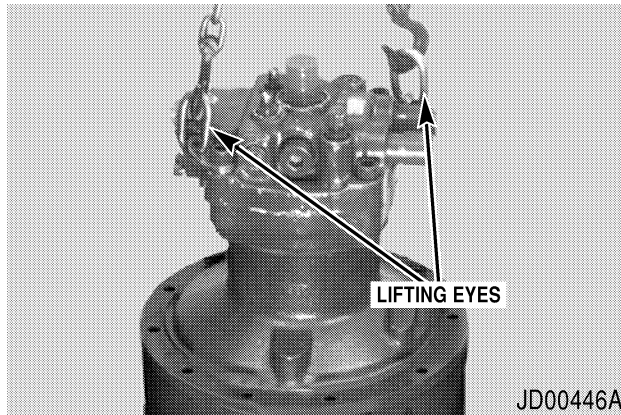


Installation

STEP 1

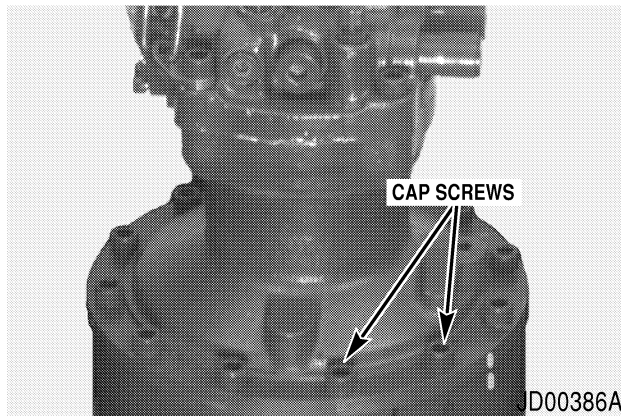
Remove the protective covering from the swing reduction gear. Degrease the mating mounting surfaces of the swing reduction gear and the swing motor housing. Apply Loctite 504 to the swing reduction gear.

STEP 2



Connect suitable lifting equipment to the swing motor. Move the swing motor to the machine and position above the swing reduction gear. Carefully lower the swing motor on the swing reduction gear.

STEP 3



Apply Loctite 262 to the threads of the twelve socket head cap screws. Install the twelve socket head cap screws to secure the swing motor to the swing reduction gear. Tighten the socket head cap screws to 420 lb-ft (569 Nm).

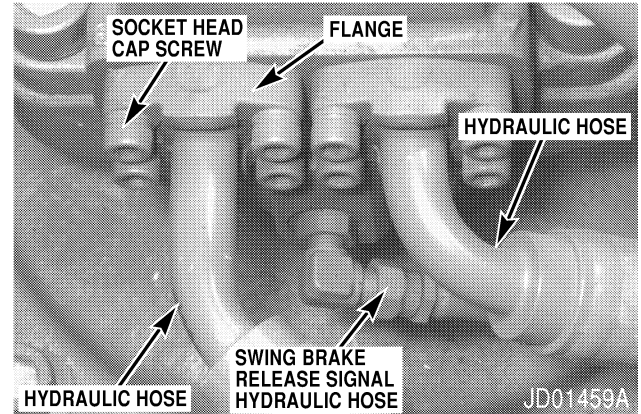
STEP 4

Disconnect the lifting equipment from swing motor.

STEP 5

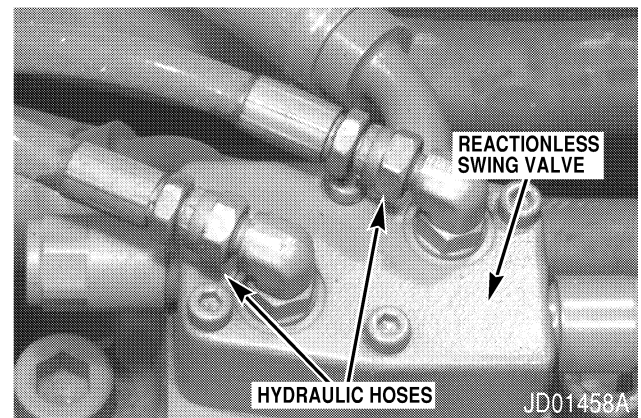
Connect a vacuum pump to the hydraulic reservoir if not already connected. (See Section 8000). Turn on the vacuum pump.

