

GROUP 6 TRAVEL DEVICE (TYPE 1)

1. REMOVAL AND INSTALL

1) REMOVAL

- (1) Swing the work equipment 90° and lower it completely to the ground.
- (2) Operate the control levers and pedals several times to release the remaining pressure in the hydraulic piping.
- (3) Loosen the breather slowly to release the pressure inside the hydraulic tank.

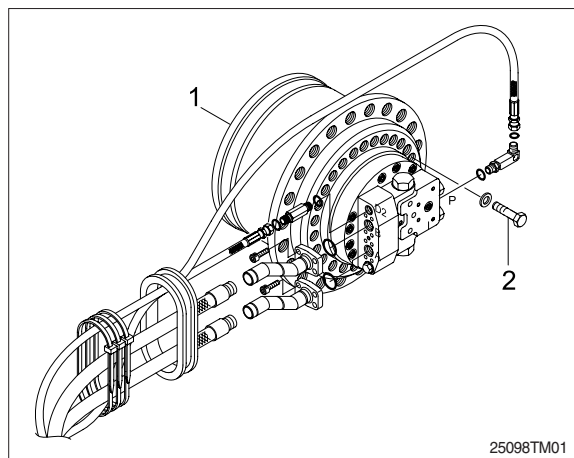
▲ Escaping fluid under pressure can penetrate the skin causing serious injury.

※ When pipes and hoses are disconnected, the oil inside the piping will flow out, so catch it in oil pan.

- (4) Remove the track shoe assembly.
For details, see **removal of track shoe assembly**.
- (5) Remove the cover.
- (6) Remove the hose.
※ Fit blind plugs to the disconnected hoses.
- (7) Remove the bolts and the sprocket.
- (8) Sling travel device assembly (1).
- (9) Remove the mounting bolts (2), then remove the travel device assembly.
· Weight : 276 kg (608 lb)

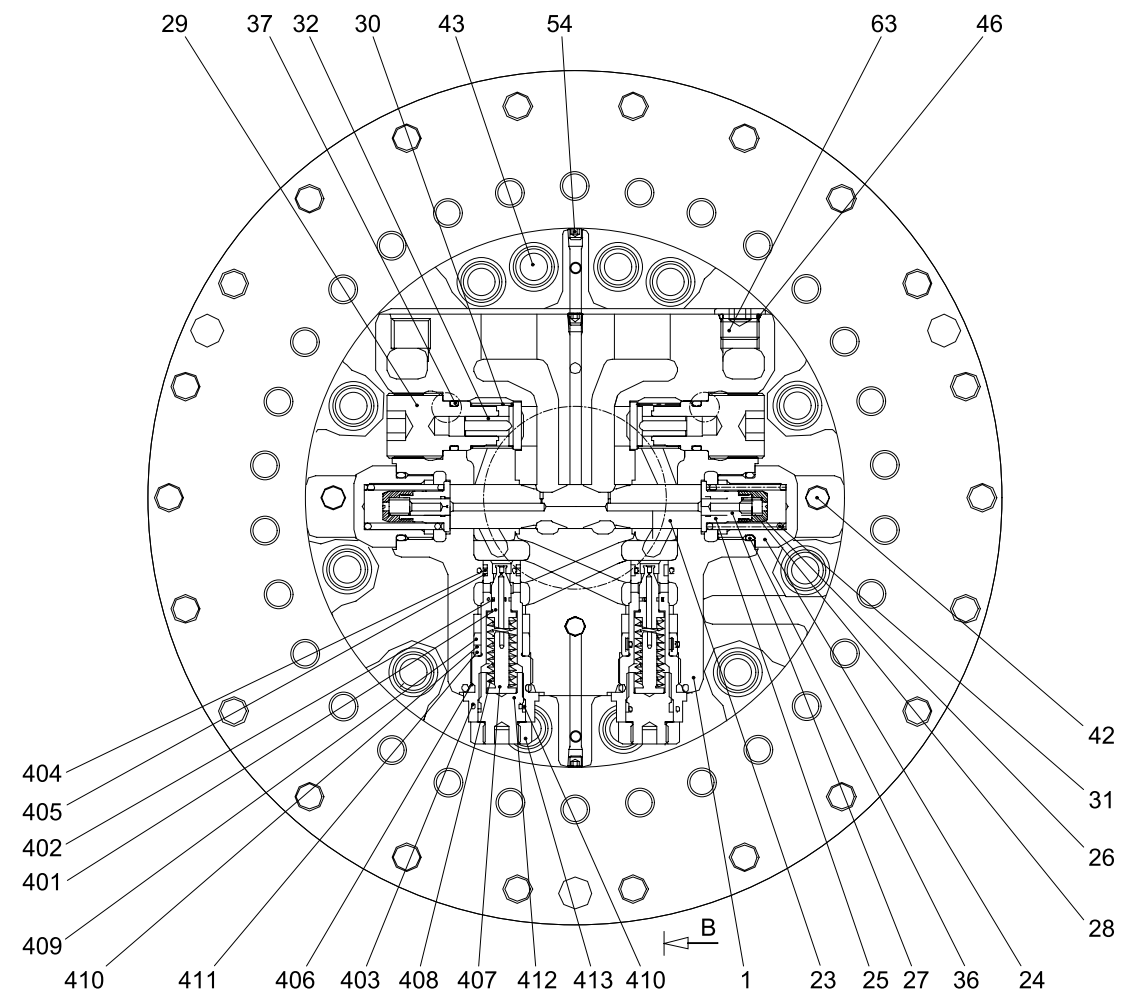
2) INSTALL

- (1) Carry out installation in the reverse order to removal.
- (2) Bleed the air from the travel motor.
 - ① Remove the air vent plug.
 - ② Pour in hydraulic oil until it overflows from the port.
 - ③ Tighten plug lightly.
 - ④ Start the engine, run at low idling, and check oil come out from plug.
 - ⑤ Tighten plug fully.
- (3) Confirm the hydraulic oil level and check the hydraulic oil leak or not.

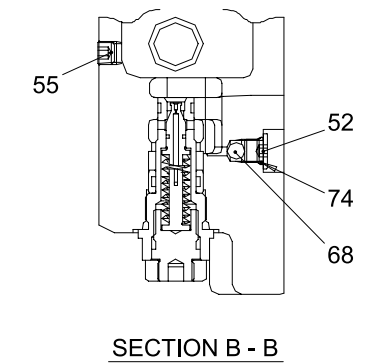
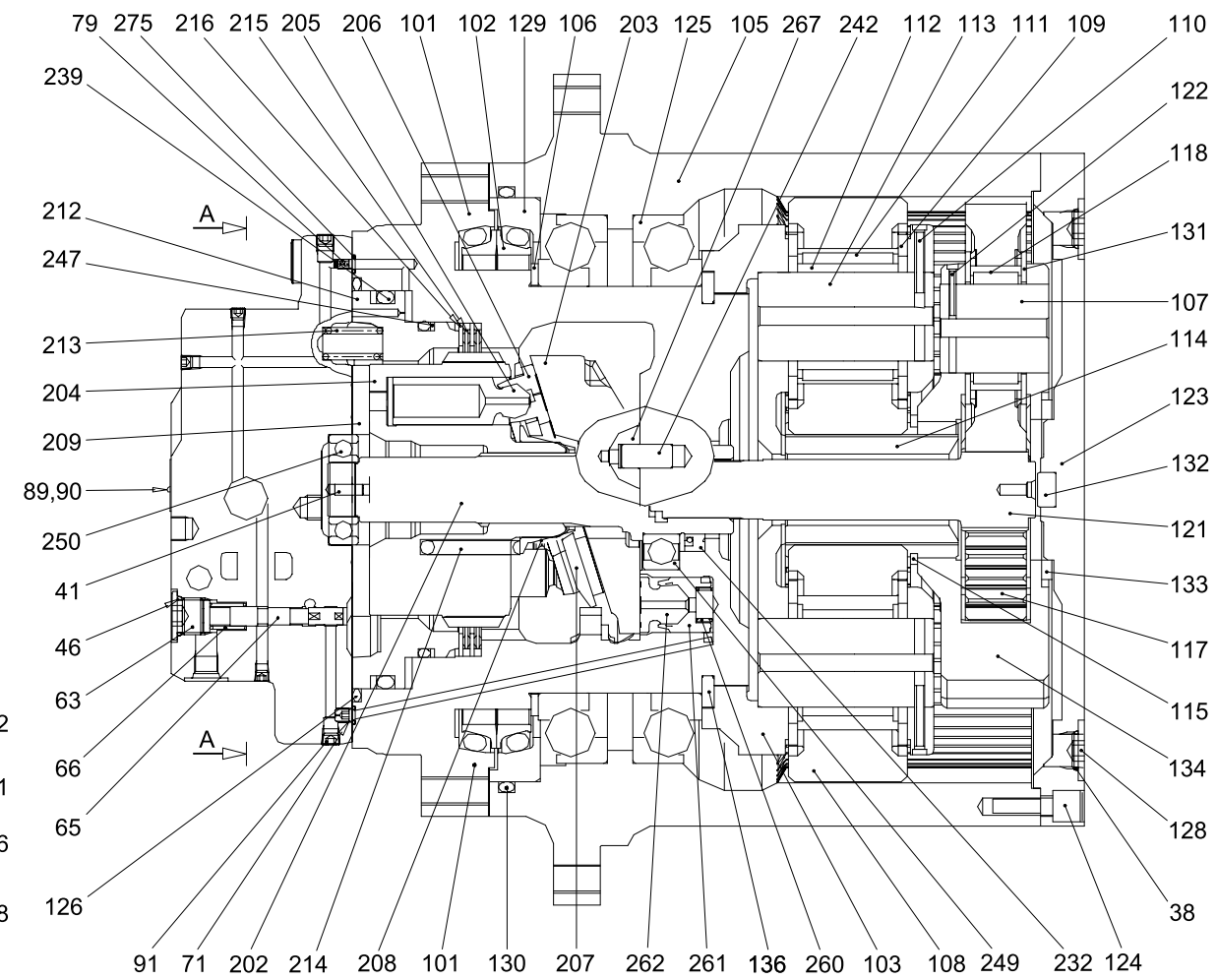


2. TRAVEL MOTOR

1) STRUCTURE



SECTION A - A



SECTION B - B

1	Rear flange	46	O-ring	106	Distance piece	212	Piston (parking)	275	O-ring
23	Main spool	52	Plug	107	Shaft bearing (R)	213	Spring (parking)	401	Plunger
24	Plug (for main)	54	Plug	108	Planetary gear (F)	214	Spring (cylinder)	402	Piston seal
25	Stopper-A	55	Plug	109	Thrust washer (F)	215	Friction plate	403	Body
26	Stopper-B	63	Plug	110	Pin spring	216	Mating plate	404	Back up ring
27	Spool	65	Spool (2 speed)	111	Needle bearing	232	Oil seal	405	O-ring
28	Spring	66	Spring (2 speed)	112	Floating bushing	235	O-ring	406	O-ring
29	Plug (for check)	68	Steel ball	113	Shaft bearing (F)	239	O-ring	407	Spring retainer
30	Check valve	71	Orifice	114	Sun gear	242	Parallel pin	408	Spring
31	Spring (for main)	74	O-ring	115	Snap ring	247	Back up ring	409	Piston
32	Spring (for check)	79	Filter	117	Planetary gear (R)	248	Back up ring	410	O-ring
36	O-ring	91	Plug	118	Needle bearing	249	Ball bearing	411	Back up ring
37	O-ring	101	Spindle	121	Driver gear	250	Ball bearing	412	Adjust plug
38	O-ring	102	Floating seal	122	Pin spring	260	Spring (2 speed)	413	Lock nut
41	Parallel pin	103	Carrier No.2	123	Cover	261	Piston (2 speed)		
43	Socket bolt	105	Hub	124	Socket bolt	262	Shoe (2 speed)		
				125	Angular ball bearing	267	Pivot		

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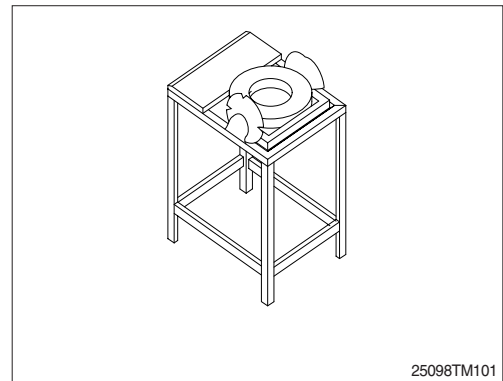
2) TOOLS

(1) Standard tools

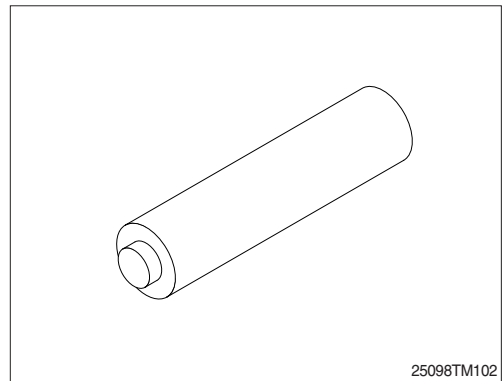
No.	Name	Description/Size	Qty
1	Hexagon wrench (JIS B 4648)	6 (M8) (PT1/4), 8 (M10)	each 1
		10 (M12) (PF1/2)	each 1
		14 (M16), 4 (M6)	1
2	Socket wrench	-	1
3	Torque wrench	Nominal 30 kgf · m dial type	1
		Nominal 90 kgf · m dial type	1
4	Adapter for torque wrench	Socket 22, 30, 32, 41, 40	each 1
		Bar 5, 6, 8, 10, 14	each 1
5	Extension bar (JIS B 4637)	150 mm	1
6	Hammer	12	1
7	Plastic hammer	L=300	1
8	(-) driver	150 mm	1
9	Snap ring plier	For shaft, For hole	1
10	Hanger	Weight : over 300 kgf	1
		Eye bolt (M16)	2
		Eye bolt (M10)	2
		Eye bolt (PF 1/2)	2
		Wire	1
11	Press	Press capacity above 200 kgf	1
12	Compressed air	3~5 kgf/cm ² , nozzle	1
13	Vessel	General vessel : W450 × D300 × H120	2
14	Heating vessel	Heating capacity : over 100 °C	1
		Volume : 500 × 500 × 500	
15	Depth micro-meter	Measuring range : 0.04 ~ 0.3 mm	1
16	Air hammer	BRH-8 (compressed air 5~6 kgf/cm ²)	1
17	Sealant	Silicone rubber (780-RTV)	1

(2) Special tools

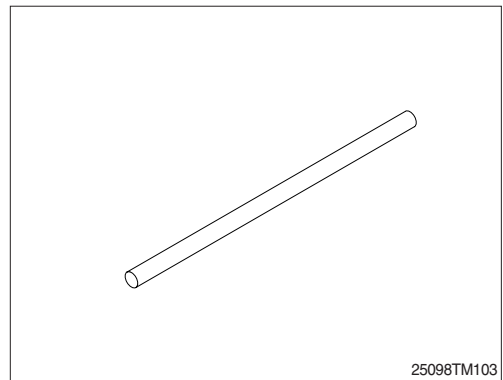
① Inversion working bench



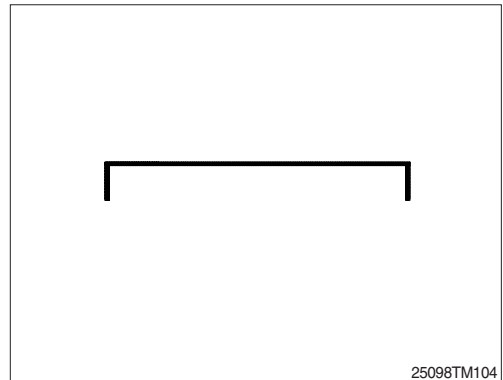
② Retainer (II)



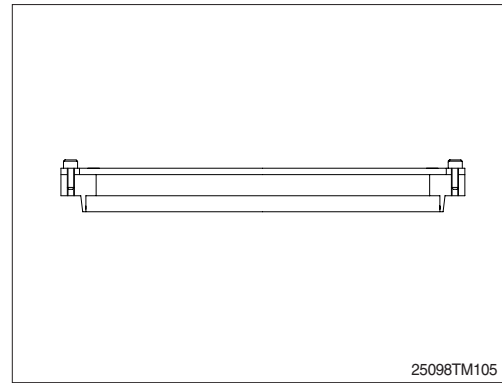
③ Steel bar



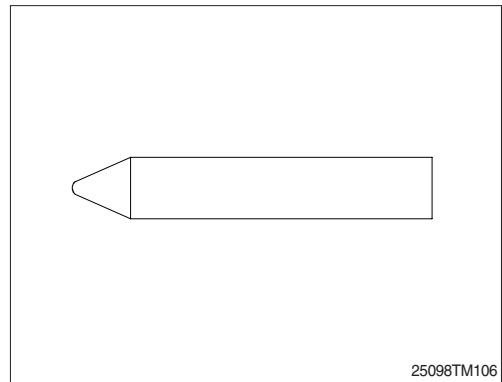
④ Pressurize jig



⑤ Floating sealing



⑥ Caulking jig



3) TIGHTENING TORQUE

Item No.	Parts name	Size	Qty	Tightening torque	
				kgf · m	lbf · ft
24	Plug	M36×1.5	2	45 ± 9	325 ± 65.1
26	Plug	M26×1.5	2	26 ± 4	188 ± 28.9
43	Socket bolt	M16×2.0	12	25.7 ± 4	186 ± 28.9
52	Plug	PF 1/4	2	3.0 ± 0.5	21.7 ± 3.6
54	Plug	NPTF 1/16	7	1.0 ± 0.25	7.2 ± 1.8
55	Plug	PT 1/4	2	3.0 ± 0.5	21.7 ± 3.6
63,128	Plug	PF 1/2	7	10 ± 2	72.3 ± 14.5
124	Socket bolt	M10×1.5	16	5.9 ± 1	42.7 ± 7.2
412	Adjust plug	M8	2	12 ± 1.5	86.8 ± 10.8

3. DISASSEMBLY

3.1 GENERAL PRECAUTIONS

- 1) Spread rubber or vinyl cover on the work bench.
- 2) When disassembling the travel motor, provide a match mark on the mating face of each part.
- 3) Arrange the detached parts to prevent them from being damaged or lost.
- 4) The disassembled seals must be replaced with new ones as a rule even if they are free from damage. For disassembly, therefore, prepare new seals in advance.

3.2 DISASSEMBLY PROCEDURE

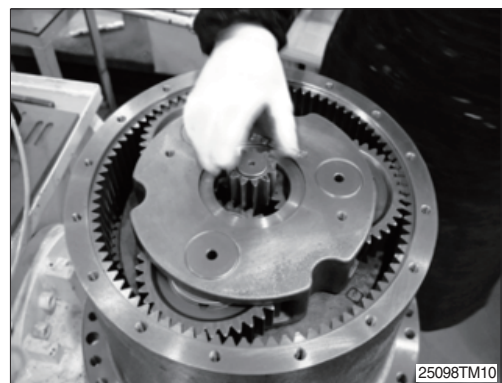
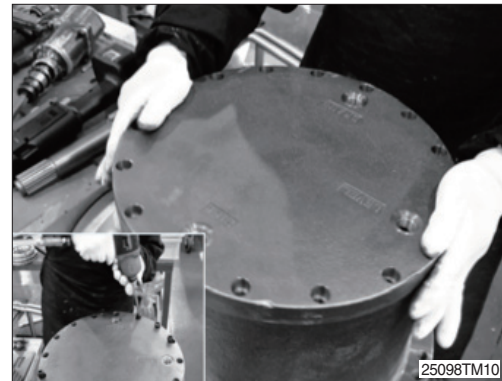
- 1) When inspecting or repairing the travel motors, use the disassembling procedures described below.
- 2) Numerals in brackets () following the part name denote the item numbers used in the structure drawing at page 8-84.
- 3) Prior to disassembly, install the travel motor on an inversion working bench.

3.3 DISASSEMBLING ORDER

1) DISASSEMBLING THE REDUCTION GEAR PART

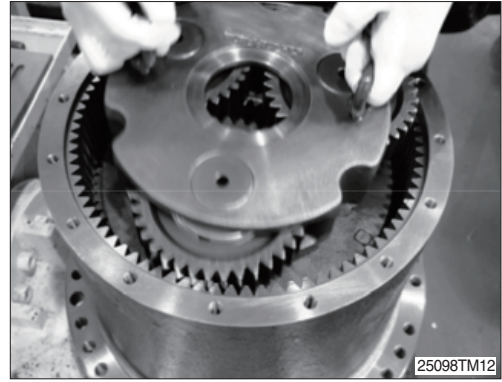
- (1) Remove plugs (128, 3EA) and drain the reduction gear oil.
- (2) Loosen socket bolts (124, 16EA) and remove the cover (123).
 - ※ Remove the cover (123), after hook it, fit the eye bolt in a screw hole for use of the plug (128). If it's impossible, please remove the cover using the rod.
 - ※ You can have difficulty removing it because loctite is spread in the socket bolt (124).
 - ※ Tools
 - Hexagon wrench 8, 10

- (3) Remove drive gear (121).



(4) Remove carrier No.1 assembly.

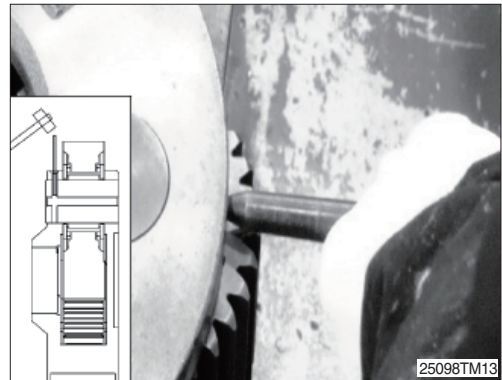
- ※ Carrier no.1 assembly consists of planetary gear (117), needle bearing (118), shaft bearing (107), carrier (134), thrust washer (131) and spring pin (122).



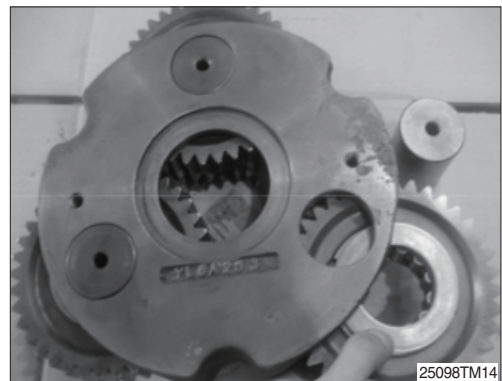
(5) Disassembling the carrier No.1 assembly.

