

Product: EXCAVATOR  
Model: 225 EXCAVATOR 51U  
Configuration: 225 EXCAVATOR 51U00001-00589 (MACHINE)

## Disassembly and Assembly 225 EXCAVATOR VEHICLE SYSTEMS

Media Number -SEN7907-00

Publication Date -01/02/1979

Date Updated -12/10/2001

### Swing Drive

SMCS - 5459-12; 5459-15; 5459-16; 5459-11

### Remove Swing Drive

Tools Needed		A
7M7474	Engine Support	2
1A5822	Bolt	2

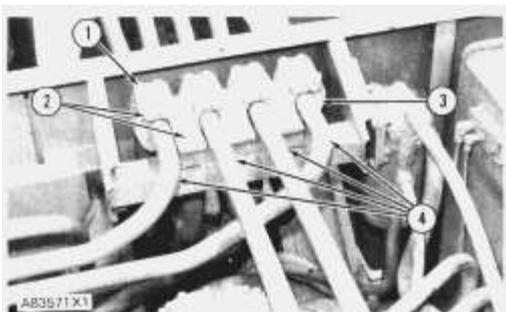
start by:

a) release oil pressure in main system

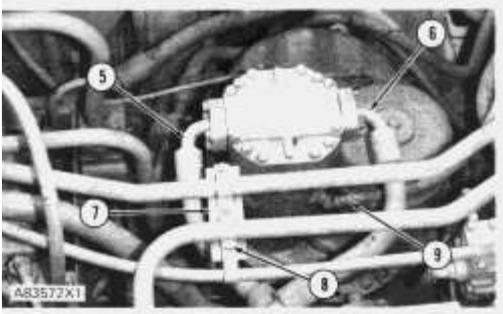


**WARNING**

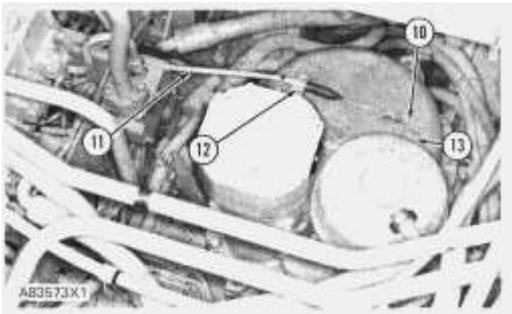
**Do not disconnect or remove any oil lines until all oil pressure in main system has been released.**



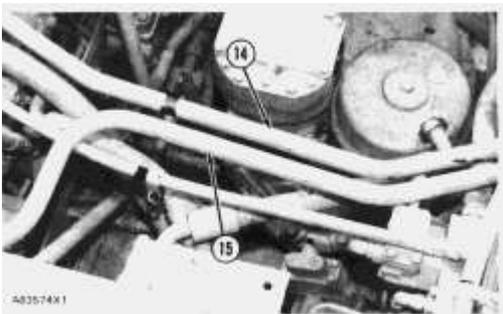
1. Remove bolts (2), then remove hose clamp (3).
2. Remove bolts (1) to remove hoses (4).



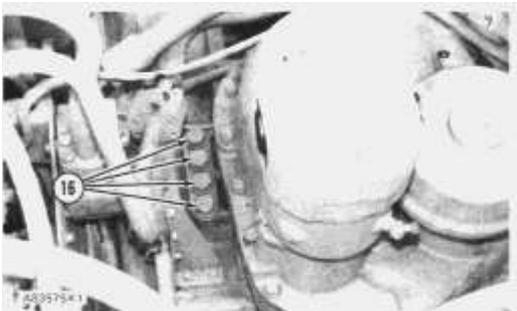
3. Disconnect hoses (5), (6) and (9) from the motor.
4. Remove bolts (8), then remove bracket (7) from the oil lines.



5. Remove bolt (10) to disconnect linkage (11) from lever (13). Remove two bolts (12) that hold the linkage and spacer to the swing drive cover.



6. Remove oil lines (14) and (15) from three stem and five stem control valves.



7. Remove four bolts (16) from each side of the swing drive.



8. Remove three bolts from the swing drive case. Install one 1/2"-13 NC forged eyebolt in the case. Install tooling (A). Fasten a hoist and lift the swing drive until the pinion on the output shaft is above the hole in the upper frame. Remove the swing drive (17). The weight of the swing drive is 1100 lb. (495 kg).

