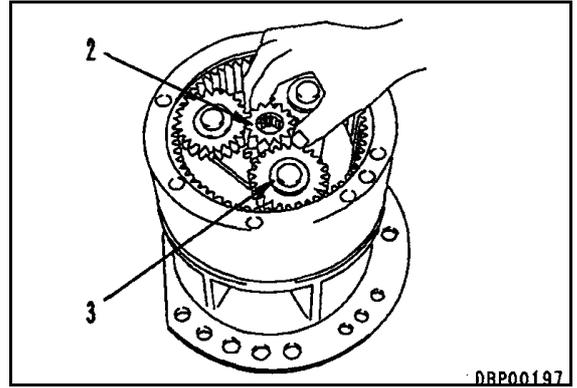


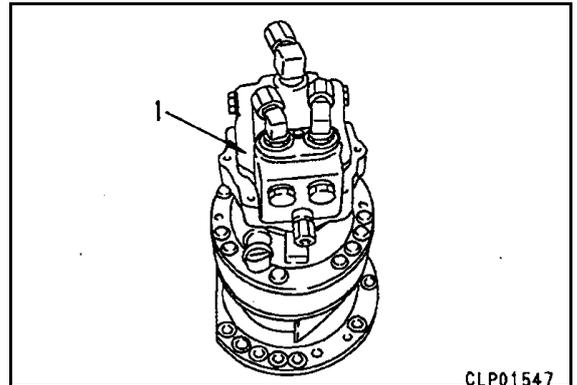
- B. Install No. 1 carrier and No.2 sun gear assembly (3).
- C. Install No. 1 sun gear (2).



8. Swing motor assembly
Install swing motor assembly (1).



Mounting bolt: $110.3 \pm 12.3 \text{ Nm}$
($11.25\text{m} \pm 1.25 \text{ kgm}$)



9. Refilling with oil
Tighten drain plug and add engine oil through oil filler.



Swing machinery case : Approx 2.5 ℓ

CENTER SWIVEL JOINT

REMOVAL



Lift the dump body and set the safety bar.



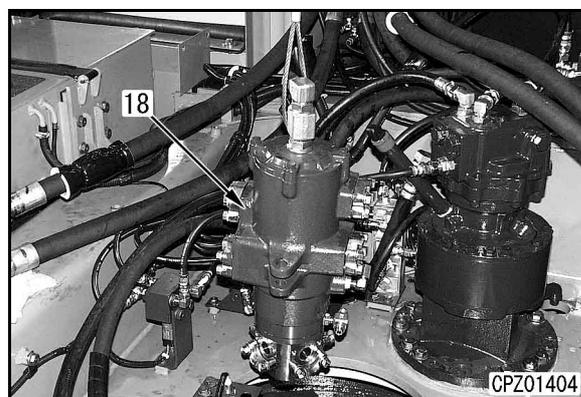
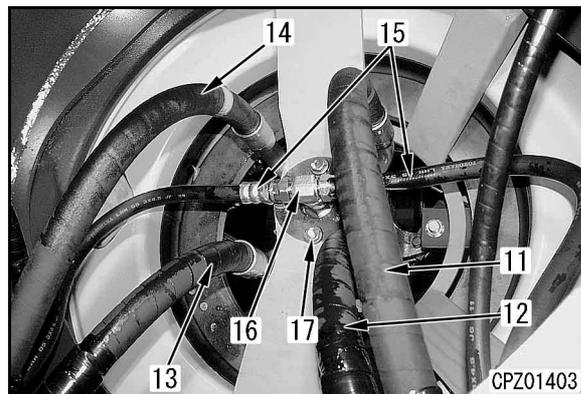
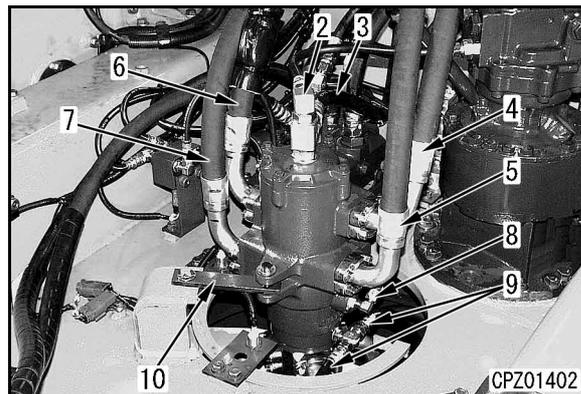
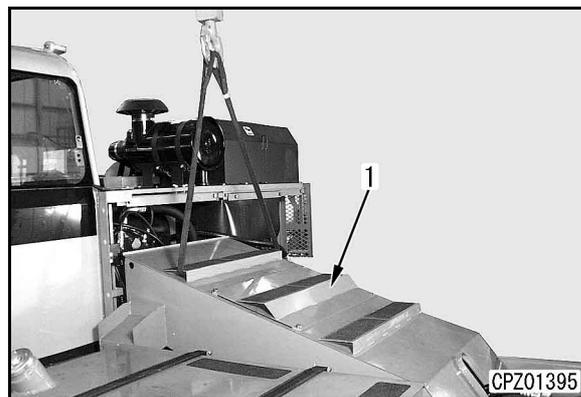
Loosen the oil filler cap on the hydraulic tank slowly to reduce pressure in the tank.

