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1. STRUCTURE

This service manual has been prepared as an aid to improve the quality of repairs by giving the serviceman an accurate understanding of the product and by showing him the correct way to perform repairs and make judgements. Make sure you understand the contents of this manual and use it to full effect at every opportunity.

This service manual mainly contains the necessary technical information for operations performed in a service workshop.

For ease of understanding, the manual is divided into the following sections.

SECTION 1 GENERAL

This section explains the safety hints and gives the specification of the machine and major components.

SECTION 2 STRUCTURE AND FUNCTION

This section explains the structure and function of each component. It serves not only to give an understanding of the structure, but also serves as reference material for troubleshooting.

SECTION 3 HYDRAULIC SYSTEM

This section explains the hydraulic circuit, single and combined operation.

SECTION 4 ELECTRICAL SYSTEM

This section explains the electrical circuit, monitoring system and each component. It serves not only to give an understanding electrical system, but also serves as reference material for trouble shooting.

SECTION 5 MECHATRONICS SYSTEM

This section explains the computer aided power optimization system and each component.

SECTION 6 TROUBLESHOOTING

This section explains the troubleshooting charts correlating **problems** to **causes**.

SECTION 7 MAINTENANCE STANDARD

This section gives the judgement standards when inspecting disassembled parts.

SECTION 8 DISASSEMBLY AND ASSEMBLY

This section explains the order to be followed when removing, installing, disassembling or assembling each component, as well as precautions to be taken for these operations.

SECTION 9 COMPONENT MOUNTING TORQUE

This section shows bolt specifications and standard torque values needed when mounting components to the machine.

The specifications contained in this shop manual are subject to change at any time and without any advance notice. Contact your HYUNDAI distributor for the latest information.

2. HOW TO READ THE SERVICE MANUAL

Distribution and updating

Any additions, amendments or other changes will be sent to HYUNDAI distributors.

Get the most up-to-date information before you start any work.

Filing method

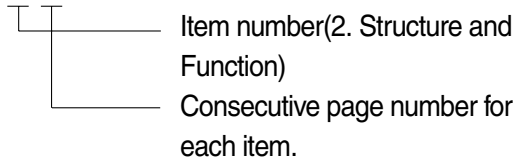
1. See the page number on the bottom of the page.

File the pages in correct order.

2. Following examples shows how to read the page number.

Example 1

2 - 3



3. Additional pages : Additional pages are indicated by a hyphen(-) and number after the page number. File as in the example.

10 - 4

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Added pages

Revised edition mark(①②③...)

When a manual is revised, an edition mark is recorded on the bottom outside corner of the pages.

Revisions

Revised pages are shown at the **list of revised pages** on the between the contents page and section 1 page.

Symbols

So that the shop manual can be of ample practical use, important places for safety and quality are marked with the following symbols.

| Symbol | Item | Remarks |
|--------|---------|---|
| | Safety | Special safety precautions are necessary when performing the work. |
| | | Extra special safety precautions are necessary when performing the work because it is under internal pressure. |
| | Caution | Special technical precautions or other precautions for preserving standards are necessary when performing the work. |

3. CONVERSION TABLE

Method of using the Conversion Table

The Conversion Table in this section is provided to enable simple conversion of figures. For details of the method of using the Conversion Table, see the example given below.

Example

1. Method of using the Conversion Table to convert from millimeters to inches

Convert 55mm into inches.

- (1) Locate the number 50 in the vertical column at the left side, take this as ①, then draw a horizontal line from ①.
- (2) Locate the number 5 in the row across the top, take this as ②, then draw a perpendicular line down from ②.
- (3) Take the point where the two lines cross as ③. This point ③ gives the value when converting from millimeters to inches. Therefore, 55mm = 2.165 inches.

2. Convert 550mm into inches.

- (1) The number 550 does not appear in the table, so divide by 10 (Move the decimal point one place to the left) to convert it to 55mm.
- (2) Carry out the same procedure as above to convert 55mm to 2.165 inches.
- (3) The original value (550mm) was divided by 10, so multiply 2.165 inches by 10 (Move the decimal point one place to the right) to return to the original value.
This gives 550mm = 21.65 inches.

Millimeters to inches

②

1mm = 0.03937 in

| | 0 | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 |
|------|-------|-------|-------|-------|-------|---------|-------|-------|-------|-------|
| 0 | | 0.039 | 0.079 | 0.118 | 0.157 | 0.197 | 0.236 | 0.276 | 0.315 | 0.354 |
| 10 | 0.394 | 0.433 | 0.472 | 0.512 | 0.551 | 0.591 | 0.630 | 0.669 | 0.709 | 0.748 |
| 20 | 0.787 | 0.827 | 0.866 | 0.906 | 0.945 | 0.984 | 1.024 | 1.063 | 1.102 | 1.142 |
| 30 | 1.181 | 1.220 | 1.260 | 1.299 | 1.339 | 1.378 | 1.417 | 1.457 | 1.496 | 1.536 |
| 40 | 1.575 | 1.614 | 1.654 | 1.693 | 1.732 | 1.772 | 1.811 | 1.850 | 1.890 | 1.929 |
| ① 50 | 1.969 | 2.008 | 2.047 | 2.087 | 2.126 | ③ 2.165 | 2.205 | 2.244 | 2.283 | 2.323 |
| 60 | 2.362 | 2.402 | 2.441 | 2.480 | 2.520 | 2.559 | 2.598 | 2.638 | 2.677 | 2.717 |
| 70 | 2.756 | 2.795 | 2.835 | 2.874 | 2.913 | 2.953 | 2.992 | 3.032 | 3.071 | 3.110 |
| 80 | 3.150 | 3.189 | 3.228 | 3.268 | 3.307 | 3.346 | 3.386 | 3.425 | 3.465 | 3.504 |
| 90 | 3.543 | 3.583 | 3.622 | 3.661 | 3.701 | 3.740 | 3.780 | 3.819 | 3.858 | 3.898 |

Millimeters to inches

1mm = 0.03937in

| | 0 | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 |
|----|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| 0 | | 0.039 | 0.079 | 0.118 | 0.157 | 0.197 | 0.236 | 0.276 | 0.315 | 0.354 |
| 10 | 0.394 | 0.433 | 0.472 | 0.512 | 0.551 | 0.591 | 0.630 | 0.669 | 0.709 | 0.748 |
| 20 | 0.787 | 0.827 | 0.866 | 0.906 | 0.945 | 0.984 | 1.024 | 1.063 | 1.102 | 1.142 |
| 30 | 1.181 | 1.220 | 1.260 | 1.299 | 1.339 | 1.378 | 1.417 | 1.457 | 1.496 | 1.536 |
| 40 | 1.575 | 1.614 | 1.654 | 1.693 | 1.732 | 1.772 | 1.811 | 1.850 | 1.890 | 1.929 |
| 50 | 1.969 | 2.008 | 2.047 | 2.087 | 2.126 | 2.165 | 2.205 | 2.244 | 2.283 | 2.323 |
| 60 | 2.362 | 2.402 | 2.441 | 2.480 | 2.520 | 2.559 | 2.598 | 2.638 | 2.677 | 2.717 |
| 70 | 2.756 | 2.795 | 2.835 | 2.874 | 2.913 | 2.953 | 2.992 | 3.032 | 3.071 | 3.110 |
| 80 | 3.150 | 3.189 | 3.228 | 3.268 | 3.307 | 3.346 | 3.386 | 3.425 | 3.465 | 3.504 |
| 90 | 3.543 | 3.583 | 3.622 | 3.661 | 3.701 | 3.740 | 3.780 | 3.819 | 3.858 | 3.898 |

Kilogram to Pound

1kg = 2.2046lb

| | 0 | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 |
|----|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|
| 0 | | 2.20 | 4.41 | 6.61 | 8.82 | 11.02 | 13.23 | 15.43 | 17.64 | 19.84 |
| 10 | 22.05 | 24.25 | 26.46 | 28.66 | 30.86 | 33.07 | 35.27 | 37.48 | 39.68 | 41.89 |
| 20 | 44.09 | 46.30 | 48.50 | 50.71 | 51.91 | 55.12 | 57.32 | 59.5 | 61.73 | 63.93 |
| 30 | 66.14 | 68.34 | 70.55 | 72.75 | 74.96 | 77.16 | 79.37 | 81.57 | 83.78 | 85.98 |
| 40 | 88.18 | 90.39 | 92.59 | 94.80 | 97.00 | 99.21 | 101.41 | 103.62 | 105.82 | 108.03 |
| 50 | 110.23 | 112.44 | 114.64 | 116.85 | 119.05 | 121.25 | 123.46 | 125.66 | 127.87 | 130.07 |
| 60 | 132.28 | 134.48 | 136.69 | 138.89 | 141.10 | 143.30 | 145.51 | 147.71 | 149.91 | 152.12 |
| 70 | 154.32 | 156.53 | 158.73 | 160.94 | 163.14 | 165.35 | 167.55 | 169.76 | 171.96 | 174.17 |
| 80 | 176.37 | 178.57 | 180.78 | 182.98 | 185.19 | 187.39 | 189.60 | 191.80 | 194.01 | 196.21 |
| 90 | 198.42 | 200.62 | 202.83 | 205.03 | 207.24 | 209.44 | 211.64 | 213.85 | 216.05 | 218.26 |

Liter to U.S. Gallon

1 l = 0.2642 U.S.Gal

| | 0 | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 |
|----|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|
| 0 | | 0.264 | 0.528 | 0.793 | 1.057 | 1.321 | 1.585 | 1.849 | 2.113 | 2.378 |
| 10 | 2.642 | 2.906 | 3.170 | 3.434 | 3.698 | 3.963 | 4.227 | 4.491 | 4.755 | 5.019 |
| 20 | 5.283 | 5.548 | 5.812 | 6.076 | 6.340 | 6.604 | 6.869 | 7.133 | 7.397 | 7.661 |
| 30 | 7.925 | 8.189 | 8.454 | 8.718 | 8.982 | 9.246 | 9.510 | 9.774 | 10.039 | 10.303 |
| 40 | 10.567 | 10.831 | 11.095 | 11.359 | 11.624 | 11.888 | 12.152 | 12.416 | 12.680 | 12.944 |
| 50 | 13.209 | 13.473 | 13.737 | 14.001 | 14.265 | 14.529 | 14.795 | 15.058 | 15.322 | 15.586 |
| 60 | 15.850 | 16.115 | 16.379 | 16.643 | 16.907 | 17.171 | 17.435 | 17.700 | 17.964 | 18.228 |
| 70 | 18.492 | 18.756 | 19.020 | 19.285 | 19.549 | 19.813 | 20.077 | 20.341 | 20.605 | 20.870 |
| 80 | 21.134 | 21.398 | 21.662 | 21.926 | 22.190 | 22.455 | 22.719 | 22.983 | 23.247 | 23.511 |
| 90 | 23.775 | 24.040 | 24.304 | 24.568 | 24.832 | 25.096 | 25.631 | 25.625 | 25.889 | 26.153 |

Liter to U.K. Gallon

1 l = 0.21997 U.K.Gal

| | 0 | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 |
|----|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|
| 0 | | 0.220 | 0.440 | 0.660 | 0.880 | 1.100 | 1.320 | 1.540 | 1.760 | 1.980 |
| 10 | 2.200 | 2.420 | 2.640 | 2.860 | 3.080 | 3.300 | 3.520 | 3.740 | 3.950 | 4.179 |
| 20 | 4.399 | 4.619 | 4.839 | 5.059 | 5.279 | 5.499 | 5.719 | 5.939 | 6.159 | 6.379 |
| 30 | 6.599 | 6.819 | 7.039 | 7.259 | 7.479 | 7.699 | 7.919 | 8.139 | 8.359 | 8.579 |
| 40 | 8.799 | 9.019 | 9.239 | 9.459 | 9.679 | 9.899 | 10.119 | 10.339 | 10.559 | 10.778 |
| 50 | 10.998 | 11.281 | 11.438 | 11.658 | 11.878 | 12.098 | 12.318 | 12.528 | 12.758 | 12.978 |
| 60 | 13.198 | 13.418 | 13.638 | 13.858 | 14.078 | 14.298 | 14.518 | 14.738 | 14.958 | 15.178 |
| 70 | 15.398 | 15.618 | 15.838 | 16.058 | 16.278 | 16.498 | 16.718 | 16.938 | 17.158 | 17.378 |
| 80 | 17.598 | 17.818 | 18.037 | 18.257 | 18.477 | 18.697 | 18.917 | 19.137 | 19.357 | 19.577 |
| 90 | 19.797 | 20.017 | 20.237 | 20.457 | 20.677 | 20.897 | 21.117 | 21.337 | 21.557 | 21.777 |

kgf · m to lbf · ft

1 kgf · m = 7.233 lbf · ft

| | 0 | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 |
|-----|--------|--------|--------|--------|--------|--------|--------|--------|--------|---------|
| | | 7.2 | 14.5 | 21.7 | 28.9 | 36.2 | 43.4 | 50.6 | 57.9 | 65.1 |
| 10 | 72.3 | 79.6 | 86.8 | 94.0 | 101.3 | 108.5 | 115.7 | 123.0 | 130.2 | 137.4 |
| 20 | 144.7 | 151.9 | 159.1 | 166.4 | 173.6 | 180.8 | 188.1 | 195.3 | 202.5 | 209.8 |
| 30 | 217.0 | 224.2 | 231.5 | 238.7 | 245.9 | 253.2 | 260.4 | 267.6 | 274.9 | 282.1 |
| 40 | 289.3 | 296.6 | 303.8 | 311.0 | 318.3 | 325.5 | 332.7 | 340.0 | 347.2 | 354.4 |
| 50 | 361.7 | 368.9 | 376.1 | 383.4 | 390.6 | 397.8 | 405.1 | 412.3 | 419.5 | 426.8 |
| 60 | 434.0 | 441.2 | 448.5 | 455.7 | 462.9 | 470.2 | 477.4 | 484.6 | 491.8 | 499.1 |
| 70 | 506.3 | 513.5 | 520.8 | 528.0 | 535.2 | 542.5 | 549.7 | 556.9 | 564.2 | 571.4 |
| 80 | 578.6 | 585.9 | 593.1 | 600.3 | 607.6 | 614.8 | 622.0 | 629.3 | 636.5 | 643.7 |
| 90 | 651.0 | 658.2 | 665.4 | 672.7 | 679.9 | 687.1 | 694.4 | 701.6 | 708.8 | 716.1 |
| 100 | 723.3 | 730.5 | 737.8 | 745.0 | 752.2 | 759.5 | 766.7 | 773.9 | 781.2 | 788.4 |
| 110 | 795.6 | 802.9 | 810.1 | 817.3 | 824.6 | 831.8 | 839.0 | 846.3 | 853.5 | 860.7 |
| 120 | 868.0 | 875.2 | 882.4 | 889.7 | 896.9 | 904.1 | 911.4 | 918.6 | 925.8 | 933.1 |
| 130 | 940.3 | 947.5 | 954.8 | 962.0 | 969.2 | 976.5 | 983.7 | 990.9 | 998.2 | 10005.4 |
| 140 | 1012.6 | 1019.9 | 1027.1 | 1034.3 | 1041.5 | 1048.8 | 1056.0 | 1063.2 | 1070.5 | 1077.7 |
| 150 | 1084.9 | 1092.2 | 1099.4 | 1106.6 | 1113.9 | 1121.1 | 1128.3 | 1135.6 | 1142.8 | 1150.0 |
| 160 | 1157.3 | 1164.5 | 1171.7 | 1179.0 | 1186.2 | 1193.4 | 1200.7 | 1207.9 | 1215.1 | 1222.4 |
| 170 | 1129.6 | 1236.8 | 1244.1 | 1251.3 | 1258.5 | 1265.8 | 1273.0 | 1280.1 | 1287.5 | 1294.7 |
| 180 | 1301.9 | 1309.2 | 1316.4 | 1323.6 | 1330.9 | 1338.1 | 1345.3 | 1352.6 | 1359.8 | 1367.0 |
| 190 | 1374.3 | 1381.5 | 1388.7 | 1396.0 | 1403.2 | 1410.4 | 1417.7 | 1424.9 | 1432.1 | 1439.4 |

kgf/cm² to lbf/in²1 kgf / cm² = 14.2233 lbf / in²

| | 0 | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 |
|-----|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| | | 14.2 | 28.4 | 42.7 | 56.9 | 71.1 | 85.3 | 99.6 | 113.8 | 128.0 |
| 10 | 142.2 | 156.5 | 170.7 | 184.9 | 199.1 | 213.4 | 227.6 | 241.8 | 256.0 | 270.2 |
| 20 | 284.5 | 298.7 | 312.9 | 327.1 | 341.4 | 355.6 | 369.8 | 384.0 | 398.3 | 412.5 |
| 30 | 426.7 | 440.9 | 455.1 | 469.4 | 483.6 | 497.8 | 512.0 | 526.3 | 540.5 | 554.7 |
| 40 | 568.9 | 583.2 | 597.4 | 611.6 | 625.8 | 640.1 | 654.3 | 668.5 | 682.7 | 696.9 |
| 50 | 711.2 | 725.4 | 739.6 | 753.8 | 768.1 | 782.3 | 796.5 | 810.7 | 825.0 | 839.2 |
| 60 | 853.4 | 867.6 | 881.8 | 896.1 | 910.3 | 924.5 | 938.7 | 953.0 | 967.2 | 981.4 |
| 70 | 995.6 | 1010 | 1024 | 1038 | 1053 | 1067 | 1081 | 1095 | 1109 | 1124 |
| 80 | 1138 | 1152 | 1166 | 1181 | 1195 | 1209 | 1223 | 1237 | 1252 | 1266 |
| 90 | 1280 | 1294 | 1309 | 1323 | 1337 | 1351 | 1365 | 1380 | 1394 | 1408 |
| 100 | 1422 | 1437 | 1451 | 1465 | 1479 | 1493 | 1508 | 1522 | 1536 | 1550 |
| 110 | 1565 | 1579 | 1593 | 1607 | 1621 | 1636 | 1650 | 1664 | 1678 | 1693 |
| 120 | 1707 | 1721 | 1735 | 1749 | 1764 | 1778 | 1792 | 1806 | 1821 | 1835 |
| 130 | 1849 | 2863 | 1877 | 1892 | 1906 | 1920 | 1934 | 1949 | 1963 | 1977 |
| 140 | 1991 | 2005 | 2020 | 2034 | 2048 | 2062 | 2077 | 2091 | 2105 | 2119 |
| 150 | 2134 | 2148 | 2162 | 2176 | 2190 | 2205 | 2219 | 2233 | 2247 | 2262 |
| 160 | 2276 | 2290 | 2304 | 2318 | 2333 | 2347 | 2361 | 2375 | 2389 | 2404 |
| 170 | 2418 | 2432 | 2446 | 2460 | 2475 | 2489 | 2503 | 2518 | 2532 | 2546 |
| 180 | 2560 | 2574 | 2589 | 5603 | 2617 | 2631 | 2646 | 2660 | 2674 | 2688 |
| 200 | 2845 | 2859 | 2873 | 2887 | 2901 | 2916 | 2930 | 2944 | 2958 | 2973 |
| 210 | 2987 | 3001 | 3015 | 3030 | 3044 | 3058 | 3072 | 3086 | 3101 | 3115 |
| 220 | 3129 | 3143 | 3158 | 3172 | 3186 | 3200 | 3214 | 3229 | 3243 | 3257 |
| 230 | 3271 | 3286 | 3300 | 3314 | 3328 | 3343 | 3357 | 3371 | 3385 | 3399 |
| 240 | 3414 | 3428 | 3442 | 3456 | 3470 | 3485 | 3499 | 3513 | 3527 | 3542 |

TEMPERATURE

Fahrenheit-Centigrade Conversion.

A simple way to convert a fahrenheit temperature reading into a centigrade temperature reading or vice verse is to enter the accompanying table in the center or boldface column of figures.

These figures refer to the temperature in either Fahrenheit or Centigrade degrees.

If it is desired to convert from Fahrenheit to Centigrade degrees, consider the center column as a table of Fahrenheit temperatures and read the corresponding Centigrade temperature in the column at the left.

If it is desired to convert from Centigrade to Fahrenheit degrees, consider the center column as a table of Centigrade values, and read the corresponding Fahrenheit temperature on the right.

| °C | | °F | °C | | °F | °C | | °F | °C | | °F |
|-------|-----|-------|-------|----|-------|------|----|-------|------|-----|-------|
| -40.4 | -40 | -40.0 | -11.7 | 11 | 51.8 | 7.8 | 46 | 114.8 | 27.2 | 81 | 117.8 |
| -37.2 | -35 | -31.0 | -11.1 | 12 | 53.6 | 8.3 | 47 | 116.6 | 27.8 | 82 | 179.6 |
| -34.4 | -30 | -22.0 | -10.6 | 13 | 55.4 | 8.9 | 48 | 118.4 | 28.3 | 83 | 181.4 |
| -31.7 | -25 | -13.0 | -10.0 | 14 | 57.2 | 9.4 | 49 | 120.2 | 28.9 | 84 | 183.2 |
| -28.9 | -20 | -4.0 | -9.4 | 15 | 59.0 | 10.0 | 50 | 122.0 | 29.4 | 85 | 185.0 |
| | | | | | | | | | | | |
| -28.3 | -19 | -2.2 | -8.9 | 16 | 60.8 | 10.6 | 51 | 123.8 | 30.0 | 86 | 186.8 |
| -27.8 | -18 | -0.4 | -8.3 | 17 | 62.6 | 11.1 | 52 | 125.6 | 30.6 | 87 | 188.6 |
| -27.2 | -17 | 1.4 | -7.8 | 18 | 64.4 | 11.7 | 53 | 127.4 | 31.1 | 88 | 190.4 |
| -26.7 | -16 | 3.2 | -6.7 | 20 | 68.0 | 12.8 | 55 | 131.0 | 32.2 | 90 | 194.0 |
| -26.1 | -15 | 5.0 | -6.7 | 20 | 68.0 | 12.8 | 55 | 131.0 | 32.2 | 90 | 194.0 |
| | | | | | | | | | | | |
| -25.6 | -14 | 6.8 | -6.1 | 21 | 69.8 | 13.3 | 56 | 132.8 | 32.8 | 91 | 195.8 |
| -25.0 | -13 | 8.6 | -5.6 | 22 | 71.6 | 13.9 | 57 | 134.6 | 33.3 | 92 | 197.6 |
| -24.4 | -12 | 10.4 | -5.0 | 23 | 73.4 | 14.4 | 58 | 136.4 | 33.9 | 93 | 199.4 |
| -23.9 | -11 | 12.2 | -4.4 | 24 | 75.2 | 15.0 | 59 | 138.2 | 34.4 | 94 | 201.2 |
| -23.3 | -10 | 14.0 | -3.9 | 25 | 77.0 | 15.6 | 60 | 140.0 | 35.0 | 95 | 203.0 |
| | | | | | | | | | | | |
| -22.8 | -9 | 15.8 | -3.3 | 26 | 78.8 | 16.1 | 61 | 141.8 | 35.6 | 96 | 204.8 |
| -22.2 | -8 | 17.6 | -2.8 | 27 | 80.6 | 16.7 | 62 | 143.6 | 36.1 | 97 | 206.6 |
| -21.7 | -7 | 19.4 | -2.2 | 28 | 82.4 | 17.2 | 63 | 145.4 | 36.7 | 98 | 208.4 |
| -21.1 | -6 | 21.2 | -1.7 | 29 | 84.2 | 17.8 | 64 | 147.2 | 37.2 | 99 | 210.2 |
| -20.6 | -5 | 23.0 | -1.1 | 35 | 95.0 | 21.1 | 70 | 158.0 | 51.7 | 125 | 257.0 |
| | | | | | | | | | | | |
| -20.0 | -4 | 24.8 | -0.6 | 31 | 87.8 | 18.9 | 66 | 150.8 | 40.6 | 105 | 221.0 |
| -19.4 | -3 | 26.6 | 0 | 32 | 89.6 | 19.4 | 67 | 152.6 | 43.3 | 110 | 230.0 |
| -18.9 | -2 | 28.4 | 0.6 | 33 | 91.4 | 20.0 | 68 | 154.4 | 46.1 | 115 | 239.0 |
| -18.3 | -1 | 30.2 | 1.1 | 34 | 93.2 | 20.6 | 69 | 156.2 | 48.9 | 120 | 248.0 |
| -17.8 | 0 | 32.0 | 1.7 | 35 | 95.0 | 21.1 | 70 | 158.0 | 51.7 | 125 | 257.0 |
| | | | | | | | | | | | |
| -17.2 | 1 | 33.8 | 2.2 | 36 | 96.8 | 21.7 | 71 | 159.8 | 54.4 | 130 | 266.0 |
| -16.7 | 2 | 35.6 | 2.8 | 37 | 98.6 | 22.2 | 72 | 161.6 | 57.2 | 135 | 275.0 |
| -16.1 | 3 | 37.4 | 3.3 | 38 | 100.4 | 22.8 | 73 | 163.4 | 60.0 | 140 | 284.0 |
| -15.6 | 4 | 39.2 | 3.9 | 39 | 102.2 | 23.3 | 74 | 165.2 | 62.7 | 145 | 293.0 |
| -15.0 | 5 | 41.0 | 4.4 | 40 | 104.0 | 23.9 | 75 | 167.0 | 65.6 | 150 | 302.0 |
| | | | | | | | | | | | |
| -14.4 | 6 | 42.8 | 5.0 | 41 | 105.8 | 24.4 | 76 | 168.8 | 68.3 | 155 | 311.0 |
| -13.9 | 7 | 44.6 | 5.6 | 42 | 107.6 | 25.0 | 77 | 170.6 | 71.1 | 160 | 320.0 |
| -13.3 | 8 | 46.4 | 6.1 | 43 | 109.4 | 25.6 | 78 | 172.4 | 73.9 | 165 | 329.0 |
| -12.8 | 9 | 48.2 | 6.7 | 44 | 111.2 | 26.1 | 79 | 174.2 | 76.7 | 170 | 338.0 |
| -12.2 | 10 | 50.0 | 7.2 | 45 | 113.0 | 26.7 | 80 | 176.0 | 79.4 | 172 | 347.0 |

SECTION 1 GENERAL

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

SECTION 1 GENERAL

GROUP 1 SAFETY

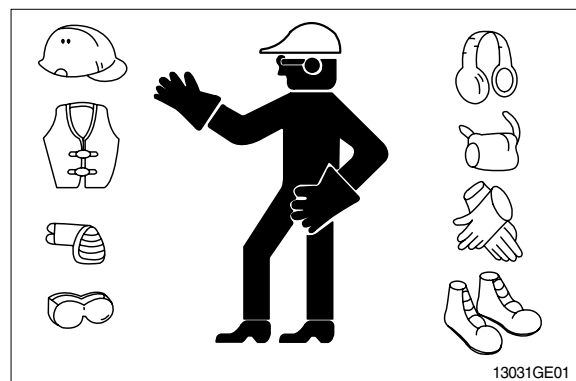
FOLLOW SAFE PROCEDURE

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



WEAR PROTECTIVE CLOTHING

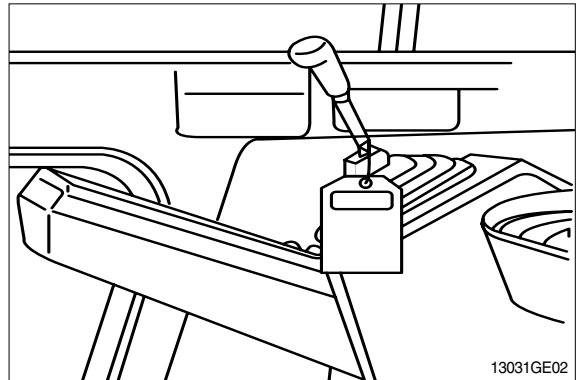
Wear close fitting clothing and safety equipment appropriate to the job.



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.



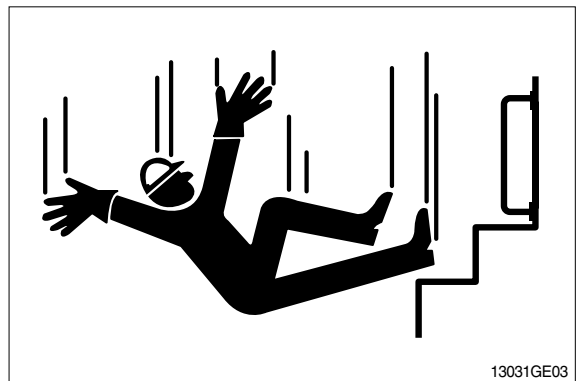
USE HANDHOLDS AND STEPS

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.

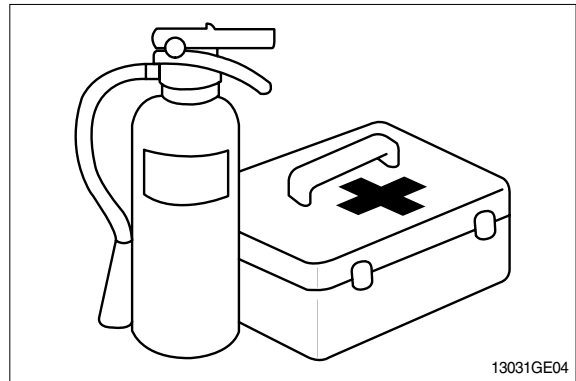


PREPARE FOR EMERGENCIES

Be prepared if a fire starts.

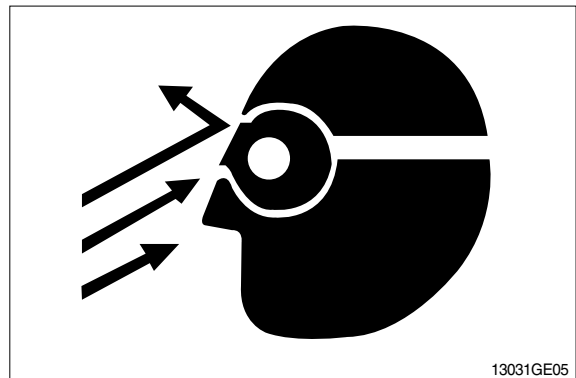
Keep a first aid kit and fire extinguisher handy.

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



PROTECT AGAINST FLYING DEBRIS

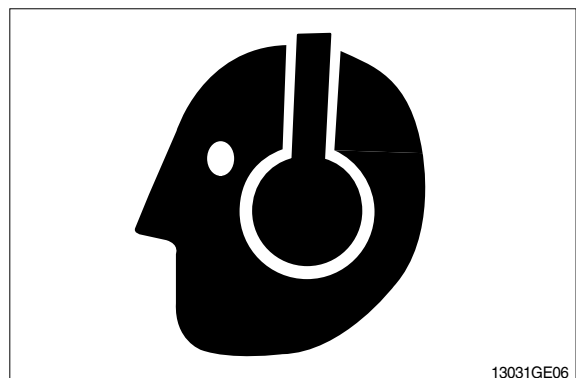
Guard against injury from flying pieces of metal or debris; Wear goggles or safety glasses.



PROTECT AGAINST NOISE

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

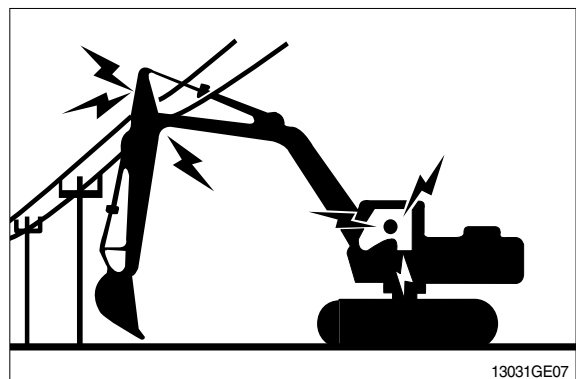
Wear a suitable hearing protective device such as earmuffs or earplugs to protect against objectionable or uncomfortable loud noises.



AVOID POWER LINES

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

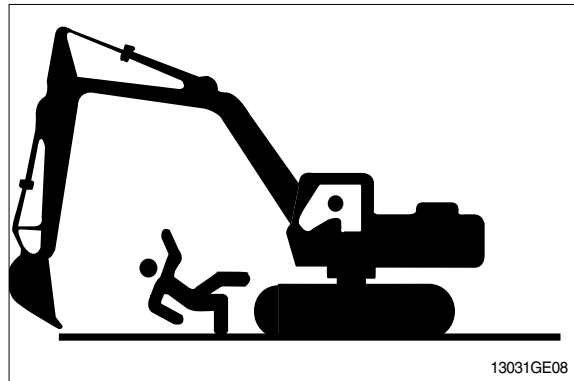
Never move any part of the machine or load closer to electric line than 3m(10ft) plus twice the line insulator length.



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.

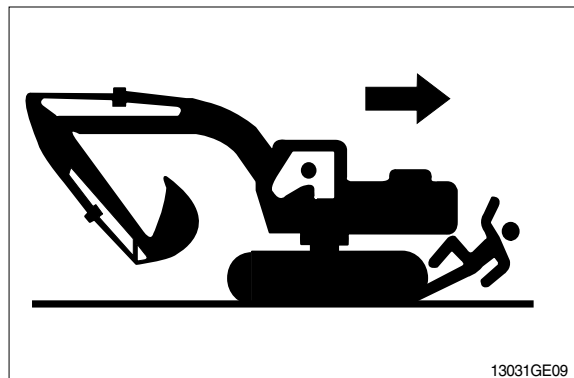


MOVE AND OPERATE MACHINE SAFELY

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:

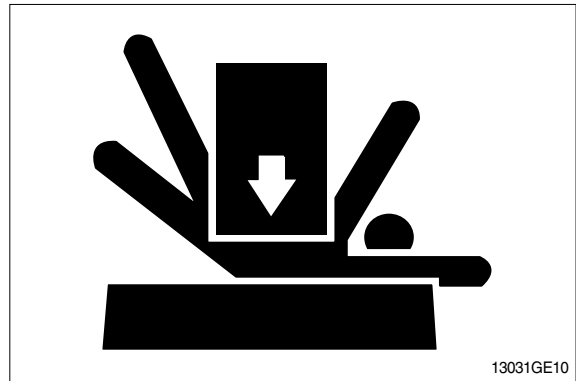
- Park machine on a level surface.
- Lower bucket to the ground.
- Turn auto idle switch off.
- Run engine at 1/2 speed without load for 2 minutes.
- Turn key switch to OFF to stop engine. Remove key from switch.
- Move pilot control shutoff lever to locked position.
- Allow engine to cool.

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

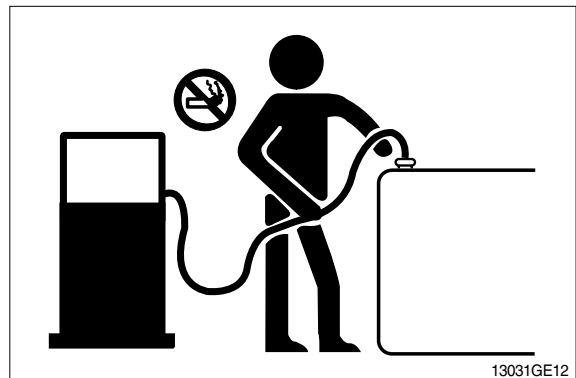
Explosive release of fluids from pressurized cooling system can cause serious burns.

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



HANDLE FLUIDS SAFELY-AVOID FIRES

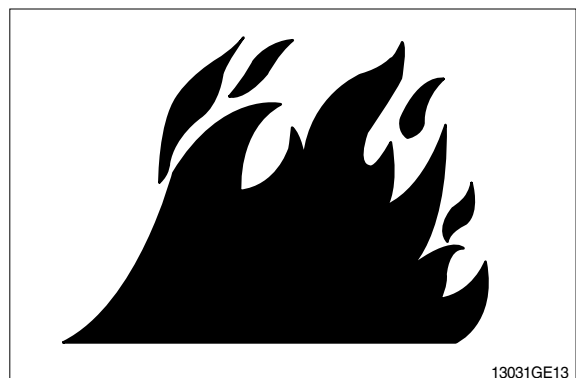
Handle fuel with care; It is highly flammable. Do not refuel the machine while smoking or when near open flame or sparks. Always stop engine before refueling machine. Fill fuel tank outdoors.



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

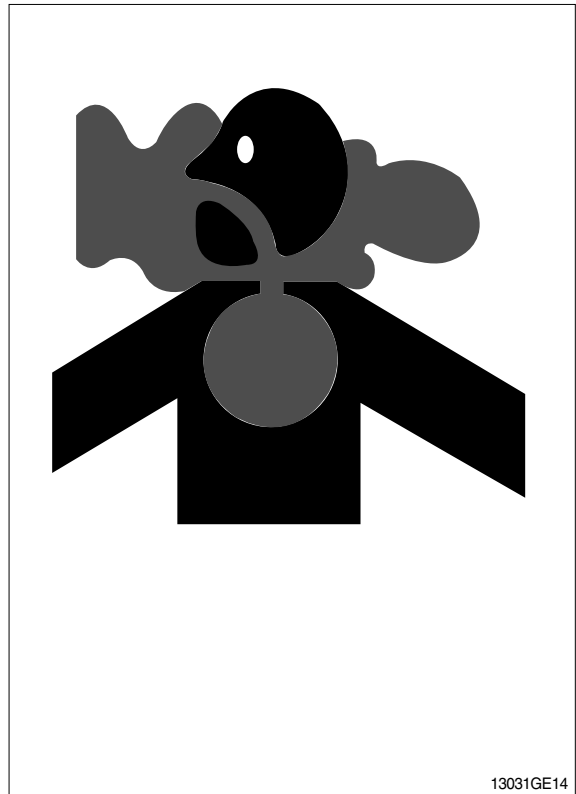
Avoid potentially toxic fumes and dust.

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

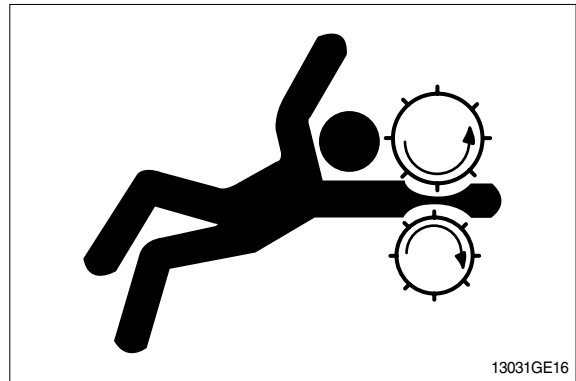
Illuminate your work area adequately but safely. Use a portable safety light for working inside or under the machine. Make sure the bulb is enclosed by a wire cage. The hot filament of an accidentally broken bulb can ignite spilled fuel or oil.



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.

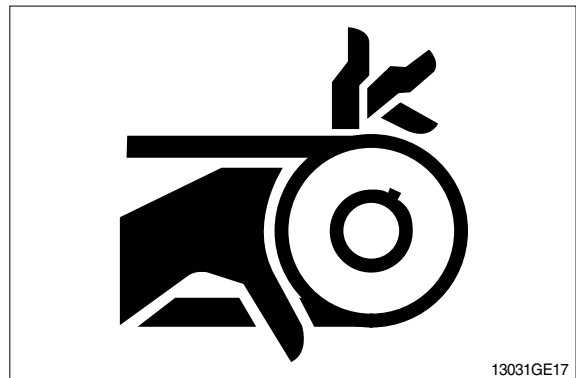
Remove rings and other jewelry to prevent electrical shorts and entanglement in moving parts.



STAY CLEAR OF MOVING PARTS

Entanglements in moving parts can cause serious injury.

