Product: WHEEL LOADER
Model: 972G WHEEL LOADER 4WW
Configuration: 972G Wheel Loader 4WW00001-UP (MACHINE) POWERED BY 3306 Engine

Disassembly and Assembly
966G and 972G Wheel Loaders Power Train
Media Number -RENR2106-08 **Publication Date -01/05/2004** **Date Updated -28/05/2004**

i07399197

Torque Converter (Freewheel Stator) - Assemble

SMCS - 3101-016

Assembly Procedure

Table 1

Required Tools			
Tool	**Part Number**	**Part Description**	**Qty**
A	138-7575	Link Bracket	2
B	1P-0510	Driver Gp	1
C	2P-8312	Retaining Ring Pliers	1
D	7F-6068	Sleeve	1

Note: Cleanliness is an important factor. Before assembly, all parts should be thoroughly cleaned 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.

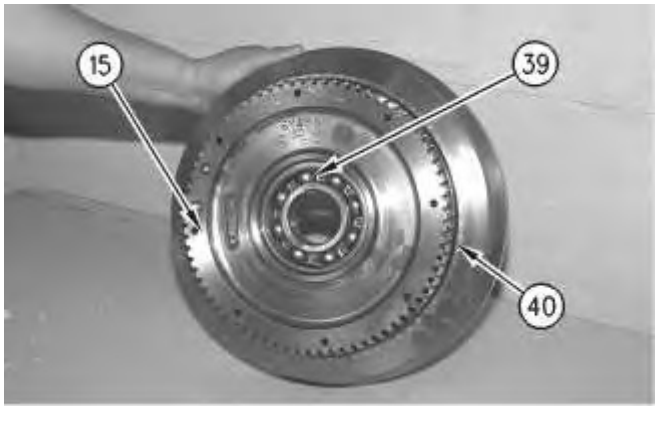


Illustration 1 g00878809

1. Install bearing (39) and ring (40) on rotating housing (15).

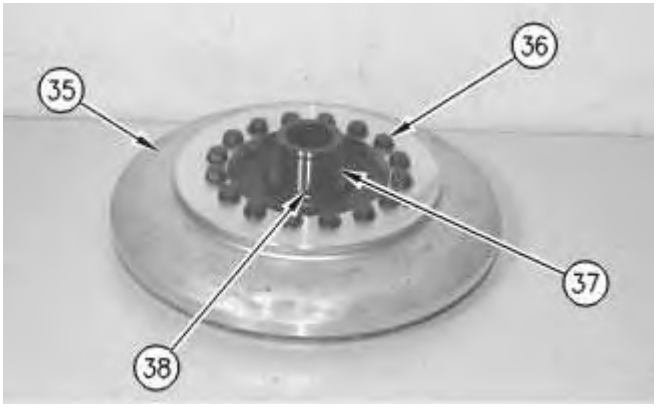


Illustration 2 g00878808

1. Install locating dowel (38) in turbine hub assembly (37).
2. Install turbine hub assembly (37) to turbine (35). Install bolts (36) and the washers. The torque for bolts (36) is 60 ± 7 N·m (44 ± 5 lb ft).

Illustration 3 g00878784

3. Turn rotating housing (15) onto opposite side. Install turbine (35).

Illustration 4 g00878783

4. Install bearing spacer (34).
5. Use Tooling (C) to install retaining ring (33) on turbine hub assembly (37). Retaining ring (33) must be securely seated in the groove.
6. Install O-ring seal (32).

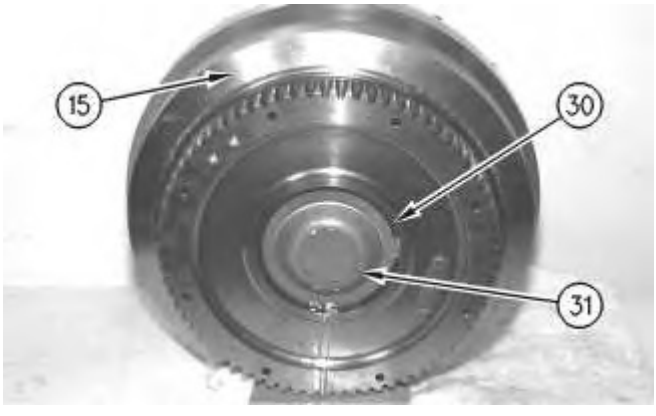


Illustration 5 g00878781

7. Install end cover (31) and retaining ring (30) in rotating housing (15).

Illustration 6 g00878780

8. Lower the temperature of bearing (29).
9. Install bearing (29) in impeller (14).

   Note: The notch in bearing (29) must face downward, as shown.