① Drive spring pins (122) into shaft bearing (R) (107).

- ※ Please don't remove if repair isn't necessary.
- ※ Do not reuse the spring pin (122).

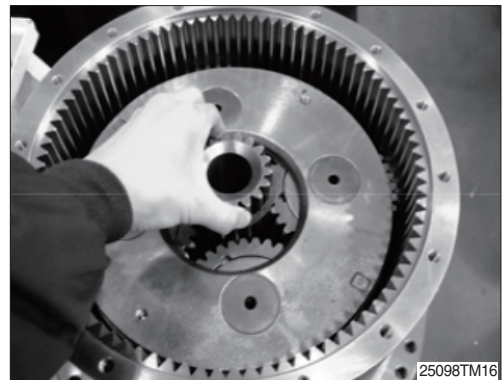


② Remove shaft bearing (R) (107), planetary gears (R) (117), thrust washer (R) (131), needle bearings (118) and thrust washer (R) (131).



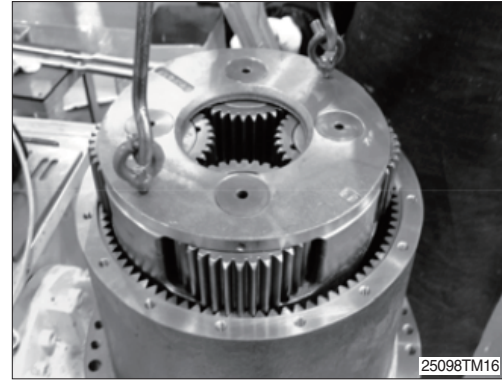
(6) Remove sun gear (114).

- ※ Snap ring (115) is assembled in sun gear (114). Don't remove it if not necessary.



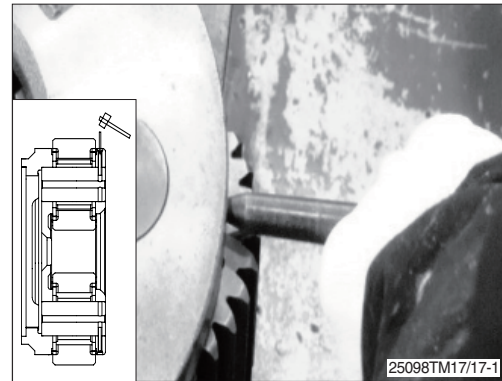
(7) Remove the carrier No.2 assembly.

- ※ Remove it using a crane after M10 eye bolt is assembled.

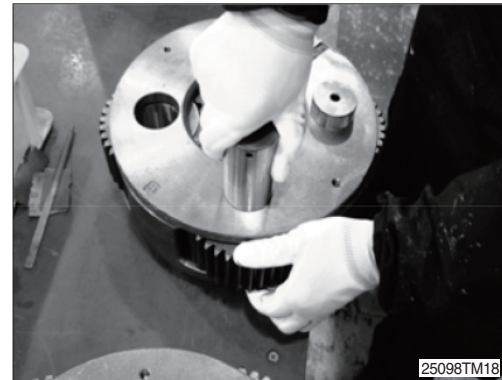


(8) Drive spring pins (110) into shaft bearing (F) (113)

- ※ Do not reuse the spring pin (110).

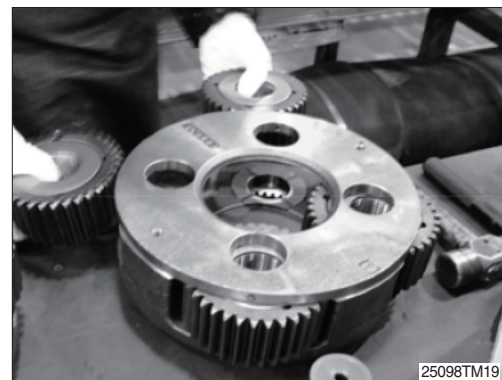


(9) Remove shaft bearing (113, 4EA).

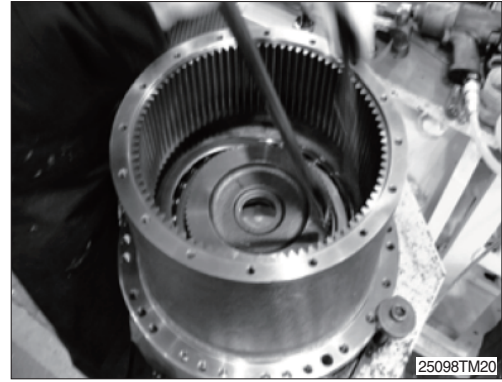


(10) Remove the thrust washer (F) (109), planetary gears (F) (108), needle bearings (111) and floating bushing (112) from carrier No.2 (103).

- ※ Each part consists of the 1st.

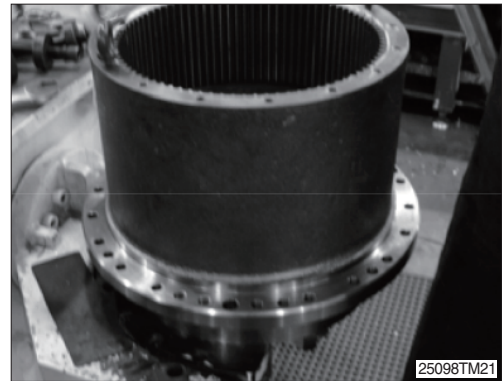


(11) Take off lock shim plate (136) by hammering on chisel or on similar tool placed at parting surface.

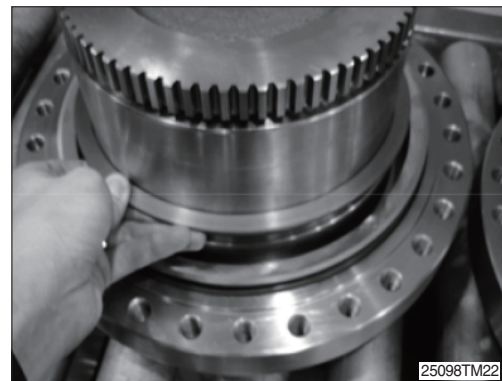


(12) Remove the hub (105) from the spindle (101).

- ※ Remove it using a crane after M16 eye bolt is assembled at the hub (105).

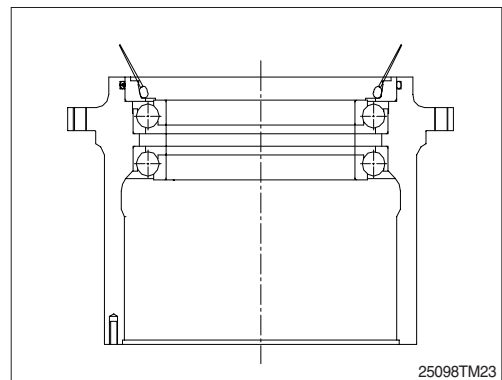


(13) Remove the distance piece (106) from the spindle (101).



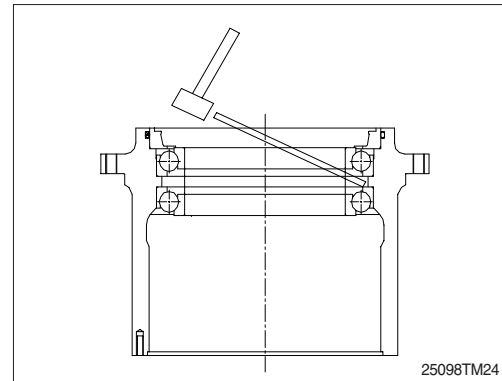
(14) Remove the floating seal (102) from the hub (105) and the spindle (101).

- ※ User can remove easily if using (-) driver.



(15) The sealing (129), the angular bearing (125, 2EA), the O-ring (130) are assembled on the hub (105) with the floating seal (102).

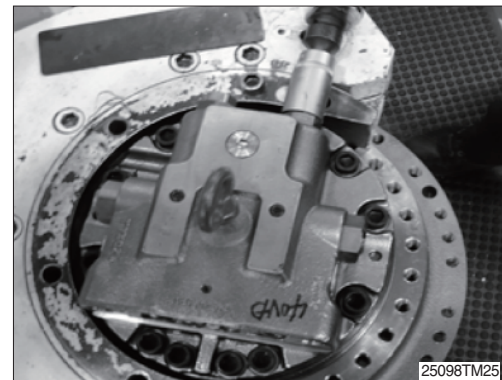
- ※ Don't remove if not necessary.
In case of the removal, be careful not to scratch using aluminum rod or hammer.



2) DISASSEMBLING THE HYDRAULIC MOTOR PART

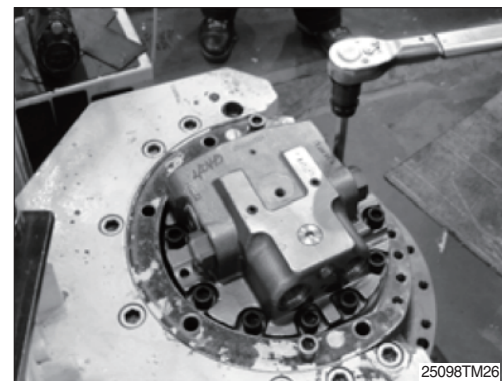
(1) Remove the relief valve (2EA) from rear flange (1).

- ※ Tools
 - Hexagon socket 32
 - Torque wrench



(2) Remove hexagon socket head bolts (43) from the rear flange (1).

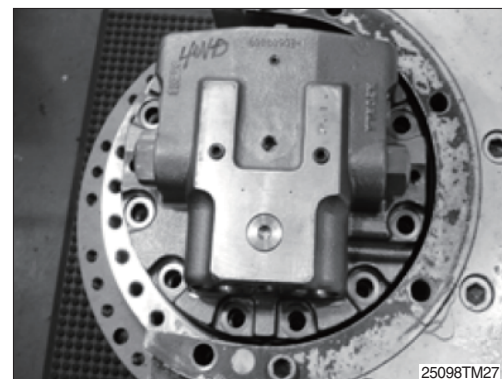
- ※ Tools
 - Hexagon wrench 14



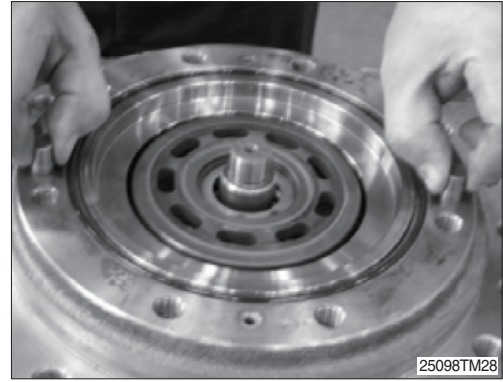
(3) Remove the rear flange (1) from the spindle (101).

(4) Remove the spring (213, 10EA) from the rear flange [1].

- ※ Remove the rear flange (1) carefully after taken using hands. Be careful not to detach the timing plate (209) and the spring (213) if twisted or beated by constraint.

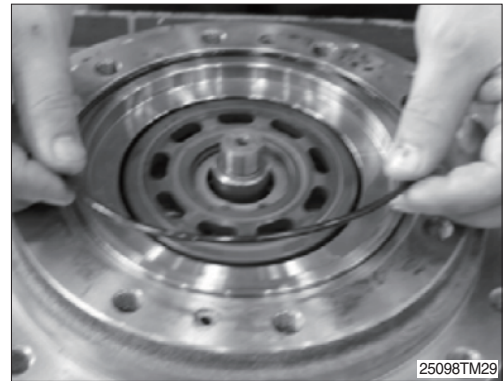


(5) Remove the parallel pin (42) from the spindle (101).



(6) Remove the O-ring (126) from the spindle (101).

※ Do not reuse the O-ring (126).

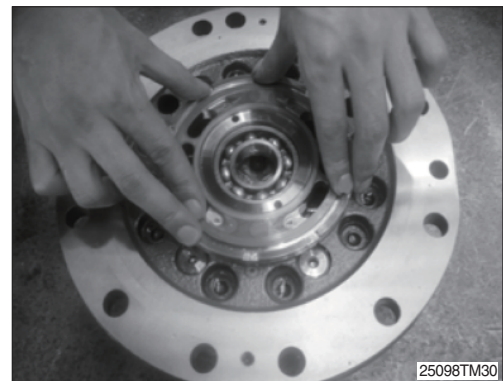


(7) Disassembling the rear flange (1) part

① Remove the timing plate (9) from the rear flange (1).

※ When removing the timing plate, user can have difficulty of the removal due to the close adhesion of rear flange (1) and oil. Remove it after fitting a rod through the hole which is used when a casting is detached.

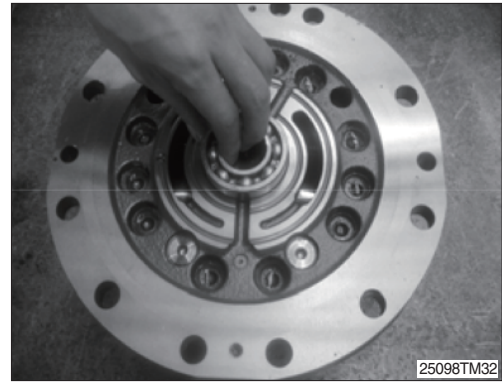
※ Be careful of the leakage due to both surface scratch if using a sharp tool.



② Remove the parallel pin (41) from the rear flange (1).

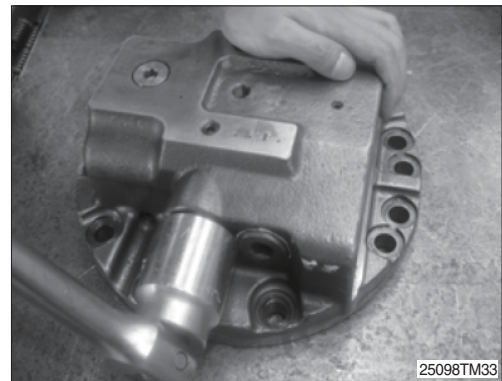


- ③ Remove the ball bearing (250) from the rear flange (1).

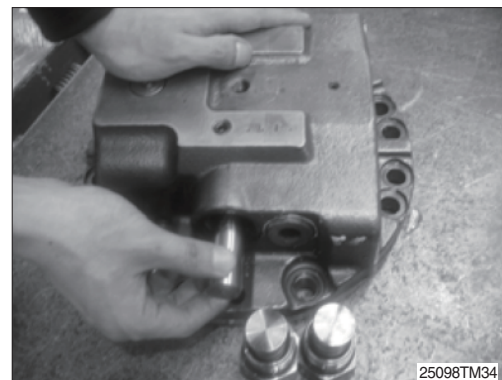


Disassembling the spool

- ① Remove two plugs (24) from the rear flange (1).
- ※ User can work easily if sub-disassembly was done on the reversal table.
 - ※ Tools
 - Hexagon socket 41
 - Torque wrench

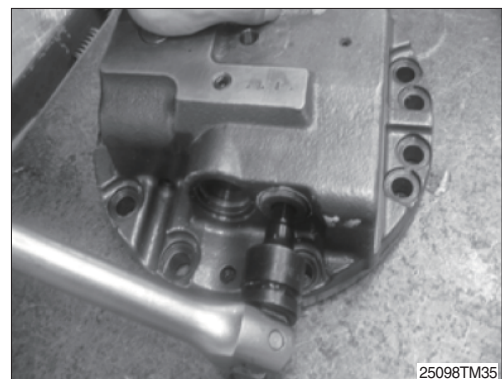


- ② Take out two springs (31), two stopper (25, 26) from the rear flange (1).
- ③ Remove the spool (23) from the rear flange (1).
- ※ Be careful not to damage the outer surface of the spool (23) and the sliding surface of the rear flange (1).
 - ※ Since the rear flange (1) and the spool (23) are of the selective fitting type, replace them together as a kit even if only one of the two parts is damaged.

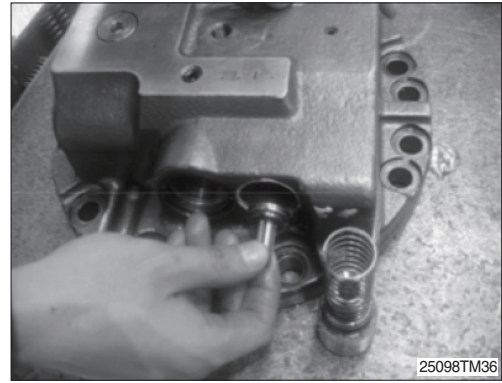


Disassembling the check valve

- ① Remove two plugs (29) from the rear flange (1).
- ※ User can work easily if sub-disassembly was done on the reversal table.
 - ※ Tools
 - Hexagon wrench 14

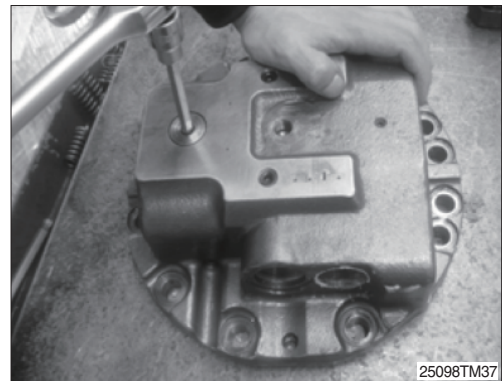


- ② Remove the spring (32, 2EA), valve (30, 2EA) from rear flange (1).

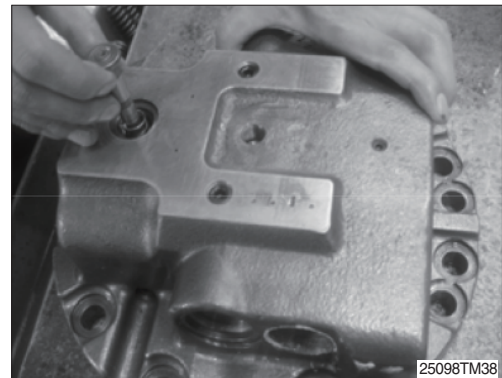


Disassembling the two speed valve

- ① Remove the plug (63) from the rear flange (1).
- ※ User can work easily if sub-disassembly was done on the reversal table.
 - ※ Tools
 - Hexagon wrench 10



- ② Remove the spool (65) and spring (66) from rear flange (1).



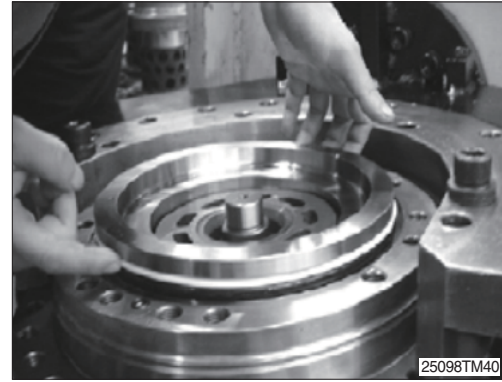
(8) Disassembling the parking brake

- ① Remove the piston (212) by injecting compressed air from the parking brake access hole in the spindle (101).
- ※ Use the protection cover on the upper part of spindle (101) when users put the pressed air into suddenly. Otherwise part damage and accident might go on because the piston (212) is rushed out of the spindle (101).



- ② Remove the O-rings (235, 239) and backup rings (247, 248) from the piston (212).

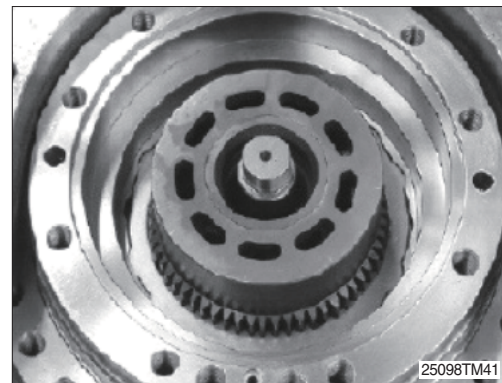
※ Do not reuse O-rings (235, 239) and backup rings (247, 248) after removal.



(9) Disassembling the hydraulic motor part

- ① Lay the travel motor body on the side.
② Drain out the oil from the travel motor.

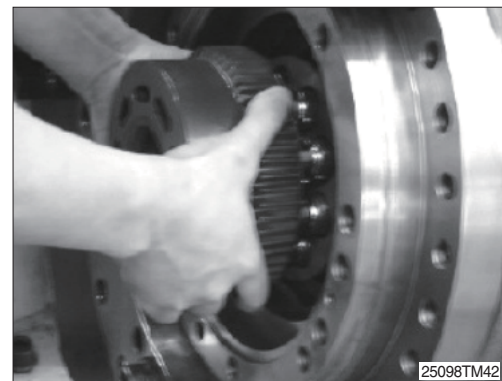
※ Place an oil receptacle under the travel motor to receive the oil flowing out as the motor is being laid on the side.



- ③ Hold the cylinder block (204) with both hands, and remove it from the shaft (202).
④ Remove the mating plates (216) and friction plates (215) from the cylinder block (204).

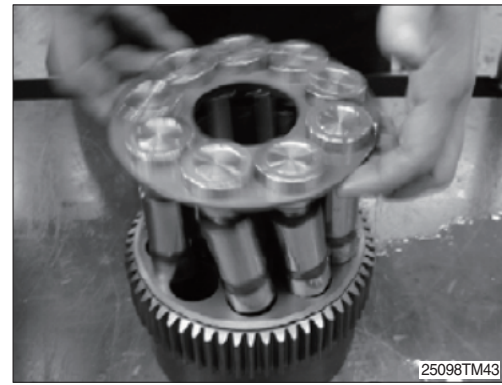
※ Before removal, hold the cylinder block (204) with both hands and turn it two to three times in a clockwise and a counterclockwise direction alternately to detach the shoe (206) from the swash plate (203).

※ Be careful that if an attempt is made to remove the cylinder block (204) without detaching the shoe (206) from the swash plate (203), then the piston, shoe and other parts that are connected to the cylinder block may come the cylinder loose and fall into the spindle.



Disassembling the cylinder block kit

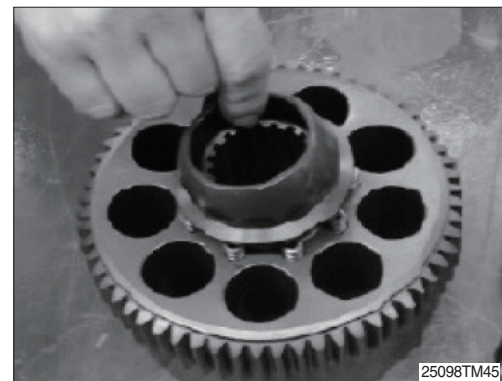
- ① Piston assembly [piston (205), shoe (206))] from the removed cylinder block (204).



