

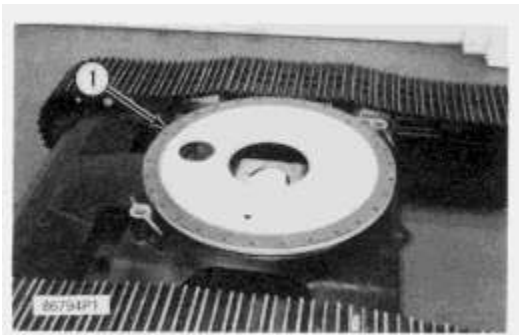
## Swing Gear And Bearing

SMCS - 7063-010

### Remove And Install Swing Gear And Bearing

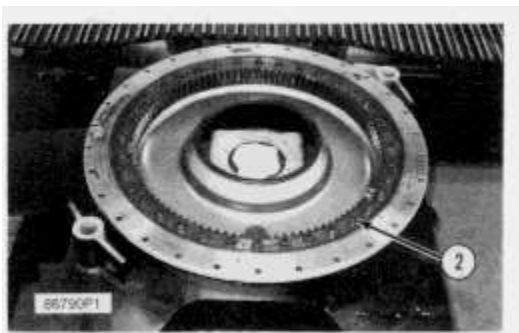
Start By:

- a. remove undercarriage



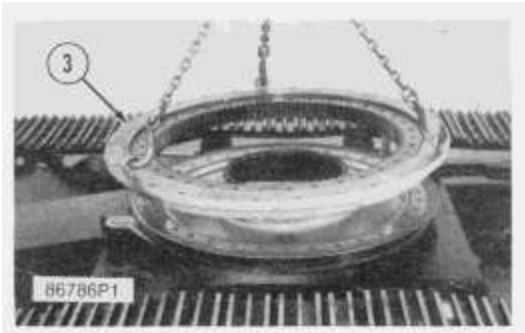
Typical Example

1. Remove cover (1). The weight of the cover is 52 kg (115 lb.).



Typical Example

2. Remove thirty-six bolts (2).



3. Install three 7/8" - 9 NC forged eyebolts and nuts in the gear and bearing. Fasten a hoist and remove the gear and bearing (3). The weight of the gear and bearing is 450 kg (1000 lb.).

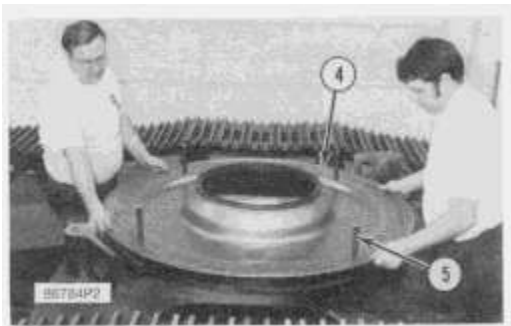


Typical Example

4. Remove pan (4). The weight of the pan is 29 kg (65 lb.).

**NOTE:** The following steps are for the installation of swing gear and bearing.

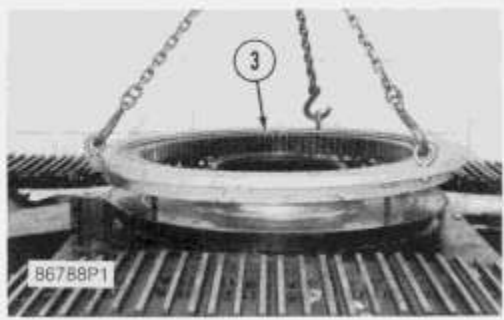
5. Clean the old liquid gasket material from the contact surfaces of the pan and carbody frame. Put 7M7260 Liquid Gasket on the surfaces.



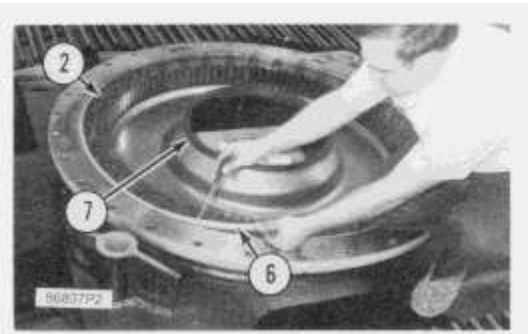
6. Install four 7/8" - 9 NC guide pins (5). Using the pins as a guide, install pan (4).

7. Clean the old liquid gasket material from the contact surfaces of the pan and gear.

8. Inspect the seal on the bottom of the gear and bearing. Replace if necessary.



**9.** Install three 7/8" - 9 NC forged eyebolts and nuts in the gear and bearing. Fasten a hoist to the gear and bearing. Put 7M7260 Liquid Gasket on the contact surfaces of the pan and gear. Install the gear and bearing (3) using the guide pins as a guide.



**10.** Install thirty-six bolts (2). Tighten to a torque of  $810 \pm 55$  N·m ( $600 \pm 40$  lb.ft.).

**11.** Inspect seal (6). Replace if necessary.

**12.** Clean the old liquid gasket material from the contact surfaces of the bearing and cover. Put 7M7260 Liquid Gasket on the surfaces.

**13.** Put 5P960 Multipurpose Grease on the surfaces of seal (7) that make contact with the cover. Install the cover.

End By:

**a.** install undercarriage

---