

1. INSTRUCTION FOR NEW MACHINE

- 1) It takes about 100 operation hours to enhance its designed performance.
- 2) Operate according to the 3 steps and avoid excessive operation for the initial 100 hours.

Service meter	Load
Until 10 hours	About 60 %
Until 100 hours	About 80 %
After 100 hours	100 %

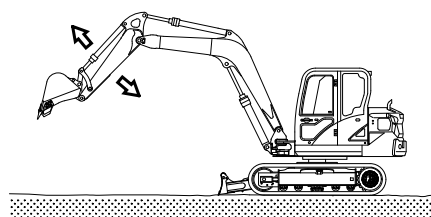
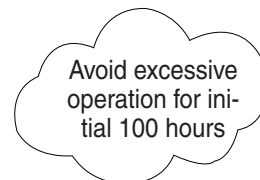
※ **Excessive operation may deteriorate the performance of the machine and shorten the life of the machine.**

3) Be careful during the initial 100 hours operation

- (1) Check daily for the level and leakage of fluids.
- (2) Check greasing points on a regular basis and grease all points as needed. Refer to greasing chart located on the machine.
- (3) Check over all hose connections, bolts, nuts and screws, on a daily basis.
- (4) Warm up the machine fully before operating.
- (5) Check all gauges occasionally during the operation.
- (6) Check if the machine is operating normally during operation of the machine.

4) After the initial 250 hours of operation replace the following:

Checking items	Hours
Engine oil	250
Engine oil filter	
Fuel filter element	
Hydraulic oil return filter	
Pilot line filter element	
Travel reduction gear oil	



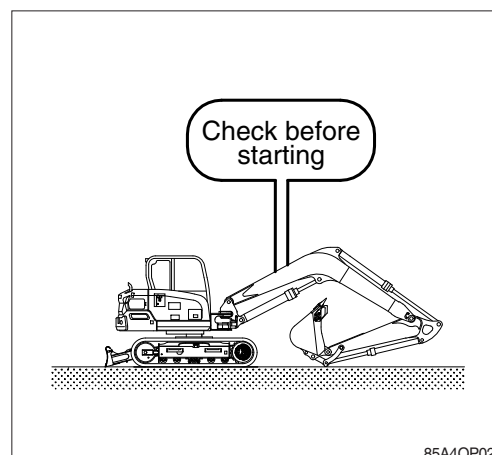
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2. CHECK BEFORE STARTING THE ENGINE

- 1) Look around and under the machine to check:
 - Check for loose nuts, bolts or wiring
 - Collection of dirt
 - Collection of dust at places which reach high temperature
 - Leakage of oil, fuel or coolant
 - Condition of the work equipment and hydraulic system.

※ Refer to section, Maintenance check list in chapter 6.

- 2) Adjust operator seat to best fit the operator.
- 3) Adjust all mirrors to best fit the operator.



3. STARTING AND STOPPING THE ENGINE

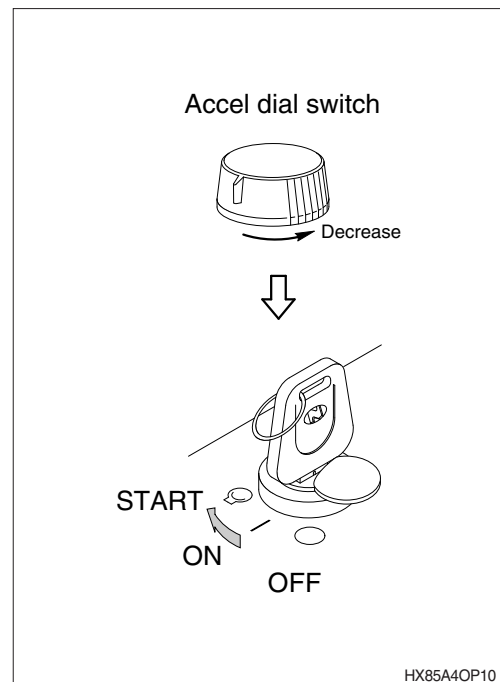
1) CHECK INDICATOR LIGHTS

- (1) Confirm all operating lever is on the neutral position.
 - (2) Turn the starting switch to the ON position, and check following.
 - ① If all the lamps light up, buzzer will sound for 6 seconds.
 - ② Only below lamps will light up and all the other lights will go OFF after 2 seconds.
 - Battery charging warning lamp
 - Engine oil pressure warning lamp
 - ③ The preheat pilot lamp will light up when the coolant temperature is below 10 °C (50 °F).
 - ④ The warming up pilot lamp will light up when the coolant temperature is below 30 °C (86 °F).
- ※ If the ESL function is set to the YES, enter the password to start engine.
- ※ If the incorrect password is entered a total of 5 times, you must wait 30 minutes before trying again.
- ※ Refer to page 3-8 for the ESL function.



2) STARTING ENGINE IN NORMAL

- ▲ Check if any obstacles or people are in the working area. Sound the horn to warn anyone in the vicinity that you are starting the engine.
- (1) Turn the multimodal dial to low idle position.
 - (2) Turn the starting switch to START position to start the engine.
 - △ Do not hold the starting switch in the START position for longer than 20 seconds. The start system may be seriously damaged.
 - ※ If the engine does not start, allow the stator to cool for about 2 minutes before re-attempting to start the engine again.
 - (3) Release the starting switch instantly after the engine starts to avoid possible damage to the starting motor.



3) STARTING ENGINE IN COLD WEATHER

※ By following below steps, you will be able to improve startability and fuel consumption in cold weather.

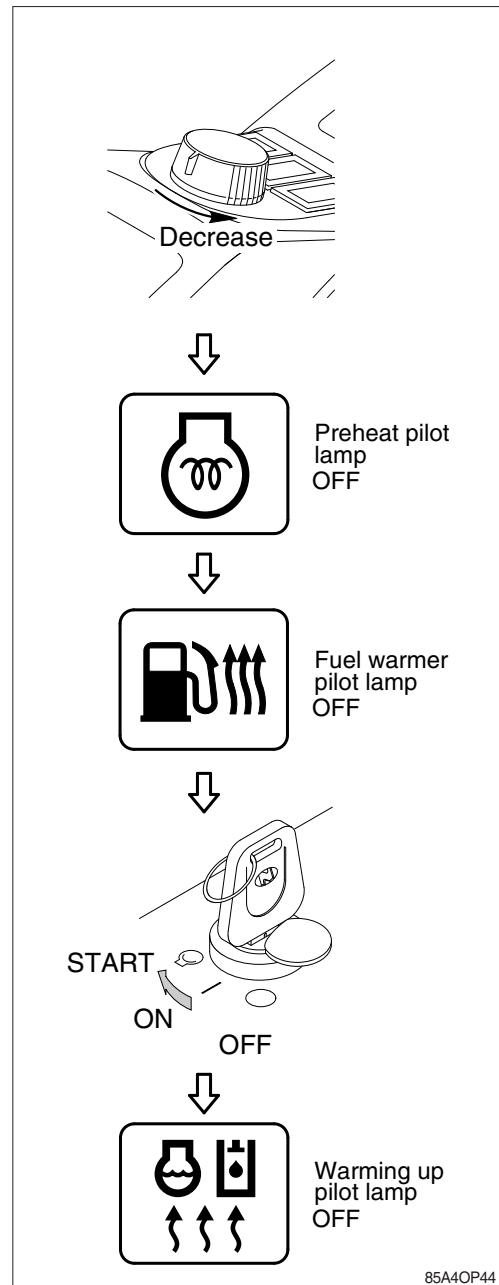
▲ Always check for obstacles in the area and sound horn before starting the engine.

※ Check engine oil and fuel and replace as necessary. See page 2-21.

※ Top off coolant as needed.

※ When you turn ON starting switch, the fuel warmer automatically heats the fuel as needed by sensing coolant temperature.

- (1) Confirm all levers are in the neutral position.
- (2) Turn the multimodal dial to low idle position.
- (3) Turn the starting switch to the ON position, and wait 1~2 minutes. More time might be required, it depends on the ambient temperature.
- (4) Wait for five minutes to warm up the engine after the preheating pilot lamp turns off, and then turn the starting switch to the START position to start the engine.
 - ※ If the engine does not start, allow the starter to cool for about 2 minutes before attempting to start the engine again.
- (5) Release the starting switch immediately after starting engine.
- (6) If the temperature of the coolant is lower than 30 °C (86 °F) the warming up process automatically starts.
 - ※ Do not operate the working devices, or change the operation mode during the warming up.



4) INSPECTION AFTER ENGINE START

Inspect and confirm the following after engine starts.

