

Product: EXCAVATOR

Model: 352F XE VG EXCAVATOR XAJ

Configuration: 352F XE VG Excavator XAJ00001-UP (MACHINE) POWERED BY C13 Engine

Disassembly and Assembly 349F XE and 352F XE Excavators Machine Systems

Media Number -UENR6800-01

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i05331849

Final Drive - Disassemble

SMCS - 4050-015

Disassembly Procedure

Table 1

| Required Tools | | | |
|----------------|-------------|---------------------------|-----|
| Tool | Part Number | Part Description | Qty |
| A | 1P-2420 | Transmission Repair Stand | 1 |
| B | 138-7575 | Link Brackets | 2 |
| C | 4C-8359 | Eyebolt | 3 |
| D | 138-7574 | Link Brackets | 2 |
| E | 154-6182 | Forcing Bolts | 3 |

Start By:

- A. Remove the final drive and travel motor.
 - B. Remove the sprocket.
-

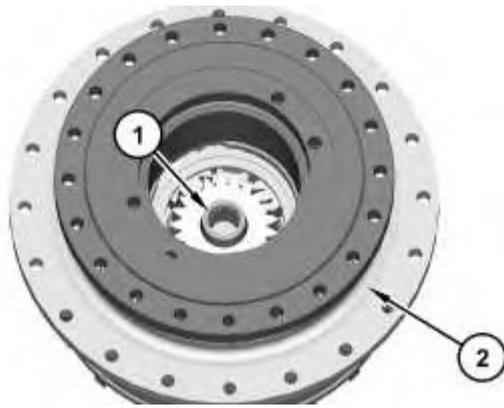


Illustration 1

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1. Remove coupling (1) from final drive (2) .
2. Attach a suitable lifting device to the final drive, and turn final drive (2) over 180 degrees. The weight of final drive (2) is approximately 590 kg (1300 lb).

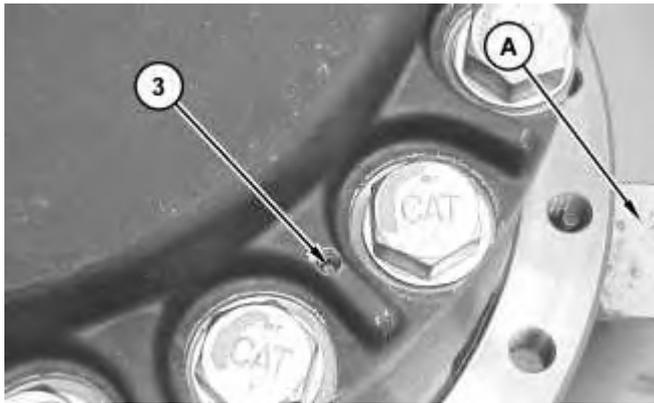


Illustration 2

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3. Attach the final drive to Tooling (A) . Put an alignment mark across the sections of the final drive for assembly purposes. All parts must be reinstalled in the original locations.
 4. Remove setscrews (3) .
-



Illustration 3

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5. Attach Tooling (B) and a suitable lifting device to cover (5) . The weight of cover (5) is approximately 52 kg (115 lb).

Note: Use a soft faced hammer in order to break the seal between cover (5) and the ring gear.

6. Remove bolts (4) , the washers, and cover (5) .

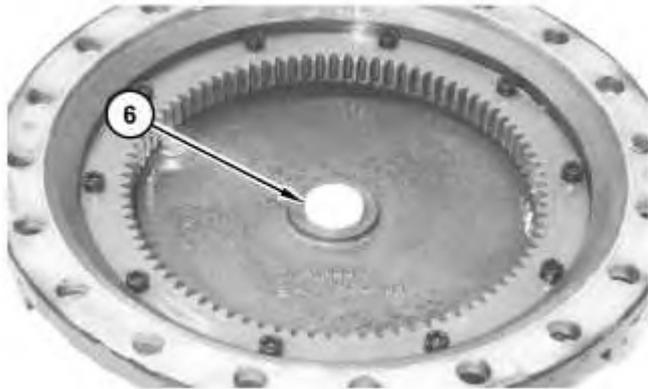


Illustration 4

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7. Remove spacer (6) .



Illustration 5

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8. Remove shims (7) .
9. Remove socket head bolts (8) and ring gear (9) .

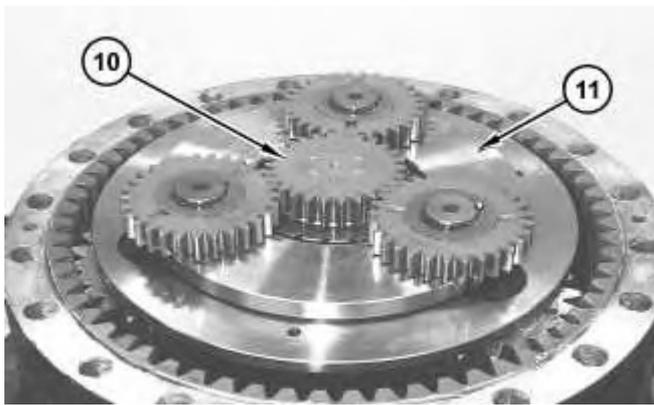


Illustration 6

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10. Remove sun gear (10) .
 11. Remove carrier assembly (11) .
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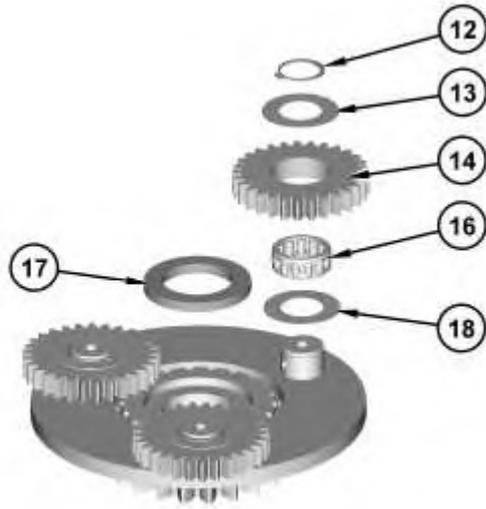


Illustration 7

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12. Remove spacer (17) .
13. Remove retaining ring (12) , thrust washer (13) , planetary gear (14) , bearing (16) , and thrust washer (18) . Repeat for the remaining planetary gears.



