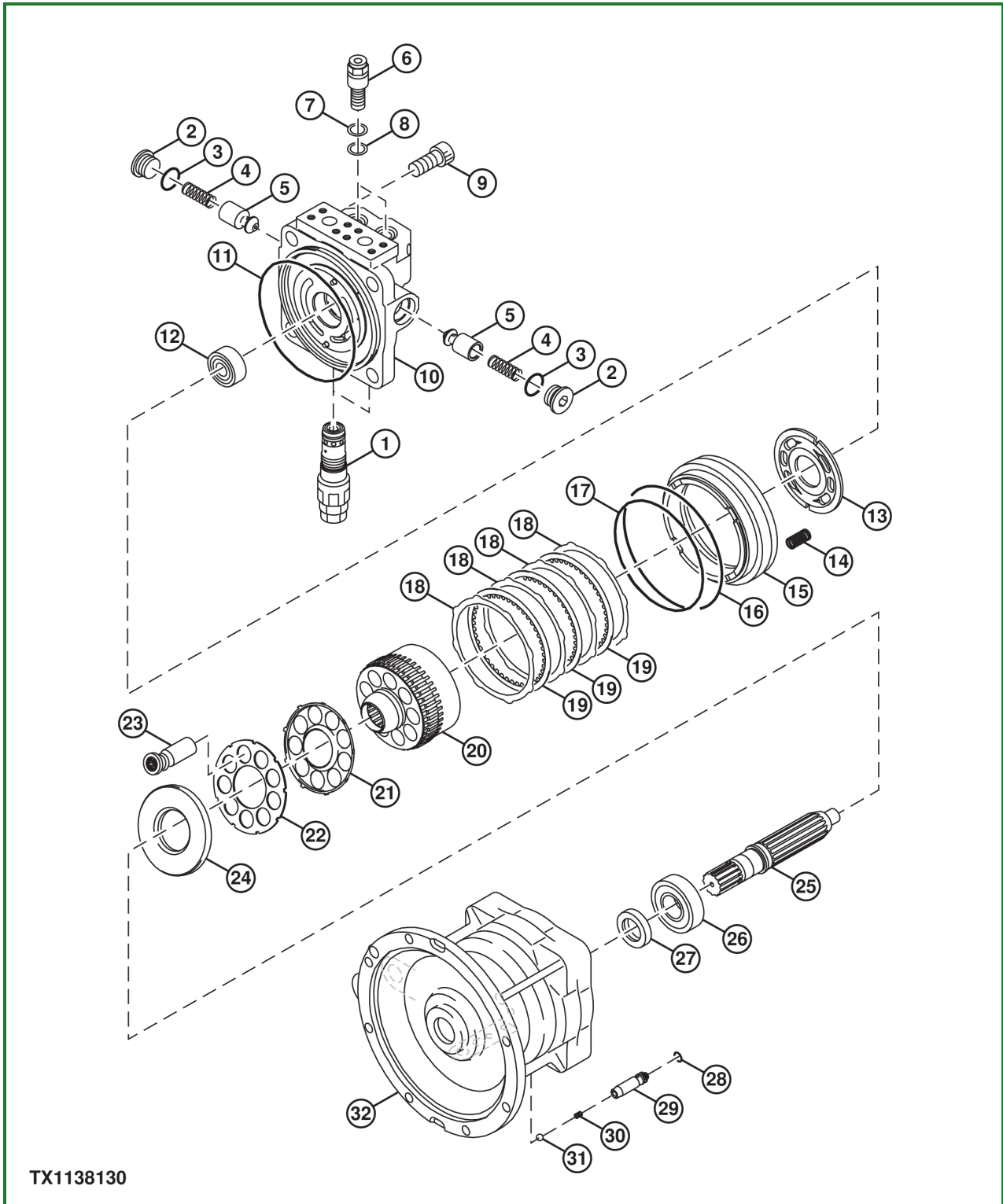


Swing Motor and Park Brake Assemble



TX1138130-UN: Swing Motor and Park Brake

LEGEND:

- 1 - Crossover Relief Valve (2 used)
- 2 - Make-Up Check Valve Plug (2 used)
- 3 - O-Ring (2 used)
- 4 - Spring (2 used)
- 5 - Poppet (2 used)
- 6 - Damper Valve (2 used)
- 7 - Back-Up Ring (2 used)
- 8 - Packing (2 used)

- 9 - Cap Screw (4 used)
- 10 - Park Brake Valve Casing
- 11 - O-Ring
- 12 - Roller Bearing
- 13 - Valve Plate
- 14 - Spring (24 used)
- 15 - Brake Piston
- 16 - O-Ring
- 17 - O-Ring
- 18 - Plate (4 used)
- 19 - Friction Plate (3 used)
- 20 - Rotor
- 21 - Retainer
- 22 - Plate
- 23 - Plunger (9 used)
- 24 - Shoe Plate
- 25 - Shaft
- 26 - Roller Bearing
- 27 - Oil Seal
- 28 - O-Ring
- 29 - Piston
- 30 - Spring
- 31 - Ball
- 32 - Swing Motor gear Case

-: Specifications

SPECIFICATIONS	
Valve Casing Cap Screw Torque	431 N·m 318 lb·ft
Damper Valve Torque	70 N·m 52 lb·ft
Make-Up Check Valve Plug Torque	334 N·m 246 lb·ft
Crossover Relief Valve Torque	177 N·m 131 lb·ft

1. Install inner race of bearings (26 and 12) to shaft (25) using press.
2. Install oil seal (27) to swing motor gear case (32).
3. Install outer race of bearing (26) to case.
4. **IMPORTANT:**
Prevent possible oil seal damage. Wrap tape around shaft splines during installation.
Install shaft to swing motor gear case.
5. Install shoe plate (24) to swing motor gear case with the chamfered side toward case.