



# Service Repair Manual

## **Models**

323D2 L Excavator

---

Product: EXCAVATOR

Model: 323D2 L EXCAVATOR XBK

Configuration: 323D2 L Excavators XBK00001-UP (MACHINE) POWERED BY C7.1 Engine

## **Disassembly and Assembly 323D2 Excavator Machine Systems**

Media Number -UENR3338-02

Publication Date -01/07/2017

Date Updated -19/07/2017

i01219550

# **Travel Motor - Disassemble**

SMCS - 4351-015

## **Disassembly Procedure**

### **Start By:**

- a. Remove the travel motor.

**Reference:** Refer to Disassembly and Assembly, "Travel Motor - Remove" in this manual.

---

### **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.**

---

1. Thoroughly clean the outside of the travel motor prior to disassembly.
2. Fasten the travel motor to a suitable holding fixture in a vertical position. The weight of the travel motor is 60 kg (132 lb).

- Put an alignment mark across the head and the body of the travel motor for assembly purposes. The head must be reinstalled in the head's original position on the body of the travel motor.



Illustration 1

g00510326

**Note:** During the removal of head (2) from the body of the travel motor, be careful not to scratch or damage the mating surfaces of the components.

- Remove socket head bolts (1).
- Remove head (2) from the body of the travel motor.

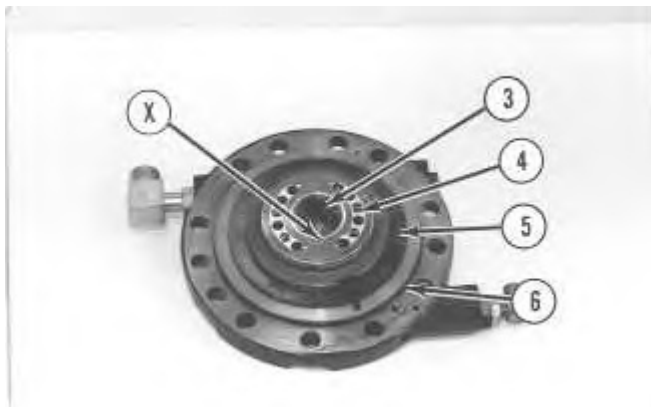


Illustration 2

g00510341



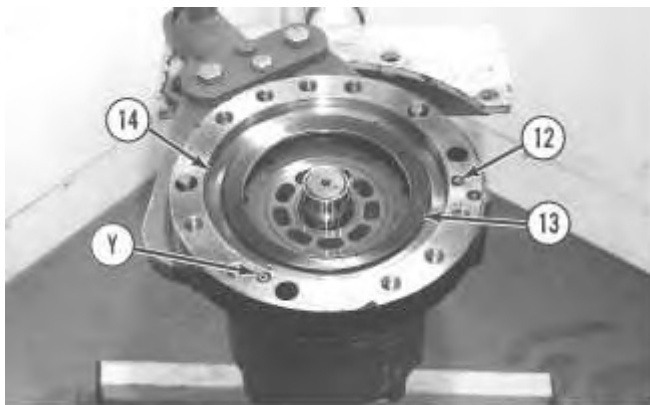
6. Turn over head (2).
7. Remove O-ring seal (6), shims (5), port plate (4), and bearing (3) from the head.
8. Remove the two check valve assemblies from the head.

**Note:** There is a retainer under spring (9). This retainer is a press fit in head (2). Do not remove the retainer.

9. Insert a dowel rod with a small diameter into hole (X). Tap the dowel rod with a plastic hammer in order to remove spring (9), poppet (8) and seat (7) from the head.



10. Remove three fittings (10) and plugs (11) from the head. Remove the O-ring seal from each fitting.



11. Remove three O-ring seals (12) and washer set (13) from the body of the travel motor.
  12. Place a shop towel over brake piston (14). Retain brake piston (14) by hand, and apply approximately 525 kPa (75 psi) of shop air pressure to brake release port (Y). Make sure that the shop air pressure is free of water. Brake piston (14) will move up the piston guide, and out of the piston guide. Remove brake piston (14) from the body of the travel motor.
-

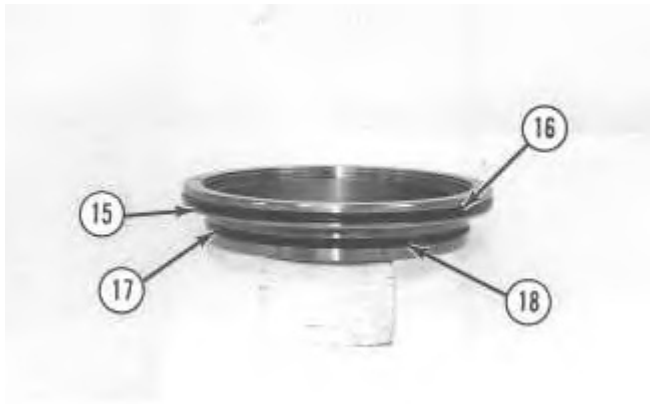


Illustration 6

g00510353

13. Remove O-ring seal (15) from the brake piston. Remove backup ring (16) from the brake piston.
14. Remove O-ring seal (17) from the brake piston. Remove backup ring (18) from the brake piston.