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



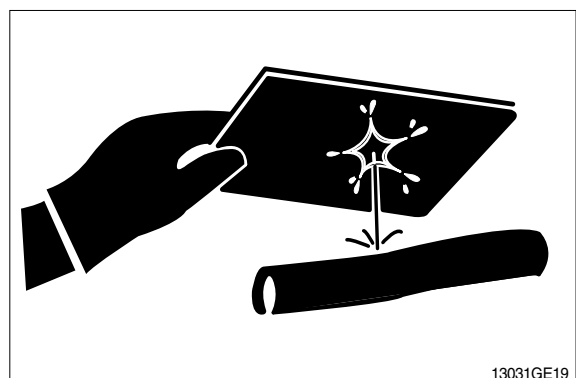
AVOID HIGH PRESSURE FLUIDS

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:

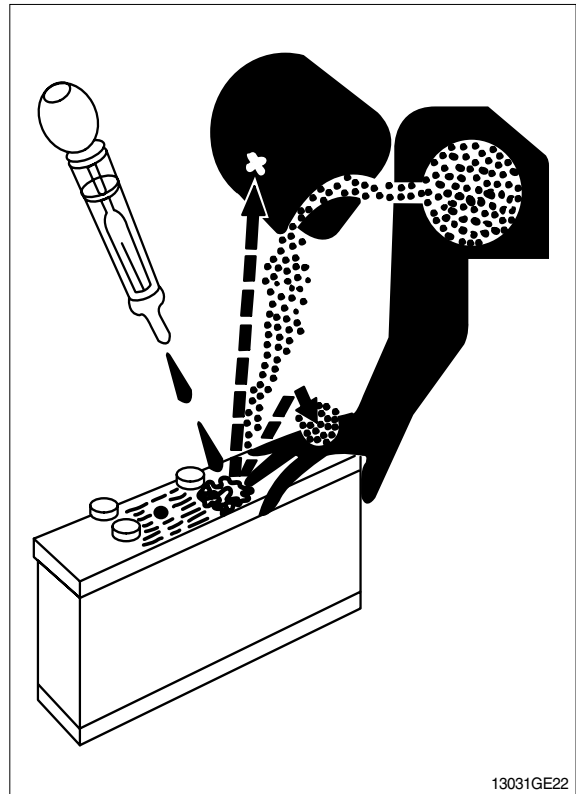
1. Filling batteries in a well-ventilated area.
2. Wearing eye protection and rubber gloves.
3. Avoiding breathing fumes when electrolyte is added.
4. Avoiding spilling or dripping electrolyte.
5. Use proper jump start procedure.

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.



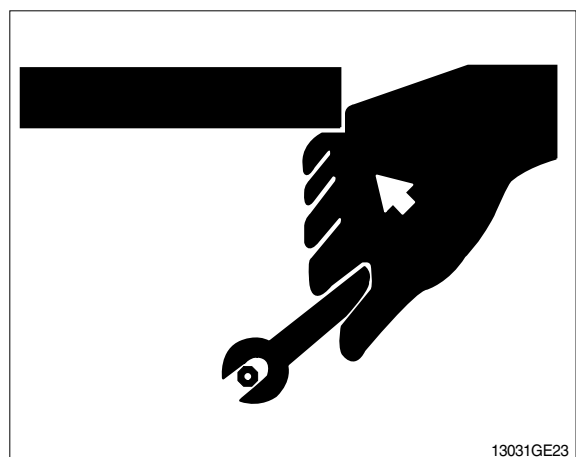
USE TOOLS PROPERLY

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.)

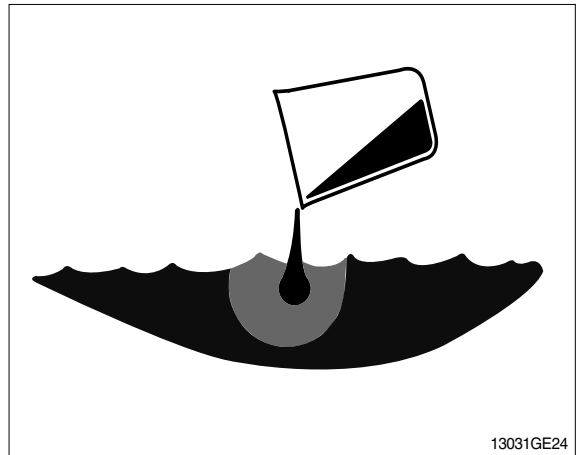


DISPOSE OF FLUIDS PROPERLY

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.

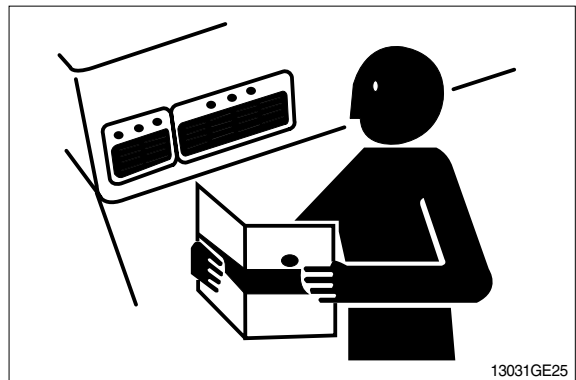
Use proper containers when draining fluids. Do not use food or beverage containers that may mislead someone into drinking from them.

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.

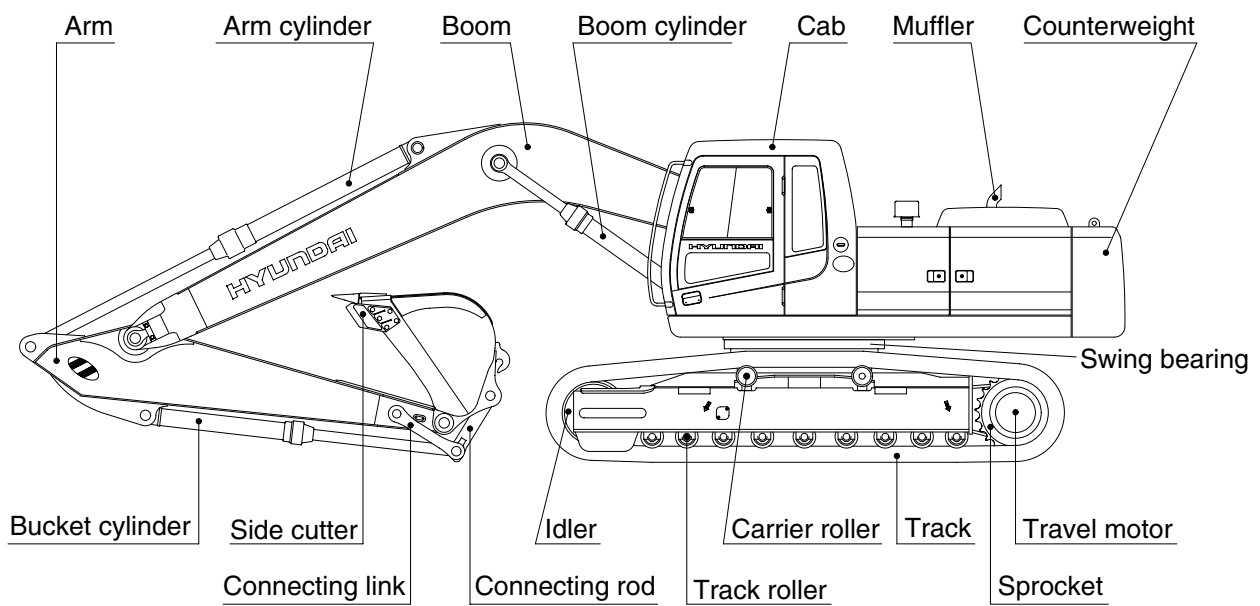
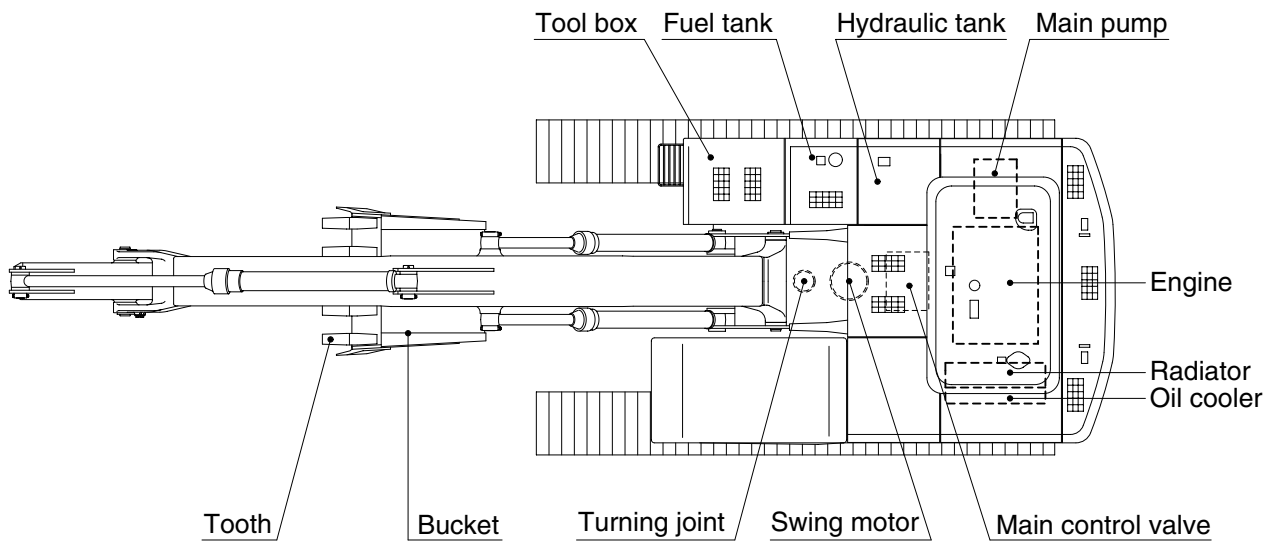


LIVE WITH SAFETY

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

GROUP 2 SPECIFICATIONS

1. MAJOR COMPONENT

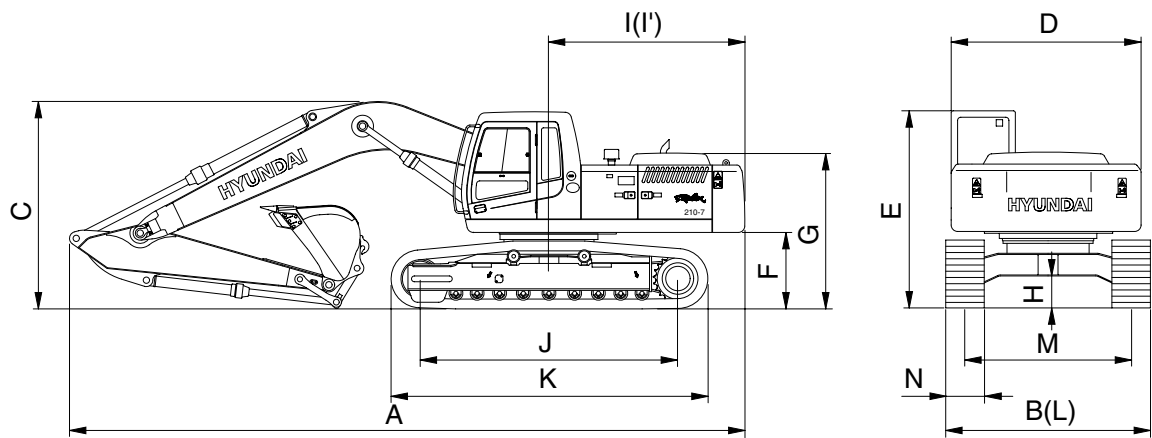


RD2107V2SP01

2. SPECIFICATIONS

1) ROBEX 210-7V

· 5.68m (18' 8") BOOM, 2.4m (7' 10") ARM WITH 500mm TRACK SHOE

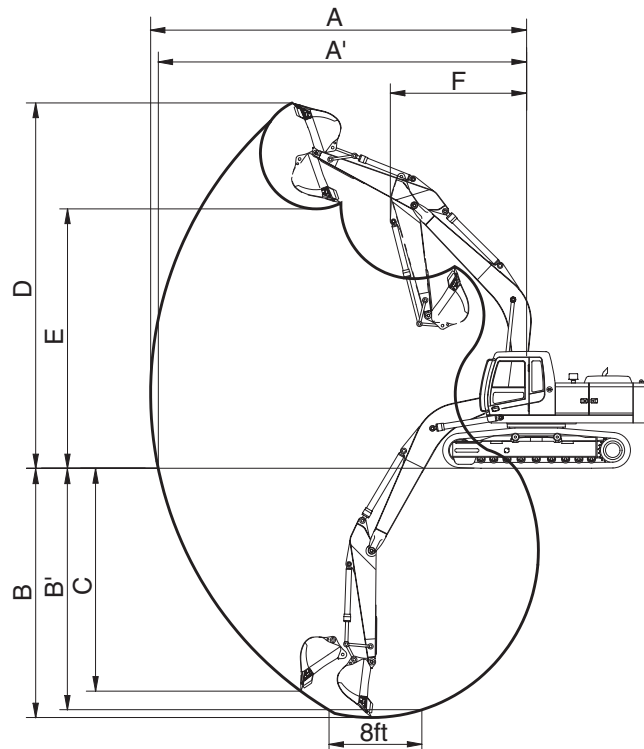


RD2107V2SP02

| Description | | Unit | Specification |
|---------------------------------------|----|-----------------------------------|------------------|
| Operating weight | | kg(lb) | 21000(46300) |
| Bucket capacity(SAE heaped), standard | | m ³ (yd ³) | 0.92(1.20) |
| Overall length | A | mm(ft-in) | 9570(31' 5") |
| Overall width, with 500mm shoe | B | | 2700(8' 10") |
| Overall height | C | | 3110(10' 2") |
| Superstructure width | D | | 2700(8' 10") |
| 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' | | 2830(9' 3") |
| Distance between tumblers | J | | 3370(11' 1") |
| Undercarriage length | K | | 4160(13' 8") |
| Undercarriage width | L | | 2700(8' 10") |
| Track gauge | M | | 2200(7' 3") |
| Track shoe width, standard | N | | 500(20") |
| Travel speed(Low/high) | | km/hr(mph) | 3.5/5.2(2.2/3.2) |
| Swing speed | | rpm | 11.0 |
| Gradeability | | Degree(%) | 35(70) |
| Ground pressure(500mm shoe) | | kgf/cm ² (psi) | 0.56(7.97) |

3. WORKING RANGE

1) R210-7V [5.68m(18' 8") BOOM]



21072SP03

| Description | | *2.40m(7' 10") Arm | 2.92m(9' 7") Arm |
|---------------------------------|-----|--------------------|------------------|
| Max digging reach | A | 9500mm (31' 2") | 9940mm (32' 7") |
| Max digging reach on ground | A' | 9330mm (30' 7") | 9780mm (32' 1") |
| Max digging depth | B | 6220mm (20' 5") | 6740mm (22' 1") |
| Max digging depth(8ft level) | B' | 6010mm (19' 9") | 6550mm (21' 6") |
| Max vertical wall digging depth | C | 5720mm (18' 9") | 6120mm (20' 1") |
| Max digging height | D | 9340mm (30' 8") | 9470mm (31' 1") |
| Max dumping height | E | 6520mm (21' 5") | 6670mm (21' 11") |
| Min swing radius | F | 3740mm (12' 3") | 3640mm (11' 11") |
| Bucket digging force | SAE | 133 kN | 133 kN |
| | | 13600 kgf | 13600 kgf |
| | | 29980 lbf | 29980 lbf |
| | ISO | 152 kN | 152 kN |
| | | 15500 kgf | 15500 kgf |
| | | 34170 lbf | 34170 lbf |
| Arm digging force | SAE | 113 kN | 97 kN |
| | | 11500 kgf | 9900 kgf |
| | | 25350 lbf | 21830 lbf |
| | ISO | 118 kN | 101 kN |
| | | 12000 kgf | 10300 kgf |
| | | 26460 lbf | 22710 lbf |

* : Standard

4. WEIGHT

1) R210-7V













| Item | R210-7V | |
|---|---------|-------|
| | kg | lb |
| Upperstructure assembly | 8950 | 19730 |
| Main frame weld assembly | 1720 | 3790 |
| Engine assembly | 430 | 950 |
| Main pump assembly | 120 | 265 |
| Main control valve assembly | 200 | 440 |
| Swing motor assembly | 190 | 420 |
| Hydraulic oil tank assembly | 240 | 530 |
| Fuel tank assembly | 195 | 430 |
| Counterweight | 4000 | 8820 |
| Cab assembly | 310 | 680 |
| Lower chassis assembly | 8700 | 19180 |
| Track frame weld assembly | 2720 | 6000 |
| Swing bearing | 260 | 570 |
| Travel motor assembly | 305 | 670 |
| Turning joint | 55 | 120 |
| Track recoil spring | 140 | 310 |
| Idler | 170 | 370 |
| Carrier roller | 20 | 45 |
| Track roller | 50 | 110 |
| Track-chain assembly(500mm standard triple grouser shoe) | 1190 | 2620 |
| Front attachment assembly(5.68m boom, 2.4m arm, 0.92m³ SAE heaped bucket) | 4025 | 8870 |
| 5.68m boom assembly | 1530 | 3370 |
| 2.4m arm assembly | 670 | 1480 |
| 0.92m³ SAE heaped bucket | 765 | 1690 |
| Boom cylinder assembly | 180 | 400 |
| Arm cylinder assembly | 290 | 640 |
| Bucket cylinder assembly | 175 | 390 |
| Bucket control link assembly | 170 | 370 |

5. LIFTING CAPACITIES

1) ROBEX 210-7V













(1) 5.68m(18' 8") boom, 2.92m(9' 7") arm equipped with 0.92m³(SAE heaped) bucket, 500mm (20") triple grouser shoe and 4000kg 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 (25ft) | kg lb | | | | | | | | | | | *3120 *6880 | 3000 6610 | 7.72 (25.3) |
| 6.0m (20ft) | kg lb | | | | | | | | | | | *3210 *7080 | 2330 5140 | 8.69 (28.5) |
| 4.5m (15ft) | kg lb | | | | | | | *3770 *8310 | *3770 *8310 | *3590 *7910 | 2960 6530 | 3340 7360 | 1990 4390 | 9.27 (30.4) |
| 3.0m (10ft) | kg lb | | | *9160 *20190 | *9160 *20190 | *5760 *12700 | *5760 *12700 | *4530 *9990 | 4140 9130 | *3950 *8710 | 2830 6240 | 3140 6920 | 1810 3990 | 9.55 (31.3) |
| 1.5m (5ft) | kg lb | | | *8660 *19090 | *8660 *19090 | *7430 *16380 | 5940 13100 | *5380 *11860 | 3840 8470 | *4390 *9680 | 2670 5890 | 3080 6790 | 1760 3880 | 9.54 (31.3) |
| Ground Line | kg lb | | | *9310 *20530 | *9310 *20530 | *8550 *18850 | 5550 12240 | *6060 *13360 | 3610 7960 | 4410 9720 | 2550 5620 | 3200 7050 | 1820 4010 | 9.26 (30.4) |
| -1.5m (-5ft) | kg lb | *8550 *18850 | *8550 *18850 | *12160 *26810 | 10530 23210 | *8950 *19730 | 5400 11900 | 6150 13560 | 3490 7690 | 4340 9570 | 2480 5470 | 3550 7830 | 2040 4500 | 8.67 (28.4) |
| -3.0m (-10ft) | kg lb | *11700 *25790 | *11700 *25790 | *13020 *28700 | 10680 23550 | *8680 *19140 | 5410 11930 | 6140 13540 | 3490 7690 | | | *4230 *9330 | 2530 5580 | 7.69 (25.2) |
| -4.5m (-15ft) | kg lb | | | *11040 *24340 | 11010 24270 | *7560 *16670 | 5580 12300 | | | | | *4140 *9130 | 3830 8440 | 6.09 (20.0) |

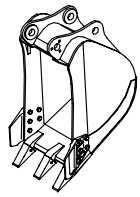
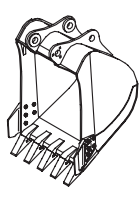
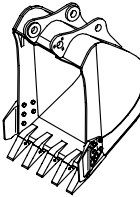
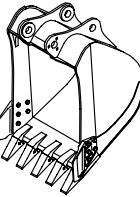
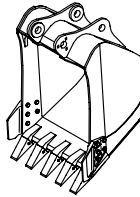
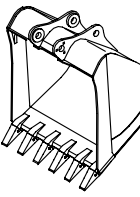
- Note
1. Lifting capacity are based on SAE J1097 and ISO 10567.
 2. Lifting capacity of the ROBEX series does not exceed 75% of tipping load with the machine on firm, level ground or 87% of full hydraulic capacity.
 3. The load point is a hook located on the back of the bucket.
 4. *indicates load limited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

(2) 5.68m(18' 8") boom, 2.40m(7' 10") arm equipped with 0.92m³(SAE heaped) bucket, 500mm (20") triple grouser shoe and 4000kg counterweight.

| 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 (25ft) | kg lb | | | | | | | | | | | *3450 *7610 | 3390 7470 | 7.15 (23.5) |
| 6.0m (20ft) | kg lb | | | | | | | *3750 *8270 | *3750 *8270 | | | *3520 *7760 | 2560 5640 | 8.20 (26.9) |
| 4.5m (15ft) | kg lb | | | | | | | *4190 *9240 | *4190 *9240 | *3940 *8690 | 2890 6370 | *3630 *8000 | 2160 4760 | 8.82 (28.9) |
| 3.0m (10ft) | kg lb | | | | | *6420 *14150 | 6370 14040 | *4920 *10850 | 4060 8950 | *4240 *9350 | 2780 6130 | 3380 7450 | 1970 4340 | 9.11 (29.9) |
| 1.5m (5ft) | kg lb | | | | | *7960 *17550 | 5800 12790 | *5690 *12540 | 3790 8360 | 4520 9960 | 2650 5840 | 3330 7340 | 1920 4230 | 9.10 (29.9) |
| Ground Line | kg lb | | | *8300 *18300 | *8300 *18300 | *8820 *19440 | 5500 12130 | 6260 13800 | 3590 7910 | 4410 9720 | 2550 5620 | 3480 7670 | 2010 4430 | 8.81 (28.9) |
| -1.5m (-5ft) | kg lb | *9220 *20330 | *9220 *20330 | *12750 *28110 | 10650 23480 | *8970 *19780 | 5420 11950 | 6170 13600 | 3510 7740 | | | 3930 8660 | 2280 5030 | 8.18 (26.8) |
| -3.0m (-10ft) | kg lb | *13340 *29410 | *13340 *29410 | *12280 *27070 | 10860 23940 | *8430 *18580 | 5500 12130 | *6110 *13470 | 3550 7830 | | | *4360 *9610 | 2930 6460 | 7.12 (23.4) |
| -4.5m (-15ft) | kg lb | | | *9840 *21690 | *9840 *21690 | *6850 *15100 | 5740 12650 | | | | | | | |


6. BUCKET SELECTION GUIDE


1) GENERAL BUCKET


| | | | | | |
|---|---|---|---|---|---|
|  |  |  |  |  |  |
| 0.51m³ SAE heaped bucket | 0.80m³ SAE heaped bucket | ※0.92m³ SAE heaped bucket | 1.05m³ SAE heaped bucket | 1.20m³ SAE heaped bucket | 1.34m³ SAE heaped bucket |

| Capacity | | Width | | Weight | Recommendation | | | |
|----------------------|---------------------|------------------------|---------------------|-------------------|---------------------|----------------------|----------------------|------------------------|
| | | | | | 5.68m (18' 8") boom | | | |
| SAE heaped | CECE heaped | Without side cutter | With side cutter | | 2.0m arm (6' 7") | 2.4m arm (7' 10") | 2.92m arm (9' 7") | 3.90m arm (12' 10") |
| 0.51m³ (0.67yd³) | 0.45m³ (0.59yd³) | 700mm (27.6") | 820mm (32.3") | 570kg (1260lb) | | | | |
| 0.80m³ (1.05yd³) | 0.70m³ (0.92yd³) | 1000mm (39.4") | 1120mm (44.1") | 700kg (1540lb) | | | | |
| ※0.92m³ (1.20yd³) | 0.80m³ (1.05yd³) | 1150mm (45.3") | 1270mm (50.0") | 770kg (1700lb) | | | | |
| 1.05m³ (1.37yd³) | 0.90m³ (1.18yd³) | 1250mm (49.2") | 1370mm (53.9") | 810kg (1790lb) | | | | |
| 1.20m³ (1.57yd³) | 1.00m³ (1.31yd³) | 1400mm (55.1") | 1520mm (59.8") | 850kg (1870lb) | | | | |
| 1.34m³ (1.75yd³) | 1.15m³ (1.50yd³) | 1550mm (61.0") | 1670mm (65.7") | 920kg (2030lb) | | | | |

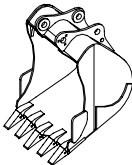
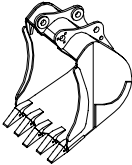
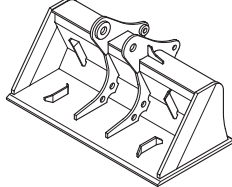
※ : Standard bucket

 Applicable for materials with density of 2000kg/m³ (3370lb/yd³) or less

 Applicable for materials with density of 1600kg/m³ (2700lb/yd³) or less


 Applicable for materials with density of 1100kg/m³ (1850lb/yd³) or less


2) HEAVY DUTY, ROCK-HEAVY DUTY AND SLOPE FINISHING BUCKET


| | | |
|---|---|---|
|  |  |  |
| ◆0.74, 0.90, 1.05m³ SAE heaped bucket | ⊙0.87, 1.20m³ SAE heaped bucket | ■0.75m³ SAE heaped bucket |

| Capacity | | Width | | Weight | Recommendation | | | |
|-------------------|------------------|---------------------|------------------|-----------------|---------------------|-------------------|-------------------|---------------------|
| | | | | | 5.68m (18' 8") boom | | | |
| SAE heaped | CECE heaped | Without side cutter | With side cutter | | 2.0m arm (6' 7") | 2.4m arm (7' 10") | 2.92m arm (9' 7") | 3.90m arm (12' 10") |
| ◆0.74m³ (0.97yd³) | 0.65m³ (0.85yd³) | 985mm (38.8") | - | 770kg (1700lb) | | | | |
| ◆0.90m³ (1.18yd³) | 0.80m³ (1.05yd³) | 1070mm (42.0") | - | 810kg (1790lb) | | | | |
| ◆1.05m³ (1.37yd³) | 0.92m³ (1.20yd³) | 1290mm (50.8") | - | 890kg (1960lb) | | | | |
| ⊙0.87m³ (1.14yd³) | 0.75m³ (0.98yd³) | 1140mm (44.9") | - | 900kg (1980lb) | | | | |
| ⊙1.20m³ (1.57yd³) | 1.00m³ (1.31yd³) | 1410mm (55.5") | - | 1030kg (2270lb) | | | | |
| ■0.75m³ (0.98yd³) | 0.65m³ (0.85yd³) | 1790mm (70.5") | - | 880kg (1940lb) | | | | |

◆ : Heavy duty bucket ⊙ : Rock-Heavy duty bucket ■ : Slope finishing bucket

 Applicable for materials with density of 2000kgf/m³ (3370lbf/yd³) or less

 Applicable for materials with density of 1600kgf/m³ (2700lbf/yd³) or less

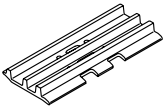
 Applicable for materials with density of 1100kgf/m³ (1850lbf/yd³) or less

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 | | Triple grouser |
|---------|------------------|---------------------------|---|
| | | |  |
| R210-7V | Shoe width | mm(in) | 500(20) |
| | Operating weight | kg(lb) | 21000(46300) |
| | Ground pressure | kgf/cm ² (psi) | 0.56(7.97) |
| | Overall width | mm(ft-in) | 2700(8' 10") |

3) NUMBER OF ROLLERS AND SHOES ON EACH SIDE

| Item | Quantity |
|-----------------|----------|
| Carrier rollers | 2EA |
| Track rollers | 7EA |
| Track shoes | 46EA |

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.

※ **Table 1**

| Track shoe | Specification | Category |
|----------------------|---------------|----------|
| 500mm triple grouser | Standard | A |

※ **Table 2**

| Category | Applications | Precautions |
|----------|---|---|
| A | Rocky ground, river beds, normal soil | <ul style="list-style-type: none">Travel at low speed on rough ground with large obstacles such as boulders or fallen trees |

8. SPECIFICATIONS FOR MAJOR COMPONENTS

1) ENGINE

| Item | Specification |
|---|--|
| Model | Kirloskar 6R1080T |
| Type | 6 cylinder, 4-cycle turbocharged 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 | 105 × 125mm(4.1" × 4.92") |
| Piston displacement | 6495cc(416cu in) |
| Compression ratio | 17.6 : 1 |
| Rated gross horse power (ISO 3046) | 150Hp @ 1900rpm(112kW @ 1900rpm) |
| Maximum torque | 585N · m @ 1500rpm(431lb · ft) |
| Engine oil quantity(1 st FILL) | 15 l (4.0U.S. gal) |
| Dry weight | 700kg(1543lb) |
| High idling speed | 2400 ± 50rpm |
| Low idling speed | 1000 ± 100rpm |
| Rated fuel consumption | 158g/Hp · hr @ 1300rpm |
| Starting motor | 24V-4.5kW |
| Alternator | 24V, 55A |
| Battery | 2 × 12V × 100Ah |

2) MAIN PUMP

| Item | Specification |
|------------------|--|
| Type | Variable displacement tandem axis piston pumps |
| Capacity | 2 × 113cc/rev |
| Maximum pressure | 330kgf/cm ² (4694psi) |
| Rated oil flow | 2 × 210 l /min (55.5U.S. gpm/ 46.2U.K. gpm) |

3) GEAR PUMP

| Item | Specification |
|------------------|---|
| Type | Fixed displacement gear pump single stage |
| Capacity | 10cc/rev |
| Maximum pressure | 35kgf/cm ² (500psi) |
| Rated oil flow | 19.5 l /min(5.2U.S. gpm/4.2U.K. gpm) |

4) MAIN CONTROL VALVE

| Item | Specification |
|--------------------------------|----------------------------------|
| Type | 9 spools mono-block |
| Operating method | Hydraulic pilot system |
| Main relief valve pressure | 330kgf/cm ² (4695psi) |
| Overload relief valve pressure | 390kgf/cm ² (5550psi) |

5) SWING MOTOR

| Item | Specification |
|------------------------|--|
| Type | Two fixed displacement axial piston motor |
| Capacity | 151cc/rev |
| Relief pressure | 240kgf/cm ² (3414psi) |
| Braking system | Automatic, spring applied hydraulic released |
| Braking torque | 59kgf · m(427lbf · ft) |
| Brake release pressure | 33~50kgf/cm ² (470~711psi) |
| Reduction gear type | 2 - stage planetary |
| Swing speed | 11.0rpm |

6) TRAVEL MOTOR

| Item | Specification |
|------------------------|--|
| Type | Variable displacement axial piston motor |
| Relief pressure | 330kgf/cm ² (4695psi) |
| Reduction gear type | 2-stage planetary |
| Braking system | Automatic, spring applied hydraulic released |
| Brake release pressure | 11kgf/cm ² (156psi) |
| Braking torque | 49.3kgf · m(357lbf · ft) |

7) REMOTE CONTROL VALVE

| Item | | Specification |
|-------------------------|---------|--------------------------------|
| Type | | Pressure reducing type |
| Operating pressure | Minimum | 6.5kgf/cm ² (92psi) |
| | Maximum | 26kgf/cm ² (370psi) |
| Single operation stroke | Lever | 61mm(2.4in) |
| | Pedal | 123mm(4.84in) |

8) CYLINDER

| Item | | Specification |
|-----------------|-----------------------------|------------------------|
| Boom cylinder | Bore dia × Rod dia × Stroke | ø 120 × ø 85 × 1290mm |
| | Cushion | Extend only |
| Arm cylinder | Bore dia × Rod dia × Stroke | ø 140 × ø 100 × 1510mm |
| | Cushion | Extend and retract |
| Bucket cylinder | Bore dia × Rod dia × Stroke | ø 125 × ø 85 × 1055mm |
| | 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 |
|---------|----------|------------|-----------------------------------|---------------|----------------|
| R210-7V | Standard | 500mm(20") | 0.56kgf/cm ² (7.97psi) | 46 | 2700mm(8' 10") |

10) BUCKET

| Item | | Capacity | | Tooth quantity | Width | |
|---------|-----|--|---|----------------|---------------------|------------------|
| | | SAE heaped | CECE heaped | | Without side cutter | With side cutter |
| R210-7V | STD | 0.92m ³ (1.20yd ³) | 0.80m ³ (1.05yd ³) | 5 | 1150mm(45.3") | 1270mm(50.0") |
| | OPT | 0.51m ³ (0.67yd ³) | 0.45m ³ (0.59yd ³) | 3 | 700mm(27.6") | 820mm(32.3") |
| | | 0.80m ³ (1.05yd ³) | 0.70m ³ (0.92yd ³) | 5 | 1000mm(39.4") | 1120mm(44.1") |
| | | 1.05m ³ (1.37yd ³) | 0.90m ³ (7.18yd ³) | 5 | 1250mm(49.2") | 1370mm(53.9") |
| | | 1.20m ³ (1.57yd ³) | 1.00m ³ (1.31yd ³) | 6 | 1400mm(55.1") | 1520mm(59.8") |
| | | 1.34m ³ (1.75yd ³) | 1.15m ³ (1.50yd ³) | 6 | 1550mm(61.0") | 1670mm(65.7") |
| | | ◆0.74m ³ (0.97yd ³) | 0.65m ³ (0.85yd ³) | 5 | 985mm(38.8") | - |
| | | ◆0.90m ³ (1.18yd ³) | 0.80m ³ (1.05yd ³) | 5 | 1070mm(42.0") | - |
| | | ◆1.05m ³ (1.37yd ³) | 0.92m ³ (1.20yd ³) | 5 | 1290mm(50.8") | - |
| | | ⊙0.87m ³ (1.14yd ³) | 0.75m ³ (0.98yd ³) | 5 | 1140mm(44.9") | - |
| | | ⊙1.20m ³ (1.57yd ³) | 1.00m ³ (1.31yd ³) | 5 | 1410mm(55.5") | - |
| | | ■0.75m ³ (0.98yd ³) | 0.65m ³ (0.85yd ³) | - | 1790mm(70.5") | - |

◆ : Heavy duty bucket

⊙ : Rock-Heavy duty bucket

■ : Slope finishing bucket

9. RECOMMENDED OILS

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

| Service point | Kind of fluid | Capacity l (U.S. gal) | Ambient temperature °C (°F) | | | | | | |
|------------------------------|--|--|-----------------------------|-------------|-----------|-------------------------------------|-------------|------------|-------------|
| | | | -20 (-4) | -10 (14) | 0 (32) | 10 (50) | 20 (68) | 30 (86) | 40 (104) |
| Engine oil pan | Engine oil | 15.0(4.0) | | | | | SAE 30 | | |
| | | | | | | SAE 10W | | | |
| | | | | | | SAE 10W-30 | | | |
| | | | | | | SAE 15W-40 | | | |
| | | | | | | | | | |
| Swing drive | Gear oil | 5.0(1.3) | | | | | SAE 85W-140 | | |
| Final drive | | 5.8 × 2 (1.5 × 2) | | | | | | | |
| Hydraulic tank | Hydraulic oil | Tank; 180(48) System; 290(77) | | | | ISO VG 32 | | | |
| | | | | | | ISO VG 46 | | | |
| | | | | | | ISO VG 68 | | | |
| Fuel tank | Diesel fuel | 340(90) | 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 water 50 : 50 | 35(9.2) | | | | Ethylene glycol base permanent type | | | |

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

SECTION 2 STRUCTURE AND FUNCTION

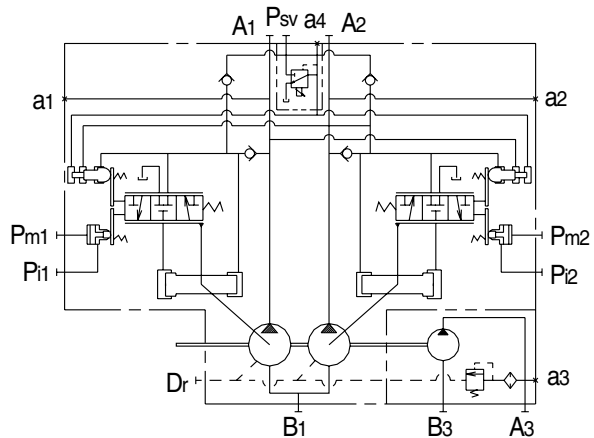
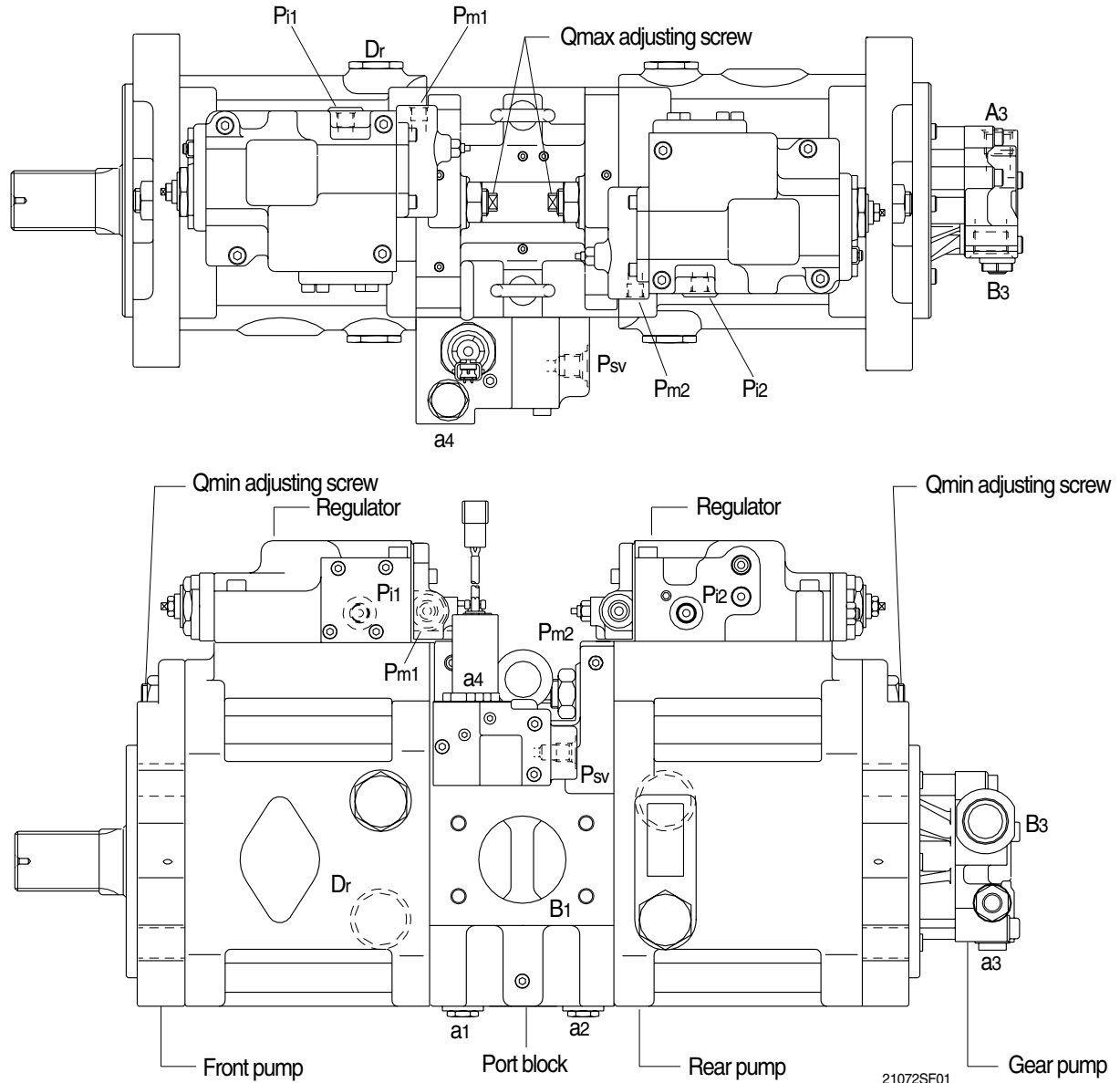
| | |
|----------------------------------|------|
| Group 1 Pump Device | 2-1 |
| Group 2 Main Control Valve | 2-21 |
| Group 3 Swing Device | 2-54 |
| Group 4 Travel Device | 2-76 |
| Group 5 RCV Lever | 2-84 |
| Group 6 RCV Pedal | 2-91 |

SECTION 2 STRUCTURE AND FUNCTION

GROUP 1 PUMP DEVICE

1. STRUCTURE

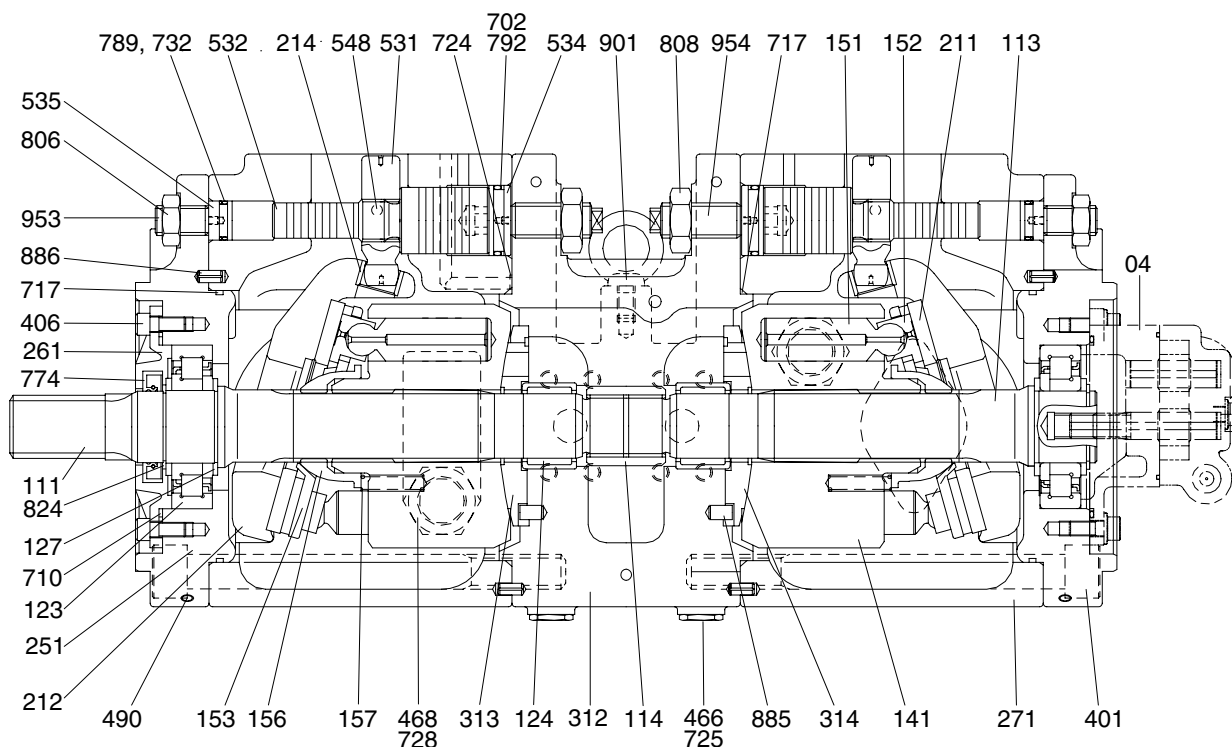
The pump device consists of main pump, regulator and gear pump.



| Port | Port name | Port size |
|--------|-------------------------|-------------------|
| A1,2 | Delivery port | SAE6000psi 3/4" |
| B1 | Suction port | SAE2500psi 2 1/2" |
| Dr | Drain port | PF 3/4 - 20 |
| Pi1,i2 | Pilot port | PF 1/4 - 15 |
| Pm1,m2 | Qmax cut port | PF 1/4 - 15 |
| Psv | Servo assist port | PF 1/4 - 15 |
| a1,2,4 | Gauge port | PF 1/4 - 15 |
| a3 | Gauge port | PF 1/4-14 |
| A3 | Gear pump delivery port | PF 1/2 - 19 |
| B3 | Gear pump suction port | PF 3/4 - 20.5 |

1) MAIN PUMP(1/2)

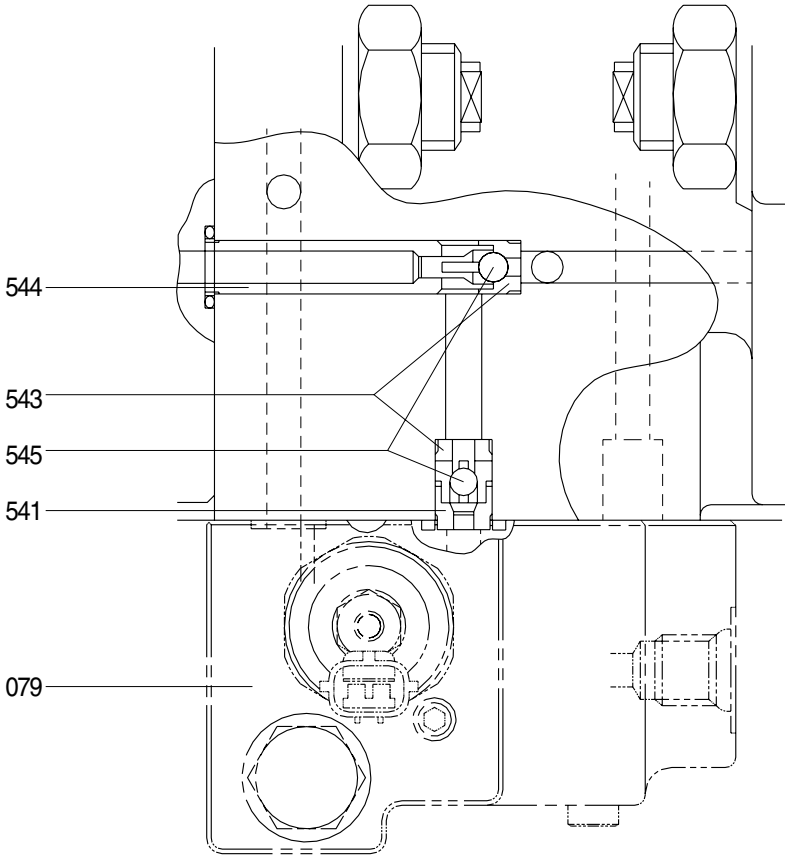
The main pump consists of two piston pumps(front & rear) and valve block.



