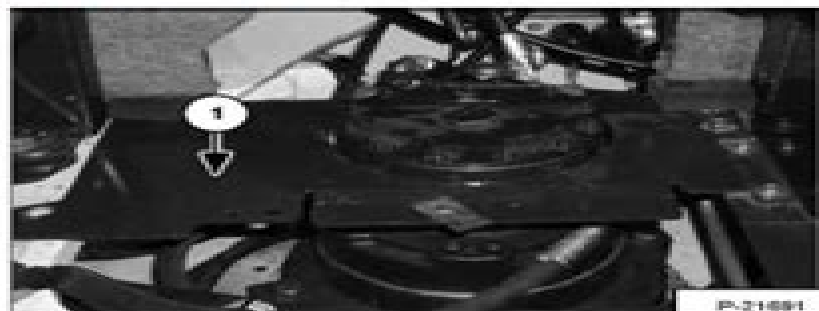


## SWING MOTOR (CONT'D)

### Removal And Installation (Cont'd)

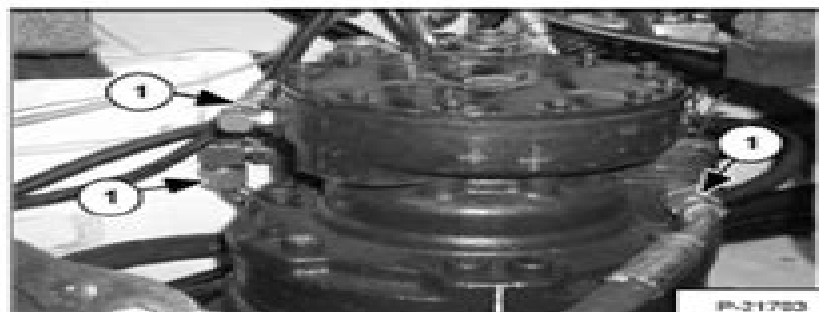
Figure 20-90-13



Lift and remove the floor panel (Item 1) [Figure 20-90-13] from the cab.

Mark all hydraulic hoses, for proper installation.

Figure 20-90-14

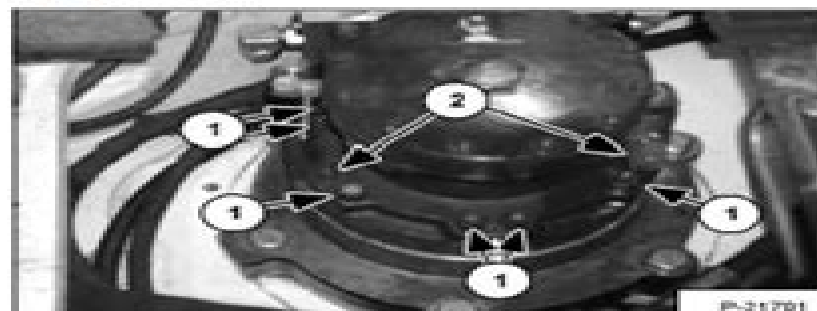


Disconnect the three hydraulic hoses (Item 1) [Figure 20-90-14] from the swing motor.

Cap and plug the hoses and fittings.

**NOTE:** The brake can be replaced without removing the swing motor from the excavator. Follow the brake replacement procedure listed in the swing motor disassembly section. (See Page 20-90-7.)

Figure 20-90-15



Remove the ten (10 mm) swing motor mounting bolts (Item 1) [Figure 20-90-15].

**Installation:** Coat threads with non-permanent blue grade thread lock adhesive. Tighten all bolts snug. Then tighten the mounting bolts to 110 ft.-lbs. (149 Nm) torque.

**NOTE:** The socket head bolts (Item 2) [Figure 20-90-15] are 6 mm and fasten the motor cam ring to the motor housing. Do Not remove these bolts when removing the swing motor mounting bolts.

Figure 20-90-16



Disconnect the three hydraulic hoses (Item 1) [Figure 20-90-16] from the cross port block.

Cap and plug the hoses and fittings.

# Manual Engine D 341

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