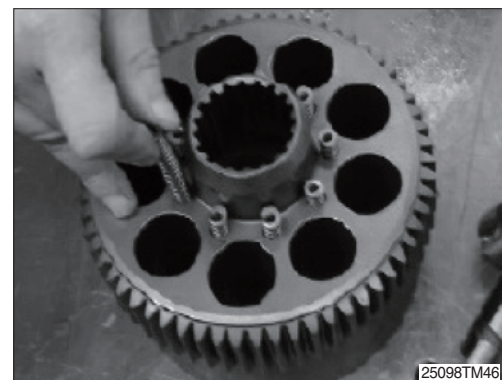
- ② Piston (205) and shoe (206) from the removed retainer plate (207).



- ③ Thrust ball (208) from the removed cylinder block (204).



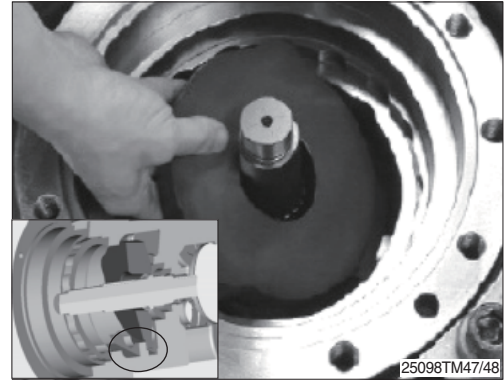
- ④ Spring (214, 9EA) from the removed cylinder block (204).



(10) Remove swash plate (203) from the shaft (202).

(11) Remove shaft (202) from the spindle (101).

- ※ When separating the swash plate, separate and turn it by using hands to free from intervention of the stopper.

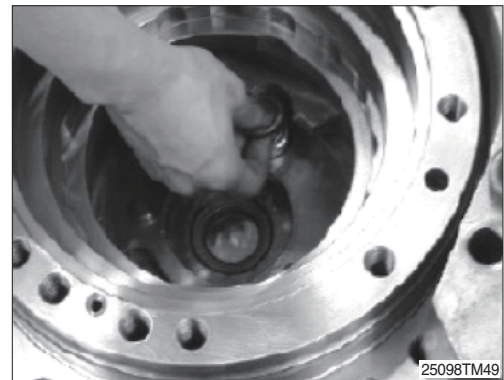


(12) Remove speed selector piston assembly [piston (261) and shoe (262)] from the spindle [101] by feeding compressed air from the access hole in spindle (101).

(13) Remove parallel pin (242) and pivot (267) from the spindle (101).

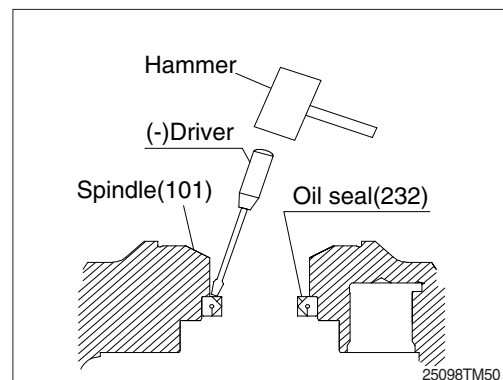
(14) Remove ball bearing (249) from the spindle (101).

- ※ Piston assembly ; Piston (261), Shoe (262)
- ※ Compressed air ; 3~5 kgf/cm² (43~71 psi)
- ※ When piston (261) or shoe (262) is damaged, if exchange is necessary, they have to be exchanged together because the separation is impossible. Use the protection cover on the upper part spindle when users put the pressed air into suddenly. Otherwise part damage and accident might go on because the piston is rushed out of the spindle.



(15) Remove oil seal (232) from the spindle (101).

- ※ Remove the oil seal (232) by hammering using (-) driver.
- ※ Do not reuse the oil seal (232).



4. REASSEMBLY

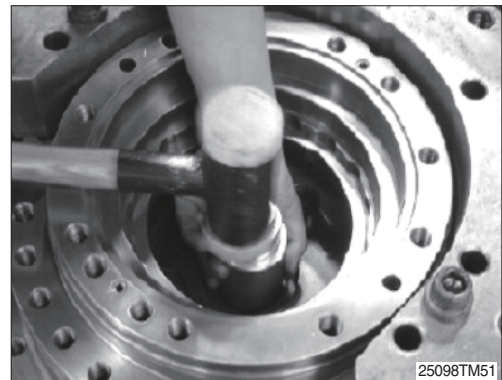
4.1 GENERAL PRECAUTIONS

- 1) Reassemble in a work area that is clean and free from dust and dirt.
- 2) Handle parts with bare hands to keep them free of liny contaminants.
- 3) Repair or replace the damaged parts.
Each parts must be free of burrs its corners.
- 4) Do not reuse O-ring, oil seal and floating seal that were removed in disassembly. Provide the new parts.
- 5) Wash all parts thoroughly in a suitable solvent. Dry thoroughly with compressed air.
Do not use the cloths.
- 6) When reassembling oil motor components of travel motor, be sure to coat the sliding parts of the motor and valve with fresh hydraulic oil. (NAS class 9 or above)
- 7) Use a torque wrench to tighten bolts and plugs, to the torque specified as follows.

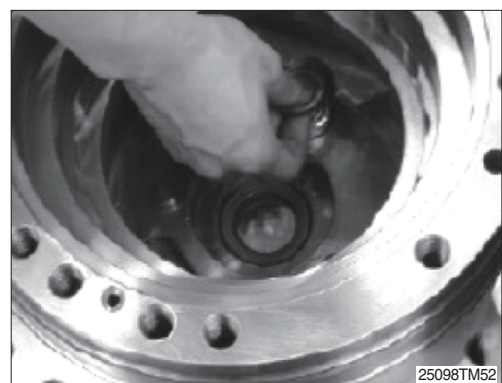
4.2 REASSEMBLY PROCEDURE

1) REASSEMBLE THE HYDRAULIC MOTOR PART

- (1) Install oil seal (232) into the oil seal hole of spindle (101).
 - ※ Apply lithium grease to the lip portion of oil seal (232) position the squarely over the bore of spindle (101).

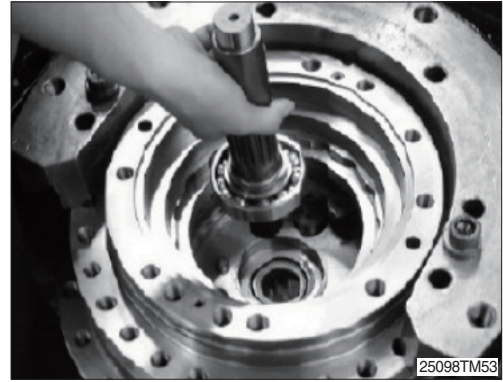


- (2) Install parallel pin (242, 2EA) and two speed piston assembly (261, 262) into the spindle (101).

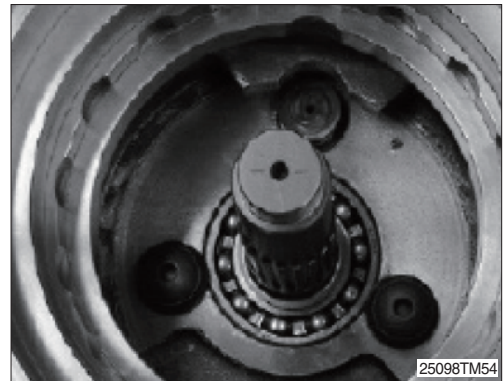


(3) Install shaft (202) into the spindle (101).

※ Assemble after applying grease on oil seal lip (232).

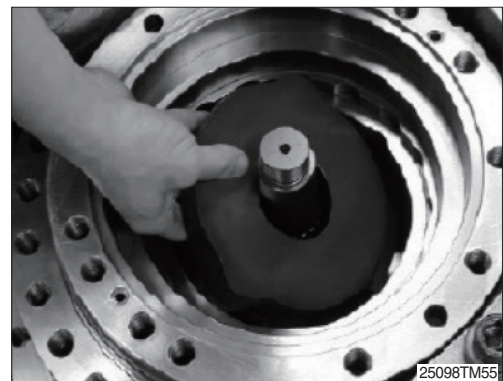


(4) Install pivot (267, 2EA) into the spindle (101).



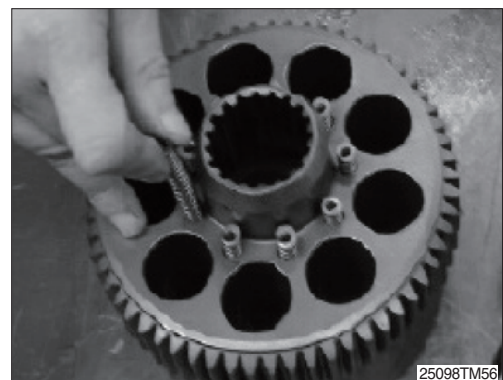
(5) Install swash plate (303) to the spindle (101).

※ The swash plate (203) and the 2 speed stopper of the spindle are interferenced. Install the swash plate (203) after rotating. And then install it as the regular position.

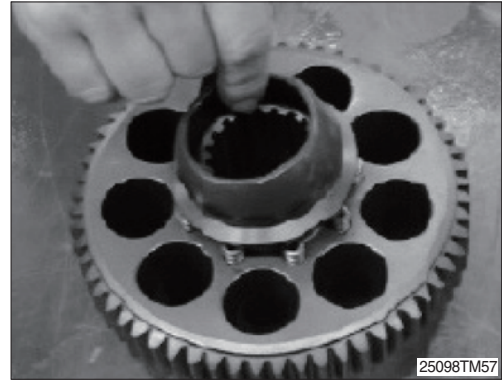


(6) Reassemble the cylinder block kit

① Install spring (214, 9EA) to the cylinder block (204).

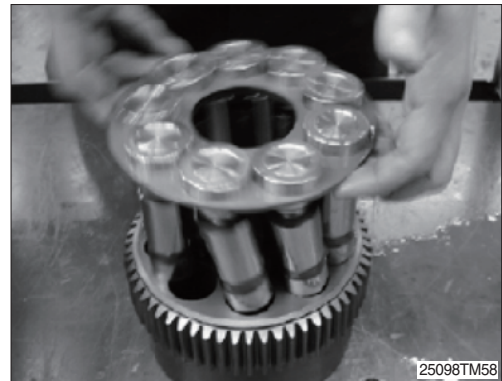


- ② Install thrust ball (208) to the cylinder block (204).



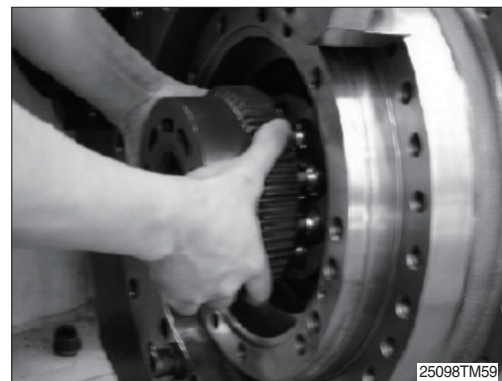
- ③ Insert piston assembly [piston (205) and shoe (206)] into retainer plate (207).
④ Mount the piston assembly into the cylinder block (204).

※ After mounting, immerse the entire them in a working fluid.



- (7) Install cylinder block (204) assembly to the shaft (202).

- ※ After fitting splines of both cylinder block (204) and shaft (202), assemble them.
※ After installing the cylinder (204), confirm whether it revolves or not by turning using both hands.
※ Motor is malfunction when it isn't revolve.



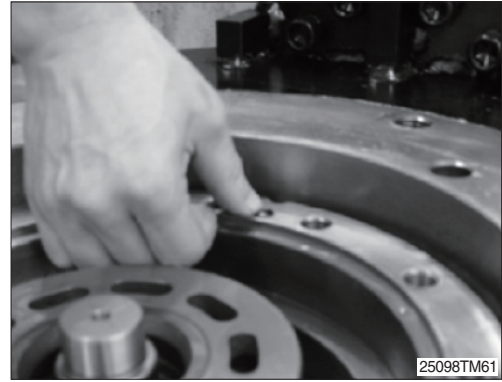
(8) Reassemble the parking brake

- ① Install mating plate (216) first and then a friction plate (215), one by one, into the grooves of the outer surface of the cylinder block (204).

※ Immerse the friction plates (215) in a working fluid before fitting them into the grooves.



- ② Install O-ring (275, 2EA) into the spindle (101).



- ③ Install two O-rings (235, 239) and two back up ring (247, 248) in then O-ring grooves.

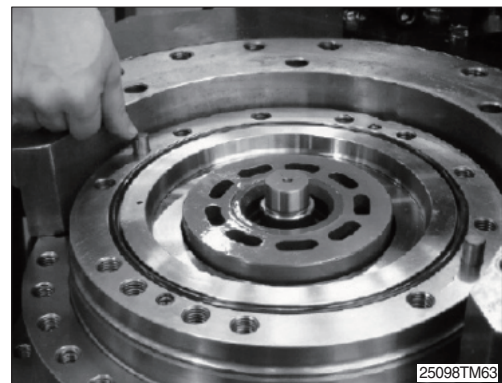
- ④ Mount a piston (212) in the spindle (101).

- ※ Apply a thin coat of grease to the O-rings (235, 239).
- ※ If the piston (212) does not fit into the spindle (101) because of the resistance of the O-ring, tap the edge of the piston (212) lightly and equally with a plastic hammer.
- ※ Be careful not to damage the O-ring and back up ring at this time.



- ⑤ Insert a O-ring (126) into spindle (101).

- ⑥ Insert a paralell pin (42, 2EA) into spindle (101).



1) REASSEMBLE THE REAR FLANGE PART [1]

(1) Reassemble the check valve

① Install O-ring (37, 2EA) on the plug (29, 2EA).

※ Apply grease to the O-ring (37).

② Install spring (32) and a valve (30) into the plug (29).

③ Install plug (29) into the rear flange (1).

※ Install a spring (32) and a valve (30) into the plug (29), and then grease the spring (32) and the valve (30) and hand-lock the former.

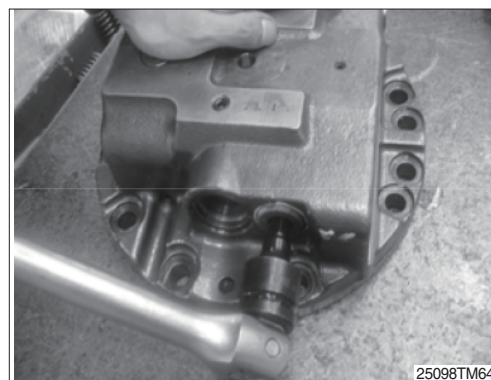
④ Install plug (29) in conjunction with the spring (32) and the valve (30) into the rear flange (1), and tighten the plug to the required torque.

※ Tightening torque : $26 \pm 4.0 \text{ kgf} \cdot \text{m}$ ($188 \pm 28.9 \text{ lbf} \cdot \text{ft}$)

※ Tools

· Adapter for hexagon wrench 14

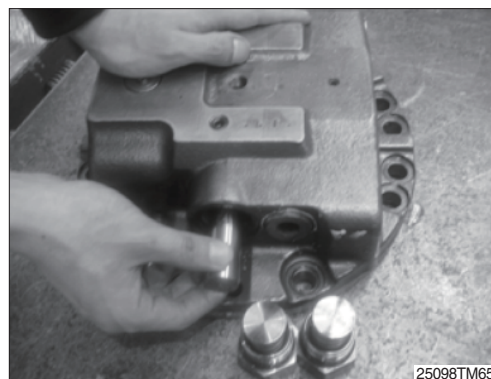
· Torque wrench



(2) Reassemble the spool

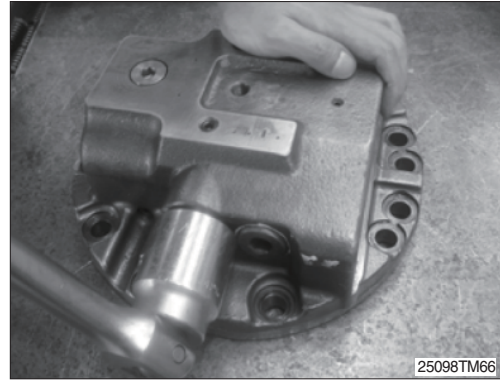
① Install spool (23) into the rear flange (1).

※ Before installing the spool (23), apply hydraulic oil to the spool. Be careful not to damage the spool's surface and the inner of rear flange (1).



- ② Install O-ring (36) on the plug (24).
- ③ Install spring (31) and a stopper (25, 26) into the plug (24).
- ④ Install plug (24) into the rear flange (1).
- ⑤ Tighten the plug (24) to the required torque.

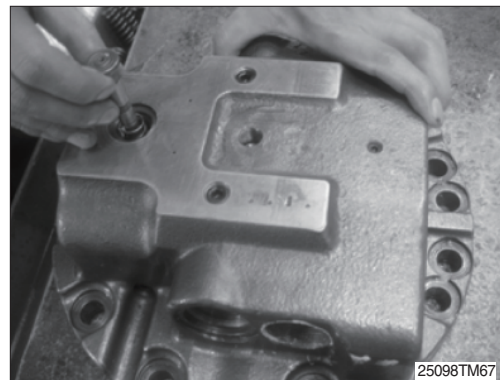
- ※ Apply grease to the O-ring (36).
- ※ Tightening torque : $45 \pm 9 \text{ kgf} \cdot \text{m}$ ($325 \pm 65.1 \text{ lbf} \cdot \text{ft}$)
- ※ Exchange it as the rear flange kit if the exchange is necessary, because the rear flange (301), the spool (323) insist of the rear flange kit.
- ※ Sochet (#41)/Torque for hexagon wrench.
- ※ Tools
 - Hexagon socket 41
 - Torque wrench



(3) Reassemble the two speed valve

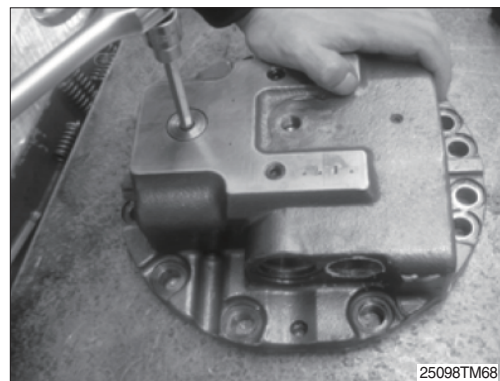
- ① Install O-rings (46) on plugs (63).
- ② Insert a spool (65) and spring (66) into the rear flange (1).

- ※ Apply grease to the O-ring (46).
- ※ Apply hydraulic oil to the spool (65), while the spool (65) is installed into the rear flange (1).
- ※ Be careful not to damage the hole's inner of the rear flange (1) and the spool (65) outer. It brings on low efficiency of the travel motor because of the leakage increase after reassembling.
- ※ The shaft center should align with the hole center because of little gap.
- ※ It is in order to protect the damage and smooth assembling of the rear flange (1) and the spool (65).



- ③ Insert a plug (63) into the rear flange (1).

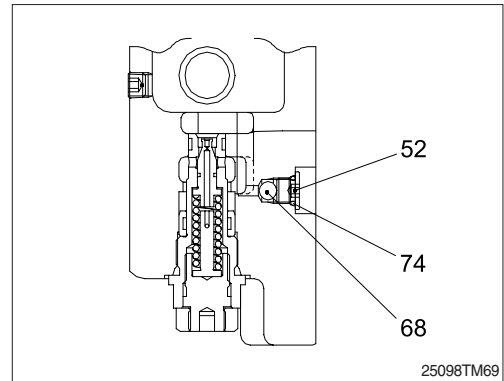
- ※ Tightening torque : $10 \pm 2 \text{ kgf} \cdot \text{m}$ ($72.3 \pm 14.5 \text{ lbf} \cdot \text{ft}$)
- ※ Tools
 - Adapter for hexagon wrench 10
 - Torque wrench



(4) Assembling of the rear flange's inner parts

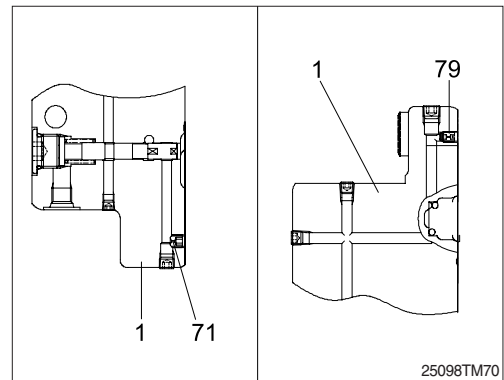
① After installing the O-ring (74) on the plug (52), install the steel ball (68) and the plug (52) into the rear flange (1).

- ※ Apply grease to the O-ring (74).
- ※ Do not disassemble and assemble if not necessary.



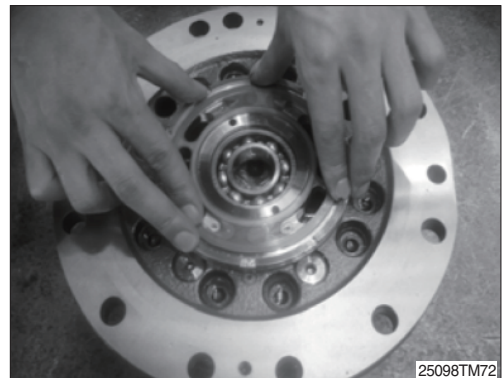
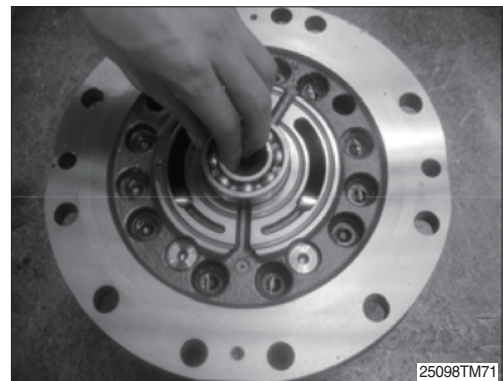
② Install orifice (71), filter (79) into the rear flange (1). Caulk it after assembling certainly.

- ※ Do not disassemble and assemble if not necessary.



