

Product: MINI HYD EXCAVATOR

Model: 303.5E MINI HYD EXCAVATOR RKY

Configuration: 303.5E Mini Hydraulic Excavator RKY00001-UP (MACHINE) POWERED BY C1.8 Engine

## **Disassembly and Assembly 303E CR, 303.5E, 304E, 305.5E and 305E Mini Hydraulic Excavators Machine Systems**

Media Number -UENR0148-04

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i04778100

## **Swing Motor and Swing Drive - Assemble**

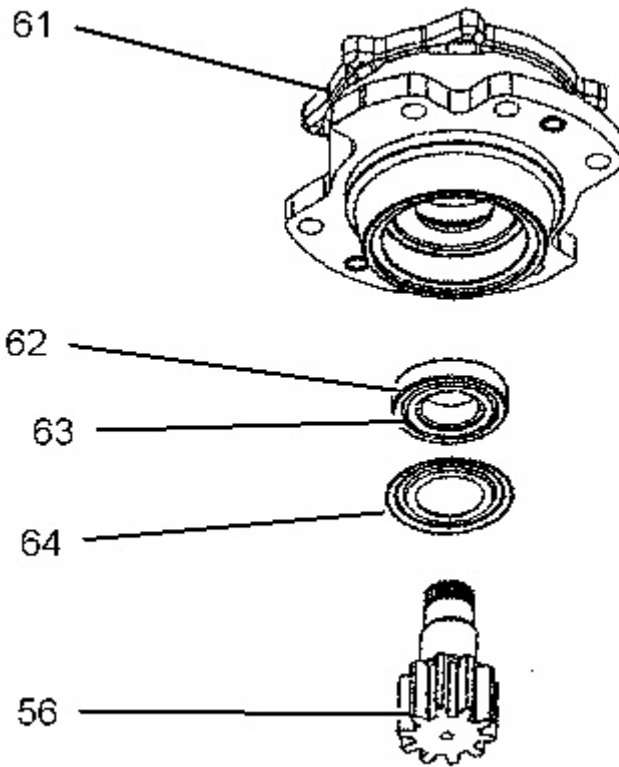
SMCS - 5058-016-ZW; 5459-016

### **Assembly Procedure**

Table 1

<b>Required Tools</b>			
<b>Tool</b>	<b>Part Number</b>	<b>Part Description</b>	<b>Qty</b>
C	1P-1857	Retaining Ring Pliers	1
D	1P-1859	Retaining Ring Pliers	1

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Illustration 1

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1. Lower the temperature of bearing cup (62).
2. Install bearing cup (62) into housing (61).
3. Install seal (64) and bearing cone (63) onto shaft (56).



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Illustration 2

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4. Lower the temperature of bearing cup (59).
  5. Install lip seal (60) and bearing cup (59).
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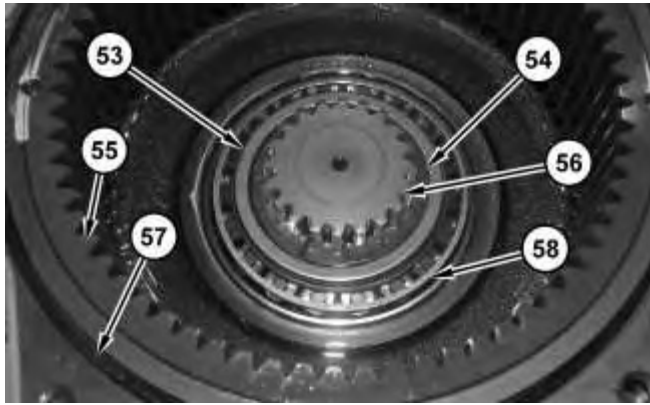


Illustration 3

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6. Install shaft (56) and bearing cone (58).
7. Install retainers (54), ring (53), ring gear (55), and O-ring seal (57).

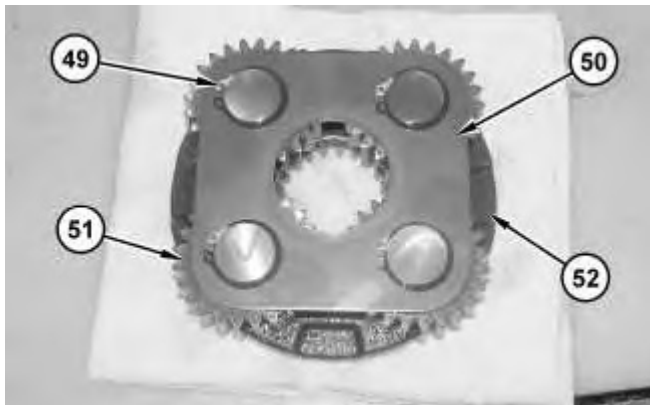


Illustration 4

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8. Install the bearings, gears (51), and plate (50) onto carrier (52).
9. Use Tooling (D) in order to install retaining ring (49).

