



PRODUCT SUPPORT BULLETIN BULLETIN NO. 337

DATE: September 27, 2001

MACHINE: 18-Ton Crane

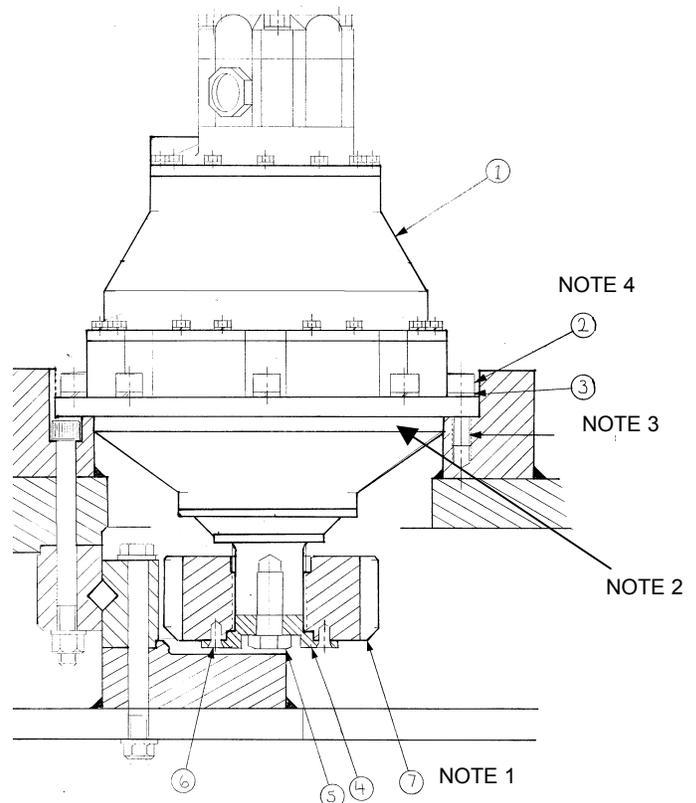
SERIAL
NUMBER(S): 8910, 8911, 9008, 9009 & 9010 ONLY

SUBJECT: Swing Drive Retrofit Kit – 840070

This Swing Drive Retrofit Kit will replace the original Swing Drive, p/n F-230, with a new, more readily available drive. The **Swing Drive Retrofit Kit, p/n 840070**, includes a new **Drive Assembly, p/n F-411**, and all required hardware and instructions.

Installation Notes:

1. Drive Gear, p/n C-22307, will be fixed to the shaft by Step Plate, p/n 840071, and secured by one (1) 1" x 2" NF Grade 8 capscrew & four (4) 3/8" x 1" Flat Head Machine Screws. Apply Loctite #242 (blue).
2. Drive F-411 will be mounted to the lower step as shown. The pilot diameter of the motor is 14.000/13.997". It may be necessary on some cranes to machine down the pilot diameter of the motor to allow it to fit into the pilot hole.
3. Drill 8 holes .65 dia. X 2.375 deep; tap 3/4-10 (2B), 1.625 deep on 15.50 dia. Bolt circle. Chamfer .094" x 45°.
4. Secure Drive with eight (8) 3/4" x 2-1/4" Socket Head Capscrews and high collar lock washers.



Contact the NORDCO Service Department for additional information.