STEP 6

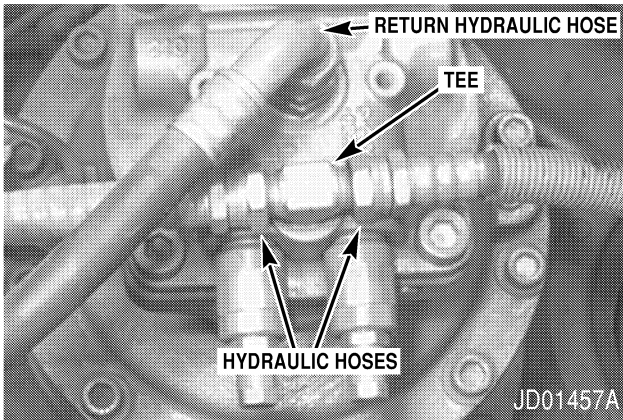


Remove the plugs from the hydraulic hoses and the swing motor ports. Remove the cap from the elbow and the plug from the swing brake release signal hydraulic hose. Connect the swing brake release signal hydraulic hose to the elbow installed in the left side of the swing motor following the tags applied during removal. Connect the two hydraulic hoses to the side of the swing motor using new O-rings following the tags applied during removal. Install the four flanges and secure with eight lock washers and socket head cap screws. Remove and discard the tags.

STEP 7



Remove the caps from the elbows and the plugs from the hydraulic hoses. Connect the two hoses to the elbows installed in the reactionless swing valve following the tags applied during removal. Remove and discard the tags.

STEP 8

Remove the caps from the adapter and the tee and the plugs from the hydraulic hoses. Connect the two hoses to the tee following the tags installed during removal. Fill the swing motor with 1.6 quarts (1.5 liters) of clean hydraulic oil through the return port. Connect the return hydraulic hose to the adapter. Remove and discard the tags.

STEP 9

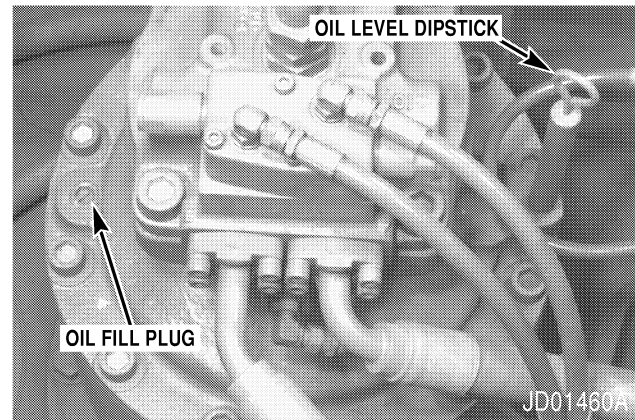
Turn off and disconnect the vacuum pump from the hydraulic reservoir. (See Section 8000). Remove the tags from the hoses.

STEP 10

Remove the DO NOT OPERATE tag from the ignition key.

STEP 11

Refer to Section 8001 and adjust the swing motor relief valves.

STEP 12

Check that the swing reduction gear oil drain plug is tight. Remove the oil fill plug. Add Case 135H EP gear lubricant until the oil level is in the lower part of the dipstick that has the crosshatch marks.

STEP 13

Install the top front center access cover.

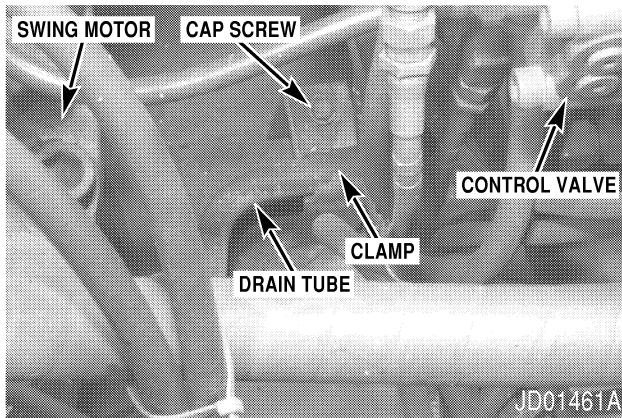
SWING MOTOR AND SWING REDUCTION GEAR ASSEMBLY

Removal

STEP 1

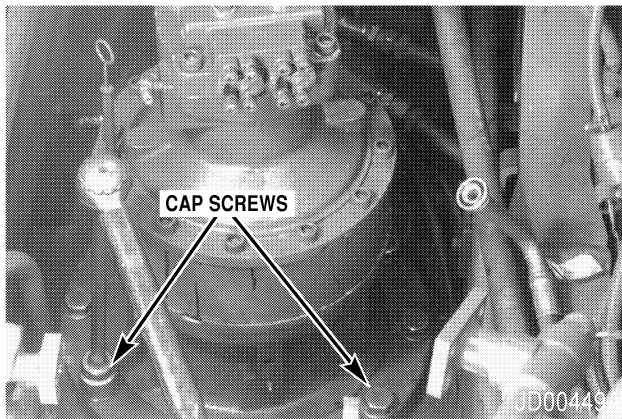
Refer to Swing Motor Removal and do steps 1 through 18.

