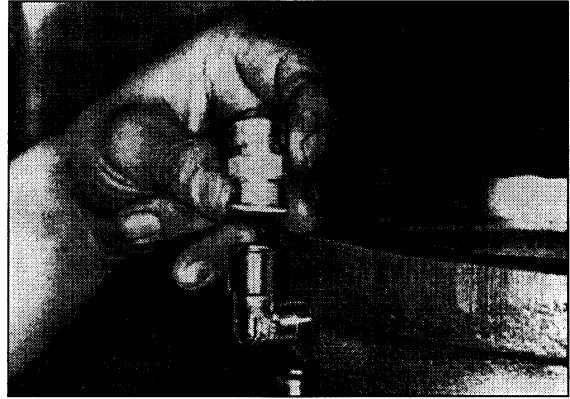
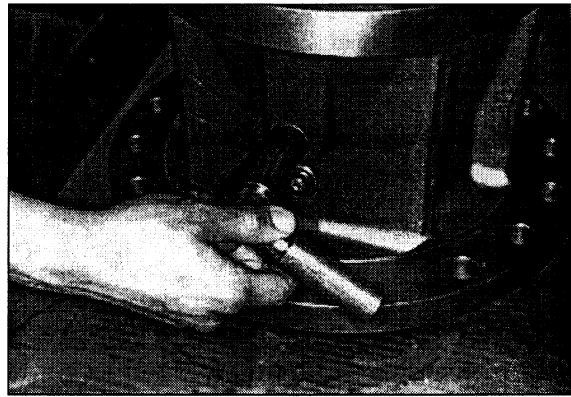


**ASSEMBLING****STEP 92**

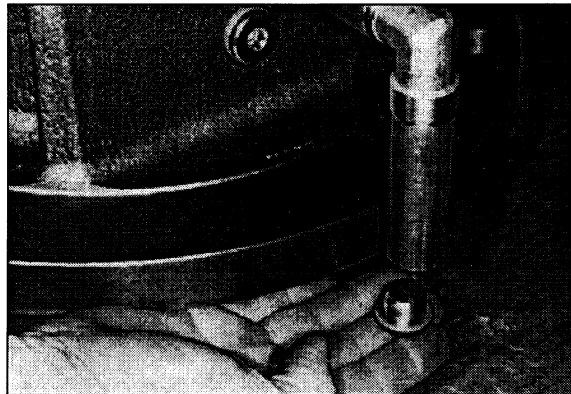
Assemble the breather plug G1/4 (pos. 47).

**STEP 93**

Assemble the extensions (pos. 10), the angle (pos. 11) and the washer (pos. 8) in the gearbox housing (pos. 7).

**STEP 94**

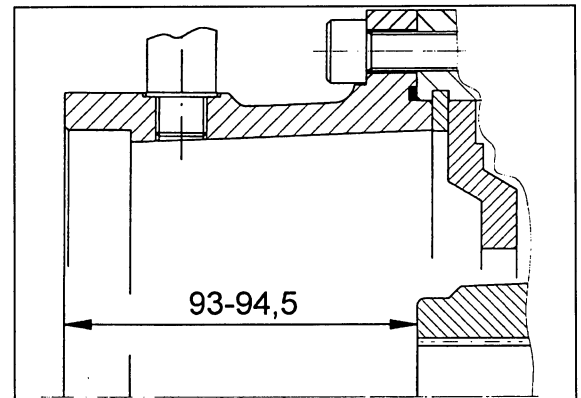
Assemble the plug M18x1,5 (pos. 9).



**ASSEMBLING****STEP 95****⚠ Important**

After mounting the hydraulic motor, verify, through a depth slide gauge, the axial dimension of the gearbox measured by input side of the motor adaptor (pos. 50) to the brake shaft (pos. 35).

Axial dimension = 93-94,5 mm.