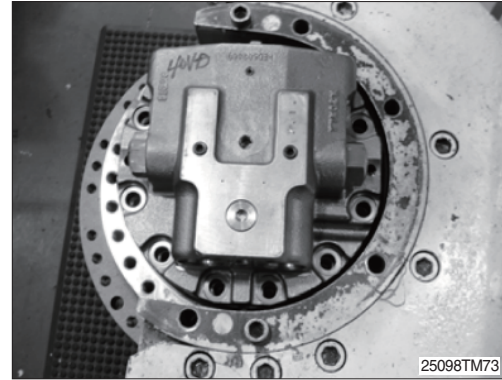
(5) Insert a ball bearing (250), timing plate (209), parallel pin (41, 1EA) and spring (213, 12EA) into the rear flange (1).

- ※ Be careful not so that the spring (213) and the timing plate (209) should not separate from the rear flange (1).
- ※ Apply hydraulic oil to the ball bearing (250).



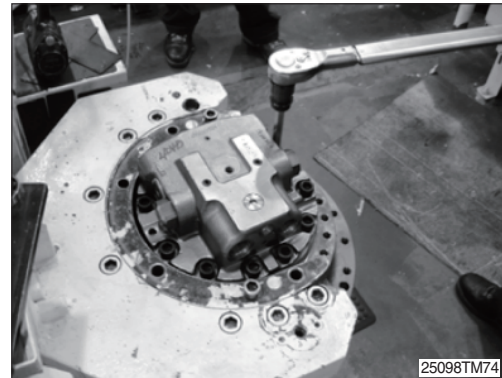
(6) Reassemble the rear flange (1) and spindle (101).

- ① Mount the rear flange (1) on the spindle (101).
- ※ When the rear flange (1) is mounted on the spindle (101), fix the spring (13) applied grease to not drop.



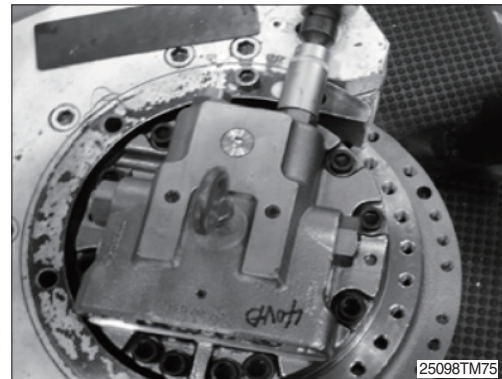
- ② Tighten the socket bolt (43) into the spindle (101) to the required torque.

- ※ Tightening torque : $5.9 \pm 1.0 \text{ kgf} \cdot \text{m}$ ($42.7 \pm 7.2 \text{ lbf} \cdot \text{ft}$)
- ※ Tools
 - Adapter for hexagon wrench 14
 - Torque wrench



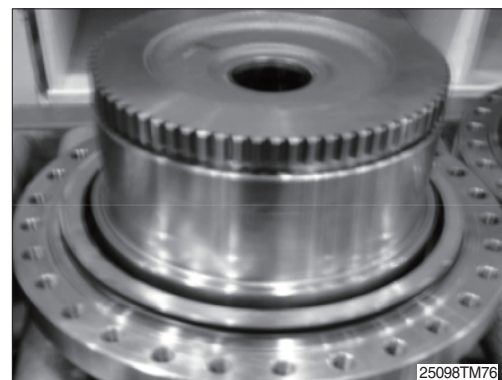
- (7) Tighten the relief valve into the rear flange (1) to the required torque.

- ※ Tightening torque : $25 \pm 5 \text{ kgf} \cdot \text{m}$ ($181 \pm 36.2 \text{ lbf} \cdot \text{ft}$)
- ※ Tools
 - Hexagon socket 32
 - Torque wrench



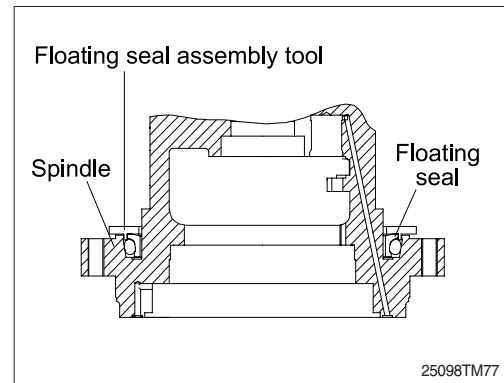
3) THE REDUCTION GEAR ASSEMBLY

- (1) Rotate the travel motor through 180 degrees to make the spindle side face upward.



(2) Install floating seal (102) on the spindle (101).

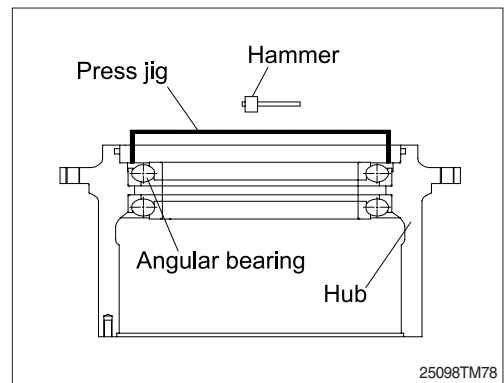
※ Apply grease to the floating seal (102).



(3) Hub assembly

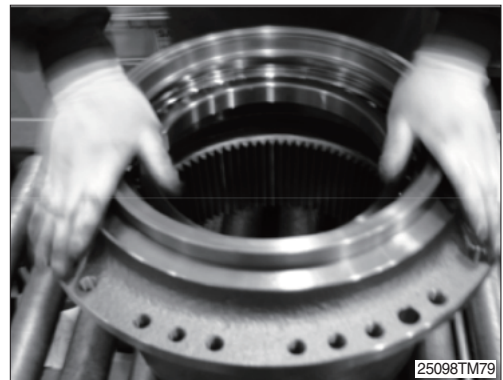
① Install angular bearing (125) into the hub (105).

※ Be careful for the insert direction.

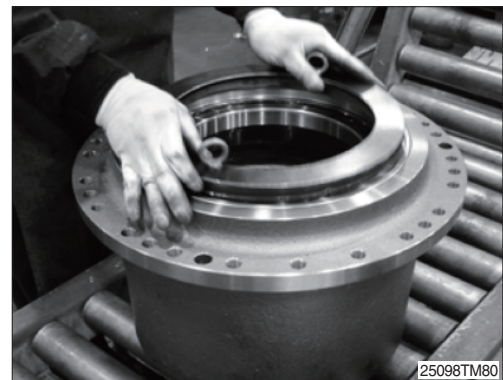


② Insert the O-ring (130), the sealing (129) in the hub (105).

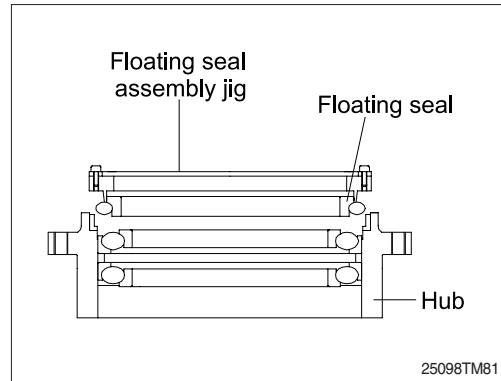
※ Apply grease to the O-ring (130) thinly.



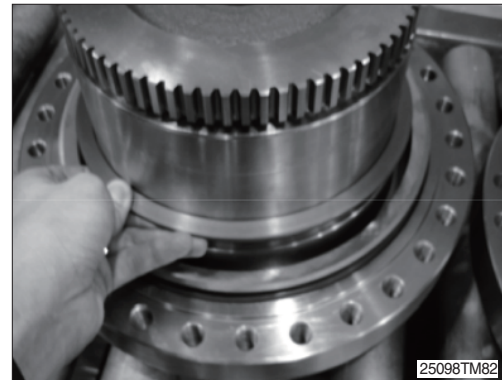
③ Install floating seal (102) on the hub (105).



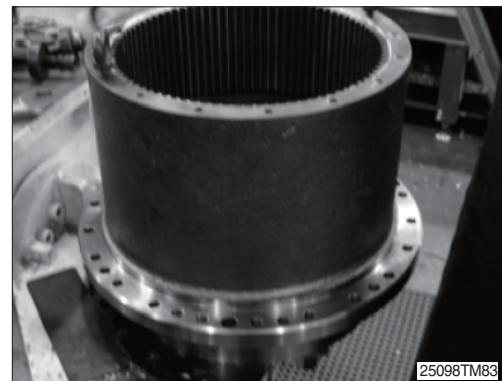
※ Apply grease to the floating seal (102).



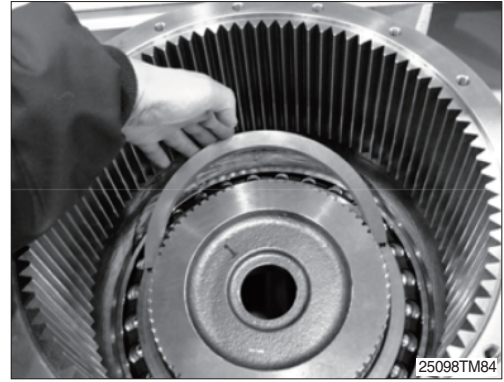
④ Install distance piece (106) into the spindle.



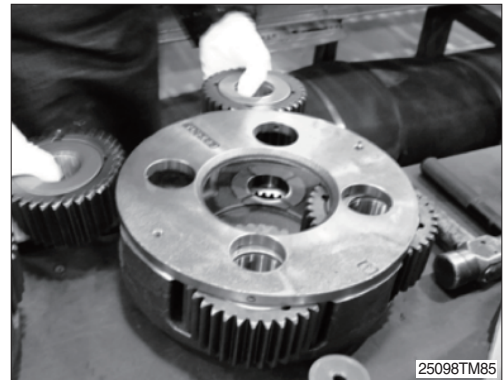
⑤ Install the hub assembly into the spindle.



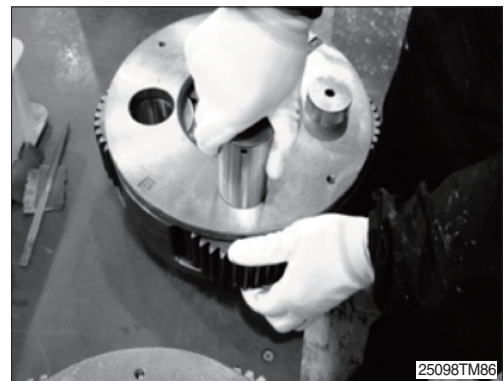
- ⑥ Use a press, and press inner face of bearing (125) into its full depth.
- ⑦ While pressing flange of spindle (101), install shim plate (136) into groove.



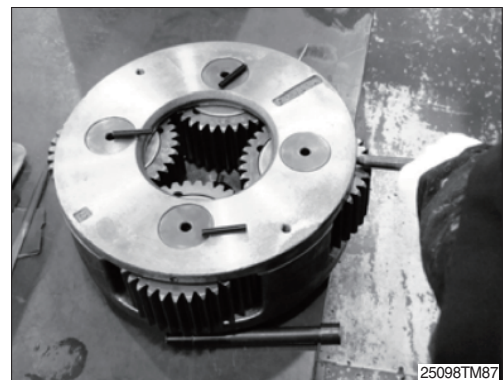
- ⑧ Install thrust washer (F) (109), planetary gears (F) (108), needle bearings (111) and floating bushing (112) from carrier No.2 (103).



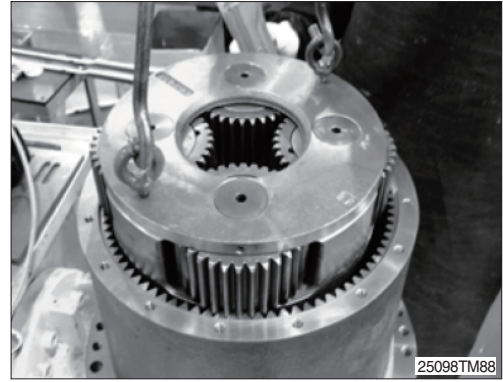
- ⑨ Install shaft bearing (113) into the carrier No.2 (103).



- ⑩ Install spring pin (110) into the carrier No.2 (103).



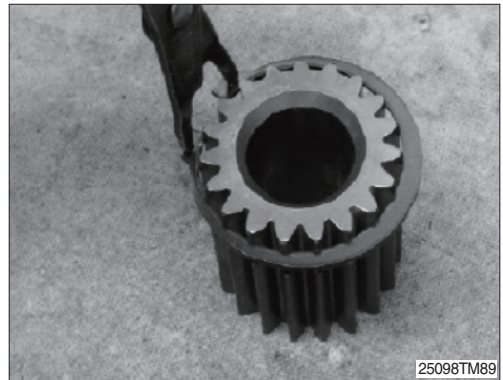
⑪ Place carrier No.2 assembly into hub (105).



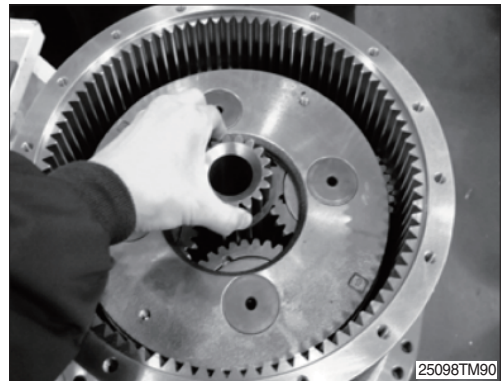
⑫ Fit the snap ring (115) on the sun gear (114).

※ Tools

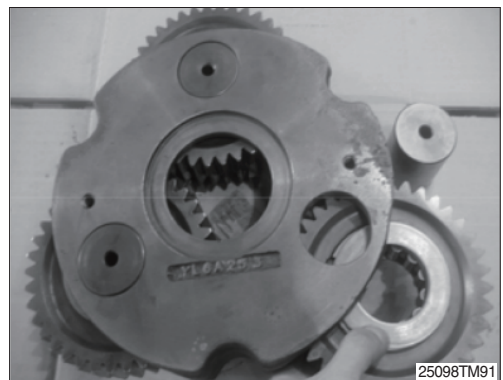
- Snap ring plier (C-75(S))



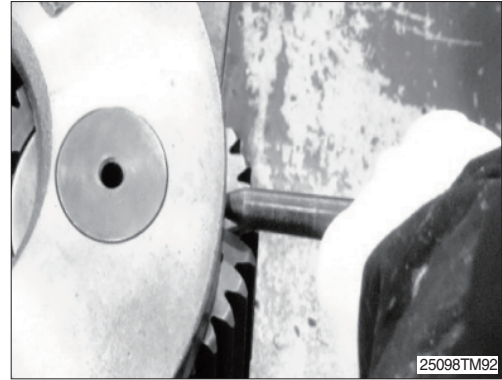
⑬ Install sun gear (114).



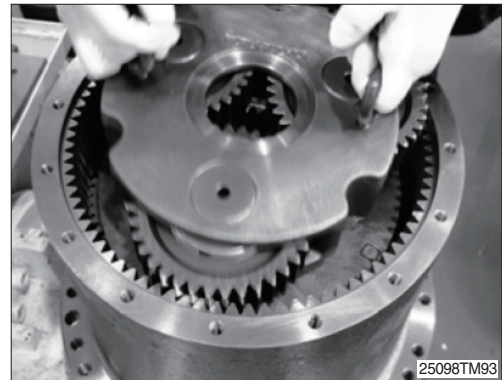
⑭ Install thrust washer (R) (131), planetary gears (R) (117), needle bearings (118) and shaft bearing (R) (107) from carrier No.1 (134).



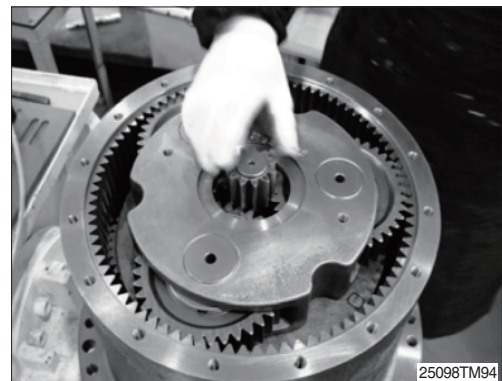
- ⑮ Install the spring pin (122) into the carrier No.1 (134).



- ⑯ Place carrier No.1 assembly into hub (105).

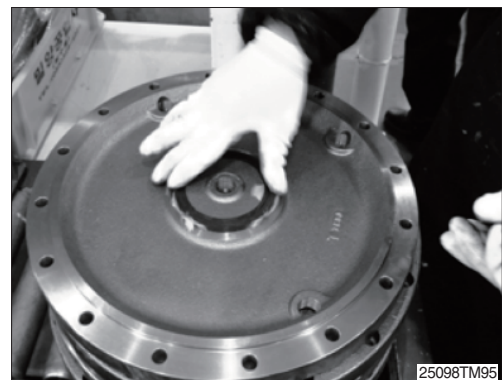


- ⑰ Install drive gear (121) in the carrier No.1 assembly.

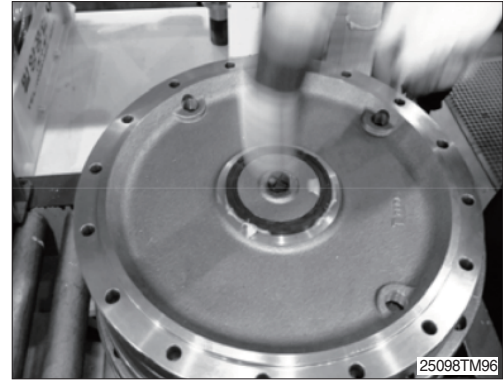


- ⑱ Install thrust plate (133) in the cover (123).

※ Apply grease to the thrust plate (133).



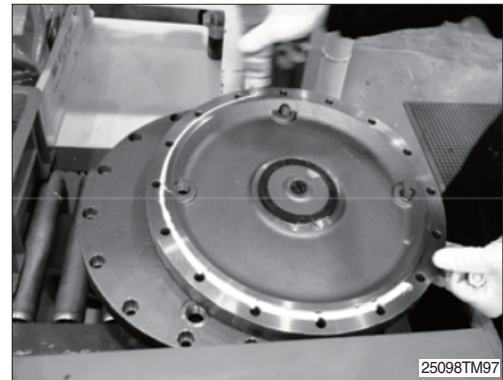
⑱ Install thrust washer (M) (132) in the cover (123).



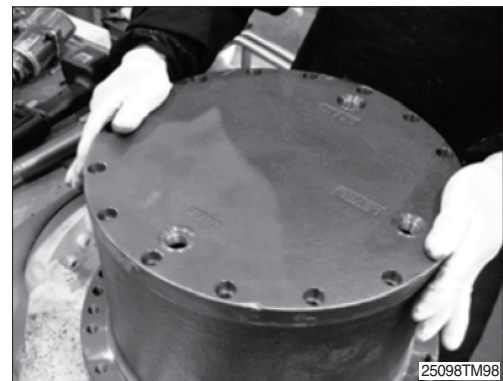
⑳ Apply sealant to the cover (123) after installing with the hub (105).

※ Tools

- Sealant : Silicone rubber (780-RTV)



㉑ Mount the cover (123) on the hub (105).



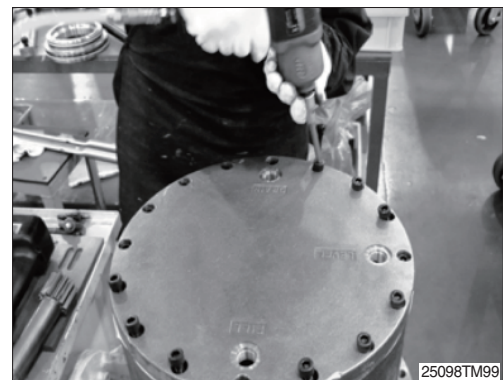
㉒ Tighten the socket bolt (124, 16EA) to the specified torque.

※ Tightening torque : 5.9 ± 1.0 kgf · m (42.7 ± 7.2 lbf · ft)

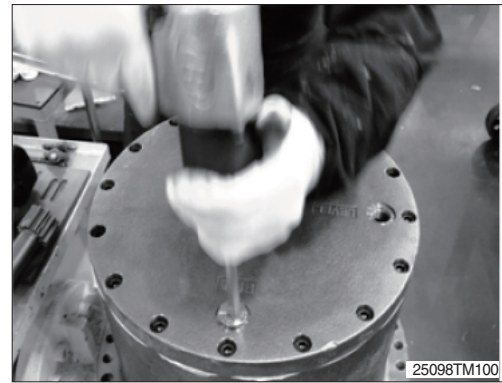
※ Tools

- Adapter for hexagon wrench 8
- Torque wrench

※ Apply loctite to the socket bolt (124) and then install it.



- ②③ Install O-ring (38) in the plug (128).
- ②④ Tighten the plug (128) to the specified torque into the cover (123).
- ※ Apply grease to the O-ring (38).
- ※ Tightening torque : $10 \pm 2.0 \text{ kgf} \cdot \text{m}$ ($72.3 \pm 14.5 \text{ lbf} \cdot \text{ft}$)
- ※ Tools
 - Adapter for hexagon wrench 10
 - Torque wrench



3.3 CHECKING FACTS AFTER ASSEMBLY

1) AIR TEST OF REDUCTION GEAR

Disassemble plug (032) of reduction gear part. When compressed air (0.3 kgf/cm^2) is inserted that in water during the 2 minutes, it should be not happened air bubble.

Fill the gear oil.

- Oil amount : 3.3 liter (0.87 U.S.gallon)

2) AIR TEST OF HYDRAULIC MOTOR

One port should be opened, the others port should be closed. When compressed air (3 kgf/cm^2) is inserted opened port in water during the 2 minutes, it should be not happened air bubble.

Fill the hydraulic oil.

- Oil amount : 1.0 liter (0.26 U.S.gallon)

GROUP 6 TRAVEL DEVICE (TYPE 2)

1. REMOVAL AND INSTALL

1) REMOVAL

- (1) Swing the work equipment 90° and lower it completely to the ground.
- (2) Operate the control levers and pedals several times to release the remaining pressure in the hydraulic piping.
- (3) Loosen the breather slowly to release the pressure inside the hydraulic tank.

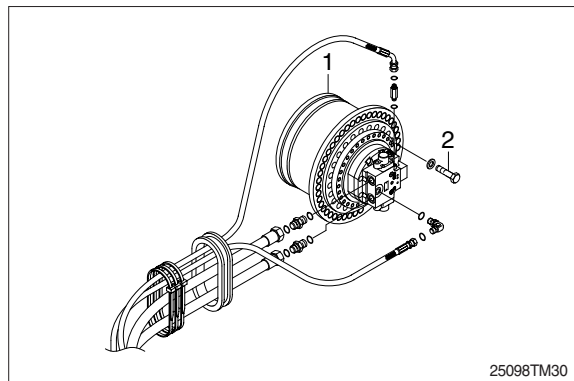
▲ Escaping fluid under pressure can penetrate the skin causing serious injury.