Illustration 7 g00878778

10. Install drive gear (28) and bolts (27). The torque for bolts (27) is 105 ± 15 N·m (75 ± 11 lb ft).

    Note: If the torque converter is equipped with a freewheel stator, continue with Steps 11 through 16.

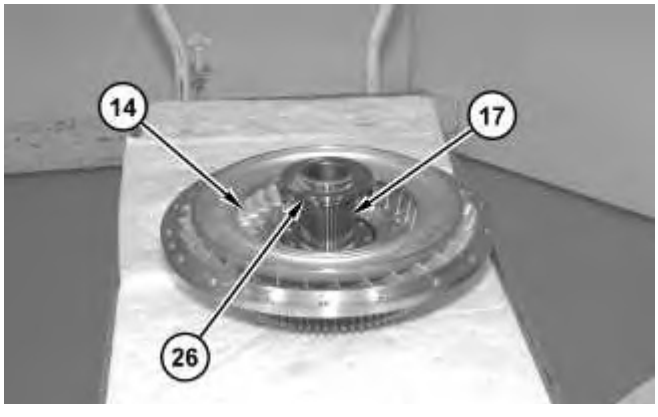


Illustration 8 g01151541

11. Install the seal ring (not shown) onto carrier shaft (17). Use a suitable press to install carrier shaft (17) in impeller (14).
12. Install spacer (26) over shaft (17).

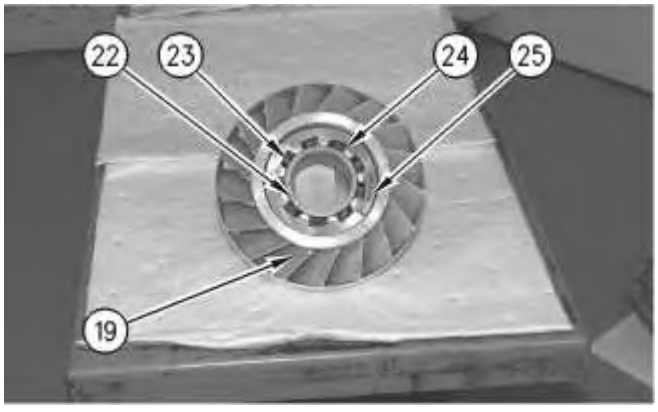


Illustration 9 g00878585

13. Install freewheel cam (25), freewheel springs (24), freewheel rollers (23), and bearing race (22) in stator (19).

    Note: If necessary, raise the temperature of stator (19) to a maximum temperature of 135 °C (275 °F). Install the cam with the IMPELLER SIDE facing downward. Continue with the installation until freewheel cam (25) contacts the retaining ring (not shown).

    Note: Install freewheel springs (24) with the maximum number of loops toward the outside diameter of freewheel cam (25).

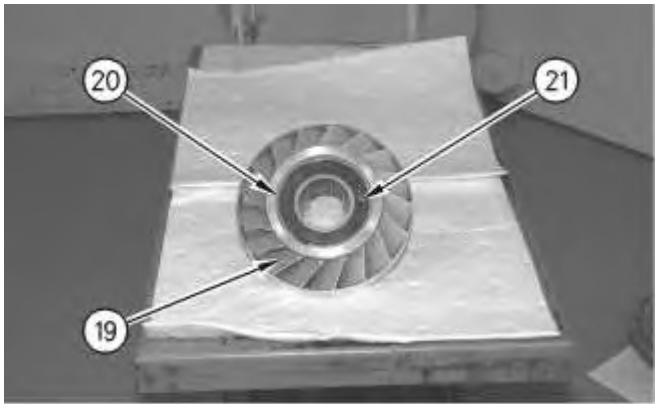


Illustration 10 g00878584

14. Install washer (21) and retaining ring (20) on stator (19). Repeat the procedure for the opposite side of stator (19).

