

SECTION 1 GENERAL

Group 1 Safety Hints	1-1
Group 2 Specifications	1-10

SECTION 1 GENERAL

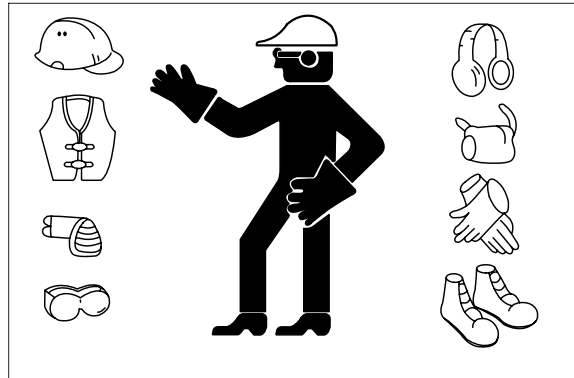
GROUP 1 SAFETY

FOLLOW SAFE PROCEDURE

Unsafe work practices are dangerous. Understand service procedure before doing work; Do not attempt shortcuts.

WEAR PROTECTIVE CLOTHING

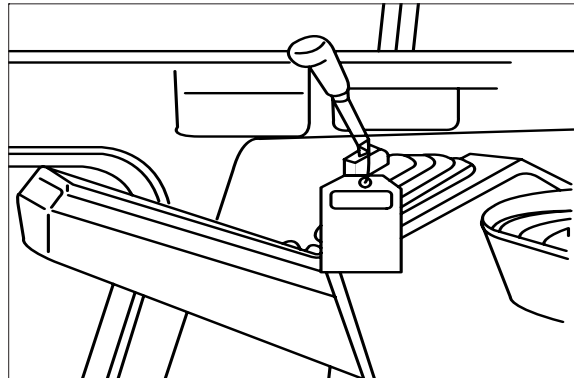
Wear close fitting clothing and safety equipment appropriate to the job.



WARN OTHERS OF SERVICE WORK

Unexpected machine movement can cause serious injury.

Before performing any work on the excavator, attach a 「Do Not Operate」 tag on the right side control lever.



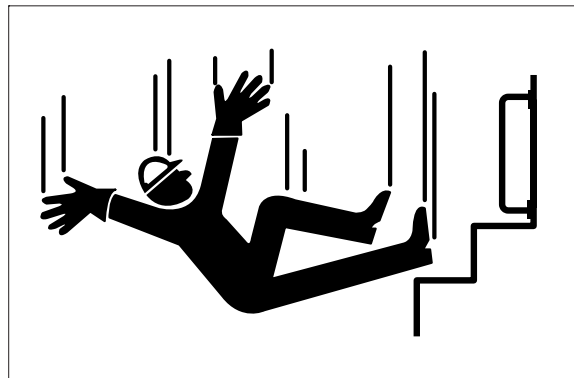
USE HANDHOLDS AND STEPS

Falling is one of the major causes of personal injury.

When you get on and off the machine, always maintain a three point contact with the steps and handrails and face the machine. Do not use any controls as handholds.

Never jump on or off the machine. Never mount or dismount a moving machine.

Be careful of slippery conditions on platforms, steps, and handrails when leaving the machine.

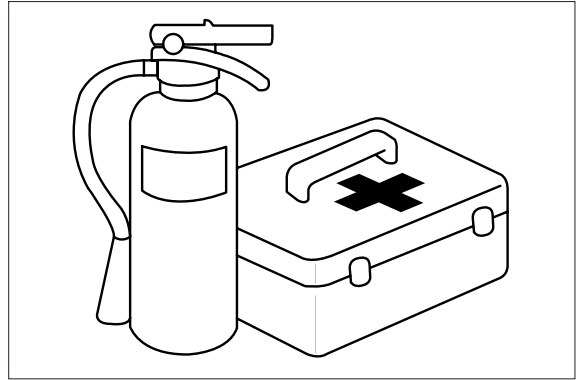


PREPARE FOR EMERGENCIES

Be prepared if a fire starts.

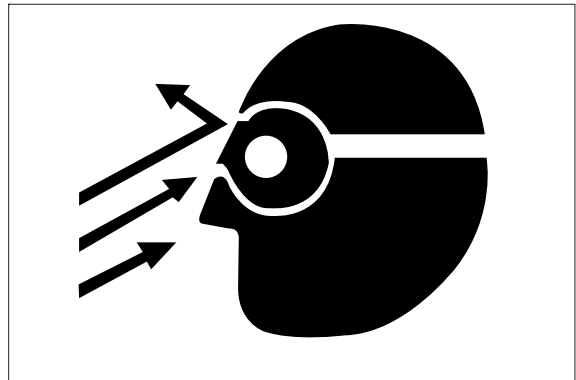
Keep a first aid kit and fire extinguisher handy.

Keep emergency numbers for doctors, ambulance service, hospital, and fire department near your telephone.



PROTECT AGAINST FLYING DEBRIS

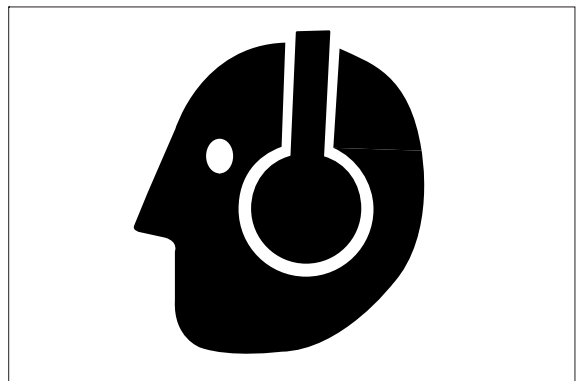
Guard against injury from flying pieces of metal or debris; Wear goggles or safety glasses.



PROTECT AGAINST NOISE

Prolonged exposure to loud noise can cause impairment or loss of hearing.