- (1) Is the oil level gauge of hydraulic tank in the normal operation range?
- (2) Is there any leakage of oil or water?
- (3) Are all the warning lamps turned OFF (1)?
- (4) Are the indicator of water temperature gauge (2) and hydraulic temperature gauge (3) in the operating range?
- (5) Is the engine sound and the color of exhaust gas normal?
- (6) Are the sound and vibration normal?

△ **Do not increase engine speed quickly after starting, it can damage engine or turbocharger.**

※ **If there are problems in the control panel, stop the engine immediately and correct problem as required.**



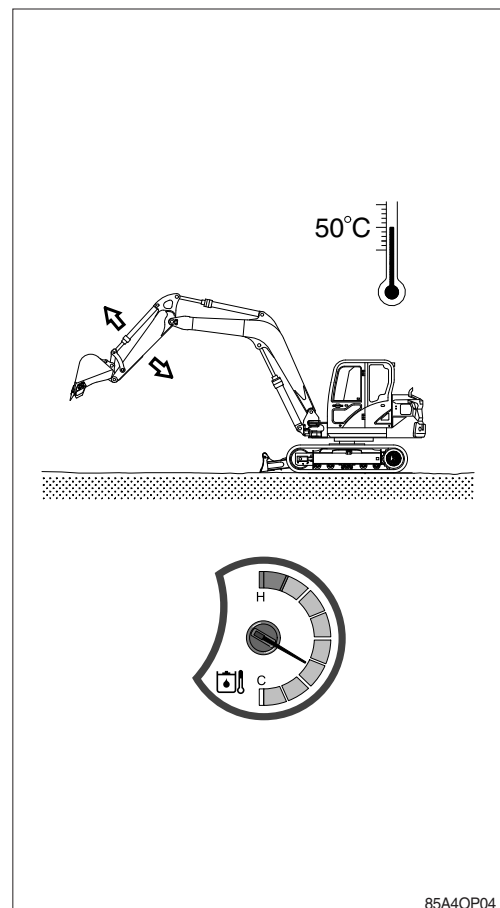
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5) WARMING-UP OPERATION

※ The most suitable temperature for the hydraulic oil is about 50°C (122°F).

△ **If the hydraulic oil temperature drops below 25°C (77°F), sudden operation can damage the hydraulic system. So temperature must be raised to at least 25°C (77°F) before starting work.**

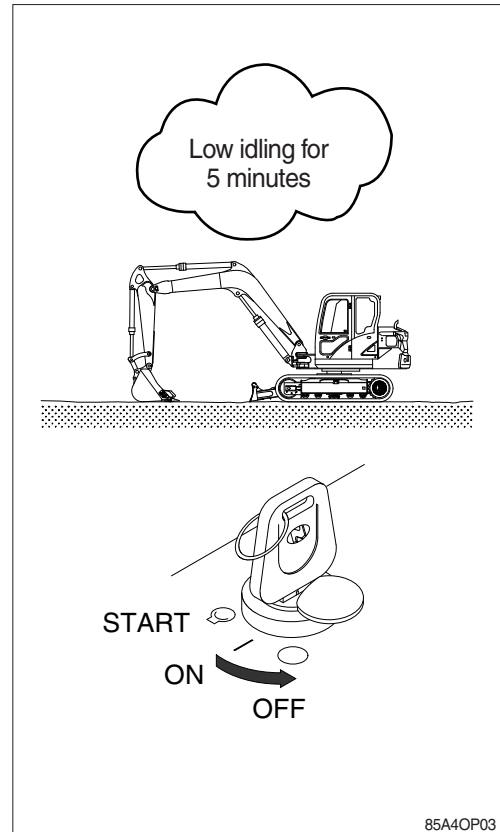
- (1) Run the engine at low idling for 5 minutes.
 - (2) Speed up the idling and run the engine at mid-range speed.
 - (3) Operate bucket lever for 5 minutes.
- ※ **Do not operate anything except bucket lever.**
- (4) Run the engine at the high speed and operate the bucket lever and arm lever for 5-10 minutes.
- ※ **Operate only the bucket lever and arm lever.**
- (5) Finally this warming-up process will be completed by operating all cylinders several times along with the operation of swing and traveling.
- ※ **Increase the warming-up operation during winter.**



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6) TO STOP THE ENGINE

- ※ If the engine is abruptly stopped before it has cooled down, engine life may be greatly shortened. Consequently, do not abruptly stop the engine apart from an emergency.
 - ※ In particular if the engine has overheated, do not abruptly stop it but run it at low speed to allow it to cool gradually, then stop the engine.
- (1) Lower the bucket to the ground then put all the levers in the neutral position.
 - (2) Run the engine at low idle for about 5 minutes.
 - (3) Return the key of starting switch to the OFF position.
 - (4) Remove the key to prevent other people using the machine and the safety knob.
 - (5) Lock the cab door.

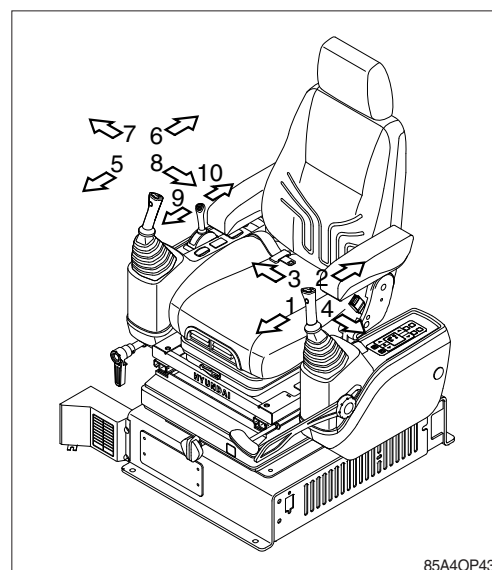


4. OPERATION OF WORKING DEVICE

※ **Confirm the operation of control lever and working device.**

- 1) Left control lever controls arm and swing.
- 2) Right control lever controls boom and bucket.
- 3) When you release the control lever, control lever returns to neutral position automatically.

※ **When operating swing, consider the swing distance by inertia.**



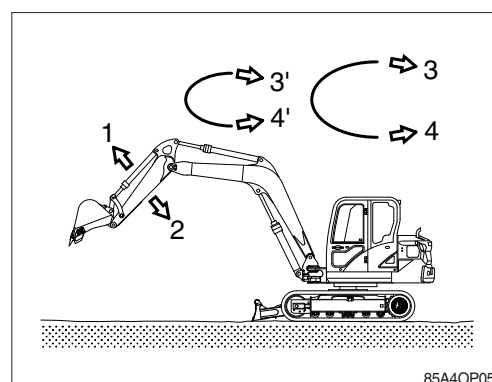
※ **Left control lever**

- 1 Arm roll-out
- 2 Arm roll-in
- 3 Swing right
- 4 Swing left

※ **Boom swing (boom offset switch selected)**

- 3' Boom swing right
- 4' Boom swing left

※ **Refer to page 3-16 for boom offset switch.**

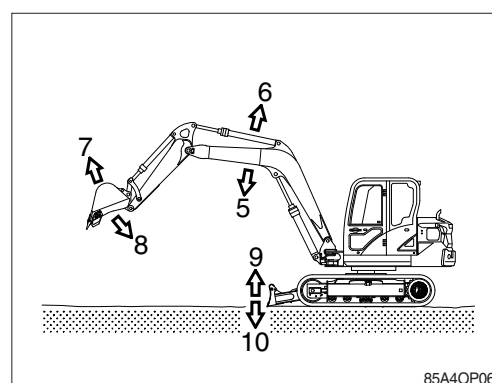


※ **Right control lever**

- 5 Boom lower
- 6 Boom raise
- 7 Bucket roll-out
- 8 Bucket roll-in

※ **Dozer control lever**

- 9 Dozer blade up
- 10 Dozer blade down



5. TRAVELING OF THE MACHINE

1) BASIC OPERATION

(1) Traveling position

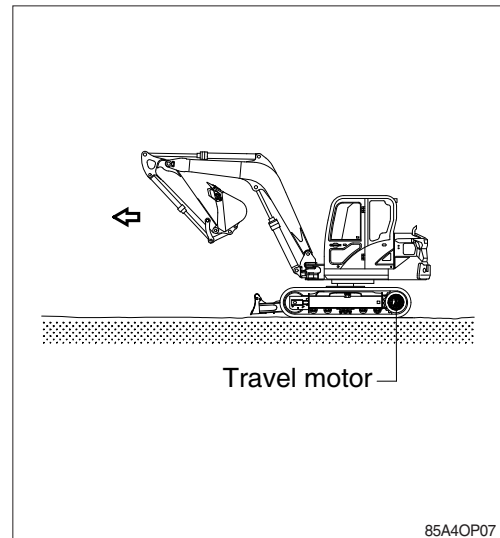
The travel motor is in the rear and the working device is forward.

