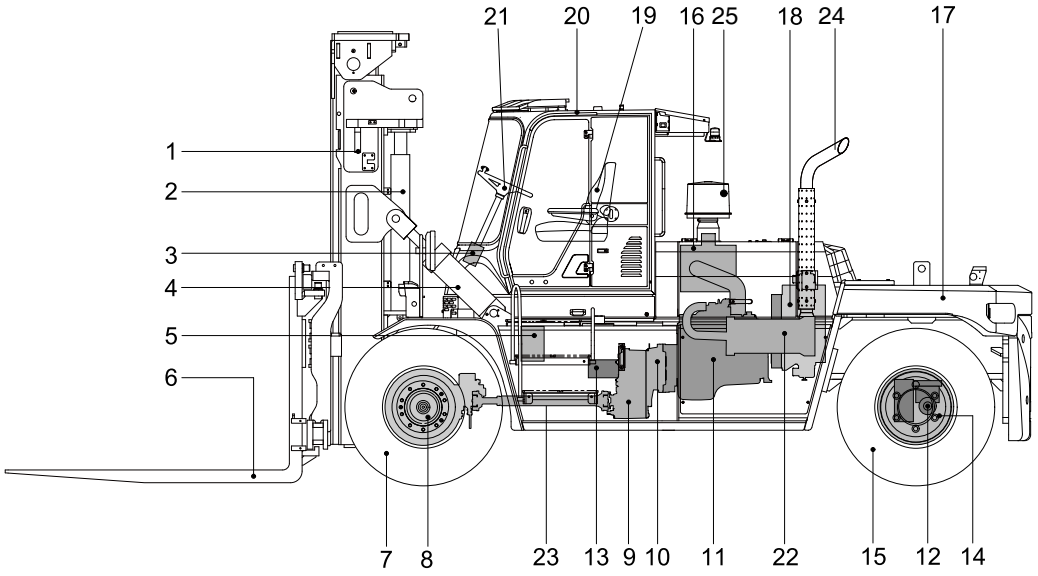
SECTION 2 REMOVAL & INSTALLATION OF UNIT

GROUP 1 STRUCTURE



250D9VOM21

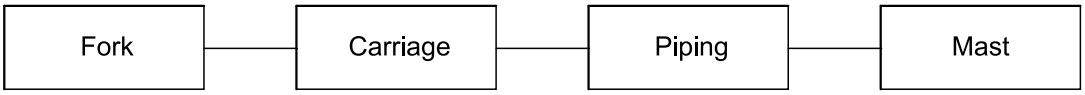
1	Mast	10	Torque converter	19	Seat
2	Lift cylinder	11	Engine	20	Cabin
3	Steering unit	12	Steering cylinder	21	Steering wheel
4	Tilt cylinder	13	Hydraulic pump	22	Aftertreatment device
5	Main control valve	14	Steering axle	23	Propeller shaft
6	Fork	15	Rear wheel	24	Silencer
7	Front wheel	16	Air cleaner	25	Precleaner
8	Drive axle	17	Counterweight		
9	Transmission	18	Radiator		

GROUP 2 REMOVAL AND INSTALLATION OF UNIT

Remove and install following units as explained in the flow chart.

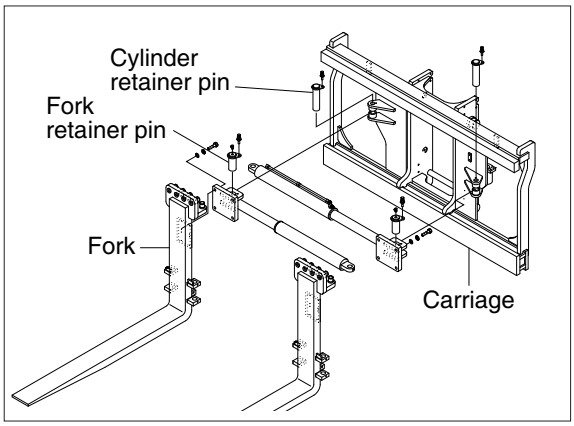
1. MAST

1) REMOVAL



(1) Forks

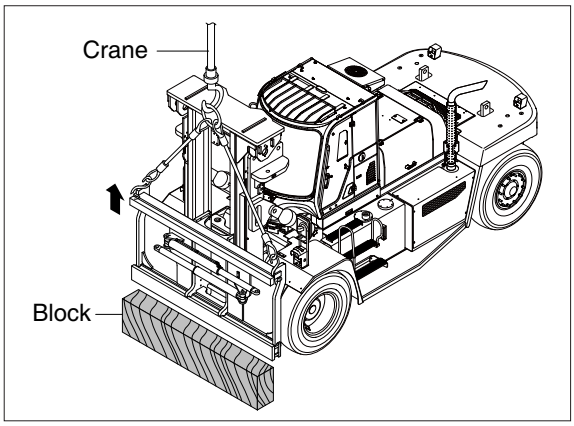
① Lower the fork carriage until the forks are approximately 25 mm (1 in) from the floor.
② Release fork retainer by removing the fork retainer pin.
Remove the cylinders at a time out of carriage assembly.
③ Remove only one fork at a time.
※ On larger forks it may be necessary to use a block of wood.



250D9RE51

(2) Carriage

① With the mast vertical, raise the carriage high enough to place blocks under the load forks. This is done to create slack in the load chains when the carriage is lowered. Lower the carriage all the way down to the floor. Make sure the carriage is level, this will prevent any binding when the mast is raised.



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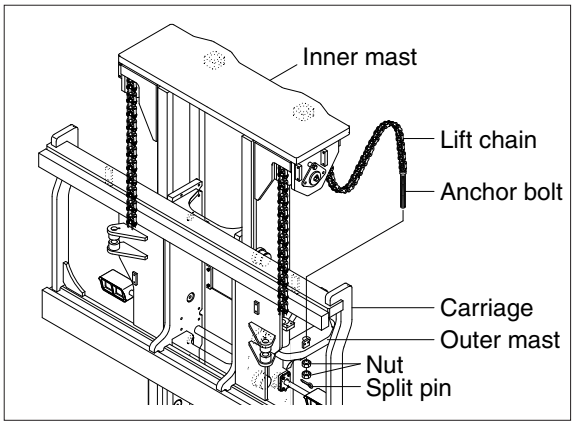
② While supporting lift chains, remove nuts from the anchor bolt.



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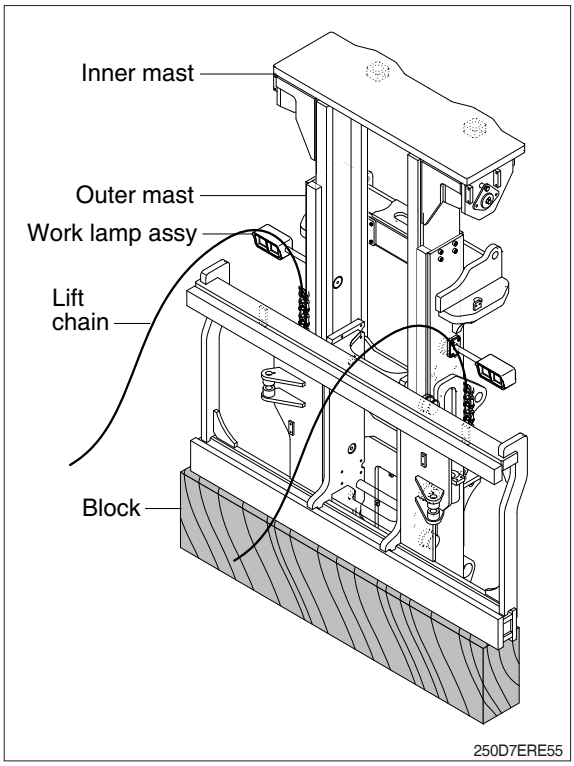
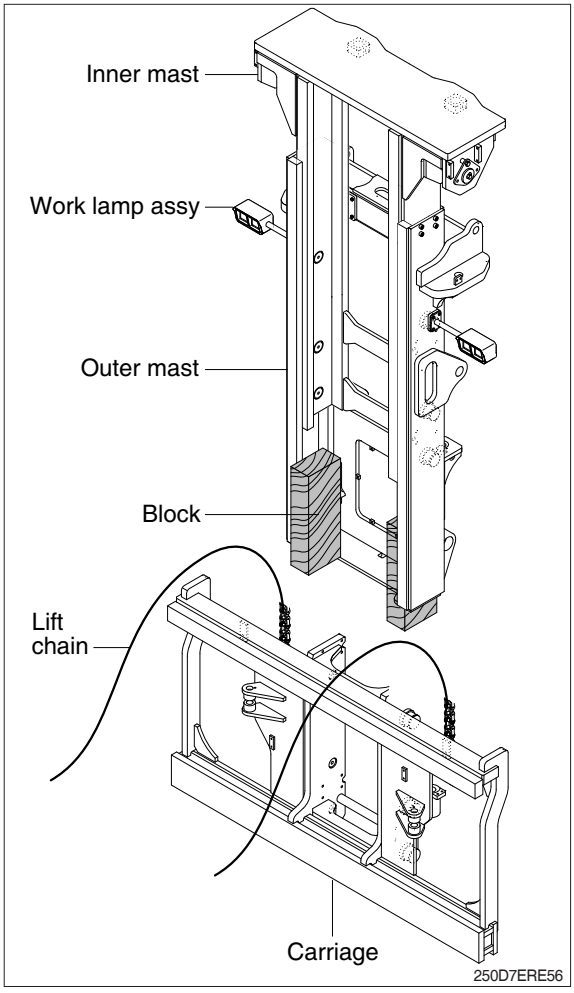
③ Pull the chains out of the sheaves and drape them over the front of the carriage.