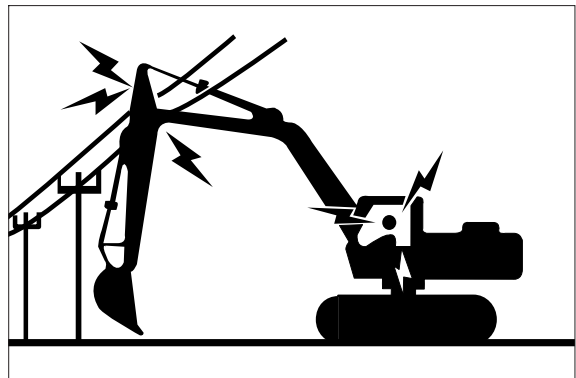
Wear a suitable hearing protective device such as earmuffs or earplugs to protect against objectionable or uncomfortable loud noises.



AVOID POWER LINES

Serious injury or death can result from contact with electric lines.

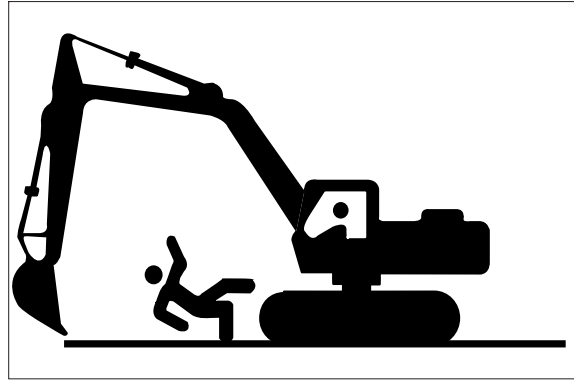
Never move any part of the machine or load closer to electric line than 3m(10ft) plus twice the line insulator length.



KEEP RIDERS OFF EXCAVATOR

Only allow the operator on the excavator. Keep riders off.

Riders on excavator are subject to injury such as being struck by foreign objects and being thrown off the excavator. Riders also obstruct the operator's view resulting in the excavator being operated in an unsafe manner.

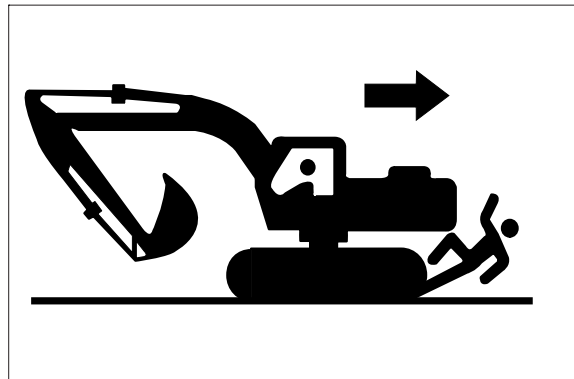


MOVE AND OPERATE MACHINE SAFELY

Bystanders can be run over. Know the location of bystanders before moving, swinging, or operating the machine.

Always keep the travel alarm in working condition. It warns people when the excavator starts to move.

Use a signal person when moving, swinging, or operating the machine in congested areas. Coordinate hand signals before starting the excavator.



OPERATE ONLY FROM OPERATOR'S SEAT

Avoid possible injury machine damage. Do not start engine by shorting across starter terminals.

NEVER start engine while standing on ground. Start engine only from operator's seat.



PARK MACHINE SAFELY

Before working on the machine:

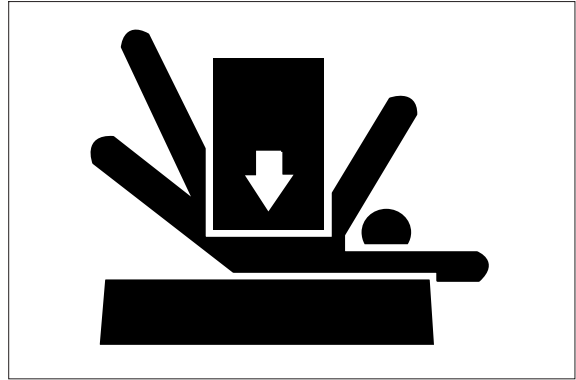
- Park machine on a level surface.
- Lower bucket to the ground.
- Turn auto idle switch off.
- Run engine at 1/2 speed without load for 2 minutes.
- Turn key switch to OFF to stop engine. Remove key from switch.
- Move pilot control shutoff lever to locked position.
- Allow engine to cool.

SUPPORT MACHINE PROPERLY

Always lower the attachment or implement to the ground before you work on the machine. If you must work on a lifted machine or attachment, securely support the machine or attachment.

Do not support the machine on cinder blocks, hollow tiles, or props that may crumble under continuous load.

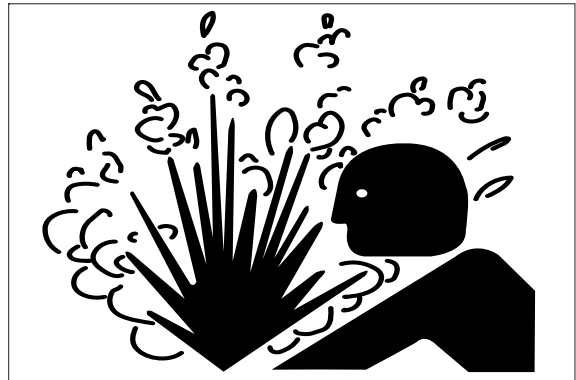
Do not work under a machine that is supported solely by a jack. Follow recommended procedures in this manual.



SERVICE COOLING SYSTEM SAFELY

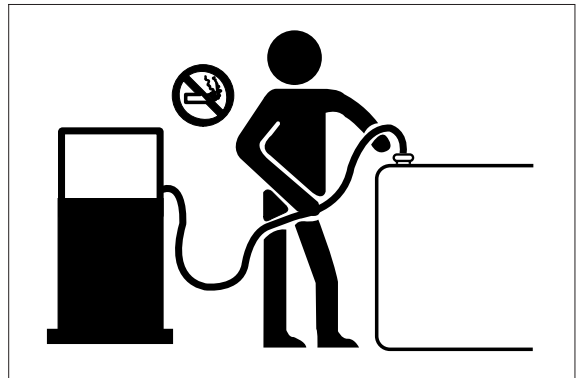
Explosive release of fluids from pressurized cooling system can cause serious burns.

Shut off engine. Only remove filler cap when cool enough to touch with bare hands.



