CATERPILLAR®

Service Repair Manual

Models

345C and 345C L Excavator

Product: EXCAVATOR
Model: 345C EXCAVATOR PJW
Configuration: 345C L Hydraulic Excavator PJW00001-UP (MACHINE) POWERED BY C13 Engine

Disassembly and Assembly
345C Excavator and 345C MHPU
Mobile Hydraulic Power Unit Machine Systems
Media Number -RENR8612-06 **Publication Date -01/02/2013** **Date Updated -21/02/2013**

i05970668

Final Drive - Assemble

SMCS - 4050-016

Assembly Procedure

Table 1

Required Tools			
Tool	**Part Number**	**Part Description**	**Qty**
A	1P-2420	Transmission Repair Stand	1
B	138-7573	Link Bracket	2
C	1P-1860	Retaining Ring Pliers	1
D	4C-8359	Eyebolt	3
E	4C-8359	Eyebolt	2
F	138-7574	Link Bracket	2
G	8T-0531	Duo-Cone Seal Installer As	1
H	4C-5599	Anti-Seize Compound	1
J	9S-3263	Thread Lock Compound	1
K	1U-8846	Gasket Sealant	1
L	6V-7059	Micrometer	1
M	1U-9895	Crossblock	1

1. Make sure that all parts of the final drive are thoroughly clean and free of dirt and debris prior to assembly. Check the condition of all O-ring seals that are used in the final drive. If

any of the seals are damaged, use new parts for replacement. Reassemble the final drive on Tooling (A) .

Illustration 1 g01208879

2. Apply Tooling (H) to the surfaces inside sprocket housing (35) that makes contact with the bearing cups. Install a bearing cup that is in each side of the sprocket housing with a press. Make sure that the bearing cups are properly seated.

3. Apply Tooling (H) to the surfaces inside the motor housing that makes contact with bearing cones (42) .

4. Install inner bearing cone (42) on the motor housing.

Illustration 2 g01208625

5. Apply Tooling (F) and a suitable lifting device to sprocket housing (35) , as shown. The weight of sprocket housing (35) is approximately 127 kg (280 lb). Install sprocket housing (35) on the motor housing. Carefully install outer bearing cone (42) on the sprocket housing.

Illustration 3 g01208578

6. Adjust the bearing preload of the final drive. Determine the correct number of shims (40) that are required for the proper bearing preload, as follows:

Illustration 4 g01208987

   a. Use a depth micrometer in order to measure the step height of coupling gear (38) at several locations around the gear. Find the average for the measured dimensions around the gear and record the dimension. Call this Dimension (X) .

   b. Apply a load of 10000 kg (22000 lb)to bearing cones (42) .

   c. Rotate sprocket housing (35) several times in order to seat the bearing cones.

   d. Reduce the load to 3500 ± 350 kg (7700 ± 770 lb).

Illustration 5 g00631001

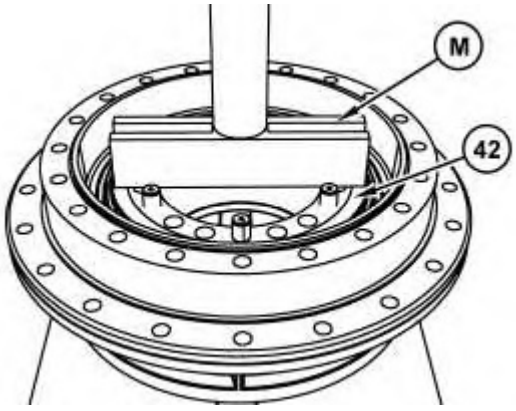

Illustration 6 g03742848

e. While the load is still on the bearing cones, measure the distance between the top face of the motor housing and the top face of bearing cone (42) . Take measurements in several locations around the motor housing. Find the average of the measured dimensions, and record the dimensions. Call this Dimension (Y) .

f. Determine the correct thickness of shims (40) which are used between bearing cone (42) and coupling gear (38) . Use the following equation in order to determine the shim pack thickness.

   Shim pack thickness ... (X) − (Y) ± 0.05 mm (0.002 inch)

   Note: If shims (40) are required, install the thinnest shim next to coupling gear (38) during final assembly.

Illustration 7 g01208625

7. Apply Tooling (F) and a suitable lifting device to sprocket housing (35) , as shown. Separate sprocket housing (35) from the motor housing.

   ReferenceRefer to Disassembly and Assembly, "Duo-Cone Conventional Seals - Install".

   Note: The rubber seals and all surfaces that makes contact with the seals must be clean and dry. After installation of the seals, put clean SAE 30 oil on the contact surfaces of the metal seals.

Illustration 8 g00631006

Illustration 9 g01208999

8. Install Duo-Cone seal kit (43) in the sprocket housing with Tooling (G) .

Illustration 10 g00631014

Illustration 11 g01208626

Illustration 12 g01208625

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