④ Slowly raise inner mast upright until mast clears top of fork carriage. Move carriage to work area and lower the mast.

⚠ Make sure that carriage remains on floor and does not bind while mast is being raised.

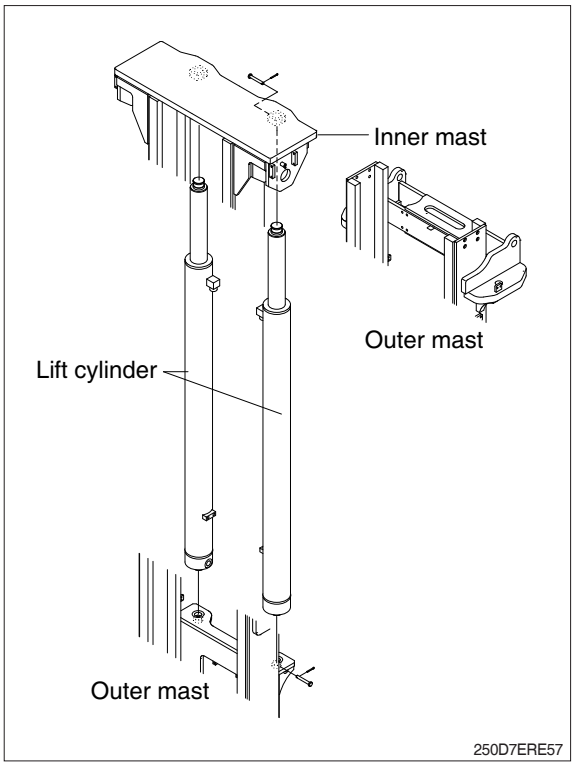
⑤ Inspect all parts for wear or damage. Replace all worn or damaged parts.



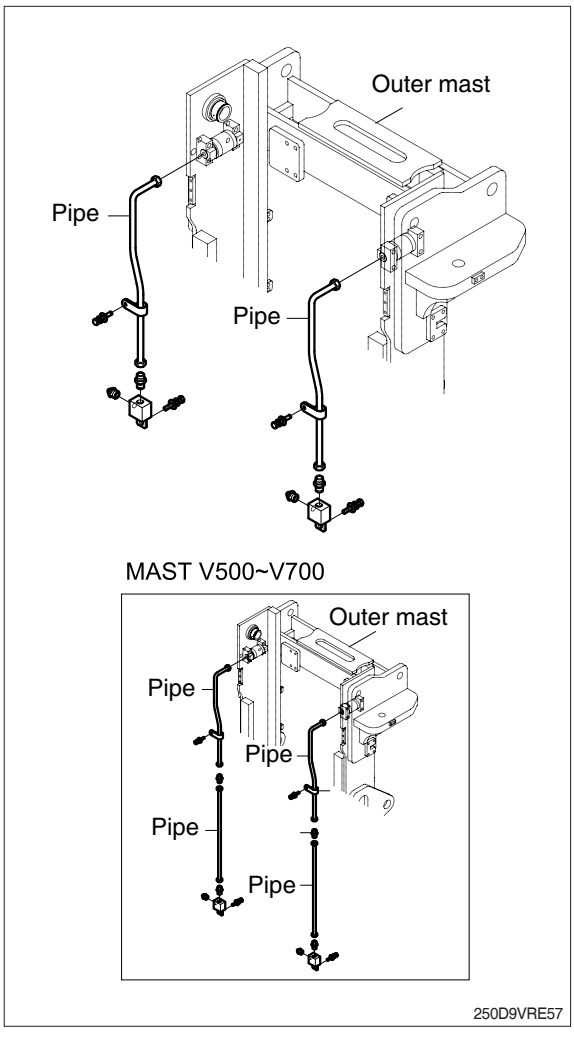
(3) Piping

① Remove the pipes and clamps attached to the cylinder.

※ Put blind plugs in the piping immediately after removing pipes.
This prevents the hydraulic oil from flowing out and also prevents dust and dirt from getting in.



② Remove the lubrication pipes and clamps.



(4) Lift cylinder

① Remove the split pin and clevis pin securing lift cylinders to inner mast.

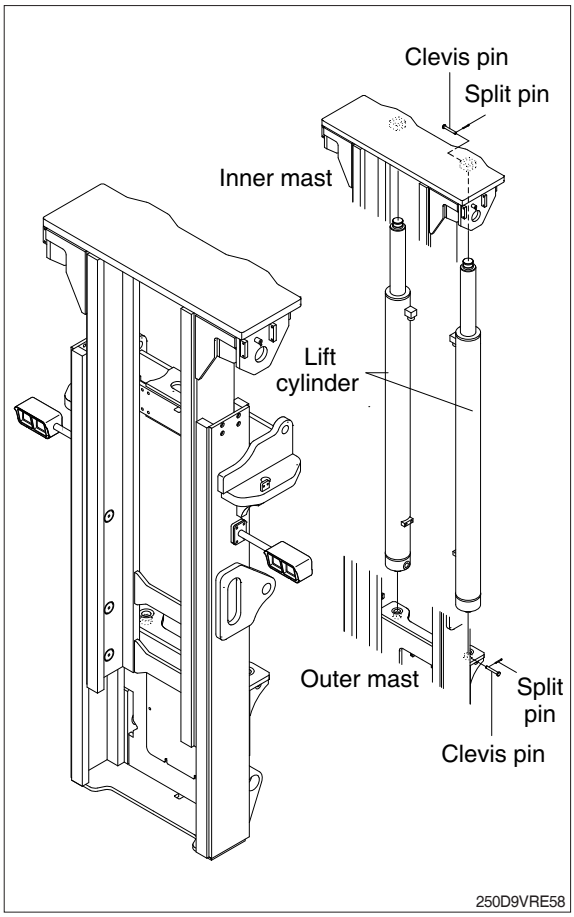
② Bind the lift cylinder with overhead hoist rope and pull up so that the rope has no slack or binding.

⚠ Make sure the lift cylinder be tightened firmly for safety.

③ Remove the split pin and clevis pin securing lift cylinders to outer mast.

④ Using an overhead hoist, slowly raise the inner mast high enough to clear lift cylinder.

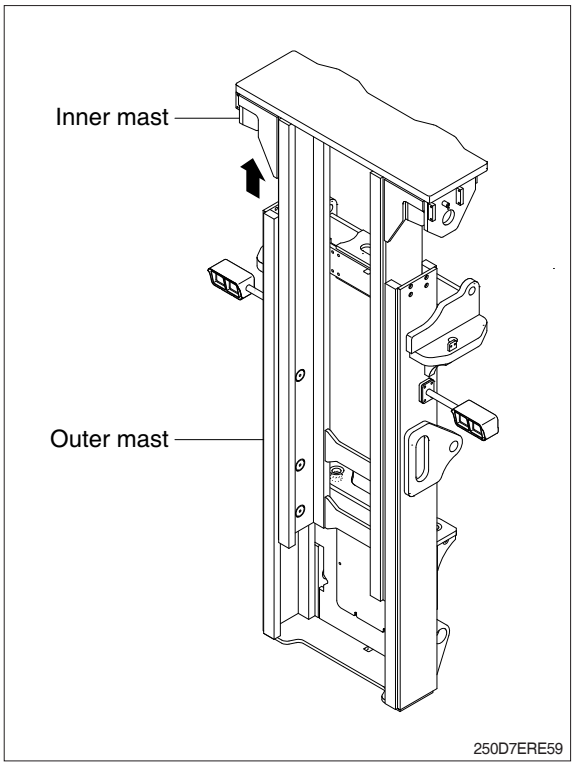
⑤ Using an overhead hoist, draw out lift cylinder carefully and put down on the work floor.