## Install Swing Drive

	Tools Needed	A
7M7474	Engine Support	2
1A5822	Bolt	2

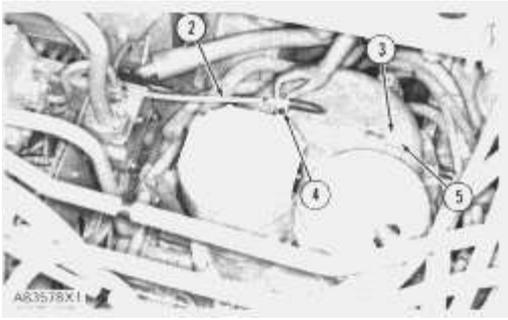


1. Install one 1/2"-13 NC forged eyebolt in the swing drive case. Install tooling (A). Put 2P2506 Anti-Seize Compound on the finished surfaces of the cartridge (output shaft housing). Fasten a hoist and put the swing drive (1) in position on the upper frame.

**NOTE:** Turn the swivel brake drum to get alignment of the pinion and swing gear.

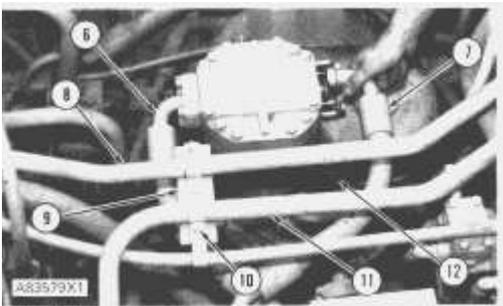
2. Install the four bolts on each side of the swing drive. Tighten the bolts to a torque of  $560 \pm 60$  lb.ft. ( $764 \pm 80$  N·m).

3. Remove tooling (A) and the eyebolt. Install the three bolts in the swing drive case. Tighten the bolts to a torque of  $100 \pm 10$  lb.ft. ( $135 \pm 14$  N·m).

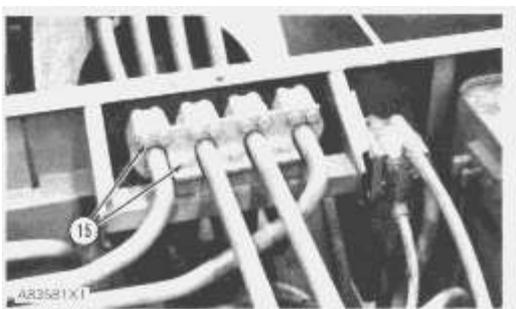
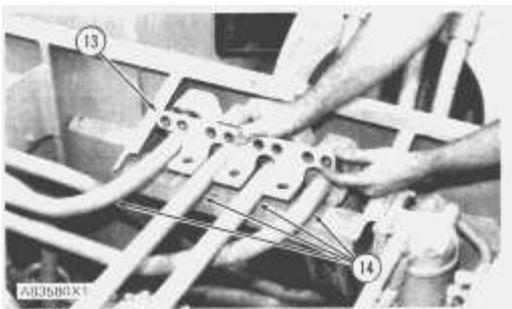


4. Put linkage (2) in position on the swing drive cover with spacer, clamp (4) and the two bolts that hold it.

5. Connect linkage (2) to lever (5) with the bolt (3) that holds it.



6. Connect hoses (6), (7) and (12) to the swing motor. Install three and five stem control valve lines (8) and (11) with bracket (9) and the bolts (6) that hold them.



7. Put the four hoses (14) in position on bracket, then install hose clamp (13) and bolts (15) that hold it.

8. Fill the swing motor with SAE 10W hydraulic oil.

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**NOTICE**

Do not start the engine without the swing motor filled with oil.

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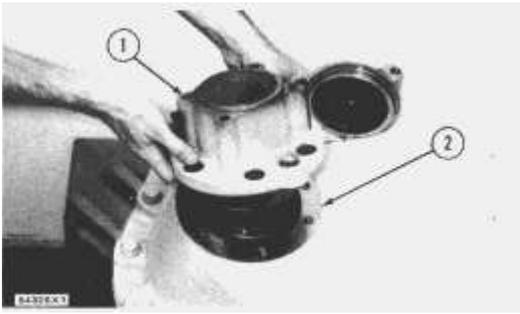
## Disassemble Swing Drive

