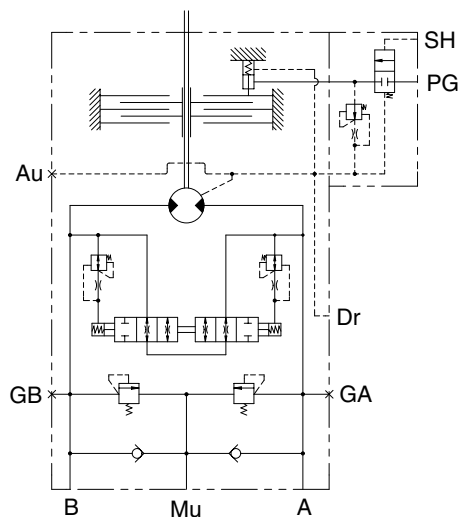
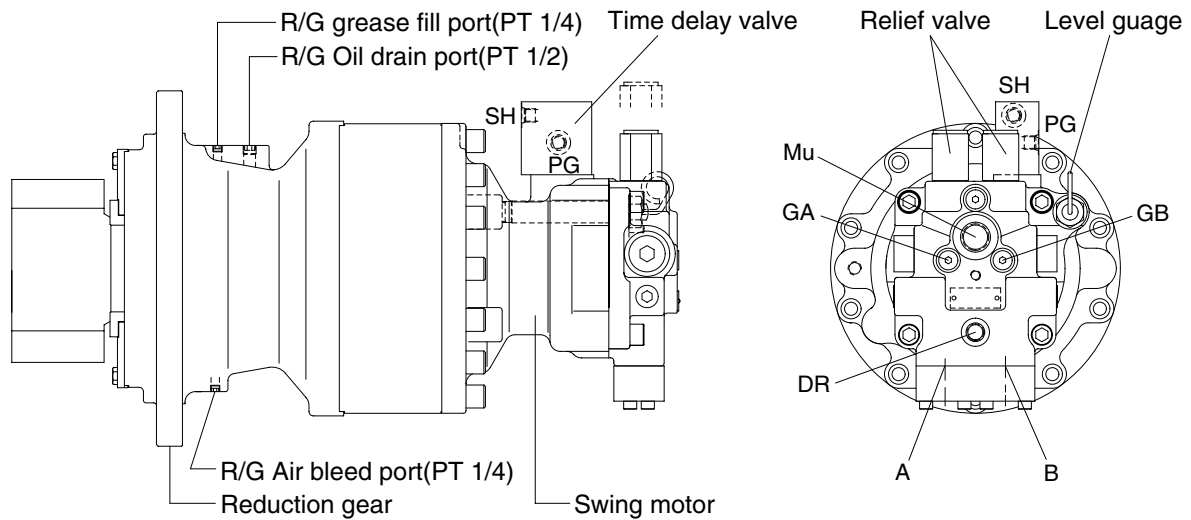


GROUP 3 SWING DEVICE

1. STRUCTURE

Swing device consists swing motor, swing reduction gear.

Swing motor include mechanical parking valve, relief valve, make up valve and time delay valve.