(5) Inner mast

① Using an overhead hoist raise the inner mast straight and carefully draw out of outer mast section.

⚠ **Be careful the mast not to swing or fall.**



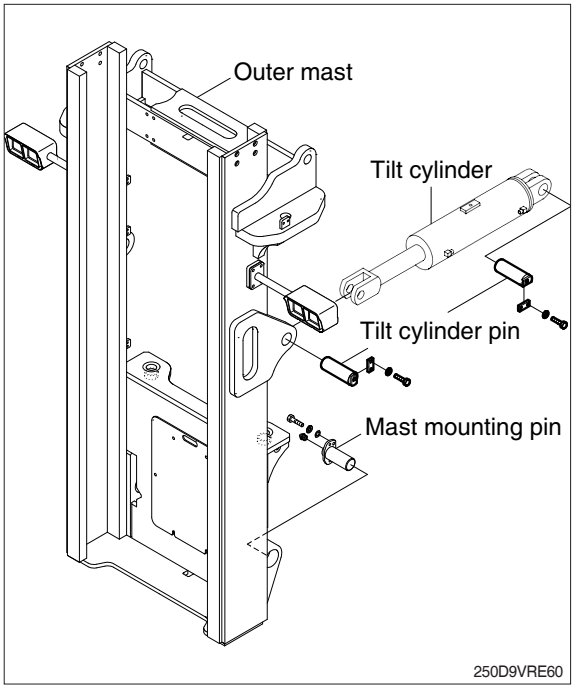
(6) Tilt cylinder pin

Loosen the bolt and remove the lock plate and tilt cylinder pin.

(7) Mast support pin

① Attach a crane to the stay at the top of the outer mast, and raise it.
Remove the mounting bolts and pins from drive axle, then slowly raise outer mast.

※ This operation is carried out under the machine, so use a pit, or if there is no pit, jack up the machine and loosen with an impact wrench.



2) INSTALLATION

After assembling mast components totally without piping connections, install mast assembly to the equipment.

※ Installation procedure for each of mast component is the reverse of the removal procedure.

(1) Mast support pin

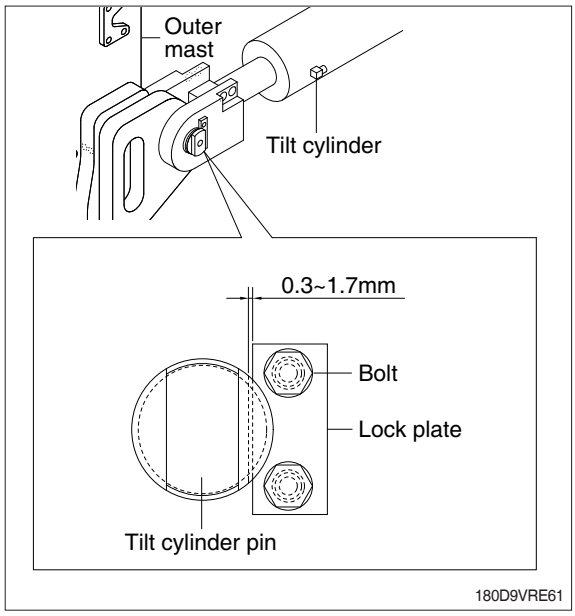
Check the mast support pins for wear, then install pins into the mast support bracket and main frame and tighten the mast pin lock bolts.

· Tightening torque : 19.6 kgf·m (142 lbf·ft)

(2) Tilt cylinder pin

① Hold the mast with a crane, operate the tilt control lever and align the holes, then knock the pin and install the lock plate by the bolts.

· Tightening torque : 15.8 kgf·m
(114 lbf·ft)



(3) Lift cylinder installation and adjustment

① Assemble the lift cylinder inside the outer mast, then tighten the stopper bolt. If the cylinder assembly has been replaced, adjust as follows so that the left and right cylinders are synchronized at the maximum lifting height.

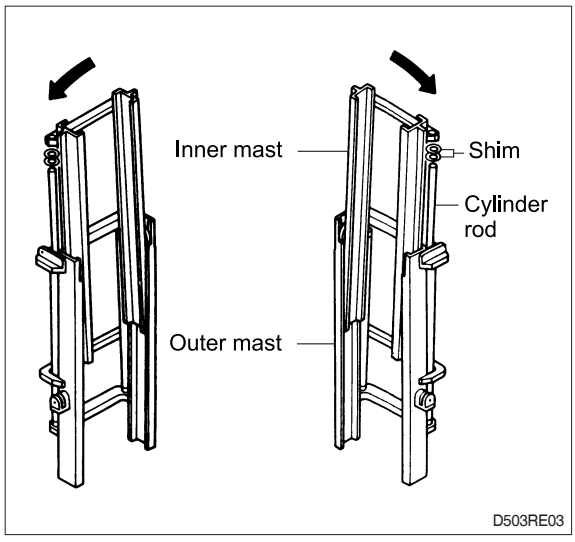
② Assemble the cylinder rod to the inner mast, and check the left-to-right play of the mast at the maximum lifting height.

※ If play is to LEFT, install adjustment shim to LEFT cylinder.

※ If play is to RIGHT, install adjustment shim to RIGHT cylinder.

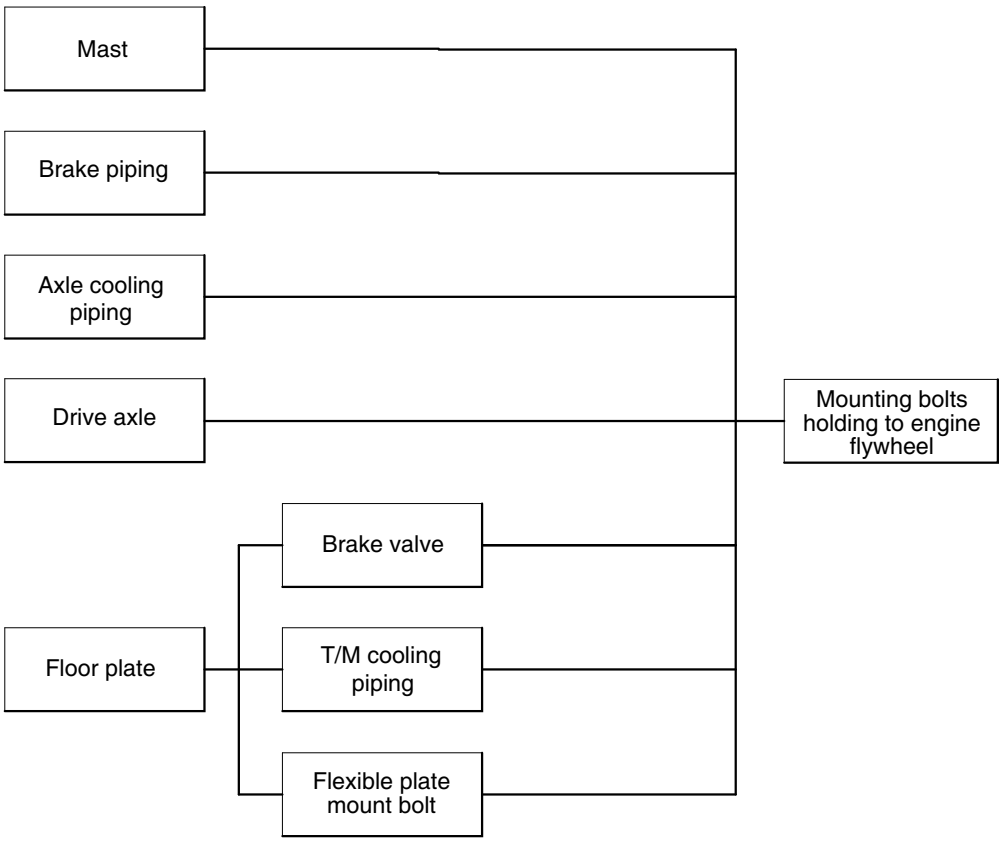
· Shim thickness : 1.0 mm (0.04 in)

※ Lubricate the grease into the nipple sufficiently.