※ When pipes and hoses are disconnected, the oil inside the piping will flow out, so catch it in oil pan.

- (4) Remove the track shoe assembly.
For details, see **removal of track shoe assembly**.
- (5) Remove the cover.
- (6) Remove the hoses.
※ Fit blind plugs to the disconnected hoses.
- (7) Remove the bolts and the sprocket.
- (8) Sling travel device assembly (1).
- (9) Remove the mounting bolts (2), then remove the travel device assembly.
· Weight : 305 kg (670 lb)

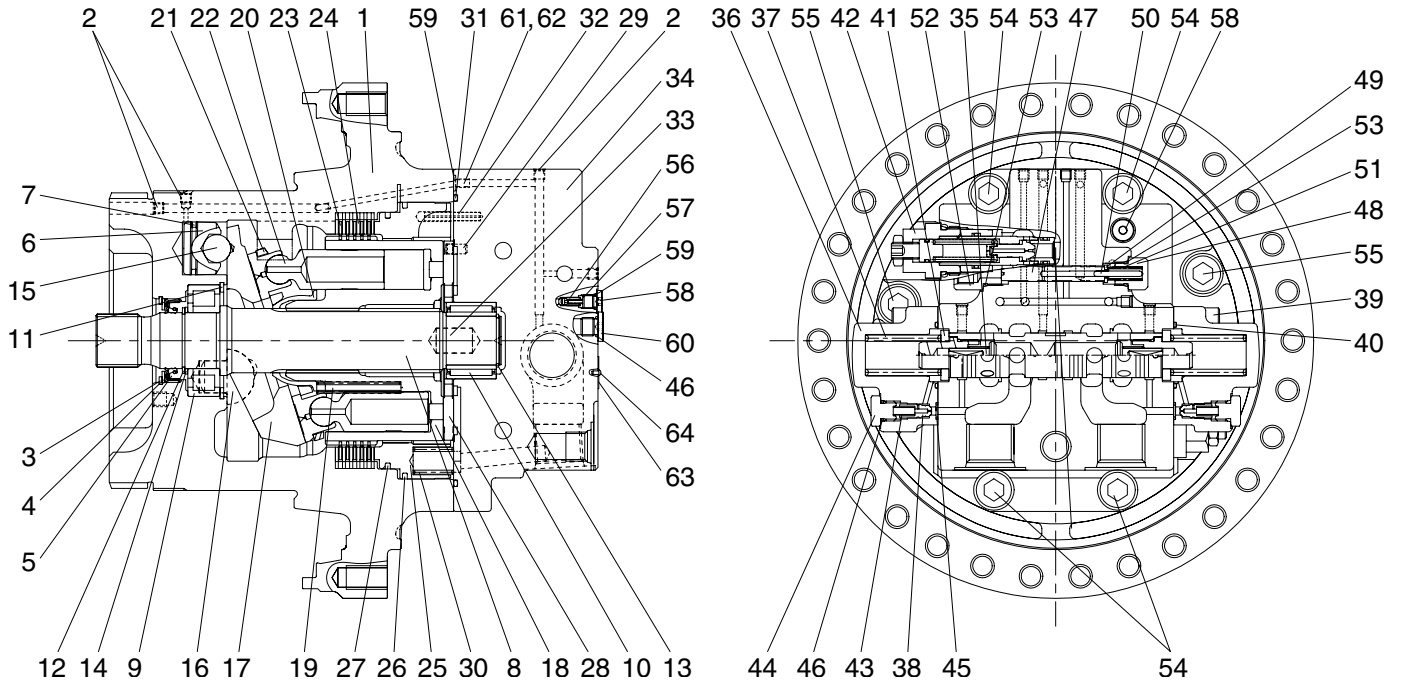
2) INSTALL

- (1) Carry out installation in the reverse order to removal.
- (2) Bleed the air from the travel motor.
 - ① Remove the air vent plug.
 - ② Pour in hydraulic oil until it overflows from the port.
 - ③ Tighten plug lightly.
 - ④ Start the engine, run at low idling, and check oil come out from plug.
 - ⑤ Tighten plug fully.
- (3) Confirm the hydraulic oil level and check the hydraulic oil leak or not.



2. TRAVEL MOTOR

1) STRUCTURE

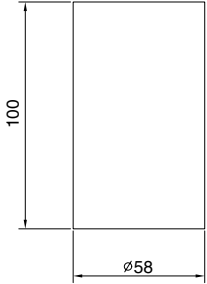
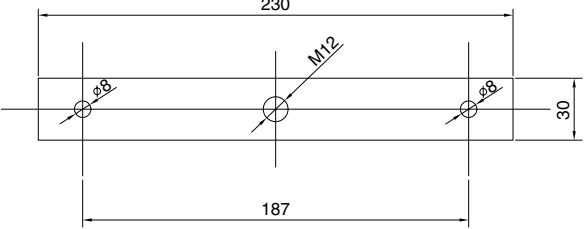
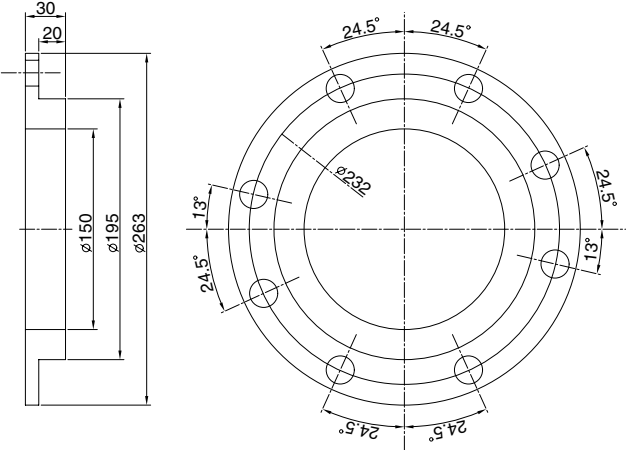


1	Casing	23	Friction plate	44	Plug
2	Plug	24	Separated plate	45	O-ring
3	Oil seal	25	Parking piston	46	O-ring
4	Thrust plate	26	D-ring	47	Spool
5	Snap ring	27	D-ring	48	Plug
6	Piston	28	Valve plate	49	Seat spring
7	Piston seal	29	Parallel pin	50	Parallel pin
8	Shaft	30	Spring	51	Spring
9	Cylinder roller bearing	31	O-ring	52	Connector
10	Needle bearing	32	Spring pin	53	O-ring
11	Snap ring	33	Parallel pin	54	Hexagon socket head bolt
12	Snap ring	34	Rear cover	55	Hexagon socket head bolt
13	Snap ring	35	Main spool assy	56	Check valve
14	Thrust plate	36	Cover	57	Spring
15	Steel ball	37	Spring	58	Plug
16	Pivot	38	Restrictor	59	O-ring
17	Swash plate	39	Hexagon socket head bolt	60	Plug
18	Cylinder block	40	O-ring	61	Restrictor
19	Spring	41	Seat spring	62	Restrictor
20	Ball guide	42	Relief valve assy	63	Name plate
21	Retainer plate	43	Spring	64	Rivet
22	Piston assy				

25092TM21

2) TOOLS AND TIGHTENING TORQUE

(1) Tools

Tool name	Remark
Hexagon wrench	Width across flat 5, 6, 8, 10, 14 mm
Snap ring prier	For shaft $\varnothing 60\sim 80$ mm
Snap ring prier	For bore $\varnothing 32\sim 58$ mm
Plastic hammer	1 piece
Screw driver	Minus (-), medium size, 2 pieces
Torque wrench	10 kgf·m (72.3 lbf·ft), 33 kgf·m (238.6 lbf·ft), 45 kgf·m (325.4 lbf·ft)
Gig for inserting oil seal	 <p style="text-align: right;">25098TM31</p>
Gig for inserting parking piston (M10×100 bolt 2EA, M12×100 bolt 1EA)	 <p style="text-align: right;">25098TM32</p>
Gig for pulling out brake piston	 <p style="text-align: right;">25098TM33</p>

(2) Tightening torque

Item	Name	Size	Torque	
			kgf · m	lbf · ft
2	Plug	NPTF 1/16	1.1±0.1	7.9±0.72
39	Hexagon socket head bolt	M12	1.0±1.0	72.3±7.2
42	Relief valve	1 5/16	34±3.4	246±24.6
44	Plug	PF 1/4	2.8±0.3	20.3±2.17
48	Plug	PF 3/8	5.5±0.5	39.8±3.6
52	Connector	PF 3/8	5.5±0.5	39.8±3.6
54	Hexagon socket head bolt	M18	38±3.8	275±27.5
55	Hexagon socket head bolt	M18	38±3.8	275±27.5
58	Plug	PF 1/8	1.5±0.1	10.8±0.72
60	Plug	PF 1/4	3±0.3	21.7±2.17

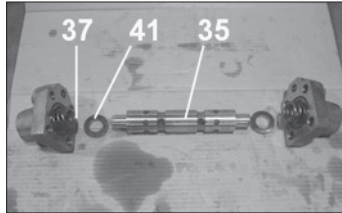
3. DISASSEMBLING

1) GENERAL INSTRUCTIONS

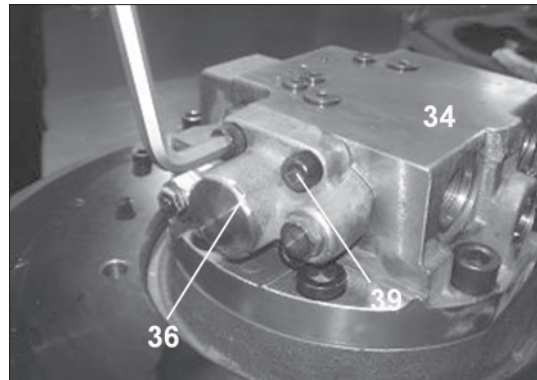
- ▲ Combustibles such as white kerosene are used for washing parts.**
These combustibles are easily ignited, and could result in fire or injury.
Be very careful when using.
 - ▲ Internal parts are coated with hydraulic fluid during disassembling and are slippery.**
If a part slips out of your hand and falls, it could result in bodily injury or could damage the park.
Be very careful when handling.
- (1) Generally, hydraulic equipment is precisely manufactured and clearances between each parts are very narrow. Therefore, disassembling and assembling works should be performed on the clean place where dusts hardly gather. Tools and kerosene to wash parts should also be clean and handled with great care.
 - (2) When motor is removed from the host machine, wash around the ports sufficiently and put the plugs so that no dust and/or water may invade. Take off these plugs just before the piping works when re-attach it to the host machine.
 - (3) Before disassembling, review the sectional drawing and prepare the required parts, depending on the purpose and the range of disassembling.
Seals, O-rings, etc., if once disassembled, are not reusable.
There are some parts that should be replaced as a subassembly.
Consult with the parts manual in advance.
 - (4) The piston can be inserted to whichever cylinder block for the initial assembling.
However, their combination should not be changed if they are once used. To reuse them, put the matching mark on both pistons and cylinder block before disassembling.
- ▲ Take great care not to pinch your hand between parts while disassembling nor let fall parts on your foot while lifting them.**

2) DISASSEMBLING TRAVEL MOTOR

- (1) Disassemble the wrench bolt (39) to tighten the spool cover (36) and rear cover (34) by using the L-wrench or impact wrench and then disassemble the spring (37), spring seat (41) and main spool assy (35) in order.

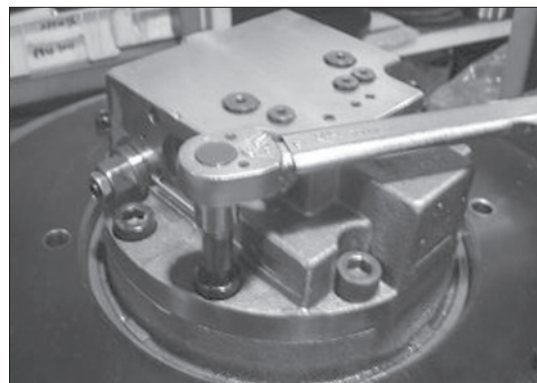


25098TM034



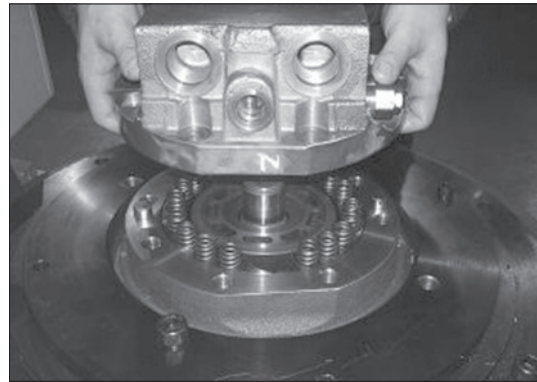
25098TM035

- (2) Disassemble the wrench bolt (54, 55) to tighten the casing (1) and rear cover (34) by using the L-wrench or impact wrench.



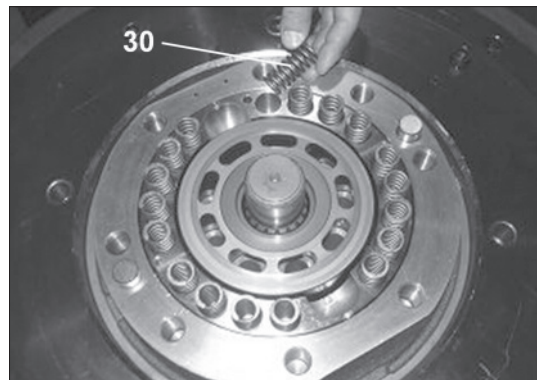
25098TM036

- (3) Separate the casing (1) and rear cover (34).



25098TM037

- (4) Disassemble the brake spring (30, 18EA) from the piston.

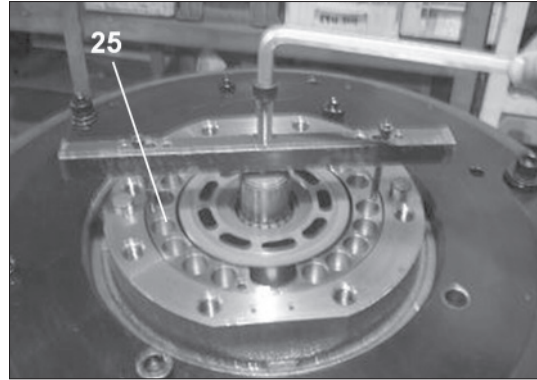


25098TM118

- (5) Disassemble the parking piston (25) by using the jig for disassembling parking piston.

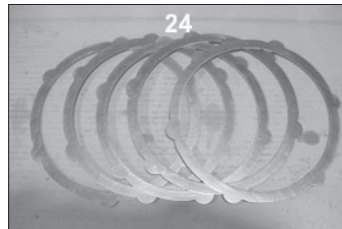


25098TM039

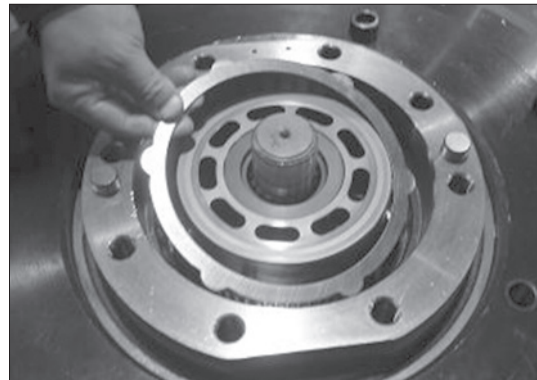


25098TM040

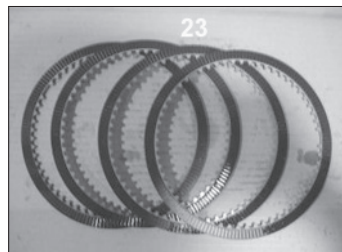
- (6) Disassemble the separate plate (24, 5EA) and friction plate (23, 4EA) from the casing.



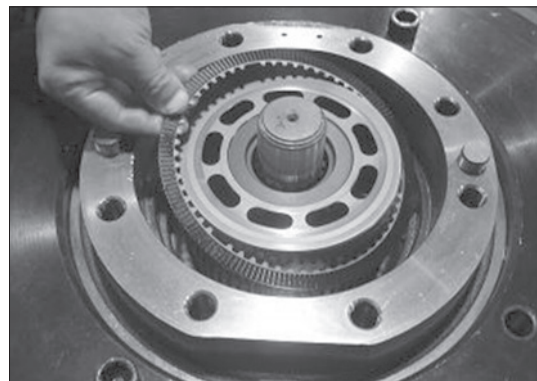
25098TM041



25098TM042

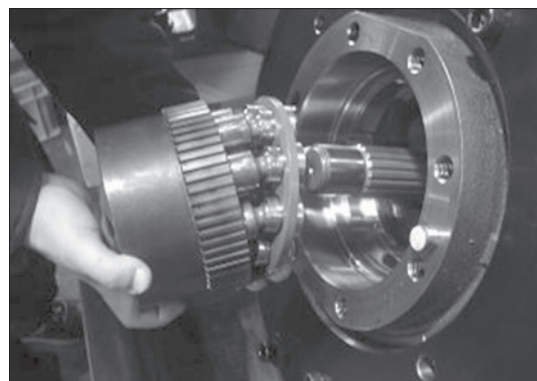


25098TM043



25098TM044

- (7) Turn the casing (1) horizontal by using the assemble truck and disassemble the cylinder block kit form the casing (1).

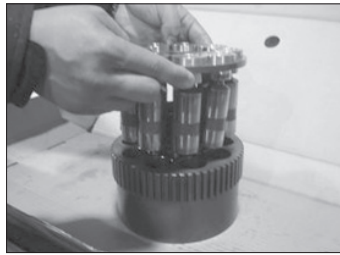


25098TM045

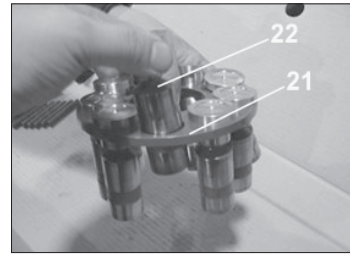
(8) Disassemble the cylinder block (18), retainer plate (21), piston assy (22), ball guide (20) and spring (19) from the cylinder block kit.



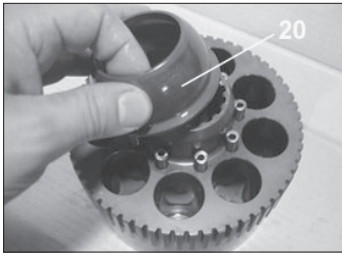
25098TM046



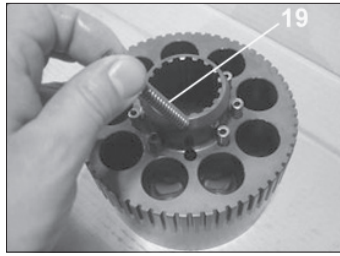
25098TM047



25098TM048

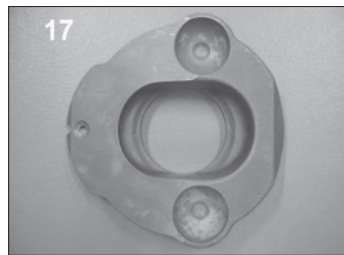


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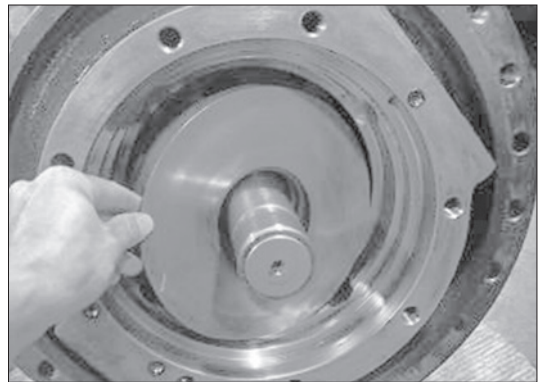


25098TM050

(9) Disassemble the swash plate (17) from the casing.

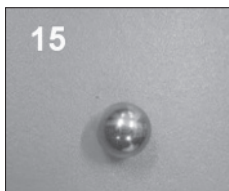


25098TM051

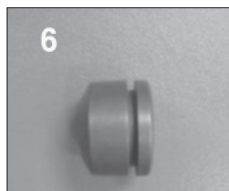


25098TM052

(10) Disassemble the steel ball (15) and swash piston (6) from the casing.



25098TM053

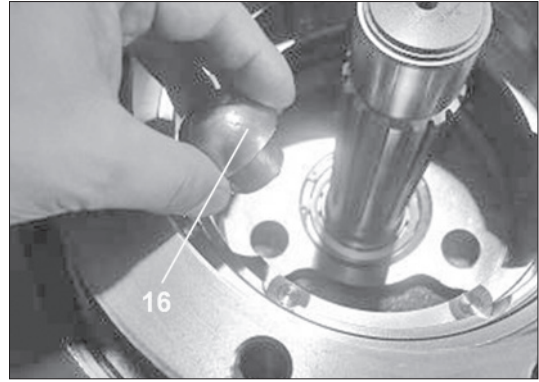


25098TM054



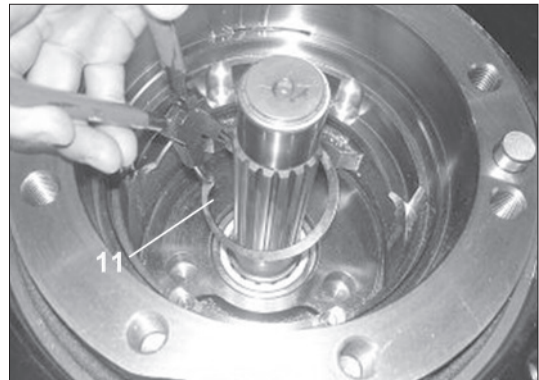
25098TM055

(11) Disassemble the pivot (16, 2EA) from the casing.



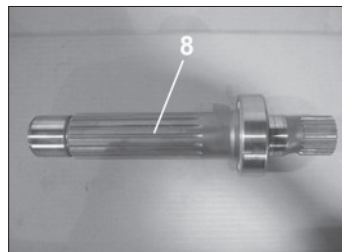
25098TM056

(12) Disassemble the snap ring (11) from the shaft (8) with the pryer for retaining ring.



25098TM057

(13) Disassemble the shaft (8) from the casing (1).

