

Disassembly and Assembly

924H, 924HZ, 928HZ and 930H Wheel Loaders Power Train
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i05264316

Axle Housing - Assemble

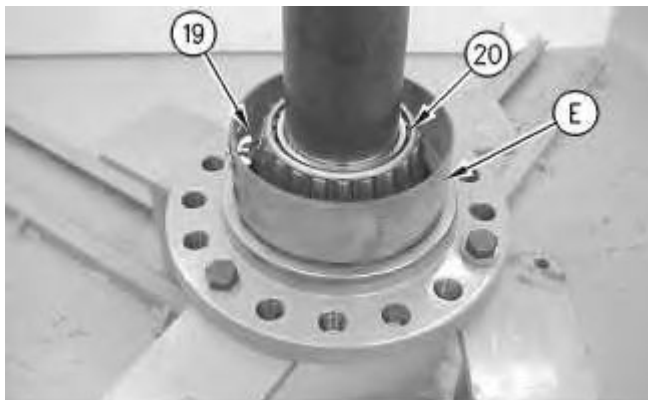
SMCS - 3260-016-FR; 3260-016-RE

Assembly Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	1P-2420	Transmission Repair Stand	1
B	6V-2156	Link Bracket	3
C	4c-8502	Spanner Wrench As	1
D	1H-3107	Puller Group	1
G	1U-8697	Duo-Cone Seal Installer As	1
H	1U-8846	Gasket Sealant	

Note: Cleanliness is an important factor. Before assembly, thoroughly clean all parts in cleaning fluid. Allow the parts to air dry. Wiping cloths or rags should not be used to dry parts. Lint may be deposited on the parts which may cause later trouble. Inspect all parts. If any parts are worn or damaged, use new parts for replacement.



1. Use Tooling (G) in order to install seal (19). Refer to Disassembly and Assembly, "Duo-Cone Conventional Seals - Install" for the proper procedure.

Note: Lubricate the bearing with the lubricant that is being used.

2. Raise the temperature of bearing cone (20).
3. Install bearing cone (20).

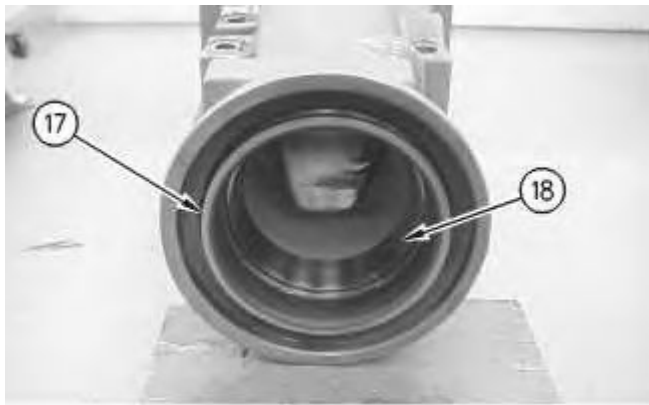


Illustration 2

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4. Lower the temperature of bearing cup (18).
5. Install bearing cup (18). Use Tooling (G) in order to install seal (17). Refer to Disassembly and Assembly, "Duo-Cone Conventional Seals - Install" for the proper procedure.



Illustration 3

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6. Lower the temperature of bearing cup (15).
 7. Install bearing cup (15).
 8. Lower the temperature of ring gear (16) and install ring gear (16). Install pins (14) and peen the housing in order to retain pins (14).
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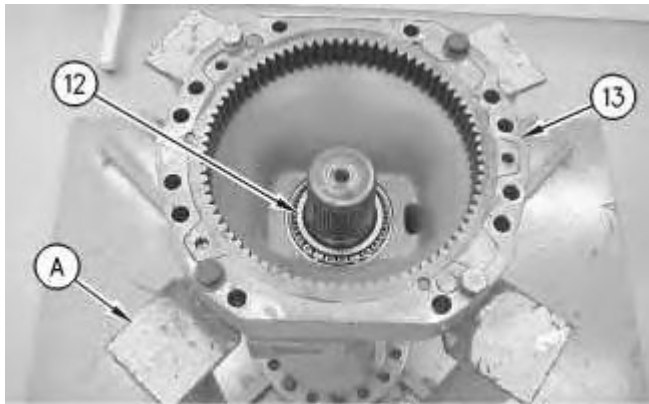