- ▲ **Be careful as the traveling direction will be the opposite when the machine is rotated 180°.**

(2) Traveling operation

It is possible to travel by either travel lever or pedal.

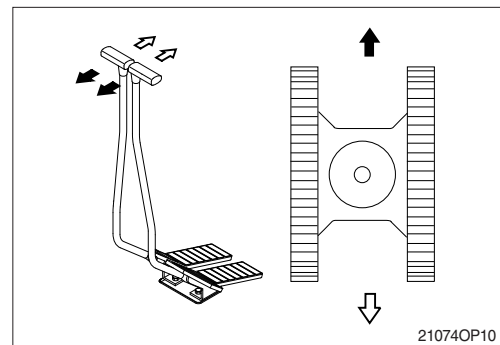
- ※ **Do not travel continuously for a long time.**
- ※ **Reduce the engine speed and travel at a low speed when traveling on uneven ground.**



(3) Forward and backward traveling

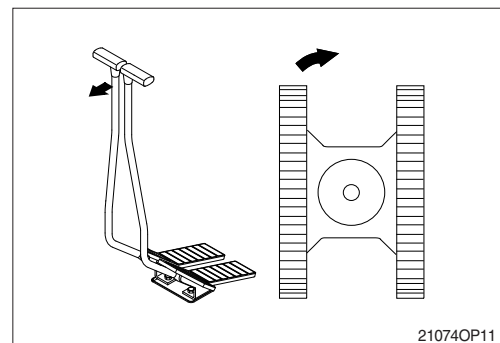
When the left and right travel levers or pedals are pushed at the same time, the machine will travel forward or backward depending on your selection.

- ※ **The speed can be controlled by the operation stroke of lever or pedal and change of direction will be controlled by difference of the left and right stroke.**



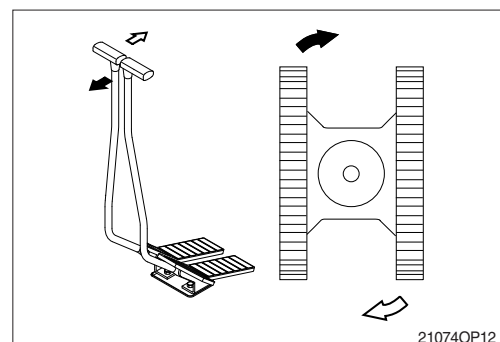
(4) Pivot turning

Operating only one side of lever or pedal makes the change of direction possible by moving only one track.



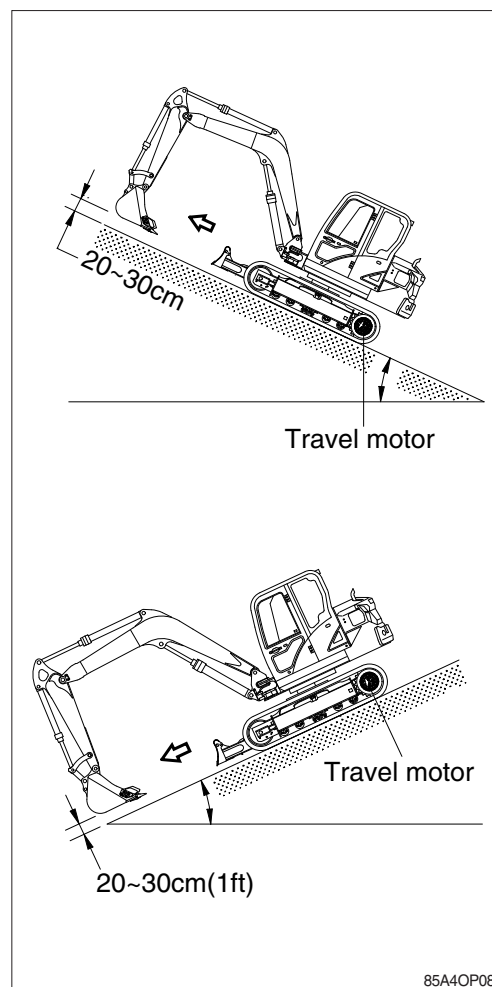
(5) Counter rotation

It is to rotate the undercarriage (only) while not advancing the machine forward or backward. This is accomplished by moving the travel levers and or pedals in the opposite direction of each other.



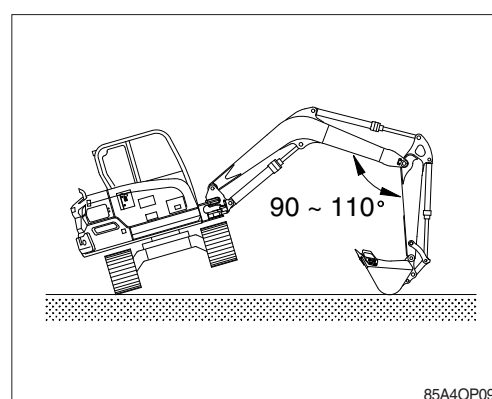
2) TRAVELING ON A SLOPE

- (1) Make sure that the travel lever is properly maneuvered by confirming the travel motor is in the right location.
 - (2) Maintain the bucket 20 to 30 cm (1 ft) from the ground so that it can be used as a brake in the event of an emergency.
 - (3) If the machine starts to slide or loses stability, lower the bucket immediately as it will help slow or stop the machine.
 - (4) When parking on a slope, use the bucket as a brake.
- ※ Machine cannot travel effectively on a slope when the oil temperature is low. Do the warming-up operation when it is going to travel on a slope.
- ▲ Be careful when working on slopes. It may cause the machine to lose its balance and turn over. Serious injury or death could occur.
- ▲ Be sure to keep the travel speed switch on the LOW (turtle mark) while traveling on a slope.



3) TRAVELING ON SOFT GROUND

- ※ If possible, avoid operating on soft ground.
- (1) Move forward as far as machine can move.
 - (2) Take care not to go beyond the depth where towing is impossible on soft ground.
 - (3) When driving becomes impossible, lower bucket and use boom and arm to pull the machine. Operate boom, arm, and travel lever at the same time to avoid the machine sinking.



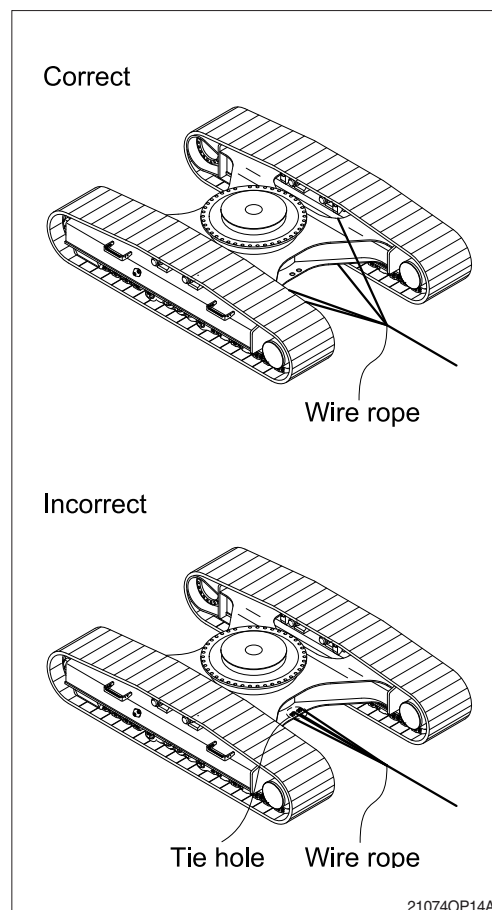
4) TOWING THE MACHINE

Tow the machine as follows when it can not move on its own.

- (1) Tow the machine after hooking the wire rope to the frame as shown in the upper right illustration.
- (2) Hook the wire rope to the frame and put a support under each part of wire rope to prevent damage.