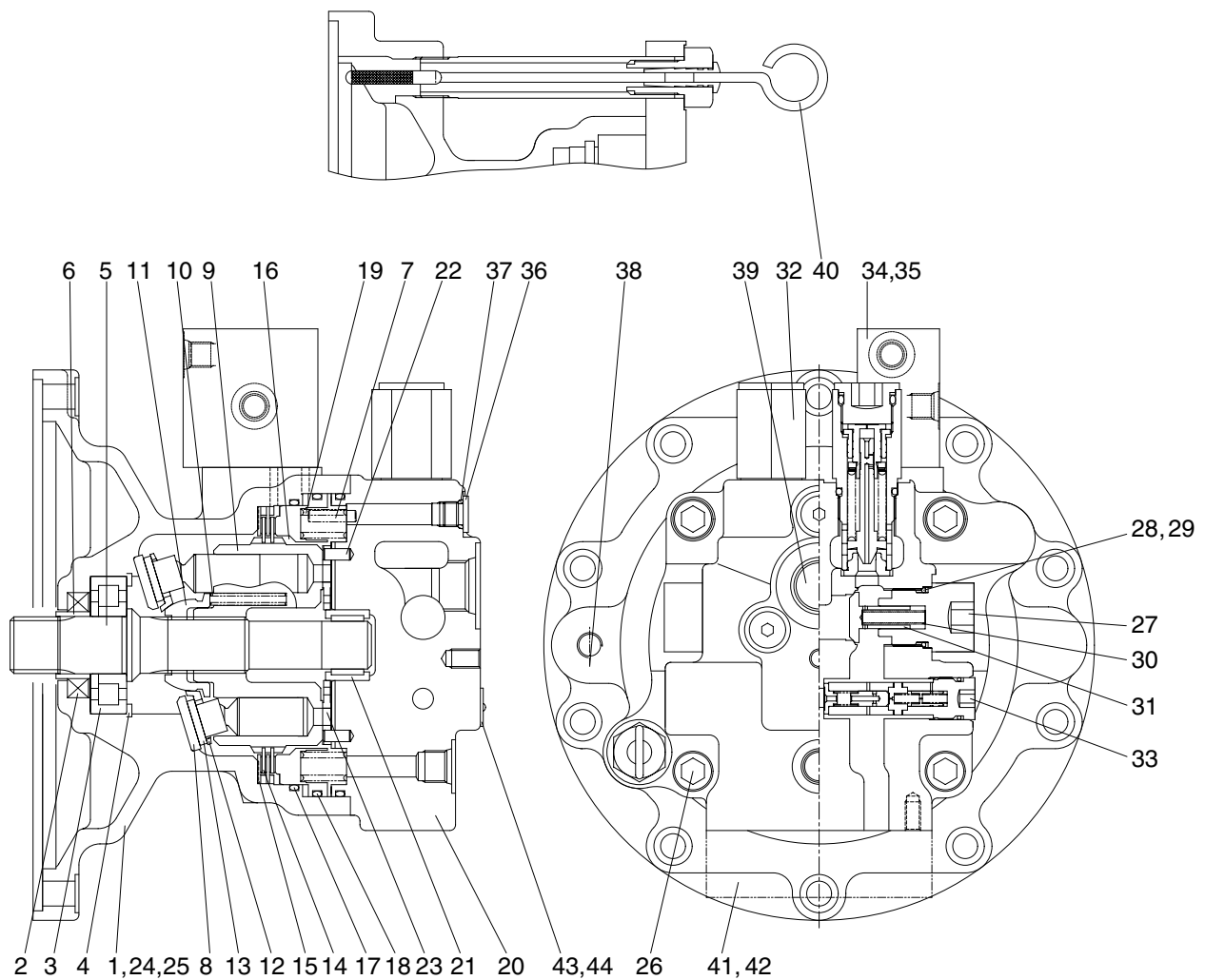


Hydraulic circuit

Port	Port name	Port size
A	Main port	PF 3/4
B	Main port	PF 3/4
Dr	Drain port	PF 1/2
Mu	Make up port	PF 3/4
SH	Brake release port	PF 1/4
PG	Stand by port	PF 1/4
GA, GB	Gage port	PF 1/4
Au	Air vent port	PF 1/4

