

Product: EXCAVATOR

Model: 350-A EXCAVATOR 7RK

Configuration: 350 350L TRACK-TYPE EXCAVATORS 7RK00001-UP (MACHINE) POWERED BY 3306 ENGINE

Disassembly and Assembly 350 AND 350 L EXCAVATOR MACHINE SYSTEMS

Media Number -SEN6148-04

Publication Date -01/11/2004

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SEN61480038

Swing Motor (Right)

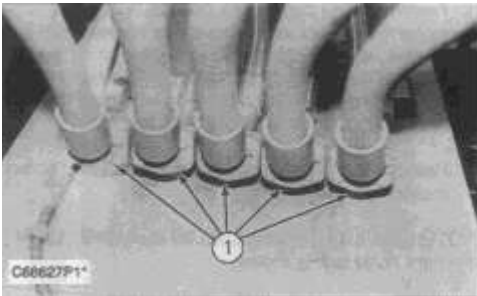
SMCS - 5058-010; 5058-015; 5058-016; 5058

Remove & Install Swing Motor (Right)

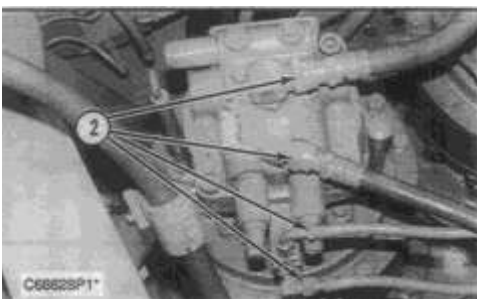
Start By:

- a. remove swing control valve

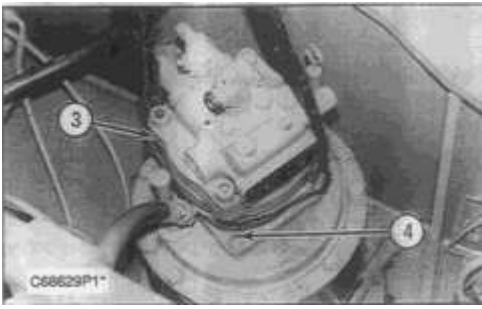
NOTE: To prevent oil loss and to keep dirt and debris out of the hydraulic system, put plugs in all hose assemblies as they are being disconnected.



1. Disconnect five hose assemblies (1) at the boom. Move the hose assemblies clear of the right hand swing motor.



2. Put identification marks on four hose assemblies (2) that are connect to the right hand swing motor for installation purposes. Disconnect the hose assemblies from the right hand swing motor.



3. Fasten a lifting sling and a hoist to right hand swing motor (3) as shown. Remove four socket head bolts (4) that hold the right hand swing motor to the swing drive. Carefully remove the right hand swing motor from the swing drive. The weight of the right hand swing motor is **64 kg (140 lb)**.

4. Remove the O-ring seal from the right hand swing motor.

NOTE: The following steps are for the installation of the right hand swing motor.

5. Make sure the mating surfaces of the right hand swing motor and the right hand swing drive are thoroughly clean.

6. Check the condition of the O-ring seal used on the right hand swing motor and in the hose assemblies that connect to the right hand swing motor. If any of the seals are damaged, use new parts for replacement.

7. Install the O-ring seal on the right hand swing motor.

8. Install the right hand swing motor in the reverse order of removal.

NOTICE

Make sure the right hand swing motor is filled with clean hydraulic oil to the fill port before operation.

9. Fill the hydraulic oil tank with oil to the correct level. Refer to the 350 & 350 L Excavators Operation & Maintenance Manual for the correct filling procedure.

End By:

a. install swing control valve

Disassemble Swing Motor (Left & Right)

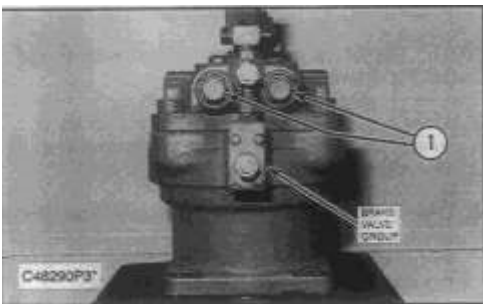
Tools Needed		A
6V-3009	Crossblock	1
1P-0074	Slide Hammer Puller	1
	Threaded Rod - M8 x 1.25 254 mm (10.0 in) Long	2
5P-7970	Nut	4
9M-1974	Washer	4

Start By:

a. remove swing motor (left or right)

NOTE: The disassembly procedure which follows is for both the left and right swing motors.