※ **Never tow the machine using only the tie hole, because this may break.**

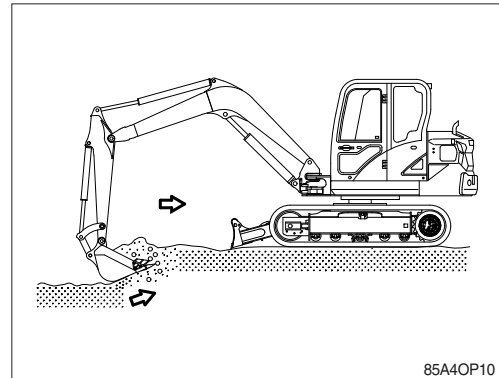
▲ **Make sure no personnel are standing close to the tow rope as serious injury or death could occur if it breaks.**



6. EFFICIENT WORKING METHOD

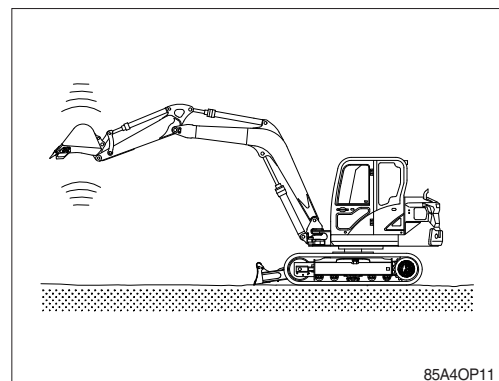
1) Do the digging work by arm.

Use the pulling force of arm for digging and use together with the digging force of the bucket if necessary.

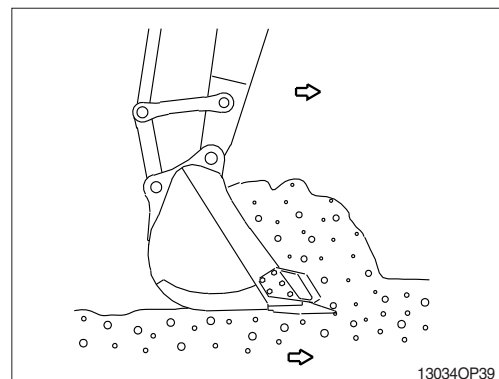


2) When lowering and raising the boom operate softly for the beginning and the end.

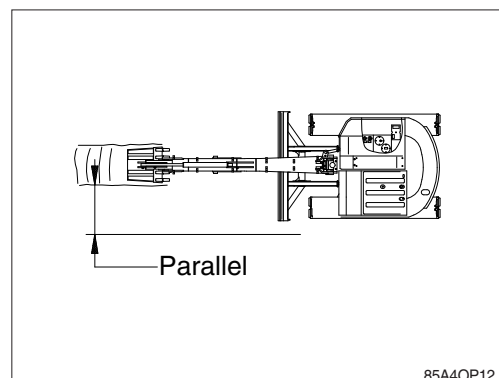
In particularly, sudden stops while lowering the boom may cause damage to the machine.



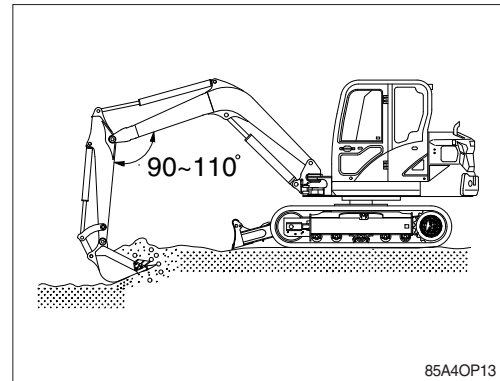
3) The digging resistance and wearing of tooth can be reduced by putting the end of bucket tooth to the digging direction.



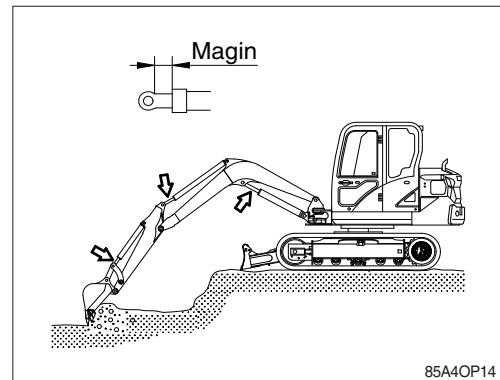
4) Set the tracks parallel to the line of the ditch to be excavated when digging ditch. Do not swing while digging.



- 5) Dig slowly while keeping the angle of boom and arm at a 90-110° when maximum digging force is required.



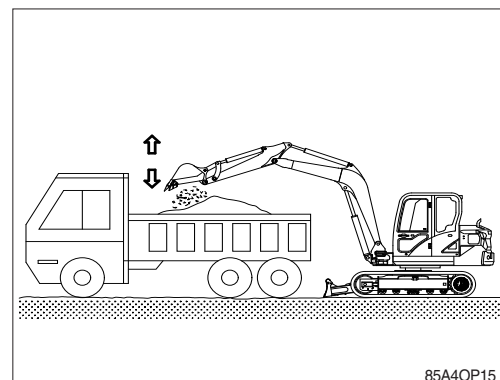
- 6) Leave a small margin of cylinder stroke to prevent damage of cylinder when working with the machine.



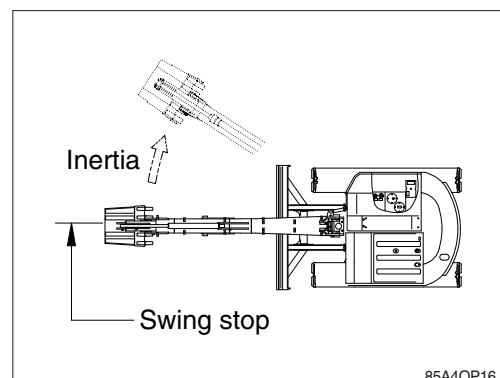
- 7) Keep the bucket to the dumping position and the arm horizontal when dumping the soil from the bucket.

Operate bucket lever 2 or 3 times when hard to dump.

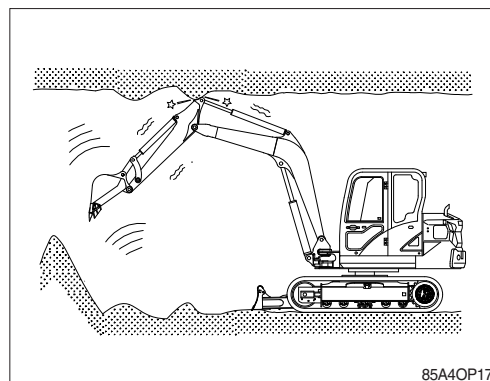
- ※ Do not use the impact of bucket tooth when dumping.



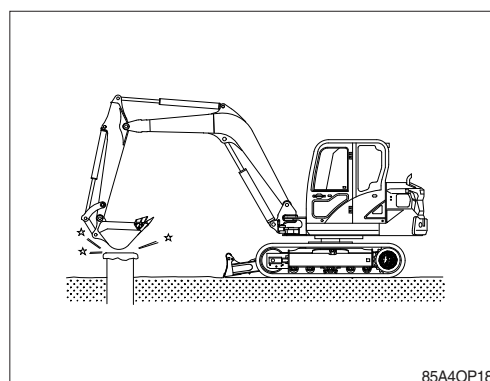
- 8) Operate stop of swing considering the swing slip distance is created by inertia after neutralizing the swing lever.



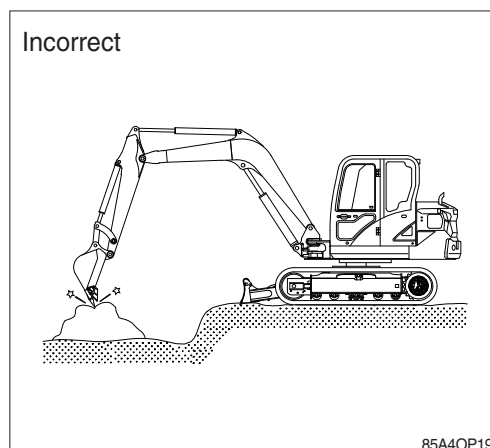
- 9) Do not use the dropping force of the work equipment for digging.
The machine can be damaged by the impact.



- 10) Do not use the bucket to crack hard objects like concrete or rocks.
This may break a tooth or pin, or bend boom.



- 11) Do not use the bucket to crack hard objects like concrete or rocks.
This may break a tooth or pin, or bend boom.



12) NEVER CARRY OUT EXCESSIVE OPERATIONS

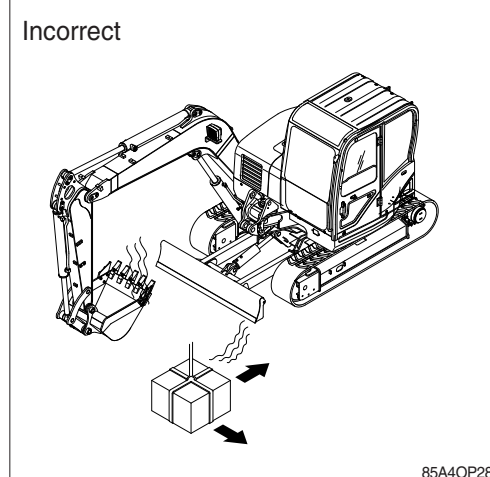
Operation exceeding machine performance may result in accident or failure, causing serious injury or death.

