

Replacement of the swivel hub on 680 2014 and after

*We recommend to lift the table for an easier work.

- 1- Remove the chain cover on the side of the machine.
- 2- Remove the chain that turns the drive rolls.
- 3- Unscrew the 3 bolts of the flanges (that hold the bearing).
- 4- Unscrew the Allen screw to remove the first shaft (photo 1).

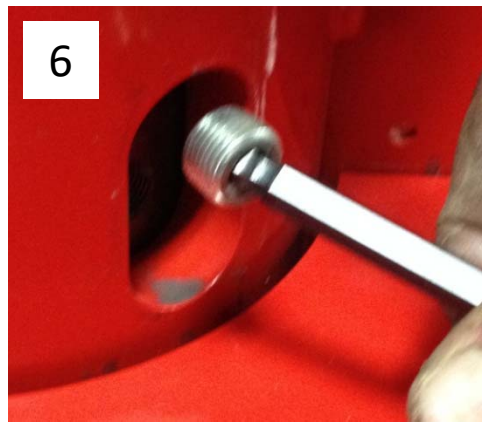


- 5- Remove the shear bolt (photo 2). You can now take off that piece of the shaft.



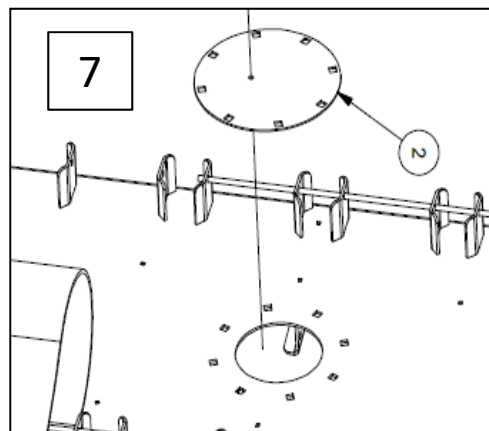
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6- Unscrew the nut and its bushing with a 13/16" socket from the swivel hub (photo 3-4). Unscrew the Allen plug from the bottom hole (photo 5-6).



7- Drop the table (using handles of the main valve), turn the table ¼ turn and unscrew the 8 cover bolts of the miter gears (photo 7).

***Be careful, the table is not linked to the machine anymore.**



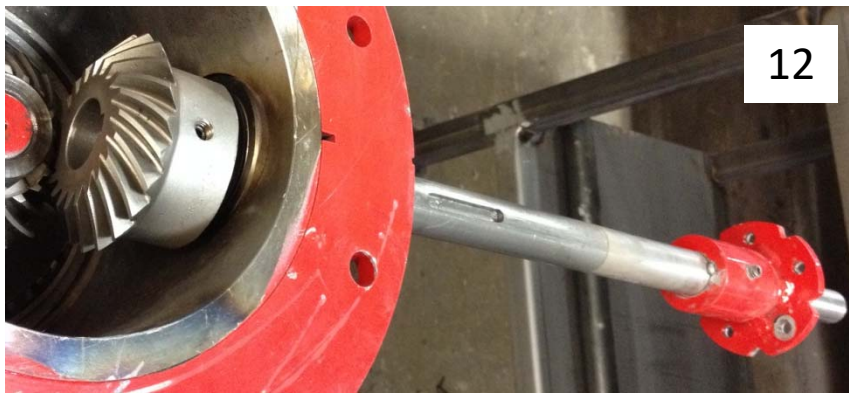
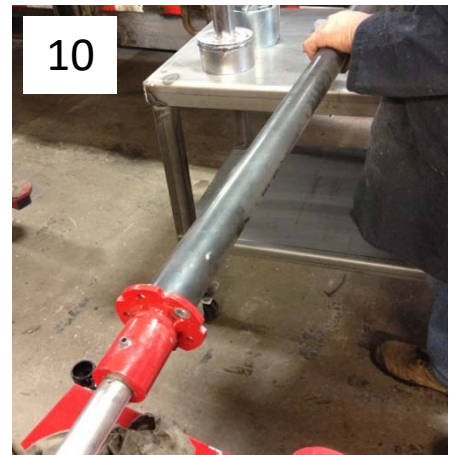
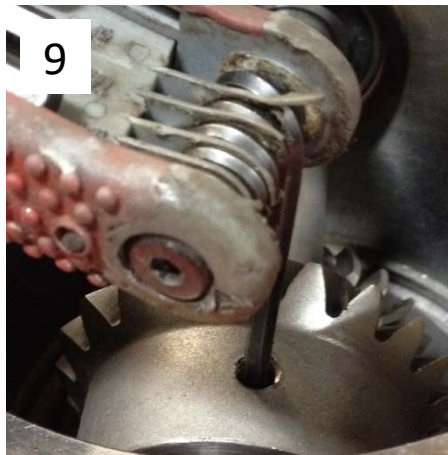
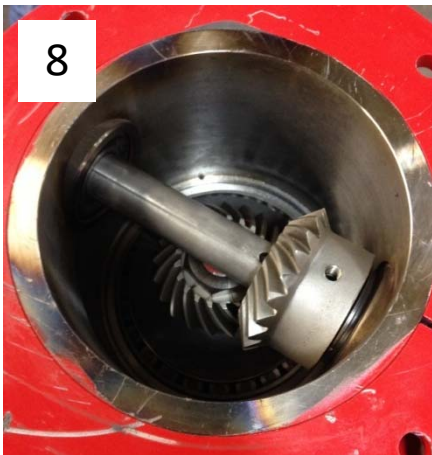
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8- Remove the gear cover and clean up the grease (photo 8).