★ Attach tags to pipes and hoses so that their locations are not mistaken.

1. Remove the cover (1).
2. Disconnect the hose (2) between the swivel joint and the swing motor.
3. Disconnect hose (3) between the swivel joint and hydraulic tank.
4. Disconnect the hose (4) between the swivel joint and the travel control valve (L.H. travel forward).
5. Disconnect hose (5) between swivel joint and the travel control valve (L.H. travel reverse).
6. Disconnect the hose (6) between the swivel joint and the travel control valve (R.H. travel forward).
7. Disconnect the hose (7) between the swivel joint and the travel control valve (R.H. travel reverse).
8. Disconnect the hose (8) between the swivel joint and the solenoid.
9. Disconnect the hose (9) between the swivel joint and the left-and-right travel motor.
10. Disconnect the locking plate (1)
11. Disconnect the hoses (11), (12), (13), and (14) between the swivel joint and the left-and-right travel motor.
12. Disconnect the hose (15) between the swivel joint and the left and right drain ports.
13. Remove the tee (16).
14. Sling the swivel joint and remove 4 mounting bolts (17).
15. Sling the center swivel joint assembly (18) to remove it.



Center swivel joint assembly: 45 kg

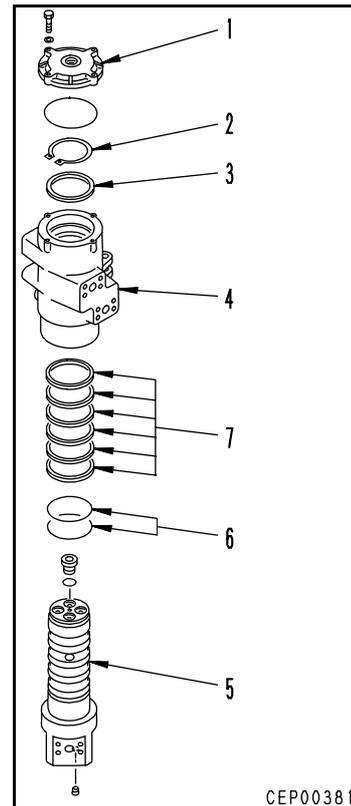


INSTALLATION

- Perform installation in the reverse order to removal.
- Refilling with oil (Hydraulic tank)
 - ★ Supply oil up to the specified level through the oil filler port. Start the engine to circulate oil through the piping and then check the oil level again.
- Bleeding air
 - ★ See "Air Bleeding from Each Part" in TESTING AND ADJUSTING, and bleeding air from the travel motor.

DISASSEMBLY

1. Remove cover (1).
2. Remove snap ring (2).
3. Use puller T, pull out swivel rotor (4) and ring (3) from swivel shaft (5).
4. Remove O-ring (6) and slipper seal (7) from swivel rotor

**ASSEMBLY**

1. Assemble slipper seal (7) and O-ring (6) to swivel rotor.
2. Set swivel shaft (5) to block, then using push tool, tap swivel rotor (4) with a plastic hammer to install.

 Contact surface of rotor, shaft :
Grease (G2-LI)

- ★ When installing the rotor, be extremely careful not to damage the slipper seal and O-ring.

3. Install ring (3) and secure with snap ring(2).
4. Fit O-ring and install cover (1).

 Mounting bolt: 31.4 ± 2.9 Nm
(3.2 ± 0.3 kgm)