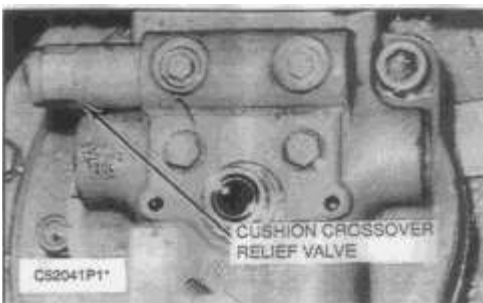
1. Make sure the outside of the swing motor is clean and free of dirt and debris prior to disassembly.



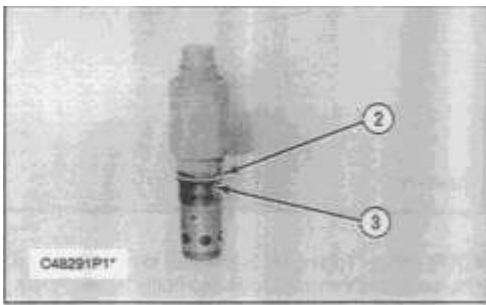
Typical Example

2. Put the swing motor on wood blocks as shown. The weight of the swing motor is **64 kg (140 lb)**. Put identification marks on each relief valve assembly (1) as to its location in the swing motor. Remove two relief valve assemblies (1).

3. Remove the brake valve group from the body of the swing motor.

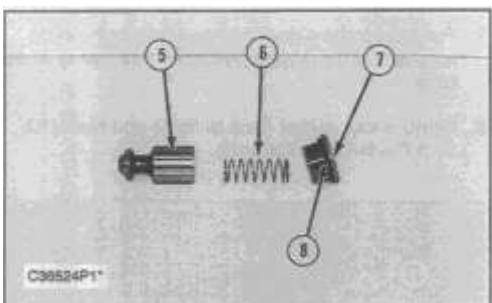
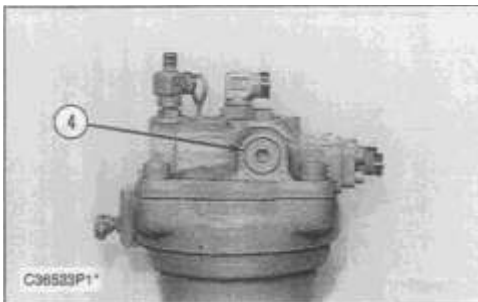


4. Remove the cushion crossover relief valve group from the head of the swing motor.



5. Remove O-ring seal (3) and back-up ring (2) from each relief valve assembly.

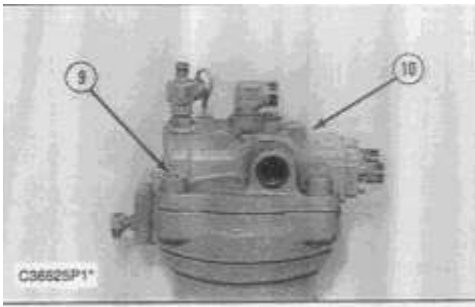
NOTE: For the disassembly procedure for relief valve assemblies (1), see Steps 25a through 25m. For the disassembly procedure for the brake valve group, see Steps 26a through 26e. For the disassembly of the cushion crossover relief valve group, see Steps 27a through 27d.



NOTICE

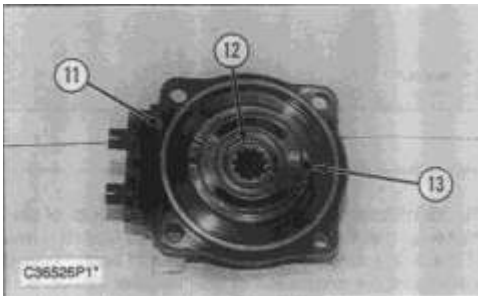
Put identification marks on the components of each make-up valve (4) as they are removed from the head of the swing motor. The components of each make-up valve must be reinstalled in their original locations.

6. Remove two make-up valves (4) from the head of the swing motor. Remove plugs (7), springs (6) and valves (5). Remove O-ring seal (8) from each plug (7).