9- Unscrew the miter gear Allen screw of the lateral shaft (photo 9).

10- With a puller tool (homemade pipe) and a hammer, remove the shaft (towards the swivel hub, photo 10) until the woodruff key is removable (photo 11).

*Be careful: Do not hit directly on the shaft. Remove the whole shaft and the miter gear (opposite way, photo 12).

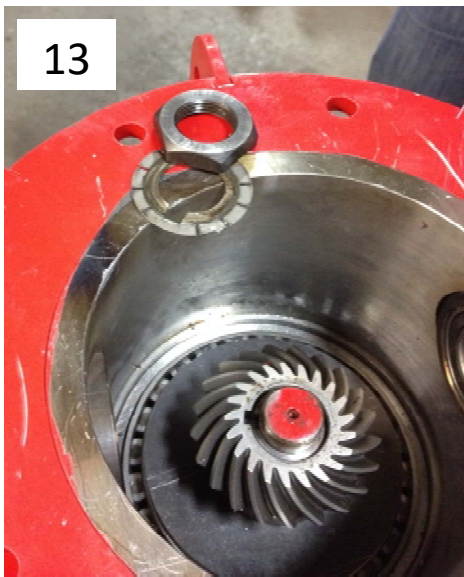


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11- Unscrew the shaft nut (using a 1½" socket, photo 13).

*When reassembling, the tightening torque for the nut is about 60 lb/ft.

12- Remove the miter gear with the puller (#223235) designed by Anderson Group (photo 14).



13- Remove the metal washer. Remove the bearing with the puller (#223244, photo 15) designed by Anderson Group. You have to install it and screw the adjustment (photo 16). The parts will be released together.

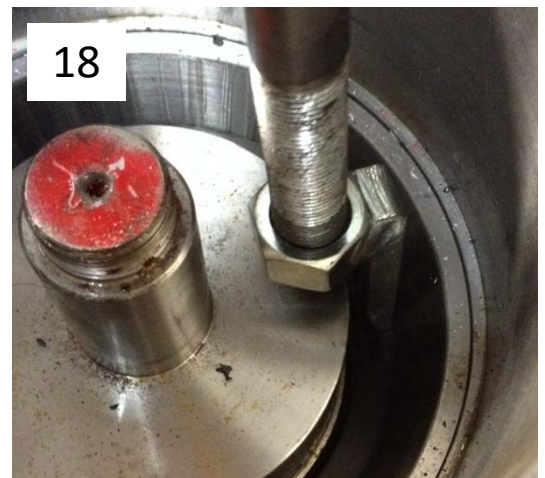


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14- Extract the bearing cage with a puller (photo 17). Put the tool tip designed by Anderson Group (#224246, photo 18) to the puller (photo 17).

15- Remove the teflon washer. You can remove it in many ways. One of them is to take a 3" wood screw and insert it to the teflon center (photo 19). The parts will be released together. The washer will be reusable. With a blade, remove the smudge left by the wood screw.

16- Remove the swivel hub with the puller designed by Anderson Group (#223243, photo 20). Screw the thinning rods through the swivel then screw the biggest one until the piece is released.



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17- Always replace the seals (#303005, photo 21) of the swivel hub. Clean up the hub from grease and use a magnet to remove all metal debris.

Important:

You must make the verification of the shaft (photo 22) before reassembly. If there is a moderately deep scratch facing the swivel hub (seals), you will have to change the dumping table.



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18- When reassembly, be sure the swivel hub is well aligned (advice: draw arrows, photos 23 et 24).

When replacing the swivel hub, use the tool designed by Anderson Group (#223245, photos 25 et 26).

Make these steps backwards for reinstallation.