STEP 2



Remove the cap screw and the clamp securing the swing reduction gear drain tube to the machine.

STEP 3



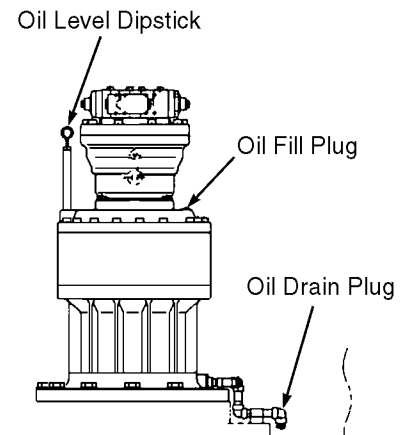
Remove the twelve cap screws and flat washers.

STEP 4



Carefully raise the swing motor and the swing reduction gear while moving it so the drain tube clears the control valve. Raise the swing motor and the swing reduction gear from the turntable and move away from the machine.

STEP 5



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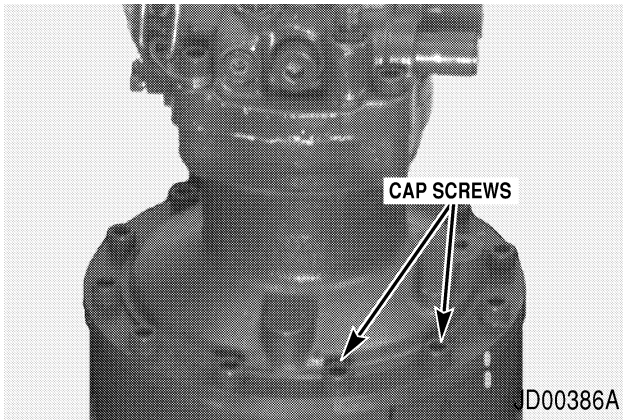
Position a 4 gallon (15 liter) container beneath the swing reduction gear drain plug. Capacity of the swing reduction gear is 3.8 gallons (14.5 liters). Remove the drain plug and drain the oil. Install the drain plug.

STEP 6

Lower the swing motor and swing reduction gear to the ground and place on suitable supports.

NOTE: Supports should be of sufficient height to ensure the pinion gear does not touch the ground.

STEP 7

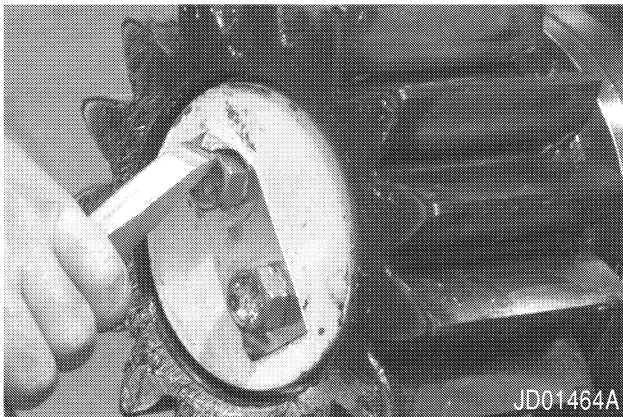


Remove the twelve socket head cap screws securing the swing motor to the swing reduction gear.

STEP 8

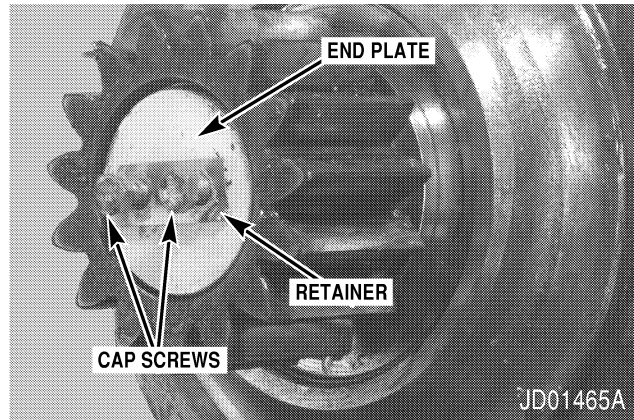
Carefully raise the swing motor up and away from the swing reduction gear. Move the swing motor away from the swing reduction gear and place in a clean area.