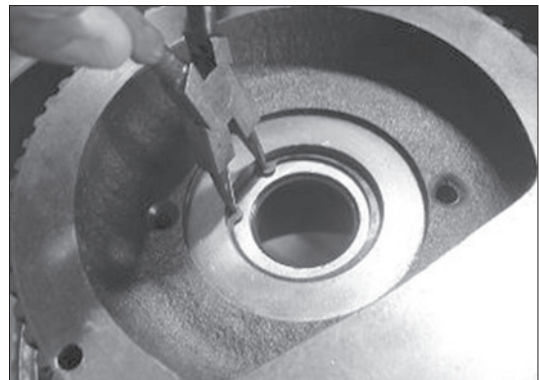


25098TM058



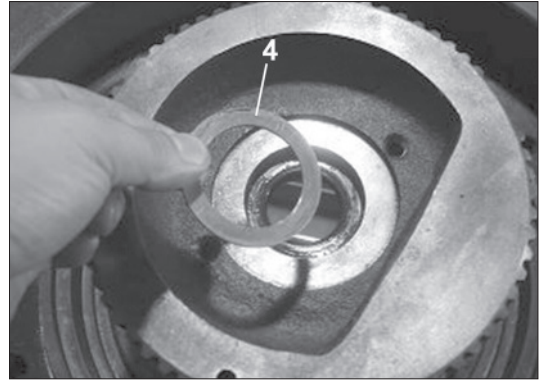
25098TM059

(14) Disassemble the snap ring (5) from the casing (1) with the pryer for retaining ring.



25098TM060

(15) Disassemble the thrust plate (4) from the casing (1).

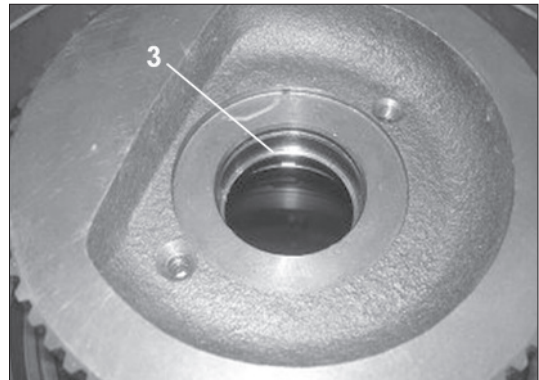


25098TM061

(16) Disassemble the oil seal (3) from the casing (1) with suitable tool.

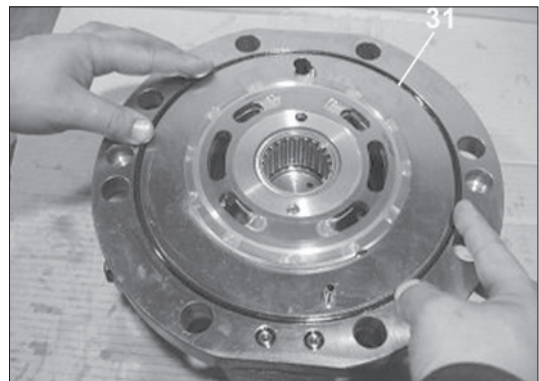


25098TM062



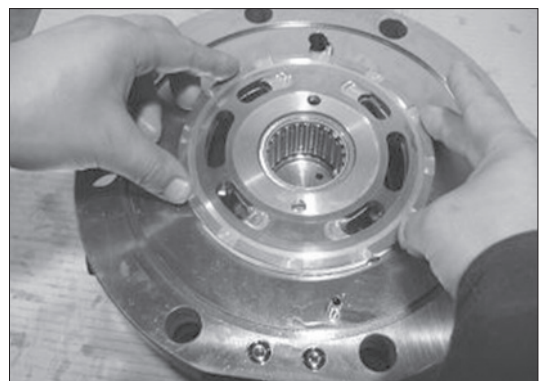
25098TM063

(17) Disassemble the O-ring (31) from the casing (1).



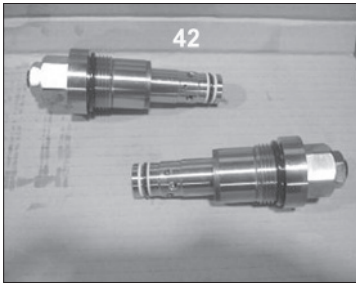
25098TM064

(18) Disassemble the valve plate (28) from the casing (1).

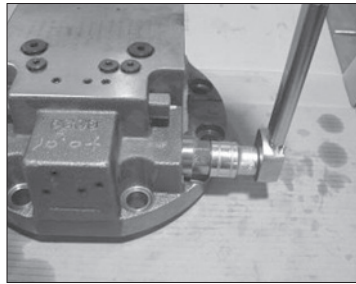


25098TM065

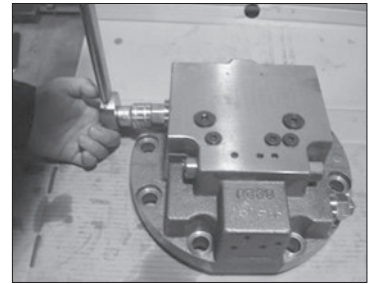
(19) Disassemble the relief valve (42, 2EA) from the rear cover (34) by using the torque wrench.



25098TM066

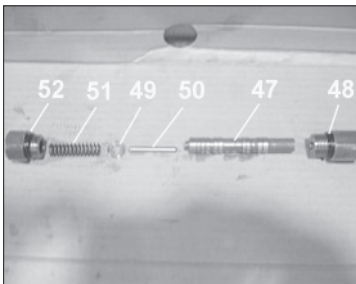


25098TM067

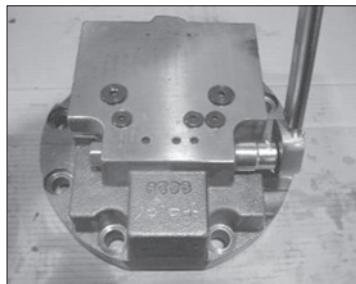


25098TM068

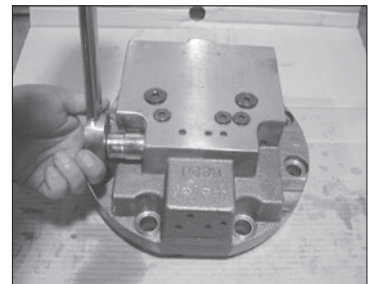
(20) Disassemble both side of the plug (48) and connector (52) from the rear cover (34) by using the torque wrench and then disassemble the spring (51), spring seat (49), parallel pin (50) and spool (47) in order.



25098TM069

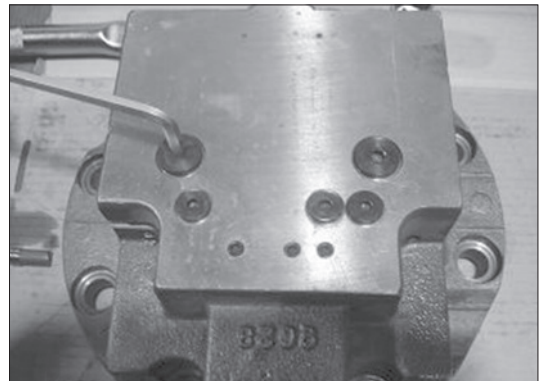


25098TM070



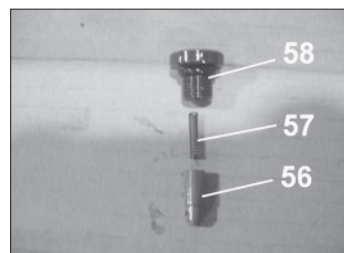
25098TM071

(21) Disassemble the plug (60) from the rear cover.

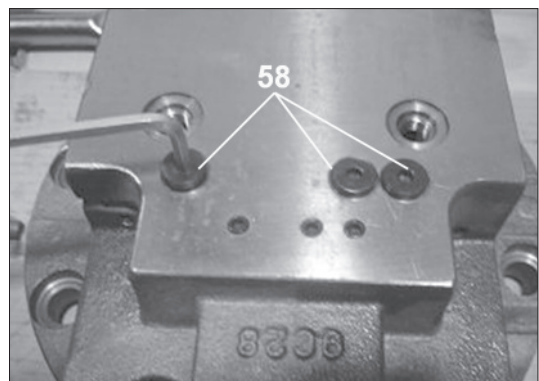


25098TM072

(22) Disassemble the plug (58) and then disassemble the spring (57) and check valve (56) from the rear cover in order.



25098TM073



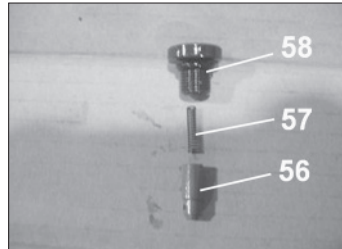
25098TM074

4. REASSEMBLING

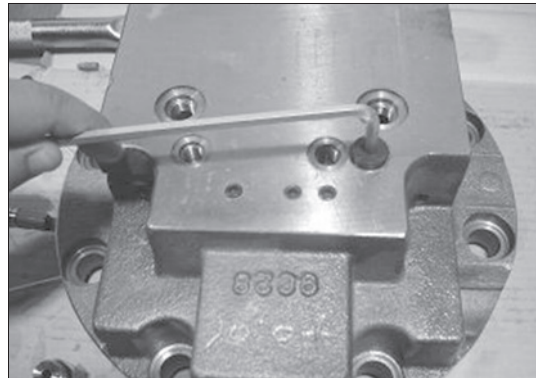
1) ASSEMBLING MOTOR

- REAR COVER ASSY

- (1) Assemble the check valve (56) and the spring (57) to the rear cover and then tighten the plug (60) by using the L-wrench.

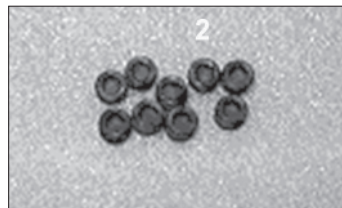


25098TM075

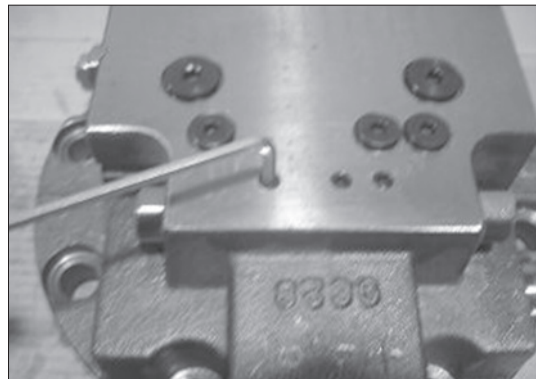


25098TM076

- (2) Apply the loctite #242 on the NPTF 1/16 plug (2, 12EA) and tighten it.

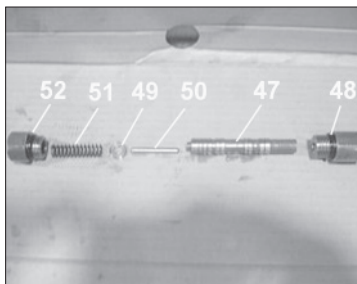


25098TM077

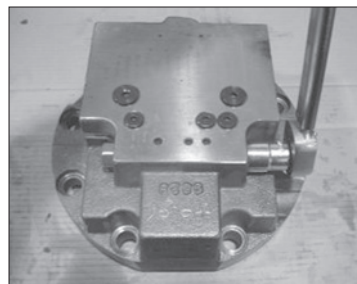


25098TM078

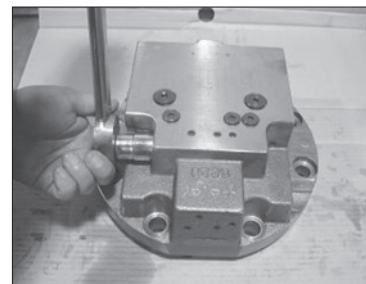
- (3) Assemble the spool (47), parallel pin (50), spring seat (49) and spring (51) into the rear cover (34) and tighten both side of the plug (48) and connector (52) into the rear cover (34).



25098TM079

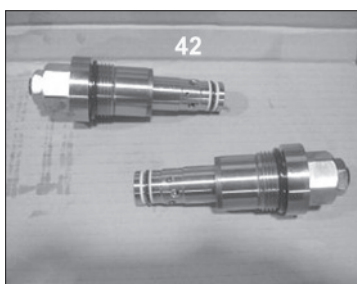


25098TM080

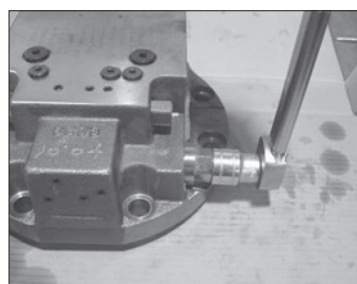


25098TM081

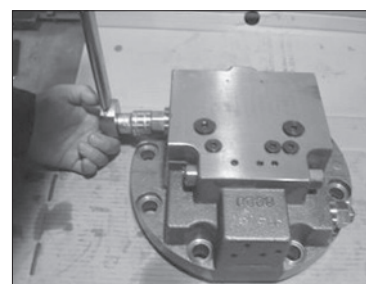
- (4) Assemble the relief valve (42, 2EA) into rear cover (34).



25098TM082



25098TM083



25098TM084

- (5) Tight fit the needle bearing (10) into rear cover (34) by using pressing jig.



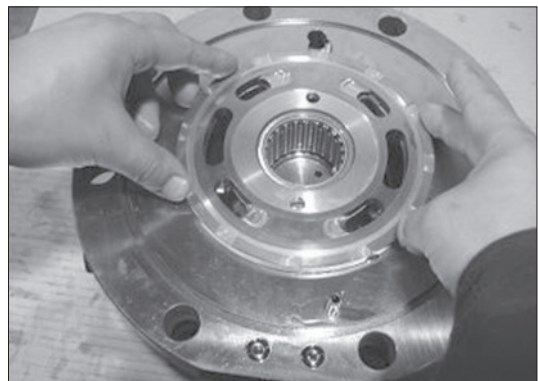
25098TM085

- (6) Assemble the spring pin (32) and parallel pin (29) into rear cover (34) by using round bar or small hammer.



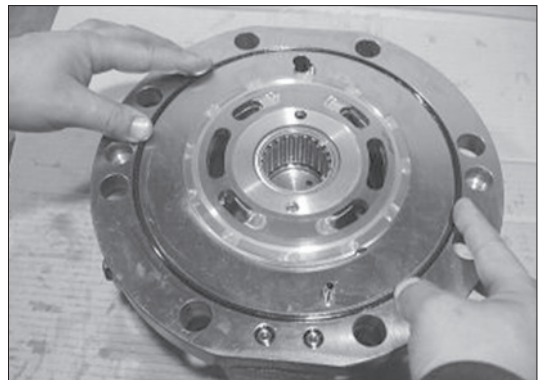
25098TM086

- (7) Assemble the valve plate (28) into rear cover (34).
Before assembling, apply some grease on contact surface of the valve plate.



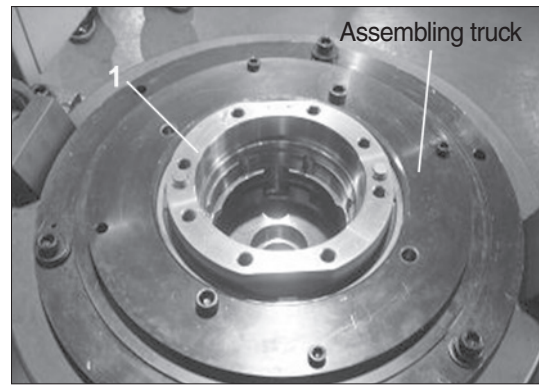
25098TM087

- (8) Apply some grease on the O-ring and fit it into groove.



25098TM088

(9) Assemble the casing (1) on the assembling truck.



25098TM089

(10) Tight fit the oil seal (3) into the casing (1) by using jig.

※ Be careful direction of the oil seal.

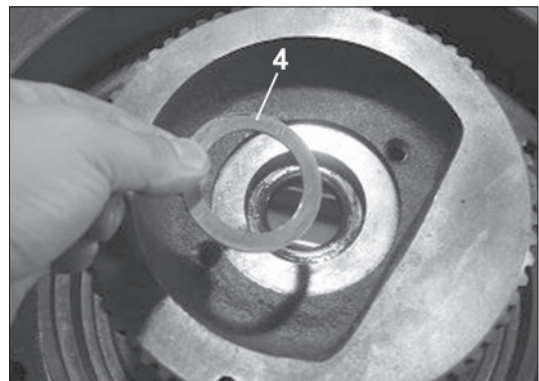


25098TM090



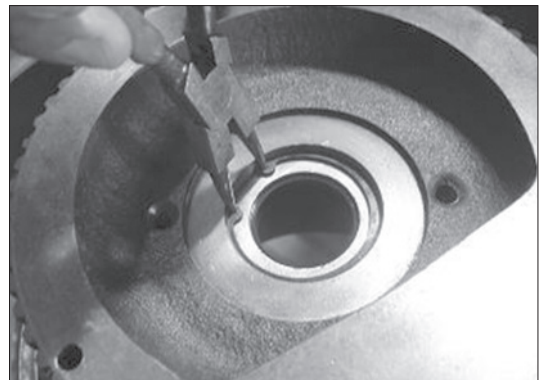
25098TM091

(11) Assemble the thrust plate (4) into the casing (1).



25098TM092

(12) Assemble the snap ring (5) into the casing (1) with the plier for retaining ring.



25098TM093

(13) Heat the roller bearing (9) and fit it into the shaft with shrink fitting.

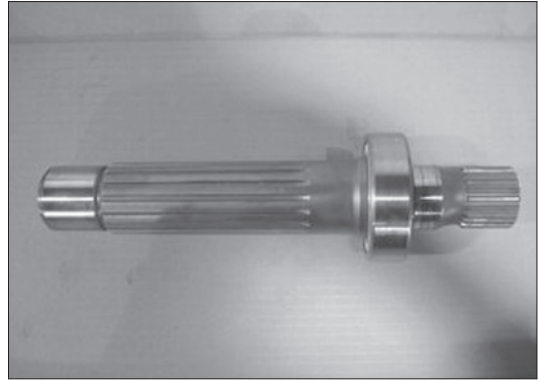
- a. Shrink fitting can be used induction heating system and set the temperature at 100°C.
- b. Be careful not to damage the sliding surface of the oil seal of the shaft.



25098TM094

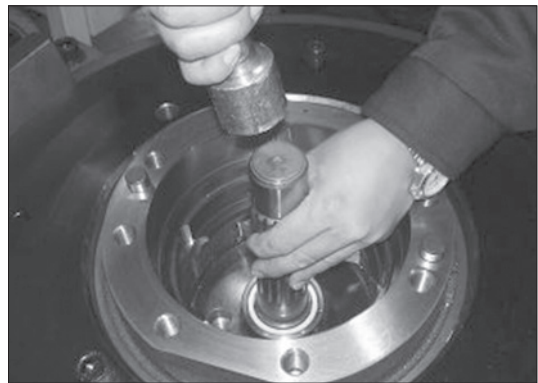


25098TM095



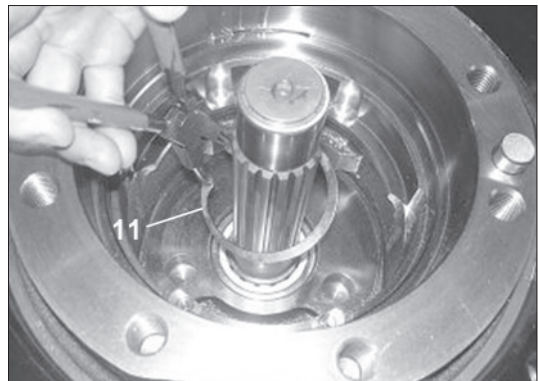
25098TM096

(14) Assemble the heat-fitted shaft (8) into casing (1).



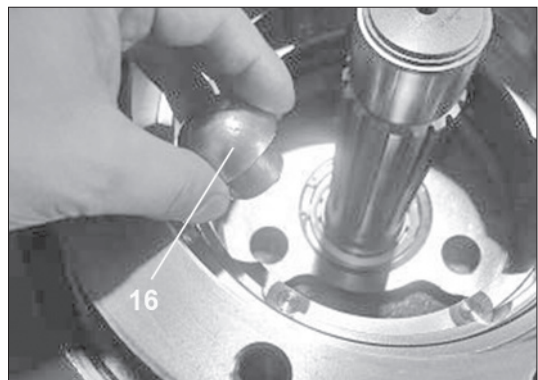
25098TM097

(15) Assemble the snap ring (11) into the casing (1) with the plier for retaining ring.



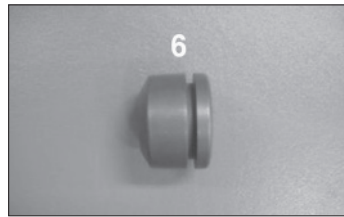
25098TM098

(16) Apply a little grease on the pivot (16, 2EA) and assemble it into the casing (1).

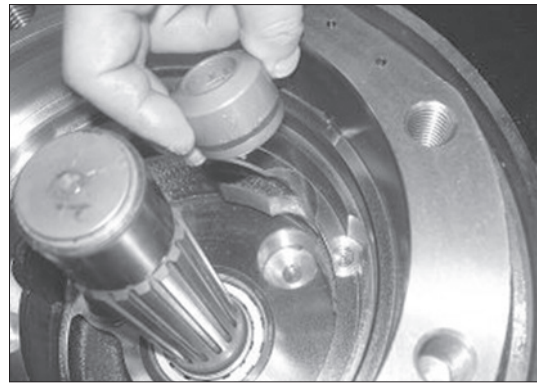


25098TM099

(17) Heat the piston seal (7) and fit it into the swash piston (6) and then tighten it a few minutes by band or tie. Loosen the band or tie and assemble it to the casing (1).

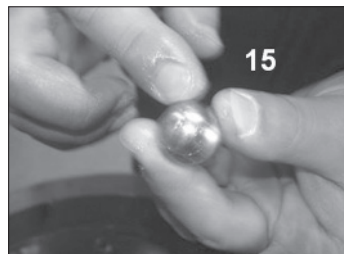


25098TM100



25098TM101

(18) Apply a little grease on the steel ball (15) and assemble it into the swash plate (17).



25098TM102



25098TM103

(19) Apply some grease on the steel ball hole of the swash plate (17) and assemble it casing (1).