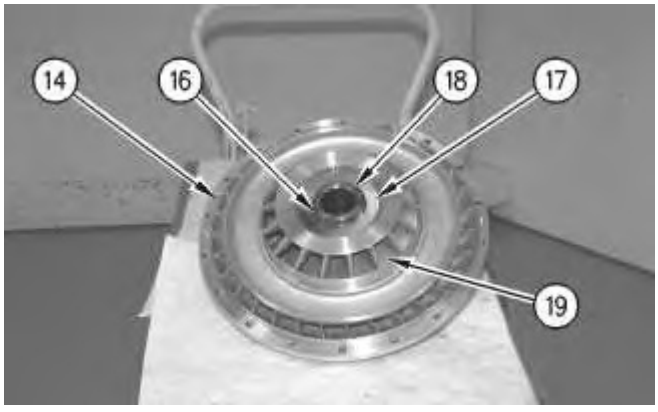


Illustration 11 g00878581

15. Install stator (19) on impeller (14).
16. Install plate (18) and retaining ring (16) on carrier shaft (17).

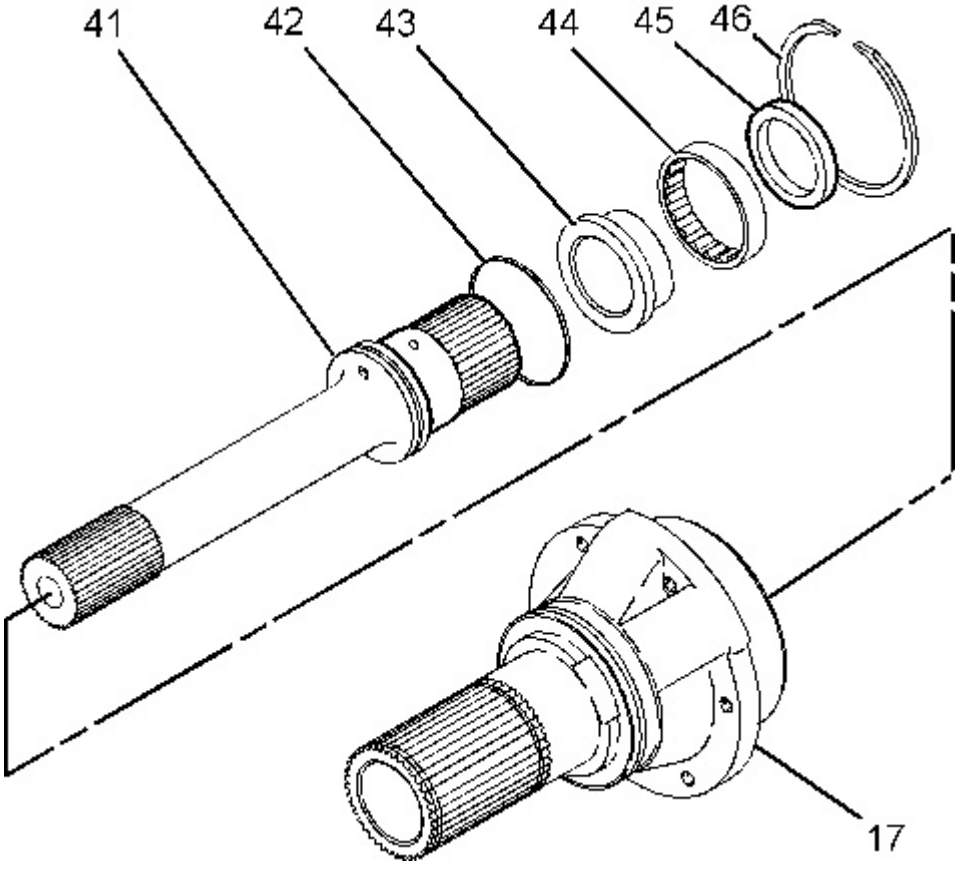


Illustration 12 g01152618

17. Assemble carrier shaft (17), as follows.
18. Install ring (42) on shaft (41).
19. Use a suitable press to install inner race (43) onto shaft (41).
20. Install outer bearing (44).

21. Use Tooling (B), Tooling (D), and a suitable press to install shaft assembly (41) and outer bearing (44) into carrier shaft (17).

22. Install plate (45) and retaining ring (46).

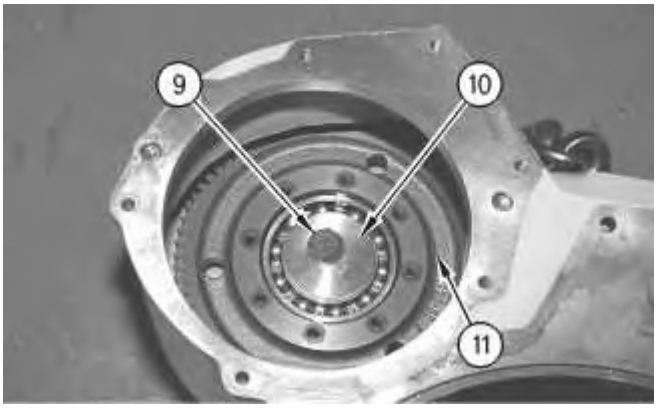
Illustration 13 g00456243

23. Install impeller (14) on rotating housing (15). The weight of the impeller assembly is approximately 36 kg (80 lb).

24. Install bolts (13) and the washers. The torque for bolts (13) is 60 ± 7 N·m (44 ± 5 lb ft).

Illustration 14 g00456176

25. Use Tooling (B) to install bearing (12) in pump drive gear (11).



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