STEP 9



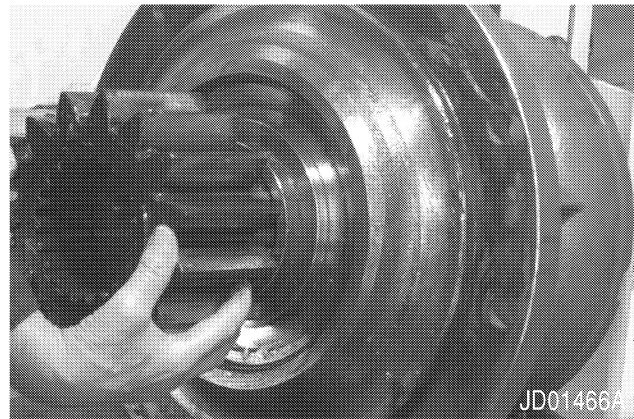
Turn the reduction gear over to gain access to the pinion gear. Bend the corners of the retainer to free the cap screws.

STEP 10



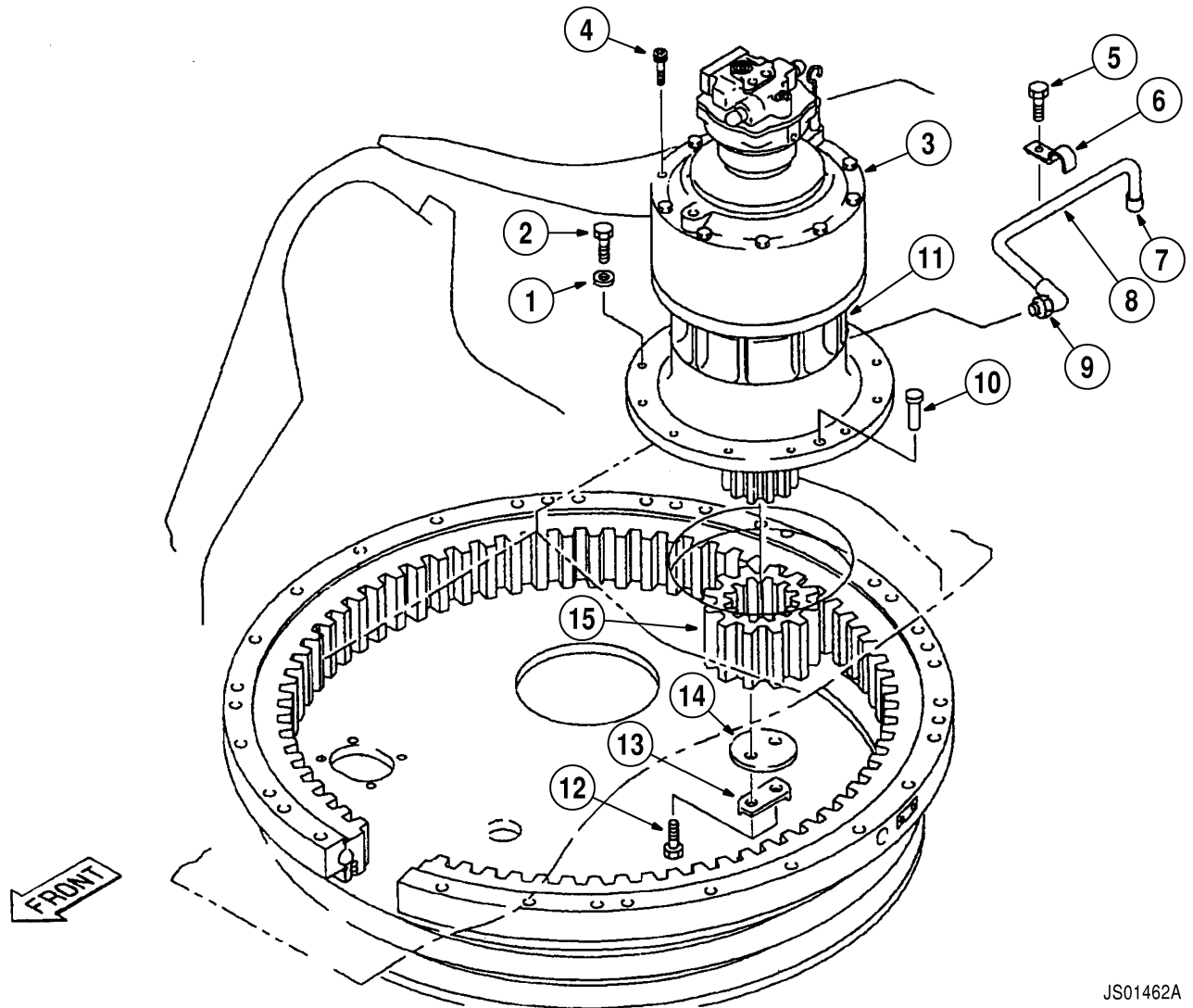
Remove the two cap screws, retainer, and end plate from the pinion gear.