RD21072SF02

| | | | | | |
|-----|-----------------|-----|---------------------|-----|------------------|
| 04 | Gear pump | 261 | Seal cover(F) | 717 | O-ring |
| 111 | Drive shaft(F) | 271 | Pump casing | 724 | O-ring |
| 113 | Drive shaft(R) | 312 | Valve block | 725 | O-ring |
| 114 | Spline coupling | 313 | Valve plate(R) | 728 | O-ring |
| 123 | Roller bearing | 314 | Valve plate(L) | 732 | O-ring |
| 124 | Needle bearing | 401 | Hexagon socket bolt | 774 | Oil seal |
| 127 | Bearing spacer | 406 | Hexagon socket bolt | 789 | Back up ring |
| 141 | Cylinder block | 466 | VP Plug | 792 | Back up ring |
| 151 | Piston | 468 | VP Plug | 806 | Hexagon head nut |
| 152 | Shoe | 490 | Plug | 808 | Hexagon head nut |
| 153 | Set plate | 531 | Tilting pin | 824 | Snap ring |
| 156 | Bushing | 532 | Servo piston | 885 | Pin |
| 157 | Cylinder spring | 534 | Stopper(L) | 886 | Spring pin |
| 211 | Shoe plate | 535 | Stopper(S) | 901 | Eye bolt |
| 212 | Swash plate | 548 | Pin | 953 | Set screw |
| 214 | Bushing | 702 | O-ring | 954 | Set screw |
| 251 | Support | 710 | O-ring | | |

MAIN PUMP(2/2)

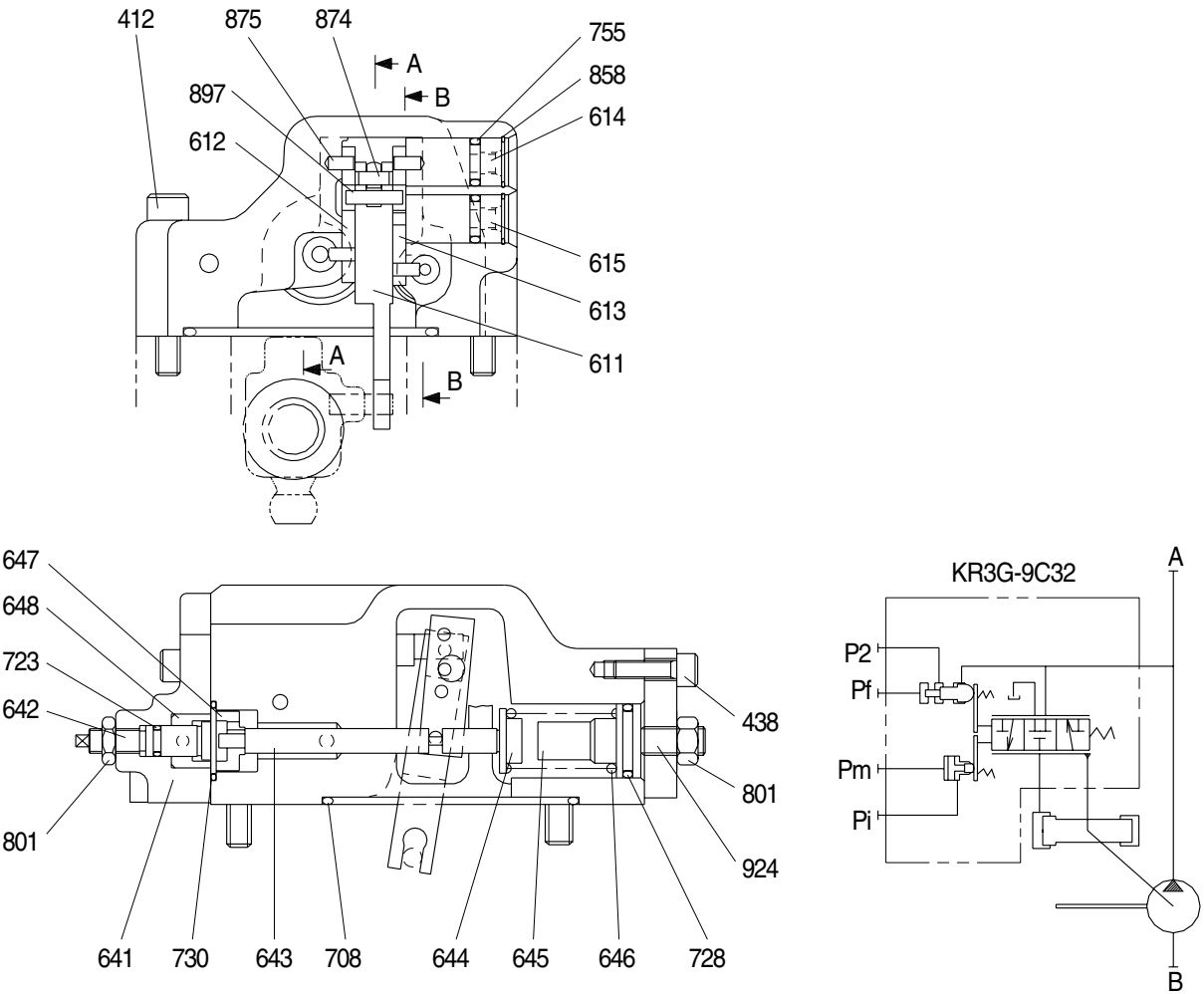


VIEW A

2-3

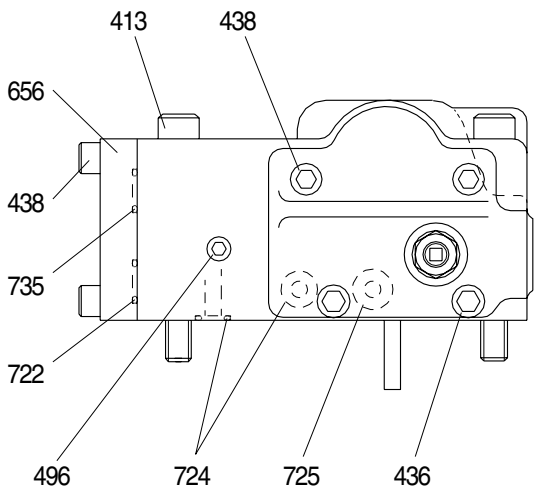
- | | | | | | |
|-----|-----------------------------|-----|-----------|-----|------------|
| 079 | Proportional reducing valve | 543 | Stopper 1 | 545 | Steel ball |
| 541 | Seat | 544 | Stopper 2 | | |

2) REGULATOR(1/2)



SECTION B-B

2-4

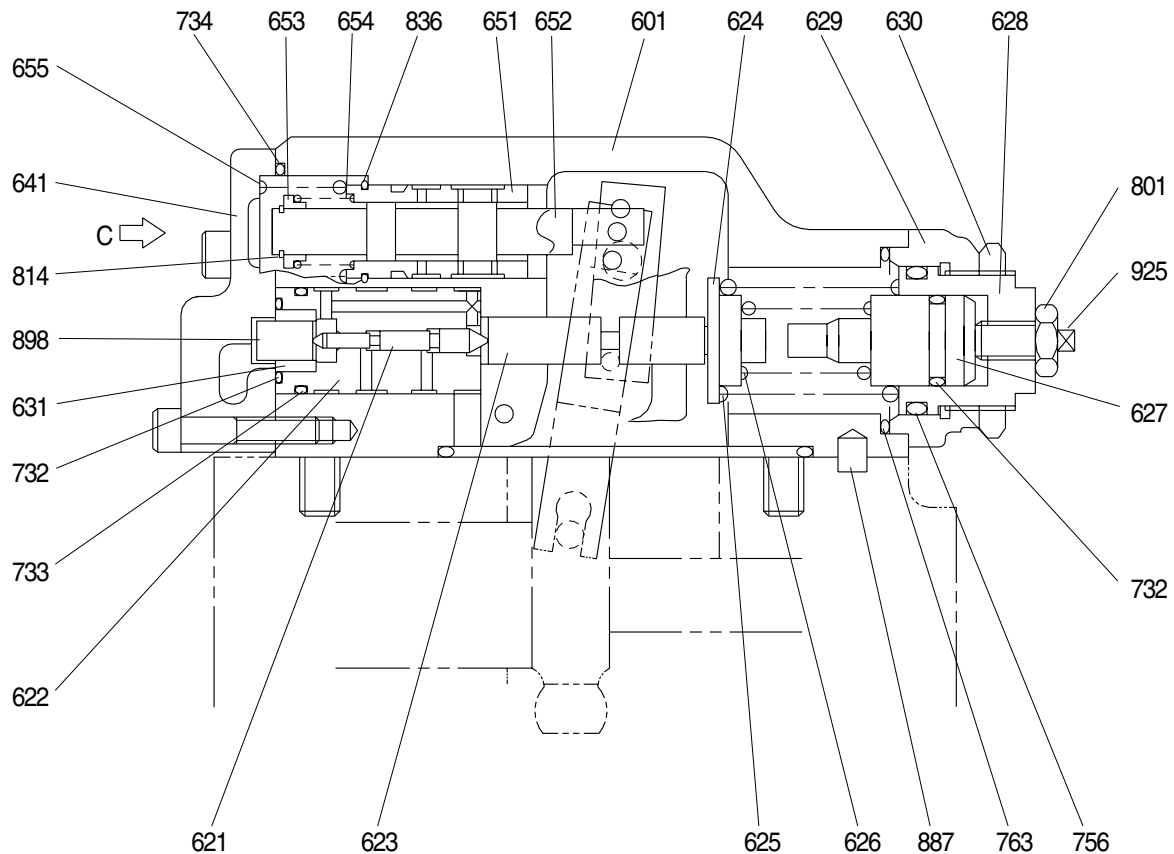


VIEW C

| Port | Port name | port size |
|------|---------------|-----------|
| A | Delivery port | 3/4" |
| B | Suction port | 2 1/2" |
| Pi | Pilot port | PF 1/4-15 |
| Pm | Qmax cut port | PF 1/4-15 |

2-4

REGULATOR(2/2)

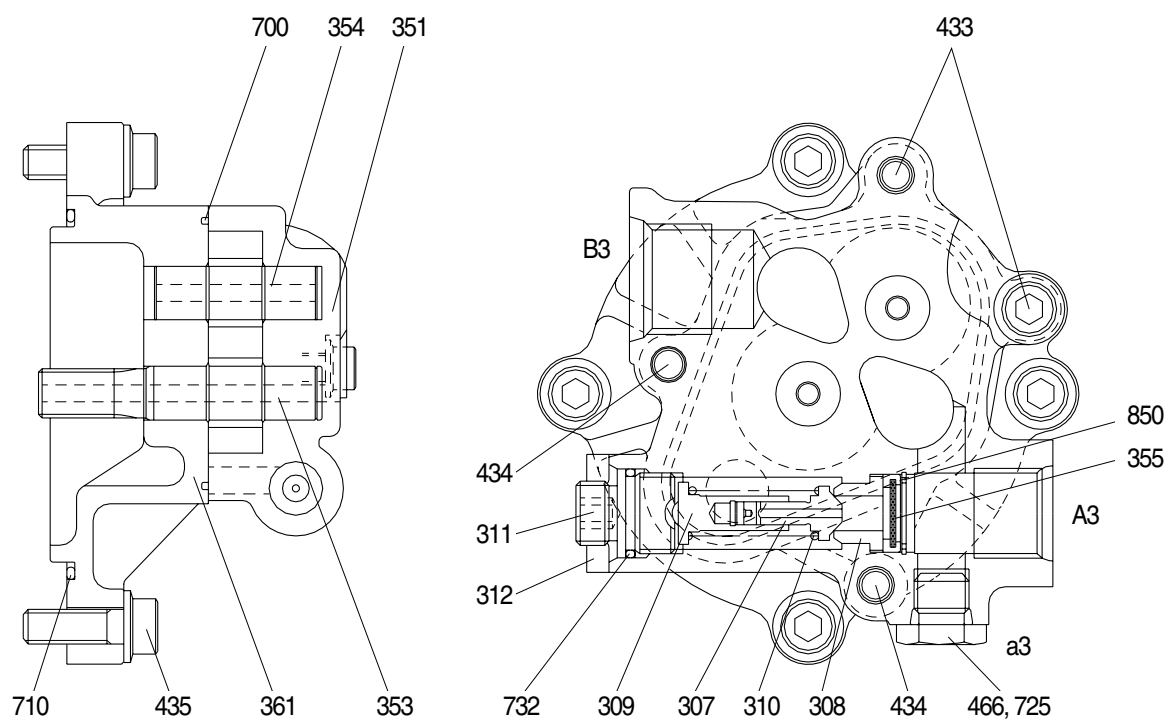


SECTION A-A

2-5

| | | |
|--------------------------|----------------------|----------------------|
| 412 Hexagon socket screw | 631 Sleeve, pf | 730 O-ring |
| 413 Hexagon socket screw | 641 Pilot cover | 732 O-ring |
| 436 Hexagon socket screw | 642 Pilot cover(QMC) | 733 O-ring |
| 438 Hexagon socket screw | 643 Pilot piston | 734 O-ring |
| 496 Plug | 644 Spring seat(Q) | 735 O-ring |
| 601 Casing | 645 Adjust stem(Q) | 755 O-ring |
| 611 Feed back lever | 646 Pilot spring | 756 O-ring |
| 612 Lever(1) | 647 Stopper | 763 O-ring |
| 613 Lever(2) | 648 Piston(QMC) | 801 Nut |
| 614 Fulcrum plug | 651 Sleeve | 814 Snap ring |
| 615 Adjust plug | 652 Spool | 836 Snap ring |
| 621 Compensator piston | 653 Spring seat | 858 Snap ring |
| 622 Piston case | 654 Return spring | 874 Pin |
| 623 Compensator rod | 655 Set spring | 875 Pin |
| 624 Spring seat(C) | 656 Block cover | 887 Pin |
| 625 Outer spring | 708 O-ring | 897 Pin |
| 626 Inner spring | 722 O-ring | 898 Pin |
| 627 Adjust stem(C) | 723 O-ring | 924 Set screw |
| 628 Adjust screw(C) | 724 O-ring | 925 Adjust screw(QI) |
| 629 Cover(C) | 725 O-ring | |
| 630 Lock nut | 728 O-ring | |

3) GEAR PUMP



2-6

307 Poppet
308 Seat
309 Spring seat
310 Spring
311 Screw
312 Nut
351 Gear case

353 Drive gear
354 Driven gear
355 Filter
361 Front case
433 Flange socket
434 Flange socket
435 Flange socket

466 Plug
700 Ring
710 O-ring
725 O-ring
732 O-ring
850 Snap ring

2. FUNCTION

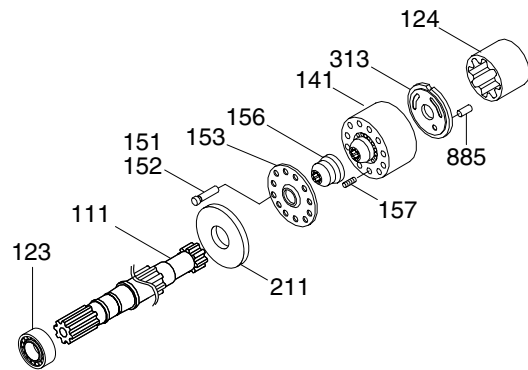
1) MAIN PUMP

The pumps may be classified roughly into the rotary group performing a rotary motion and working as the major part of the whole pump function: the swash plate group that varies the delivery rates: and the valve cover group that changes over oil suction and discharge.

(1) Rotary group

The rotary group consists of drive shaft (F)(111), cylinder block(141), piston shoes(151,152), set plate(153), spherical bush(156) and cylinder spring(157). The drive shaft is supported by bearing (123,124) at its both ends.

The shoe is caulked to the piston to form a spherical coupling. It has a pocket to relieve thrust force generated by loading pressure and the take hydraulic balance so that it slides lightly over the shoe plate(211). The sub group composed by a piston and a shoe is pressed against the shoe plate by the action of the cylinder spring via a retainer and a spherical bush. Similarly, the cylinder block is pressed against valve plate(313) by the action of the cylinder spring.



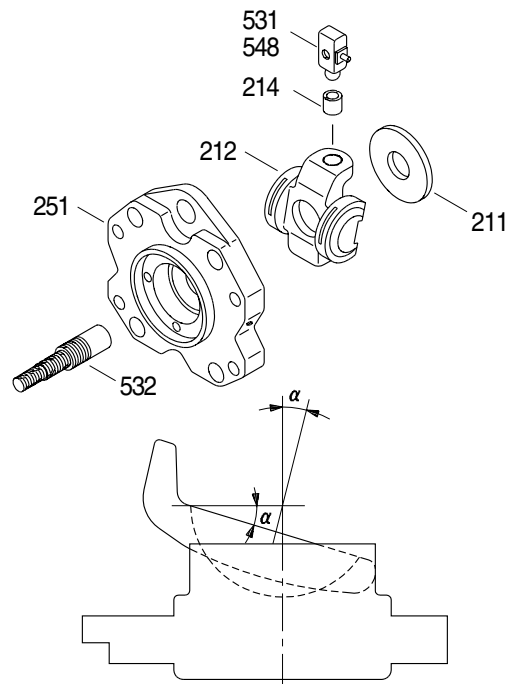
RD210722-71

(2) Swash plate group

The swash plate group consists of swash plate(212), shoe plate(211), swash plate support(251), tilting bush(214), tilting pin(531) and servo piston(532).

The swash plate is a cylindrical part formed on the opposite side of the sliding surface of the shoe and is supported by the swash support.

If the servo piston moves to the right and left as hydraulic force controlled by the regulator is admitted to hydraulic chamber located on both sides of the servo piston, the swash plate slides over the swash plate support via the spherical part of the tilting pin to change the tilting angle(α)



2-7

(3) Valve block group

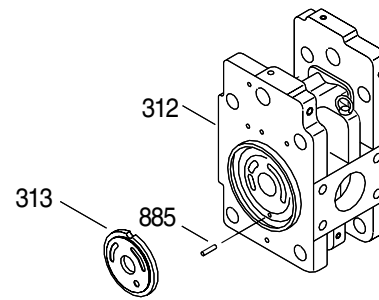
The valve block group consists of valve block(312), valve plate(313) and valve pin(885).

The valve plate having two melon-shaped ports is fixed to the valve block and feeds and collects oil to and from the cylinder block.

The oil changed over by the valve plate is connected to an external pipeline by way of the valve block.

Now, if the drive shaft is driven by a prime mover(electric motor, engine, etc), it rotates the cylinder block via a spline linkage at the same time. If the swash plate is tilted as in Fig(previous page) the pistons arranged in the cylinder block make a reciprocating motion with respect to the cylinder block, while they revolve with the cylinder block.

If you pay attention to a single piston, it performs a motion away from the valve plate(oil sucking process) within 180 degrees, and makes a motion towards the valve plate(or oil discharging process) in the rest of 180 degrees. When the swash plate has a tilting angle of zero, the piston makes no stroke and discharges no oil.



2-8

2) REGULATOR

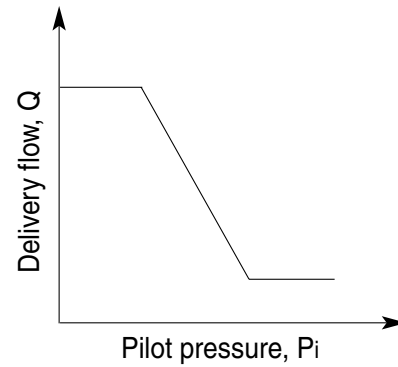
Regulator consists of the negative flow control, total horse power control and power shift control function.

(1) Negative flow control

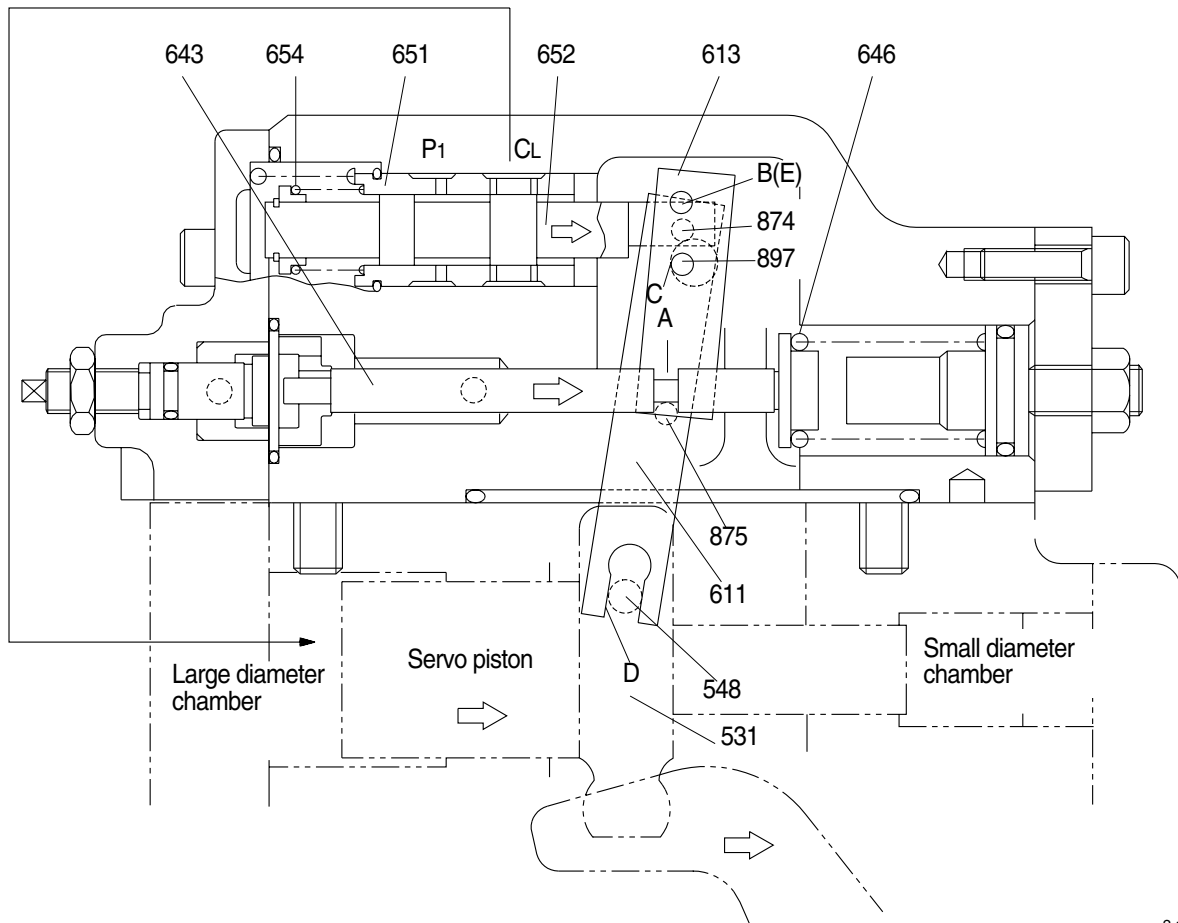
By changing the pilot pressure P_i , the pump tilting angle (delivery flow) is regulated arbitrarily, as shown in the figure.

This regulator is of the negative flow control in which the delivery flow Q decreases as the pilot pressure P_i rises.

With this mechanism, when the pilot pressure corresponding to the flow required for the work is commanded, the pump discharges the required flow only, and so it does not consume the power uselessly.



① Flow reducing function



2-10

As the pilot pressure P_i rises, the pilot piston(643) moves to the right to a position where the force of the pilot spring(646) balances with the hydraulic force.

The groove(A) in the pilot piston is fitted with the pin(875) that is fixed to lever 2(613). Therefore, when the pilot piston moves, lever 2 rotates around the fulcrum of point B [fixed by the fulcrum plug(614) and pin(875)]. Since the large hole section(C) of lever 2 contains a protruding pin(897) fixed to the feedback lever(611), the pin(897) moves to the right as lever 2 rotates. Since the opposing-flat section(D) of the feedback lever is fitted with the pin(548) fixed by the tilting pin(531) that swings the swash plate, the feedback lever rotates around the fulcrum of point D, as the pin(897) moves.

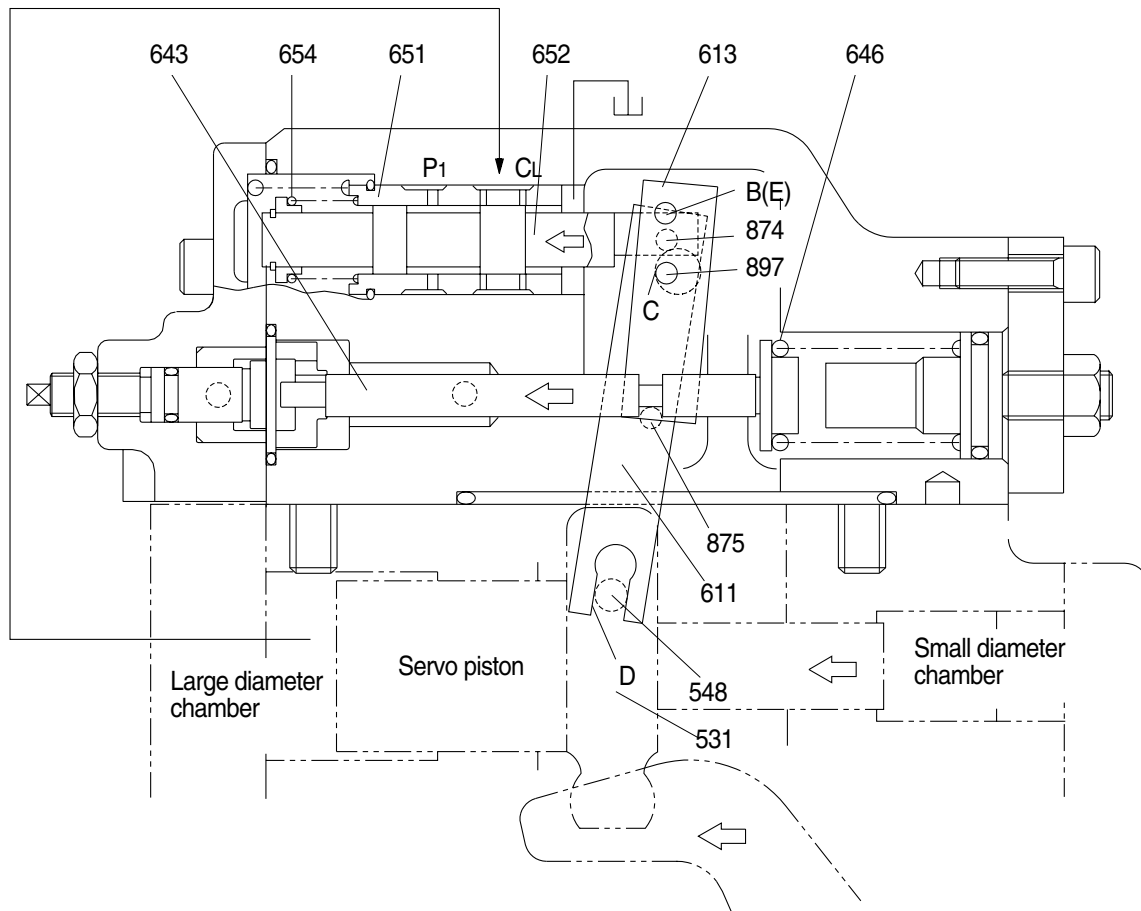
Since the feedback lever is connected with the spool(652) via the pin(874), the spool moves to the right.

The movement of the spool causes the delivery pressure P_1 to connect to port CL through the spool and to be admitted to the large diameter section of the servo piston. The delivery pressure P_1 that is constantly admitted to the small diameter section of the servo piston moves the servo piston to the right due to the area difference, resulting in decrease of the tilting angle.

When the servo piston moves to the right, point D also moves to the right. The spool is fitted with the return spring(654) and is tensioned to the left at all times, and so the pin(897) is pressed against the large hole section(C) of lever 2.

Therefore, as point D moves, the feedback lever rotates around the fulcrum of point C, and the spool is shifted to the left. This causes the opening between the sleeve(651) and spool(652) to close slowly, and the servo piston comes to a complete stop when it closes completely.

② Flow increasing function



2-11

As the pilot pressure P_i decreases, the pilot piston(643) moves to the left by the action of the pilot spring(646) and causes lever 2(613) to rotate around the fulcrum of point B. Since the pin(897) is pressed against the large hole section(C) of lever 2 by the action of the return spring(654) via the spool(652), pin(874), and feedback lever(611), the feedback lever rotates around the fulcrum of point D as lever 2 rotates, and shifts the spool to the left. Port CL opens a way to the tank port as the spool moves. This deprives the large diameter section of the servo piston of pressure, and shifts the servo piston to the left by the discharge pressure P_1 in the small diameter section, resulting in an increase in the flow rate.

As the servo piston moves, point D also moves to the left, the feedback lever rotates around the fulcrum of point C, and the spool moves to the right till the opening between the spool and sleeve is closed.

③ Adjustment of flow control characteristic

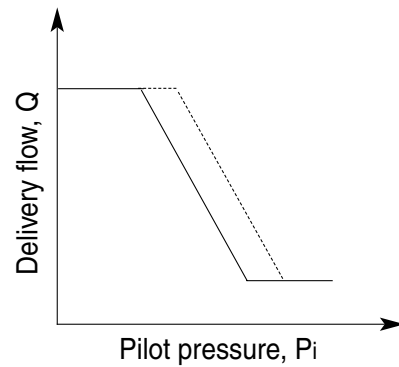
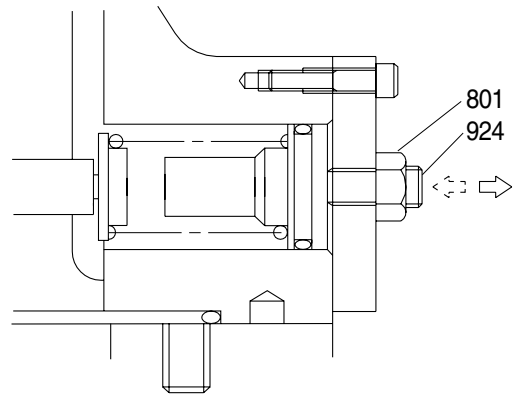
The flow control characteristic can be adjusted with the adjusting screw.

Adjust it by loosening the hexagon nut(801) and by tightening(or loosening) the hexagonal socket head screw(924).

Tightening the screw shifts the control chart to the right as shown in the figure.

※ **Adjusting values are shown in table.**

| Speed | Adjustment of flow control characteristic | | |
|----------------------|---|--|--------------------|
| | Tightening amount of adjusting screw(924) | Flow control starting pressure change amount | Flow change amount |
| (min ⁻¹) | (Turn) | (kgf/cm ²) | (l /min) |
| 1950 | +1/4 | +1.5 | +12.7 |



(2) Total horsepower control

The regulator decreases the pump tilting angle(delivery flow) automatically to limit the input torque within a certain value with a rise in the delivery pressure P_1 of the self pump and the delivery pressure P_2 of the companion pump.

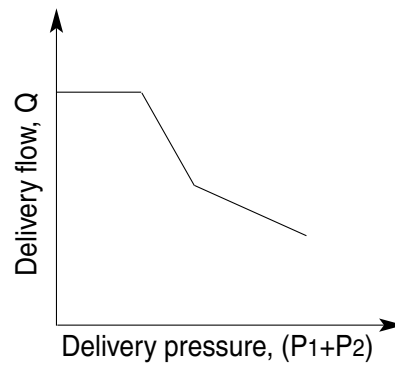
(The input horsepower is constant when the speed is constant.)

Since the regulator is of the simultaneous total horsepower type that operates by the sum of load pressures of the two pumps in the tandem double-pump system, the prime mover is automatically prevented from being overloaded, irrespective of the load condition of the two pumps, when horsepower control is under way.

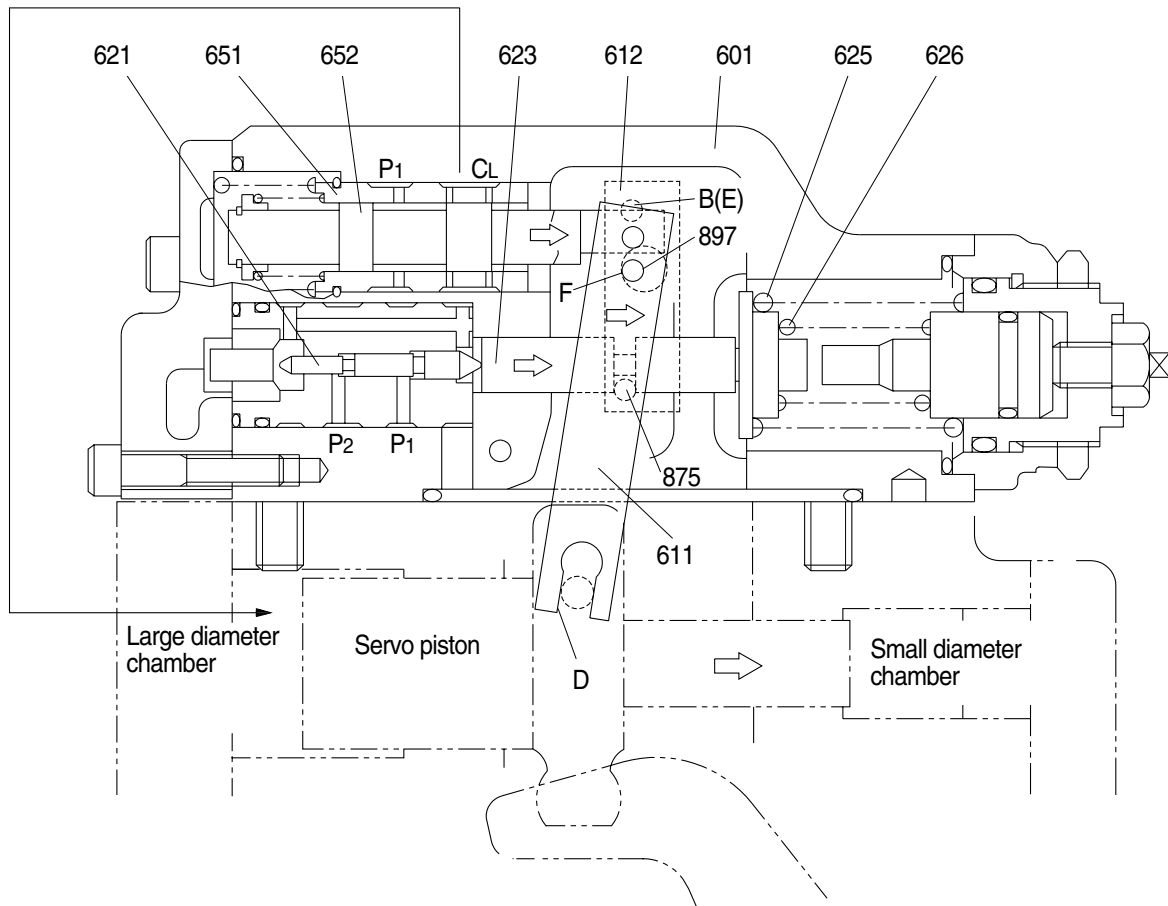
Since this regulator is of the simultaneous total horsepower type, it controls the tilting angles(displacement volumes) of the two pumps to the same value as represented by the following equation :

$$\begin{aligned} T_{in} &= P_1 \times q/2\pi + P_2 \times q/2\pi \\ &= (P_1+P_2) \times q/2\pi \end{aligned}$$

The horsepower control function is the same as the flow control function and is summarized in the following.(For detailed behaviors of respective parts, refer to the section of flow control).