HANDLE FLUIDS SAFELY-AVOID FIRES

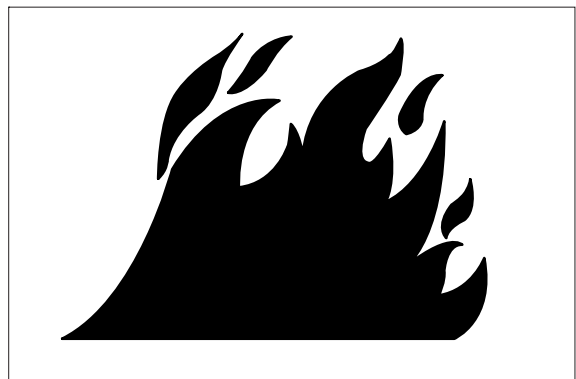
Handle fuel with care; It is highly flammable. Do not refuel the machine while smoking or when near open flame or sparks. Always stop engine before refueling machine. Fill fuel tank outdoors.



Store flammable fluids away from fire hazards. Do not incinerate or puncture pressurized containers.

Make sure machine is clean of trash, grease, and debris.

Do not store oily rags; They can ignite and burn spontaneously.



BEWARE OF EXHAUST FUMES

Prevent asphyxiation. Engine exhaust fumes can cause sickness or death.

If you must operate in a building, be positive there is adequate ventilation. Either use an exhaust pipe extension to remove the exhaust fumes or open doors and windows to bring enough outside air into the area.

REMOVE PAINT BEFORE WELDING OR HEATING

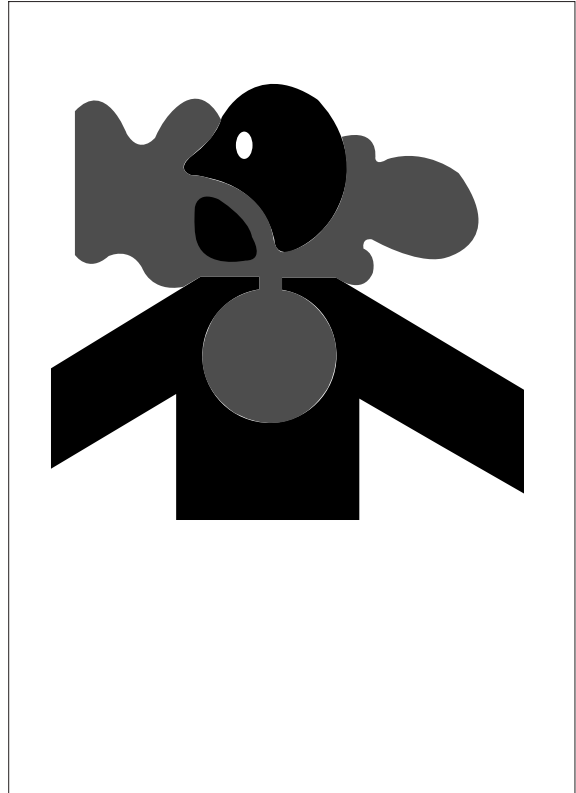
Avoid potentially toxic fumes and dust.

Hazardous fumes can be generated when paint is heated by welding, soldering, or using a torch.

Do all work outside or in a well ventilated area. Dispose of paint and solvent properly.

Remove paint before welding or heating:

- If you sand or grind paint, avoid breathing the dust.
Wear an approved respirator.
- If you use solvent or paint stripper, remove stripper with soap and water before welding. Remove solvent or paint stripper containers and other flammable material from area. Allow fumes to disperse at least 15 minutes before welding or heating.



ILLUMINATE WORK AREA SAFELY

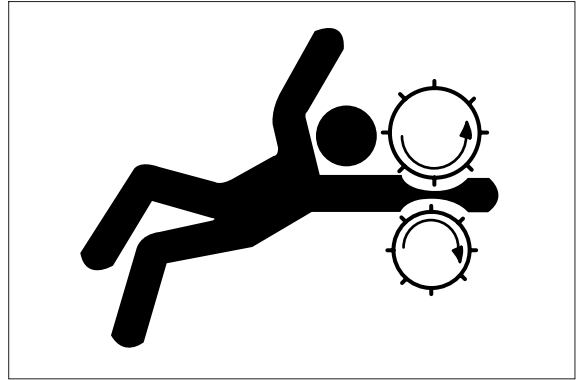
Illuminate your work area adequately but safely. Use a portable safety light for working inside or under the machine. Make sure the bulb is enclosed by a wire cage. The hot filament of an accidentally broken bulb can ignite spilled fuel or oil.



SERVICE MACHINE SAFELY

Tie long hair behind your head. Do not wear a necktie, scarf, loose clothing or necklace when you work near machine tools or moving parts. If these items were to get caught, severe injury could result.

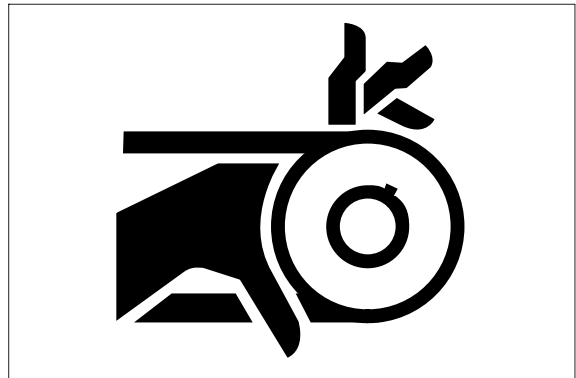
Remove rings and other jewelry to prevent electrical shorts and entanglement in moving parts.



STAY CLEAR OF MOVING PARTS

Entanglements in moving parts can cause serious injury.

To prevent accidents, use care when working around rotating parts.