Carry out lifting operation within specified load limit.

Never carry out operations which may damage the machine such as overload or over-impact-load.

Never travel while carrying a load.

If you need an overload warning device installed for object handling procedure, please contact your local HD Hyundai Construction Equipment distributor.



13) BUCKET WITH HOOK

When carrying out lifting work, the special lifting hook is necessary.

The following operations are prohibited.

- Lifting loads with a wire rope fitted around the bucket teeth.
- Lifting loads with the wire rope wrapped directly around the boom or arm.

When performing lifting operation, securely hook the wire rope onto the special lifting hook.

When performing lifting operation, never raise or lower a person.

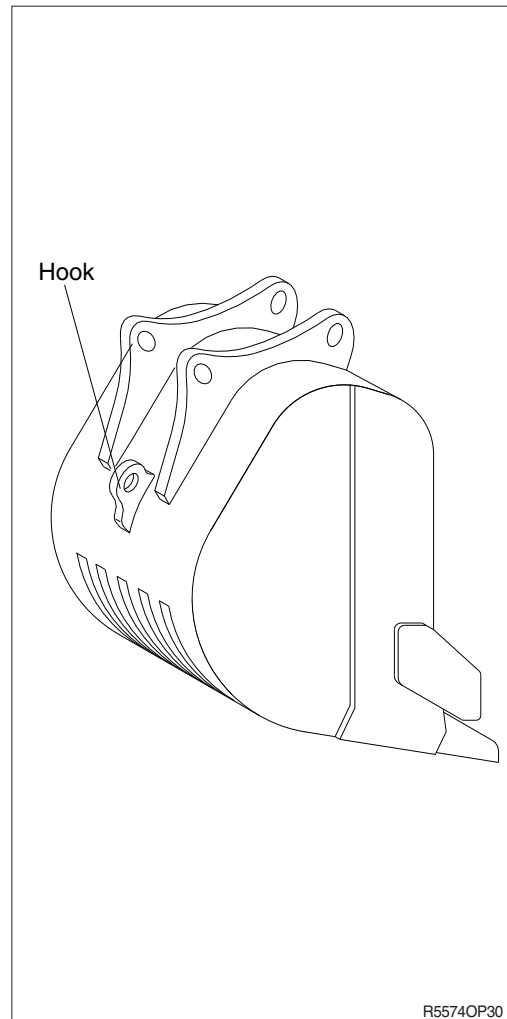
Due to the possible danger of the load falling or of collision with the load, no persons shall be allowed in the working area.

Before performing lifting operation, designate an operation supervisor.

Always execute operation according to their instructions.

- Execute operating methods and procedures under their direction.
- Select a person responsible for signaling.
Operate only on signals given by such person.

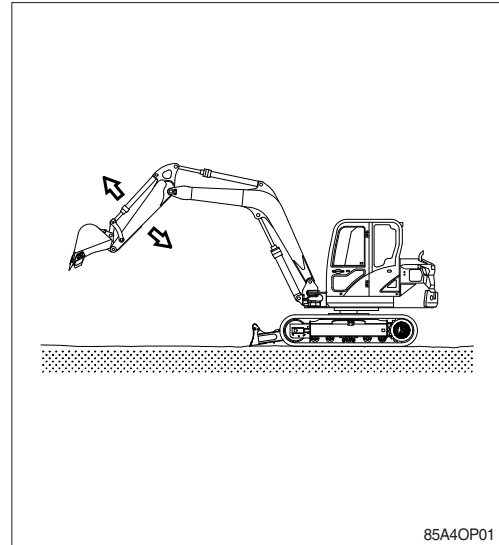
Never leave the operator's seat while lifting a load.



7. OPERATION IN THE SPECIAL WORK SITES

1) OPERATING THE MACHINE IN A COLD WEATHER

- (1) Use proper engine oil and fuel for the weather.
- (2) Fill the required amount of antifreeze in the coolant.
- (3) Refer to the starting engine in cold weather.
Start the engine and extend the warming up operation.
- (4) Be sure to open the heater cock when using the heater.
- (5) Always keep the battery completely charged.
※ **Discharged batteries will freeze more easily than fully charged.**
- (6) Clean the machine and park on wood plates.



2) OPERATION IN SANDY OR DUSTY WORK SITES

- (1) Inspect air cleaner element frequently. Clean or replace element more frequently, if warning lamp lights up and buzzer sounds simultaneously, regardless of inspection period.
※ **Replace the inner and outer element after 4 times of cleaning.**
- (2) Inspect radiator, oil cooler and condenser frequently, and keep cooling fins clean.
- (3) Prevent sand or dust from getting into fuel tank and hydraulic tank during refilling.
- (4) Prevent sand or dust from penetrating into hydraulic circuit by tightly closing breather cap of hydraulic oil tank. Replace hydraulic oil filter and air breather element frequently. Also, replace the fuel filter frequently.
- (5) Keep all lubricated parts, such as pins and bushings, clean at all times.
- (6) If the air conditioner and heater filters clog, the heating or cooling capacity will drop. Clean or replace the filter element more frequently.
- (7) Clean electrical components, especially the starting motor and alternator, to avoid accumulation of dust.

3) SEA SHORE OPERATION

- (1) Prevent ingress of salt by securely tightening plugs, cocks and bolts of each part.
- (2) Wash machine after operation to remove salt residue.
Pay special attention to electrical parts, hydraulic cylinders and track tension cylinder to prevent corrosion.
- (3) Inspection and lubrication must be carried out more frequently.
Supply sufficient grease to replace all old grease in bearings which have been submerged in water for a long time.

4) OPERATION IN MUD, WATER OR RAIN WORK SITES

- (1) Perform a walk around inspection to check for any loose fittings, obvious damage to the machine or any fluid leakage.
- (2) After completing operations, clean mud, rocks or debris from the machine. Inspect for damage, cracked welds or loosened parts.
- (3) Perform all daily lubrication and service.
- (4) If the operations were in salt water or other corrosive materials, make sure to flush the affected equipment with fresh water.

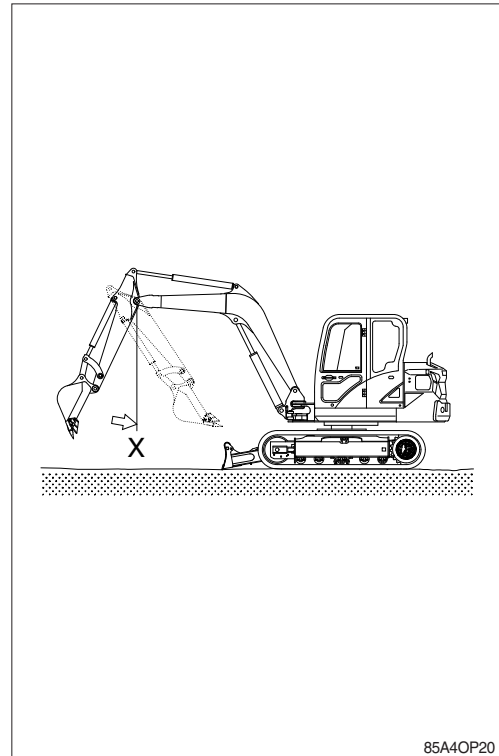
5) OPERATION IN ROCKY WORK SITES

- (1) Check for damage to the undercarriage and for looseness, flaws, wear and damage in bolts and nuts.
- (2) Loosen the track tension slightly when working in such areas.
- (3) Do not turn the undercarriage directly over the sharp edge rock.

8. NORMAL OPERATION OF EXCAVATOR

The following may occur during operation due to the nature of a hydraulic excavator.

- 1) When rolling in the arm, the roll-in movement stops momentary at point X in the picture shown, then recovers speed again after passing point X. This is because movement by the arm weight is faster than the speed of oil flow into the cylinder.
- 2) When lowering the boom, you may hear continuous sound. This is caused by oil flow in the valve.
- 3) Overloaded movement will produce sound caused by the relief valves, which are for the protection of the hydraulic systems.
- 4) When the machine is started swinging or stopped, a noise near the swing motor may be heard. The noise is generated when the brake valve relieves.



9. ATTACHMENT LOWERING (when engine is stopped)

- 1) On machines equipped with an accumulator, for a short time (within 2 minutes) after the engine is stopped, the attachment will lower under its own weight when the attachment control lever is shifted to LOWER. This happens only when the starting switch is ON and the safety knob is in the UNLOCK position. After the engine is stopped, set the safety knob to the LOCK position.