① Overload preventive function



2-14

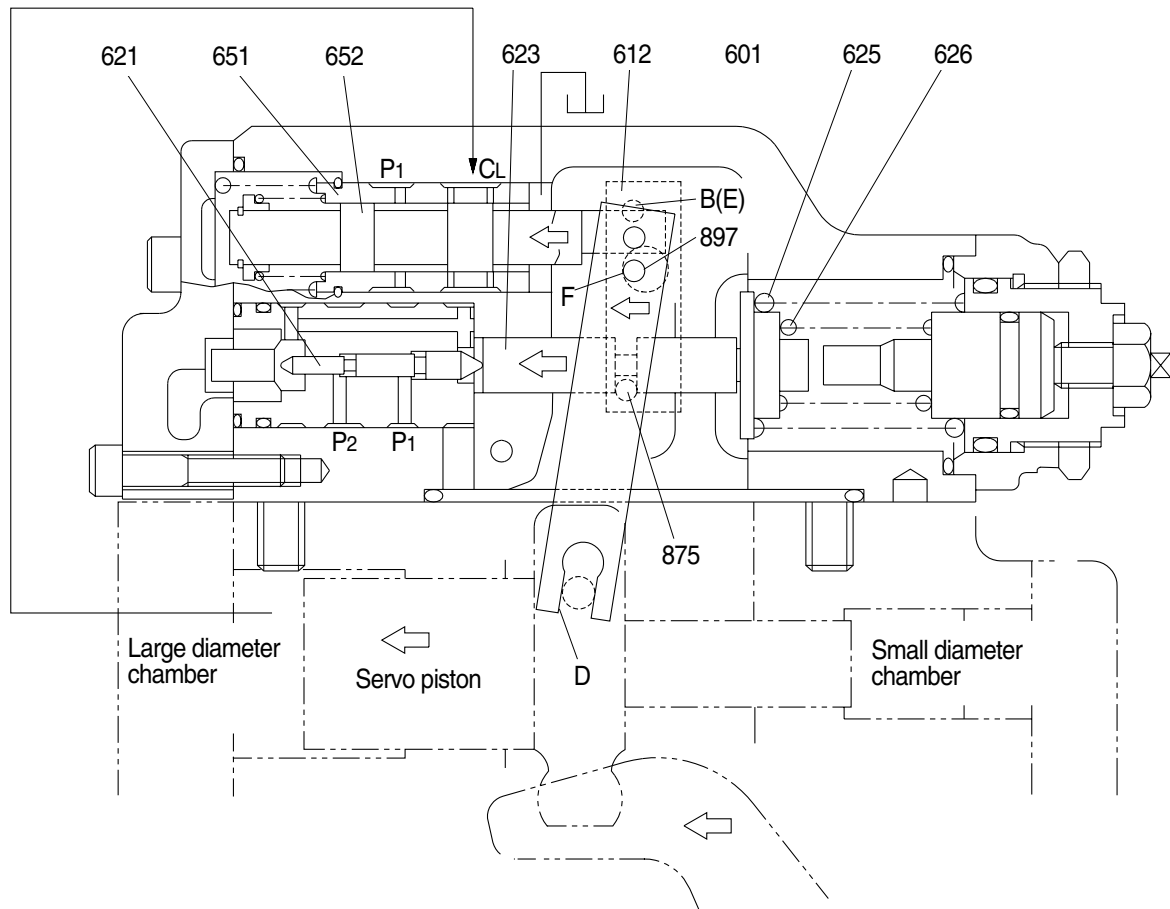
When the self pump delivery pressure P1 or the companion pump delivery pressure P2 rises, it acts on the stepped part of the compensating piston(621). It presses the compensating rod(623) to the right till the force of the outer spring(625) and inner spring(626) balances with the hydraulic force. The movement of the compensating rod is transmitted to lever 1(612) via pin(875).

Lever 1 rotates around the pin(875) (E) fixed to the casing(601).

Since the large hole section(F) of lever 1 contains a protruding pin(897) fixed to the feedback lever(611), the feedback lever rotates around the fulcrum of point D as lever 1 rotates, and then the spool(652) is shifted to the right. As the spool moves, the delivery pressure P1 is admitted to the large diameter section of the servo piston via port CL, causes the servo piston move to the right, reduces the pump delivery, flow rate, and prevents the prime mover from being overloaded.

The movement of the servo piston is transmitted to the feedback lever via point D. Then the feedback lever rotates around the fulcrum of point F and the spool is shifted to the left. The spool moves till the opening between the spool(652) and sleeve(651) is closed.

② Flow reset function



2-15

As the self pump delivery pressure P1 or the companion pump delivery pressure P2 decreases, the compensating rod(623) is pushed back by the action of the springs(625 & 626) to rotate lever 1(612) around point E. Rotating of lever 1 causes the feedback lever(611) to rotate around the fulcrum of point D and then the spool(652) to move to the left. As a result, port CL opens a way to the tank port.

This causes the servo piston to move to the left and the pump's delivery rate to increase.

The movement of the servo piston is transmitted to the spool by the action of the feedback mechanism to move it till the opening between the spool and sleeve is closed.

③ Low tilting angle(Low flow) command preferential function

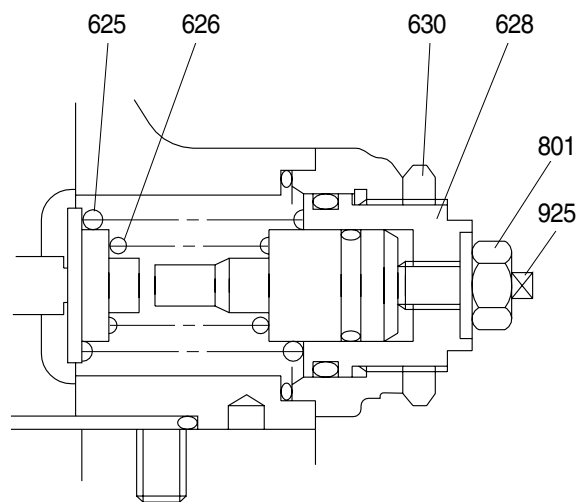
As mentioned above, flow control and horsepower control tilting angle commands are transmitted to the feedback lever and spool via the large-hole sections(C & F) of levers 1 and 2. However, since sections C and F have the pins($\varnothing 4$) protruding from the large hole($\varnothing 8$), only the lever lessening the tilting angle contacts the pin(897) ; the hole($\varnothing 8$) in the lever of a larger tilting angle command is freed without contacting the pin(897). Such a mechanical selection method permits preference of the lower tilting angle command of the flow control and horsepower control.

④ Adjustment of input horsepower

Since the regulator is of total cumulative horsepower type, adjust the adjusting screws of both the front and rear pumps, when changing the horsepower set values. The pressure change values by adjustment are based on two pumps pressurized at the same time, and the values will be doubled when only one pump is loaded.

a. Adjustment of outer spring

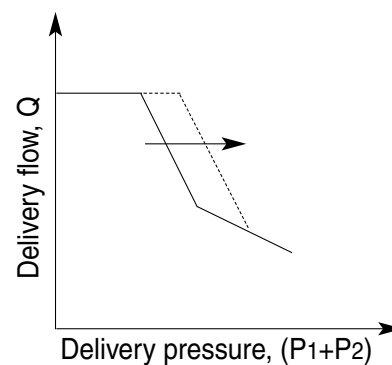
Adjust it by loosening the hexagon nut(630) and by tightening(or loosening) the adjusting screw C(628). Tightening the screw shifts the control chart to the right and increases the input horsepower as shown in the figure. Since turning the adjusting screw C by N turns changes the setting of the inner spring(626), return the adjusting screw QI(925) by $N \times A$ turns at first. ($A=1.71$)



2-16

※ Adjusting values are shown in table

| Speed | Adjustment of flow control characteristic | | |
|----------------------|---|--|--------------------|
| | Tightening amount of adjusting screw(924) | Flow control starting pressure change amount | Flow change amount |
| (min ⁻¹) | (Turn) | (kgf/cm ²) | (l /min) |
| 1950 | +1/4 | +15.9 | +17.3 |



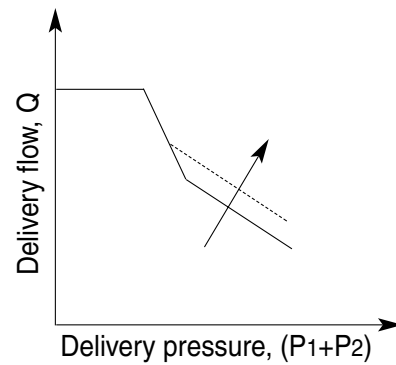
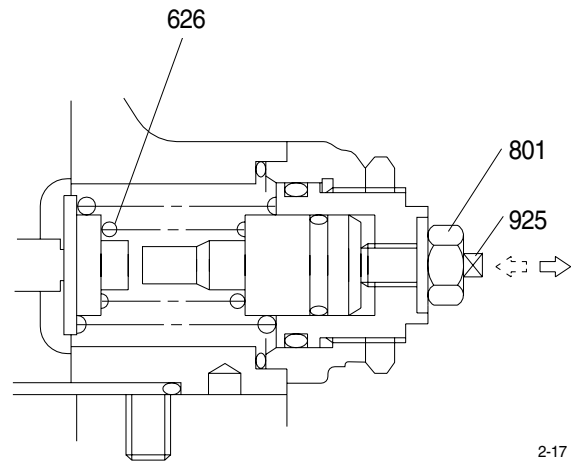
b. Adjustment of inner spring

Adjust it by loosening the hexagon nut (801) and by tightening(or loosening) the adjusting screw QI(925).

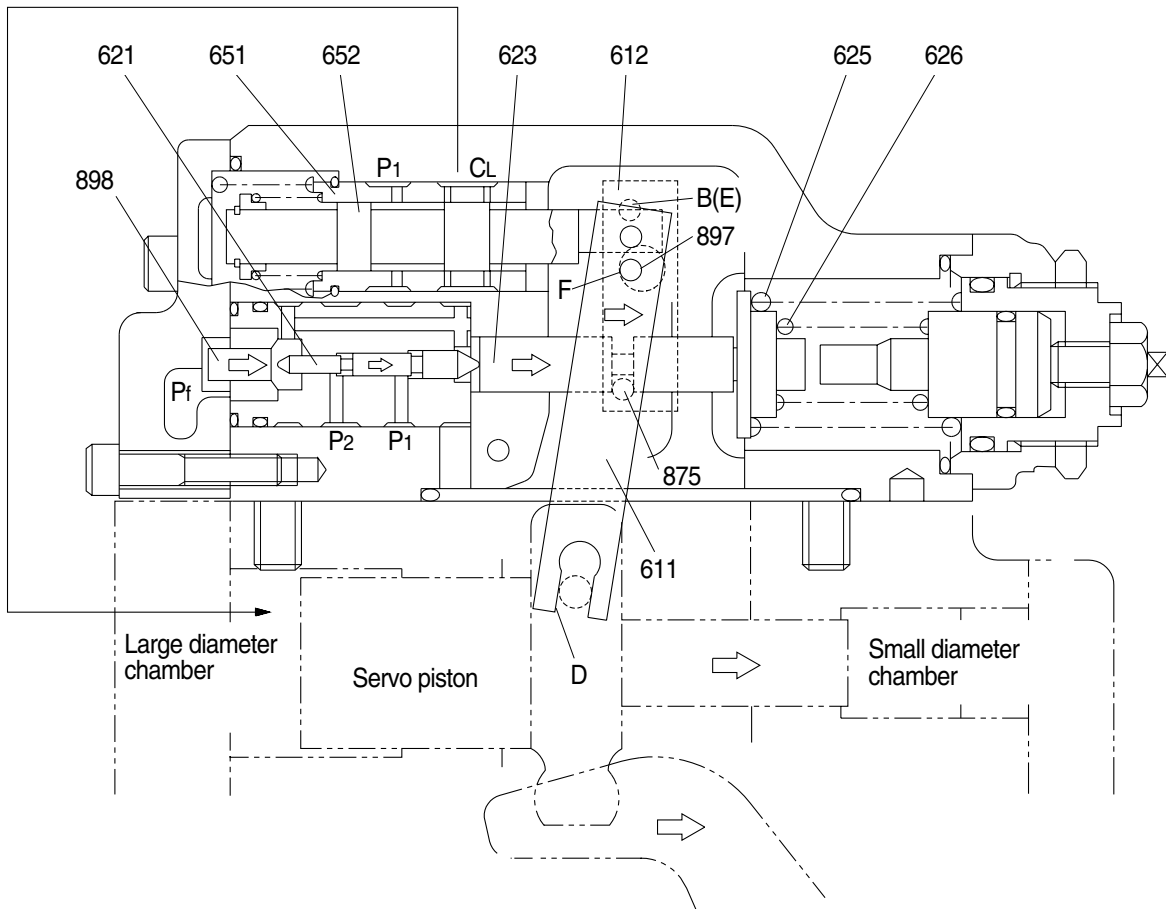
Tightening the screw increases the flow and then the input horsepower as shown in the figure.

※ **Adjusting valves are shown in table**

| Speed | Adjustment of flow control characteristic | | |
|----------------------|---|--------------------|----------------------------|
| | Tightening amount of adjusting screw(925) | Flow change amount | Input torque change amount |
| (min ⁻¹) | (Turn) | (l /min) | (kgf · m) |
| 1950 | +1/4 | +10.1 | +3.46 |



(3) Power shift control



2-18

The set horsepower valve is shifted by varying the command current level of the proportional pressure reducing valve attached to the pump.

Only one proportional pressure reducing valve is provided.

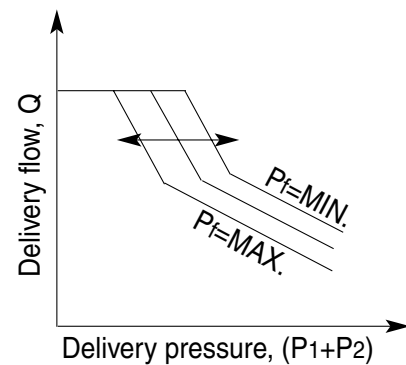
However, the secondary pressure P_f (power shift pressure) is admitted to the horsepower control section of each pump regulator through the pump's internal path to shift it to the same set horsepower level.

This function permits arbitrary setting of the pump output power, thereby providing the optimum power level according to the operating condition.

The power shift pressure P_f controls the set horsepower of the pump to a desired level, as shown in the figure.

As the power shift pressure P_f rises, the compensating rod(623) moves to the right via the pin(898) and compensating piston(621).

This decreases the pump tilting angle and then the set horsepower in the same way as explained in the overload preventive function of the horsepower control. On the contrary, the set horsepower rises as the power shift pressure P_f falls.

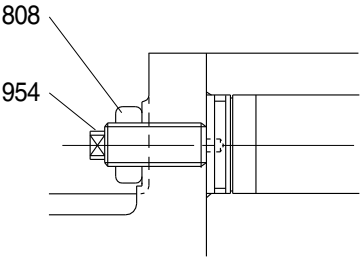


(4) Adjustment of maximum and minimum flows

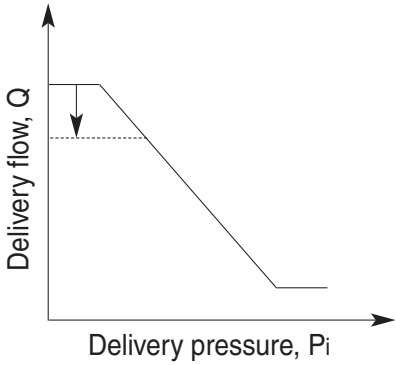
- ① Adjust it by loosening the hexagon nut(808) and by tightening(or loosening) the set screw(954).

The maximum flow only is adjusted without changing other control characteristics.

| Speed | Adjustment of max flow | |
|----------------------|--|--------------------|
| | Tightening amount of adjusting screw (954) | Flow change amount |
| (min ⁻¹) | (Turn) | (l /min) |
| 1950 | +1/4 | -5.6 |



2-19(1)

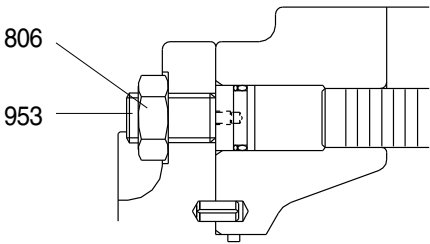


② **Adjustment of minimum flow**

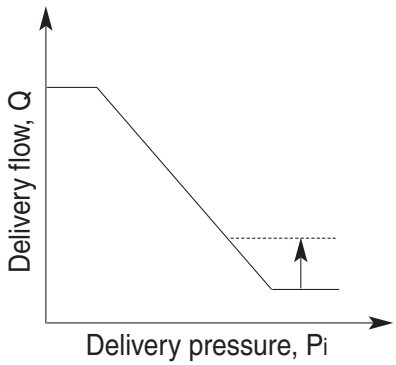
Adjust it by loosening the hexagon nut(808) and by tightening(or loosening) the hexagonal socket head set screw (953). Similarly to the adjustment of the maximum flow, other characteristics are not changed.

However, remember that, if tightened too much, the required horsepower during the maximum delivery pressure(or during relieving) may increase.

| Speed | Adjustment of min flow | |
|----------------------|--|--------------------|
| | Tightening amount of adjusting screw (953) | Flow change amount |
| (min ⁻¹) | (Turn) | (l /min) |
| 1950 | +1/4 | +4.5 |

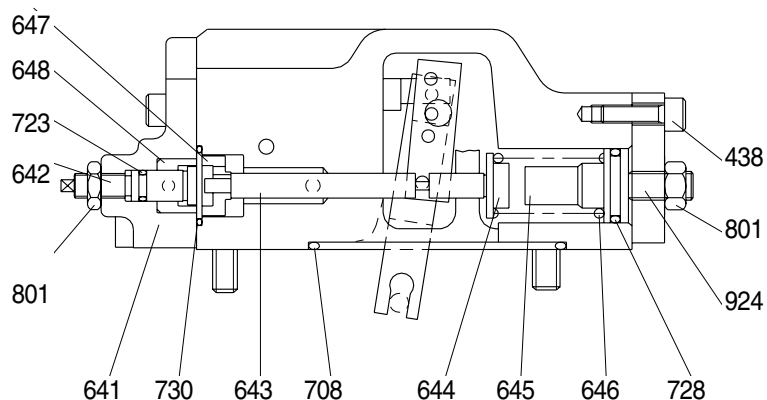


2-19(2)



(5) Qmax cut control

The regulator regulates the maximum delivery flow by inputting the pilot pressure P_m . Since this is a 2-position control method, the maximum delivery flow may be switched in two steps by turning on/off the pilot pressure P_m . (The maximum control flow cannot be controlled in intermediate level.)



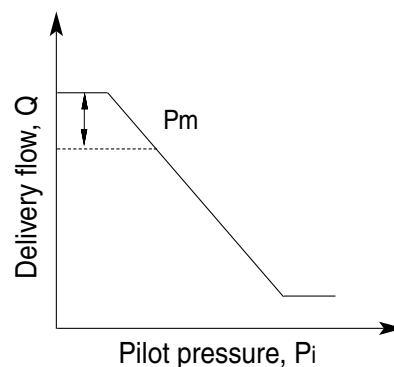
2-4

① Functional explanation

As shown in the figure, the pilot pressure P_m switches the maximum flow in two steps.

When the pilot pressure P_m is given, it is admitted to the lefthand side of the piston QMC(648). The piston QMC moves the stopper(647) and pilot piston(643) to the right, overcoming the force of the pilot spring(646), thereby reducing the delivery flow of the pump.

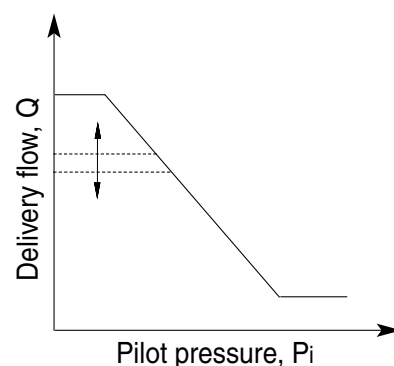
Since the adjusting screw QMC(642) is provided with a flange, the piston QMC stops upon contact with the flange, and the position of the pilot piston at this time determines the maximum flow of the pump.



② Adjustment of Qmax cut flow

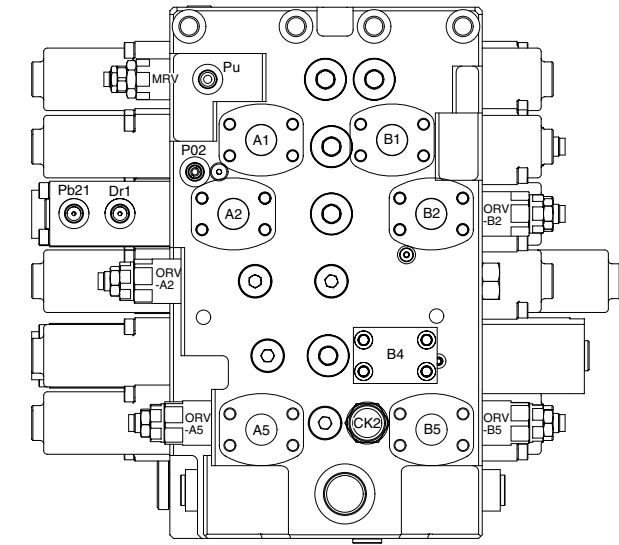
Adjust it by loosening the hexagon nut(801) and by tightening(or loosening) the adjusting screw QMC(642).

Tightening the screw decreases the Qmax cut flow as shown in the figure.

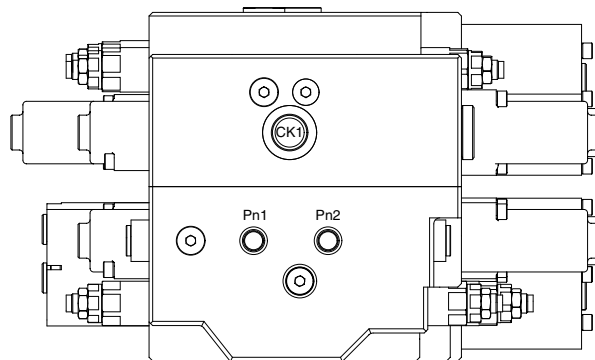
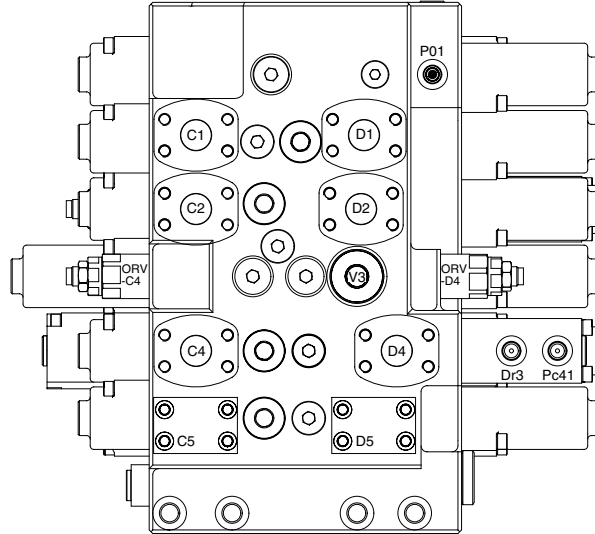
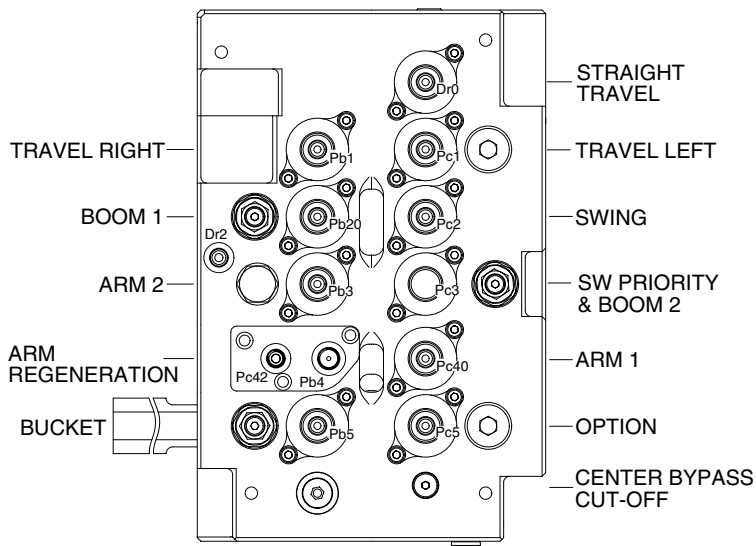
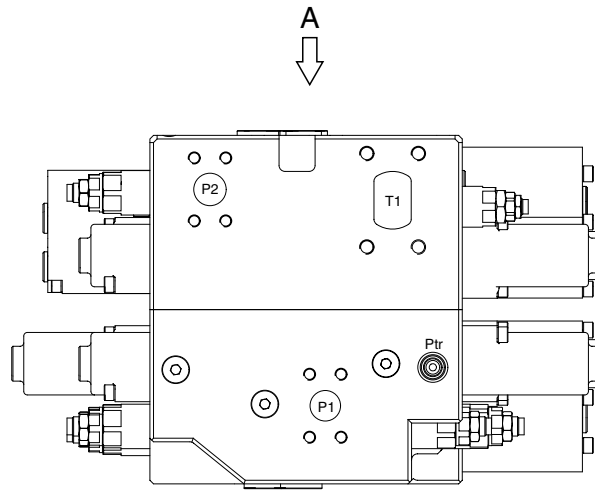


GROUP 2 MAIN CONTROL VALVE

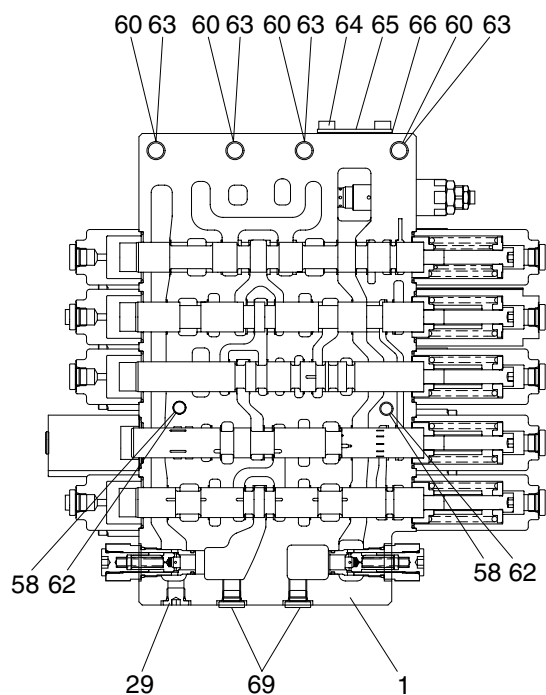
1. STRUCTURE



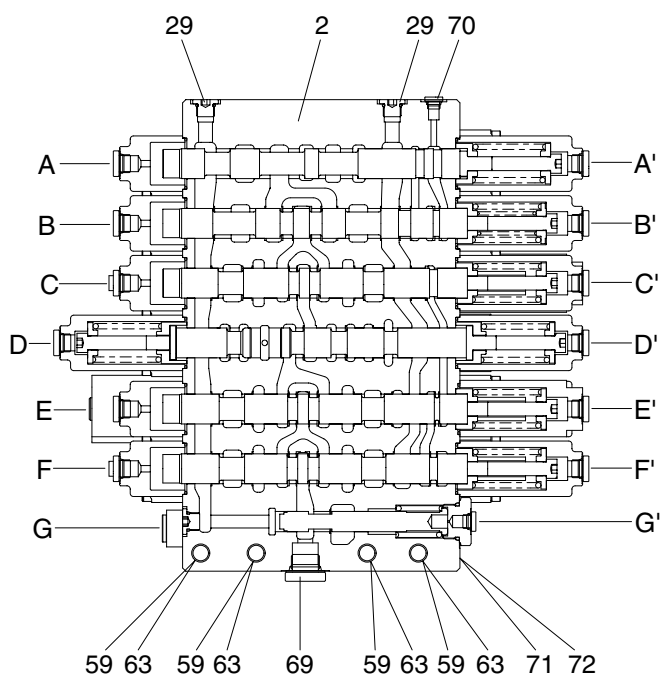
VIEW A



| Mark | Port name | Port size | Tightening torque |
|---|--|--------------------------|---|
| Rs | Make up for swing motor | G1 | 20~25 kgf · m (145~180 lbf · ft) |
| Patt Pb21 Pcb P01 P02 Pc41 Pc42 Ptr Pu Dr1 Dr2 | Auto idle signal-attachment Lock valve pilot port (boom) Bucket in confluence pilot port Pilot signal port Pilot signal port Unlock signal Arm in regen-cut signal selector port Auto idle signal-travel Power boost Drain port Drain port | G1/4 | 3.5~3.9 kgf · m (25.3~28.2 lbf · ft) |
| Ck1 Ck2 | Bucket confluence Bucket confluence | G3/4 | 17~19 kgf · m (123~137.4 lbf · ft) |
| Pa1 Pb1 Pc1 Pd1 Pa20 Pa21 Pb20 Pc2 Pd2 Pb3 Pc3 Pa4 Pb4 Pc40 Pd40 Pd41 Pa5 Pb5 Pc5 Pd5 Dr0 Pn1 Pn2 | Travel pilot port-RH (FW) Travel pilot port-RH (BW) Travel pilot port-LH (BW) Travel pilot port-LH (FW) Boom up pilot port Boom up confluence pilot port Boom down pilot port Swing pilot port (LH) Swing pilot port (RH) Arm in confluence pilot port Swing priority pilot port Option A pilot port (breaker) Arm in regeneration cut port Arm in pilot port Arm out pilot port Arm out confluence pilot port Bucket in pilot port Bucket out pilot port Option B pilot port Option B pilot port Drain port Negative control signal port (A2 port side) Negative control signal port (A1 port side) | G3/8 | 7~8 kgf · m (50.6~57.8 lbf · ft) |
| A1 B1 C1 D1 A2 B2 C2 B4 C4 D4 A5 B5 C5 D5 P1 P2 | Travel motor port-LH (FW) Travel motor port-LH (BW) Travel motor port-RH (BW) Travel motor port-RH (FW) Boom up port Boom down port Swing motor port (LH) Swing motor port (RH) Option A port (breaker) Arm in port Arm out port Bucket in port Bucket out port Option B port Option B port Pump port (A2 side) Pump port (A1 side) | SAE 5000 psi 1" | 7.5~9.2 kgf · m (54.2~66.5 lbf · ft) |
| Dr5 | Drain port | G1/8 | 1.5~1.9 kgf · m (10.8~13.7 lbf · ft) |
| T1 | Return port | SAE 3000 psi 2" (M12) | 6.4~8.6 kgf · m (46.2~62.2 lbf · ft) |

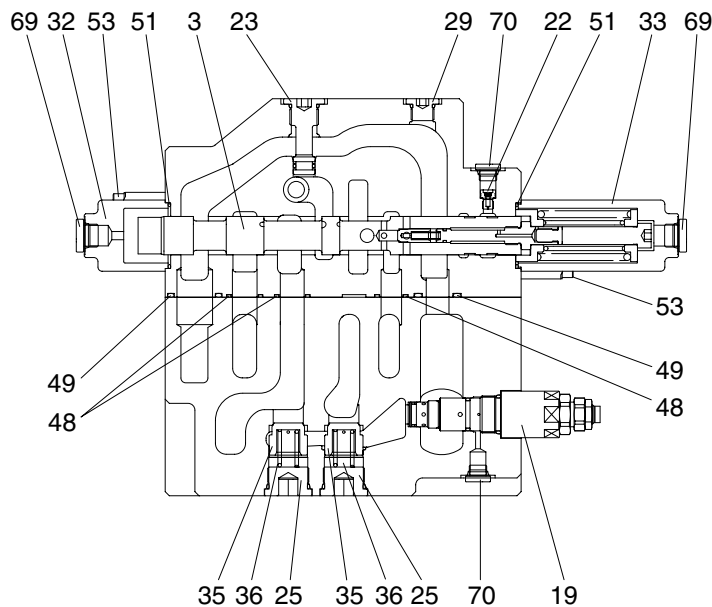


P1 BLOCK SPOOL SECTION

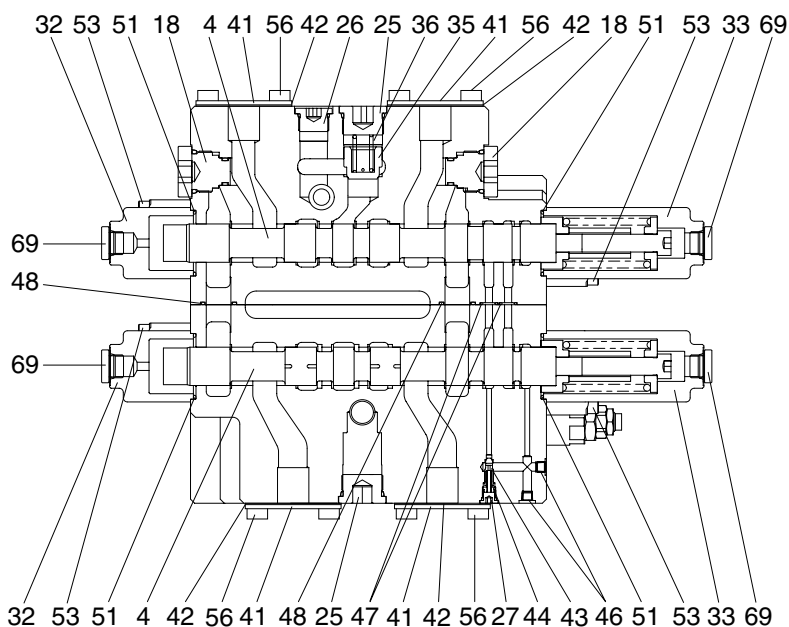


P2 BLOCK SPOOL SECTION

- 1 Housing P1
- 2 Housing P2
- 29 Plug kit
- 58 Socket bolt
- 59 Socket bolt
- 60 Socket bolt
- 62 Spring washer
- 63 Spring washer
- 64 Hexagon bolt
- 65 Cover 2
- 66 Gasket 2
- 69 Dust cap
- 70 Dust cap
- 71 Name plate
- 72 Rivet

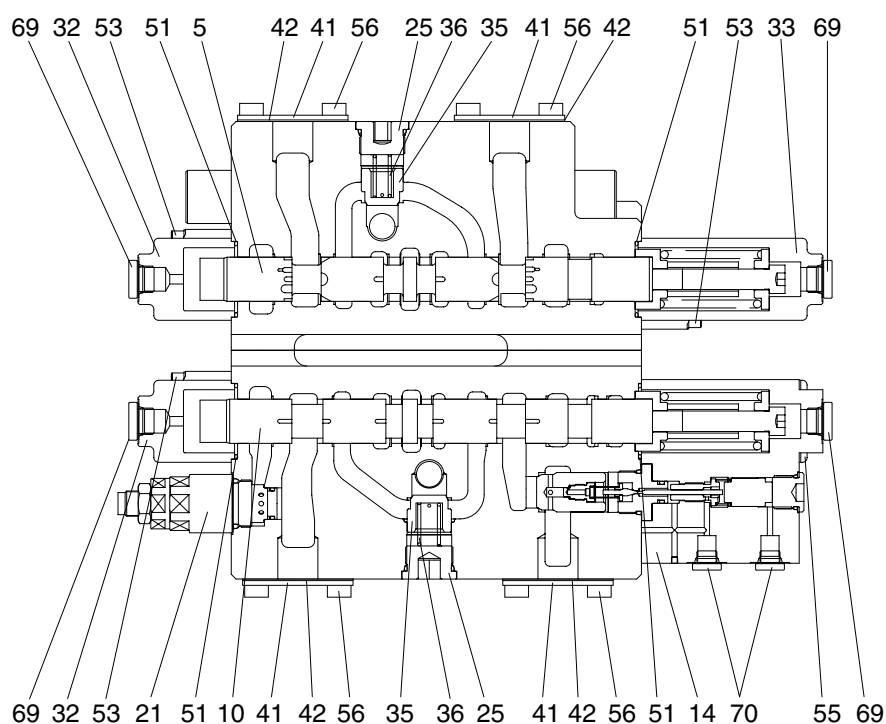


SECTION A-A' (STRAIGHT-TRAVEL & SUPPLY)



SECTION B-B' (TRAVEL RIGHT & LEFT)

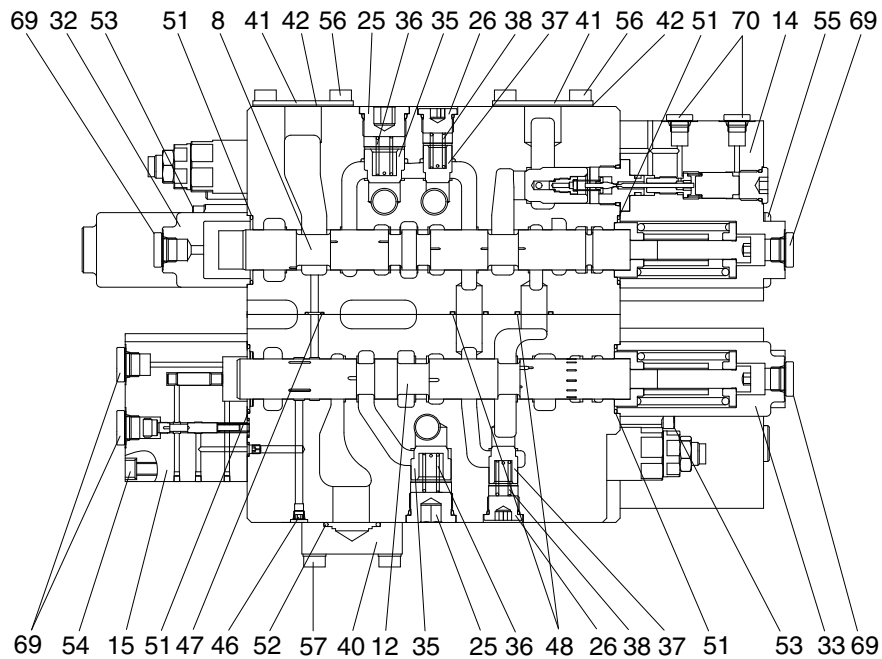
- 3 Spool assy
- 4 Spool assy
- 18 Overload R/V plug assy
- 19 Main relief valve assy
- 22 Signal orifice assy
- 23 Parallel block plug assy
- 25 Load check plug kit
- 27 Plug kit
- 29 Plug kit
- 32 Pilot cover A
- 33 Pilot cover B1
- 35 Load check poppet 1
- 36 Load check spring 1
- 41 Cover 1
- 42 Gasket 1
- 43 Poppet signal
- 44 Spring signal
- 46 Plug
- 47 O-ring
- 48 O-ring
- 49 O-ring
- 51 O-ring
- 53 Socket bolt
- 56 Hexagon bolt
- 69 Dust cap
- 70 Dust cap



SECTION C-C' (SWING & BOOM 1)

2107V2MC42

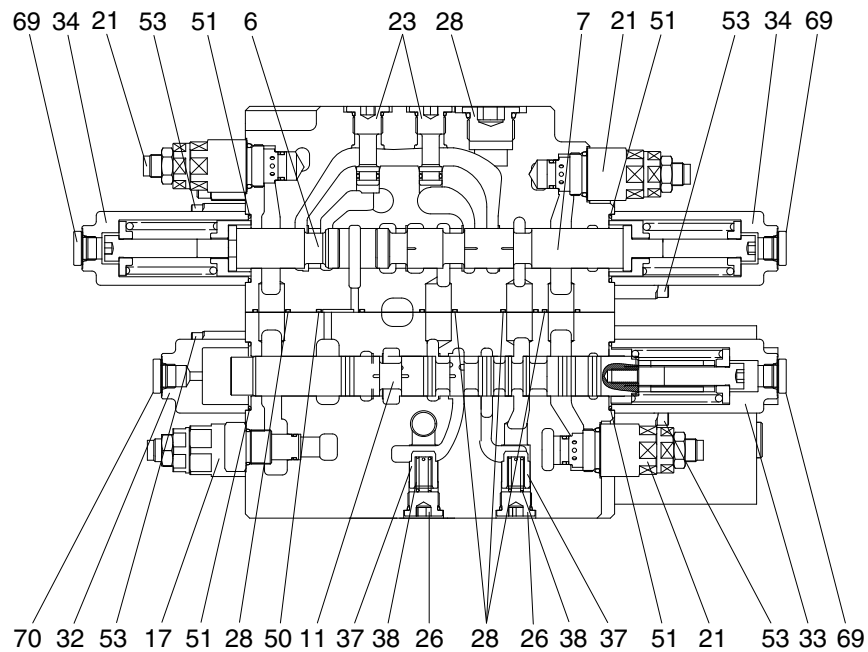
| | | | | | |
|----|----------------------|----|---------------------|----|--------------|
| 5 | Swing spool assy | 33 | Pilot cover B1 | 53 | Socket bolt |
| 10 | Boom 1 spool | 35 | Load check poppet 1 | 55 | Socket bolt |
| 14 | Holding valve assy | 36 | Load check spring 1 | 56 | Haxagon bolt |
| 21 | Overload relief assy | 41 | Cover 1 | 69 | Dust cap |
| 25 | Load check plug kit | 42 | Gasket 1 | 70 | Dust cap |
| 32 | Pilot cover A | 51 | O-ring | | |



