

- 22 - Roller Bearing
- 23 - O-Ring
- 24 - Make-Up Check Valve Plug (2 used)
- 25 - O-Ring (2 used)
- 26 - Spring (2 used)
- 27 - Poppet (2 used)
- 28 - Swing Motor Cover
- 29 - Cap Screw (4 used)
- 30 - O-Ring (2 used)
- 31 - Plug (2 used)
- 32 - Crossover Relief Valve (2 used)

1. Remove swing motor. [See Swing Motor and Park Brake Remove and Install](#) . (Group 4360.)

2. IMPORTANT:

Crossover relief valves should not be disassembled. No service parts are available.

Remove crossover relief valves (32).

3. Remove make up check valves (24—27).

4. Remove plugs (31) and O-rings (30).

5. IMPORTANT:

Swing motor valve housing and cover are under spring pressure. Remove cap screws evenly to release spring force.

NOTE:

Do not remove roller bearing from swing motor cover unless replacement is necessary.

Mark alignment of housing (1) and swing motor cover (28) and remove swing motor cover.

6. IMPORTANT:

Valve plate may remain on housing or stay with cylinder block when swing motor is disassembled. Valve plate has a polished surface and may be damaged if dropped.

Remove valve plate (21) and springs (20).

7. Remove brake piston (19).

8. Remove O-rings (17 and 18) from housing.

9. IMPORTANT:

Remove pistons from rotor carefully to not damage the sliding surfaces.

Place housing horizontally and remove cylinder block, retainer, plate, and pistons (6—9) from shaft (4).

10. Remove plates and friction plates (10 and 11) from housing.

11. IMPORTANT:

Remove shoe plate carefully to not damage the sliding surface.