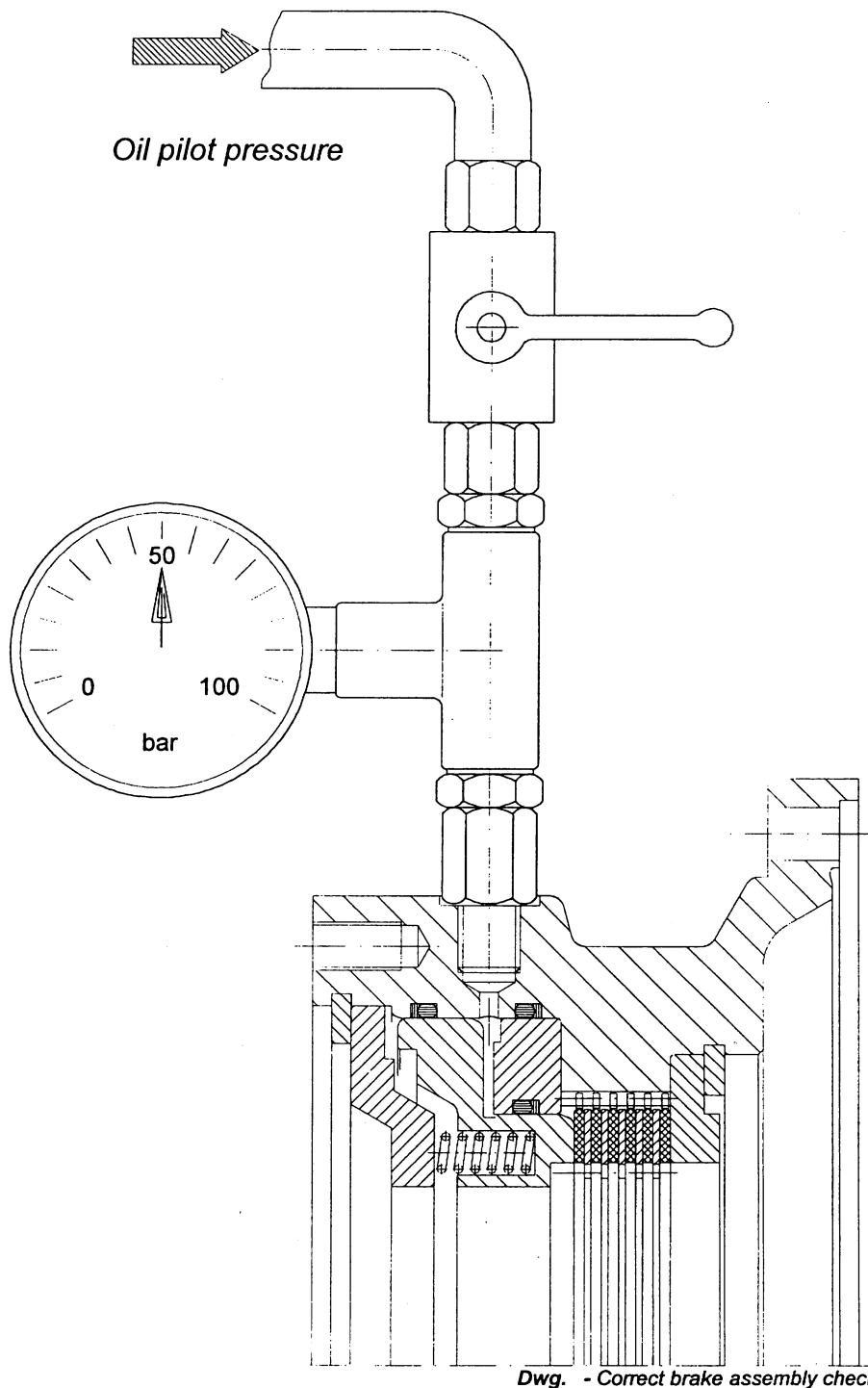
**STEP 96**

After having reassembled the gearbox, fit the hydraulic motor (taking care to include the O-ring pos. 51), through 2 fixing screws M16x40 (pos. 49), grade 8.8 tightened at a torque of 21,5 daNm. Fill the gearbox with the lubricant oil as shown in section 4.2.

