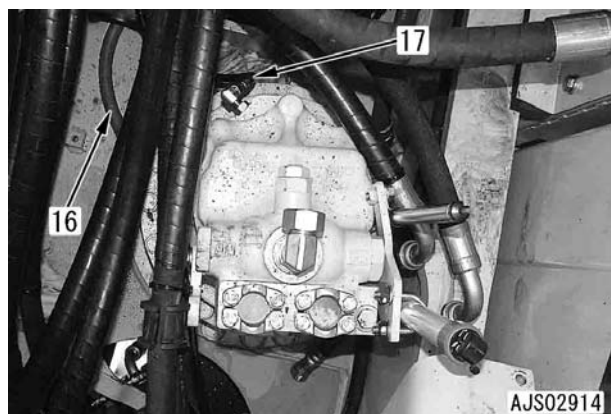
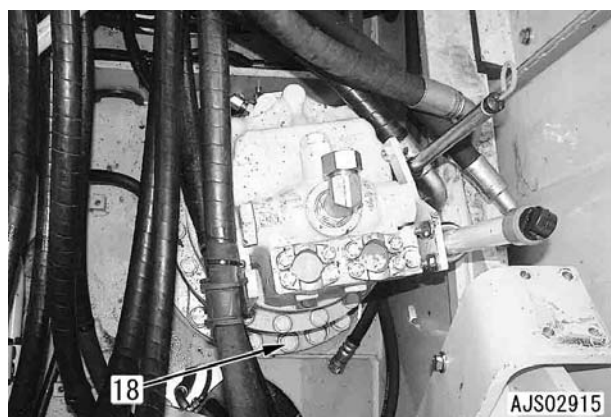


10. Pull drain hose (16) out.

11. Disconnect pilot hose to cancel swing brake (17) (B port).




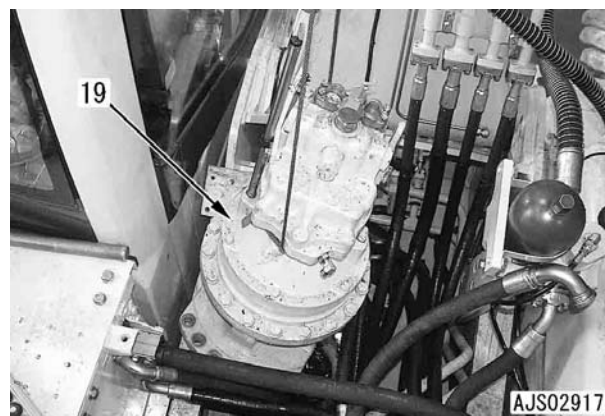
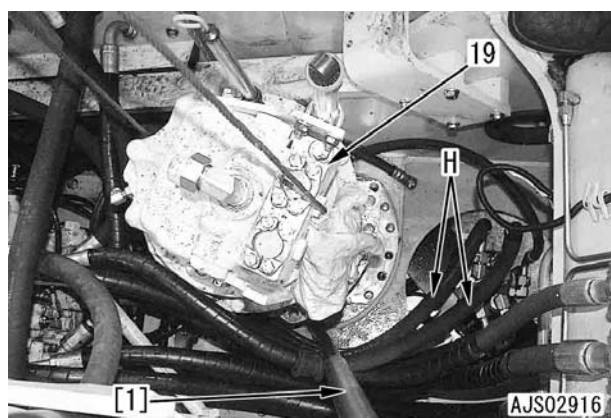
12. Remove 12 mounting bolts (18). [*1]



13. Lift and remove the swing motor and swing machinery assembly (19).

- ★ Being careful not to damage hose (H), etc. with bar [1], lift the swing motor and swing machinery assembly gradually and remove them.
- ★ Being very careful for the drain hose, lift them.
- ★ Lift them with full attention until you have surpassed the hose of the center swivel joint.


 Swing motor and swing machinery assembly: **250 kg**



Installation

- Installation is done in the reverse order of removal.