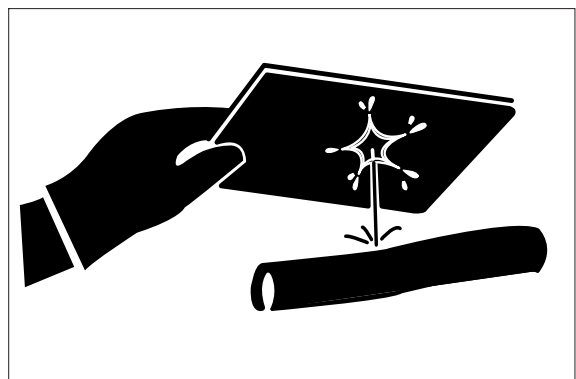
AVOID HIGH PRESSURE FLUIDS

Escaping fluid under pressure can penetrate the skin causing serious injury.

Avoid the hazard by relieving pressure before disconnecting hydraulic or other lines. Tighten all connections before applying pressure.

Search for leaks with a piece of cardboard. Protect hands and body from high pressure fluids.

If an accident occurs, see a doctor immediately. Any fluid injected into the skin must be surgically removed within a few hours or gangrene may result.



AVOID HEATING NEAR PRESSURIZED FLUID LINES

Flammable spray can be generated by heating near pressurized fluid lines, resulting in severe burns to yourself and bystanders. Do not heat by welding, soldering, or using a torch near pressurized fluid lines or other flammable materials.

Pressurized lines can be accidentally cut when heat goes beyond the immediate flame area. Install fire resisting guards to protect hoses or other materials.



PREVENT BATTERY EXPLOSIONS

Keep sparks, lighted matches, and flame away from the top of battery. Battery gas can explode.

Never check battery charge by placing a metal object across the posts. Use a volt-meter or hydrometer.

Do not charge a frozen battery; It may explode. Warm battery to 16°C (60°F).



PREVENT ACID BURNS

Sulfuric acid in battery electrolyte is poisonous. It is strong enough to burn skin, eat holes in clothing, and cause blindness if splashed into eyes.

Avoid the hazard by:

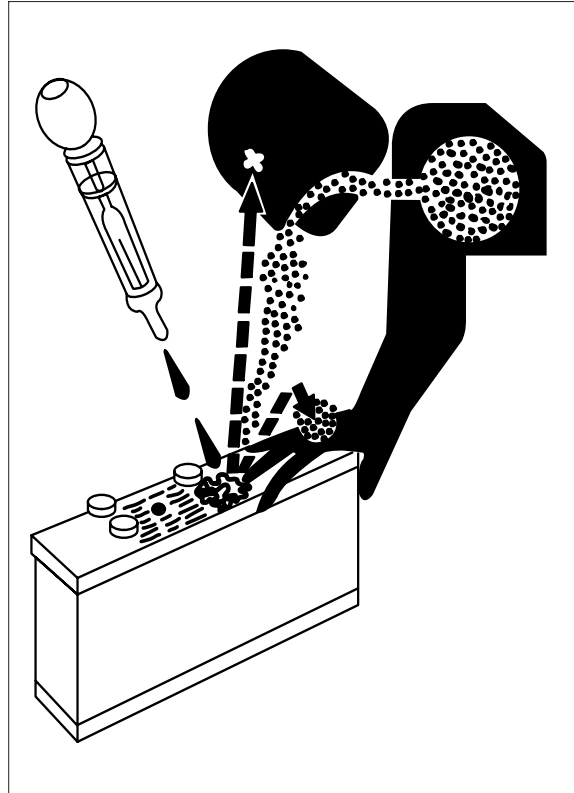
1. Filling batteries in a well-ventilated area.
2. Wearing eye protection and rubber gloves.
3. Avoiding breathing fumes when electrolyte is added.
4. Avoiding spilling or dripping electrolyte.
5. Use proper jump start procedure.

If you spill acid on yourself:

1. Flush your skin with water.
2. Apply baking soda or lime to help neutralize the acid.
3. Flush your eyes with water for 10-15 minutes. Get medical attention immediately.

If acid is swallowed:

1. Drink large amounts of water or milk.
2. Then drink milk of magnesia, beaten eggs, or vegetable oil.
3. Get medical attention immediately.



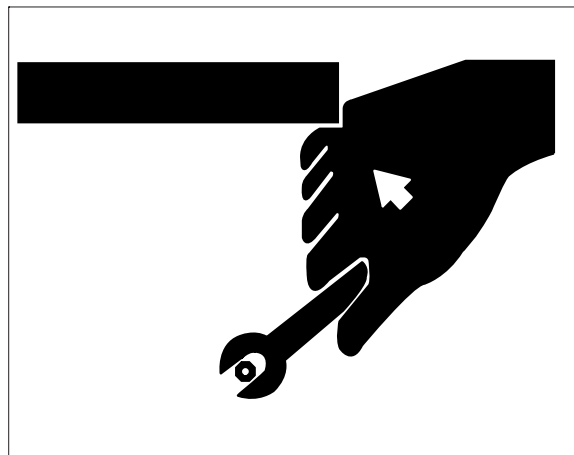
USE TOOLS PROPERLY

Use tools appropriate to the work. Makeshift tools, parts, and procedures can create safety hazards.

Use power tools only to loosen threaded tools and fasteners.

For loosening and tightening hardware, use the correct size tools. DO NOT use U.S. measurement tools on metric fasteners. Avoid bodily injury caused by slipping wrenches.

Use only recommended replacement parts. (See Parts catalogue.)

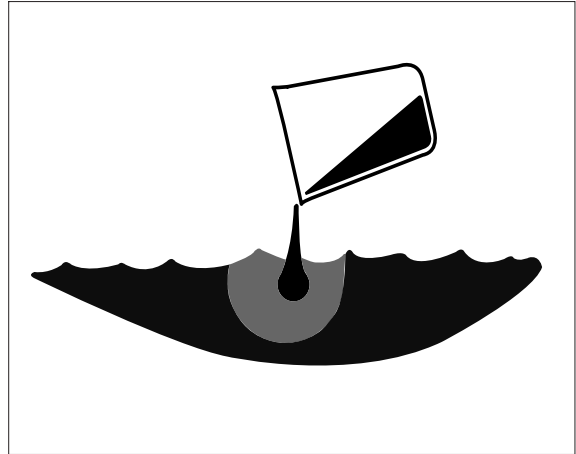


DISPOSE OF FLUIDS PROPERLY

Improperly disposing of fluids can harm the environment and ecology. Before draining any fluids, find out the proper way to dispose of waste from your local environmental agency.