2. POWER TRAIN ASSEMBLY

1) REMOVAL



(1) Mast

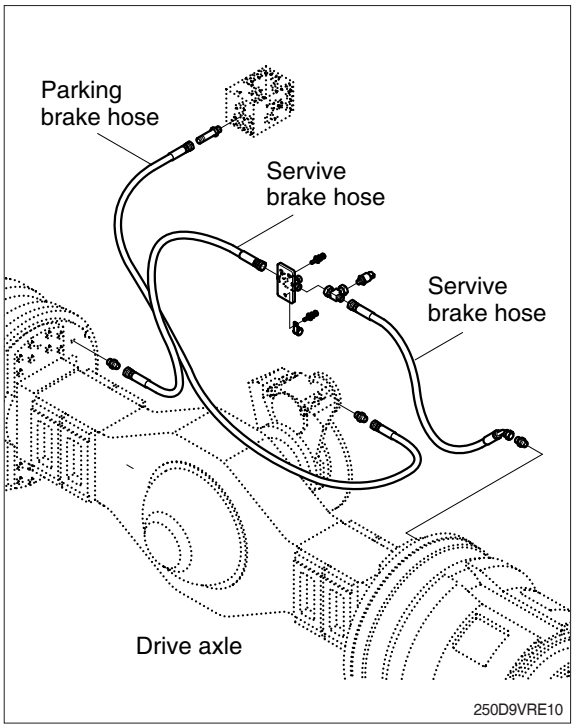
Refer to section on mast (Page 2-2)

(2) Brake piping

① **Service brake**
Disconnect the service brake hydraulic hoses from the brake housing of drive axle assy.

② **Parking brake**
Disconnect the parking brake hydraulic hose from the brake housing of drive axle assy.

⚠ When disconnecting the brake hydraulic hoses, take care that oil should not be spilt on the floor.
If someone slips due to oil spillage, it can cause to do him severe injuries.
In case of spilling out of the oil on the floor, wipe it off immediately in order to prevent someone from unexpected accident.

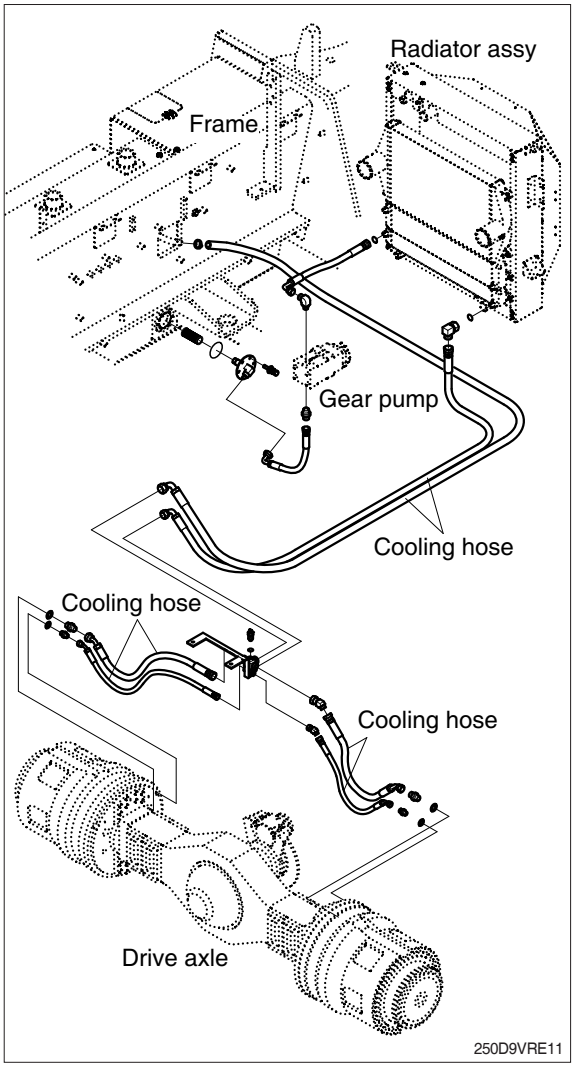


(3) Axle cooling piping

① Disconnect axle cooling hose and connector from the axle.

※ Make sure that the axle cooling oil has been drained from the line.

⚠ When disconnecting the brake hydraulic hoses, take care that oil should not be spilt on the floor.
If someone slips due to oil spillage, it can cause to do him severe injuries.
In case of spilling out of the oil on the floor, wipe it off immediately in order to prevent someone from unexpected accident.



(4) Drive axle

※ Before removing the drive axle unit, drain all of the oil from the axle.

① Jack up the machine and then put the block under the frame.

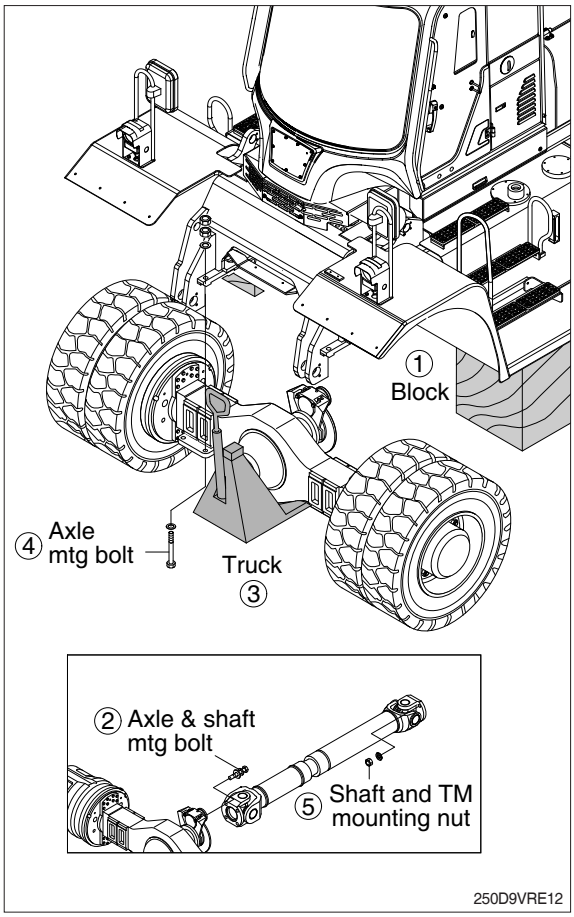
※ If there is a pit, use the pit for safety.

② Loosen hexagonal bolts connecting drive axle to the propeller shaft.

③ Prepare the truck under the drive axle unit to support it.

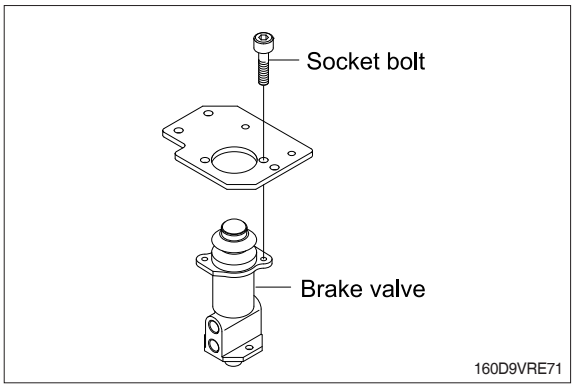
④ Remove mounting bolts fixing the axle to the frame and then carefully draw the truck out of the vehicle with the drive axle unit.

⑤ Loosen mounting nuts fixing the drive shaft to the transmission and then draw out the drive shaft.



(5) Brake valve

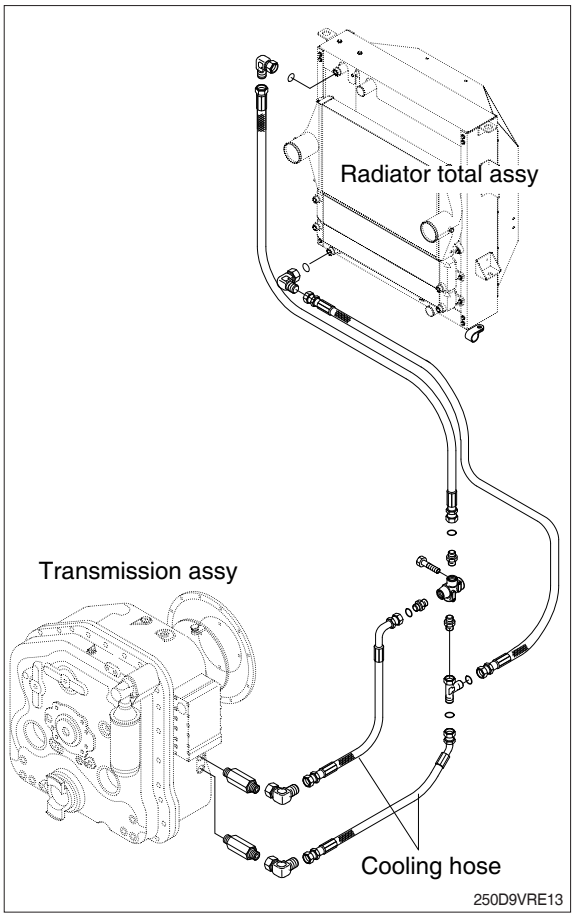
① Loosen socket bolts and remove brake valve assembly.