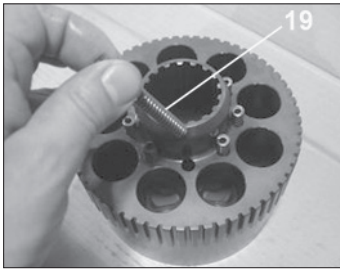


25098TM104

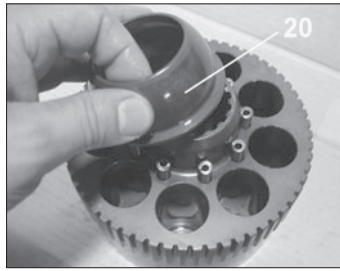


25098TM105

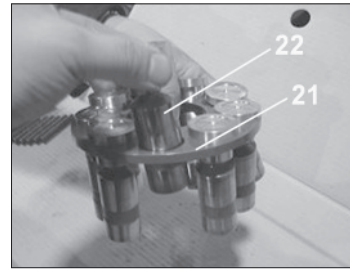
(20) Assemble the spring (19), ball guide (20), retainer plate (21) and piston assy (22) into cylinder block (18) in order.



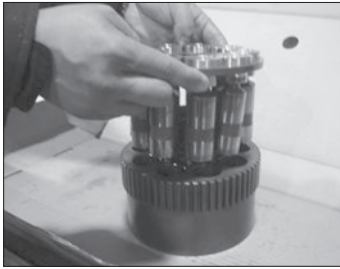
25098TM106



25098TM107



25098TM108

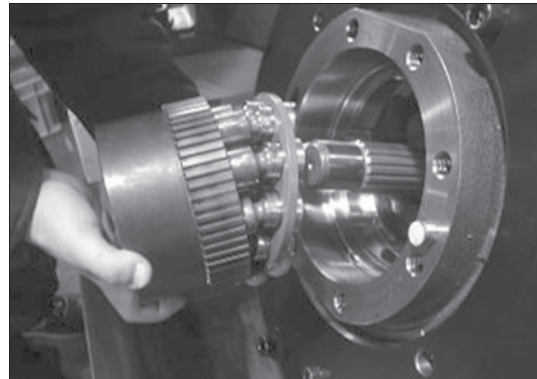


25098TM109



25098TM110

(21) Tilt the casing (1) sideways and assemble the cylinder block kit into the casing (1).



25098TM111

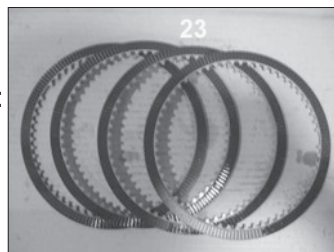
(22) Assemble the separated plate (24) and friction plate (23) into the cylinder block alternately.

Friction plate :

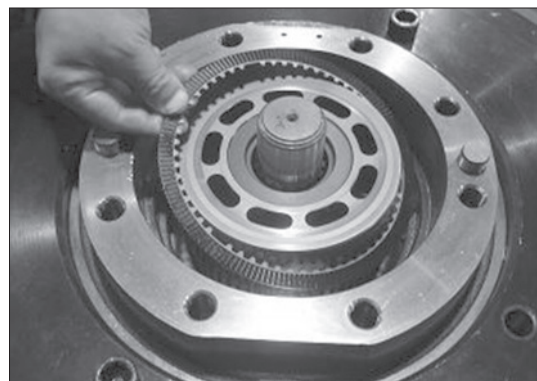
4EA

Separated plate :

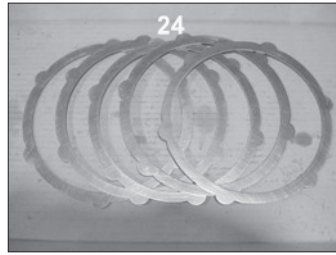
5EA



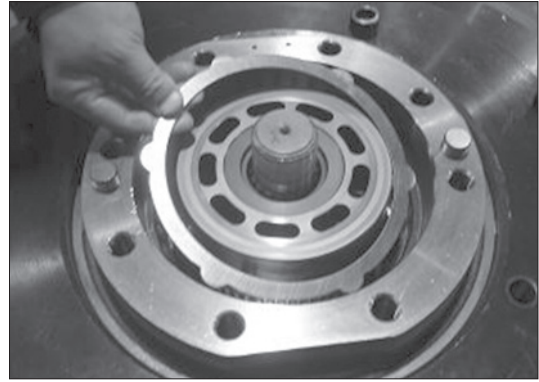
25098TM112



25098TM113

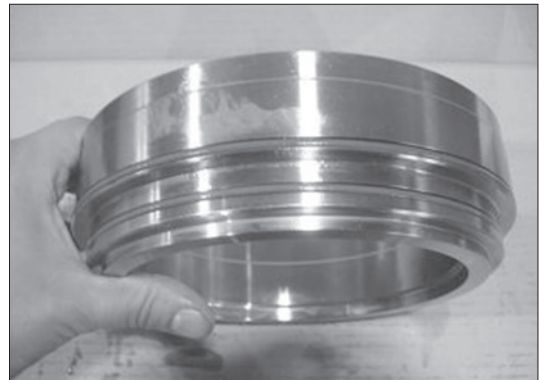


25098TM114



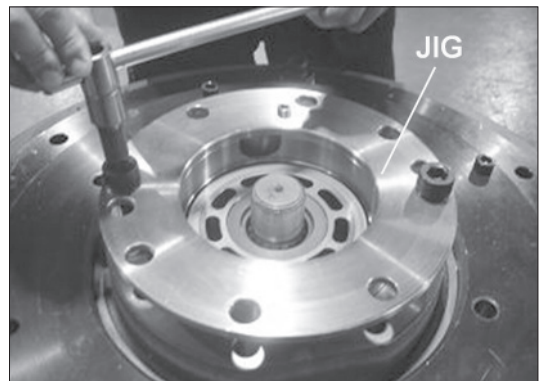
25098TM115

(23) Apply some grease on the D-ring and assemble it parking piston.



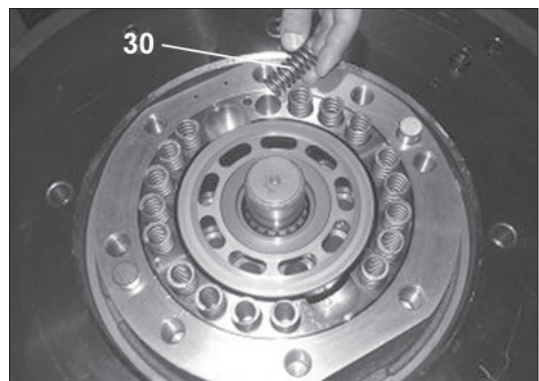
25098TM116

(24) Insert the parking piston into the casing and assemble it by using jig.



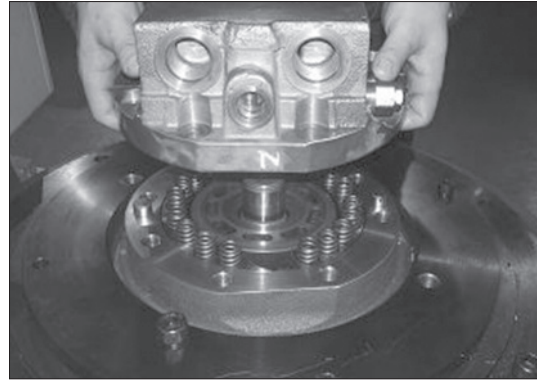
25098TM117

(25) Assemble the brake spring (30, 18EA) into the piston.



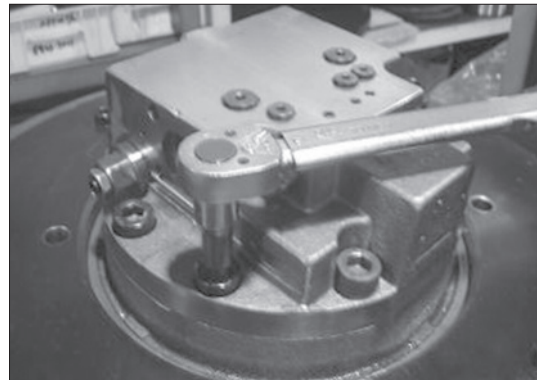
25098TM118

(26) Place the rear cover (34) on the casing (1).



25098TM119

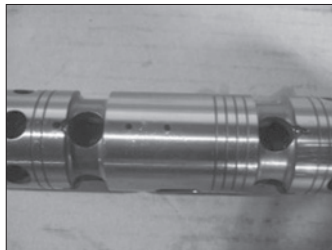
(27) Tighten the casing (1) and rear cover (34) specified torque with wrench bolt (54, 55) by using the impact wrench and torque wrench.



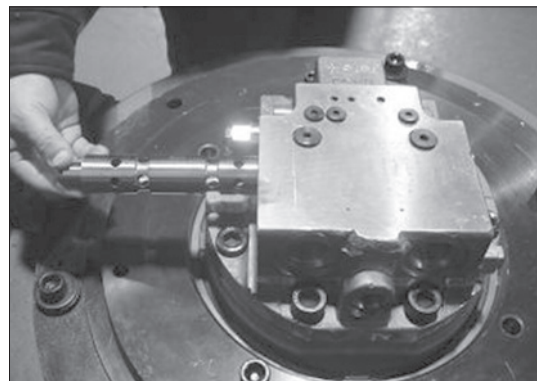
25098TM120

(28) Confirm the insert direction of the main spool Assy (35) exactly and assemble it into the rear cover (34).

※ **Assure that four balance hole is directed VA port.**

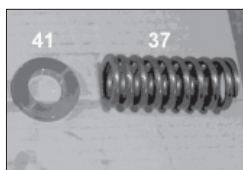


25098TM121



25098TM122

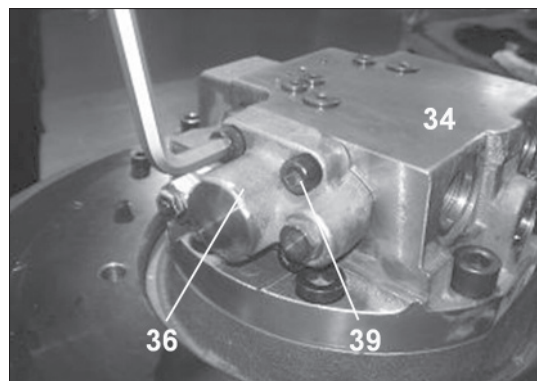
(29) Assemble the spring seat (41), spring (37) and main spool cover (36) into valve plate and tighten the wrench bolt (39, M12x35) by using L-wrench or impact wrench.



25098TM123

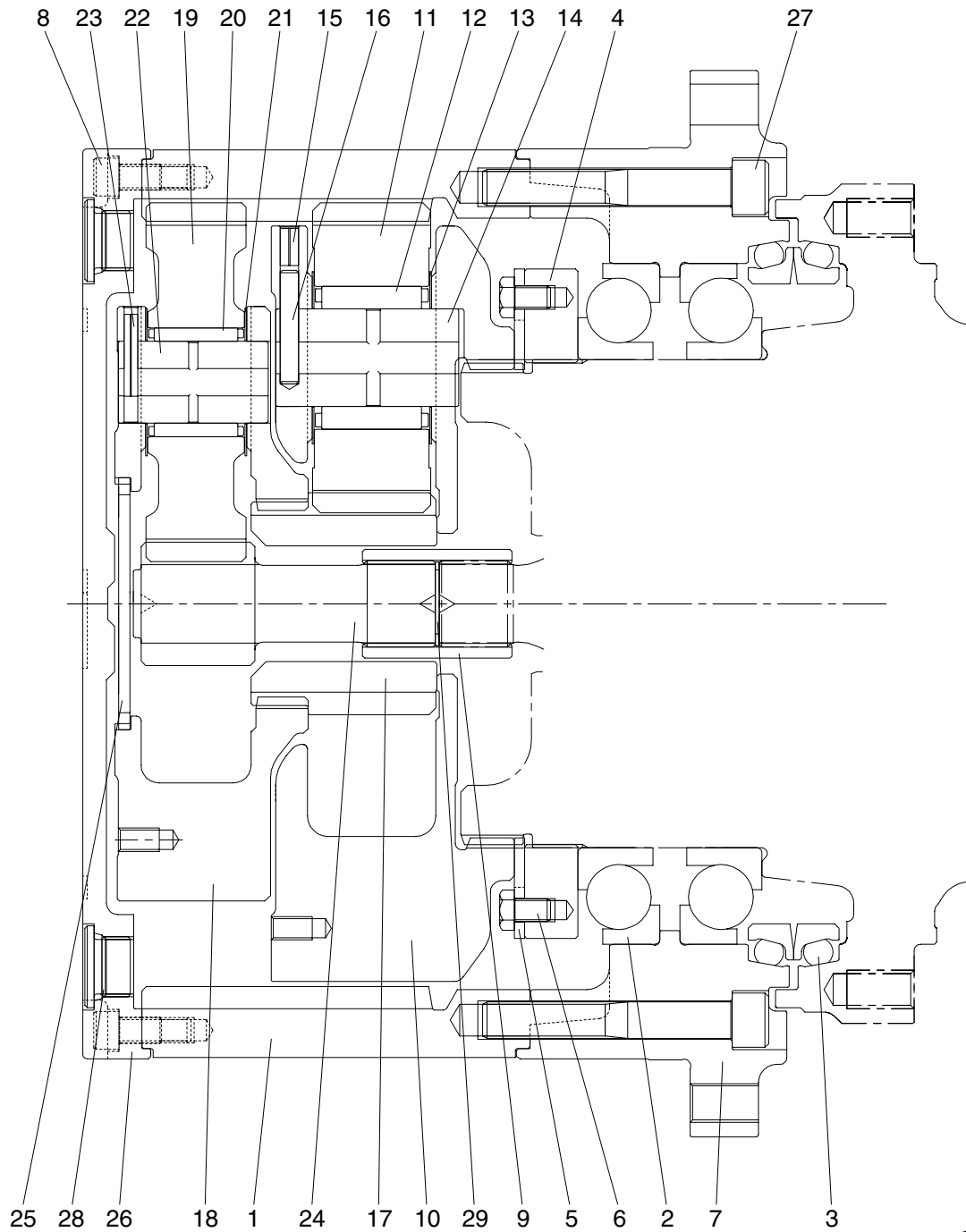


25098TM124



25098TM125

2) TRAVEL REDUCTION GEAR



25092TM22

- | | | | | | |
|----|--------------------------|----|------------------|----|--------------------------|
| 1 | Gear ring | 12 | Needle bearing 2 | 22 | Carrier pin 1 |
| 2 | Ball bearing | 13 | Thrust washer 2 | 23 | Spring pin 1 |
| 3 | Floating seal assy | 14 | Carrier pin 2 | 24 | Sun gear 1 |
| 4 | Nut ring | 15 | Spring pin 2 | 25 | Thrust plate |
| 5 | Lock plate | 16 | Solid pin 2 | 26 | Cover |
| 6 | Hexagon socket head bolt | 17 | Sun gear 2 | 27 | Hexagon socket head bolt |
| 7 | Housing | 18 | Carrier 1 | 28 | Plug |
| 8 | Hexagon socket head bolt | 19 | Planetary gear 1 | 29 | Snap ring |
| 9 | Coupling | 20 | Needle bearing 1 | 30 | Name plate |
| 10 | Carrier 2 | 21 | Thrust washer 1 | 31 | Rivet |
| 11 | Planetary gear 2 | | | | |

6. DISASSEMBLING

1) GENERAL INSTRUCTIONS

- ▲ Combustibles such as white kerosene are used for washing parts.**
These combustibles are easily ignited, and could result in fire or injury.
Be very careful when using.
 - ▲ Internal parts are coated with gear oil during disassembling and are slippery.**
If a part slips off from your hand and falls, it could result in bodily injury or could damage the park.
Be very careful when handling.
- (1) Therefore, disassembling and assembling works should be performed on the clean place where dusts hardly gather.
Tools and kerosene to wash parts should also be clean and handled with great care.
- (2) Before disassembling, review the sectional drawing and prepare the required parts, depending on the purpose and the range of disassembling.
Seals, O-rings, etc., if once disassembled, are not reusable.
There are some parts that should be replaced as a subassembly.
Consult with the parts manual in advance.
- ▲ Take great care not to pinch your hand between parts while disassembling nor let fall parts on your foot while lifting them.**

2) DISASSEMBLING TRAVEL REDUCTION GEAR

(1) Preparation for disassembling

- ① The reduction units removed from excavator are usually covered with mud. Wash outside of propelling unit and dry it.
- ② Locate reducer in order for drain port to be at the lowest level loosen taper screw plug of drain port, and drain oil from reduction gear.

※ While oil is still hot, inside of the unit may be pressurized.

▲ Take care of the hot oil gushing out of the unit when loosening the plug.

③ Mark for mating

Put marks on each mating parts when disassembling so as to reassemble correctly as before.

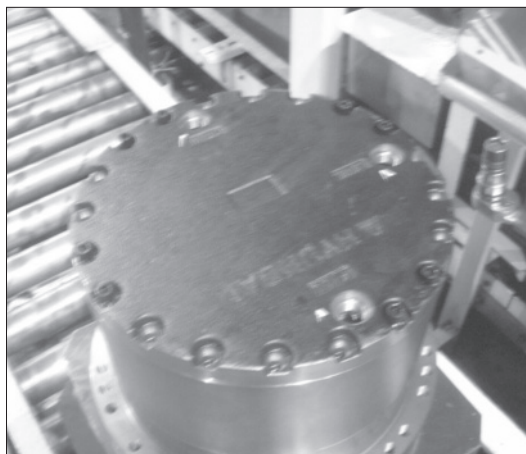


25098TM126

(2) Setting reduction unit (or whole propelling unit) on work stand for disassembling

- ① Remove 7/16-14UNC hexagon socket head bolts at 3 places from cover almost equally apart each other, and then install 7/16-14UNC eye bolts.

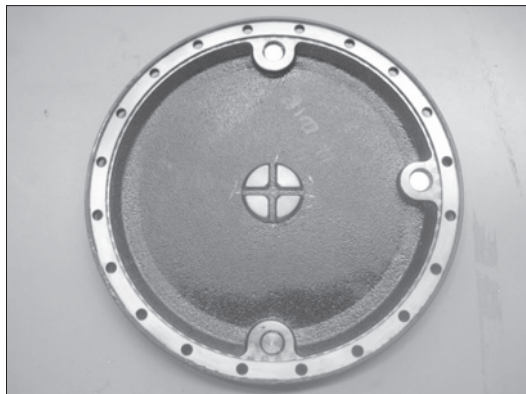
▲ Take great care not to pinch your hand between parts while disassembling nor let fall parts on your foot while lifting them.



25098TM127

(3) Removing cover

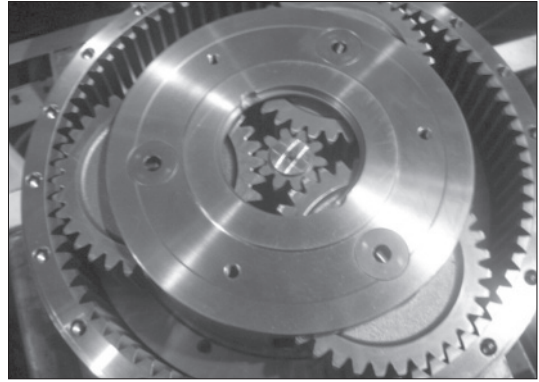
- ① Remove the rest of 7/16-14UNC hexagon socket head bolts that secure cover and ring gear. Loosen all the socket bolts and then, disassemble cover.
- ② As the cover is adhered to ring gear, disassemble ring gear and cover by lightly hammering slantwise upward using sharpen punch inserted between the cover and ring gear.



25098TM128

(4) Removing No.1 carrier sub assembly

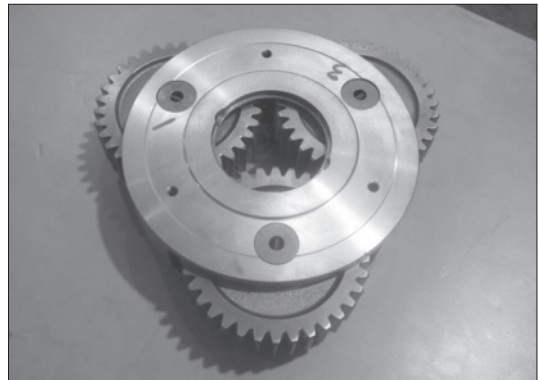
- ① Screw three M10 eye-bolt in No.1 carrier and lift up and remove No.1 carrier assy.



25098TM129

- ② Remove No.1 sun gear.

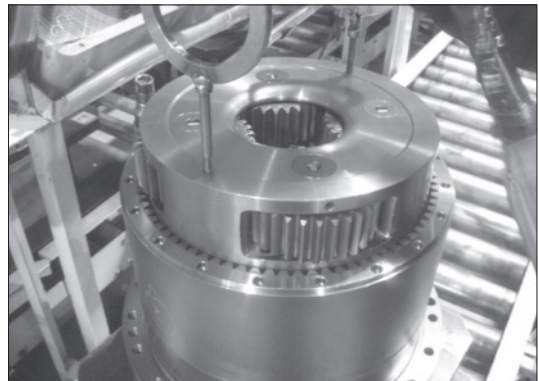
- ※ Be sure to maintain it vertical with the ground when disassembling No.1 sun gear.



25098TM130

(5) Removing No.2 carrier sub assembly

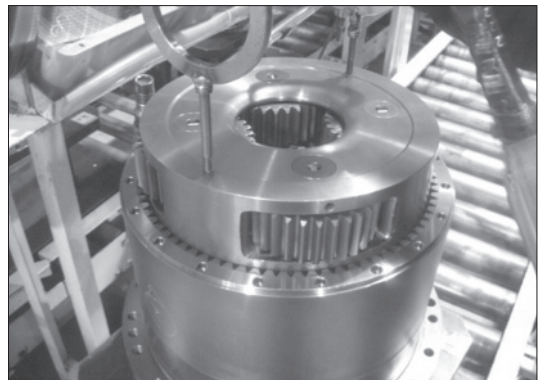
- ① Screw three M10 eye-bolt in No.2 carrier and lift up and remove No.2 carrier assy.



25098TM131

- ② Remove No.2 sun gear.

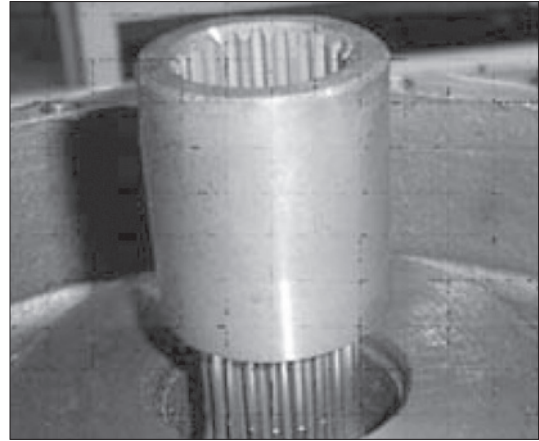
- ※ Be sure to maintain it vertical with the ground when disassembling No.1 sun gear.