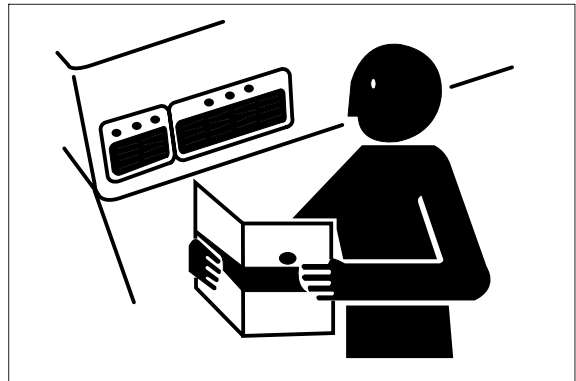
Use proper containers when draining fluids. Do not use food or beverage containers that may mislead someone into drinking from them.

DO NOT pour oil into the ground, down a drain, or into a stream, pond, or lake. Observe relevant environmental protection regulations when disposing of oil, fuel, coolant, brake fluid, filters, batteries, and other harmful waste.



REPLACE SAFETY SIGNS

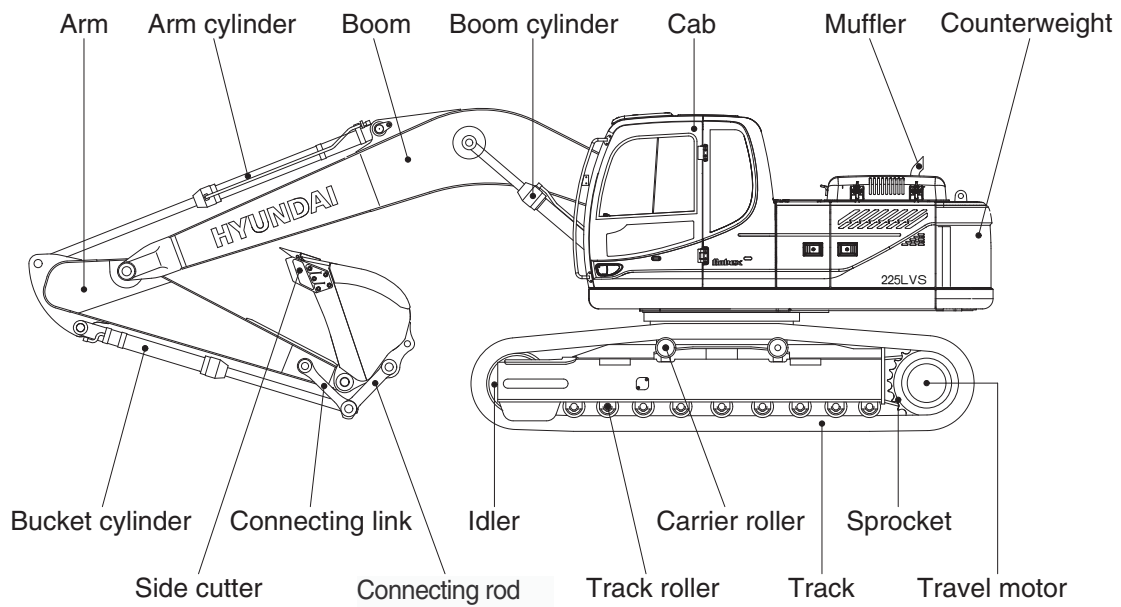
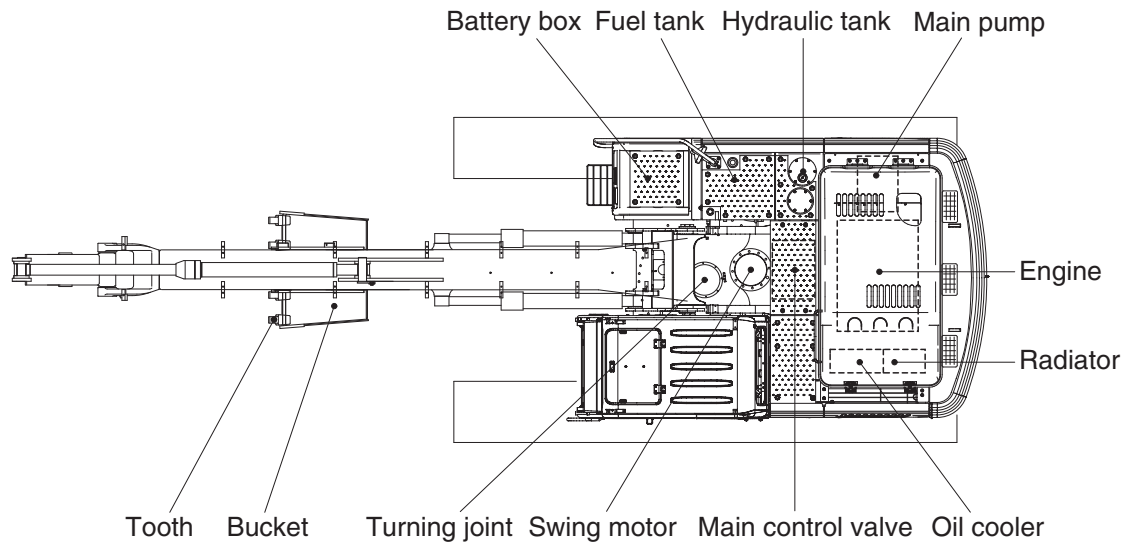
Replace missing or damaged safety signs. See the machine operator's manual for correct safety sign placement.



LIVE WITH SAFETY

Before returning machine to customer, make sure machine is functioning properly, especially the safety systems. Install all guards and shields.

