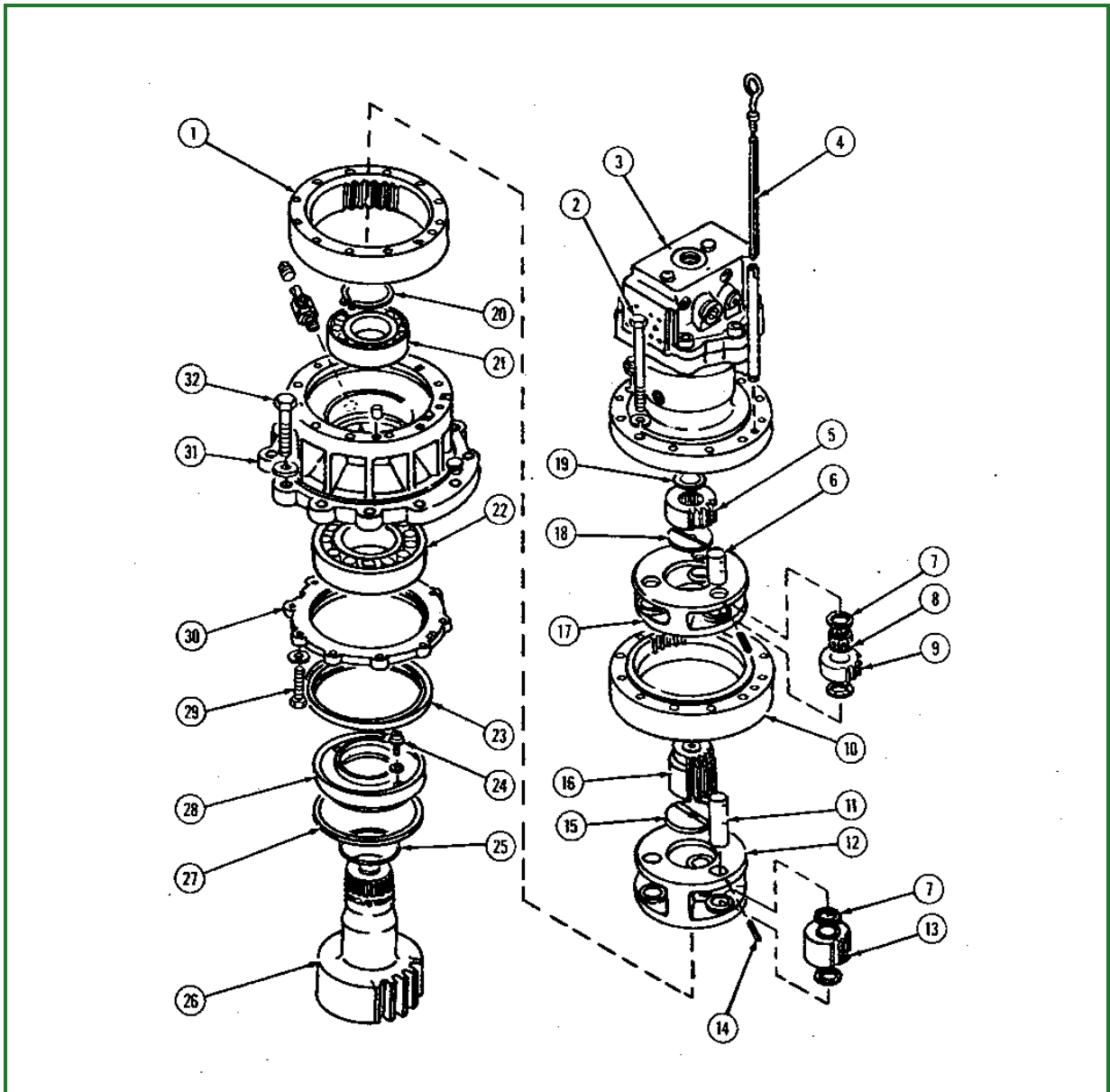


19.



T6585ME-UN: Swing Gearbox Assembly

LEGEND:

- 1 - Ring Gear
- 2 - Cap Screw (12 used)
- 3 - Swing Motor
- 4 - Dipstick
- 5 - First Planet Sun Gear
- 6 - Pin (3 used)
- 7 - Thrust Washer (12 used)
- 8 - Needle Bearing (3 used)
- 9 - First Planet Gear (3 used)
- 10 - Ring Gear
- 11 - Pin (3 used)
- 12 - First Planet Carrier
- 13 - Second Planet Gear (3 used)
- 14 - Spring Pin (6 used)
- 15 - Thrust Washer
- 16 - Second Planet Sun Gear
- 17 - Second Planet Carrier
- 18 - Thrust Washer
- 19 - Snap Ring
- 20 - Snap Ring
- 21 - Roller Bearing
- 22 - Roller Bearing

- 23 - Seal
- 24 - Magnet (2 used)
- 25 - O-Ring
- 26 - Pinion
- 27 - Snap Ring
- 28 - Sleeve
- 29 - Cap Screw (10 used)
- 30 - Cover
- 31 - Housing
- 32 - Cap Screw (10 used)

Apply liquid gasket maker to ring gears (1 and 10) and housing (31).

20. Install parts (1-32). Apply thread lock and sealer (medium strength) to cover-to-housing cap screws (29) and swing motor-to-swing gearbox cap screws (2).

Item	Measurement	Specification
Pinion Cover-to-Housing Cap Screws	Torque	47 N·m (36 lb-ft)
490D Swing Motor-to-Swing Gearbox Cap Screws	Torque	137 N·m (101 lb-ft)
590D Swing Motor-to-Swing Gearbox Cap Screws	Torque	294 N·m (217 lb-ft)

21. Add oil to swing gearbox. Approximate oil capacity is 3.2 L (3.4 qt). (See [Swing Gearbox and Track Gearbox Oils](#) in Section I, Group IV.)