1407A2SM01

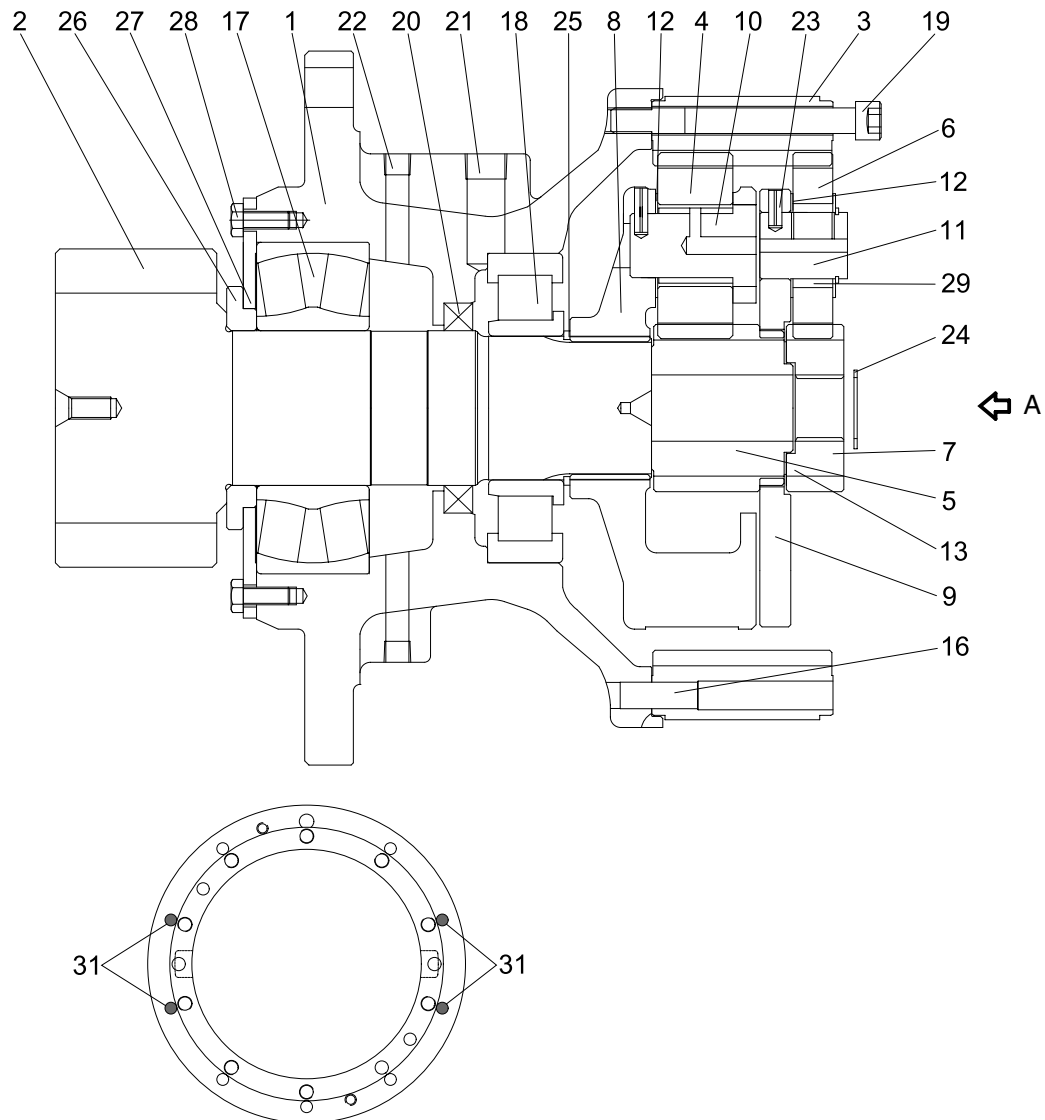
1) SWING MOTOR



1407A2SM02

- | | | |
|--------------------|-------------------|------------------------|
| 1 Body | 17 O-ring | 33 Anti-rotating valve |
| 2 Oil seal | 18 O-ring | 34 Time delay valve |
| 3 Roller bearing | 19 Spring | 35 Wrench bolt |
| 4 Snap ring | 20 Rear cover | 36 Plug |
| 5 Shaft | 21 Needle bearing | 37 O-ring |
| 6 Bushing | 22 Pin | 38 Plug |
| 7 Pin | 23 Valve plate | 39 Plug |
| 8 Shoe plate | 24 O-ring | 40 Level gauge |
| 9 Cylinder block | 25 O-ring | 41 Flange |
| 10 Spring | 26 Wrench bolt | 42 O-ring |
| 11 Ball guide | 27 Plug | 43 Name plate |
| 12 Set plate | 28 Back up ring | 44 Rivet |
| 13 Piston assembly | 29 O-ring | 45 Plug |
| 14 Friction plate | 30 Spring | 46 O-ring |
| 15 Separate plate | 31 Check | 47 O-ring |
| 16 Brake piston | 32 Relief valve | 48 Back up ring |

2) REDUCTION GEAR



VIEW A

1407A2SM03

1	Casing	11	Pin No.1	22	Plug(A)
2	Drive shaft	12	Thrust washer(B)	23	Spring pin
3	Ring gear	13	Side plate No. 1	24	Stop ring
4	Planet gear No.2	16	Knock pin	25	Stop ring
5	Sun gear No.2	17	Sph roller bearing	26	Spacer
6	Planet gear No.1	18	Cyl roller bearing	27	Cover plate
7	Sun gear No.1	19	Socket head bolt	28	Bolt
8	Carrier No.2	20	Oil seal	29	Needle cage
9	Carrier No.1	21	Plug(B)	31	Rubber cap
10	Pin No.2 assembly				

2. FUNCTION

1) ROTARY PART

When high pressurized oil enters a cylinder through port(a), which is the inlet of valve plate(23), hydraulic pressure acting on the piston causes axial force F. The pressure force F works via the piston(13) upon the set plate(12) which acts upon the shoe plate(8) via an hydrostatic bearing. Force F1 perpendicular to shoe plate(8) and force F2 perpendicular to cylinder center.

Being transferred to the cylinder block(9) through piston, force F2 causes rotational moment at surroundings of cylinder.

Since cylinder block has 9 equidistantly arrayed pistons, rotational torque is transmitted to cylinder shaft in order by several pistons connected to the inlet port of high pressurized oil. When the direction of oil flow is reversed, rotational direction of cylinder is also reversed. Output torque is given by the equation.

$$T = \frac{p \times q}{2\pi}, q = Z \cdot A \cdot \text{PCD} \cdot \tan\theta, F1 = \frac{F}{\cos\theta}, F2 = F \tan\theta, S = \text{PCD} \times \tan\theta$$

Where p : Effective difference of pressure(kgf/cm²)

q : Displacement(cc/rev)

