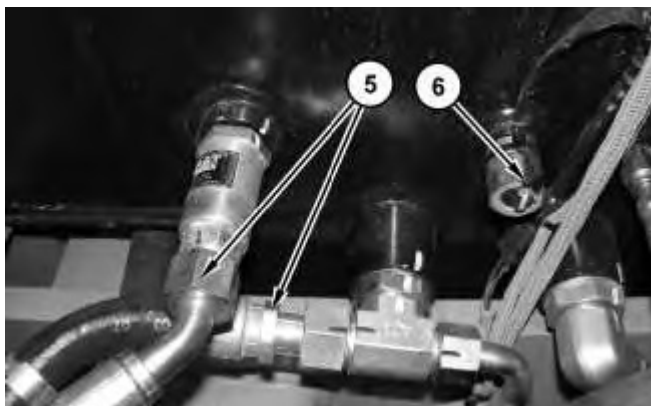
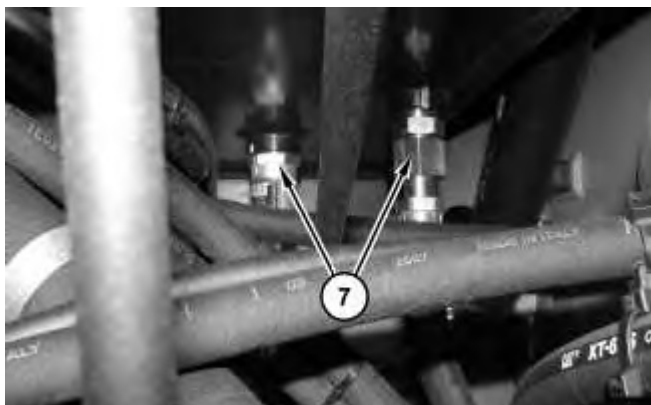


Illustration 2

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2. Disconnect hose assemblies (5) and harness assembly (6) .



3. Disconnect hose assemblies (7) .



Illustration 4

4. Disconnect hose assembly (8) .

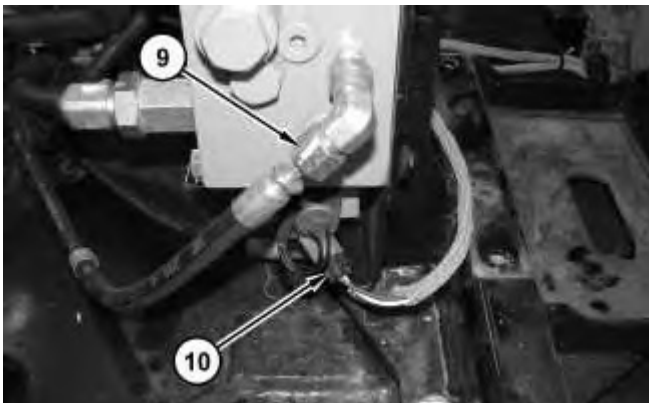


Illustration 5

5. Disconnect hose assembly (9) and harness assembly (10) .
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