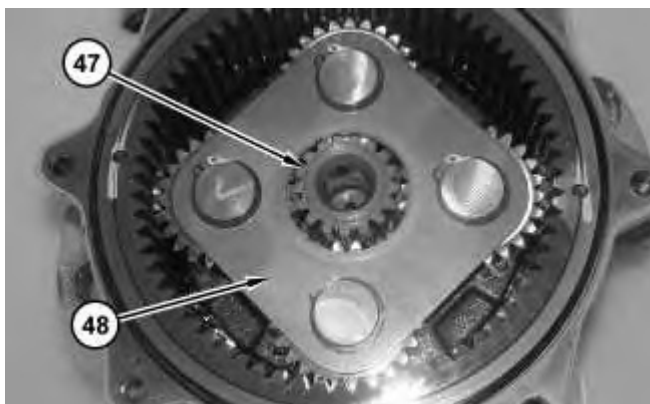


Illustration 5

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10. Install carrier assembly (48) and gear (47).

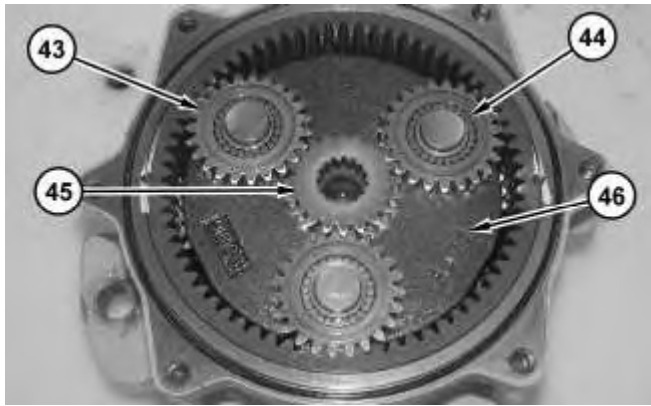


Illustration 6

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11. Install carrier (46), gear (45), bearings (44), and gears (43).

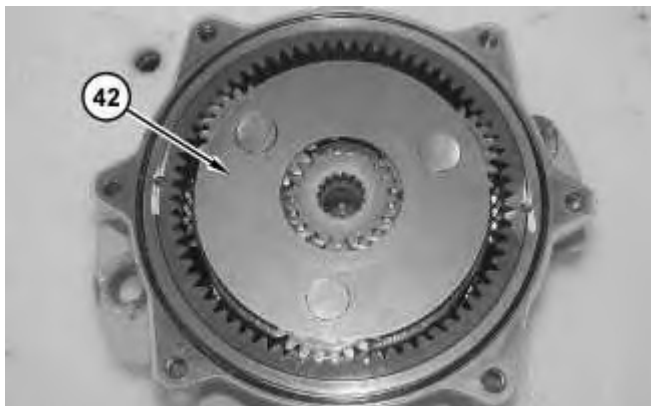


Illustration 7

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12. Install plate (42).

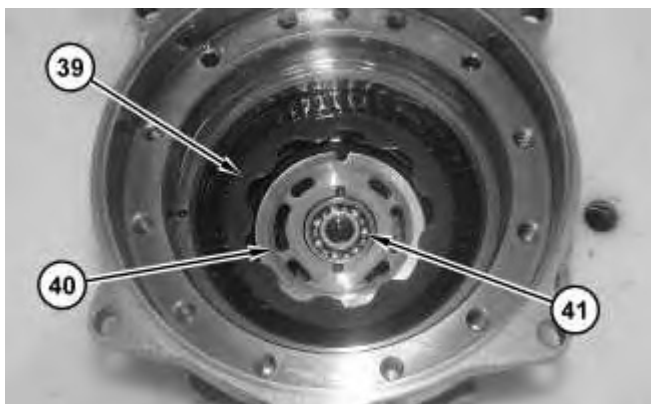


Illustration 8

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13. Install bearing (41), port plate (40), and plate (39).
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