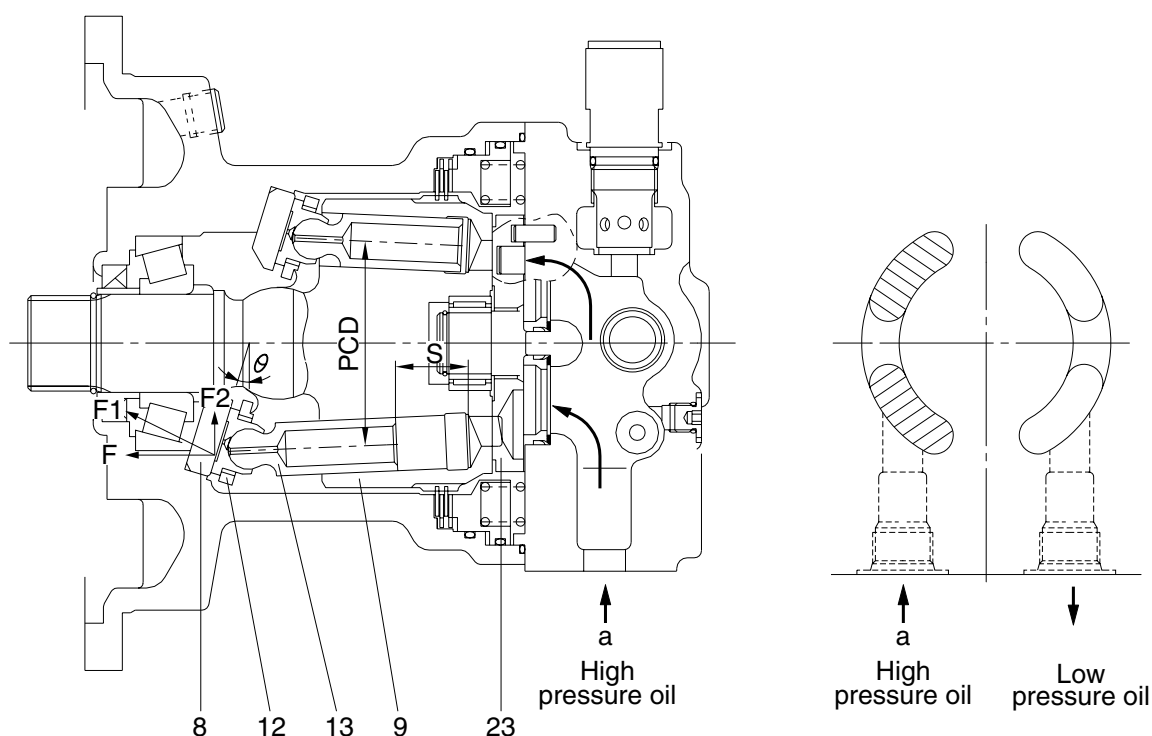
T : Output torque(kgf · cm)

Z : Piston number(9EA)

A : Piston area(cm²)

θ : Tilting angle of swash plate(degree)

S : Piston stroke(cm)



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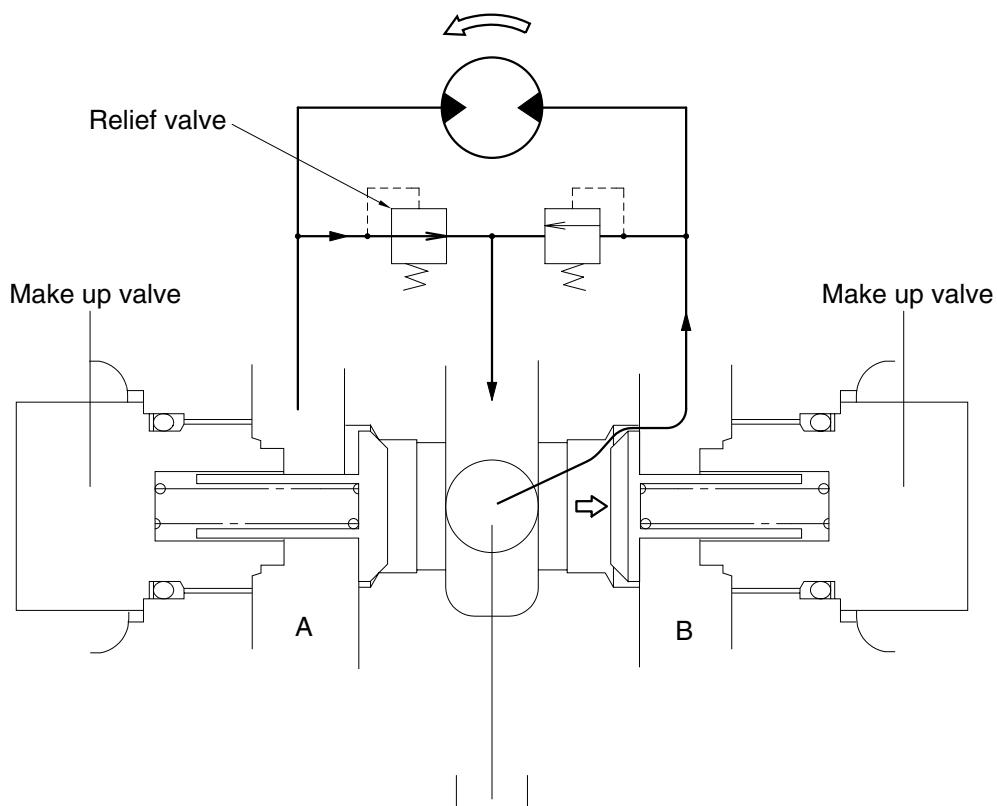
2) MAKE UP VALVE

In the system using this type of motor, there is no counterbalance functioning valve and there happens the case of revolution exceeding hydraulic supply of motor. To prevent the cavitation caused by insufficient oil flow there is a make up valve to fill up the oil insufficiency.

A make up valve is provided immediately before the port leading to the hydraulic oil tank to secure feed pressure required when the hydraulic motor makes a pumping action. The boost pressure acts on the hydraulic motor's feed port via the make up valve.