Illustration 7

g00510356

15. Remove piston guide (19), five friction plates (20) and the four steel plates from the body of the travel motor.

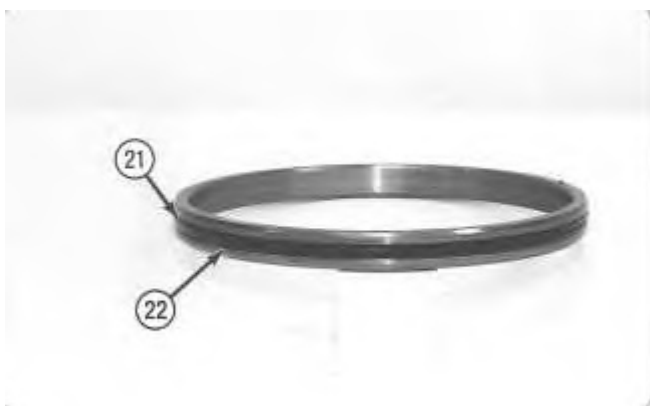


Illustration 8

g00510359

16. Remove O-ring seal (21) from the piston guide. Remove backup ring (22) from the piston guide.

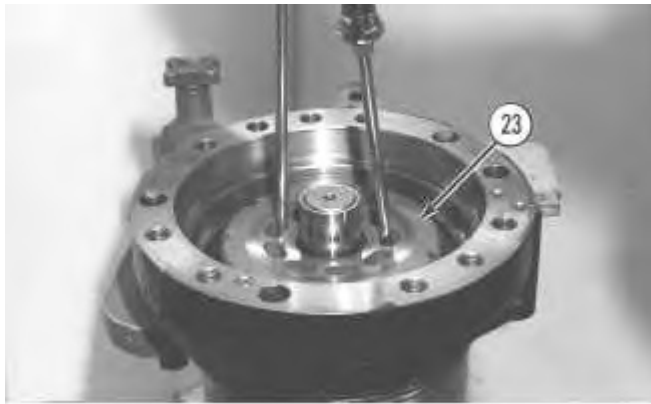


Illustration 9

g00510365

**Note:** Do not allow the components of barrel assembly (23) to come apart during the removal from the travel motor. All of the components in the barrel assembly must be reinstalled in the component's original location.

17. Use two large screwdrivers, as shown. Slowly remove barrel assembly (23) from the body of the travel motor. Do not allow the components to fall apart.



Illustration 10

g00510502

**Note:** Shoe retainer (24) and piston shoe assemblies (25) are not serviced separately. Prior to the removal of the shoe retainer and the piston shoe assemblies from barrel (26), put identification marks on piston shoe assemblies (25) for assembly purposes. Identification marks are used to identify the piston shoe assembly's location in shoe retainer (24) and barrel (26). The piston shoe assemblies must be reinstalled in the piston shoe assembly's original bores in the shoe retainer and the barrel.

18. Remove shoe retainer (24) and piston shoe assemblies (25) from barrel (26). Separate the piston shoe assemblies from the shoe retainer.
-

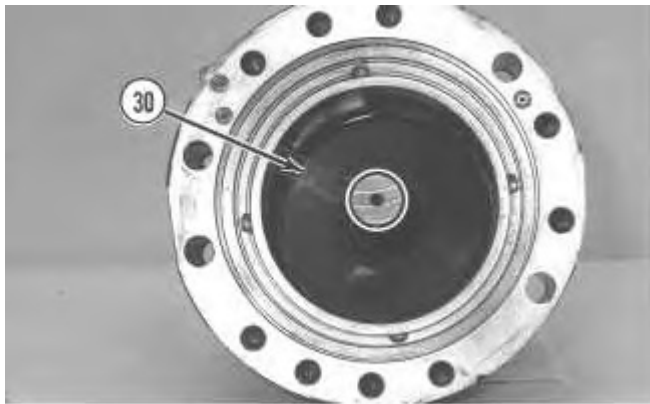


---

Illustration 11

g00510504

19. Remove guide (27), spacer (28) and springs (29) from the barrel.



---

Illustration 12

g00510547

20. Remove cam plate (30) from the body of the travel motor.



---

Illustration 13

g00510550

21. Remove two keys (31) and the two locating pins (not shown) from the body of the travel motor.
-

Thank you so much for reading.  
Please click the “Buy Now!”  
button below to download the  
complete manual.



After you pay.

You can download the most  
perfect and complete manual in  
the world immediately.

Our support email:

[ebooklibonline@outlook.com](mailto:ebooklibonline@outlook.com)