

## UNDERCARRIAGE / Swing Bearing

### Assemble Swing Bearing

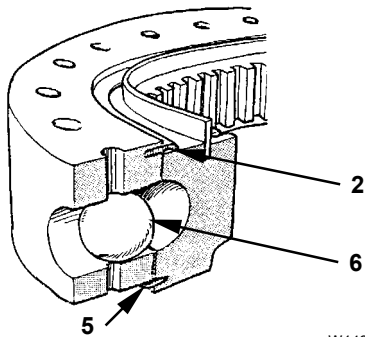
**⚠ CAUTION:** Swing bearing weight: 642 kg (1420 lb)  
Outer race (1) weight: 289 kg (640 lb)

1. Align inner race (7) of the swing bearing with the ball groove on outer race (1).

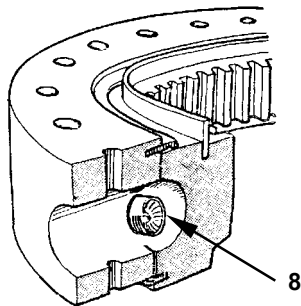
**IMPORTANT:** Apply grease to balls (6) and support (8).

2. Install balls (6) (86 used) and support (8) (86 used) alternately from the plug hole. Install ball (6) first.

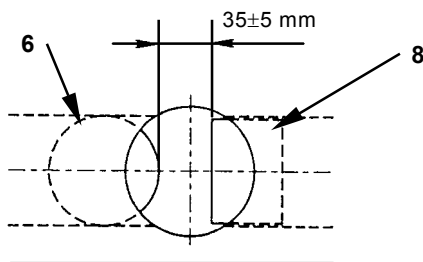
3. Clean the groove part for seals (2, 5) completely. Apply THREE BOND #1530D and install seal (2) to outer race (1). Install seal (5) to the groove part on inner race (7).
4. Install plug (4) into outer race (1). Secure plug (4) with pin (3). Crimp the head of pin (3) by using a punch.
5. Apply much grease to the swing bearing.



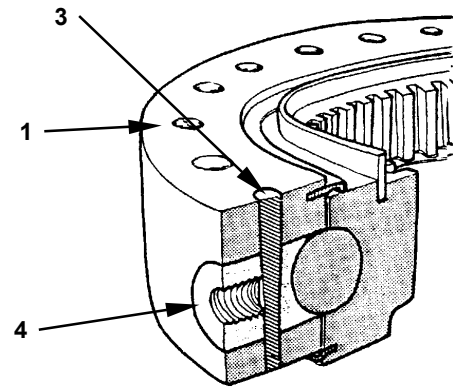
W142-03-01-005



W142-03-01-006



W142-03-01-004



W142-03-01-007

**✎ NOTE:** Dia. of support (8): 26 mm  
Dia. of support (9): 50.8 mm