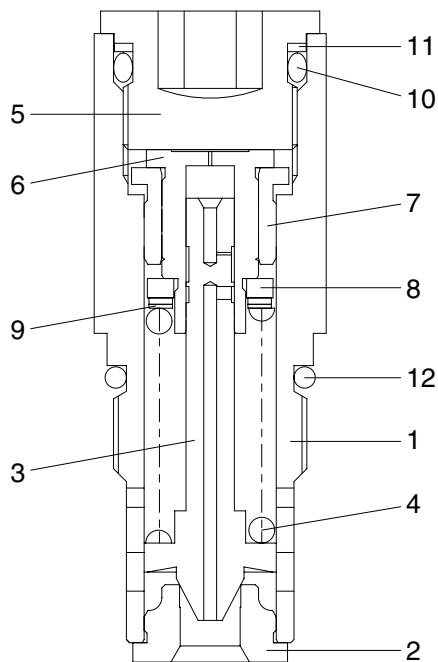
Pressurized oil into the port B, the motor rotate counterclockwise.

If the plunger of MCV moves neutral position, the oil in the motor is drain via left relief valve, the drain oil run into motor via right make up valve, which prevent the cavitation of motor.



1107A2SM04

3) RELIEF VALVE



- 1 Body
- 2 Seat
- 3 Plunger
- 4 Spring
- 5 Adjusting screw
- 6 Piston
- 7 Bushing
- 8 Spring seat
- 9 Shim
- 10 O-ring
- 11 Back up ring
- 12 O-ring

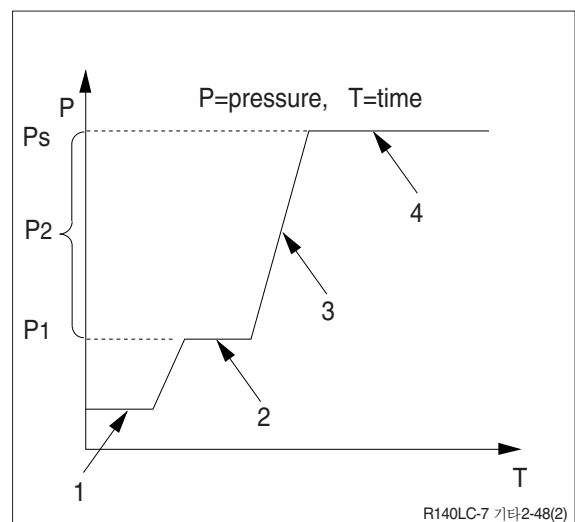
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(1) Construction of relief valve

The valve casing contains two cartridge type relief valves that stop the regular and reverse rotations of the hydraulic motor. The relief valves relieve high pressure at start or at stop of swing motion and can control the relief pressure in two steps, high and low, in order to insure smooth operation.

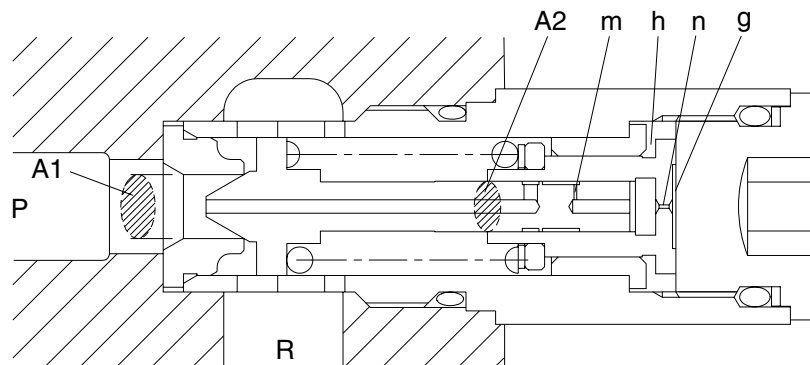
(2) Function of relief valve

Figure illustrates how the pressure acting on the relief valve is related to its rising process. Here is given the function, referring to the figure following page.



R140LC-7 기타2-48(2)

- ① Ports (P,R) at tank pressure.

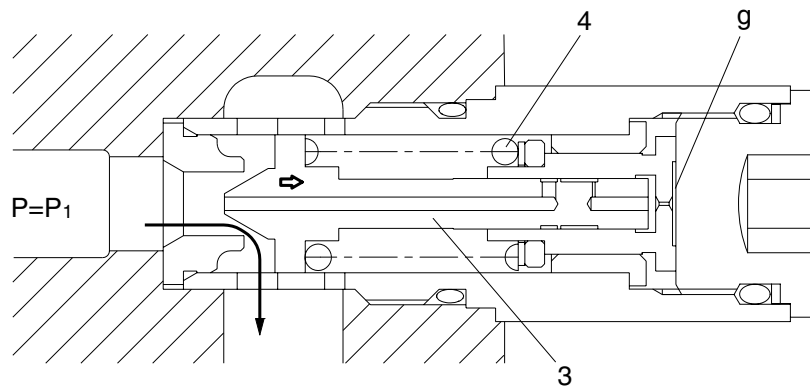


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- ② When hydraulic oil pressure($P \times A_1$) reaches the preset force(F_{sp}) of spring(4), the plunger(3) moves to the right as shown.