(6) Transmission cooling hose

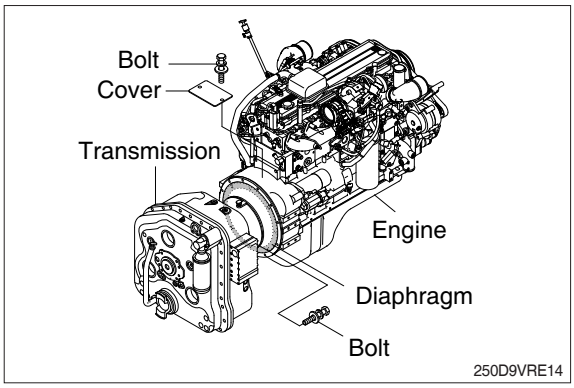
① Disconnect cooling hose and connector from the transmission.

※ Make sure that the coolant has been drained from the line.



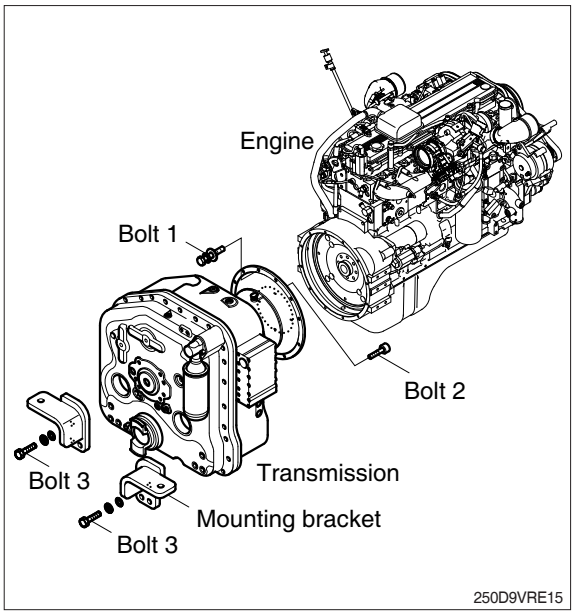
(7) Flexible plate

① Remove the cover on the right side of flywheel housing housing then remove 4 pieces of the mounting bolts installed to the engine flywheel.
To rotate the flywheel, rotate the crank shaft at the end of the engine.

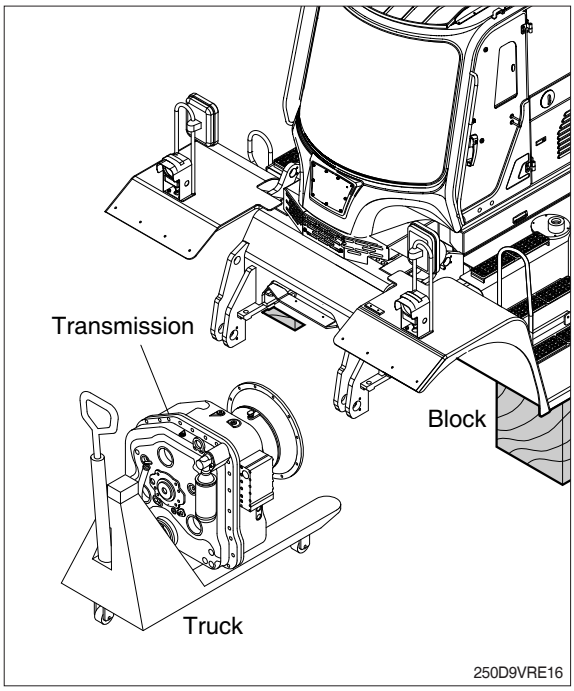


(8) Mounting bolts holding to flywheel housing

① Remove the transmission assembly from engine by loosen-ing 12 pieces of the mounting bolts. (Bolt ②)



② Using a moving truck slowly pull out transmission assembly to the front.



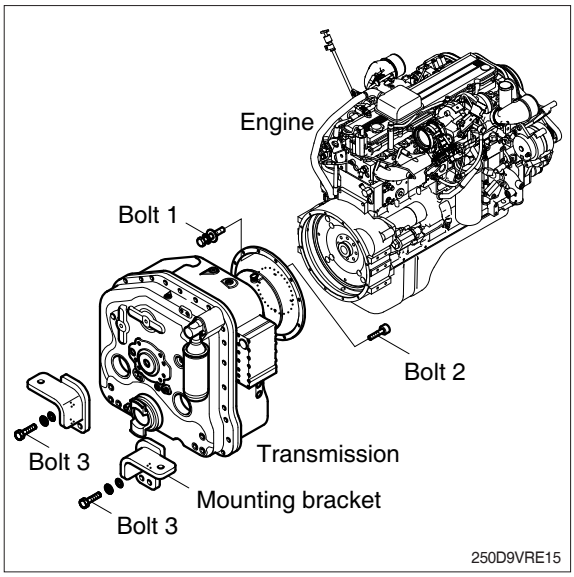
2) INSTALLATION

Installation is the reverse order to removal, but be careful of the following points.

(1) Tightening torque of mounting bolts 1 to flywheel housing.
Bolt 1 : 5.5~8.3 kgf·m (39.8~60.0 lbf·ft)

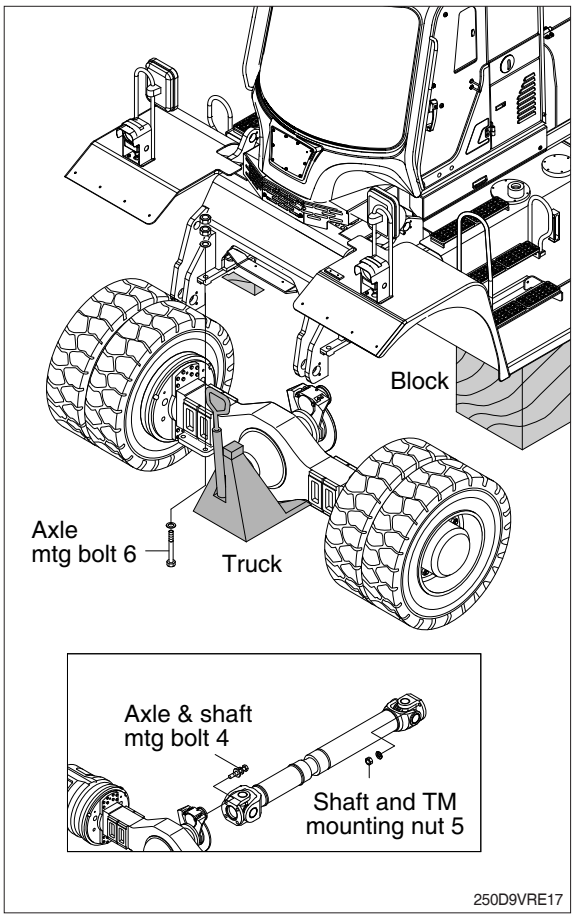
(2) Tightening torque of mounting to the fly wheel bolts 2 for diaphragm.
Bolt 2 : 3.9~5.1 kgf·m (28.2~36.9 lbf·ft)

(3) Tightening torque of mounting to the fly wheel bolts 3 for mounting bracket.
Bolt 3 : 55~66 kgf·m (398~477 lbf·ft)



(4) Tightening torque of mounting bolts 4 and nut 5 for propeller shaft.
Bolt 4 : 9.8~14.8 kgf·m (70.9~107 lbf·ft)
Nut 5 : 13~17 kgf·m (94~123 lbf·ft)

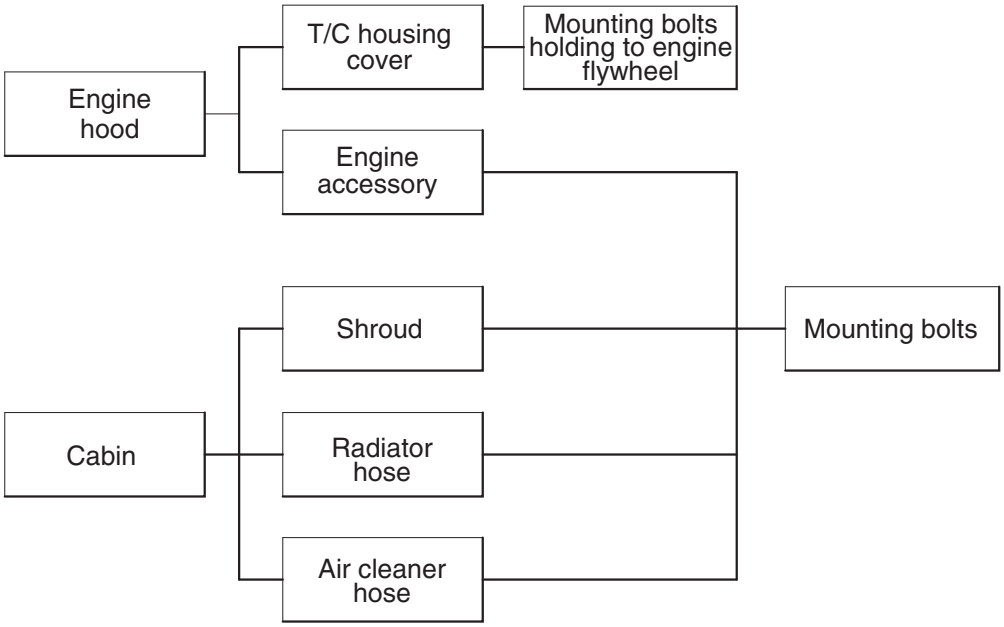
(5) Tightening torque of mounting bolts 6 for drive axle.
Bolt 6 : 105~125 kgf·m (757~903 lbf·ft)



