

20. Install lock plate (16). If lock plate does not engage with splines of shaft, tighten bearing nut (15) unit until lock plate engages.

21. Install cap screws (17) and tighten to specification.

Specification

Lock Plate-to-Bearing Nut	
Cap Screw—Torque	50 N·m 37 lb·ft

22. Align marks on ring gear and housing. Install ring gear.

23. Apply Loctite® 515™ Gasket Eliminator® Flange Sealant to motor mounting surface of ring gear. Tighten ring gear cap screws (24) to specification.

Specification

Ring Gear Cap	
Screw—Torque	140 N·m 103 lb·ft

NOTE: Procedure for assembly of first and second stage carrier assemblies is identical.

24. Install thrust plate (19) into second stage carrier (18).

25. Install needle bearings (11) into second stage planetary gears (12).

26. Install second stage planetary gears and thrust plates (13) into second stage carrier.

27. Install pins (9) into second stage carrier.

28. Install spring pins (10) with slit of spring pins towards end of pin (9).

29. Install second stage carrier into ring gear.

30. Install second stage sun gear (20).

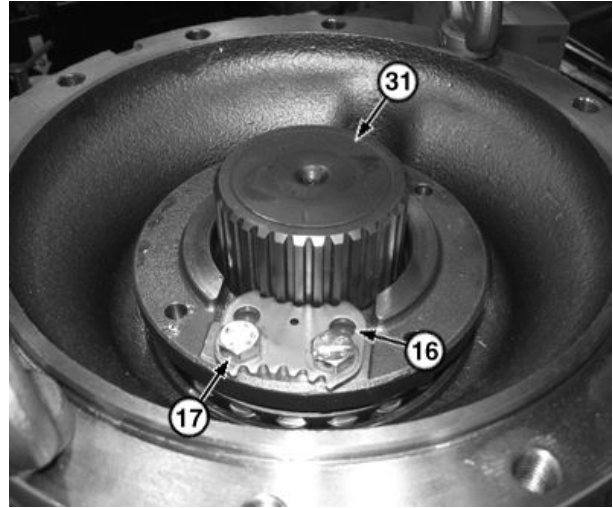
31. Install thrust plate (3) into first stage carrier (21).

32. Install needle bearings (6) into first stage planetary gears (7).

33. Install first stage planetary gears and thrust plates (8) into first stage carrier.

34. Install pins (4) into first stage carrier.

Loctite and its related brand marks are trademarks of Henkel Corporation



Lock Plate

- 16— Lock Plate
- 17— Cap Screw (2 used)
- 31— Shaft

35. Install spring pins (5) with slit of spring pins towards end of pin (4).

36. Install first stage sun gear (2) to swing motor (1).

37. Apply Loctite® 277™ Threadlocker (high strength) to motor mounting surface of ring gear.

38. Remove the M20 x 2.5 cap screws that are securing the housing to ST5098 Stand.

39. Install swing motor and park brake. See Swing Motor and Park Brake Remove and Install. (Group 4360.)

40. Install drain line (33) and drain plug (32). Tighten to specification.

Specification

Drain Plug—Torque	50 N·m 37 lb·ft
-------------------------	--------------------

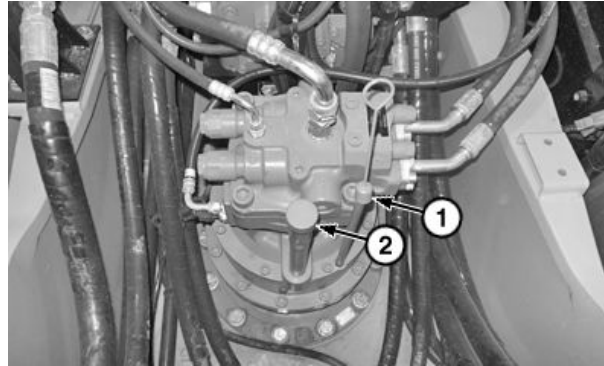
TX1165457A—UN—16JUL14

Swing Gear Case Start-Up Procedure

SPECIFICATIONS	
Swing Gear Case Oil Capacity (approximate)	3.2 L 3.4 qt

IMPORTANT: Swing gear case will be damaged if not filled with oil before operating swing function. Procedure must be performed whenever a new swing gear case is installed or oil has been drained from the gear case.

1. Check swing gear case oil level. See Check Swing Gear Case Oil Level. (Operator's Manual.)
2. If necessary, remove fill cap (2) and add oil. For information on oil types, see Swing Gear Case and Travel Gear Case Oils. (Operator's Manual.)



Swing Gear Case

1— Dipstick

2— Fill Cap

Specification

Swing Gear Case Oil—Capacity (approximate).....	3.2 L 3.4 qt
---	-----------------

TX1195443A —UN—12JUN15

CK90142.000006D -19-20NOV15-1/1