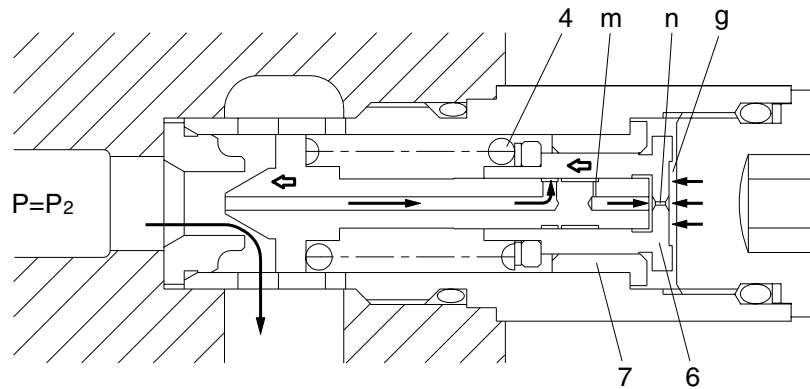
$$P_1 \times A_1 = F_{sp} + P_g \times A_2$$

$$P_1 = \frac{F_{sp} + P_g \times A_2}{A_1}$$



14007A2SM07

- ③ The oil flow chamber g via orifice m and n. When the pressure of chamber g reaches the preset force(F_{sp}) of spring(4), the piston(6) moves left and stop the piston(6) hits the bottom of bushing(7).

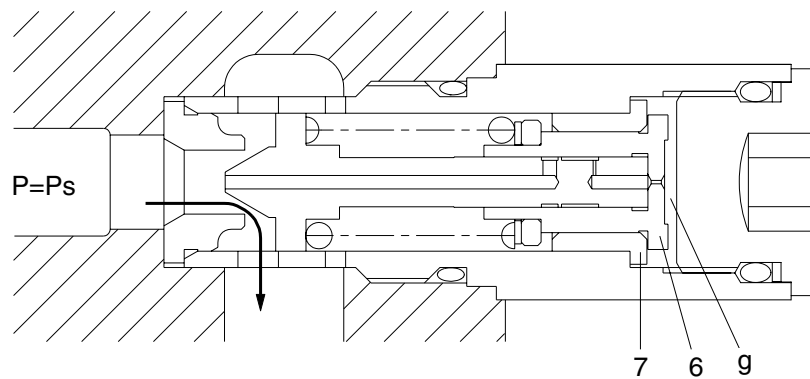


14007A2SM08

- ④ When piston(6) hits the bottom of bushing(7), it stops moving to the left any further. As the result, the pressure in chamber(g) equals(P_s).

$$P_s \times A_1 = F_{sp} + P_s \times A_2$$

$$P_s = \frac{F_{sp}}{A_1 - A_2}$$



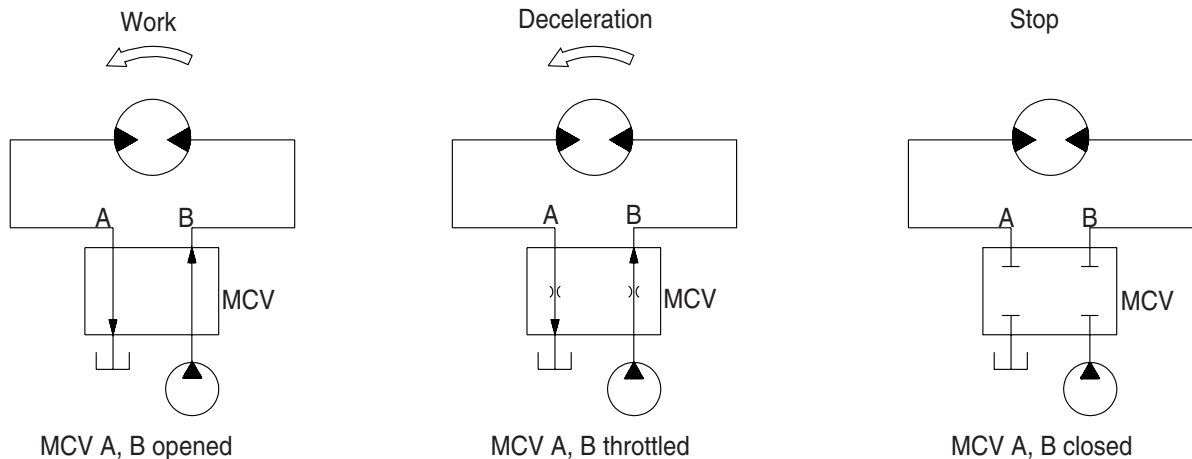
14007A2SM09

4) BRAKE SYSTEM

(1) Control valve swing brake system

This is the brake system to stop the swing motion of the excavator during operation.

In this system, the hydraulic circuit is throttled by the swing control valve, and the resistance created by this throttling works as a brake force to slow down the swing motion.