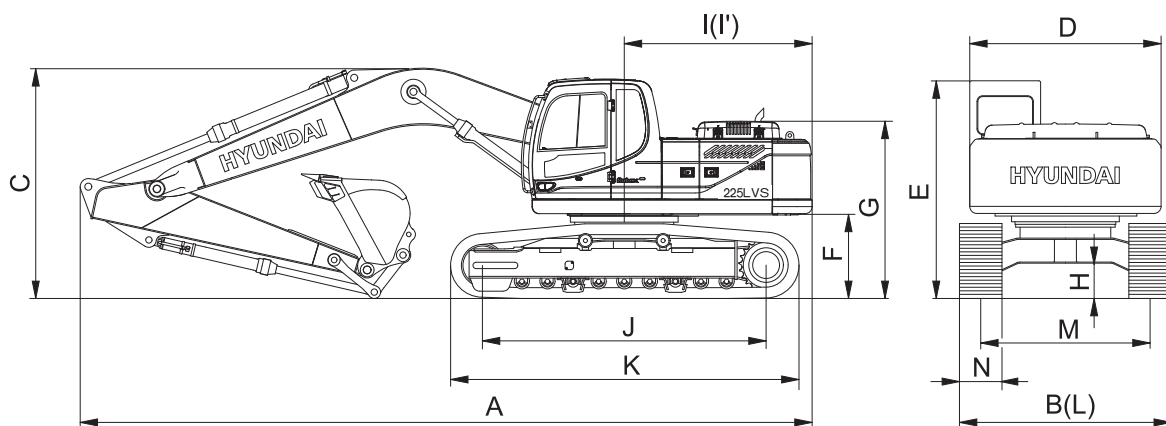
GROUP 2 SPECIFICATIONS



2. SPECIFICATIONS

1) R225LVS

· 5.68 m (18' 8") BOOM and 2.92 m (9' 7") ARM

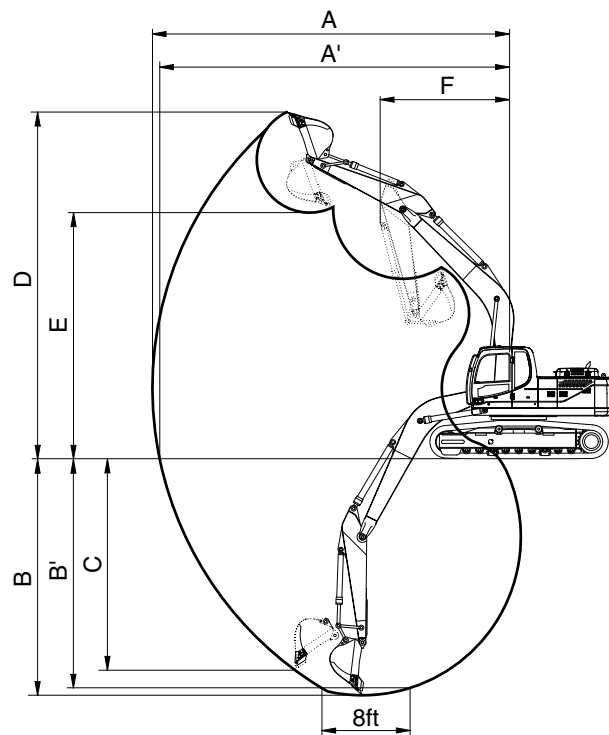


Description			Unit	Specification
Operating weight			kg (lb)	22570 (49760)
Bucket capacity (SAE heaped)		light(OPT)	m³ (yd³)	1.20 (1.57)
		narrow		1.05 (1.37)
Overall length		A	mm (ft-in)	9550 (31' 4")
Overall width	with 700 mm shoe (OPT)	B		3090 (10' 2")
	with 600 mm shoe			2990 (9' 10")
Overall height		C		3080 (10' 1")
Superstructure width		D		2740 (9' 0")
Overall height of cab		E		2920 (9' 7")
Ground clearance of counterweight		F		1060 (3' 6")
Engine cover height		G		2320 (7' 7")
Minimum ground clearance		H		480 (1' 7")
Rear-end distance		I		2770 (9' 1")
Rear-end swing radius		I'		2840 (9' 4")
Distance between tumblers		J		3650 (12' 1")
Undercarriage length		K		4440 (14' 7")
Undercarriage width		L		2990 (9' 10")
Track gauge		M		2390 (7' 10")
Track shoe width, standard		N		600 (24")
Travel speed (low/high)			km/hr (mph)	3.4/5.5 (2.1/3.4)
Swing speed			rpm	11
Gradeability			Degree (%)	35 (70)
Ground pressure	with 700 mm shoe (OPT)		kgf/cm² (psi)	0.42 (5.97)
	with 600 mm shoe			0.48 (6.83)
Max traction force			kg (lb)	20200 (44533)

3. WORKING RANGE

1) R225LVS

· 5.68 m (18' 8") BOOM



Description		※2.92m (9' 7") Arm
Max digging reach	A	9980 mm (32' 9")
Max digging reach on ground	A'	9820 mm (32' 3")
Max digging depth	B	6730 mm (22' 1")
Max digging depth (8 ft level)	B'	6560 mm (21' 6")
Max vertical wall digging depth	C	6280 mm (20' 7")
Max digging height	D	9600 mm (31' 6")
Max dumping height	E	6780 mm (22' 3")
Min swing radius	F	3740 mm (12' 3")
Bucket digging force(1.05m ³)	SAE	133.4 [145.5] kN
Arm digging force	SAE	102.0 [110.7] kN

[] : Power boost ※ : STD

4. WEIGHT

1) R225LVS

Item	R225LVS	
	kg	lb
Upperstructure assembly	9396	20715
Main frame weld assembly	1920	4230
Engine assembly	556	1226
Main pump assembly	140	310
Main control valve assembly	220	485
Swing motor assembly	240	530
Hydraulic oil tank assembly	240	530
Fuel tank assembly	195	430
Counterweight	4200	9260
Cab assembly	310	680
Lower chassis assembly	8700	19180
Track frame weld assembly	2720	6000
Swing bearing	290	640
Travel motor assembly	300	660
Turning joint	55	120
Track recoil spring	140	310
Idler	170	370
Carrier roller	20	45
Track roller	40	88
Track-chain assembly (600 mm standard triple grouser shoe)	1350	2980
Front attachment assembly (5.68 m boom, 2.92 m arm, 1.05 m³ SAE heaped bucket)	4030	8880
5.68 m boom assembly	1520	3350
2.92 m arm assembly	750	1650
1.05 m³ SAE heaped bucket	740	1630
Boom cylinder assembly	180	400
Arm cylinder assembly	290	640
Bucket cylinder assembly	175	390
Bucket control rod assembly	170	370

5. LIFTING CAPACITIES

1) R225LVS

(1) 5.68 m (18' 8") boom, 2.92 m (9' 7") arm equipped with 1.05 m³(SAE heaped) bucket and 600 mm (24") triple grouser shoe and 4200 kg (9260 lb) counterweight.