SECTION E-E ' (ARM 1 & ARM REGENERATION)

2107V2MC44

| | | | | | |
|----|----------------------|----|---------------------|----|---------------|
| 8 | Arm 1 spool assy | 37 | Load check poppet 1 | 53 | Socket bolt |
| 12 | Arm regen spool assy | 38 | Load check spring 2 | 54 | Socket bolt |
| 14 | Holding valve assy | 40 | Flange | 55 | Socket bolt |
| 15 | Regen valve assy | 41 | Cover 1 | 56 | Hexagon bolt |
| 25 | Load check plug kit | 42 | Gasket 1 | 57 | Socket bolt |
| 26 | Load check plug kit | 46 | Plug | 62 | Spring washer |
| 32 | Pilot cover A | 47 | O-ring | 69 | Dust cap |
| 33 | Pilot cover B1 | 48 | O-ring | 70 | Dust cap |
| 35 | Load check poppet 1 | 51 | O-ring | | |
| 36 | Load check spring 1 | 52 | O-ring | | |

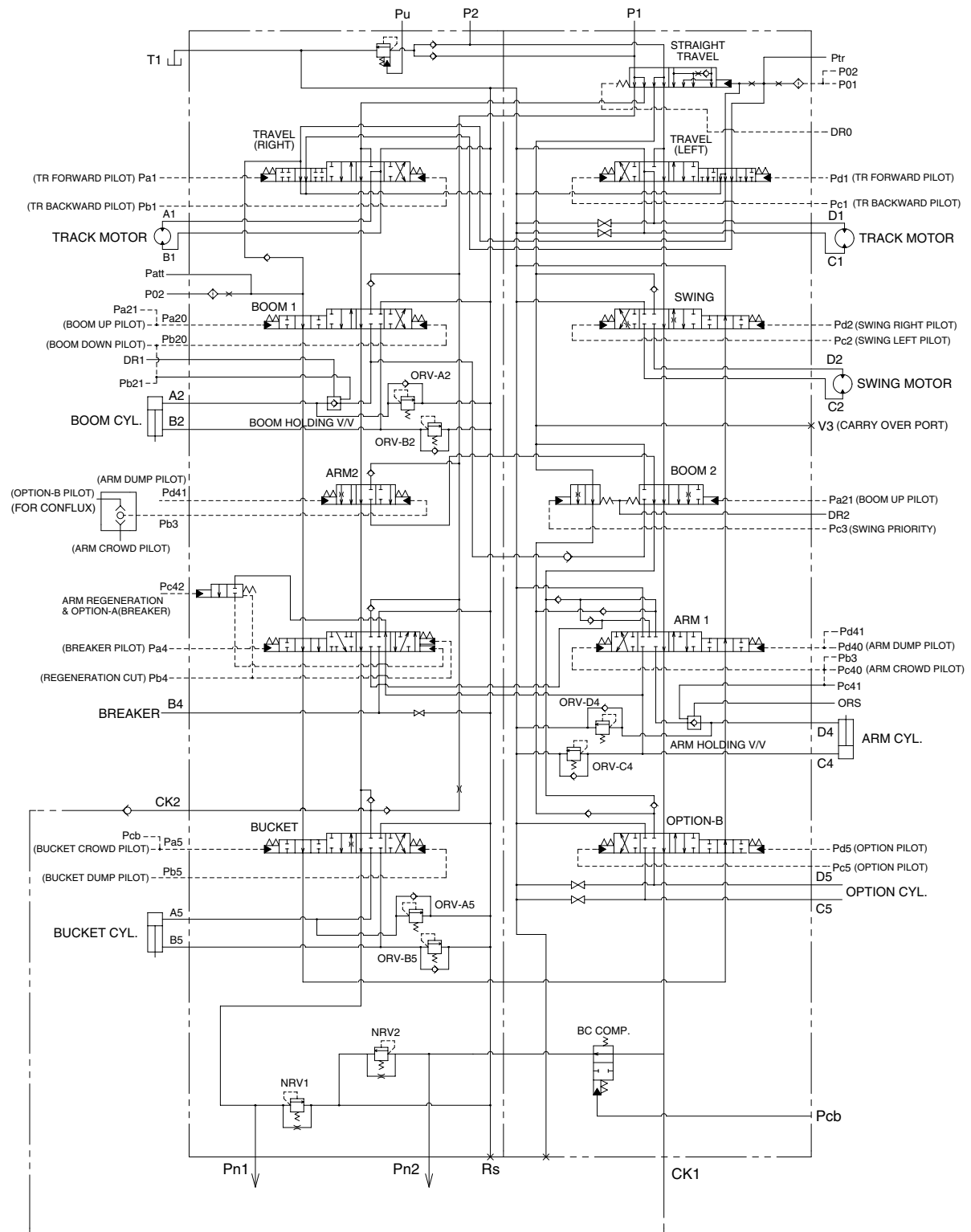


SECTION D-D ' (SWING PRIORITY & BOOM 2 & ARM 2)

D21072MC43

| | | | | | |
|----|---------------------------|----|---------------------|----|---------------------|
| 6 | Swing priority spool assy | 26 | Load check plug kit | 38 | Load check spring 2 |
| 7 | Boom 2 spool assy | 28 | Plug kit | 50 | O-ring |
| 11 | Arm 2 spool assy | 32 | Pilot cover A | 51 | O-ring |
| 17 | Overload relief plug assy | 33 | Pilot cover B1 | 53 | Socket bolt |
| 21 | Overload relief assy | 34 | Pilot cover B2 | 69 | Dust cap |
| 23 | Parallel block plug assy | 37 | Load check poppet 2 | | |

2. HYDRAULIC CIRCUIT



D21072MC02

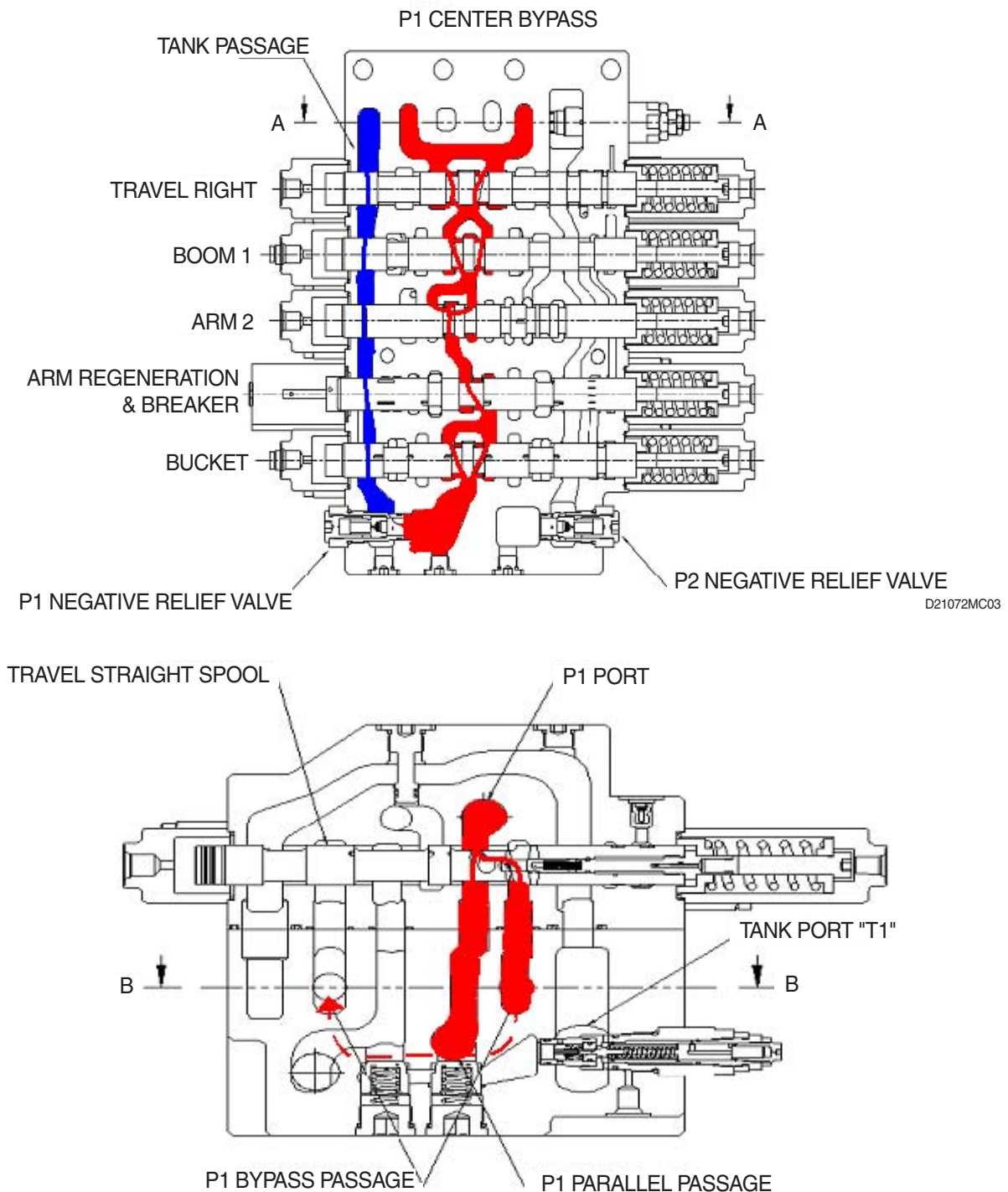
3. FUNCTION

1) CONTROL IN NEUTRAL

(1) P1 SIDE

The hydraulic fluid from pump flows into the main control valve through the inlet port "P1", pass the land of the travel straight spool, into the P1 bypass passage and P1 parallel passage.

When the straight travel spool is in neutral position, the bypass passage is not shut off. Then the hydraulic fluid from the pump P1 is directed to the tank through the bypass passage of spools : travel right, boom 1, arm 2, arm regeneration & option A and bucket, the negative relief valve of P1, tank passage, and the tank port "T1"

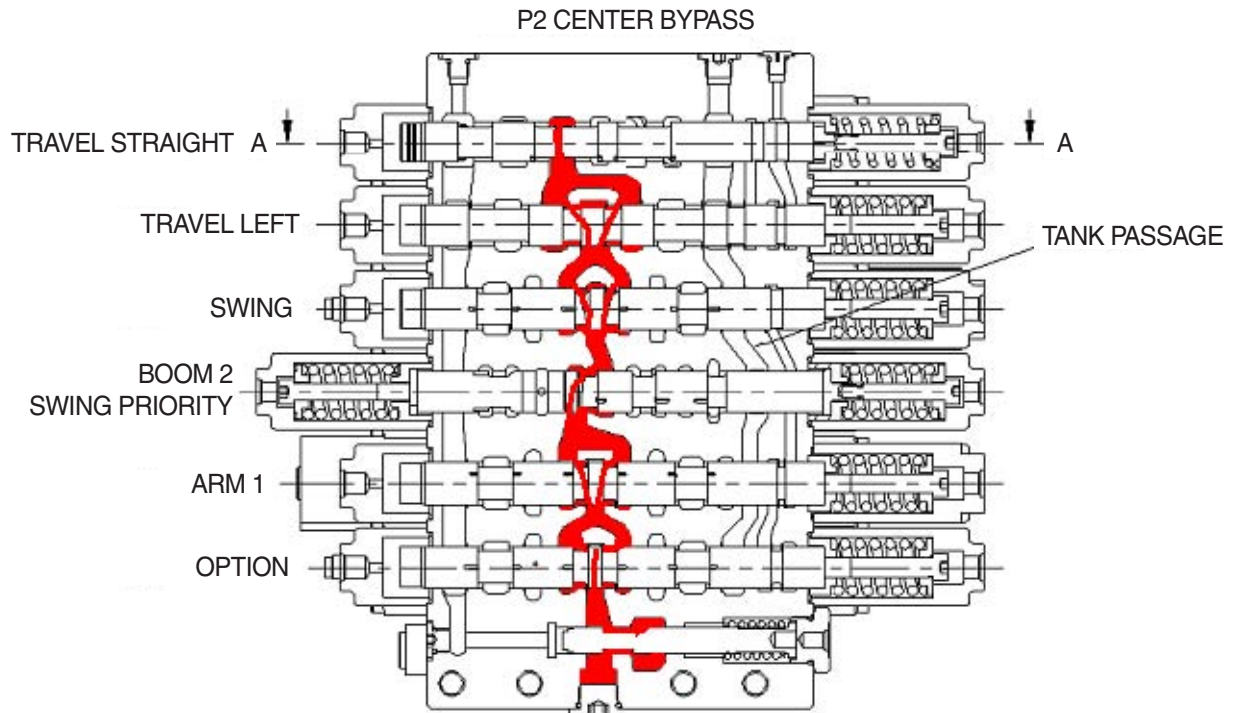


D21072MC03A

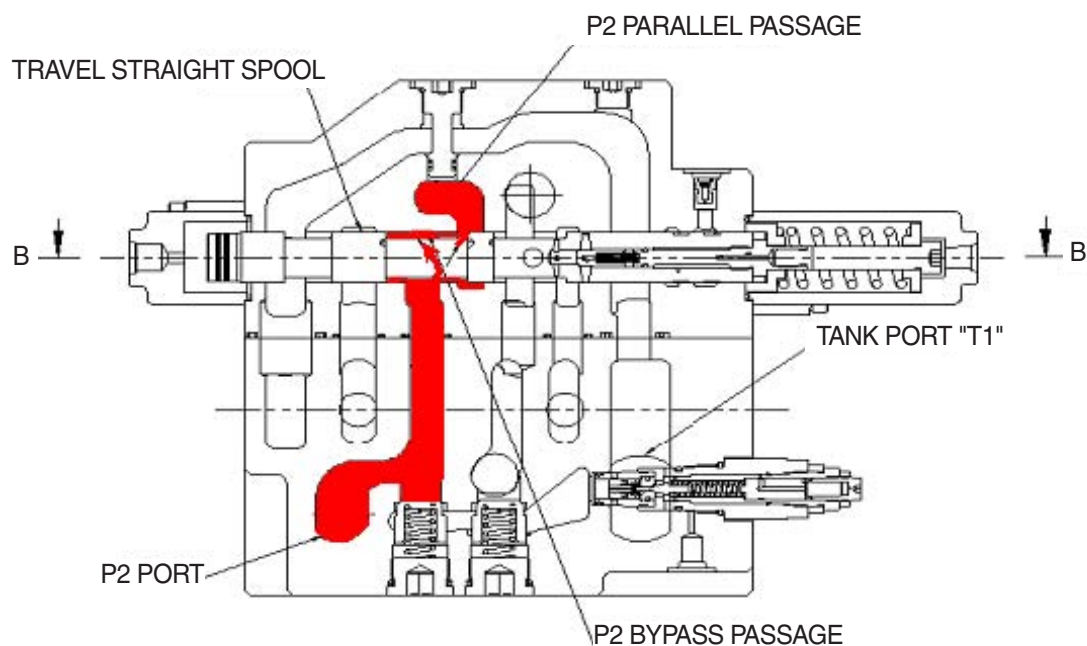
(2) P2 SIDE

The hydraulic fluid from pump flows into the main control valve through the inlet port "P2", pass the land of the straight travel spool, into the P2 bypass passage and P2 parallel passage.

When the straight travel spool is in neutral position, the bypass passage is not shut off. Then the hydraulic fluid from the pump P2 is directed to the tank through the bypass passage of spools : travel left, swing, boom 2 & swing priority, arm 1, option "B" and bucket summation and the negative relief valve of P2, the tank passage and the tank port "T1".



D21072MC05



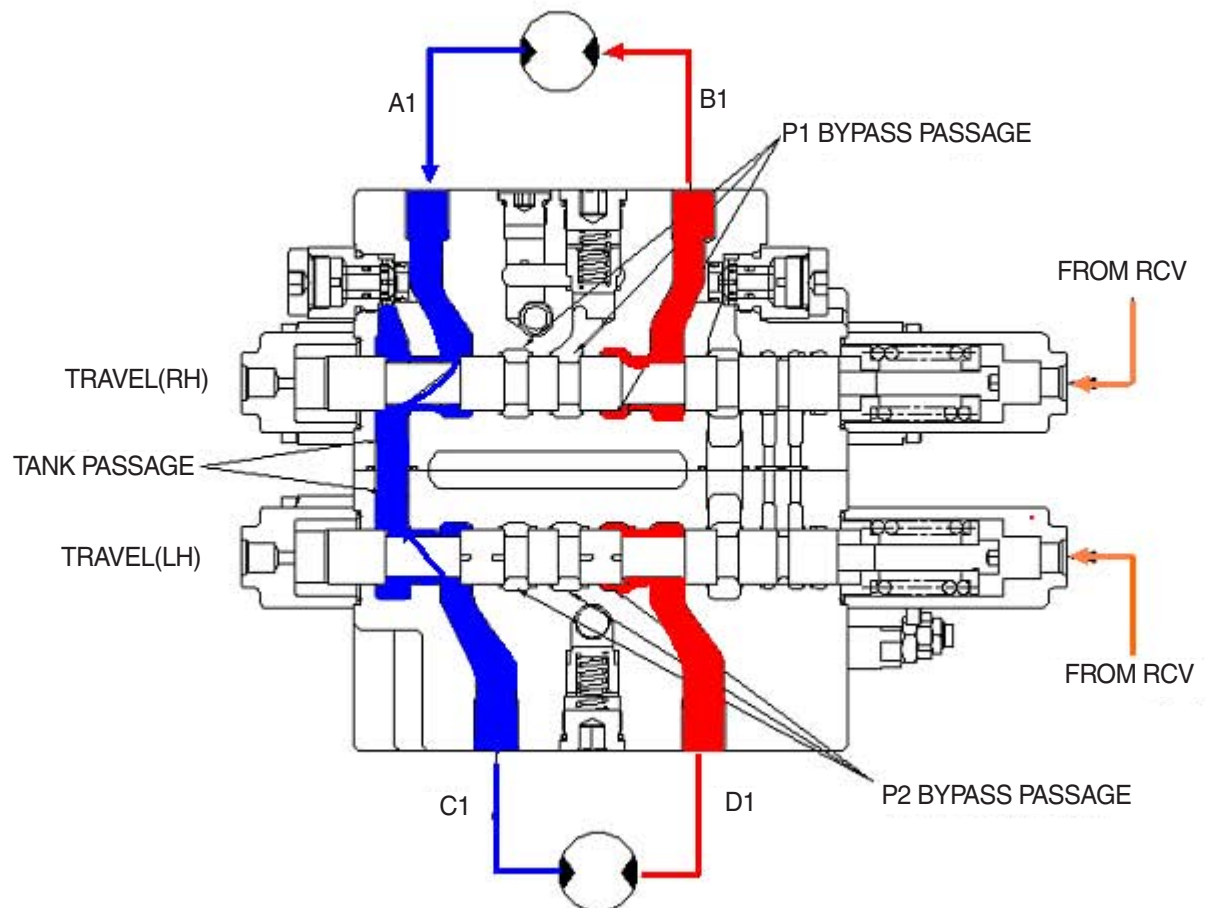
D21072MC04

2) TRAVEL OPERATION

(1) TRAVEL FORWARD OPERATION

During the travel forward operation, the pilot pressure of RCV is supplied to the port of the spring side, and it shifts travel right and left spools in the left direction against springs. Hydraulic fluid from the pump flows into the bypass passage of travel spool through the land of the straight travel spool.

Then the bypass passage is shut off by the movement of the spool, they are directed to the each travel motor through port B1 and D1. At the same time, the hydraulic fluid from the each travel motor through port A1 and C1 returns to the tank passage through the travel spools.

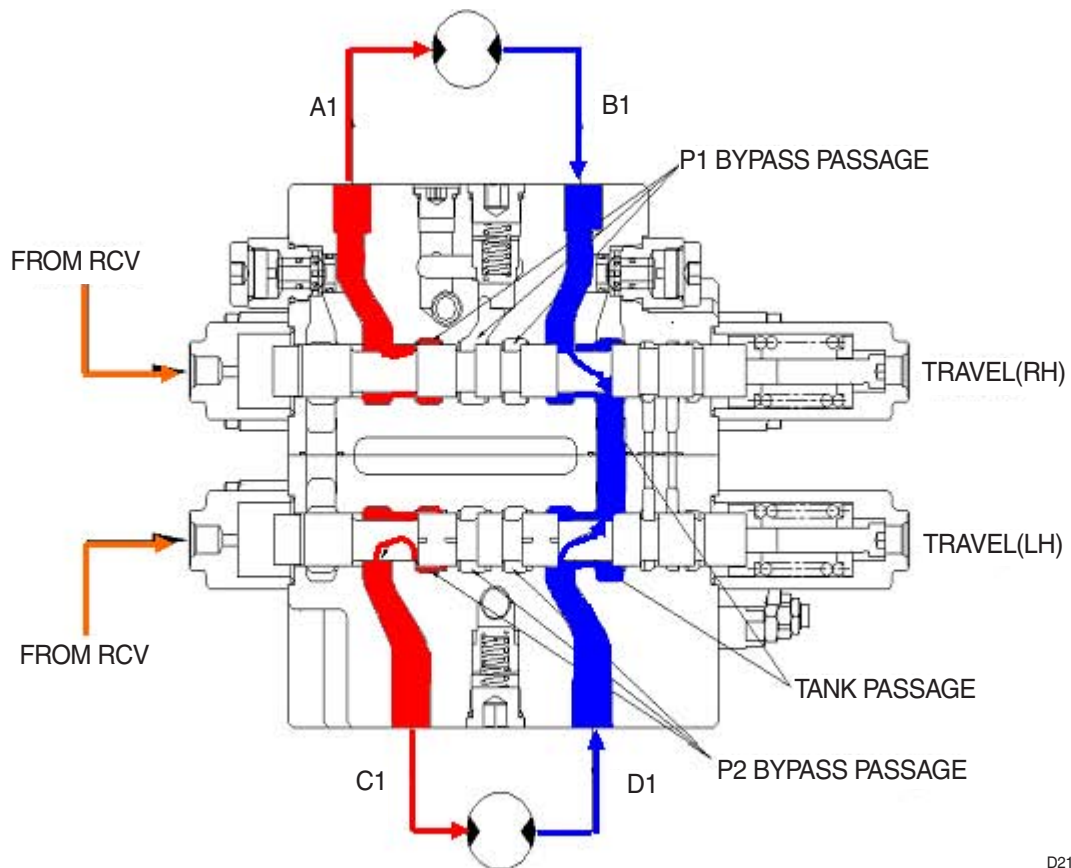


D21072MC06

(2) TRAVEL REVERSE OPERATION

During the travel reverse operation, the pilot pressure of RCV is supplied to the port of the spring opposite side, and it shifts travel right and left spools in the right direction against springs. Hydraulic fluid from the pump flows into the bypass passage of travel spool through the land of the straight travel spool.

Then the bypass passage is shut off by the movement of the spool, they are directed to the each travel motor through port A1 and C1. At the same time, the hydraulic fluid from the each travel motor through port B1 and D1 returns to the tank passage through the travel spools.



D21072MC07

(3) TRAVEL STRAIGHT FUNCTION

This function keeps straight travel in case of simultaneous operation of other actuators (boom, arm, bucket, swing) during a straight travel.

① During travel only :

The hydraulic fluid of the pump P1 is supplied to the RH travel motor and the pump P2 is supplied to the LH travel motor.

Thus, the machine keep travel straight.

② The other actuator operation during straight travel operation :

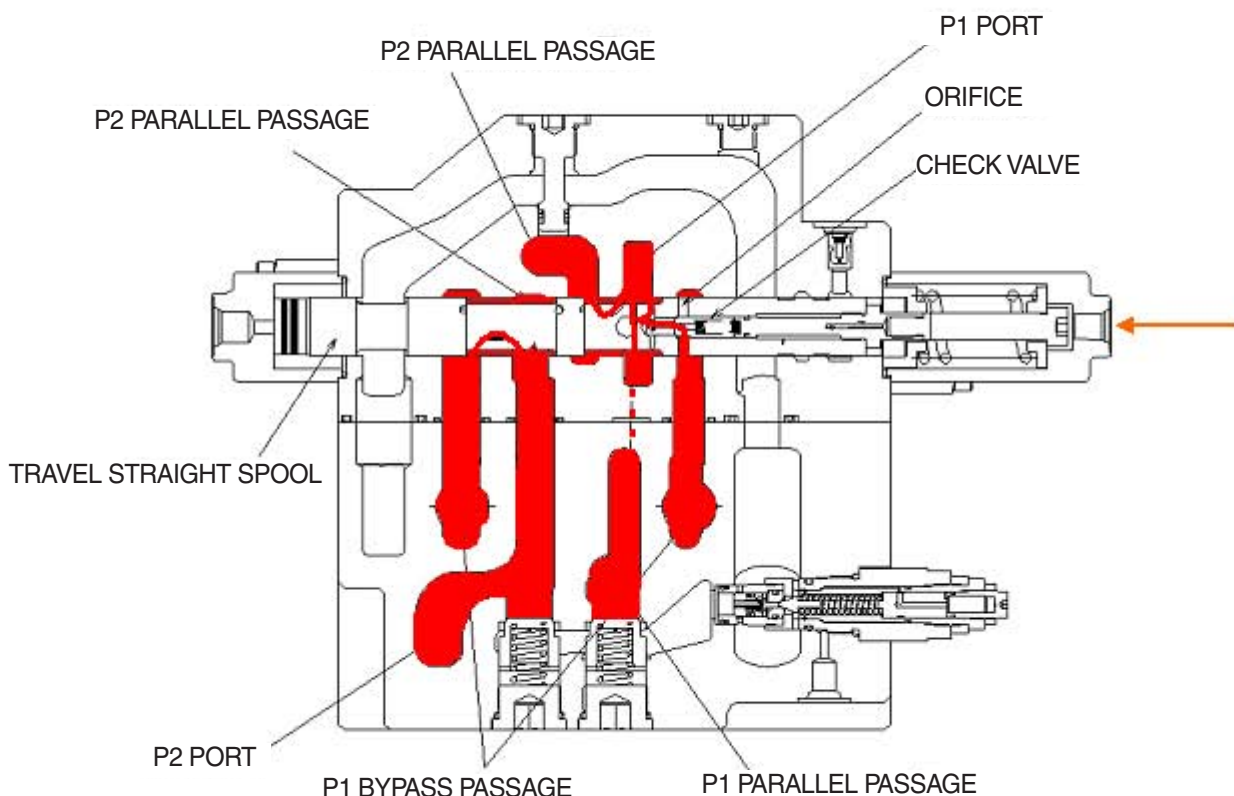
When the other actuator spool (S) is selected under straight travel operation, the straight travel spool is moved.

The hydraulic fluid from pump P1 is supplied actuator through P1 and P2 parallel pass and travel motors through orifice at side of straight travel spool.

The hydraulic oil fluid from pump P2 is supplied to travel motors (left/right).

Therefore, the other actuator operation with straight travel operation, hydraulic oil fluid from pump P1 is mainly supplied to actuator, and the hydraulic oil fluid form pump P2 is mainly supplied to travel motors (left/right).

Then the machine keeps straight travel.



D21072MC08

3) BOOM OPERATION

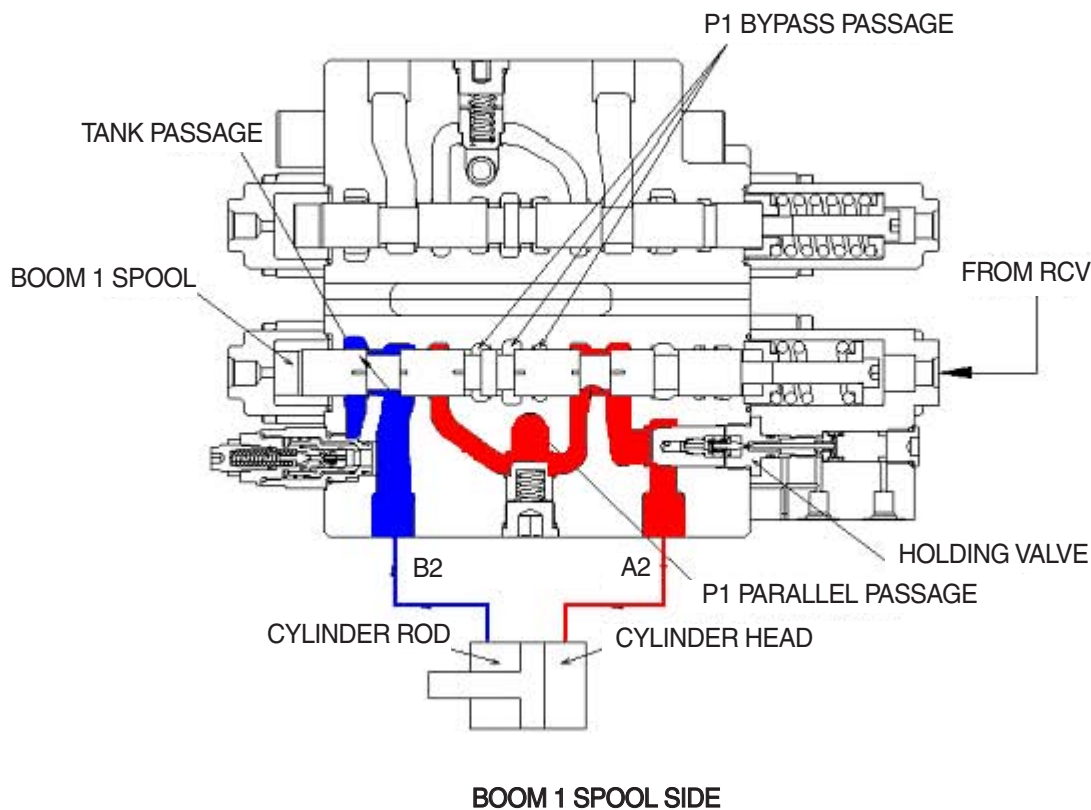
(1) BOOM UP OPERATION

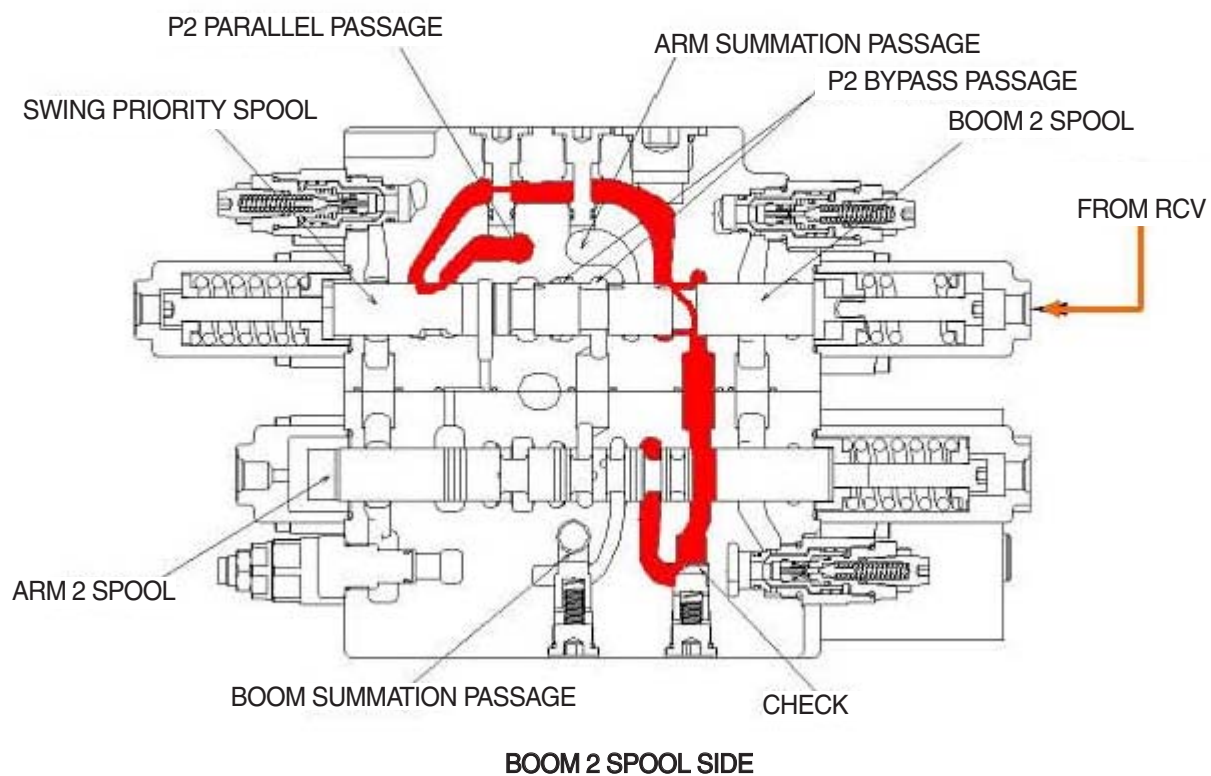
During boom up operation, the pilot secondary pressure from RCV is supplied to the port of the spring side and shifts the boom 1 spool in the left direction. The bypass passage is shut off by the movement of the spool and the hydraulic oil fluid from pump P1 is entered P1 parallel passage and then passes through the load check valve, bridge passage and boom holding valve then flows into the port A2.

Following this it flows into the head side of the boom cylinder.

(In this case, the boom holding valve is free flow condition)

At the same time, the pilot pressure from RCV is supplied to the port of the spring side of boom 2 and shifts the boom 2 spool. The bypass passage is shut off by the movement of the spool and the hydraulic oil fluid from pump P2 entered boom summation passage via the P2 parallel passage, the land of the swing priority spool, notch of the boom 2 spool, arm 2 spool and the check. The flows combine in passage and are directed to port A2 and head side of boom cylinder. At the same time, the flow from rod side of the boom cylinder return to the boom 1 spool through the port B2. There after it is directed to the hydraulic oil tank through the tank passage.





D21072MC10

(2) BOOM DOWN OPERATION

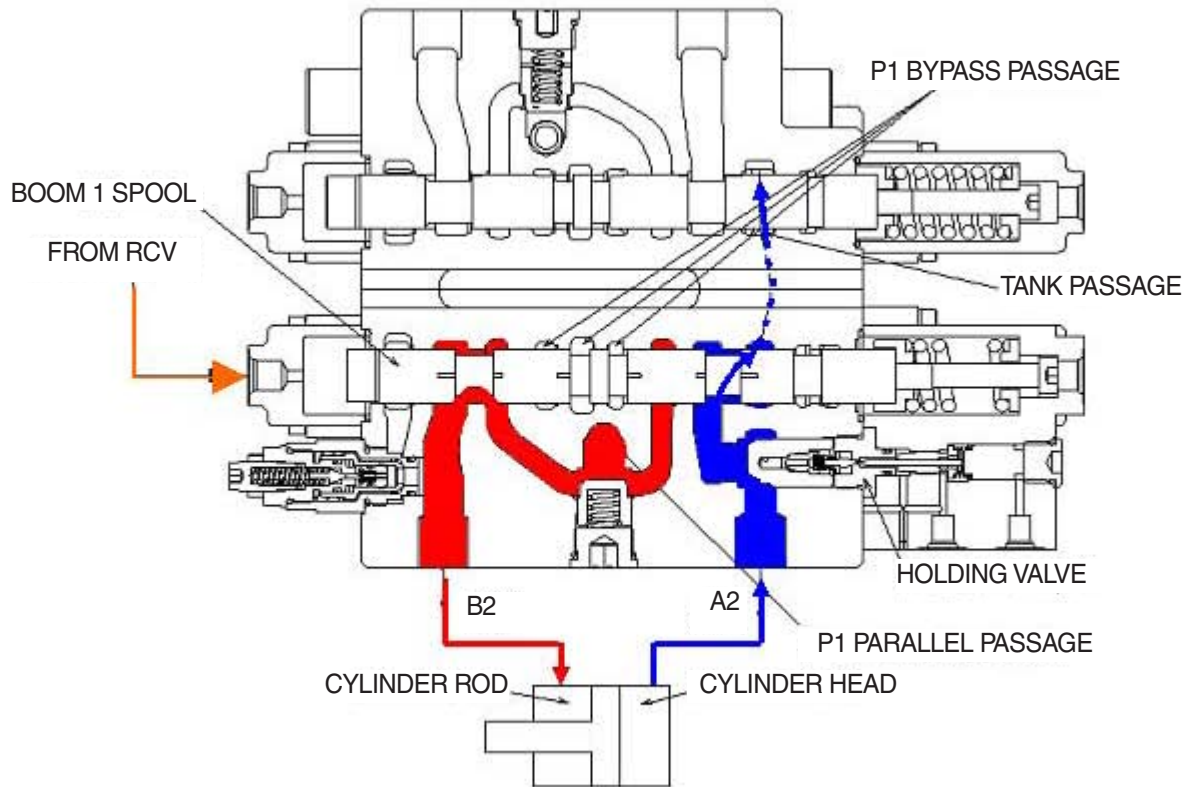
During the boom lowering operation, the pilot pressure from RCV is supplied to the port of the spring opposite side and shifts the boom 1 spool in the right direction.

The bypass passage is shut off by the movement of the spool and the hydraulic fluid from the pump P1 enters the parallel passage and is directed to the port B2 through the load check valve. Following this, it flows into the rod side of the boom cylinder.

At the same time, the return flow from the head side of the boom cylinder returns to the port A2 and boom holding valve. And it is directed to the hydraulic oil tank through opened tank passage by movement of the boom 1 spool.

In this case, the holding valve is open condition, for details of the boom holding valve, see page following page.

During the boom lowering operation, the fluid from P2 pump is not summation.



D21072MC11

4) HOLDING VALVE OPERATION

(1) HOLDING OPERATION

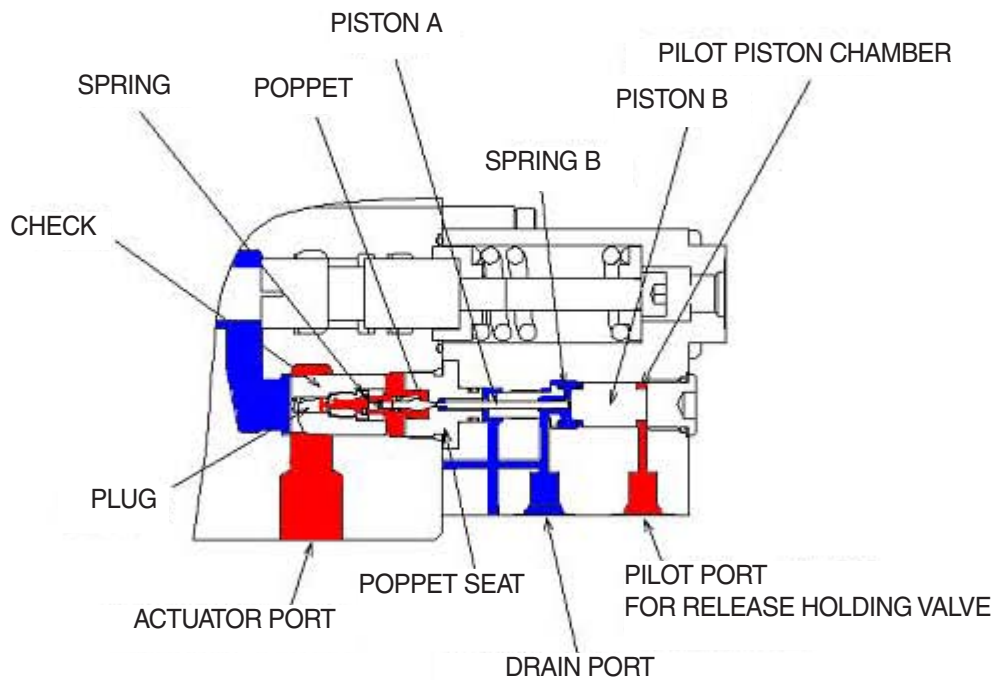
At neutral condition, the pilot piston chamber is connected to drain port through the pilot port.

And the piston "B" is supported with spring "B".