3. ENGINE

Remove the torque converter, transmission and front axle inside the frame, then remove the engine assembly

1) REMOVAL



(1) Engine hood

① **Cabin**

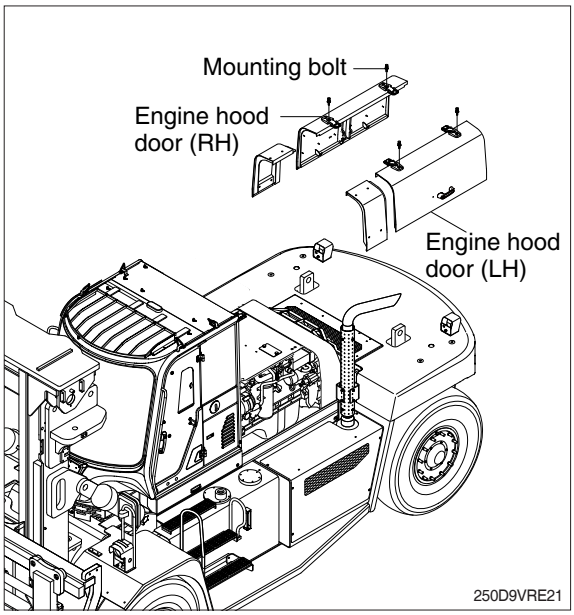
- First, tilt the cabin

※Refer to page 7-16 for operating manual.

- After remove the wiring for rear combination lamp, work lamp, head lamp and flasher lamp on the stay of the cabin and then raise it with a crane.
- Finally remove cabin for tilt option cylinder, pin and latch assy.

② **Engine cover (LH, RH)**

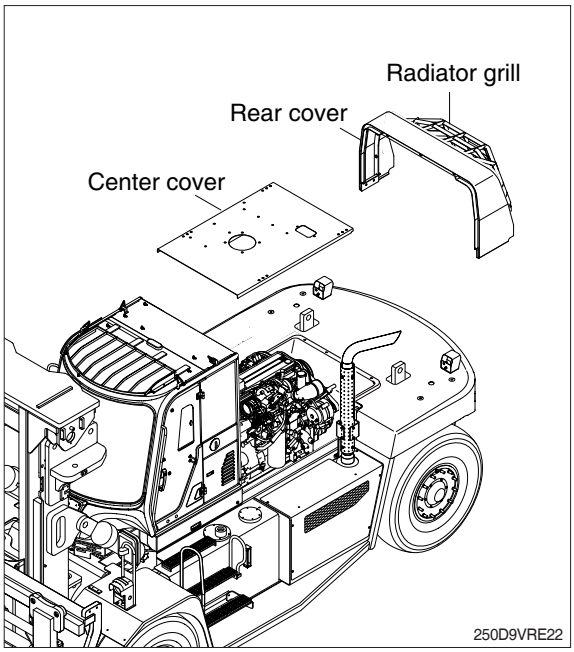
Remove engine hood door by loosening the mounting bolts.



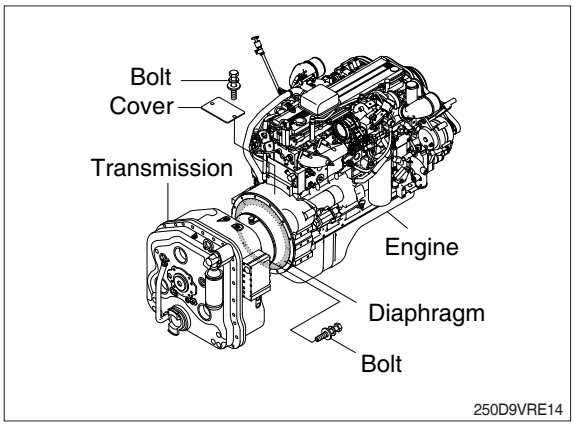
② **Engine cover (center and rear cover)**

a. Pull upside the precleaner by loosening the clamp and seal in the air intake hole of air cleaner.

b. Remove center and rear cover upward.



(2) Torque converter housing cover and mounting bolts. See page 2-13.



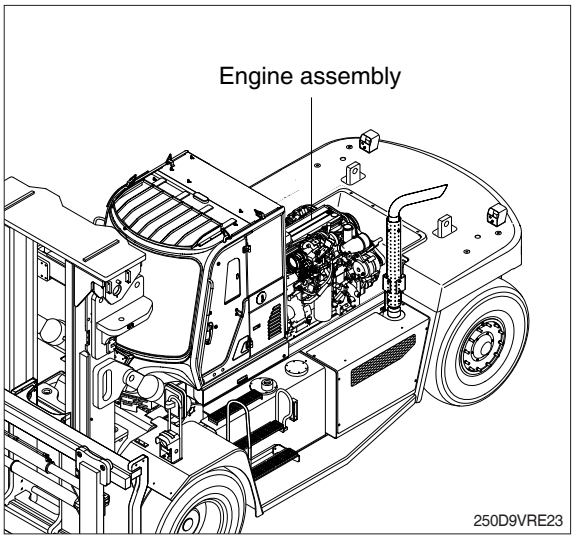
(3) Engine accessory

Remove all wiring harnesses, cables and hoses around the engine, dashboard and frame.

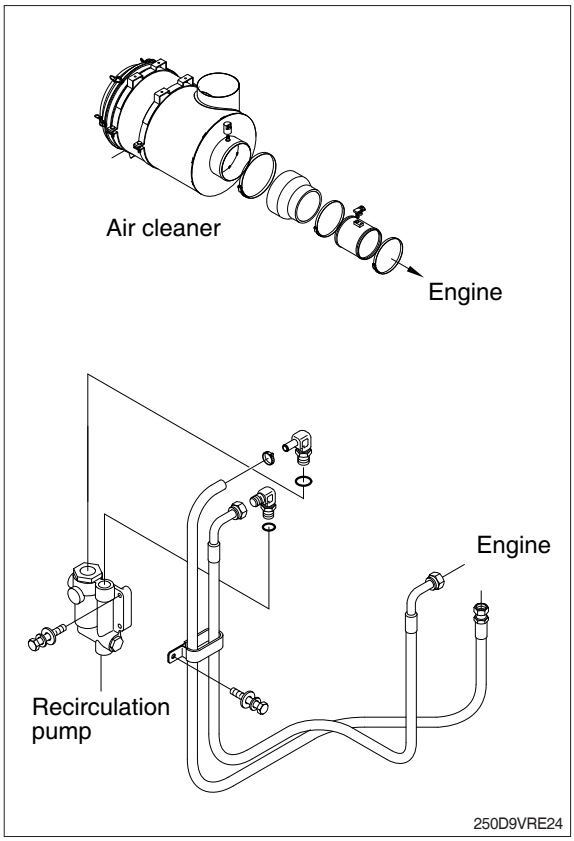
① Wiring harness to alternator and starter.

② Wiring harness for oil pressure and engine water temperature gauges.

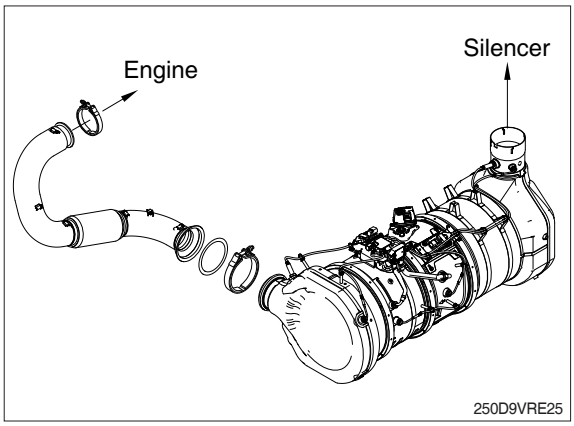
③ Cables for meters, buttons and accelerator pedal.