STEP 11



Remove the pinion gear from the shaft.

Installation

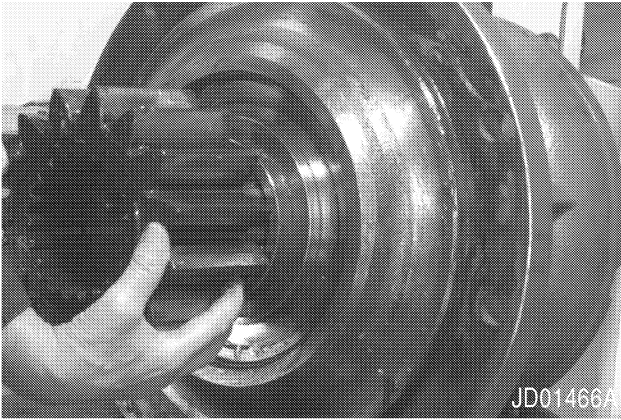


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Swing Motor and Swing Reduction Gear

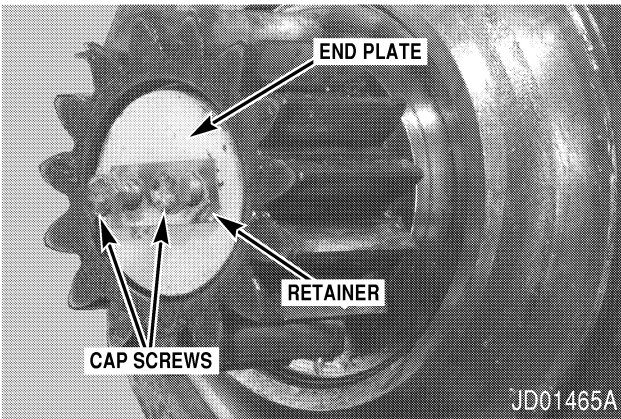
- | | |
|--------------------------|--------------------------------------|
| 1. Flat Washer | 9. Adapter |
| 2. Cap Screw | 10. Pin |
| 3. Swing Motor Assembly | 11. Swing Reduction
Gear Assembly |
| 4. Socket Head Cap Screw | 12. Cap Screw |
| 5. Cap Screw | 13. Retainer |
| 6. Clamp | 14. End Plate |
| 7. Plug | 15. Pinion Gear |
| 8. Drain Tube | |

STEP 1



Install the pinion gear on the swing reduction gear shaft.

STEP 2



Install the end plate on the pinion gear. Install the two cap screws and retainer on the end plate. Tighten the cap screws securely.

STEP 3



Bend the corners of the retainer to secure the cap screws.

STEP 4

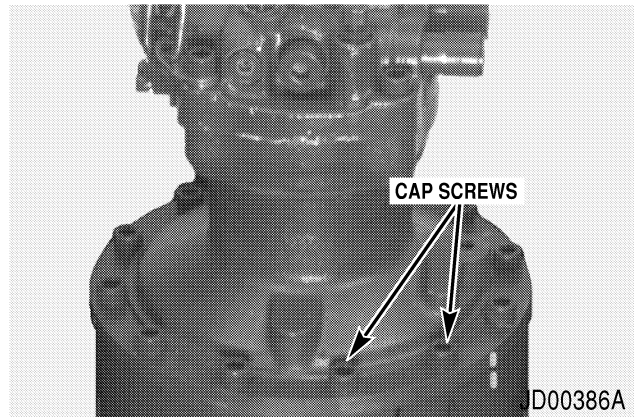
Position the swing reduction gear so that it is setting on the pinion gear.

STEP 5



Connect suitable lifting equipment to the swing motor and move into position above the swing reduction gear. Carefully lower the swing motor on the swing reduction gear.

STEP 6



Apply Loctite 262 to the threads of the twelve socket head cap screws. Install the twelve socket head cap screws to secure the swing motor to the swing reduction gear. Tighten the socket head cap screws to 420 lb-ft (569 Nm).

STEP 7

Clean the swing motor and swing reduction gear mounting surface on the turntable.