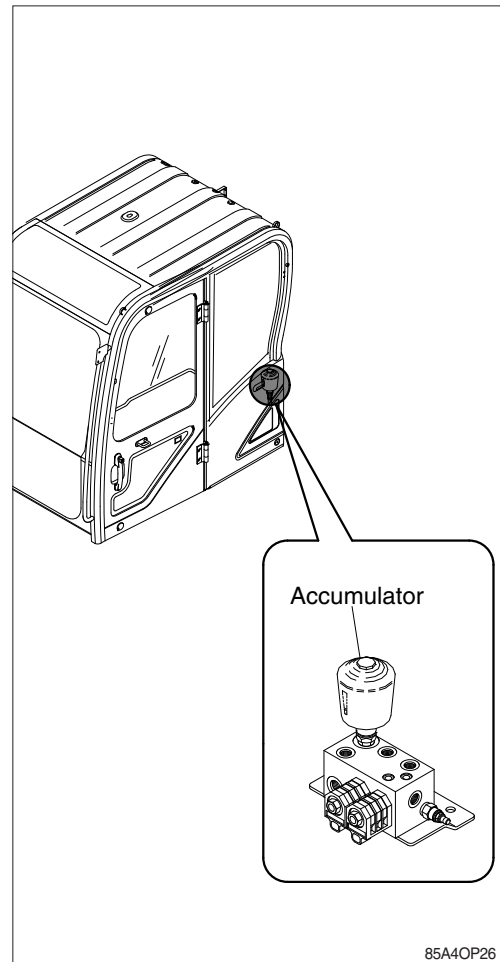
⚠ Be sure no one is under or near the attachment before lowering the boom. Failure to comply could result in serious injury or death.

- 2) The accumulator is filled with high-pressure nitrogen gas, and it is extremely dangerous if it is handled in the wrong way. Always observe the following precautions.

⚠ Never make any hole in the accumulator, expose it to flames or fire.

⚠ Do not weld anything to the accumulator.

- ※ When carrying out disassembly or maintenance of the accumulator, it is necessary to release the gas from the accumulator. A special air bleed valve is necessary for this operation, so please contact your HD Hyundai Construction Equipment distributor.



10. STORAGE

When storing the machine for longer than 1 month, follow these procedures:

1) BEFORE STORAGE

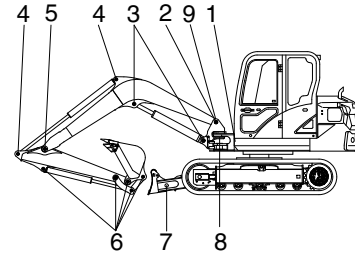
(1) Cleaning the machine

Clean the machine. Check and adjust tracks.
Grease each lubrication part.

(2) Lubrication position of each part

Change all oil.

- ※ Be particularly careful when you reuse the machine. As oil can be diluted during storage. Apply an anticorrosive lubricant on the exposed part of piston rod of cylinder and in places where the machine rusts easily.



- 1 Lubricating manifold (2EA)
- 2 Boom connection pin (2EA)
- 3 Boom cylinder pin (2EA)
- 4 Arm cylinder pin (2EA)
- 5 Boom and arm connection pin (1EA)
- 6 Arm and bucket (7EA)
- 7 Dozer blade connection pin (4EA)
- 8 Boom swing post (3EA)
- 9 Boom rear bearing center (1EA)

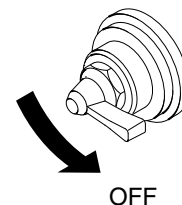
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(3) Master switch

Turn OFF the master switch mounted on the right side of the engine room.

- (4) Be sure to mix anticorrosive antifreezing solution in the radiator.

Master switch

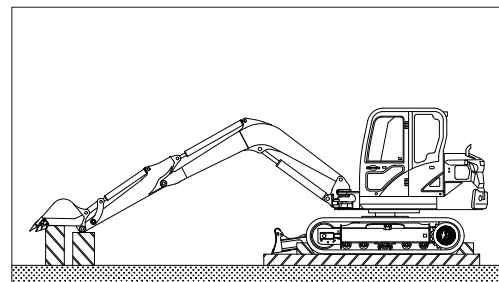


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(5) Prevention of dust and moisture

Keep machine dry. Store the machine setting wood on the ground.

- ※ Cover exposed part of piston rod on cylinder.
- ※ Lower the bucket to the ground and set a support under track.

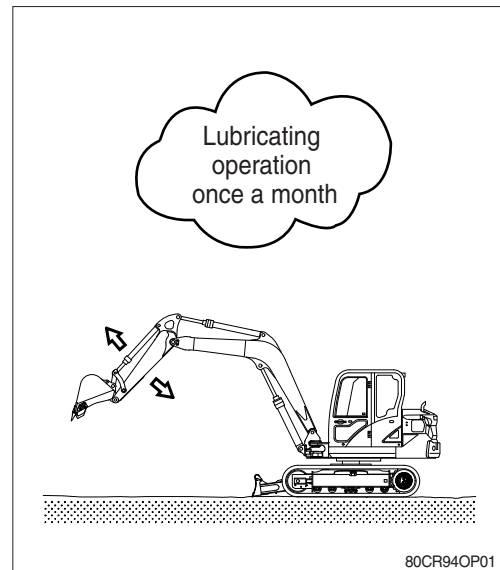


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2) DURING STORAGE

Start engine and move the machine and work equipment once a month and apply lubrication to each part.

- ※ Check the level of engine oil and coolant and fill if required when starting engine.
- ※ Clean the anticorrosive on the piston rod of cylinder.
- ※ Operate the machine such as traveling, swing and work equipment operation to make sure enough lubrication of all functional components.



※ BATTERY

- ① Once a month, start the engine for 15 minutes (or use a charger) to charge the battery.
- ② Every 2 months, check the battery voltage and keep battery voltage over 12.54V.
- ③ If the machine stock period is over 6 months, disconnect the battery negative (-) terminal.

3) AFTER STORAGE

Carry out the following procedure when taking out of a long time storage.

- (1) Wipe off the anticorrosive lubricant on the hydraulic piston rod.
- (2) Completely fill fuel tank, lubricate and add oil.

(3) When storage period is over 6 months

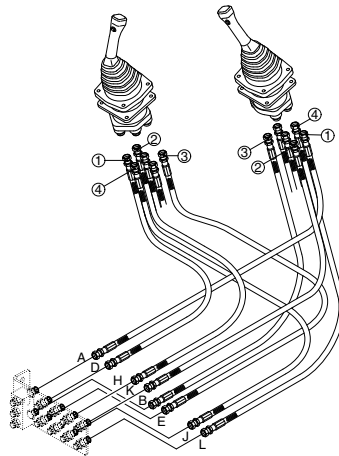
If the machine stock period is over 6 months, carry out the following procedure.

This procedure is to drain condensation water for the **swing reduction gear** durability.

- ※ Remove the drain port plug and drain the water until the gear oil comes out and then tighten the drain plug.
- ※ Refer to chapter 6, Maintenance for the drain plug location.
- ※ If the machine is stored without carrying out the monthly lubricating operation, consult your HD Hyundai Construction Equipment dealer for service.