④ Hoses to fuel tank and air cleaner.

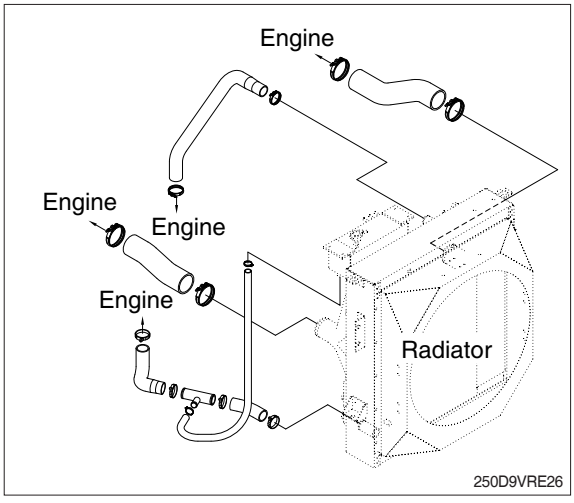


⑤ Exhaust pipe.



(4) Radiator hose

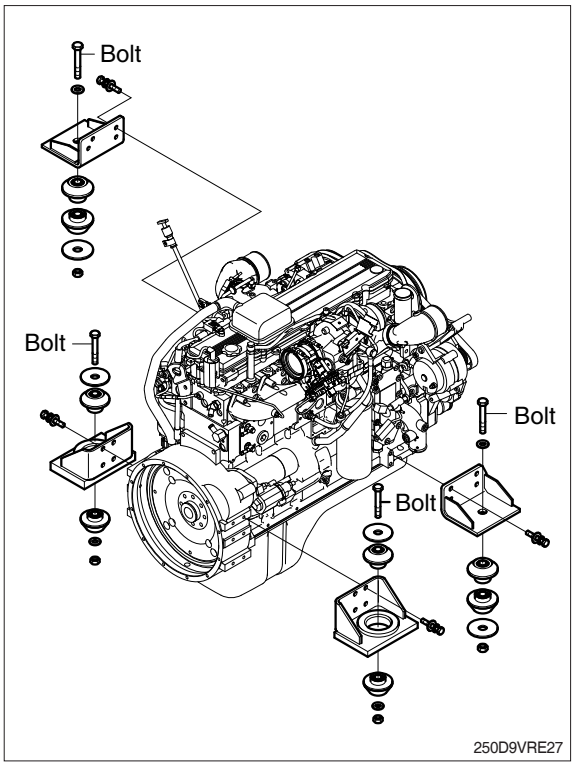
Open the drain valve of the radiator and drain the cooling water, then remove the radiator hose.



(5) Engine mounting bracket

Attach a crane to the engine hook and raise, then remove mounting bolts. Raise the engine slightly, slide towards the radiator, then lift up.

※ When sliding the engine, be careful of the collision of engine and radiator.



2) INSTALLATION

Installation is the reverse order to removal, but be careful of the following points.

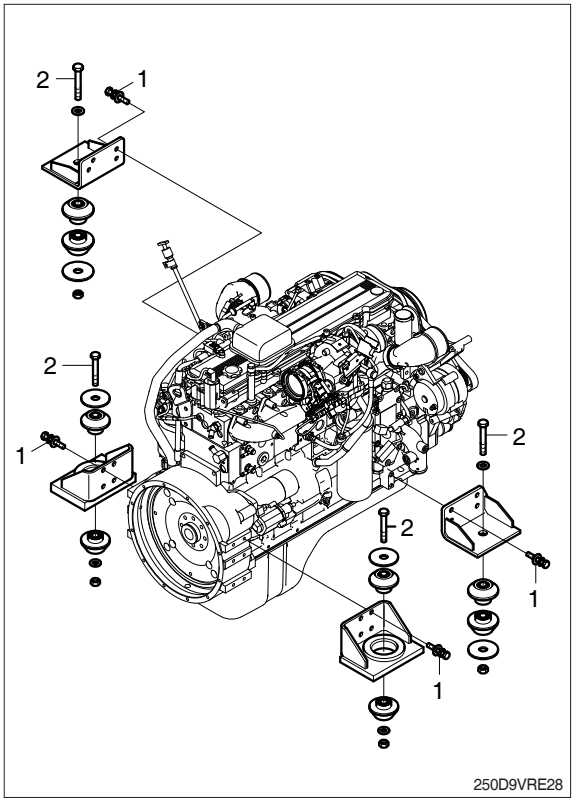
(1) Tighten the engine mounting bolts (1).
· 9.8~15.8 kgf·m (71~114 lbf·ft)

(2) Tighten the engine mounting bracket bolts (2).
· 85~115 kgf·m (615~832 lbf·ft)

※ Do not remove the bolts unless necessary. Loctite is coated over the threads of bolt. So, once the bolts were removed, coat them with loctite (#277) when installing.

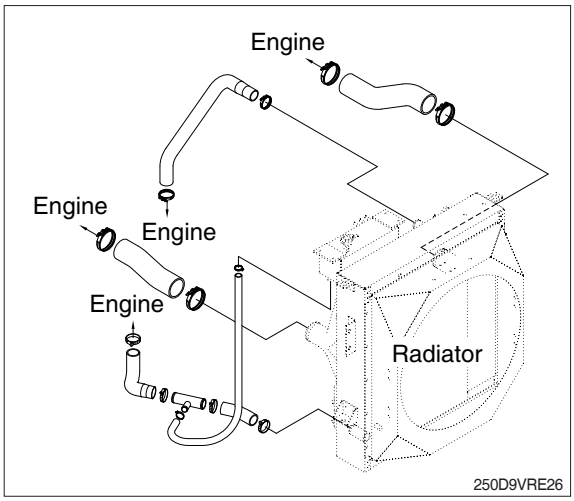
※ Before installing the bolts, loctite in the holes should be removed by a tap

(3) Tightening torque of mounting bolt installed to torque converter housing.
· See page 2-13, 2) INSTALLATION.



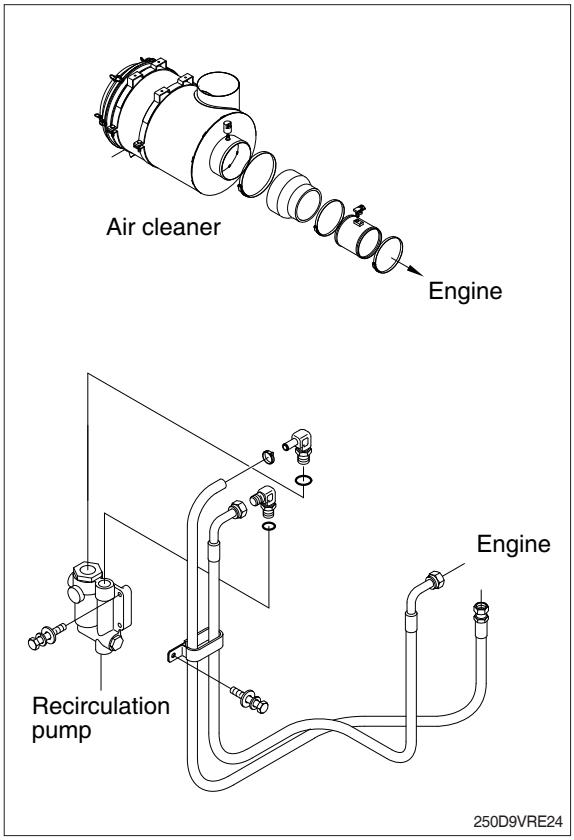
(4) Radiator hoses

Insert the radiator hoses securely and fit the clamps.



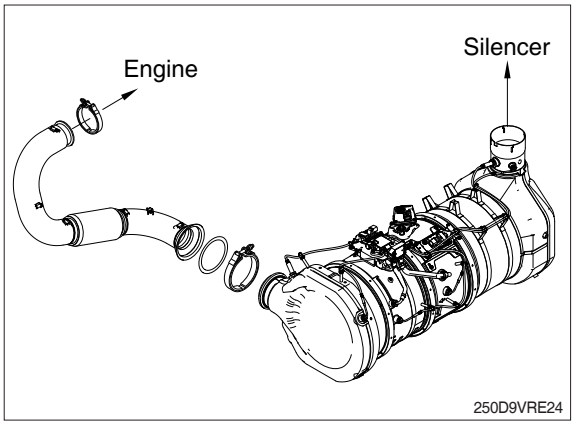
(5) Hoses to fuel tank and air cleaner

① Insert the air cleaner hose and fuel hoses securely and fit a clamp.



(6) Exhaust pipe

Insert the exhaust pipe to the engine securely and fit a clamp.