25098TM132

(6) Removing coupling

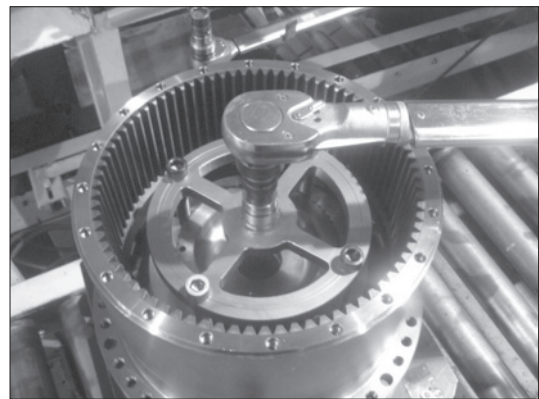
- ① Remove coupling.



25098TM133

(7) Removing nut ring & lock plate

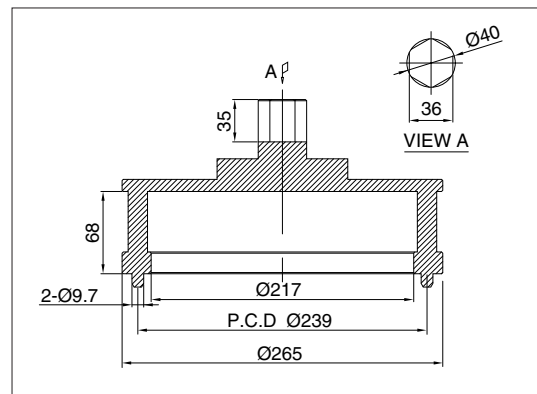
- ① Remove M12 hexagon head bolts that secure nut ring and lock plate.
- ② Remove lock plate.



25098TM134

- ③ Remove nut ring from motor casing.

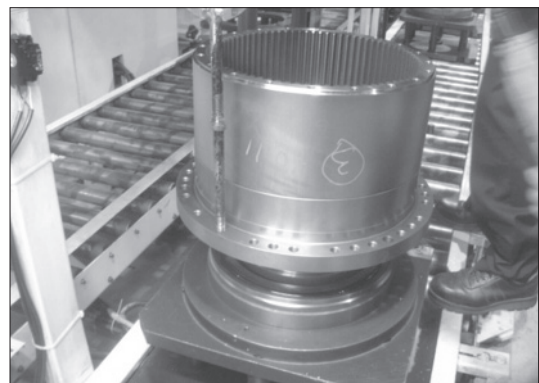
※ Remove the nut ring by using the special tool for removing the nut ring.



220L8TM01

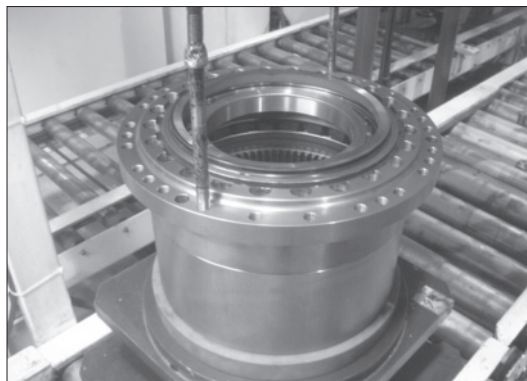
(8) Removing housing sub assembly & ring gear

- ① Screw 7/16-14UNC eye bolt in housing and lift up ring gear and housing assembly including angular bearing and floating seal.



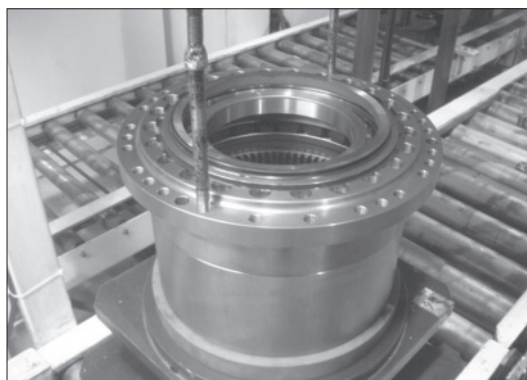
25098TM135

- ② Setting reduction unit on work stand for disassembling. Remove M16 hexagon socket head bolts that secure ring gear and housing assembly.



25098TM136

- ③ As the ring gear is adhered to housing assy, disassemble housing assy and ring gear by lightly hammering slantwise upward using sharpen punch inserted between the housing assy and ring gear.



25098TM137

(9) Removing floating seal

- ① Lift up a piece of floating seal of motor side.

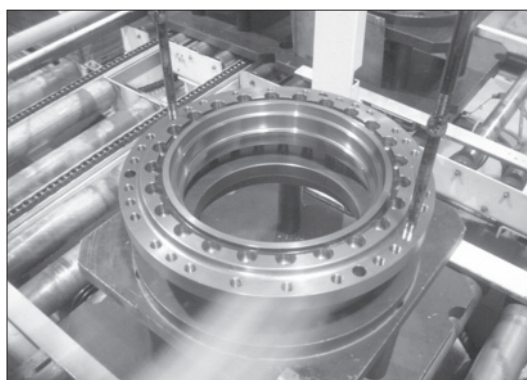


25098TM138

(10) Removing housing sub assembly

- ① Setting housing assembly on work stand for disassembling.
② After setting housing, lift up a piece of floating seal from housing and then remove it.

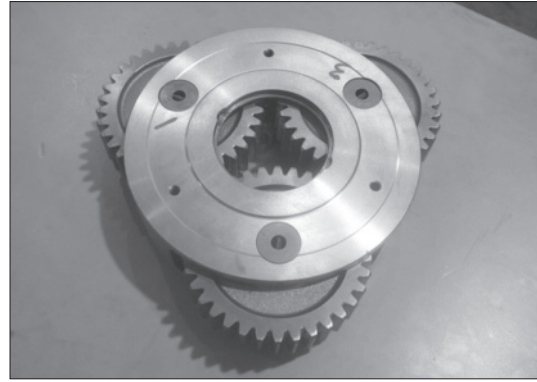
※ Don't disassemble angular bearing.



25098TM139

(11) Disassembling No.1 carrier

- ① Remove thrust plate.



25098TM140

- ② Knock spring pin fully into No.1 pin.



25098TM141

- ③ Remove planetary, thrust washer, No.1 pin, bearing from carrier.



25098TM142

(12) Disassembling No.2 carrier

- ① Knock spring pin fully into No.2 pin.
- ② Remove No.2 solid pin.
- ③ Remove planetary, thrust washer, No.2 pin, bearing from carrier.



25098TM143

7. ASSEMBLY REDUTION UNIT

1) GENERAL NOTES

- (1) Clean every part by kerosene and dry them by air blow.
- (2) Surfaces to be applied by loctite must be decreased by solvent.
- (3) Check every part for any abnormal.
- (4) Each hexagon socket head bolt should be used with loctite No.242 applied on its threads.
- (5) Apply gear oil slightly on each part before assembling.

▲ Take great care not to pinch your hand between parts or tools while assembling nor let fall parts on your foot while lifting them.

Inspection before reassembling.

Thrust washer

- Check if there are seizure, abnormal wear or uneven wear.
- Check if wear is over the allowable limit.

Gear

- Check if there are pitting or seizure on the tooth surface.
- Check if there are cracks on the root of tooth by die check.

Bearing

- Rotate by hand to see if there are something unusual such as noise or uneven rotation.

Floating seal

- Check flaw or score on sliding surfaces or O-ring.

2) ASSEMBLING CARRIER 1 ASSY

- (1) Put No.1 carrier on a flat place.
- (2) Install No.1 needle bearing into No.1 planetary gear, put 2EA of No.1 thrust washer on both sides of planetary gear, and then, install it into carrier.



25098TM144

- (3) Install No.1 pin into No.1 carrier where the holes for No.1 pin are to be in line with those of No.1 carrier, and then, install spring pins into the holes.



25098TM145

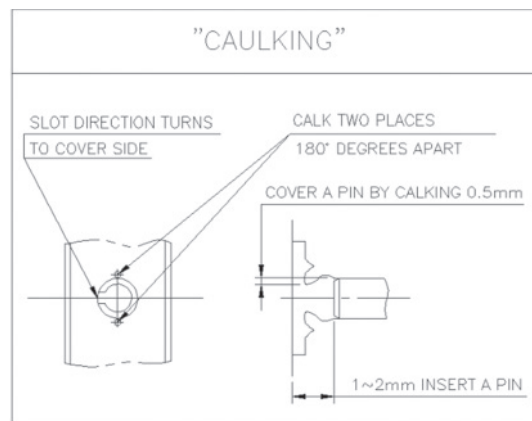
(4) Caulk carrier holes as shown on the picture.



25098TM146

3) ASSEMBLING CARRIER 2 ASSY

- (1) Put No.2 carrier on a flat place.
- (2) Install No.2 needle bearing into No.2 planetary gear, put 2EA of No.2 thrust washer on both sides of planetary gear, and then, install it into carrier.



25098TM147

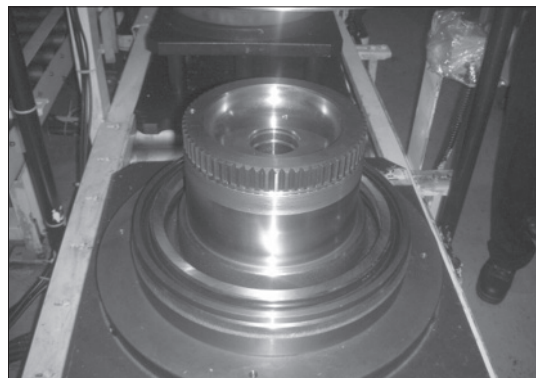
- (3) After install solid pin into the holes, install No.2 pin into No.1 carrier where the holes for No.1 pin are to be in line with those of No.1 carrier, and then, install spring pins into the holes.
- (4) Caulk carrier holes as shown on the picture.



25098TM148

4) ASSEMBLING FLOATING SEAL

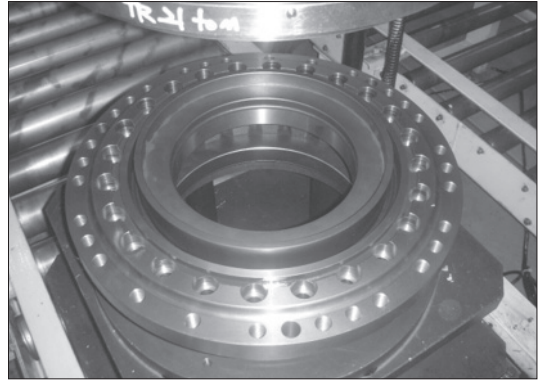
- (1) Assemble floating seal into motor by use of pressing jig.
Grease the contact parts for floating seal which is assembled into motor.
- ※ **Be sure to maintain it vertical with the ground when assembling bearing and floating seal.**



25098TM149

5) ASSEMBLING HOUSING

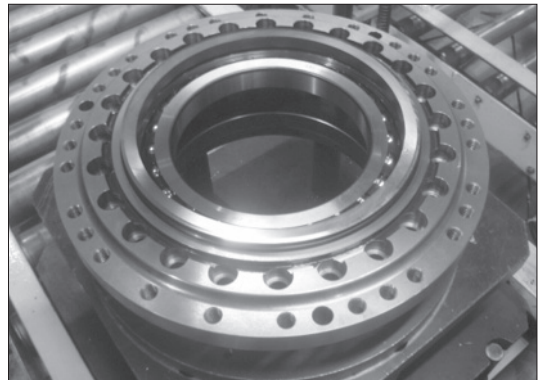
- (1) Heat housing at 60~70°C while clearing it out and then, assemble floating seal into housing by use of pressing jig.
- (2) Setting housing assembly on work stand for assembling.
Assemble angular bearing into housing by use of pressing jig.



25098TM150

- (3) Assemble floating seal into housing by use of pressing jig.
Do not reuse the disassembling O-ring.
Grease the contact parts for floating seal which is assembled into housing.

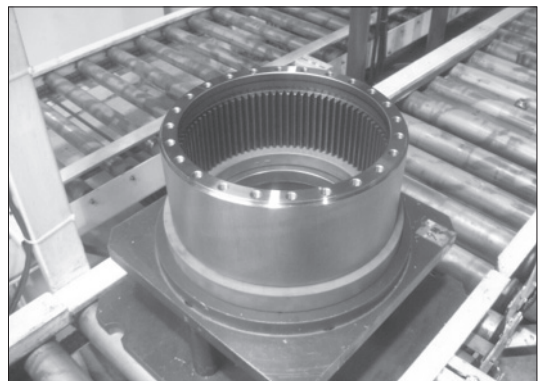
※ **Be sure to maintain it vertical with the ground when assembling bearing and floating seal.**



25098TM151

6) ASSEMBLING HOUSING ASSY AND RING GEAR

- (1) Setting ring gear on work stand for assembling.
Apply loctite #515 on ring gear for housing without gap.

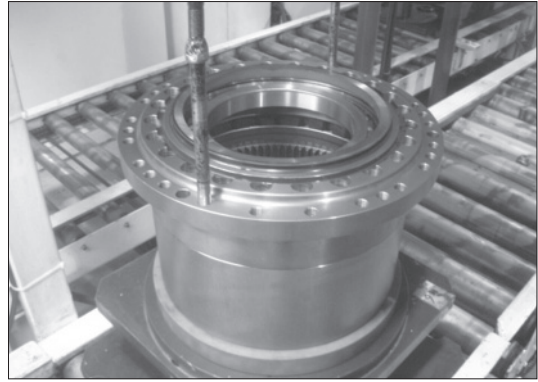


25098TM152



25098TM153

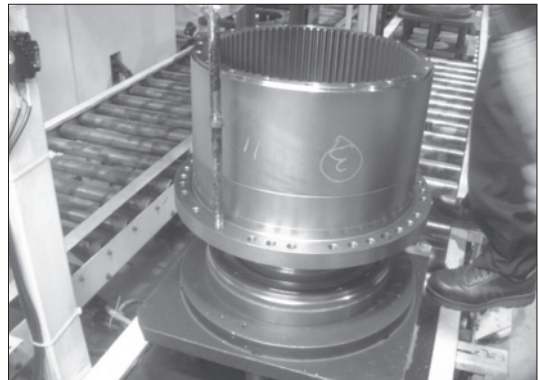
- (2) Install M16 eye-bolt on the tap of housing.
- (3) Lift housing and then, assemble into housing in order for bolt hole of ring gear and bolt hole of housing to be in line.
- (4) Apply loctite #242 on M16 hexagon socket head bolt, and then, bolt.



25098TM154

7) ASSEMBLING HOUSING ASSY AND MOTOR

- (1) Install 7/16-14UNC eye-bolt on the tap of ring gear.
 - (2) Assemble housing assembly into motor by use of hoist and eye-bolt.
- ※ **Be sure to tighten eye-bolt deep enough.**



25098TM155

8) ASSEMBLING MAIN BEARING

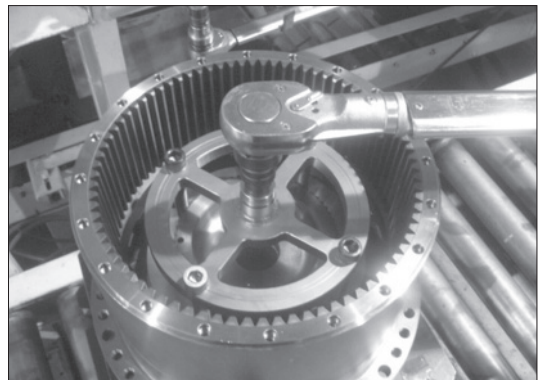
- (1) Assemble angular bearing into housing by use of pressing jig.
- ※ **Be sure to maintain it vertical with the ground when assembling bearing.**



25098TM156

9) ASSEMBLING NUT RING AND LOCK PLATE

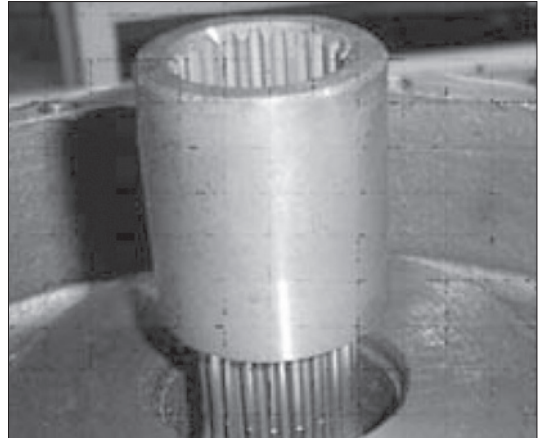
- (1) Tighten nut ring to specified torque, utilizing special tool.
- (2) After install lock plate, apply loctite #242 on M12 hexagon head bolt, and then, bolt. Tighten M12 hexagon head bolt to specified torque, with torque wrench.



25098TM157

10) ASSEMBLING COUPLING

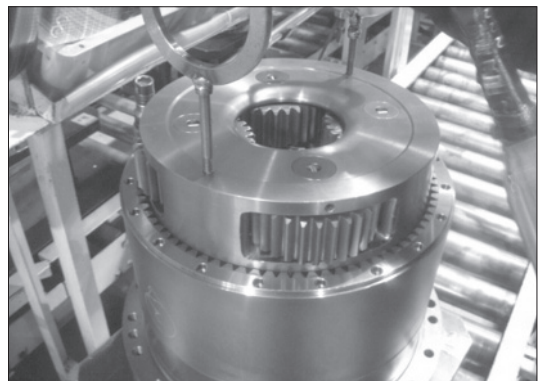
- (1) Install coupling on spline of the motor.



25098TM158

11) ASSEMBLING NO.2 CARRIER SUB ASSEMBLY

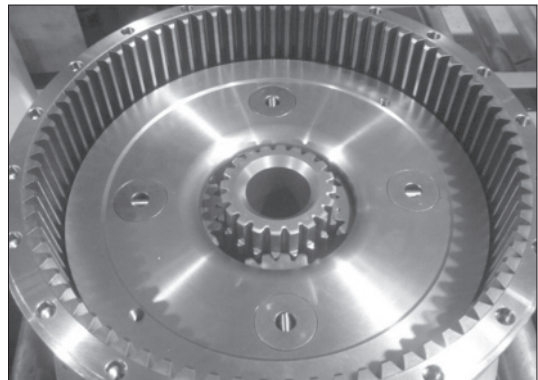
- (1) Install M10 eye-bolt on No.2 carrier assembly.
 - (2) Lift No.2 carrier assembly and then, slowly put it down on ring gear.
 - (3) Rotate planetary gear by hands and install on ring gear.
 - (4) Rotate No.2 carrier assembly by hands and install on motor.
- ※ **Match pin hole of No.2 Carrier with main(A,B) port of motor.**



25098TM159

12) ASSEMBLING NO.2 SUN GEAR

- (1) Install No.2 sun gear on the No.2 planetary gear, matching teeth of them.



25098TM160

13) ASSEMBLING NO.1 CARRIER SUB ASSEMBLY

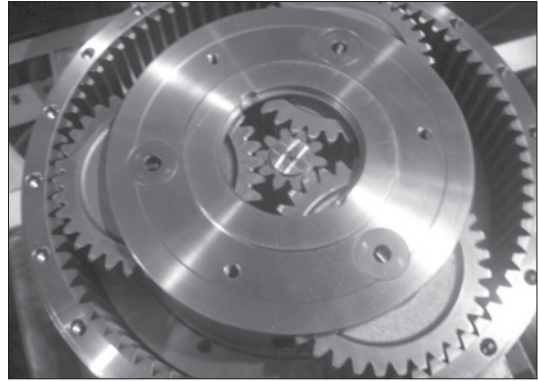
- (1) Install M10 eye-bolt on No.1 carrier assembly.
- (2) Lift No.1 carrier assembly and then, slowly put it down on ring gear.
- (3) Rotate planetary gear by hands and install on ring gear.
- (4) Rotate No.1 carrier assembly by hands and install on No.2 sun gear.



25098TM161

14) ASSEMBLING NO.1 SUN GEAR

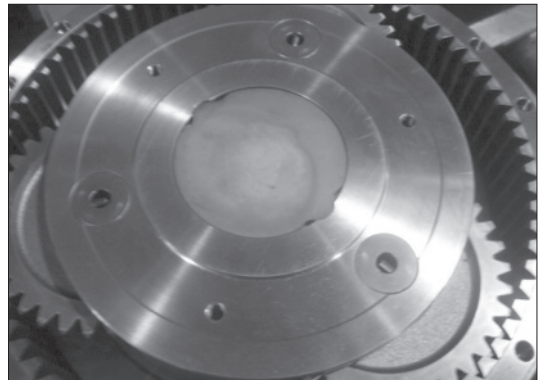
- (1) Put down No.1 sun gear on No.1 carrier, maintaining it vertical with spline of coupling.
- (2) Install No.1 sun gear on No.1 planetary gear, matching their teeth.



25098TM162

15) ASSEMBLING THRUST PLATE

- (1) Assembly thrust plate into No.1 carrier.
- ※ **Edge of thrust plate direction turns to cover side.**



25098TM163

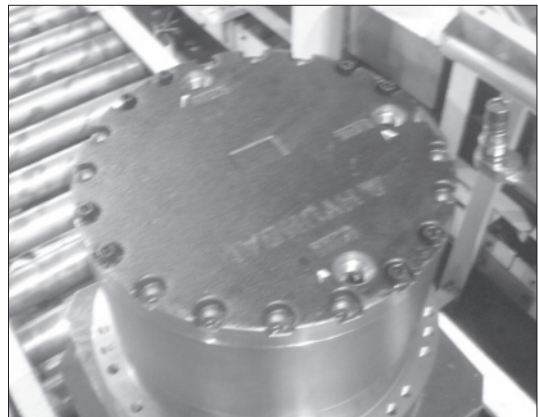
16) ASSEMBLING COVER

- (1) Apply loctite#515 on the ring gear for cover without gap.



25098TM164

- (2) Put cover on ring gear, apply loctite #242 on 7/16-14UNC hexagon socket head bolt, and then, bolt.
Tighten 7/16-14UNC hexagon socket head bolt to specified torque, with torque wrench.
- (3) Fill gear oil (6liter) into drain port.
- (4) Apply gear oil on PF3/4 hydraulic plug and then, bolt.



25098TM165