11. RCV LEVER OPERATING PATTERN

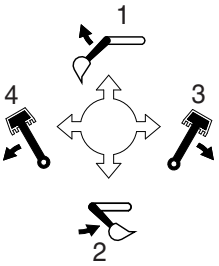
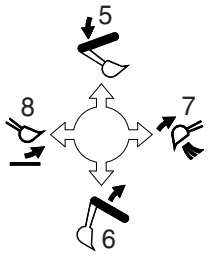
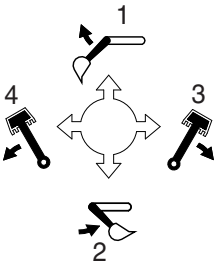
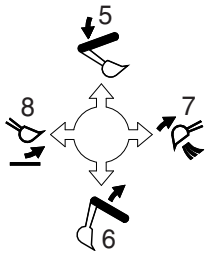
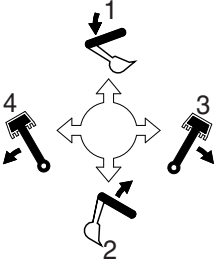
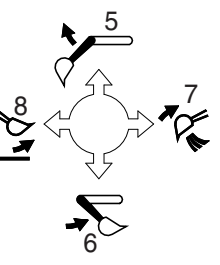
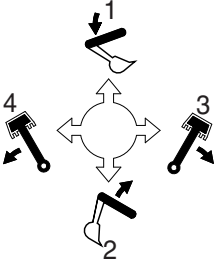
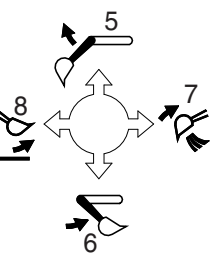
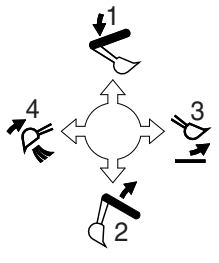
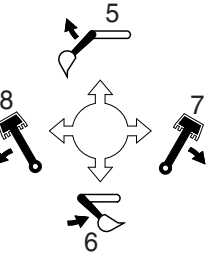
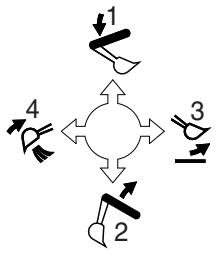
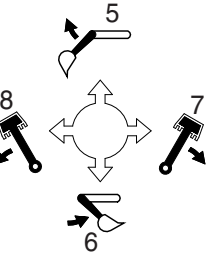
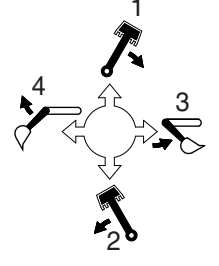
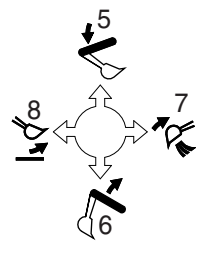
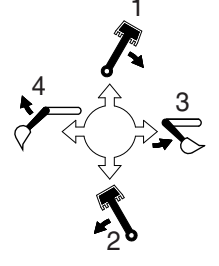
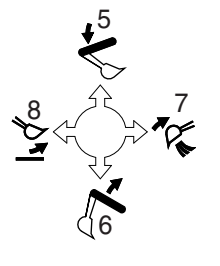
1) PATTERN CHANGE VALVE NOT INSTALLED (standard)



※ Whenever a change is made to the machine control pattern, also exchange the pattern label in the cab to match the new pattern.

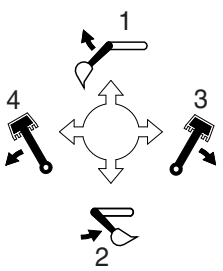
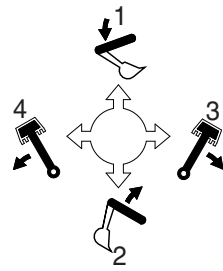
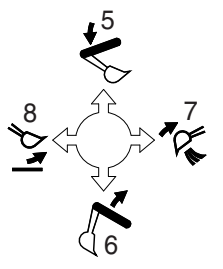
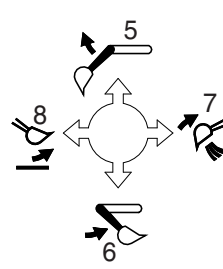
※ The hose modification works must be carried out between RCV lever and terminal block (Not between terminal block and MCV).

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Pattern	Operation		Control function	Hose connection (port)						
	Left	Right		RCV lever	Change of Terminal block					
					From	To				
ISO Type			Left	1Arm out	②	K	-			
HD Hyundai Construction Equipment				2Arm in	④	L	-			
			3Swing right	③	B	-				
			4Swing left	①	A	-				
			Right	5Boom lower	④	J	-			
				6Boom raise	②	H	-			
				7Bucket out	①	D	-			
				8Bucket in	③	E	-			
			A Type			Left	1Boom lower	②	K	G
2Boom raise	④	L	F							
			3Swing right	③	B	-				
			4Swing left	①	A	-				
			Right	5Arm out	④	J	D			
				6Arm in	②	H	E			
				7Bucket out	①	D	-			
				8Bucket in	③	E	-			
			B Type			Left	1Boom lower	②	K	G
			2Boom raise	④	L		F			
			3Bucket in	③	B	J				
			4Bucket out	①	A	H				
			Right	5Arm out	④	J	D			
				6Arm in	②	H	E			
				7Swing right	①	D	B			
				8Swing left	③	E	A			
			C Type			Left	1 Swing right	②	K	B
			2 Swing left	④	L		A			
			3 Arm in	③	B	L				
			4 Arm out	①	A	K				
			Right	Same as ISO type						

2) PATTERN CHANGE SOLENOID VALVE INSTALL (option)

- ※ If the machine is equipped with the pattern change solenoid valve, the machine operation pattern can be easily changed.
- ※ Whenever a change is made to the machine control pattern also exchange the pattern label in the cab to match the new pattern.

Operation	ISO type	A type
Left RCV lever		
Right RCV lever		

- (1) The machine control pattern can be changed from the "ISO type" to "A type" by changing the position of the pattern change switch.

Before starting the machine, check the lever

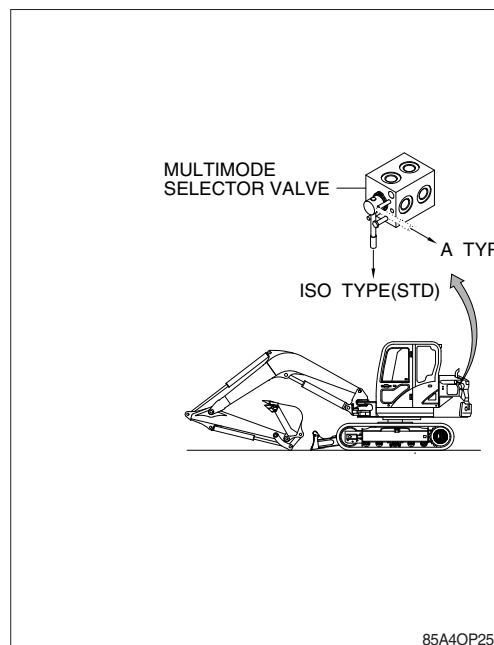
- ▲ position of pattern change switch and actual operating of attachment.

(2) Change of operating pattern

The machine control pattern is changed as below.

- Position ① : ISO type
- Position ② : A type

- ※ Refer to the page 3-40 for the switch.



12. HANDLING THE RUBBER TRACKS

1) USING THE RUBBER TRACKS PROPERLY

Rubber tracks have some advantages over steel tracks.

However, you cannot take full advantage of them if you use them in the same manner as steel ones. Use care in operating with rubber tracks in accord with the conditions of the work site and the type of work.

Comparison table of rubber and steel tracks

	Rubber	Steel
Low vibration	Excellent	Ordinary
Smooth travel	Excellent	Good
Silent travel	Excellent	Ordinary
Less damage to paved roads	Excellent	Ordinary
Simple handling	Excellent	Ordinary
Susceptibility to damage (strength)	Ordinary	Excellent
Drawbar full	Excellent	Excellent

Rubber tracks have many advantages inherent in the unique properties of the material. On the other hand, however, they are low in strength. It is essential that you fully understand the properties of rubber tracks, and observe the precautions for operating and handling them to prolong their life and get the most out of them. Be sure to read this section for using the rubber tracks before using them.

2) WARRANTY FOR RUBBER TRACKS

The rubber tracks are not warranted for free repair or replacement if they are damaged because of misuse by the customer, including the failure to comply with the prohibitions and the instructions for safe operation; (for example, the failure to check the tension of the rubber tracks or service the rubber tracks properly, or "using the rubber tracks on surfaces and terrains which could physically damage them".)

3) PROHIBITIONS FOR USING THE RUBBER TRACKS

- (1) Do not operate or turn on surfaces of terrains that have sharp stones, a hard, uneven rock base, or that expose the tracks to steel rods, scrap iron, or edges of iron plates. Failure to observe these prohibitions may damage the rubber tracks.
- (2) Do not operate the machine on a stony surface like a riverbed. Doing this may damage the rubber tracks by catching gravel in the tracks or may cause the tracks to come off. Forcibly pushing obstacles will also shorten the life of the rubber tracks.
- (3) Prevent the rubber tracks from getting exposed to oil, fuel or chemical solvents. If they are exposed, immediately wipe them. Also, do not travel on roads which have oily surfaces.
- (4) When storing the rubber tracks for a long time period (more than three months), avoid placing them in a place subject to direct exposure to sunlight or rain.

- (5) Do not operate the machine when the tracks will be exposed to heat, (i.e., near an open-air fire, on a steel plate that has been exposed to the blazing sun, or on a hot asphalt road.)
- (6) Never run on one rubber track while the other is held above the ground with the implement. Doing this may damage the rubber track or cause it to come off.