Also, the pressured fluid from actuator entered to inside of the holding valve through the periphery hole of check, crevice of the check and the plug and the periphery hole of plug.

Then, this pressured oil pushed the poppet to the poppet seat and the check to the seat of body.

So the hydraulic fluid from actuator is not escaped and the actuator is not moved.



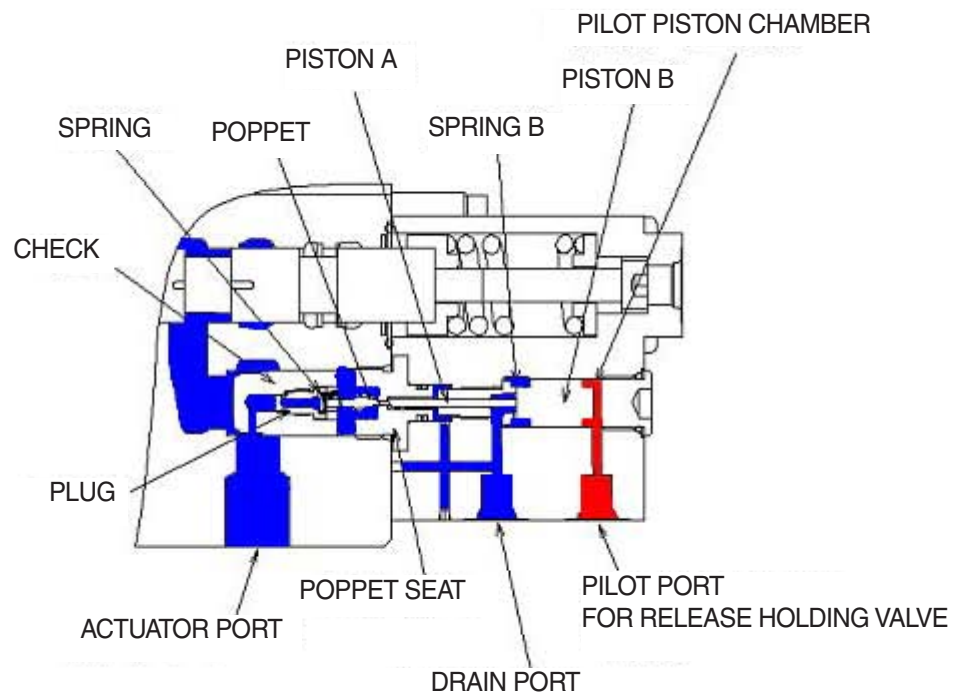
D21072MC12

(2) RELEASE HOLDING OPERATION

The pilot pressure is supplied to the pilot port for release holding valve and shifts the piston "B" in the left direction against the spring "B", and shifts the poppet in the left direction through piston "B" and piston "A" against spring "B" and shifts the spool in the left side.

At same time, the return fluid from actuator returns to the drain port through the periphery hole of check, crevice of the check and the plug, the periphery hole of the plug, in side of holding valve, crevice of the poppet and the poppet seat, the periphery hole of the poppet seat and internal passage of spool.

When the poppet is opened, pressure of inside of holding valve is decreased and the return fluid from actuator returns to the tank passage through the internal passage of spool.



D21072MC13

5) BUCKET OPERATION

(1) BUCKET IN OPERATION

① Bucket operation only

During the bucket in operation, the pilot secondary pressure from RCV is supplied to port of the spring side and shifts the bucket spool in the left direction.

The bypass passage is shut off by the movement of the spool and the hydraulic fluid from pump P1 entered P1 parallel passage and is directed to the port A5 through the check1.

At the same time, the hydraulic fluid from P1 bypass passage is directed to the port A5 through the check2.

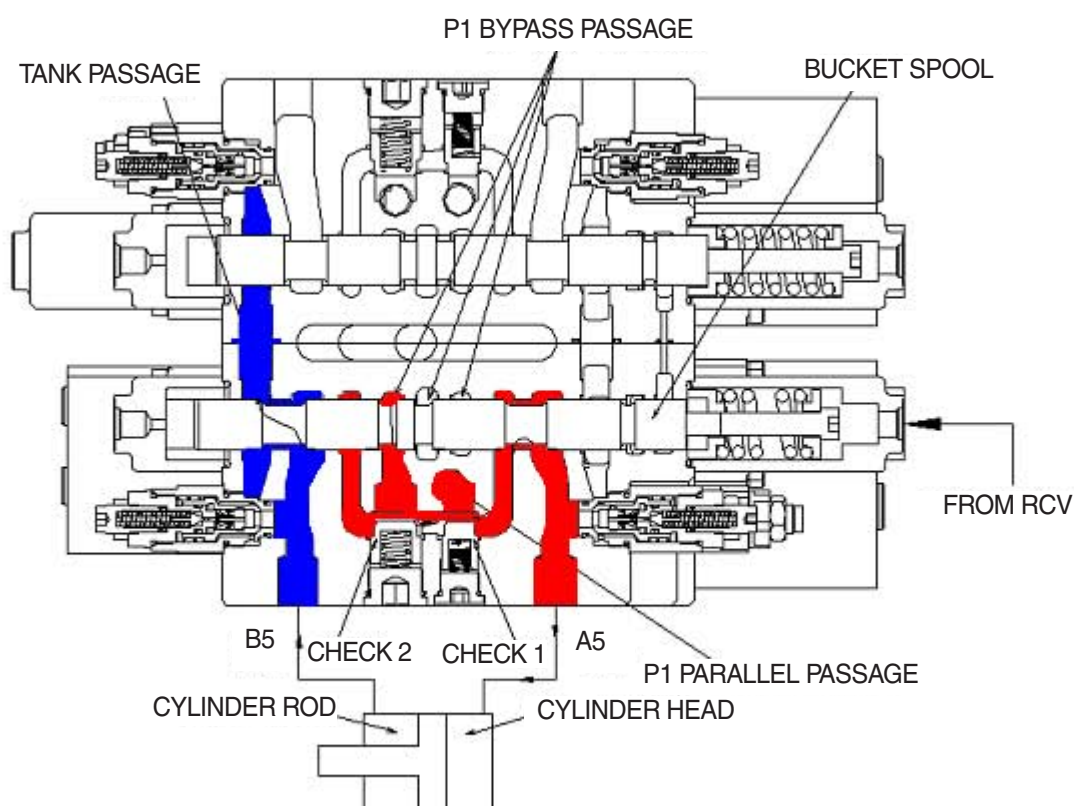
Following this it flows into the head side of the bucket cylinder.

The return flow from the rod side of the bucket cylinder returns to the bucket spool through the port B5. Thereafter it is directed to the hydraulic oil tank through the tank passage.

② Bucket operation with arm or boom operation

When combined operation, mostly same as above but the fluid from bypass passage is empty.

So only the fluid from parallel passage is supplied to the bucket cylinder. Also, parallel passage is installed the orifice for supplying the fluid from pump to the boom or the arm operation prior to the bucket operation.



(2) BUCKET OUT OPERATION

① Bucket operation only

During the bucket out operation, the pilot secondary pressure from RCV is supplied to port of the spring opposite side and shifts the bucket spool in the left direction.

The bypass passage is shut off by the movement of the spool and the hydraulic fluid from pump P1 entered P1 parallel passage and is directed to the port B5 through the check1.

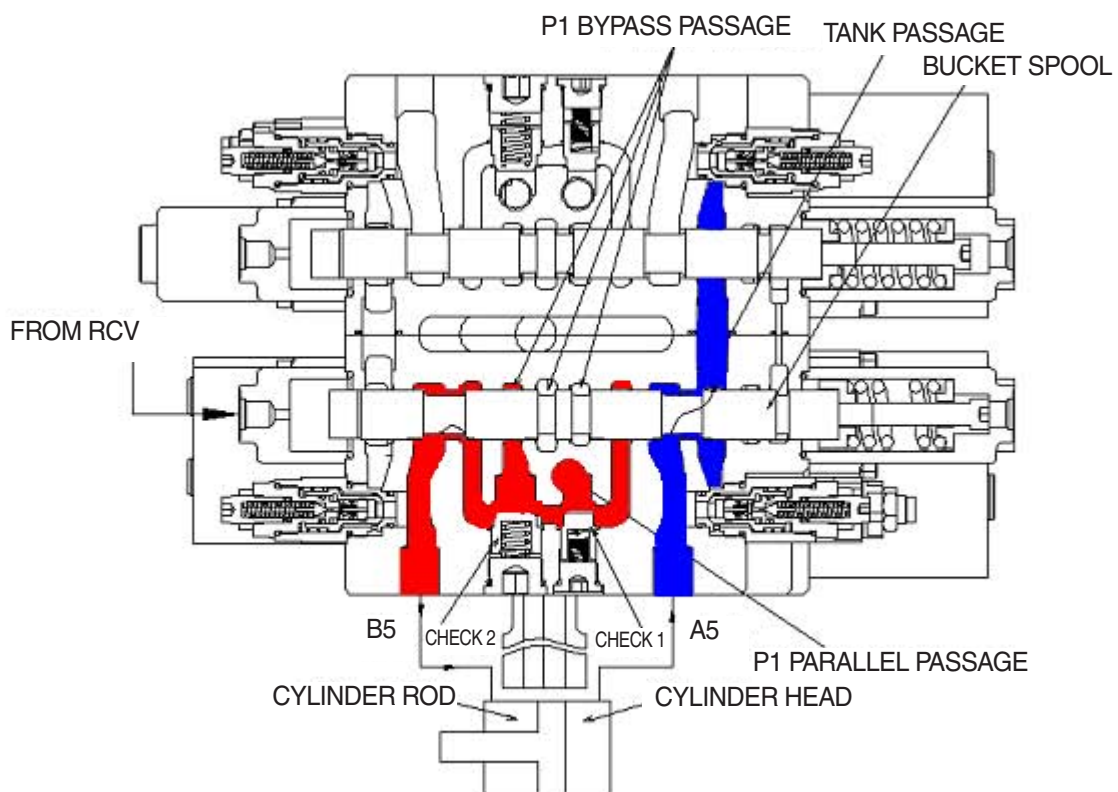
At the same time the hydraulic fluid from bypass passage is directed to the port B5 through the check 2.

The return flow from the rod side of the bucket cylinder returns to the hydraulic oil tank through the tank passage and the port A5.

② Bucket operation with arm or boom operation

When combined operation, mostly same as above but the fluid from bypass passage is empty.

So only the fluid from parallel passage is supplied to the bucket cylinder. Also, parallel passage is installed the orifice for supplying the fluid from pump to the boom or the arm operation prior to the bucket operation.



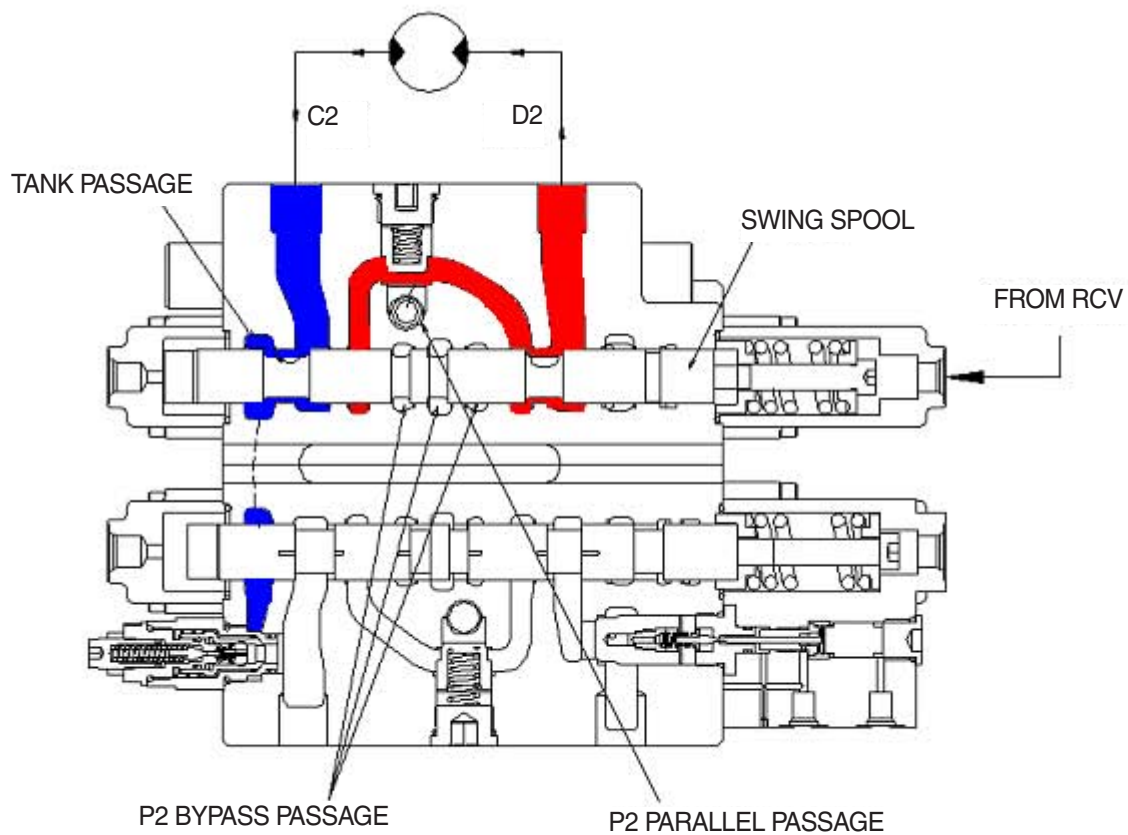
D21072MC15

6) SWING OPERATION

(1) SWING LEFT OPERATION

During the swing left operation, the pilot secondary pressure from the RCV is supplied to the port of the spring side and shift the swing spool in left direction. The bypass passage is shut off by the movement of the spool and the hydraulic fluid from pump P2 flows into swing spool through the parallel passage. Then it is directed to swing motor through the port D2.

As the result, swing motor turns and flow from the swing motor returns to the hydraulic oil tank through the port C2, swing spool and the tank passage.

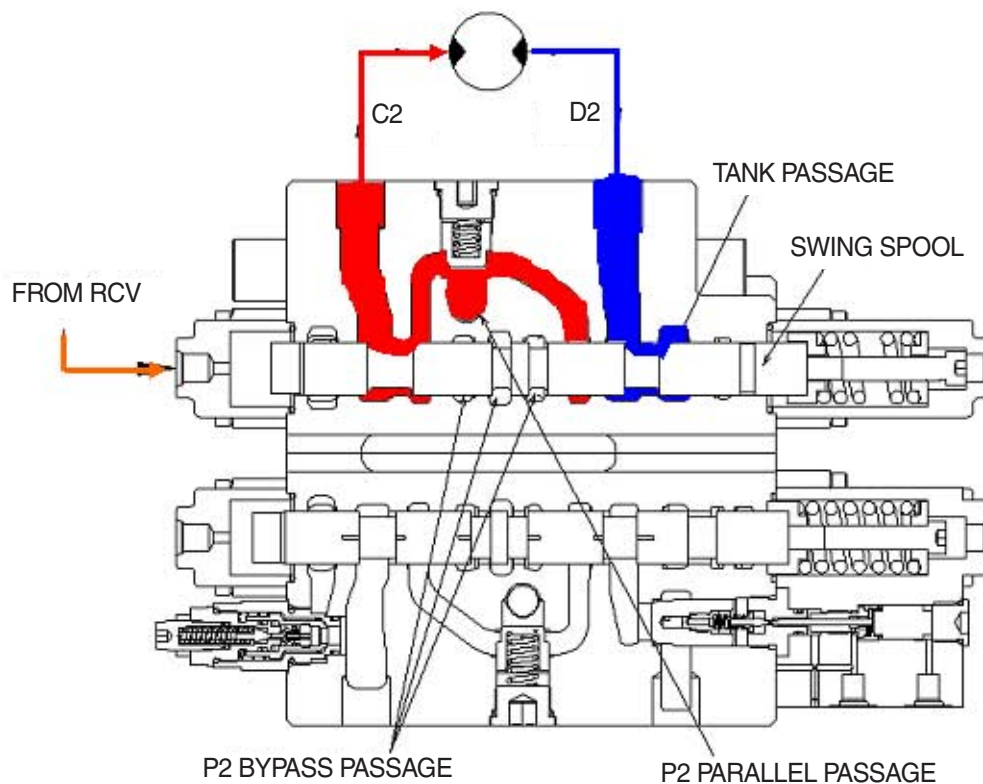


D21072MC16

(2) SWING RIGHT OPERATION

During the swing right operation, the pilot secondary pressure from the RCV is supplied to the port of the spring side and shift the swing spool in left direction. The bypass passage is shut off by the movement of the spool and the hydraulic fluid from pump P2 flows into swing spool through the parallel passage. Then it is directed to swing motor through the port C2.

As the result, swing motor turns and flow from the swing motor returns to the hydraulic oil tank through the port B2, swing spool and the tank passage.



D21072MC17

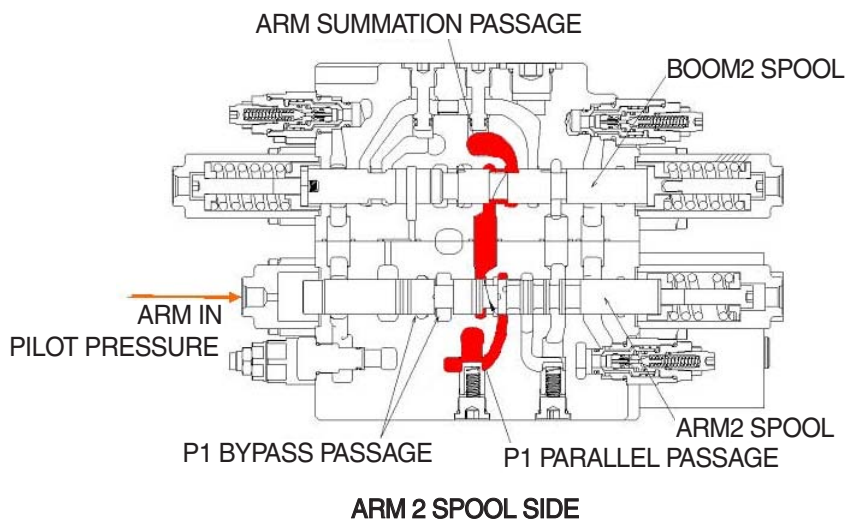
7) ARM OPERATION

(1) ARM IN OPERATION

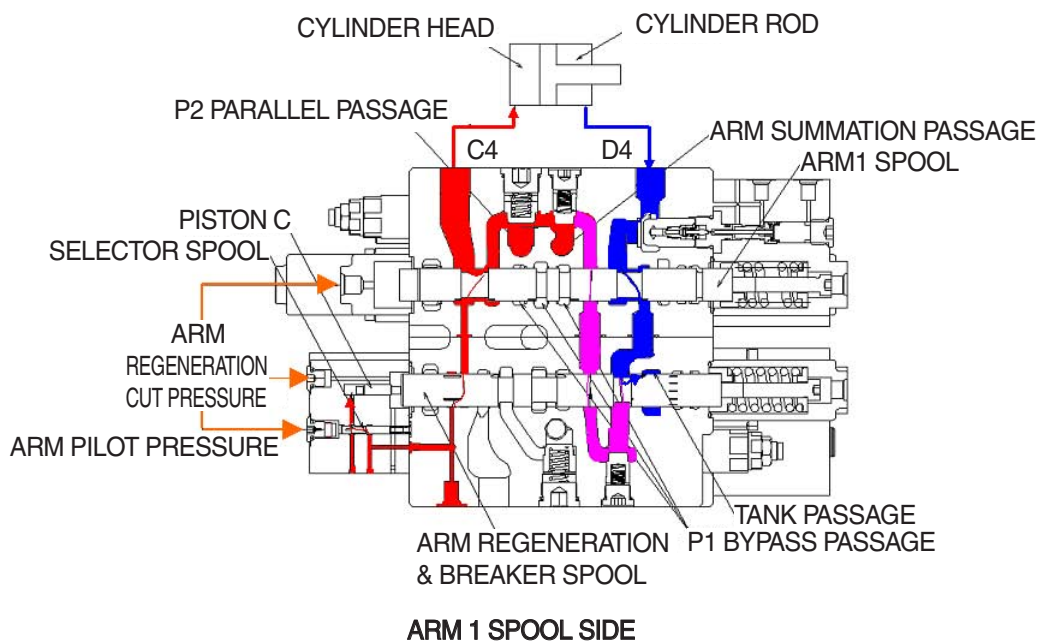
During arm in operation, the pilot secondary pressure from the RCV is supplied to the port of spring opposite side and shifts arm 1 spool in the right direction.

The bypass passage is shut off by the movement of the arm 1 spool and the hydraulic oil from the pump P2 flows into the arm cylinder head side through P2 parallel passage, the load check valve, bridge passage and the port C4.

At same time, the pilot secondary pressure from the RCV is supplied to the port of spring opposite side and shifts arm 2 spool in the right direction. The bypass passage is shut off by the movement of the spool and the hydraulic fluid from the pump P1 flows into the arm summation passage through parallel passage, the check valve, the arm 2 spool and the boom 2 spool. Then it entered the arm cylinder head side with hydraulic fluid from arm 1 spool.



D21072MC19



D21072MC18

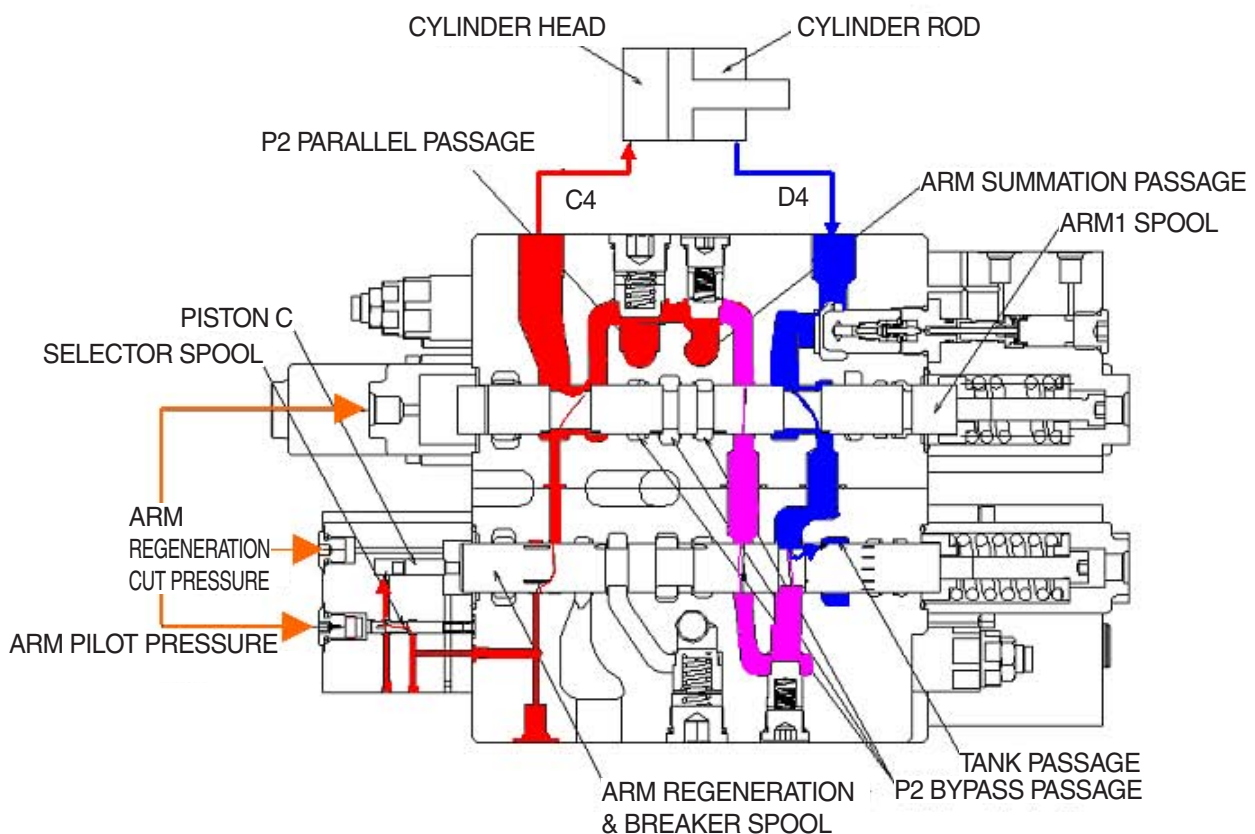
ARM REGENERATION

The return flow from the arm cylinder rod side is pressurized by self weight of arm and so, returns to port D4. The pressurized oil returning to port D4 enters the arm regeneration spool through the arm holding valve and the arm 1 spool. It is supplied the arm cylinder head through internal passage. This is called the arm regeneration function.

The amount of regeneration fluid is changed by movement of the arm regeneration spool. A few fluids after P2 parallel passage is push piston "C" through the notch of arm regeneration spool and selector spool. At this time, the selector spool is opened by pilot pressure from RCV.

Then, the arm regeneration spool shifts to right side and flow to tank pass increases and regeneration flow decreases. Therefore, pressure of arm cylinder head increases, then, arm regeneration flow decreases.

Furthermore, the arm regeneration cut pressure is supplied to the port of spring opposite side and arm regeneration spool is move into the right direction fully. The flow from the arm cylinder rod is returned to the hydraulic oil tank and regeneration function is not activated. (The return fluid is maximum condition)



D21072MC18

(2) ARM OUT OPERATION

During arm out operation, the pilot secondary pressure from RCV is supplied to the port of spring side and shifts arm 1 spool in the left direction.

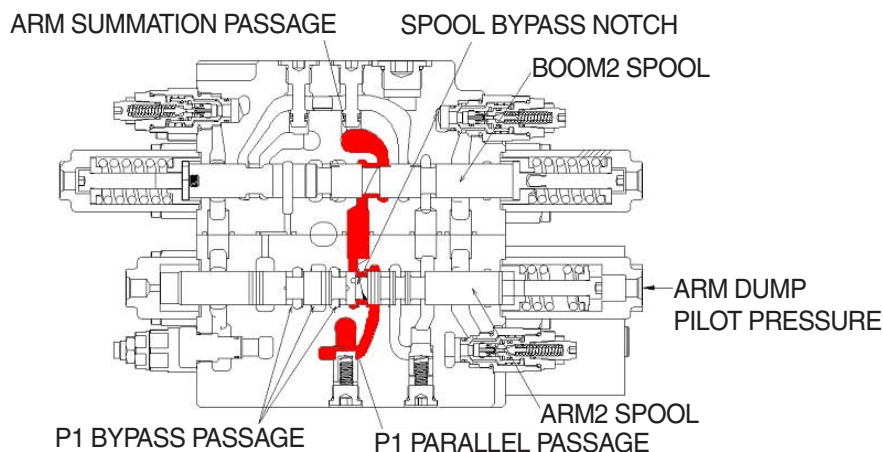
The bypass passage is shut off by the movement of the spool and the hydraulic fluid from pump P2 flows into arm 1 spool through the parallel passage. Then it enters into the arm cylinder rod side through the load check valve, bridge passage, arm holding valve and the port D4.

Also, the pilot secondary pressure from RCV is supplied to the port of spring side and shifts arm 2 spool in the left direction.

The bypass passage is shut off by the movement of the spool and some of the hydraulic fluid from pump P2 bypassed through bypass notch. The rest of hydraulic fluid from pump P2 flows into the arm summation passage through P1 parallel passage the check valve arm 2 spool and boom 2 spool.

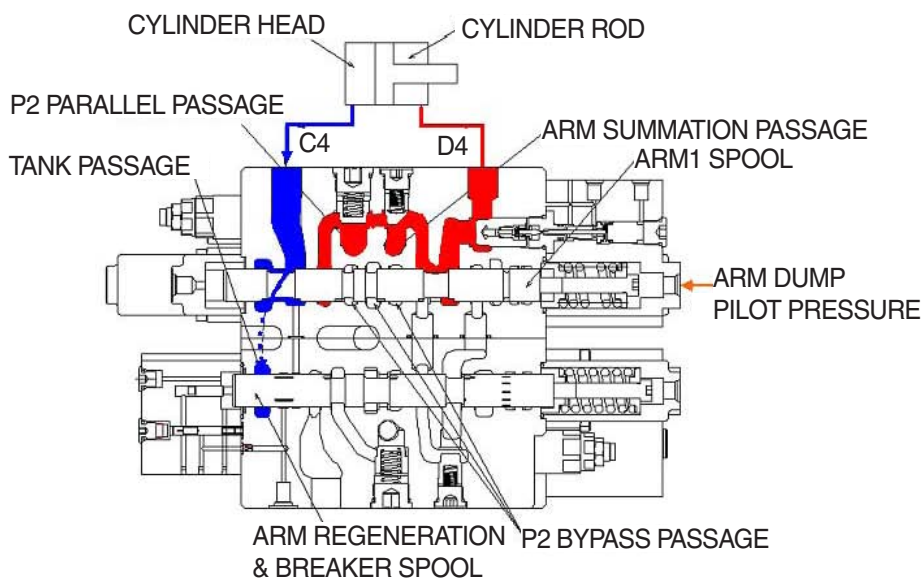
Then it enters into the arm cylinder rod side with the fluid from the arm 1 spool.

The return flow from the arm cylinder head side returns to the hydraulic tank through the port C4 the arm 1 spool and tank passage.



ARM 2 SPOOL SIDE

D21072MC21



ARM 1 SPOOL SIDE

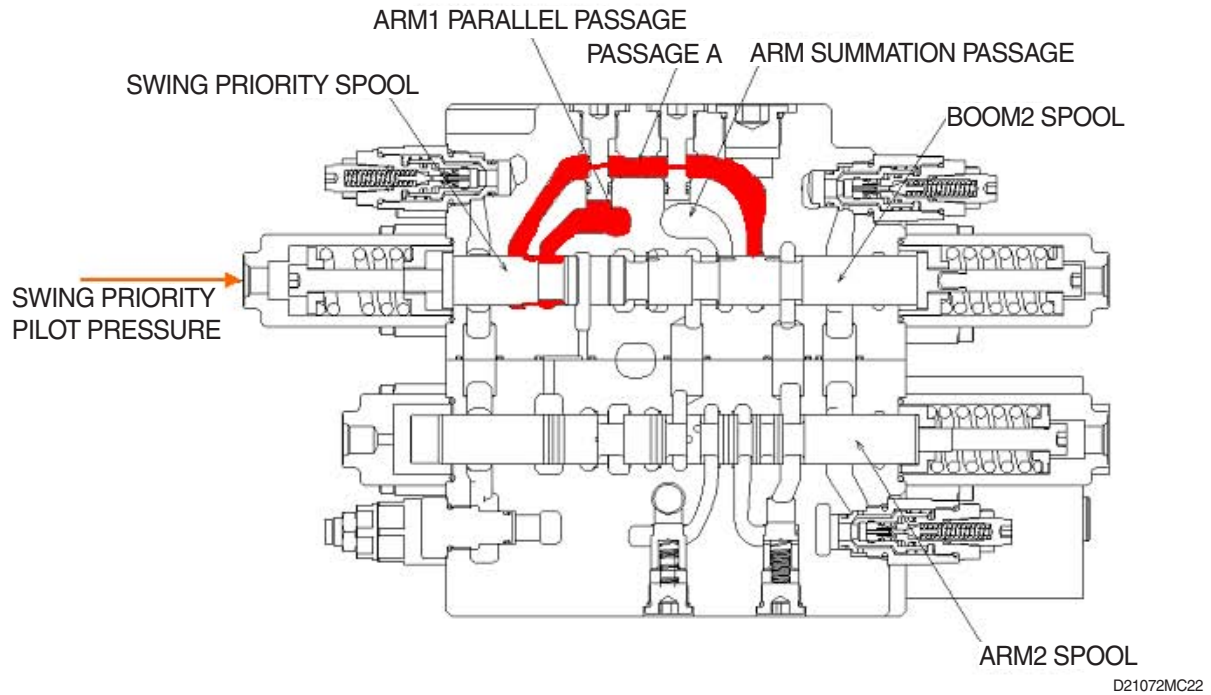
D21072MC20

8) SWING PRIORITY FUNCTION

During swing priority operation, the pilot secondary pressure is supplied to the port of the spring side of the swing priority spool and shift swing priority spool in the right direction.

The hydraulic fluid from P2 parallel passage flows into the parallel passage of arm 1 side through swing priority spool and the passage "A" and also flows into the boom 2 spool.

When the swing priority spool is neutral condition, the passage is same as normal condition. But due to shifting of the swing priority spool, the fluid from pump P2 flows to swing side more then the boom 2, arm 1, option B and bucket summation spools to make the swing operation most preferential.



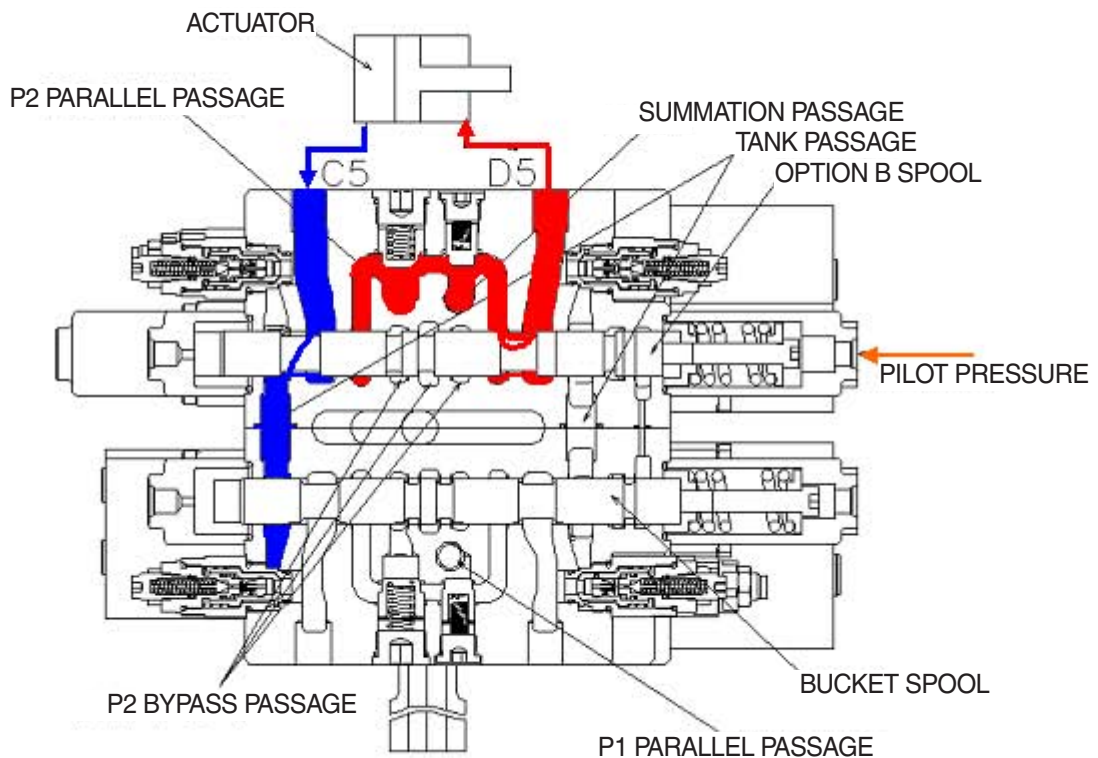
9) OPTION B OPERATION

The pilot secondary pressure from RCV is supplied to the port of spring side and shifts option spool as the figure.

The bypass passage is shut off by the movement of the spool and the hydraulic fluid from pump P2 flows into actuator through the load check valve, bridge passage and port D5.

At the same time, the fluid from actuator returns to the tank passage through port C5 and notch of the option spool.

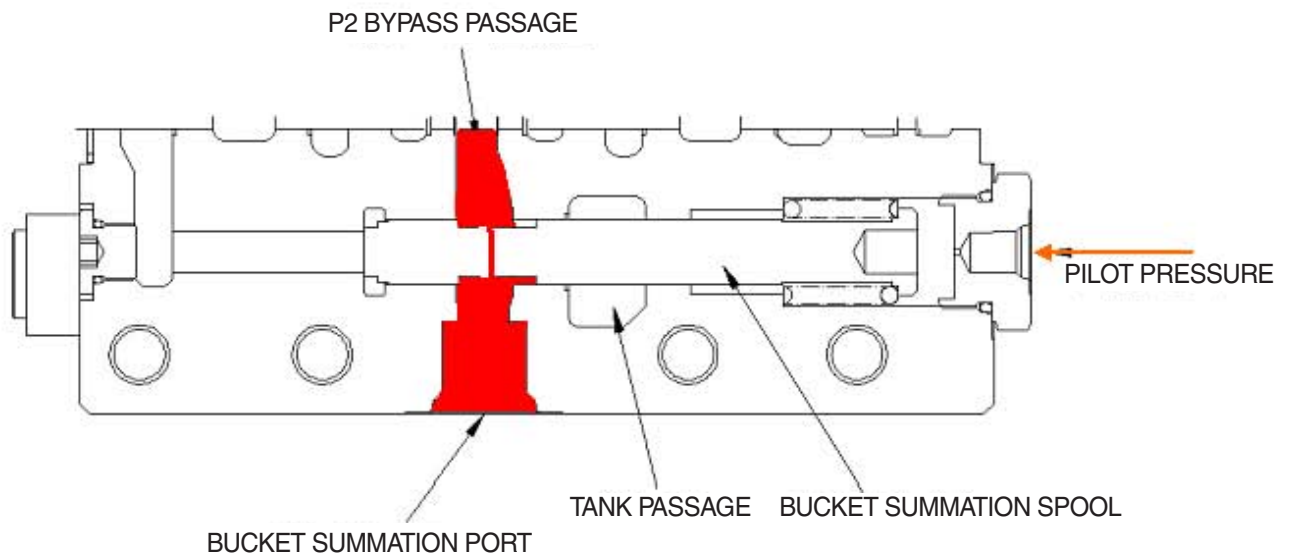
In case of reverse operation, the operating principle is same as above.



D21072MC24

10) BUCKET SUMMATION OPERATION

During bucket single operation, the bucket pilot pressure from RCV is supplied to the port of the spring side of the bucket summation spool and shift the spool in the left direction. As the spool moves, return line will be blocked and bypass pressure will open the check valve CK1 and join the parallel flow of the bucket from the P1 pump.



D21072MC25

11) NEGATIVE RELIEF VALVE OPERATION

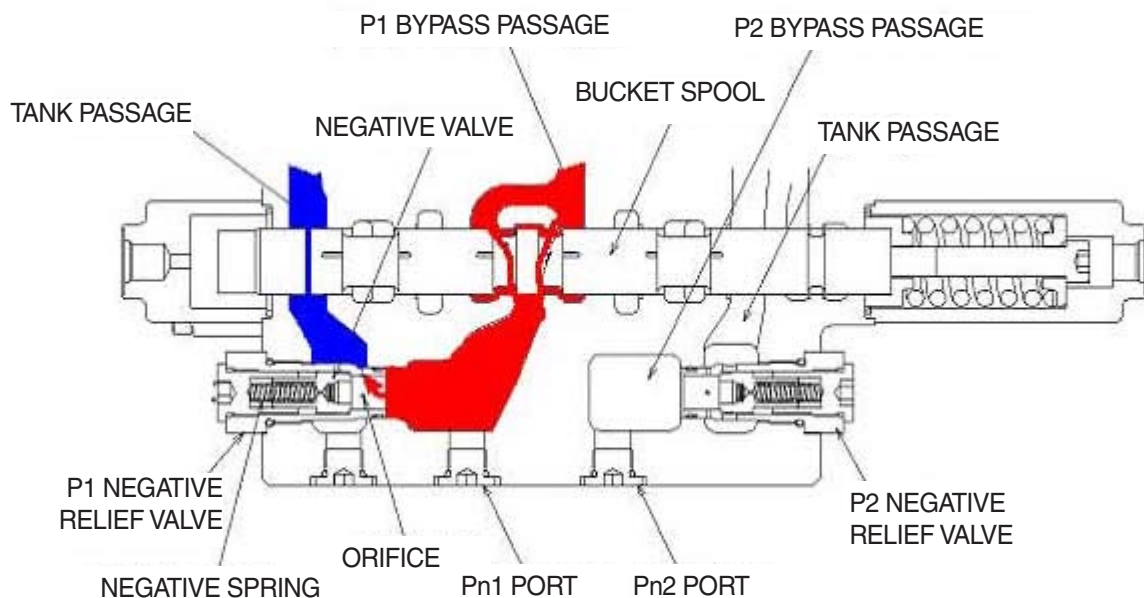
When no function is being actuated on P1 side, the hydraulic fluid from the pump P1, flows into the tank passage through the bypass passage and orifice. The restriction caused by this orifice thereby pressurizes. This pressure is transferred as the negative control signal pressure Pn1 to the pump P1 regulator.