Tools Needed		A	B	C	D	E	F	G	H	I	J
1P2420	Tran. Repair Stand	1									
8B7548	Push Puller		1		1	1					
8H684	Ratchet Box Wrench		1		1	1					
8B7554	Bearing Cup Pulling Attachment		1	1							
5F7345	Screw			1							
8B7560	Step Plate			1	1	1				1	1
8H663	Bearing Pulling Attachment				1						
8B7550	Leg					2					
1P1784	Hydraulic Cylinder Repair Stand						1				
9S8900	Cylinder Group							1			
9S5800	Pump Group							1			
5F9888	Adapter							1			
5F9892	Pin							1			
5F9882	Adapter							1			
2P8348	Adapter							1			
5F9306	Arm							2			
2B4206	Yoke Assembly							1			
1H3107	Push Puller									1	1
1H3110	Bearing Pulling Attachment									1	1
1H3108	Leg										2
5S4275	Seal Installer								1		

start by:

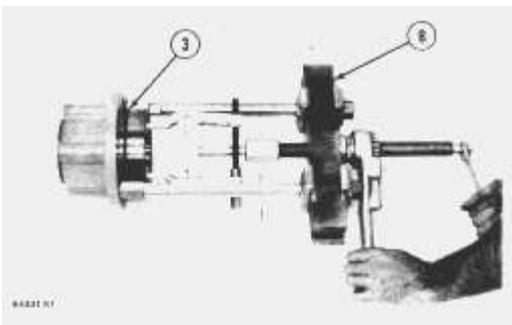
- a) remove swing drive
- b) remove swing motor
- c) disassemble swing brake

**1.** Fasten a hoist and put the swing drive in position on stand (A). The weight of the swing drive is 900 lb. (408 kg).

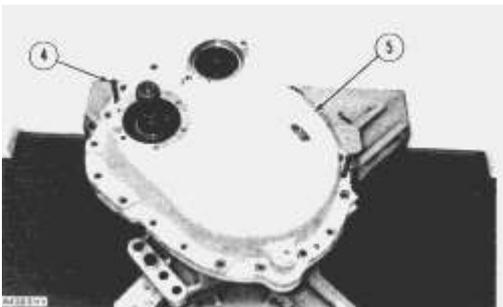


**2.** Remove the six bolts from bearing cage (1).

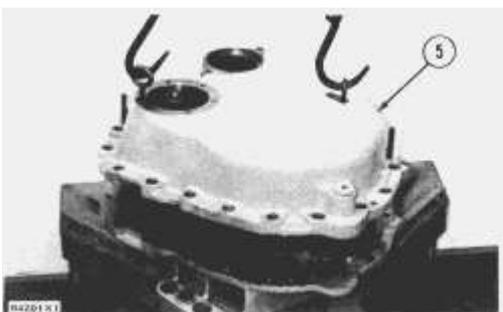
**3.** Install two 1/2"-13NC forcing screws and remove bearing cage and shims (2).



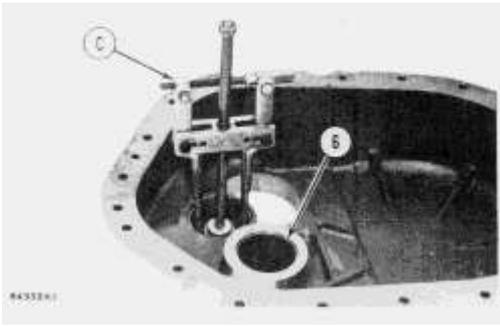
**4.** Install tooling (B) and remove the bearing cup. Remove O-ring seal (3) and lip-type seal from the cage.



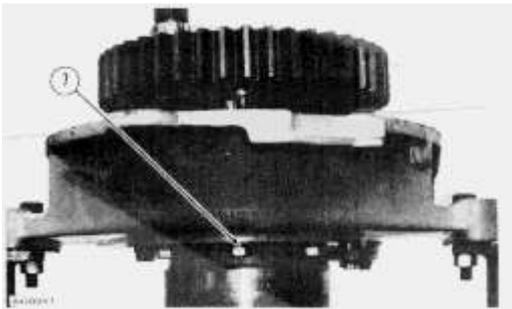
**5.** Remove the bolts from the cover. Install two 1/2"-13NC forcing screws (4) and loosen cover (5) from case.