4) PRECAUTIONS FOR USING THE RUBBER TRACKS

Observe the following precautions when operating the machine :

- (1) Never spin-turn on concrete or asphalt roads.
- (2) Do not change course suddenly. Doing this will cause the rubber track to wear early or be damaged.
- (3) Do not turn the machine across a large level gap while traveling . Remember that running over a level gap at a right angle will prevent the track from coming off.
- (4) Slowly lower the machine after it has been lifted above the ground with the implement.
- (5) It is not recommended that the machine be used to handle any materials that become oily after being crushed (e.g., soybeans, corn, rapeseed oil seeds, etc.). After unavoidably using the machine to handle such materials, clean the tracks with water.
- (6) It is not recommended that the machine be used to handle materials such as salt, ammonium sulfate, potassium chloride, potassium sulfate, or superphosphate of lime. Handling these materials may affect the core metal adversely. After using the machine to handle such materials, clean the tracks with water.
- (7) Do not operate the machine at the seashore. Doing this may affect the core metal adversely due to the salt content.
- (8) If a rubber track is cracked, it could be easily damaged when exposed to salt, sugar, wheat, or soybeans. Be sure to repair any cracks in the rubber track to prevent rubber chips from getting into the materials being handled.
- (9) Do not allow the rubber track to rub against a concrete wall.
- (10) The rubber tracks are prone to slip on snow or on a frozen road. Be careful of skidding when traveling or operating on a slope in cold weather.
- (11) Operating the machine in extremely cold weather will deteriorate the rubber tracks, shortening their life.
- (12) Use the rubber tracks between -25°C to +55°C (-13°F to +131°F) because of the physical characteristics of rubber.
- (13) Be careful not to damage the rubber tracks with the bucket while operating the machine.

5) BE CAREFUL NOT TO COME OFF THE RUBBER TRACKS

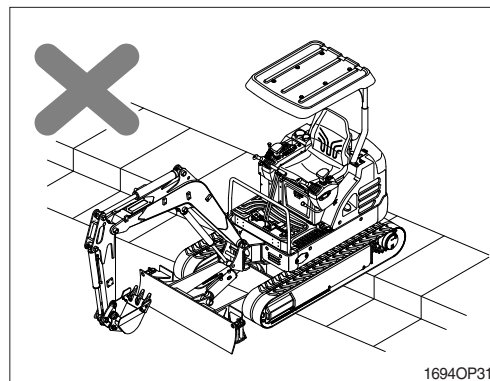
Keep the tracks in appropriate tension to prevent them from coming off.

If the tension is too low, the rubber tracks may come off under the following conditions.

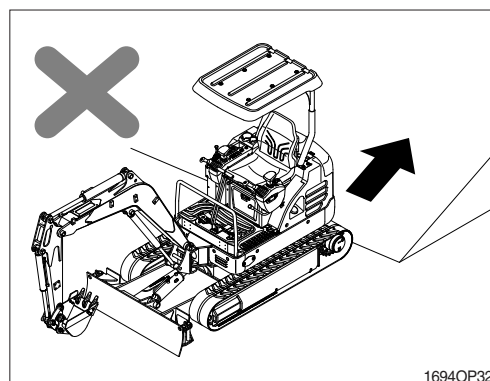
Even if the tension is adequate, take care when operating the tracks under these conditions.

Some illustrations in this section can be different from your machine.

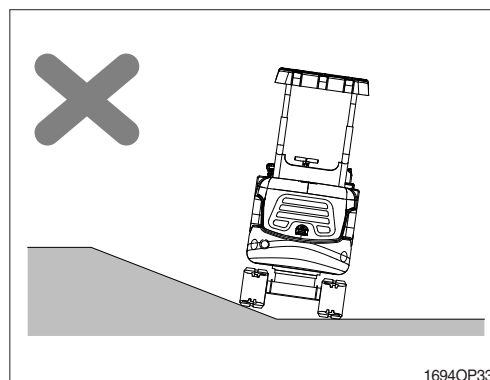
- (1) Do not steer the machine at an angle other than 90 degrees across a large level gap created by a curbstone or a rock [approximately more than 20 cm (8")]. Run over a level gap at a right angle only to prevent the tracks from coming off.



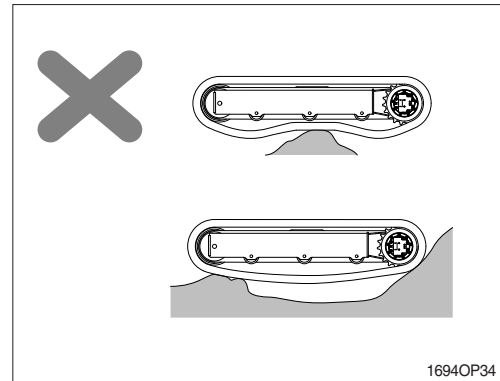
- (2) Do not steer the machine across a boundary between the flat ground and a slope, while moving backwards. If such travel is not avoidable, slow down the speed.



- (3) Do not travel with the track on one side on a slope or on convex ground (causing a machine angle of more than 10 degrees), and with the track on the other side on flat ground, to prevent the rubber track from being damaged. Be sure to travel with the tracks on both sides on the same level surface.

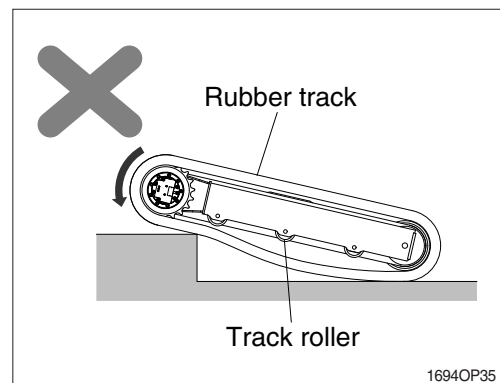


- (4) The three cases illustrated above are those which could cause the rubber tracks to loosen. In addition, do not subject machine to such ground conditions as are illustrated in the figure at the right.

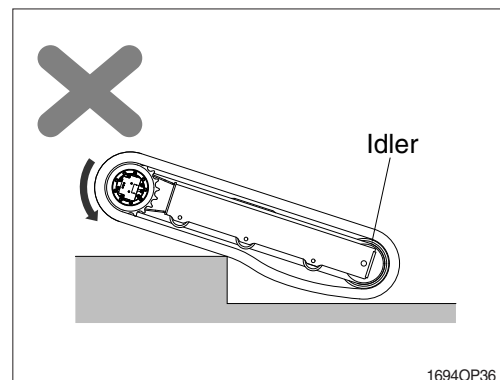


(5) **HOW THE RUBBER TRACKS COME OFF**

When running over a level gap, a clearance is created between the tracks and the track rollers. At this point, the tracks tend to come off.

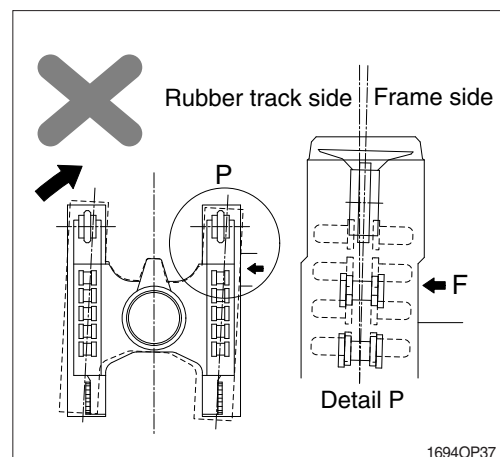


- (6) If the machine is traveling in reverse, clearance may also be created between the track rollers and the rubber tracks, and between the idlers and the rubber tracks, causing the rubber tracks to come off.

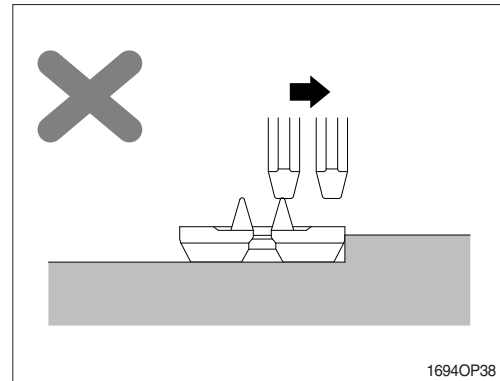


(7) Other situations to be avoided.

- ① When the machine changes the travel direction while the rubber tracks are blocked sideways by an obstacle or the like.
- ② When the idler and the track rollers are misaligned from the core metal, due to rubber track misalignment.



- ③ Traveling in reverse under the condition illustrated will cause the rubber tracks to come off.



- ④ Changing the travel direction of the machine under the condition illustrated will cause the rubber tracks to come off.