Illustration 4

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9. Use a suitable lifting device and Tooling (B) in order to install axle housing (13) onto the axle shaft. The weight of axle housing (13) is approximately 88 kg (195 lb). Use Tooling (A) in order to support axle housing (13).
10. Raise the temperature of bearing cone (12).
11. Install bearing cone (12).
12. Lubricate bearing cone (12) with the lubricant that is being sealed.

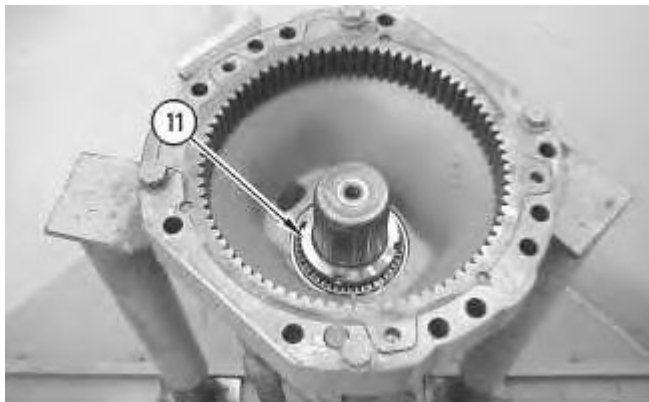


Illustration 5

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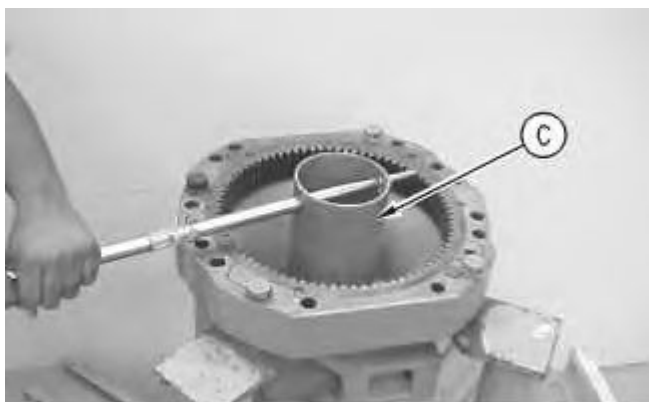


Illustration 6

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Note: Lubricate nut (11) with the lubricant that is being sealed.

13. Install nut (11). Use Tooling (C) in order to tighten nut (11). Leave slight bearing end play.



Illustration 7

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14. Use Tooling (A) in order to support the axle shaft. Install Tooling (D), as shown. Install a bolt in the center of Tooling (D). Use a torque wrench in order to rotate the axle housing and check the rolling torque (SD). This is the amount of seal drag.
15. Use Tooling (C) in order to tighten nut (11). Check the rolling torque (RT). This is the total rolling torque. Subtract the seal drag torque (SD) from the total rolling torque (RT). This is the rolling torque of the axle bearings. Tighten nut (11) until a rolling torque of the axle bearings is 4 N·m to 9 N·m (35 lb in to 80 lb in). The rolling torque for used axle bearings should be 2 N·m to 4.5 N·m (18 lb in to 40 lb in).

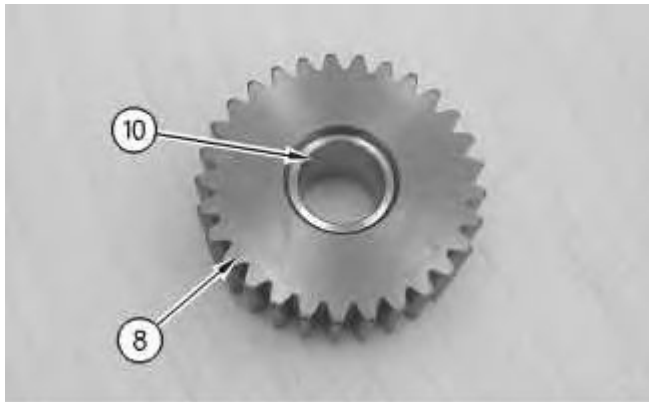


Illustration 8

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16. Install bearing (10) in gear (8).