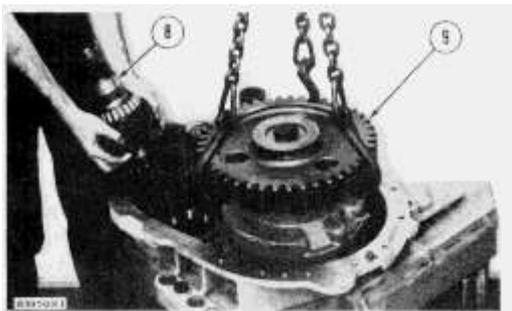
**6.** Install a 1/2"-13NC forged eyebolt and a 3/8"-16NC forged eyebolt in the cover. Fasten a hoist and remove cover (5). The weight of the cover is 160 lb. (73 kg). Remove the oil from the case.



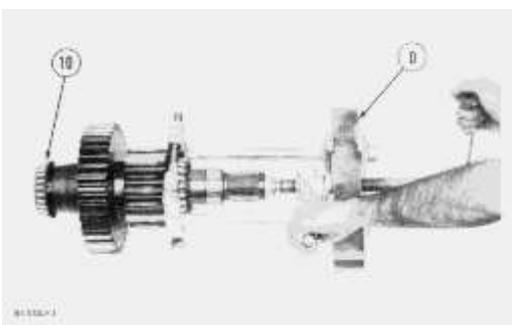
7. Install tooling (C) and remove the bearing cup from cover. Remove bearing cup (6) with a hammer and punch.



8. Remove the eight bolts (7).

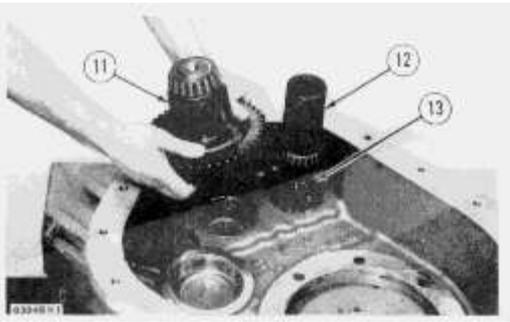


9. Fasten a hoist to gear (9). Lift the output shaft until gear (8) can be removed. Remove the gear. Remove the output shaft from the case. The weight of the output shaft is 350 lb. (159 kg).

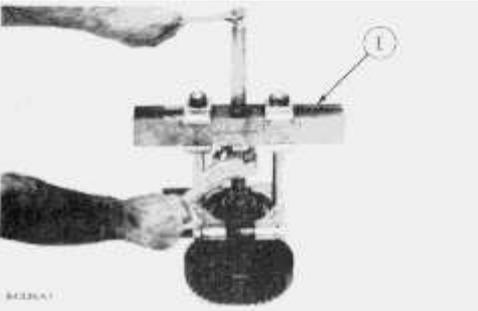


10. Install tooling (D) and remove the bearing cone from gear (8).

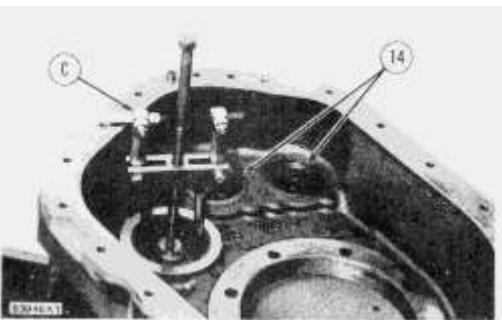
11. Install tooling (E) and remove bearing cone (10) from the gear.



12. Remove gear (11), coupling (12) and pinion (13) from the case.

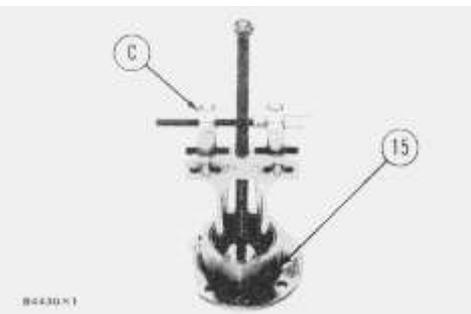


13. Install tooling (E) and remove the bearing cones for gear (11) and pinion (13).



14. Install tooling (C) and remove the bearing cup from the case.

15. Remove cages (14) and the shims from the case.



16. Install tooling (C) and remove the bearing cups from the cages. Remove O-ring seals (15).



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