R140LC-7 기타2-48(1)

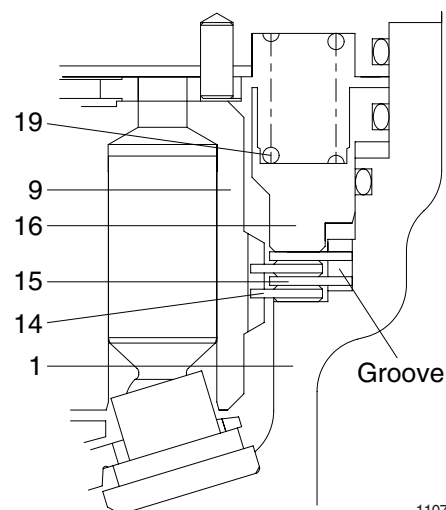
(2) Mechanical swing parking brake system

The mechanical swing parking brake system is installed to prevent the upper structure from swinging downhill because of its own weight when the excavator is parked on a slope since it completely eliminates the hydraulic drift of swing motion while the excavator is on a slope, work can be done more easily and safely.

① Brake assembly

Circumferential rotation of separate plate(15) is constrained by the groove located at body(1). When housing is pressed down by brake spring(19) through friction plate(14), separate plate(15) and brake piston(16), friction force occurs there.

Cylinder block(9) is constrained by this friction force and brake acts, while brake releases when hydraulic force exceeds spring force.



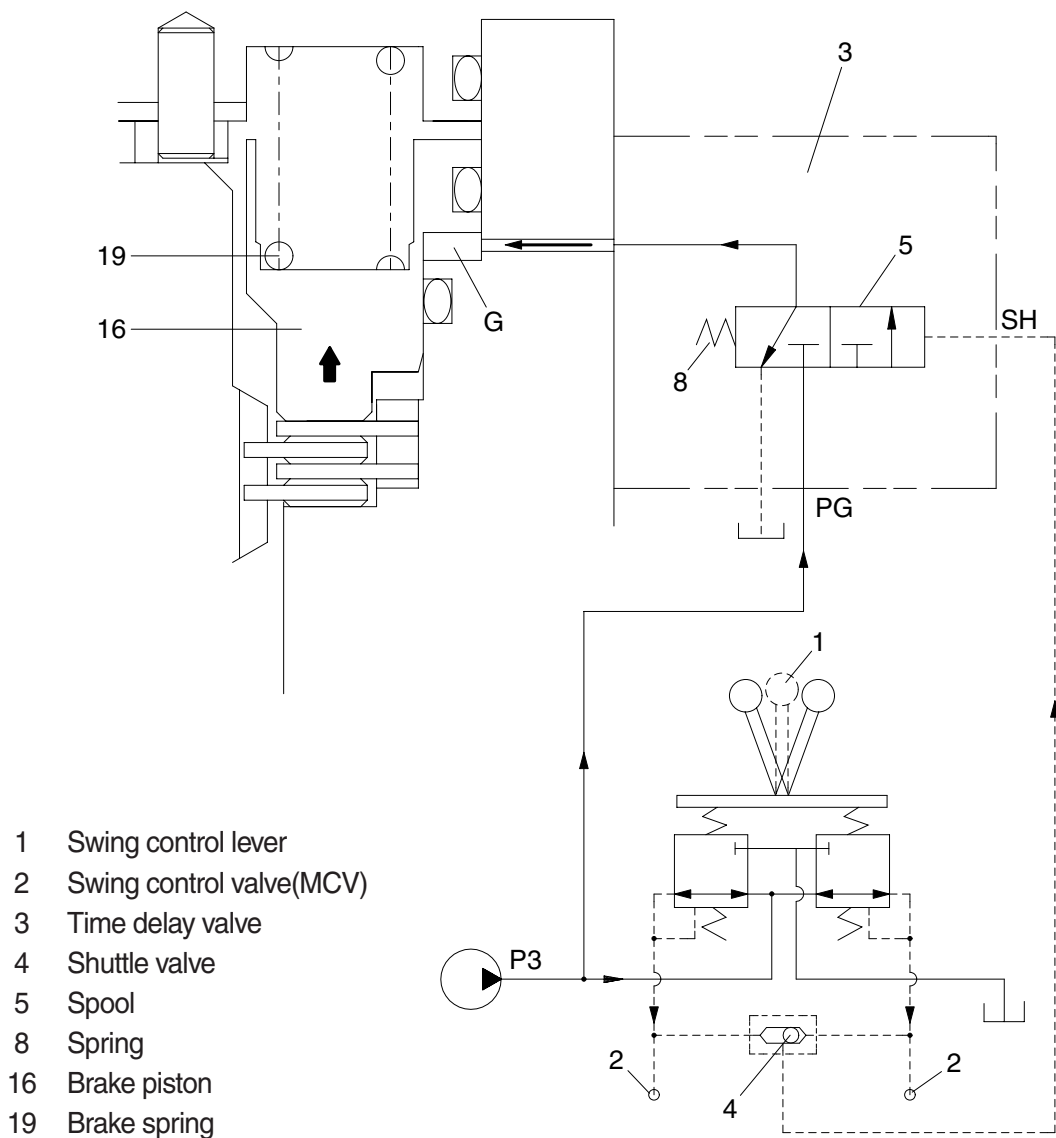
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1	Body	15	Separate plate
9	Cylinder block	16	Brake piston
14	Friction plate	19	Brake spring