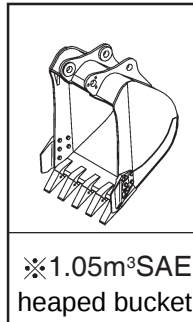
•  : Rating over-front •  : Rating over-side or 360 degree

Load point height		Load radius										At max. reach		
		1.5m(5ft)		3.0m(10ft)		4.5m(15ft)		6.0m(20ft)		7.5m(25ft)		Capacity		Reach
														m(ft)
7.5m 25.0ft	kg lb											*3240 *7140	*3240 *7140	7.73 (25.4)
6.0m 20.0ft	kg lb											*3340 *7360	2570 5670	8.69 (28.5)
4.5m 15.0ft	kg lb							*3930 *8660	*3930 *8660	*3740 *8250	3280 7230	*3470 *7650	2190 4830	9.27 (30.4)
3.0m 10.0ft	kg lb			*9670 *21320	*9670 *21320	*6050 *13340	*6050 *13340	*4740 *10450	4610 10160	*4130 *9110	3130 6900	3570 7870	2000 4410	9.55 (31.3)
1.5m 5.0ft	kg lb			*9060 *19970	*9060 *19970	*7820 *17240	6700 14770	*5640 *12430	4290 9460	*4600 *10140	2970 6550	3510 7740	1950 4300	9.54 (31.3)
Ground Line	kg lb			*9850 *21720	*9850 *21720	*9000 *19840	6290 13870	*6360 *14020	4040 8910	*5000 *11020	2840 6260	3650 8050	2020 4450	9.26 (30.4)
-1.5m -5.0ft	kg lb	*9120 *20110	*9120 *20110	*12980 *28620	12280 27070	*9430 *20790	6130 13510	*6730 *14840	3920 8640	4990 11000	2770 6110	4060 8950	2270 5000	8.68 (28.5)
-3.0m -10.0ft	kg lb	*12540 *27650	*12540 *27650	*13740 *30290	12460 27470	*9140 *20150	6150 13560	*6590 *14530	3920 8640			*4430 *9770	2830 6240	7.70 (25.3)
-4.5m -15.0ft	kg lb			*11620 *25620	*11620 *25620	*7940 *17500	6350 14000					*4340 *9570	4290 9640	6.09 (20.0)

- Note
1. Lifting capacity are based on SAE J1097 and ISO 10567.
 2. Lifting capacity of the ROBEX series does not exceed 75% of tipping load with the machine on firm, level ground or 87% of full hydraulic capacity.
 3. The load point is a hook (standard equipment) located on the back of the bucket.
 4. *indicates load limited by hydraulic capacity.

6. BUCKET SELECTION GUIDE

1) GENERAL BUCKET



Capacity		Width		Weight	Recommendation
SAE heaped	CECE heaped	Without side cutter	With side cutter		5.68m(18'8") boom
					2.92m (9'7") arm
1.05m³ (1.37yd³)	0.93m³ (1.22yd³)	1160mm (45.7")	1280mm (50.4")	875kg (1930lb)	Applicable for materials with density of 1600 kgf/m³ (2700 lbf/yd³) or less
1.20m³ (1.57yd³)	1.0m³ (1.31yd³)	1348mm (53.1")	1448mm (57.0")	906.8kg (1999lb)	

7. UNDERCARRIAGE

1) TRACKS

X-leg type center frame is integrally welded with reinforced box-section track frames. The design includes dry tracks, lubricated rollers, idlers, sprockets, hydraulic track adjusters with shock absorbing springs and assembled track-type tractor shoes with triple grousers.

2) TYPES OF SHOES

Model	Shapes		Tirper grouser	
				
R225LVS	Show width	mm(in)	600(24)	700(28)
	Oper weight	kg(lb)	22570(49760)	22920(50530)
	Ground pre	kgf/cm ² (psi)	0.48(6.83)	0.42(5.97)
	Overall width	mm(ft-in)	2990(9' 10")	3090(10' 2")

3) NUMBER OF ROLLERS AND SHOES ON EACH SIDE

Item	Quantity
	R225LVS
Carrier rollers	2 EA
Track rollers	9 EA
Track shoes	49 EA

4) SELECTION OF TRACK SHOE

Suitable track shoes should be selected according to operating conditions.

Method of selecting shoes

Confirm the category from the list of applications in table 2, then use table 1 to select the shoe. Wide shoes(Categories B and C) have limitations on applications. Before using wide shoes, check the precautions, then investigate and study the operating conditions to confirm if these shoes are suitable.

Select the narrowest shoe possible to meet the required flotation and ground pressure. Application of wider shoes than recommendations will cause unexpected problem such as bending of shoes, crack of link, breakage of pin, loosening of shoe bolts and the other various problems.