It controls the pump regulator so as to minimize the discharge of the pump P1.

The bypass passage is shut off when the shifting of one or more spools and the flow through bypass passage became zero. The pressure of negative control signal becomes zero and the discharge of the pump P1 becomes maximum.

The negative control pressure reaches to the set level, the hydraulic fluid in the passage pushes open negative control valve and escapes into the return passage.

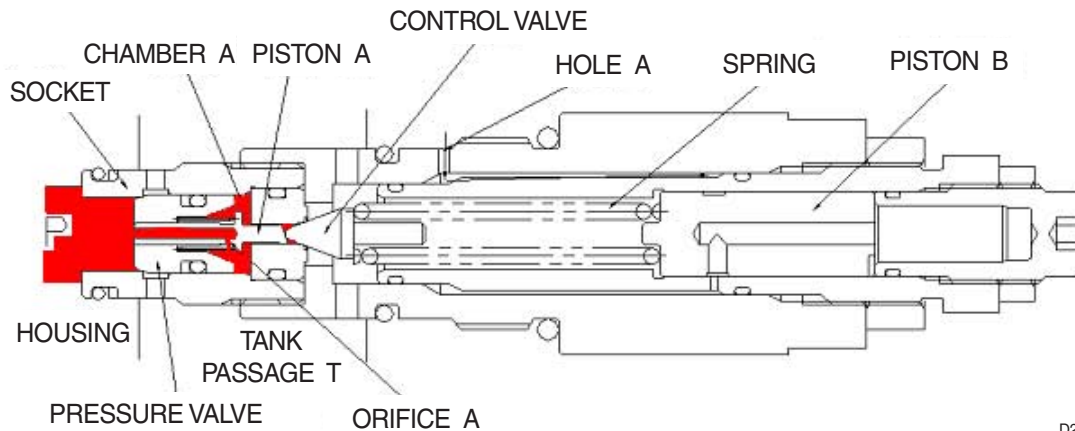
For the pump P2 the same negative control principle.



D21072MC26

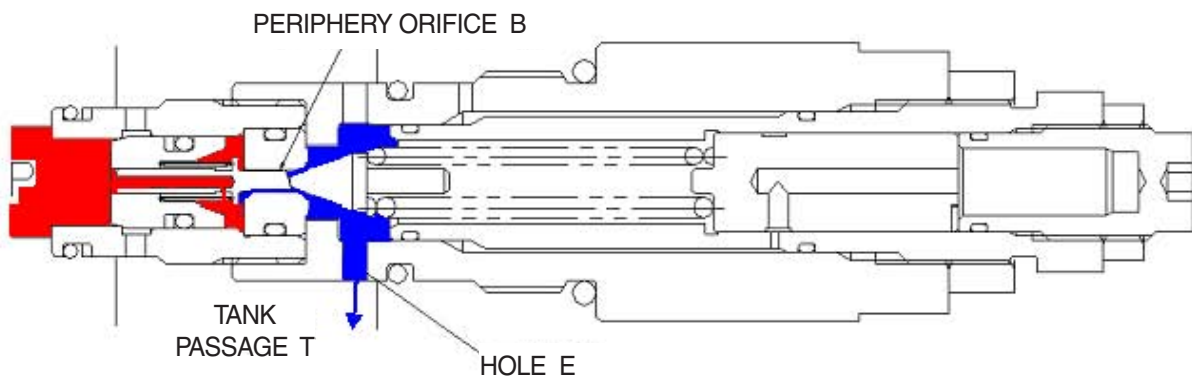
12) OPERATION OF MAIN RELIEF VALVE

- (1) The pressurized oil passes through the orifice (A) of the plunger is filled up in chamber A of the inside space, and seats the plunger against the housing securely.



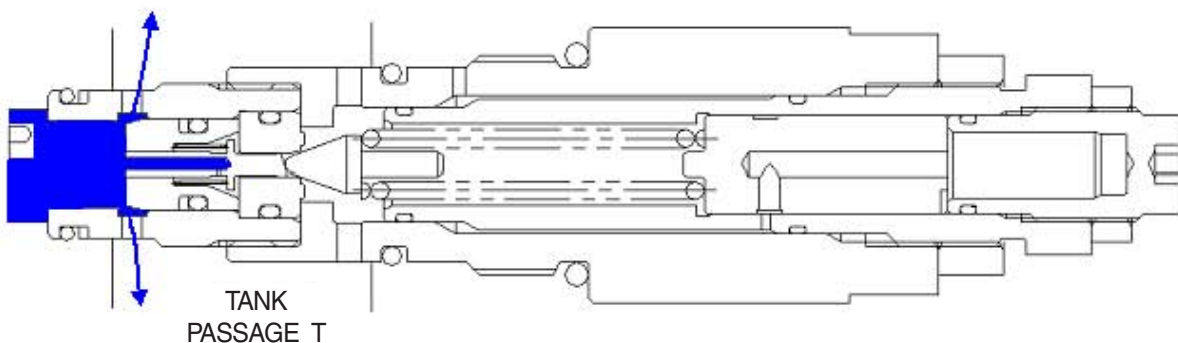
D21072MC27

- (2) When the pressure at (P) becomes equal to the set pressure of the spring the hydraulic oil passes through the piston (A) pushes open the poppet and flows to tank passage (T) through the plunger internal passage, periphery orifice A, chamber A, periphery orifice B and the hole (E).



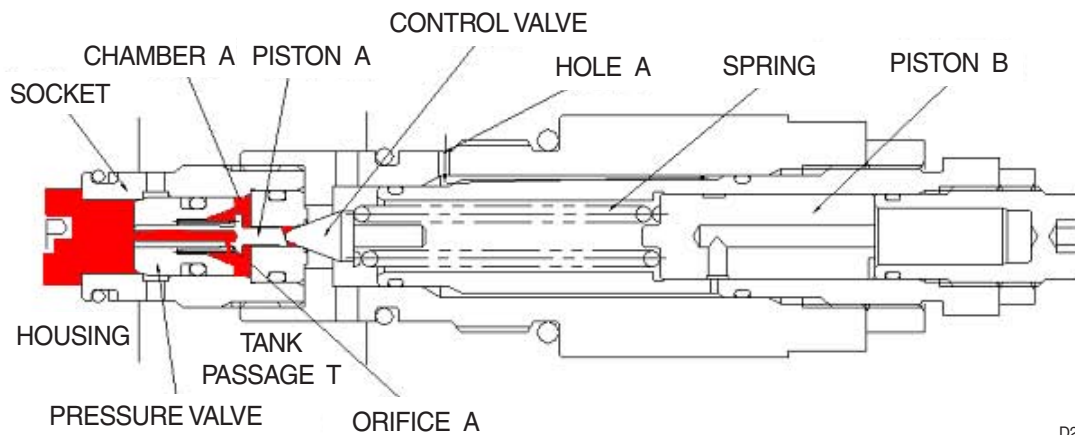
D21072MC28

- (3) Opening the poppet causes the pressure in chamber A to fall and the plunger to open. As the result the pressurized oil at port P runs into tank passage (T).

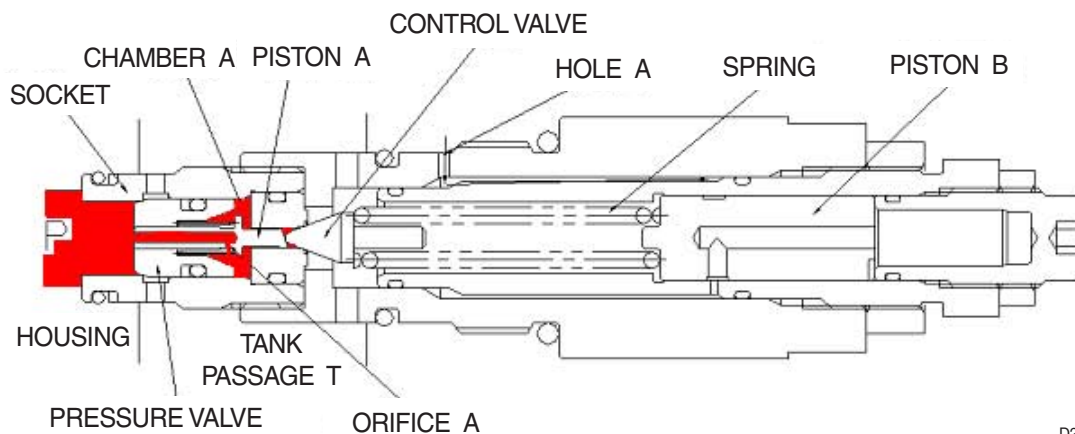


D21072MC29

- (4) The pressure at port P becomes lower than set pressure of the spring, the poppet is seated by spring force. Then the pressure at port P becomes equal to set pressure of the spring and the plunger is seated to the socket.



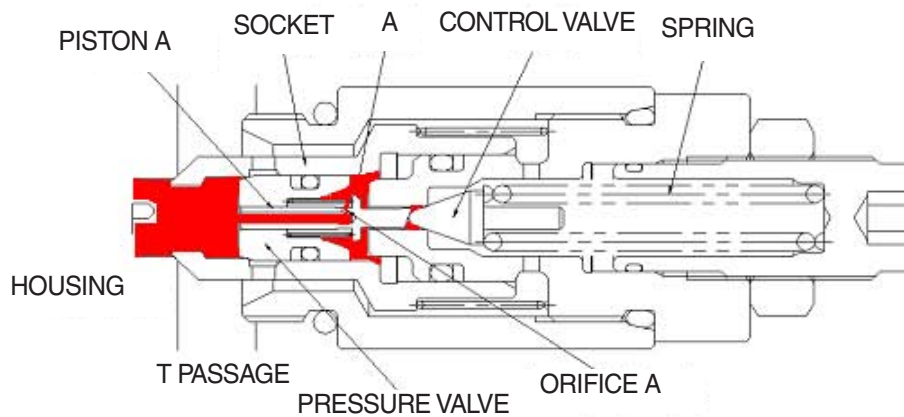
- (5) When the power boost switch is ON, the pilot pressure enters through hole A. It pushes the piston (B) in the left direction to increase the force of the spring and change the relief set pressure to the high pressure.



13) OPERATION OF OVERLOAD RELIEF VALVE

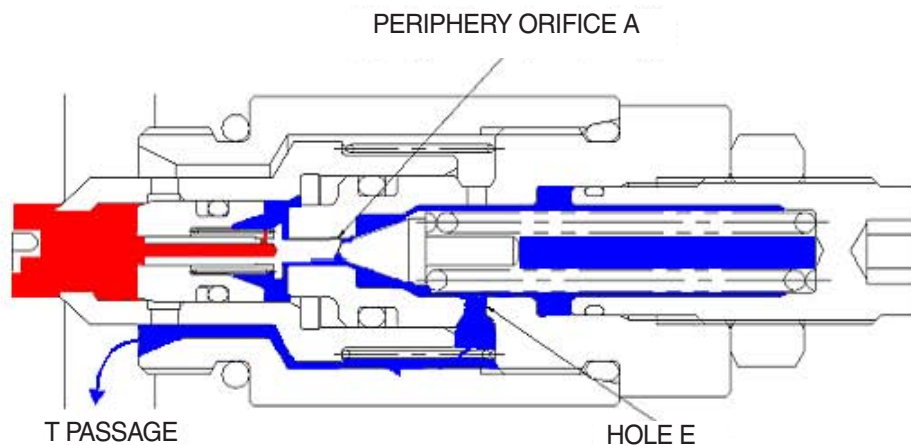
FUNCTION AS RELIEF VALVE

- (1) The pressurized oil passes through the piston and orifice A is filled up in chamber A of the inside space and seat the plunger against the socket and the socket against the housing securely.



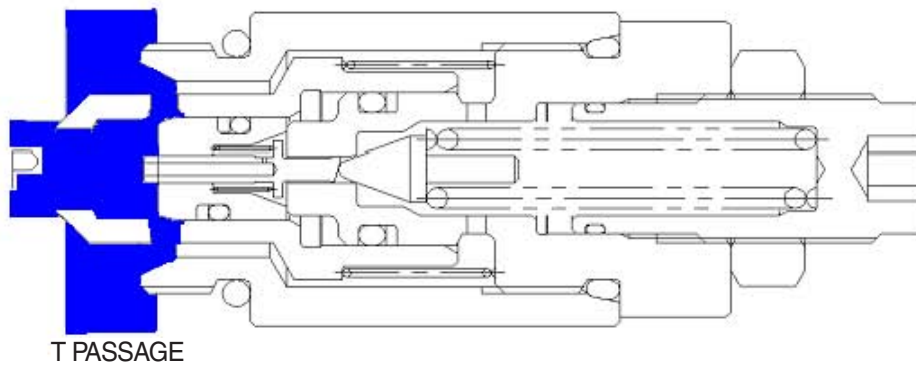
D21072MC30

- (2) When the pressure at port P becomes equal to the set pressure of the spring, the pressurized oil pushes open the poppet and flows to tank passage (T) through the plunger internal passage, orifice A, chamber A, periphery orifice B and hole E.



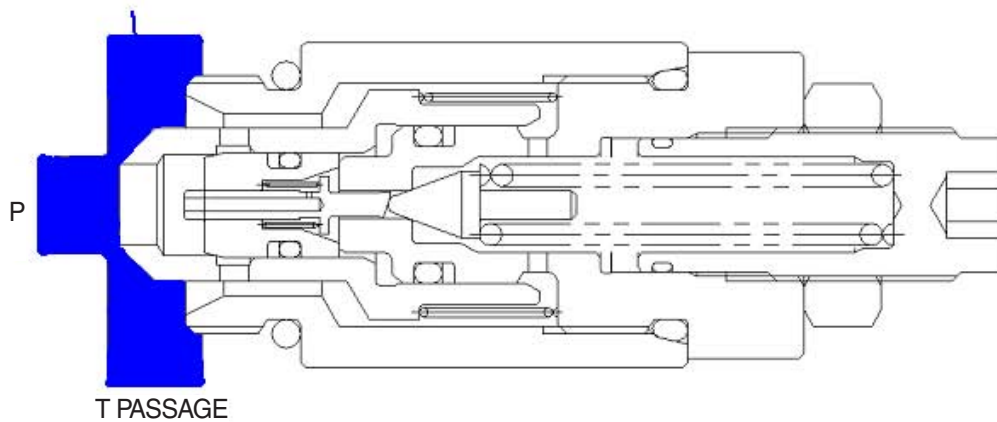
D21072MC31

- (3) Opening of the poppet causes the pressure in chamber A to fall and the plunger to open. As the result the pressurized oil at port P runs into tank passage (T).



D21072MC32

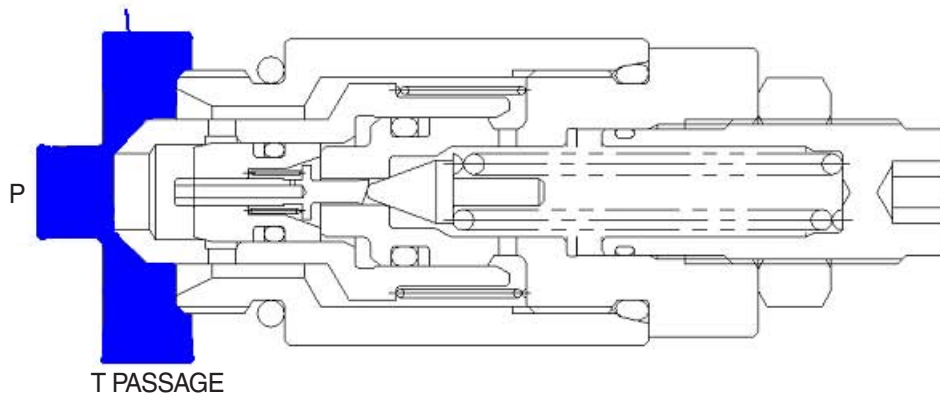
- (4) The pressure at port P becomes lower than set pressure of the spring, the poppet is seated by spring force. Then the pressure at port P becomes equal to set pressure of the spring and the plunger is seated to the socket.



D21072MC33

MAKE-UP FUNCTION

- (5) When negative pressure exists at port P, the oil is supplied through tank passage (T). When the pressure at tank passage (T) becomes higher than that of at port P, the socket moves in the right direction. Then, sufficient oil passes around the socket from tank passage (T) to port P and fills up the space.



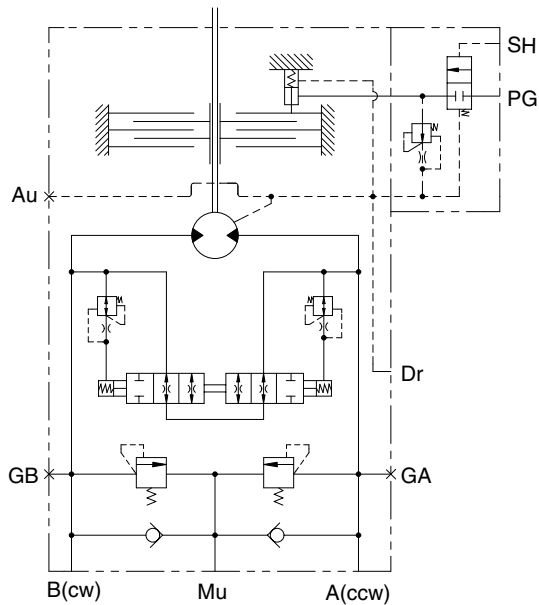
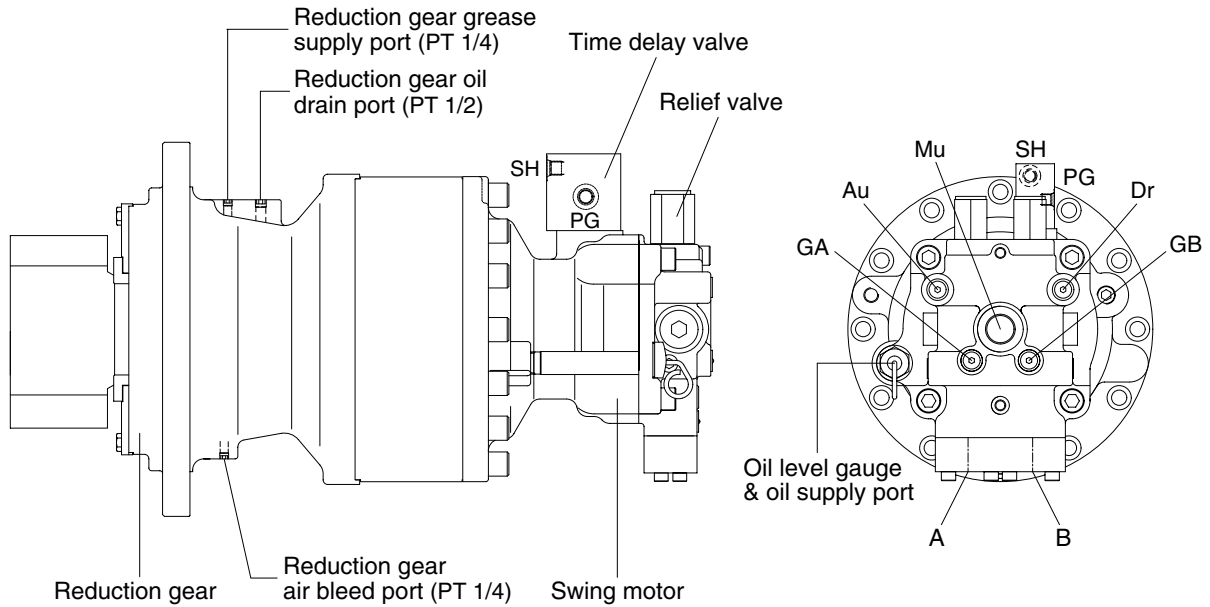
D21072MC33

GROUP 3 SWING DEVICE (TYPE 1)

1. STRUCTURE

Swing device consists swing motor, swing reduction gear.

Swing motor include mechanical parking valve, relief valve, make up valve and time delay valve.

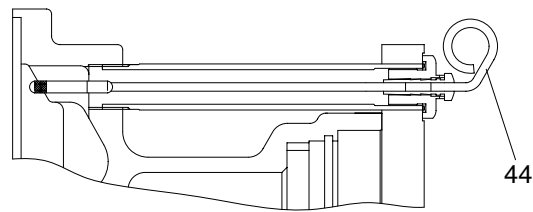


Hydraulic circuit

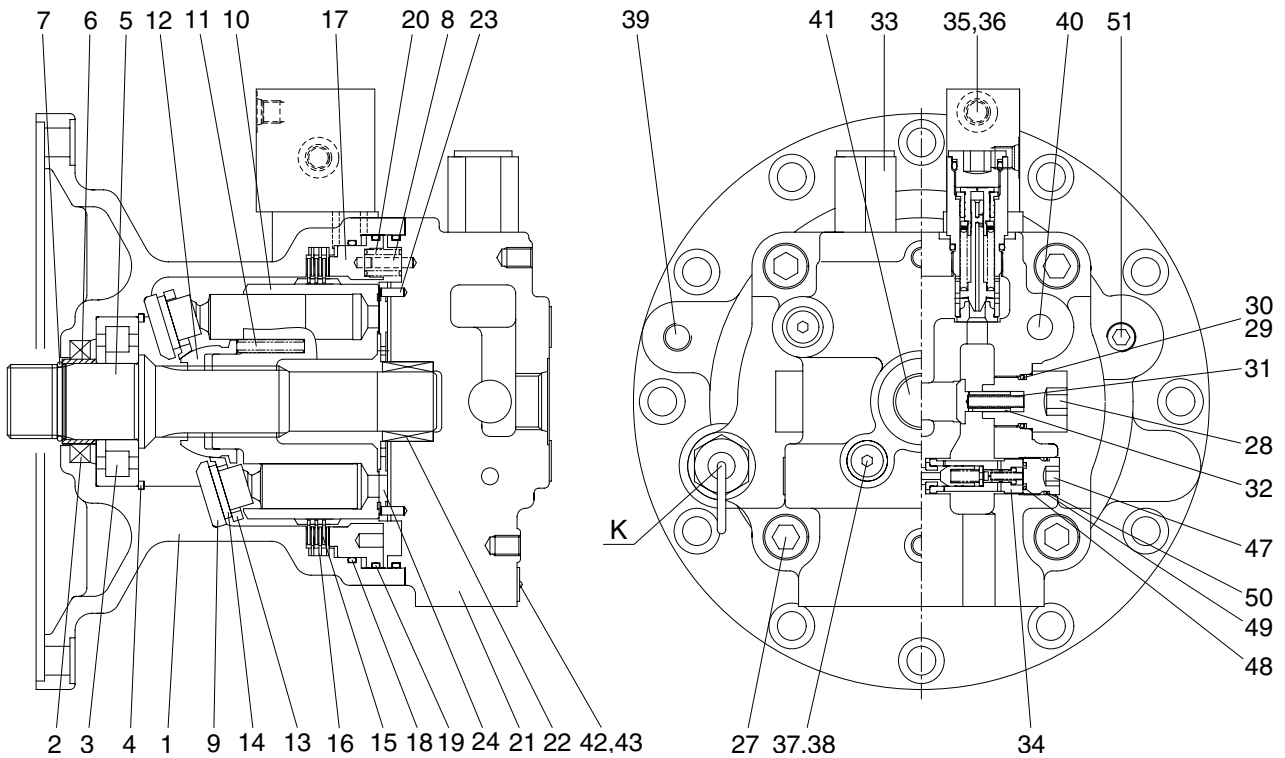
| Port | Port name | Port size |
|--------|--------------------|-----------|
| A | Main port | ø 20 |
| B | Main port | ø 20 |
| Dr | Drain port | PF 1/2 |
| Mu | Make up port | PF 1 |
| PG | Brake release port | PF 1/4 |
| SH | Stand by port | PF 1/4 |
| GA, GB | Gage port | PF 1/4 |
| Au | Air vent port | PF 1/4 |

2107V2SM01

1) SWING MOTOR



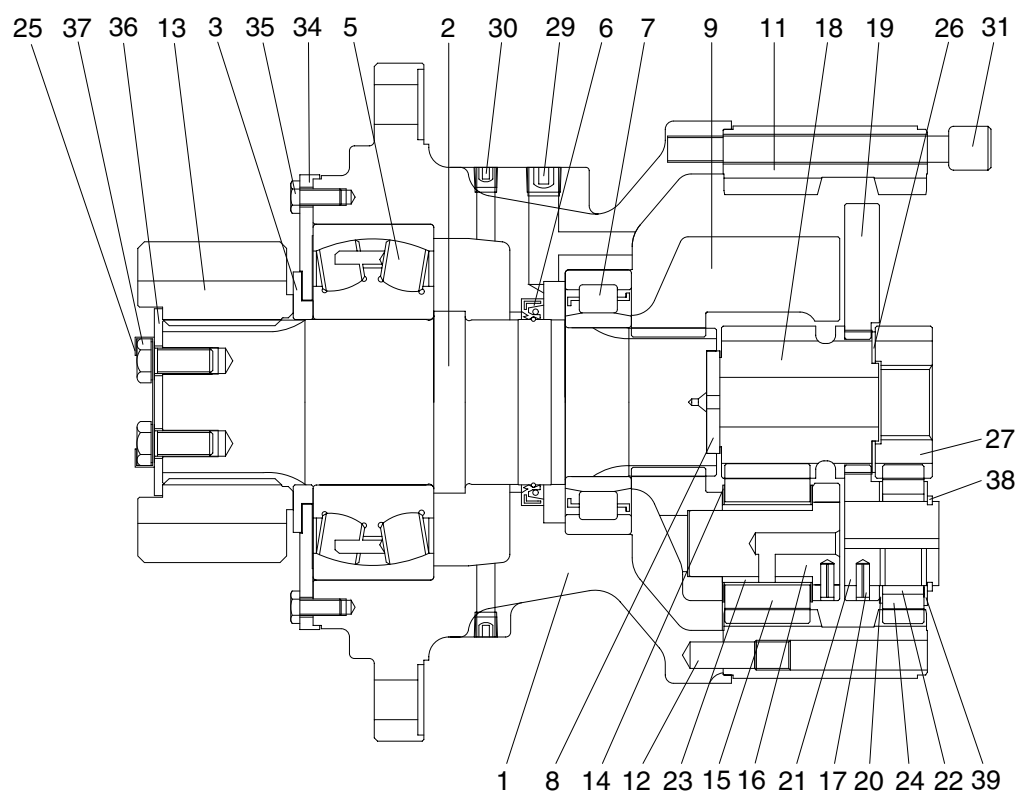
DETAIL K



2107V2SM02

- | | | |
|-------------------|------------------------------|-----------------|
| 1 Body | 18 O-ring | 37 Plug |
| 2 Oil seal | 19 O-ring | 38 O-ring |
| 3 Roller bearing | 20 Brake spring | 39 Plug |
| 4 Snap ring | 21 Rear cover | 40 Plug |
| 5 Shaft | 22 Needle bearing | 41 Plug |
| 6 Bushing | 23 Pin | 42 Name plate |
| 7 Stop ring | 24 Valve plate | 43 Rivet |
| 8 Pin | 27 Wrench bolt | 44 Level gauge |
| 9 Shoe plate | 28 Plug | 45 Flange |
| 10 Cylinder block | 29 Back up ring | 46 O-ring |
| 11 Spring | 30 O-ring | 47 Plug |
| 12 Ball guide | 31 Spring | 48 O-ring |
| 13 Set plate | 32 Check | 49 O-ring |
| 14 Piston assy | 33 Relief valve assy | 50 Back up ring |
| 15 Friction plate | 34 Anti-inversion valve assy | 51 Plug |
| 16 Separate plate | 35 Time delay valve assy | |
| 17 Brake piston | 36 Wrench bolt | |

2) REDUCTION GEAR



2107V2SM03

| | | | | | |
|----|----------------|----|---------------|----|--------------|
| 1 | Casing | 15 | Planet gear 2 | 26 | Side plate 3 |
| 2 | Drive shaft | 16 | Pin 2 | 27 | Sun gear 1 |
| 3 | Spacer | 17 | Spring pin | 29 | Plug |
| 5 | Roller bearing | 18 | Sun gear 2 | 30 | Plug |
| 6 | Oil seal | 19 | Carrier 1 | 31 | Socket bolt |
| 7 | Roller bearing | 20 | Side plate 1 | 34 | Cover plate |
| 8 | Thrust plate | 21 | Pin 1 | 35 | Hexagon bolt |
| 9 | Carrier 2 | 22 | Needle cage | 36 | Lock plate |
| 11 | Ring gear | 23 | Bush 2 | 37 | Hexagon bolt |
| 12 | Knock pin | 24 | Planet gear 1 | 38 | Stop ring |
| 13 | Pinion gear | 25 | Lock washer | 39 | Side plate 2 |
| 14 | Thrust washer | | | | |

2. PRINCIPLE OF DRIVING

1) Generating the turning force

The high hydraulic supplied from a hydraulic pump flows into a cylinder block (10) through rear cover of motor (21), and valve plate (24).

The high hydraulic is built as flowing on one side of Y-Y line connected by the upper and lower sides of piston (14).

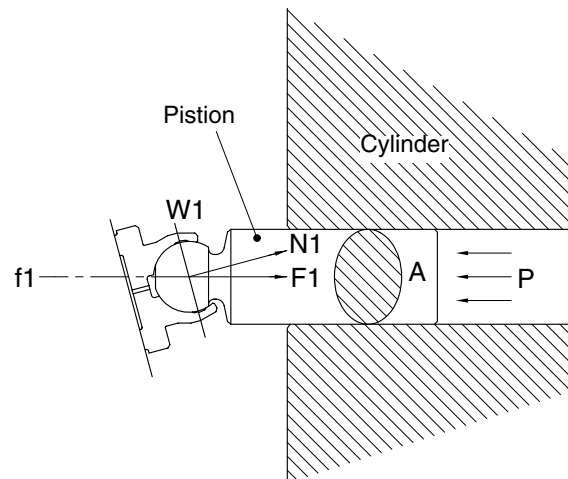
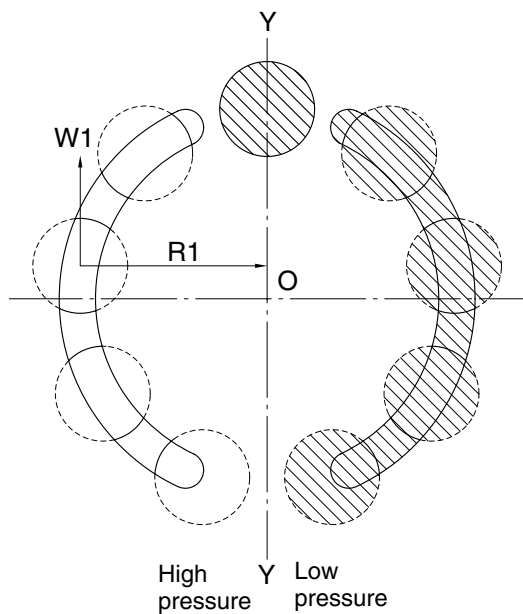
The high hydraulic can generate the force, $F1 = P \times A$ (P : supplied pressure, A : water pressure area), like following pictures, working on a piston.

This force, $F1$, is divided as $N1$ thrust partial pressure and $W1$ radial partial pressure, in case of the plate of a tilt angle, α .

$W1$ generates torque, $T = W1 \times R1$, for Y-Y line connected by the upper and lower sides of the piston as following pictures.

The sum of torque ($\sum W1 \times R1$), generated from each piston (4~5 pieces) on the side of a high hydraulic, generates the turning force.

This torque transfers the turning force to a cylinder (10) through a piston; because a cylinder is combined with a turning axis and spline, a turning axis rotates and a turning force is sent.



21078TM05

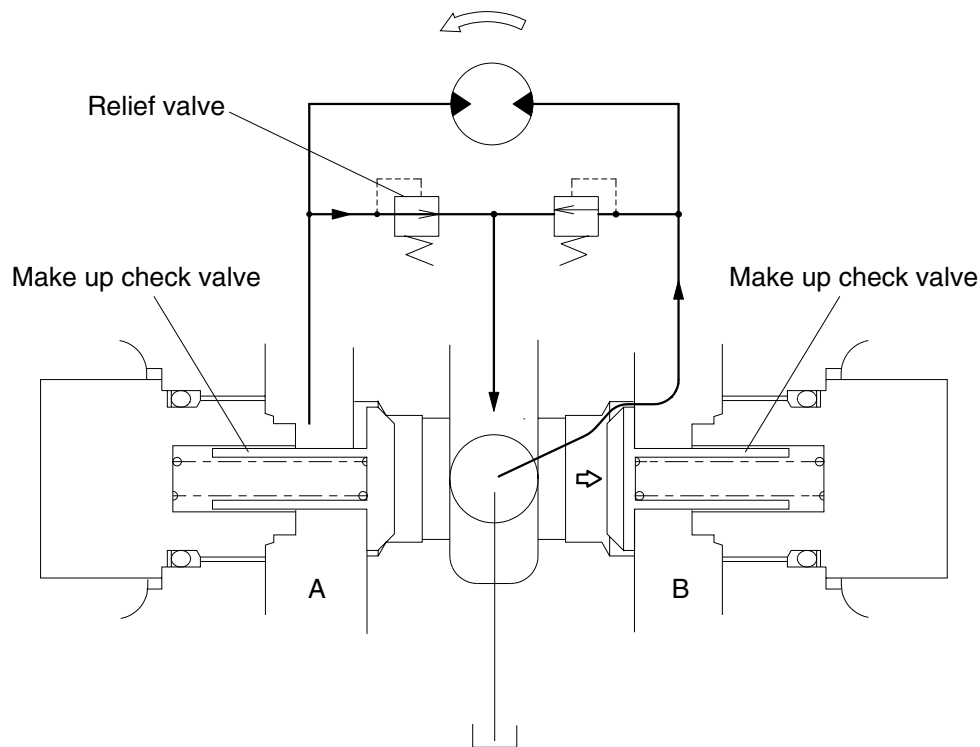
2) MAKE UP VALVE

In the system using this type of motor, there is no counter balance functioning valve and there happens the case of revolution exceeding hydraulic supply of motor. To prevent the cavitation caused by insufficient oil flow there is a make up valve to fill up the oil insufficiency.

A make up valve is provided immediately before the port leading to the hydraulic oil tank to secure feed pressure required when the hydraulic motor makes a pumping action. The boost pressure acts on the hydraulic motor's feed port via the make up valve.

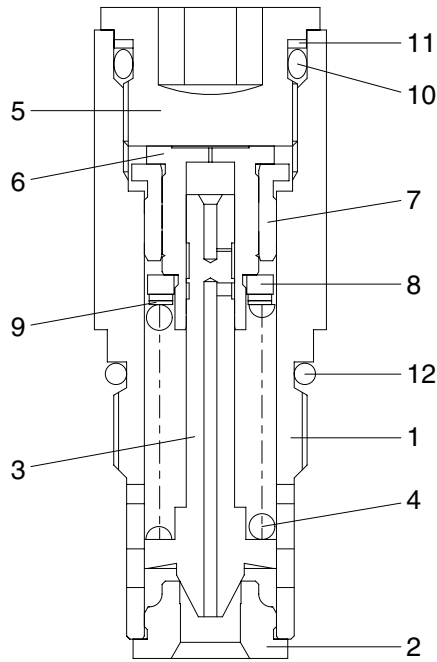
Pressurized oil into the port B, the motor rotate counterclockwise.

If the plunger of MCV moves neutral position, the oil in the motor is drain via left relief valve, the drain oil run into motor via right make up valve, which prevent the cavitation of motor.



21092SM04

3) RELIEF VALVE



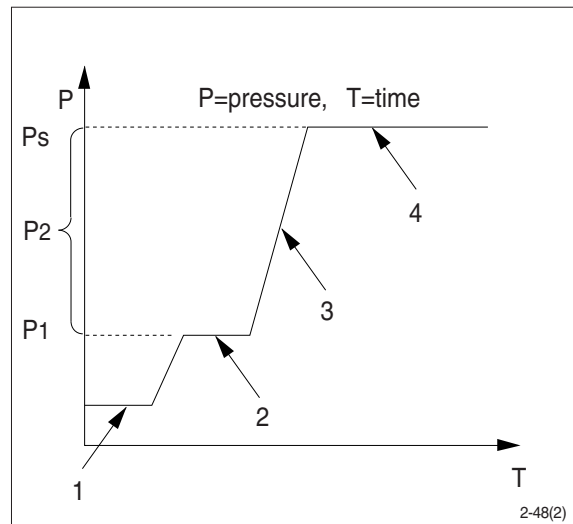
- 1 Body
- 2 Seat
- 3 Plunger
- 4 Spring
- 5 Adjusting screw
- 6 Piston
- 7 Bushing
- 8 Spring seat
- 9 Shim
- 10 O-ring
- 11 Back up ring
- 12 O-ring

(1) Construction of relief valve

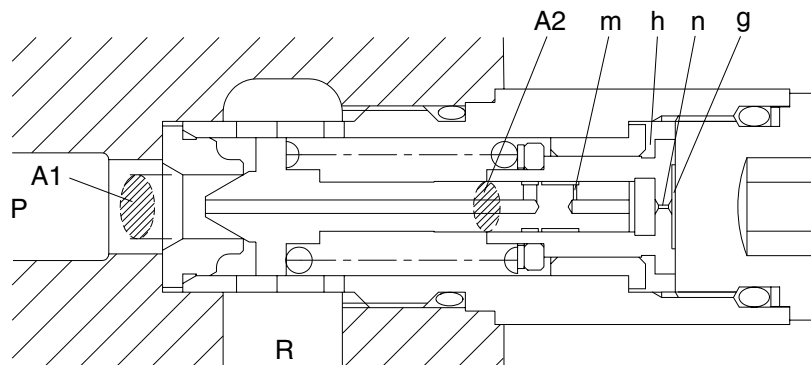
The valve casing contains two cartridge type relief valves that stop the regular and reverse rotations of the hydraulic motor. The relief valves relieve high pressure at start or at stop of swing motion and can control the relief pressure in two steps, high and low, in order to insure smooth operation.

(2) Function of relief valve

Figure illustrates how the pressure acting on the relief valve is related to its rising process. Here is given the function, referring to the figure following page.



- ① Ports (P, R) at tank pressure.

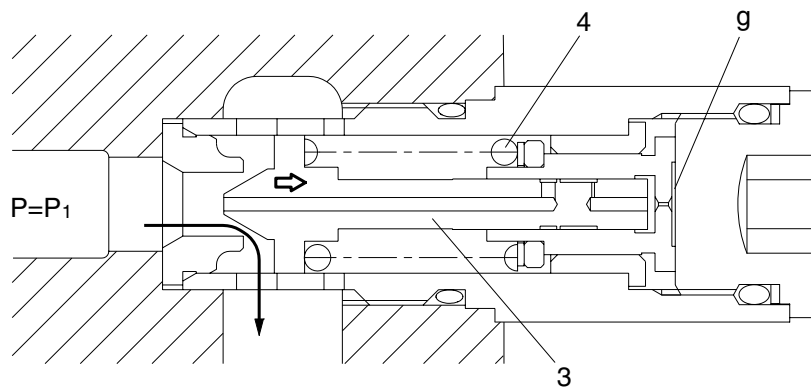


14007A2SM06

- ② When hydraulic oil pressure ($P \times A_1$) reaches the preset force (F_{SP}) of spring (4), the plunger (3) moves to the right as shown.

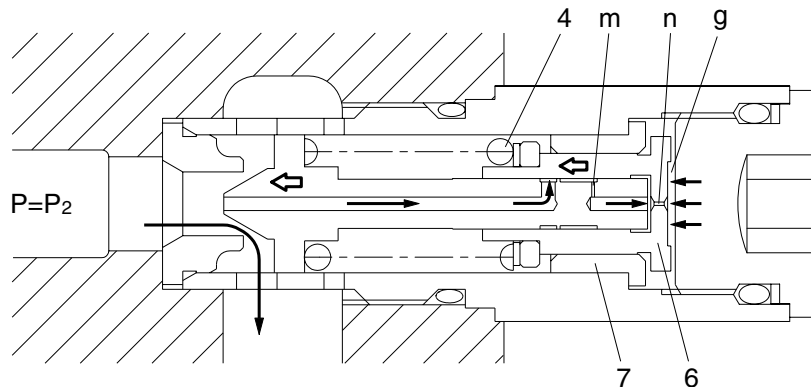
$$P_1 \times A_1 = F_{SP} + P_g \times A_2$$

$$P_1 = \frac{F_{SP} + P_g \times A_2}{A_1}$$



14007A2SM07

- ③ The oil flow chamber g via orifice m and n. When the pressure of chamber g reaches the preset force (FSP) of spring (4), the piston (6) moves left and stop the piston (6) hits the bottom of bushing (7).