② Operating principle

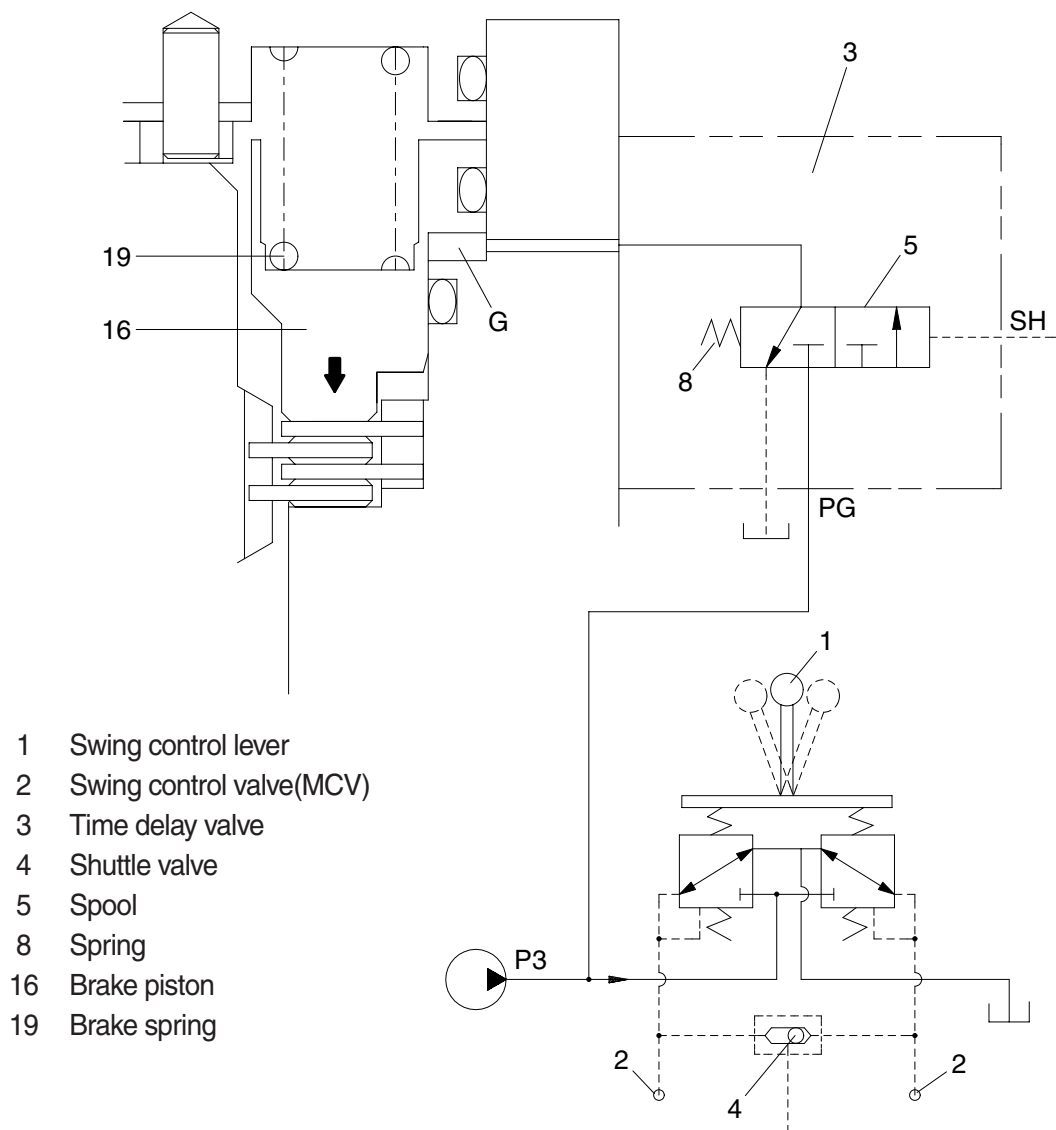
- a. When the swing control lever(1) is set to the swing position, the pilot oil go to the swing control valve(2) and to SH port of the time delay valve(3) via the shuttle valve(4), this pressure move spool(5) to the leftward against the force of the spring(8), so pilot pump charged oil(P3) goes to the chamber G.

This pressure is applied to move the piston(6) to the upward against the force of the spring(7). Thus, it releases the brake force.



14007A2SM16

- b. When the swing control lever(1) is set the neutral position, the spool(5) returns right in the time delay valve(3).
Then, the piston(6) is moved lower by spring force and the return oil from the chamber G flows back to tank.
At this time, the poppet works to make a time lag for 5 seconds.



14007A2SM17