



Service Repair Manual

Models

311B EXCAVATOR

Product: EXCAVATOR

Model: 311B EXCAVATOR 9MR

Configuration: 311B TRACK-TYPE EXCAVATOR 9MR00001-UP (MACHINE) POWERED BY 3064 ENGINE

Disassembly and Assembly 311B, 312B & 312B L EXCAVATORS MACHINE SYSTEMS

Media Number -SEN9235-01

Publication Date -01/05/2003

Date Updated -14/06/2016

SEN92350024

Swing Drive

SMCS - 4559-010; 5459-017

Remove & Install Swing Drive

Tools Needed	A
138-7574 Link Bracket	2

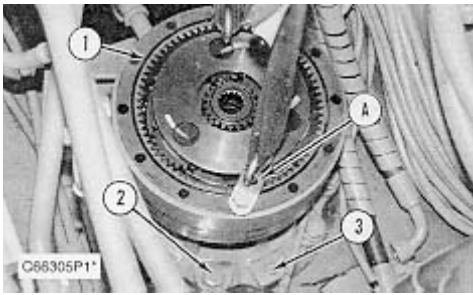
Start By:

- a. remove swing motor

Fluid Spillage Containment

Care must be taken to ensure that the fluids are contained during performance of the inspection, the maintenance, the testing, the adjusting and the repair of the machine. Be prepared to collect the fluid with suitable containers before opening any compartment or disassembling of the any components containing fluids. Refer to the "Tools And Shop Products Guide", NENG2500 for the tools and the supplies suitable to collect and contain any of the fluids in Caterpillar machines. Dispose of the fluids according to local regulations and mandates.

1. Thoroughly clean around the mounting area of the swing drive prior to removal.
2. Drain the oil from the swing drive into a suitable container. The capacity of the swing drive is **2.8 liters (.7 U.S. gal)**.



3. Remove 12 bolts (2) and the washers that hold swing drive (1) in position.
4. Fasten Tooling (A) and a hoist to the swing drive as shown.
5. Remove swing drive (1) from the machine. The weight of the swing drive is **98 kg (215 lb)**.

NOTE: The following steps are for the installation of the swing drive.

6. Thoroughly clean the mating surface of the main frame and swing drive housing.
7. Put **5P-3931 Anti-Seize Compound** on location pin (3) in the main frame.
8. Put **1U-8846 Gasket Maker** on the mating surface of the main frame and swing drive housing.

NOTE: During the installation, the locating pin for the swing drive may come out of the swing drive housing.

9. Fasten Tooling (A) and a hoist to swing drive (1). Put the swing drive in its original position on the main frame. If locating pin (3) comes out of the swing drive housing, it can be reinstalled with a hammer after the swing drive is in place.
10. Put **9S-3263 Thread Lock** on the threads of 12 bolts (2). Install the 12 bolts and the washers that hold the swing drive in place.

NOTE: Refer to the topic "Lubricant Viscosities and Refill Capacities" in the "Operation & Maintenance Manual" for the proper filling procedure and the proper levels for the hydraulic oil system and swing drive.

11. After the installation of the swing motor, fill the hydraulic oil tank and the swing drive with oil to the correct levels.

End By:

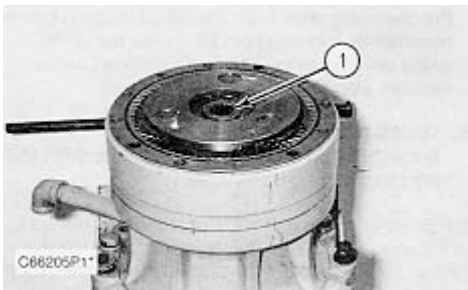
- a. install swing motor

Disassemble & Assemble Swing Drive

Tools Needed		A	B	C
1P-2420	Transmission Repair Stand	1		
138-7573	Link Bracket		2	
1P-0515	Plate			1

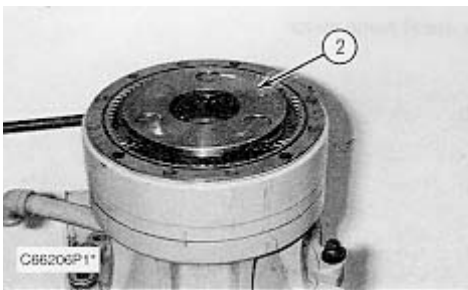
Start By:

a. remove swing drive

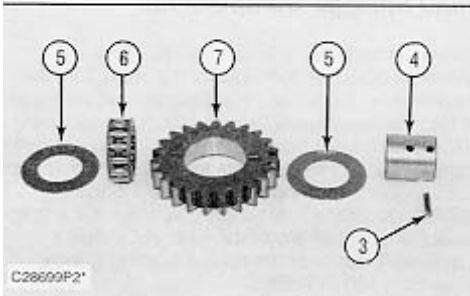
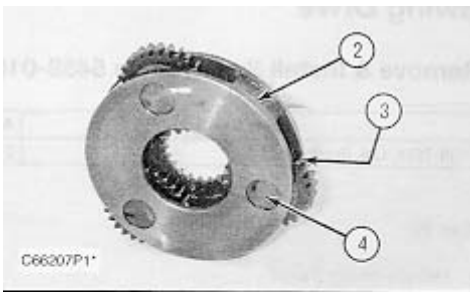


1. Install the swing drive on a suitable stand.

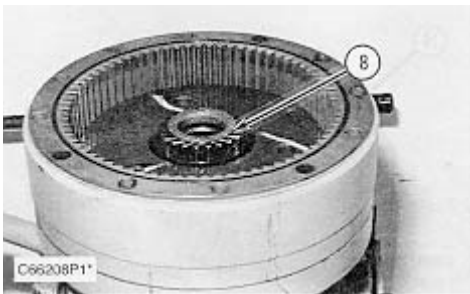
2. Remove sun gear (1) from the swing drive.



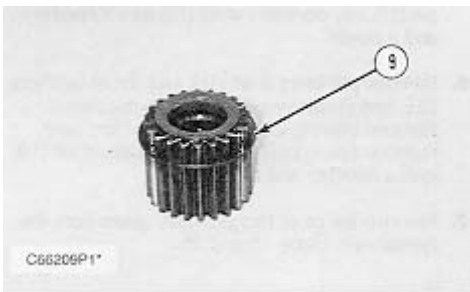
3. Remove carrier assembly (2) from the ring gear.



4. Disassemble carrier assembly (2). Drive spring pin (3) into planetary shaft (4) with a hammer and a punch.
5. Remove planetary shaft (4), two thrust washers (5), and planetary gear (7) from the carrier. Remove bearing (6) from the planetary gear. Remove spring pin (3) from planetary shaft (4) with a hammer and a punch.
6. Remove the other two planetary gears from the carrier as in Steps 4 and 5.



7. Remove sun gear (8) from the carrier.



8. Remove snap ring (9) from sun gear (8).

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