(7) Engine accessory

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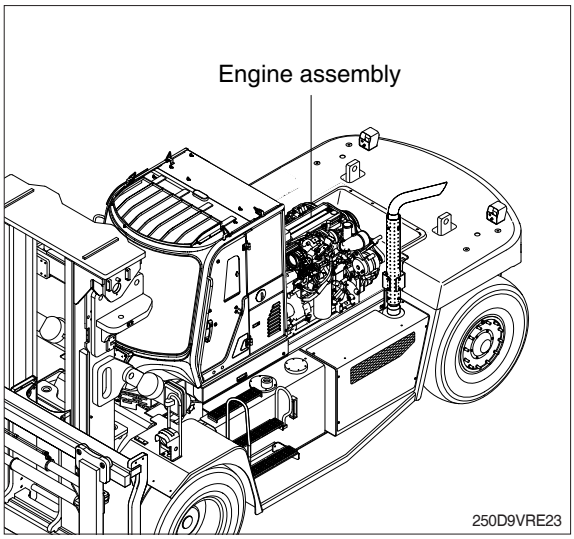
① Wiring harness to alternator and starter.

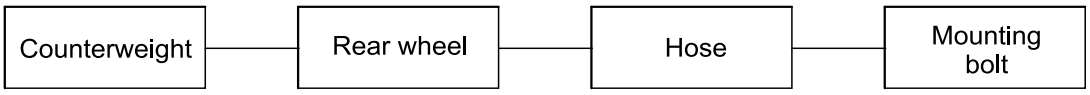
② Wiring harness for oil pressure and engine water temperature gauges.

③ Cables for meters, buttons and accelerator pedal.



4. REAR AXLE

1) REMOVAL



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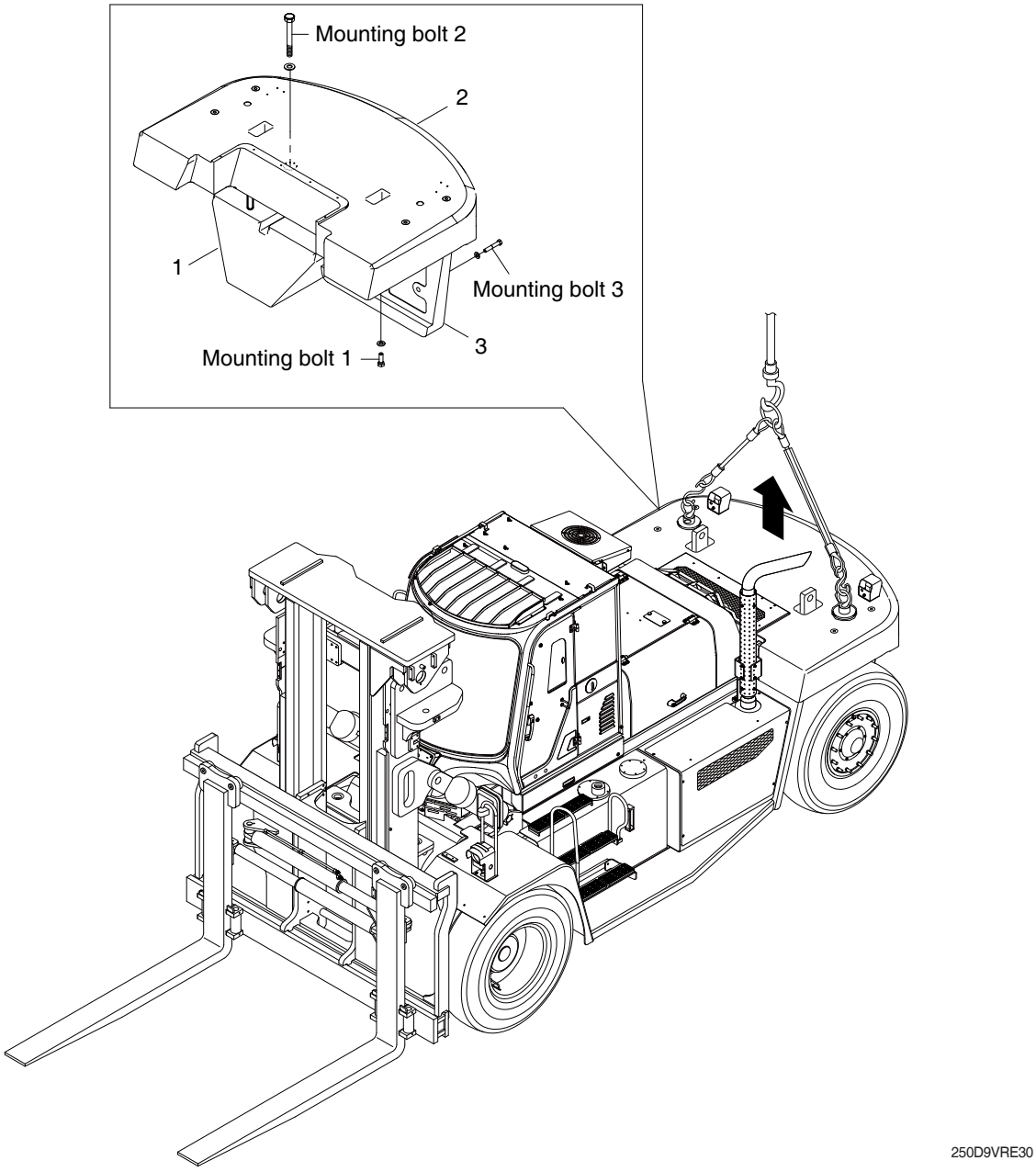


250D9VRE30

(1) Counterweight

Hold the counterweight with hoist bars, and raise it with a crane.

Remove the mounting bolts, raise slightly and move it slowly to rear side.

· Weight of counterweight (standard)

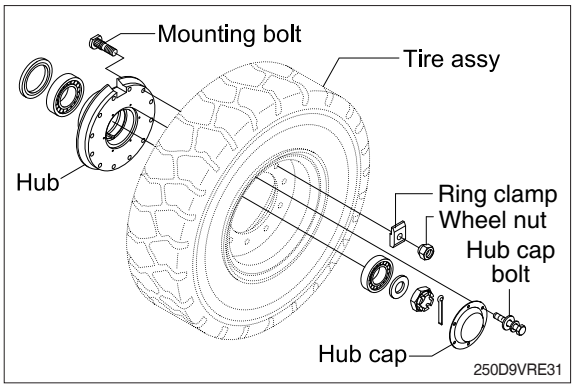
Description	Weight	Tightening torque
Counterweight (1)	2640 kg (5820 lb)	100 ± 10 kgf · m (723 ± 72.3 lbf · ft)
Counterweight-upper (2)	7416 kg (16350 lb)	100 ± 10 kgf · m (723 ± 72.3 lbf · ft)
Counterweight-lower (3)	1442 kg (3180 lb)	140 ± 15 kgf · m (1013 ± 108 lbf · ft)

※ Apply loctite #277 on the thread before tightening the bolts.

(2) Rear wheel

Remove mounting bolt and hub nut with socket wrench and then carefully take out the tire assembly.

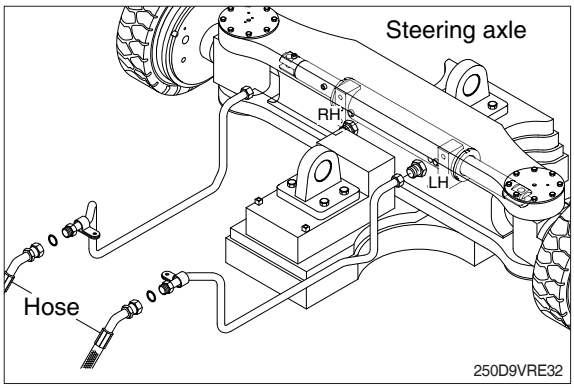
- **Wheel nut tightening torque**
  60~65 kgf·m (434~470 lbf·ft)
- **Hub cap bolt tightening torque**
  2.5±0.5 kgf·m (11.8±3.6 lbf·ft)



(3) Hose

Disconnect the hose from the steering axle and then drain out oil from the hoses.

⚠ **When disconnecting the hoses, take care that oil should not be spilt on the floor.**
If someone slips due to oil spillage, it can cause to do him severe injuries.
In case of spilling out of the oil on the floor, wipe away immediately it in order to prevent someone from unexpected accident.



(4) Mounting bolt

Put a block under the steering axle, support on a truck, an raise the frame with a crane. Remove the mounting bolts installing to the frame, and pull out to the rear.
There are shims between the support and steering axle to prevent play.

- **Mounting bolt tightening torque**
  100±15 kgf·m (723±72.3 lbf·ft)

※ Apply loctite #277 on the thread before tightening.