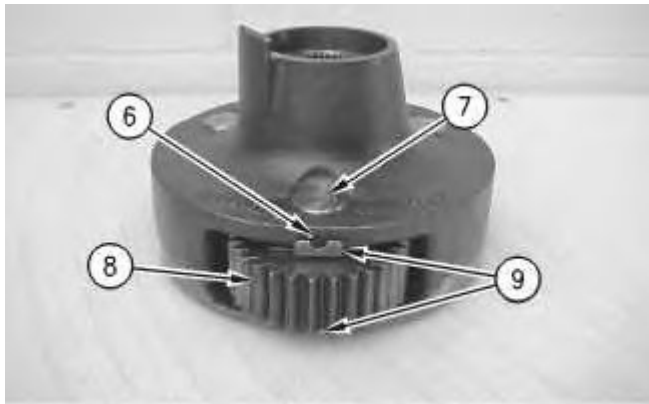


Illustration 9

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17. Install gear (8) and washers (9).

18. Install shaft (7).

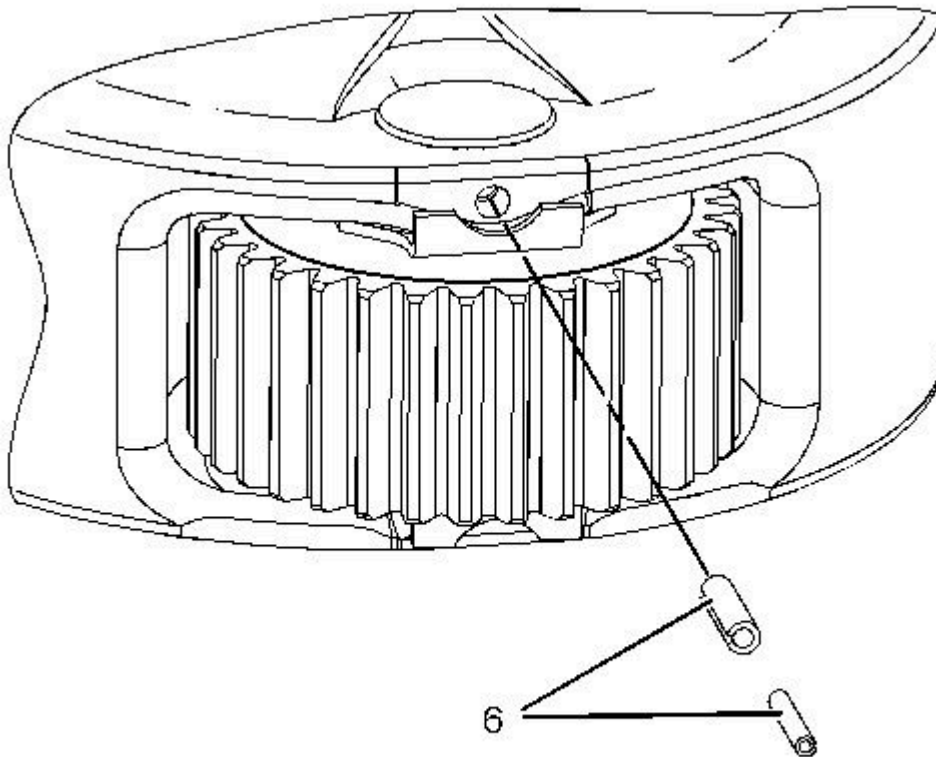


Illustration 10

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Note: The openings of pins (6) must be 180 degrees away from each other. The openings of pins (6) must be parallel to the carrier deck. Refer to illustration 10.