※ Table 1

Track shoe	Specification	Category
600mm triple grouser	Standard	A
700mm triple grouser	Option	B

※ Table 2

Category	Applications	Precautions
A	Rocky ground, river beds, normal soil	• Travel at low speed on rough ground with large obstacles such as boulders or fallen trees
B	Normal soil, soft ground	• These shoes cannot be used on rough ground with large obstacles such as boulders or fallen trees • Travel at high speed only on flat ground • Travel slowly at low speed if it is impossible to avoid going over obstacles
C	Extremely, soft ground (Swampy ground)	• Use the shoes only in the conditions that the machine sinks and it is impossible to use the shoes of category A or B • These shoes cannot be used on rough ground with large obstacles such as boulders or fallen trees • Travel at high speed only on flat ground • Travel slowly at low speed if it is impossible to avoid going over obstacles

8. SPECIFICATIONS FOR MAJOR COMPONENTS

1) ENGINE

Item	Specification
Model	GCIC QSB7 CM2880 B117
Type	4-cycle turbocharged, charger air cooled diesel engine
Cooling method	Water cooling
Number of cylinders and arrangement	6 cylinders, in-line
Firing order	1-5-3-6-2-4
Combustion chamber type	Direct injection type
Cylinder bore × stroke	107 × 124 mm (4.2" × 4.9")
Piston displacement	6700 cc (409 cu in)
Compression ratio	17.2 : 1
Rated gross horse power (SAE J1995)	167 Hp at 1900 rpm (125kW at 1900 rpm)
Maximum torque	67kgf · m at 1500 rpm
Engine oil quantity	24 l (6.3 U.S. gal)
Dry weight	556 kg (1225 lb)
High idling speed	1950+50 rpm
Low idling speed	900±100 rpm
Rated fuel consumption	151.4 g/Hp · hr at 1900 rpm
Starting motor	Remy (24V-7.5 kW)
Alternator	Delco Remy 24V-90A
Battery	2 × 12V × 120 Ah

2) MAIN PUMP

Item	Specification
Type	Variable displacement tandem axis piston pumps
Capacity	2 × 117 cc/rev
Maximum pressure	350 kgf/cm ² (4980 psi) [380 kgf/cm ² (5400 psi)]
Rated oil flow	2 × 222 l /min (58.7 U.S. gpm/ 48.8 U.K. gpm)
Rated speed	1900 rpm

[] : Power boost

3) GEAR PUMP

Item	Specification
Type	Fixed displacement gear pump single stage
Capacity	15 cc/rev
Maximum pressure	40 kgf/cm ² (570 psi)
Rated oil flow	28.5 l /min (7.45 U.S. gpm / 6.27 U.K. gpm)

4) MAIN CONTROL VALVE

Item	Specification
Type	9 spools
Operating method	Hydraulic pilot system
Main relief valve pressure	350 kgf/cm ² (4980 psi) [380 kgf/cm ² (5400 psi)]
Overload relief valve pressure	400 kgf/cm ² (5690 psi)

[] : Power boost

5) SWING MOTOR

Item	Specification
Type	Axial piston motor
Capacity	142.8 cc/rev
Relief pressure	265 kgf/cm ² (3770 psi)
Braking system	Automatic, spring applied hydraulic released
Braking torque	1083kgf · m (7838 lbf · ft)
Brake release pressure	21.3~35.7 kgf/cm ² (303~508 psi)
Reduction gear type	2 - stage planetary

6) TRAVEL MOTOR

Item	Specification
Type	Axial piston motor
Relief pressure	350 kgf/cm ² (4980 psi)
Capacity (max / min)	171.2/108.5 cc/rev
Reduction gear type	Planetary differential
Braking system	Automatic, spring applied hydraulic released
Brake release pressure	15.2 kgf/cm ² (216 psi)
Braking torque	2878 kgf · m (20829lbf · ft)

7) REMOTE CONTROL VALVE

Item		Specification
Type		Pressure reducing type
Operating pressure	Minimum	6.5 kgf/cm ² (92 psi)
	Maximum	25 kgf/cm ² (356 psi)
Single operation stroke	Lever	61 mm (2.4")
	Pedal	123 mm (4.8")

8) CYLINDER

Item		Specification
Boom cylinder	Bore dia × Rod dia × Stroke	ø 120 × ø 85 × 1290 mm
	Cushion	Extend only
Arm cylinder	Bore dia × Rod dia × Stroke	ø 140 × ø 100 × 1510 mm
	Cushion	Extend and retract
Bucket cylinder	Bore dia × Rod dia × Stroke	ø 120 × ø 80 × 1055 mm
	Cushion	Extend only

※ Discoloration of cylinder rod can occur when the friction reduction additive of lubrication oil spreads on the rod surface.

※ Discoloration does not cause any harmful effect on the cylinder performance.

9) SHOE

Item		Width	Ground pressure	Link quantity	Overall width
R225LVS	Standard	600 mm (24")	0.48 kgf/cm ² (6.83 psi)	49	2990 mm (9' 10")
	Option	700 mm (28")	0.42 kgf/cm ² (5.97 psi)	49	3090 mm (10' 2")

10) BUCKET

Item		Capacity		Tooth quantity	Width	
		SAE heaped	CECE heaped		Without side cutter	With side cutter
R225LVS	Standard	1.05m ³ (1.37yd ³)	0.93m ³ (1.22yd ³)	5	1160mm(45.7")	1280mm(50.4")
	Option	1.20m ³ (1.57yd ³)	1.0m ³ (1.31yd ³)	5	1348mm(53.1")	1448mm(57.0")

9. RECOMMENDED OILS

Use only oils listed below. Do not mix different brand oil.

Please use HYUNDAI genuine oil and grease.

Service point	Kind of fluid	Capacity ℓ (U.S. gal)	Ambient temperature °C (°F)								
			-50 (-58)	-30 (-22)	-20 (-4)	-10 (14)	0 (32)	10 (50)	20 (68)	30 (86)	40 (104)
Engine oil pan	Engine oil	24 (6.3)	SAE 5W-40								
								SAE 30			
				SAE 10W							
				SAE 10W-30							
				SAE 15W-40							
Swing drive	Gear oil	6.2 (1.6)			SAE 80W-90						
Final drive		4.5×2 (1.2×2)			SAE 85W-140						
Hydraulic tank	Hydraulic oil	Tank; 160 (42)	ISO VG 15								
				ISO VG 32							
		System; 275 (73)			ISO VG 46						
						ISO VG 68					
Fuel tank	Diesel fuel	400 (106)	ASTM D975 NO.1								
							ASTM D975 NO.2				
Fitting (grease nipple)	Grease	As required	NLGI NO.1								
					NLGI NO.2						
Radiator (reservoir tank)	Mixture of antifreeze and soft water★ ¹	35 (9.2)		Ethylene glycol base permanent type (50 : 50)							

SAE : Society of Automotive Engineers

API : American Petroleum Institute

ISO : International Organization for Standardization

NLGI : National Lubricating Grease Institute

ASTM : American Society of Testing and Material