Illustration 8

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14. Remove retaining ring (19) and sun gear (20) from the carrier.
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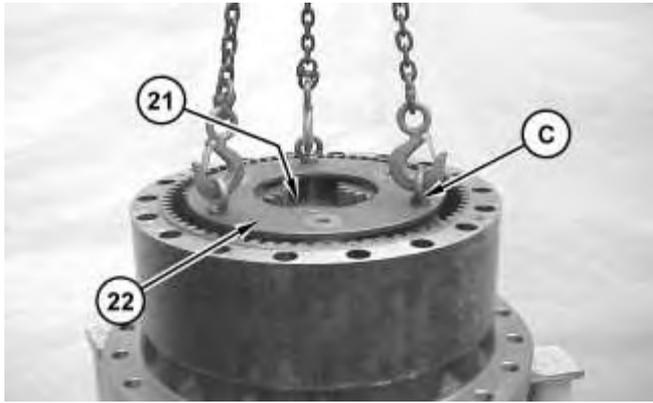


Illustration 9

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15. Remove spacer (21) .
16. Attach Tooling (C) and a suitable lifting device to carrier assembly (19) . The weight of carrier assembly (19) is approximately 45 kg (100 lb). Remove carrier assembly (22) .



Illustration 10

g02431600

17. Use a suitable punch and a suitable hammer to drive spring pin (24) into planetary shaft (23) . Remove planetary shaft (23) , thrust washer (25) , planetary gear (26) , bearing (27) , and thrust washer (28) . Remove spring pin (24) from planetary shaft (23) . Repeat for the remaining planetary gears.



Illustration 11

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18. Remove retaining ring (29) and sun gear (30) from the carrier.

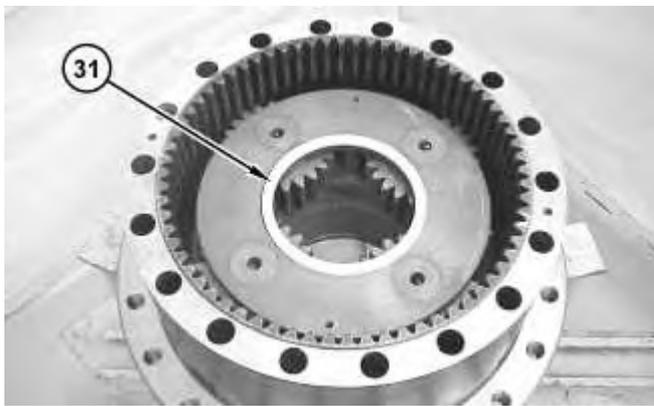


Illustration 12

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19. Remove spacer (31) .

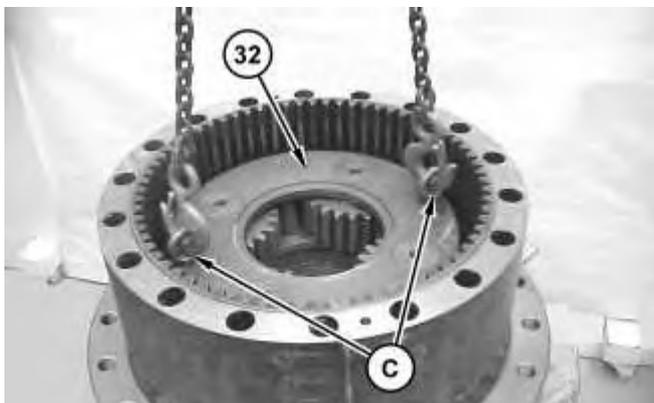


Illustration 13

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20. Attach Tooling (C) and a suitable lifting device to carrier assembly (32) . The weight of carrier assembly (32) is approximately 64 kg (140 lb). Remove carrier assembly (32) .

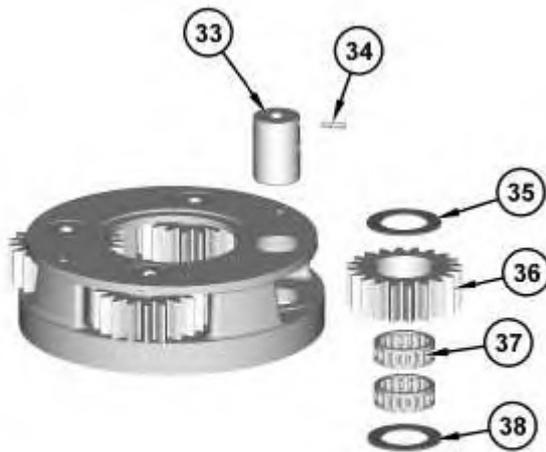


Illustration 14

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21. Use a suitable punch and a suitable hammer to drive spring pin (34) into planetary shaft (33) . Remove planetary shaft (33) , thrust washer (35) , planetary gear (36) , bearings (37) , and thrust washer (38) . Remove spring pin (34) from planetary shaft (33) . Repeat for the remaining planetary gears.



Illustration 15

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22. Attach Tooling (C) and a suitable lifting device to ring gear (39) . The weight of ring gear (39) is approximately 82 kg (180 lb). Remove ring gear (39) from sprocket housing (40) .
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