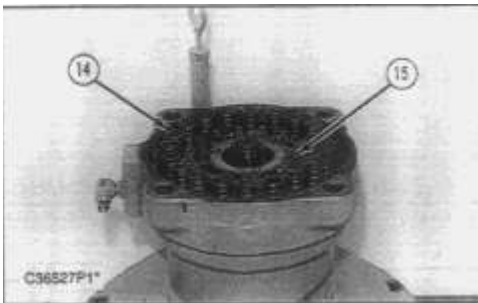


7. Put an alignment mark on head (10) so it can be reinstalled in its original position on the swing motor body.

8. Remove four socket head bolts (9) and head (10) from the swing motor body.

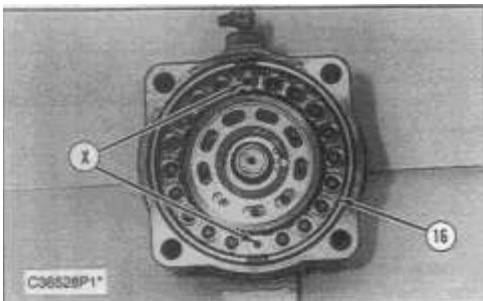


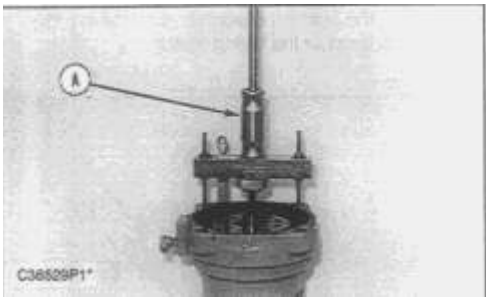
9. Remove O-ring seal (11) and bearing (12) from the head. If necessary, remove two pins (13) from the head.



10. Remove 20 springs (14) from the piston.

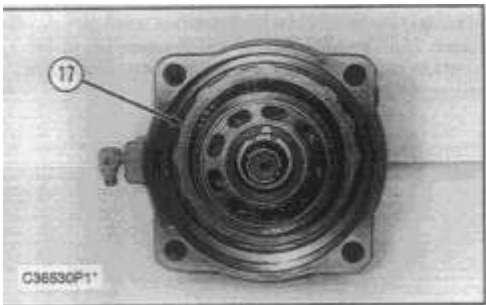
11. Remove plate (15) from the barrel assembly.



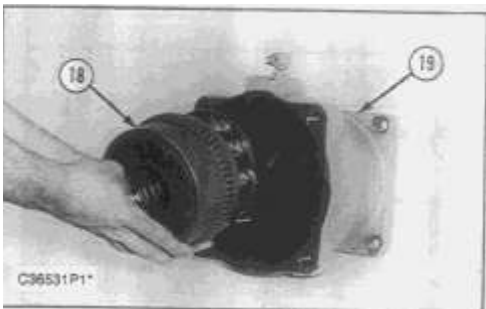


NOTE: When Tooling (A) is installed to remove piston (16), install the threaded rods into holes (X) as shown.

12. Mark the position of piston (16) in the swing motor body for assembly purposes. Install Tooling (A) in piston (16) as shown. Remove piston (16) from the swing motor body with Tooling (A).



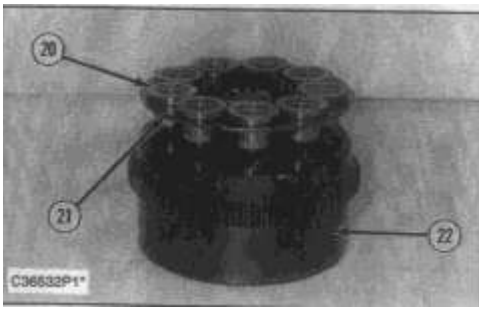
13. Remove three separator plates and two friction plates (17) from the piston.



NOTICE

During removal of barrel assembly (18) from swing motor body, do not let the components come apart. All parts in the barrel assembly must be reinstalled in their original locations.

14. Put the swing motor on its side as shown. Remove barrel assembly (18) from the shaft in body (19).



15. Disassemble barrel assembly (18) as follows:

a. Put identification marks on nine piston assemblies (20) as to their location in plate (21) and barrel (22). Remove nine piston assemblies (20) and plate (21), as a unit, from barrel (22). Separate the piston assemblies from the plate.

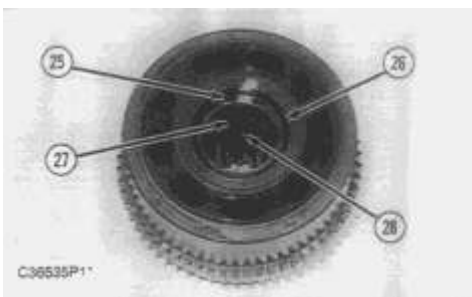


b. Remove bushing (23) from the barrel. Remove the spacer from the bushing.



NOTE: There are 12 pins (24) in barrel (22). Two pins are used in each hole location.

c. Remove 12 pins (24) from the barrel.



 **WARNING**

There is spring force against spacer (26). When retaining ring (25) is removed, the spring force will be released. To prevent possible personal

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