19. Install pins (6).

20. Deform pin holes slightly with a chisel.

21. Repeat Steps 16 through 19 for the remaining gear assemblies.

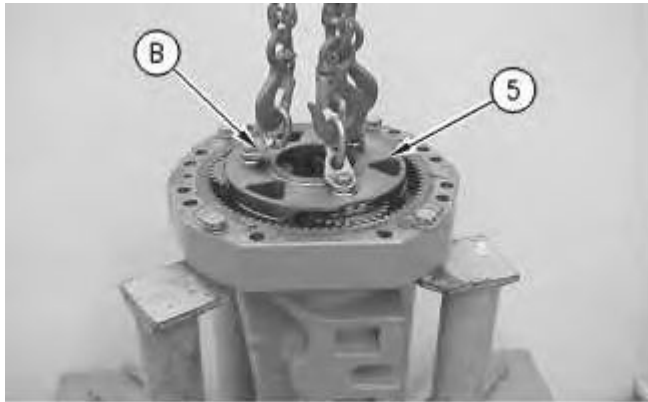


Illustration 11

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22. Use Tooling (B) and a suitable lifting device in order to install carrier assembly (5). The weight of carrier assembly (5) is approximately 28 kg (62 lb).

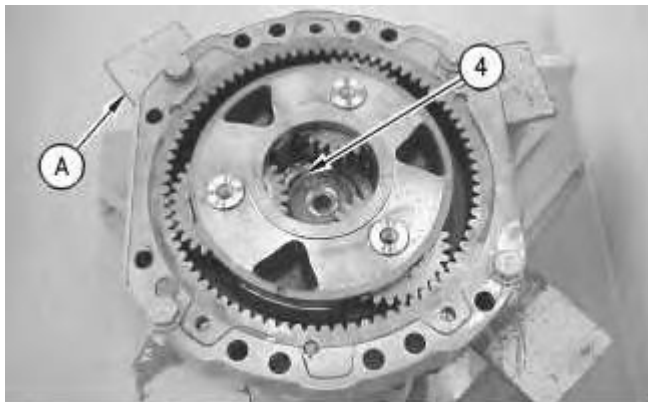


Illustration 12

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23. Install retaining ring (4).

24. Use a suitable lifting device in order to remove the axle housing from Tooling (A). The weight of the axle housing is approximately 147 kg (325 lb).



25. Clean the mating surfaces of the axle housing and apply a continuous bead of Tooling (H).

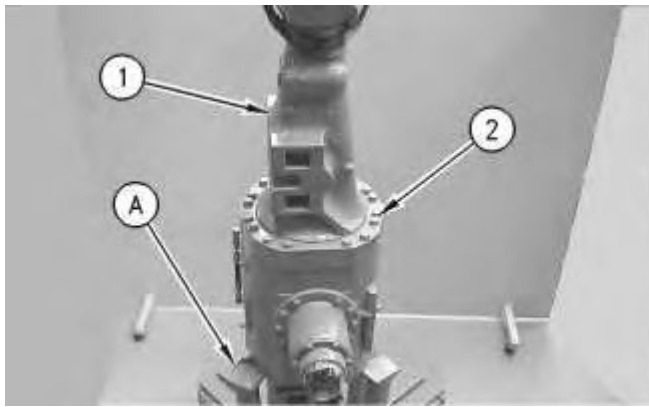


Illustration 14

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26. Use a suitable lifting device in order to install axle housing (1). The weight of axle housing assembly (1) is approximately 147 kg (325 lb). Install bolts (2).

27. Fill the axle housing with oil. Refer to Operation and Maintenance Manual, "Lubrication Viscosities and Refill Capacities".

End By:

- a. Install the axle trunnion (front and rear) on the oscillating axle housing. Refer to Disassembly and Assembly, "Axle Trunnion (Front and Rear) - Remove and Install".
 - b. Install the fixed axle housing. Refer to Disassembly and Assembly, "Fixed Axle Housing - Install".
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