[*1]

 Mounting bolt: **490 – 608 Nm {50 – 62 kgm}**

● Refilling with oil (hydraulic tank)

Refill hydraulic oil through the oil filler port to the specified level. Let the oil circulate in the hydraulic system by starting the engine. Then check the oil level again.

● Air bleeding

Bleed the air from the circuit between the valve and the hydraulic cylinder. For details, see Testing and adjusting, "Bleeding air from each part."

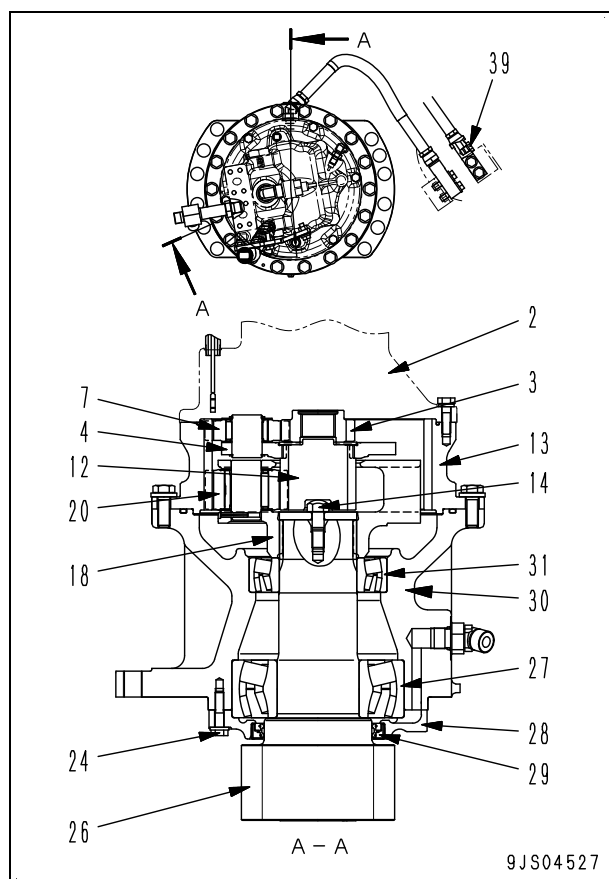
Disassembly and assembly of swing motor and swing machinery assembly

Special tools

Symbol	Part Number	Part name	Necessity	Q'ty	N/R	Sketch
F	1 790-201-2860	Push tool	■	1		
	2 796-426-1120	Push tool	■	1		
	796T-426-1130	Plate	■	1		○
	3 790-101-5421	Grip	■	1		
	01010-81240	Bolt	■	1		

● Sectional view

★ A number shows the number in the text.



Disassembly

1. Set the swing motor and the swing machinery assembly into block [1].

2. Oil drain

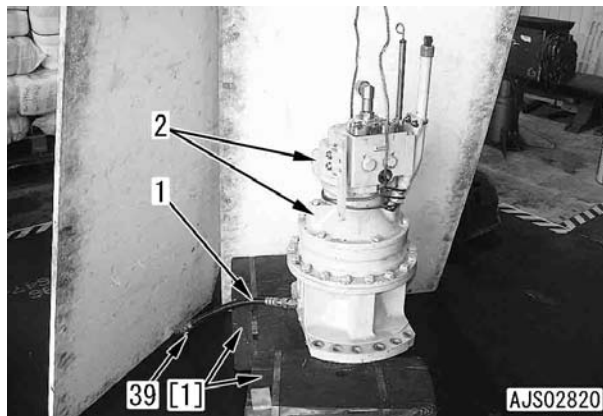
Loosen drain plug (39) and drain the oil inside the swing machinery case. [*1]

⚠ Swing machinery case: **Approx. 8 ℓ**

3. Remove drain hose (1).

4. Remove 6 mounting bolts and remove swing motor assembly (2).

⚠ Swing motor assembly: **70 kg**



5. Remove No. 1 sun gear (3).

6. No.1 carrier assembly

1) Remove No. 1 carrier assembly (4).