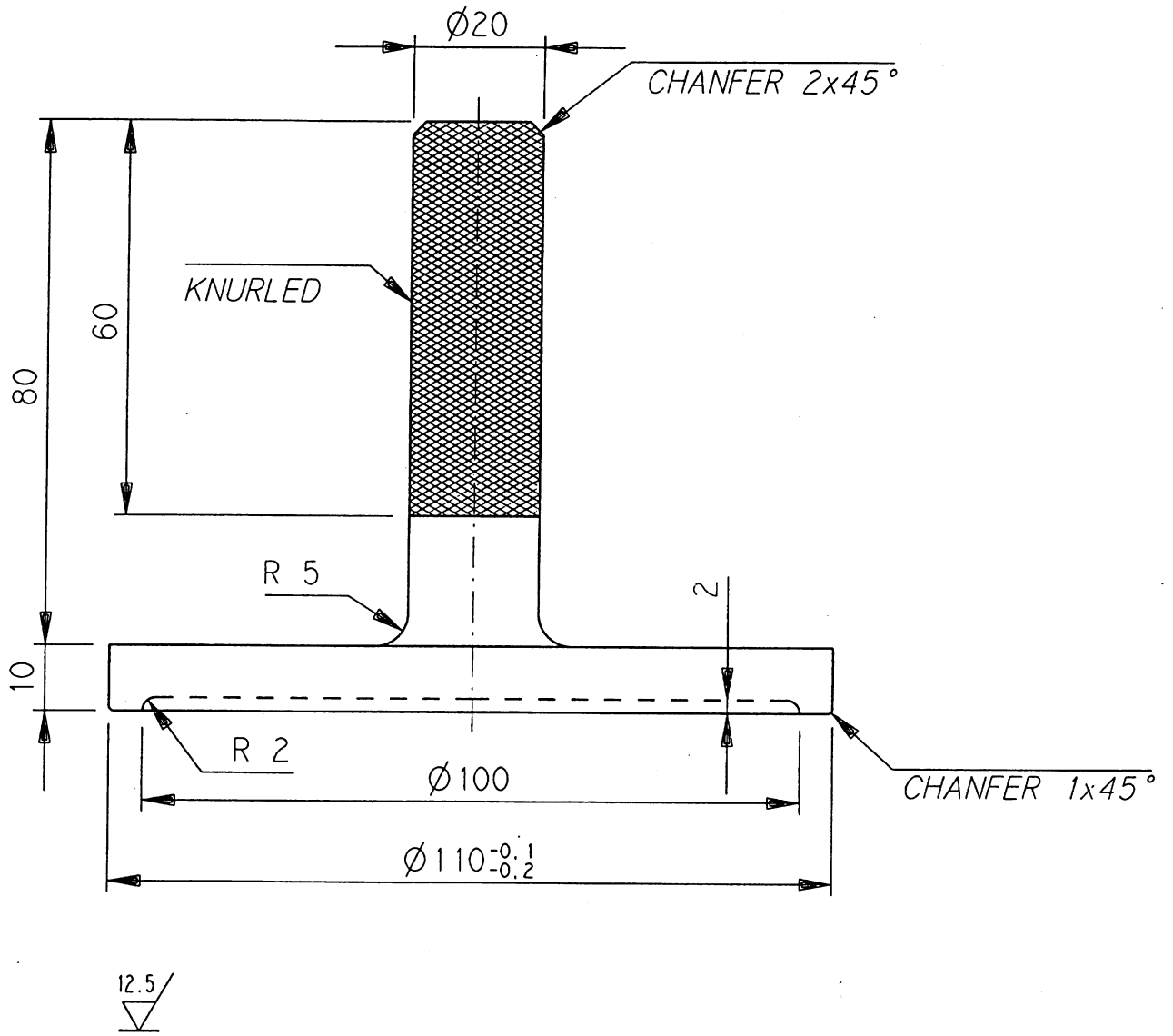
## 5. BRAKE CHECK

In order to verify the correct assembly of the brake group, it is necessary to carry out a test of the seal rings. Connect the brake port to a pump and release the brake by pumping oil. By means of a pressure gauge verify that the pressure does not decrease (see dwg. 6). In Otherwise case, the seal rings of the brake leak oil and it is necessary to disassembly the brake and provide for their replacement.

Test data: **Test duration = 3 minutes.**



(SPECIAL TOOLS FOR SWING MACHINERY)



(SPECIAL TOOLS FOR SWING MACHINERY)