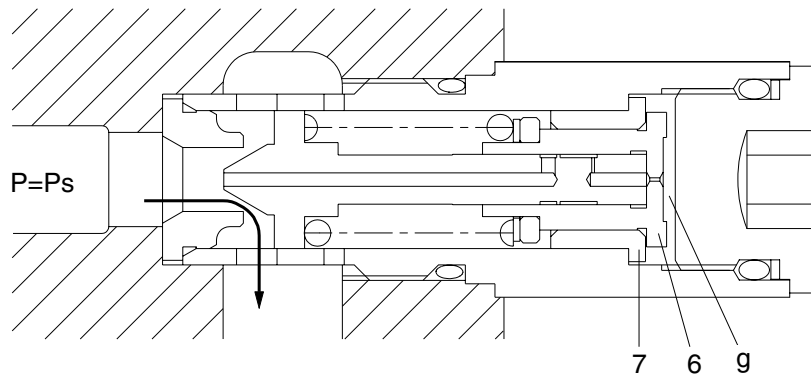


14007A2SM08

- ④ When piston (6) hits the bottom of bushing (7), it stops moving to the left any further. As the result, the pressure in chamber (g) equals (Ps).

$$P_s \times A_1 = F_{sp} + P_s \times A_2$$

$$P_s = \frac{F_{sp}}{A_1 - A_2}$$



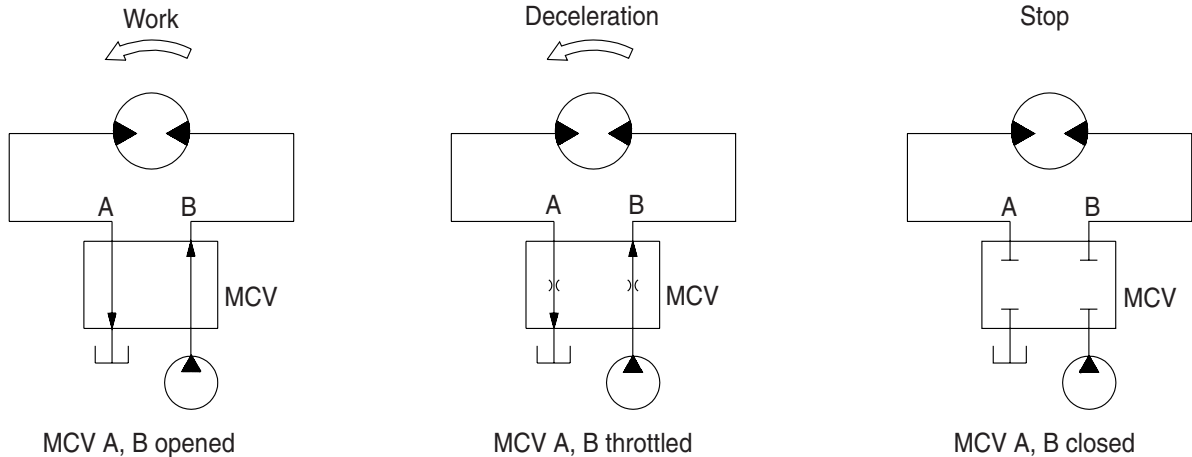
14007A2SM09

4) BRAKE SYSTEM

(1) Control valve swing brake system

This is the brake system to stop the swing motion of the excavator during operation.

In this system, the hydraulic circuit is throttled by the swing control valve, and the resistance created by this throttling works as a brake force to slow down the swing motion.



2-48(1)

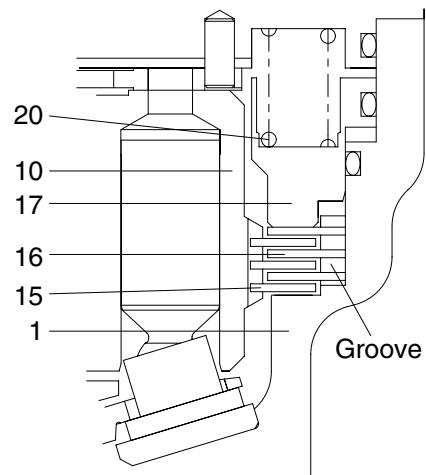
(2) Mechanical swing parking brake system

This is function as a parking brake only when all of the RCV lever (except travel pedal) are not operated.

① Brake assembly

Circumferential rotation of separate plate (16) is constrained by the groove located at housing (1). When housing is pressed down by brake spring (20) through friction plate (15), separate plate (16) and brake piston (17), friction force occurs there.

Cylinder block (10) is constrained by this friction force and brake acts, while brake releases when hydraulic force exceeds spring force.

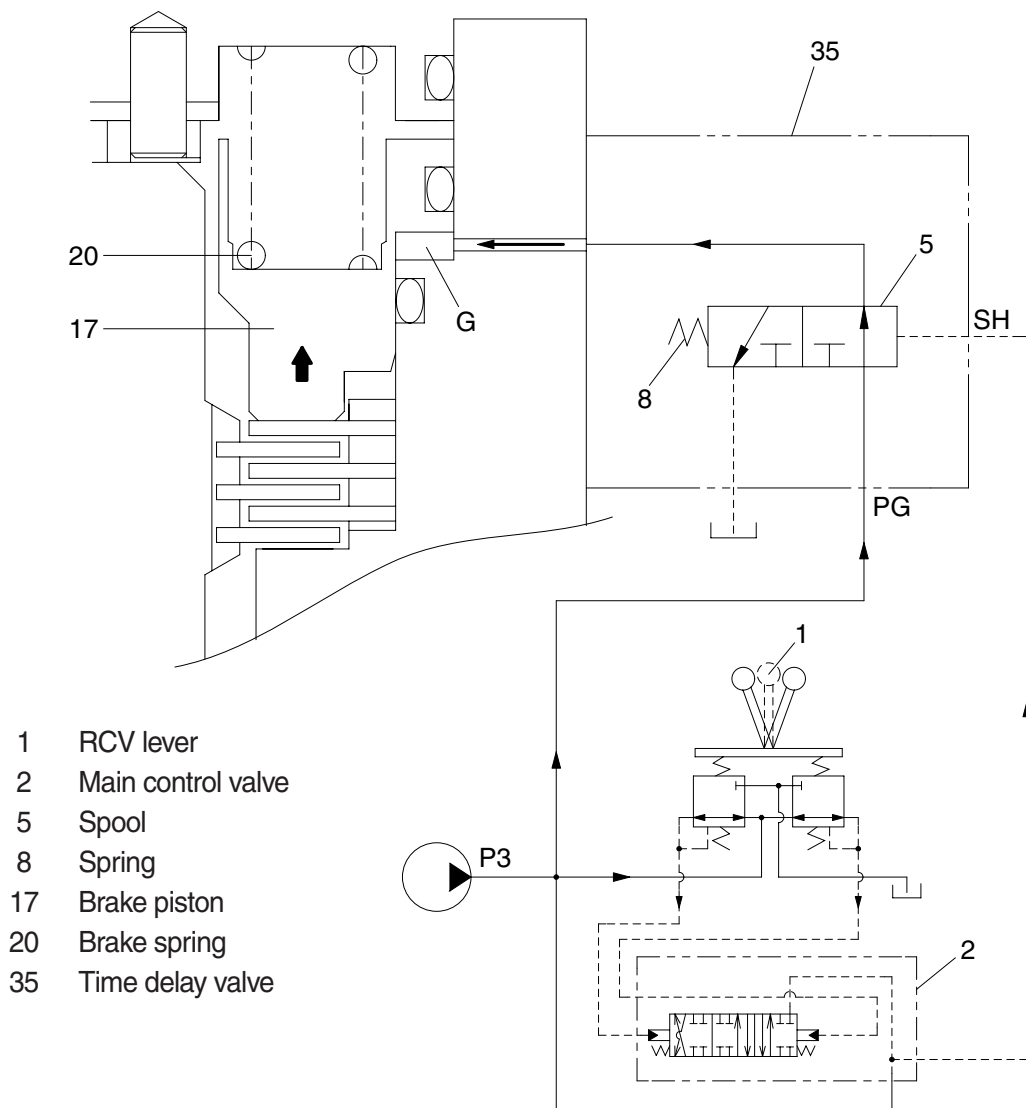


21092SM15

| | | | |
|----|----------------|----|----------------|
| 1 | Housing | 16 | Separate plate |
| 10 | Cylinder block | 17 | Brake piston |
| 15 | Friction plate | 20 | Brake spring |

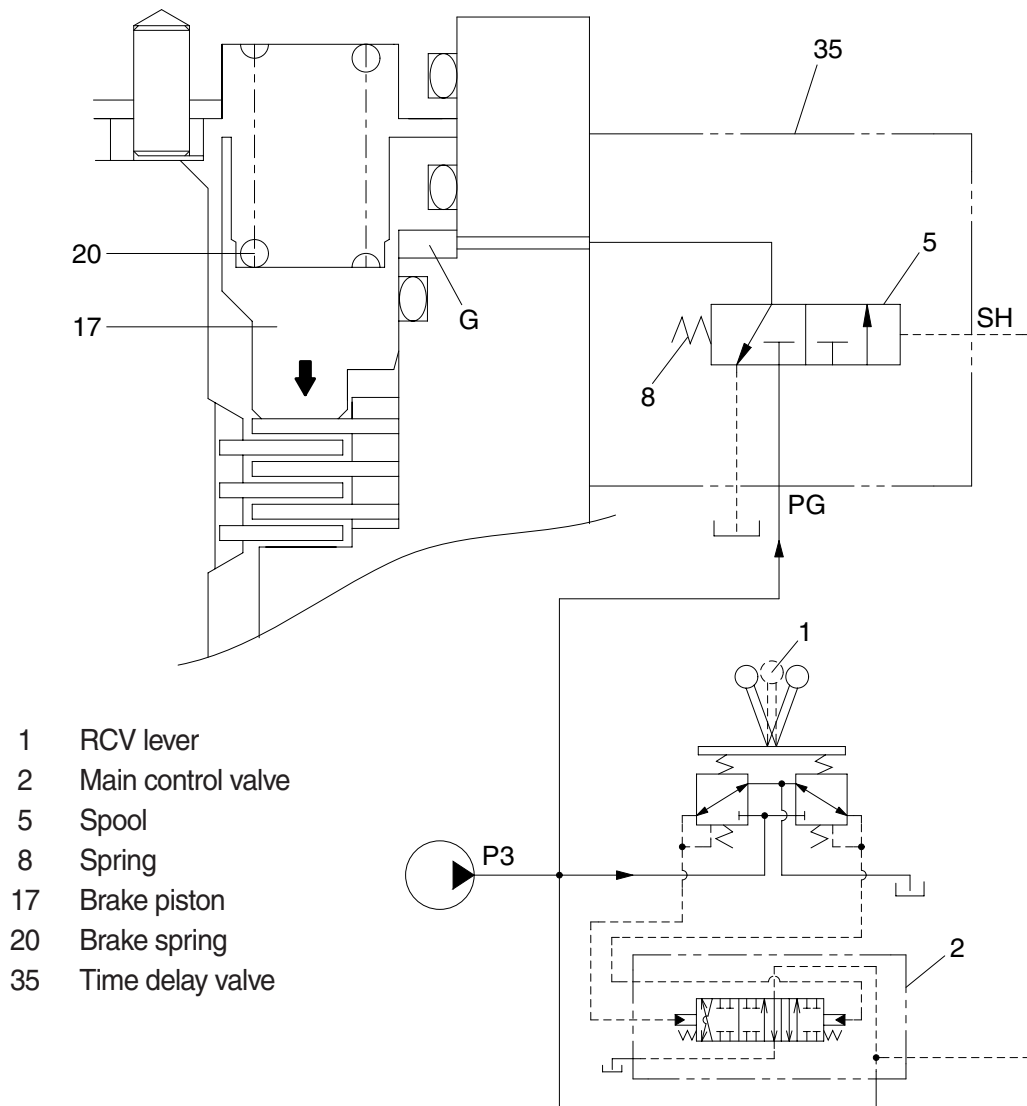
② Operating principle

- a. When one of the RCV lever (1) is set to the operation position, the each spool is shifted to left or right and the pilot oil flow is blocked. Then the pilot oil go to SH of the time delay valve (35). This pressure moves spool (5) to the leftward against the force of the spring(8), so pilot pump charged oil (P3) goes to the chamber G through port PG. This pressure is applied to move the piston (17) to the upward against the force of the spring (20). Thus, it releases the brake force.



21092SM16

- b. When all of the RCV lever (1) are set the neutral position, the spool (5) returns to right. Then, the brake piston (17) is moved lower by spring force and the return oil from the chamber G flows back to tank port. At this time, the brake works.



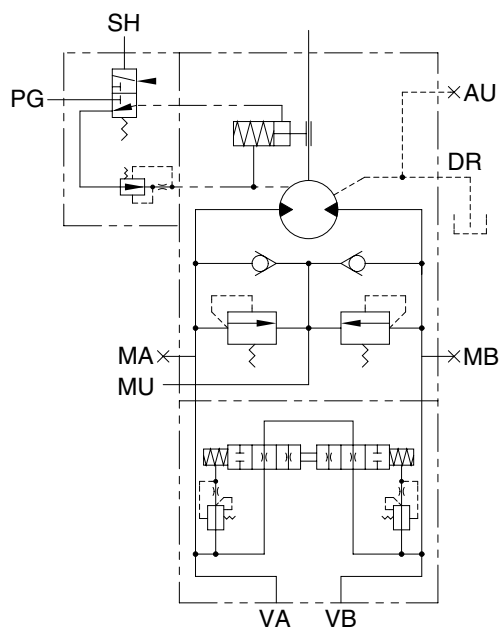
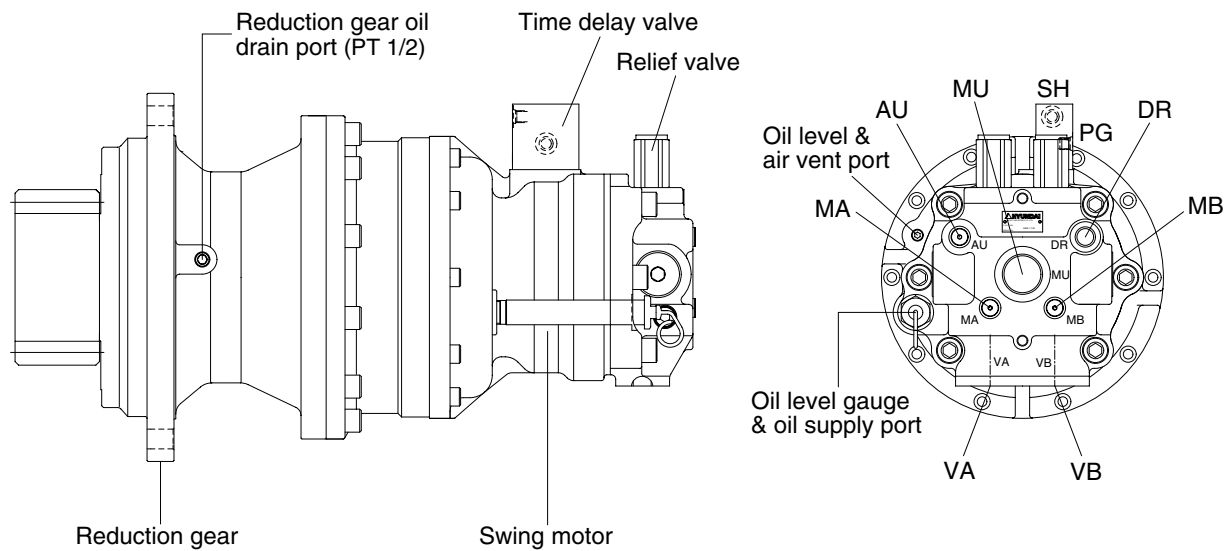
21092SM17

GROUP 3 SWING DEVICE (TYPE 2 & TYPE 3)

1. STRUCTURE

Swing device consists swing motor, swing reduction gear.

Swing motor include mechanical parking valve, relief valve, make up valve and time delay valve.

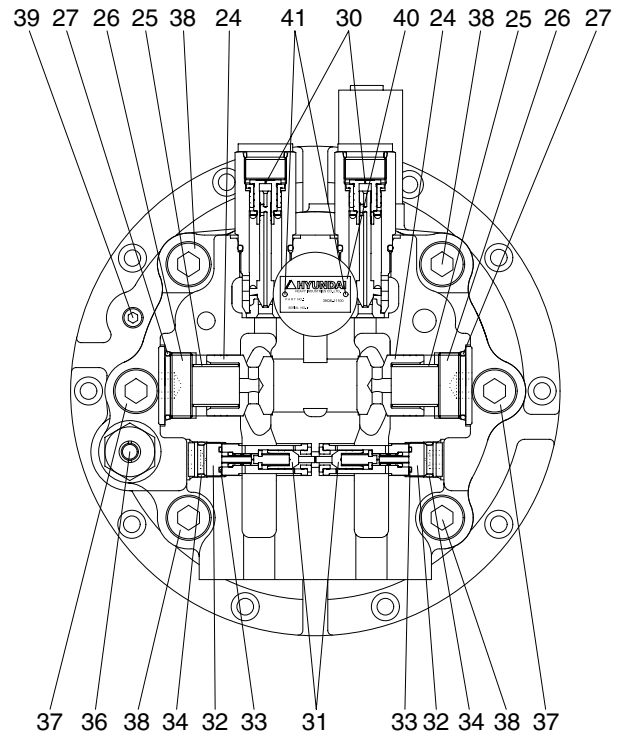
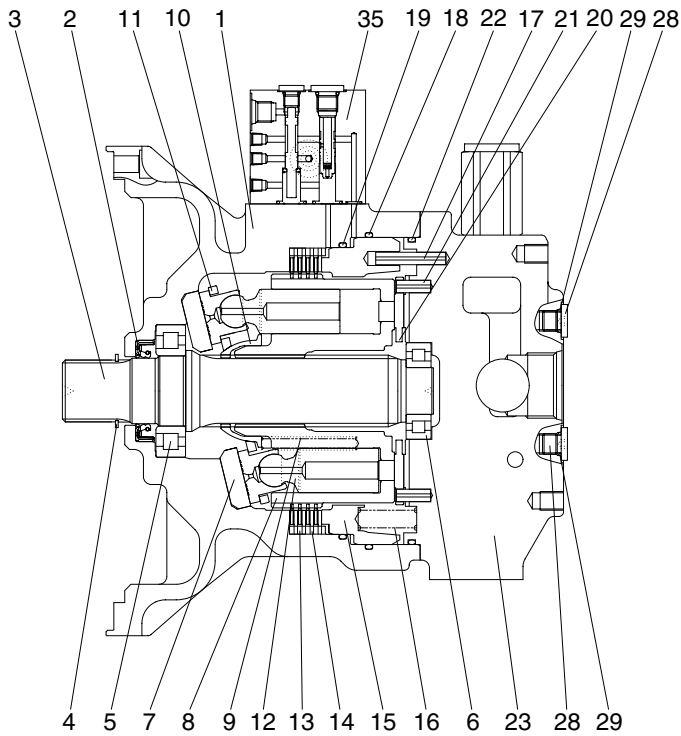


Hydraulic circuit

| Port | Port name | Port size |
|--------|--------------------|-----------|
| VA | Main port | ø 20 |
| VB | Main port | ø 20 |
| DR | Drain port | PF 1/2 |
| MU | Make up port | PF 1 1/4 |
| PG | Brake release port | PF 1/4 |
| SH | Stand by port | PF 1/4 |
| MA, MB | Gauge port | PF 1/4 |
| AU | Air vent port | PF 1/4 |

2209A2SM21

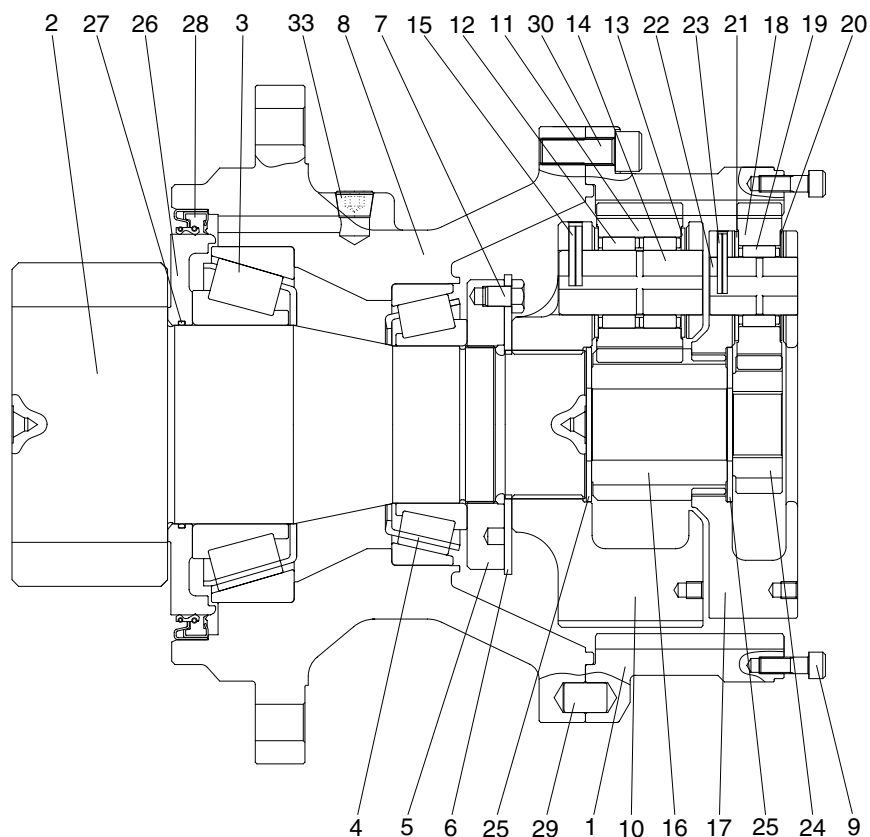
1) SWING MOTOR



2209A2SM22

| | | |
|-------------------|-------------------|----------------------------|
| 1 Casing | 15 Parking piston | 29 O-ring |
| 2 Oil seal | 16 Brake spring | 30 Relief valve assy |
| 3 Shaft | 17 Spring pin | 31 Reactionless valve assy |
| 4 Snap ring | 18 O-ring | 32 Plug |
| 5 Roller bearing | 19 O-ring | 33 O-ring |
| 6 Needle bearing | 20 Valve plate | 34 O-ring |
| 7 Swash plate | 21 Spring pin | 35 Time delay valve assy |
| 8 Cylinder block | 22 O-ring | 36 Level gauge |
| 9 Spring | 23 Valve casing | 37 Socket bolt |
| 10 Ball guide | 24 Check valve | 38 Socket bolt |
| 11 Retainer plate | 25 Spring | 39 Plug |
| 12 Piston assy | 26 Plug | 40 Name plate |
| 13 Friction plate | 27 O-ring | 41 Rivet |
| 14 Separate plate | 28 Plug | |

2) REDUCTION GEAR



2209A2SM23

| | | | | | |
|----|--------------|----|------------------|----|-----------------|
| 1 | Ring gear | 11 | Planetary gear 2 | 21 | Thrust washer 1 |
| 2 | Drive shaft | 12 | Needle bearing 2 | 22 | Carrier pin 1 |
| 3 | Bearing | 13 | Thrust washer 2 | 23 | Spring pin |
| 4 | Bearing | 14 | Carrier pin 2 | 24 | Sun gear 1 |
| 5 | Ring nut | 15 | Spring pin | 25 | Thrust plate |
| 6 | Lock plate | 16 | Sun gear 2 | 26 | Sleeve |
| 7 | Hexagon bolt | 17 | Carrier 1 | 27 | O-ring |
| 8 | Casing | 18 | Planetary gear 1 | 29 | Parallel pin |
| 9 | Socket bolt | 19 | Needle bearing 1 | 30 | Socket bolt |
| 10 | Carrier 2 | 20 | Thrust washer 1 | 33 | Plug |

2. PRINCIPLE OF DRIVING

1) GENERATING THE TURNING FORCE

The high hydraulic supplied from a hydraulic pump flows into a cylinder block (8) through valve casing of motor (23), and valve plate (20).

The high hydraulic is built as flowing on one side of Y-Y line connected by the upper and lower sides of piston (12).

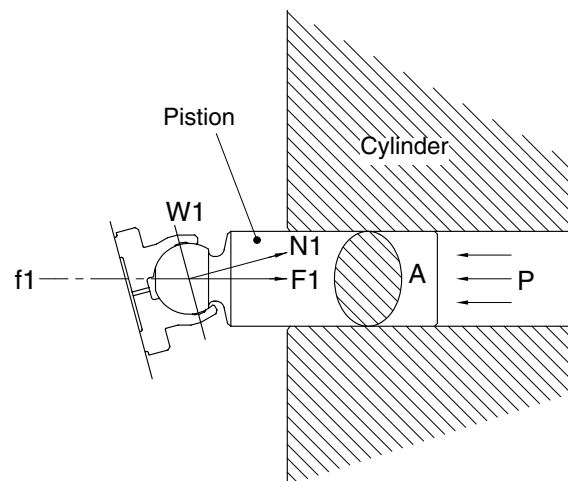
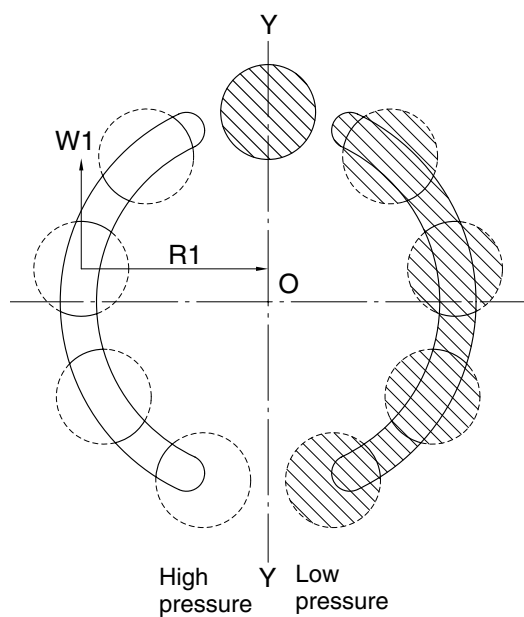
The high hydraulic can generate the force, $F1 = P \times A$ (P : supplied pressure, A : water pressure area), like following pictures, working on a piston.

This force, $F1$, is divided as $N1$ thrust partial pressure and $W1$ radial partial pressure, in case of the plate of a tilt angle, α .

$W1$ generates torque, $T = W1 \times R1$, for Y-Y line connected by the upper and lower sides of the piston as following pictures.

The sum of torque ($\Sigma W1 \times R1$), generated from each piston (4~5 pieces) on the side of a high hydraulic, generates the turning force.

This torque transfers the turning force to a cylinder (8) through a piston; because a cylinder is combined with a turning axis and spline, a turning axis rotates and a turning force is sent.



21078TM05

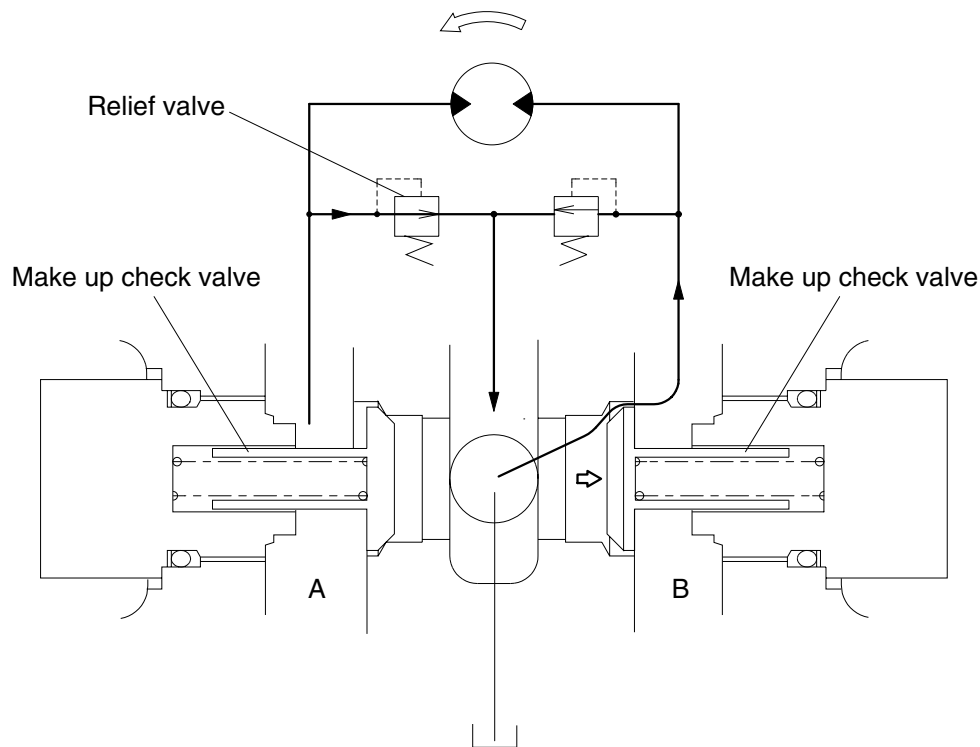
2) MAKE UP VALVE

In the system using this type of motor, there is no counter balance functioning valve and there happens the case of revolution exceeding hydraulic supply of motor. To prevent the cavitation caused by insufficient oil flow there is a make up valve to fill up the oil insufficiency.

A make up valve is provided immediately before the port leading to the hydraulic oil tank to secure feed pressure required when the hydraulic motor makes a pumping action. The boost pressure acts on the hydraulic motor's feed port via the make up valve.

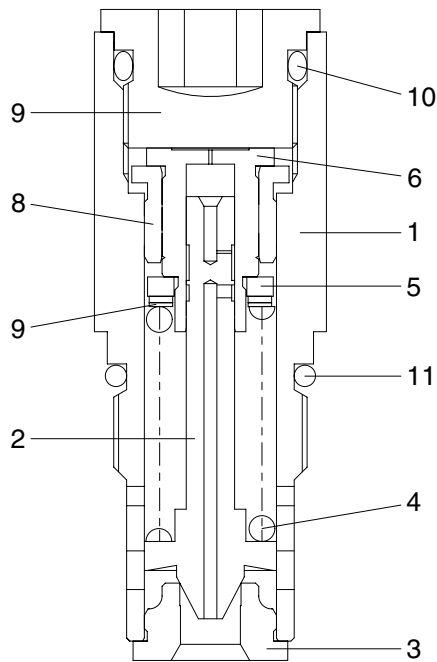
Pressurized oil into the port B, the motor rotate counterclockwise.

If the plunger of MCV moves neutral position, the oil in the motor is drain via left relief valve, the drain oil run into motor via right make up valve, which prevent the cavitation of motor.



21092SM04

3) RELIEF VALVE



2209A2SM25

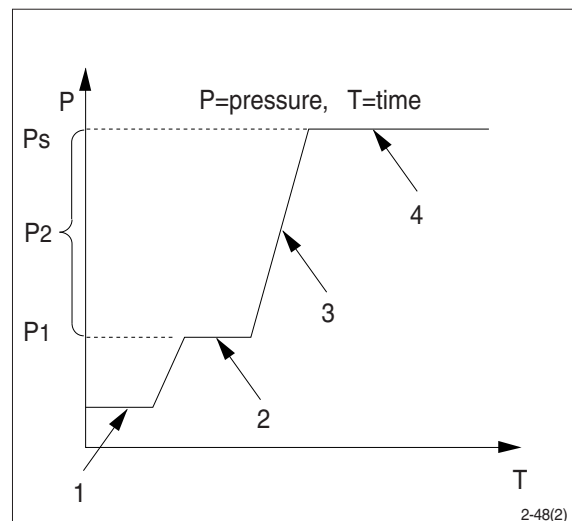
- | | |
|----|-------------|
| 1 | Sleeve |
| 2 | Poppet |
| 3 | Poppet seat |
| 4 | Spring |
| 5 | Spring seat |
| 6 | Shim |
| 7 | Piston |
| 8 | Stopper |
| 9 | Plug |
| 10 | O-ring |
| 11 | O-ring |

(1) Construction of relief valve

The valve casing contains two cartridge type relief valves that stop the regular and reverse rotations of the hydraulic motor. The relief valves relieve high pressure at start or at stop of swing motion and can control the relief pressure in two steps, high and low, in order to insure smooth operation.

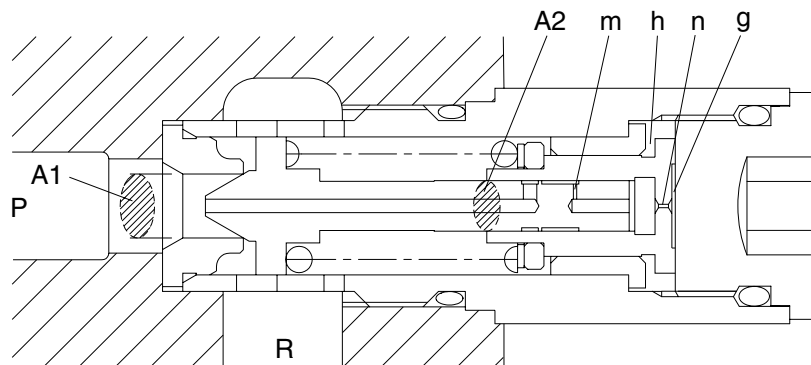
(2) Function of relief valve

Figure illustrates how the pressure acting on the relief valve is related to its rising process. Here is given the function, referring to the figure following page.



2-48(2)

- ① Ports (P, R) at tank pressure.

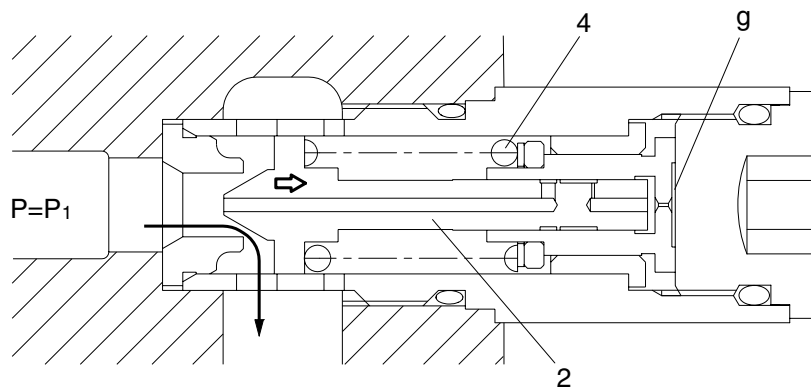


2209A2SM26

- ② When hydraulic oil pressure ($P \times A_1$) reaches the preset force (F_{SP}) of spring (4), the plunger (2) moves to the right as shown.

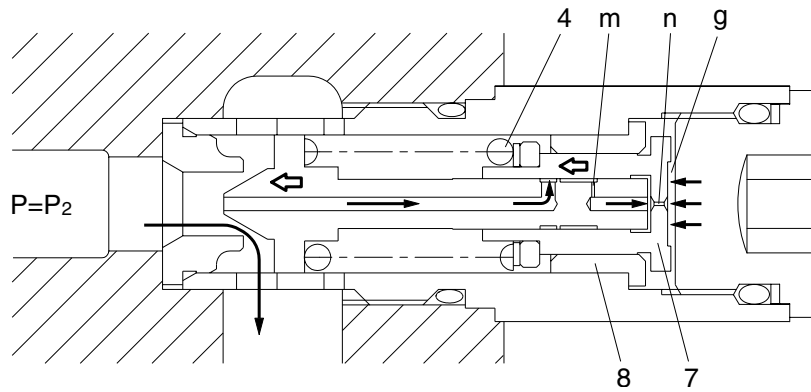
$$P_1 \times A_1 = F_{SP} + P_g \times A_2$$

$$P_1 = \frac{F_{SP} + P_g \times A_2}{A_1}$$



2209A2SM27

- ③ The oil flow chamber g via orifice m and n. When the pressure of chamber g reaches the preset force (Fsp) of spring (4), the piston (7) moves left and stop the piston (7) hits the bottom of bushing (8).

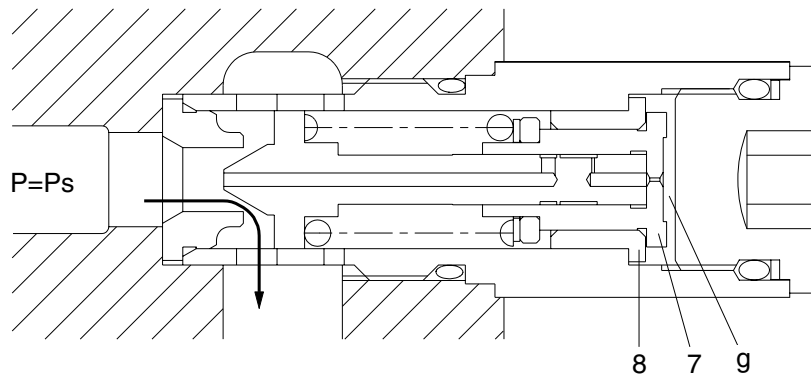


2209A2SM28

- ④ When piston (7) hits the bottom of bushing (8), it stops moving to the left any further. As the result, the pressure in chamber (g) equals (Ps).

$$P_s \times A_1 = F_{sp} + P_s \times A_2$$

$$P_s = \frac{F_{sp}}{A_1 - A_2}$$



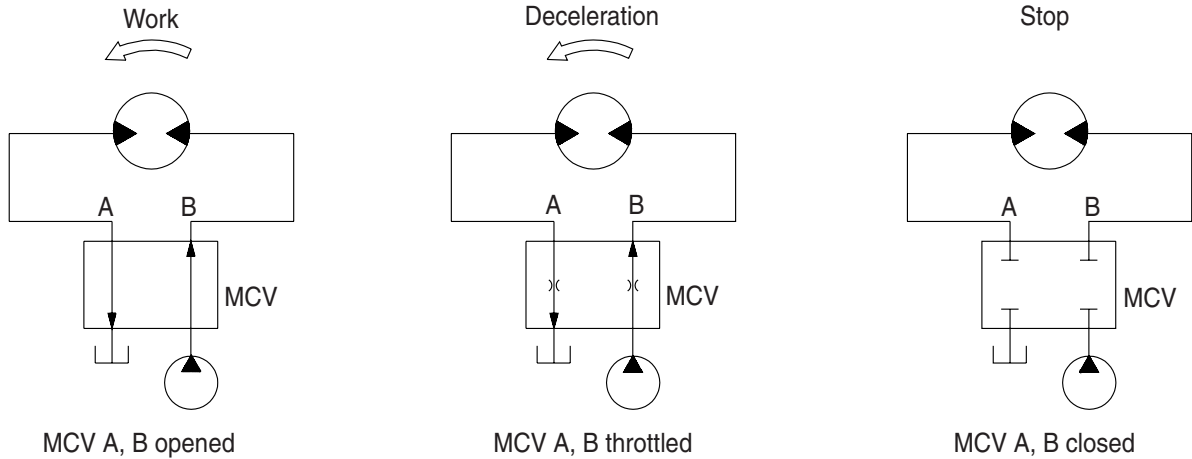
2209A2SM29

4) BRAKE SYSTEM

(1) Control valve swing brake system

This is the brake system to stop the swing motion of the excavator during operation.

In this system, the hydraulic circuit is throttled by the swing control valve, and the resistance created by this throttling works as a brake force to slow down the swing motion.



2-48(1)

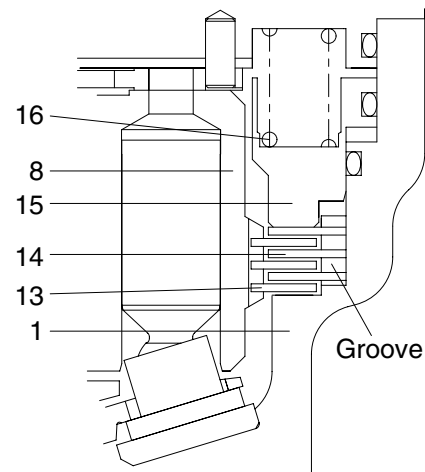
(2) Mechanical swing parking brake system

This is function as a parking brake only when all of the RCV lever (except travel pedal) are not operated.

① Brake assembly

Circumferential rotation of separate plate (14) is constrained by the groove located at casing (1). When housing is pressed down by brake spring (16) through friction plate (13), separate plate (14) and parking piston (15), friction force occurs there.

Cylinder block (8) is constrained by this friction force and brake acts, while brake releases when hydraulic force exceeds spring force.

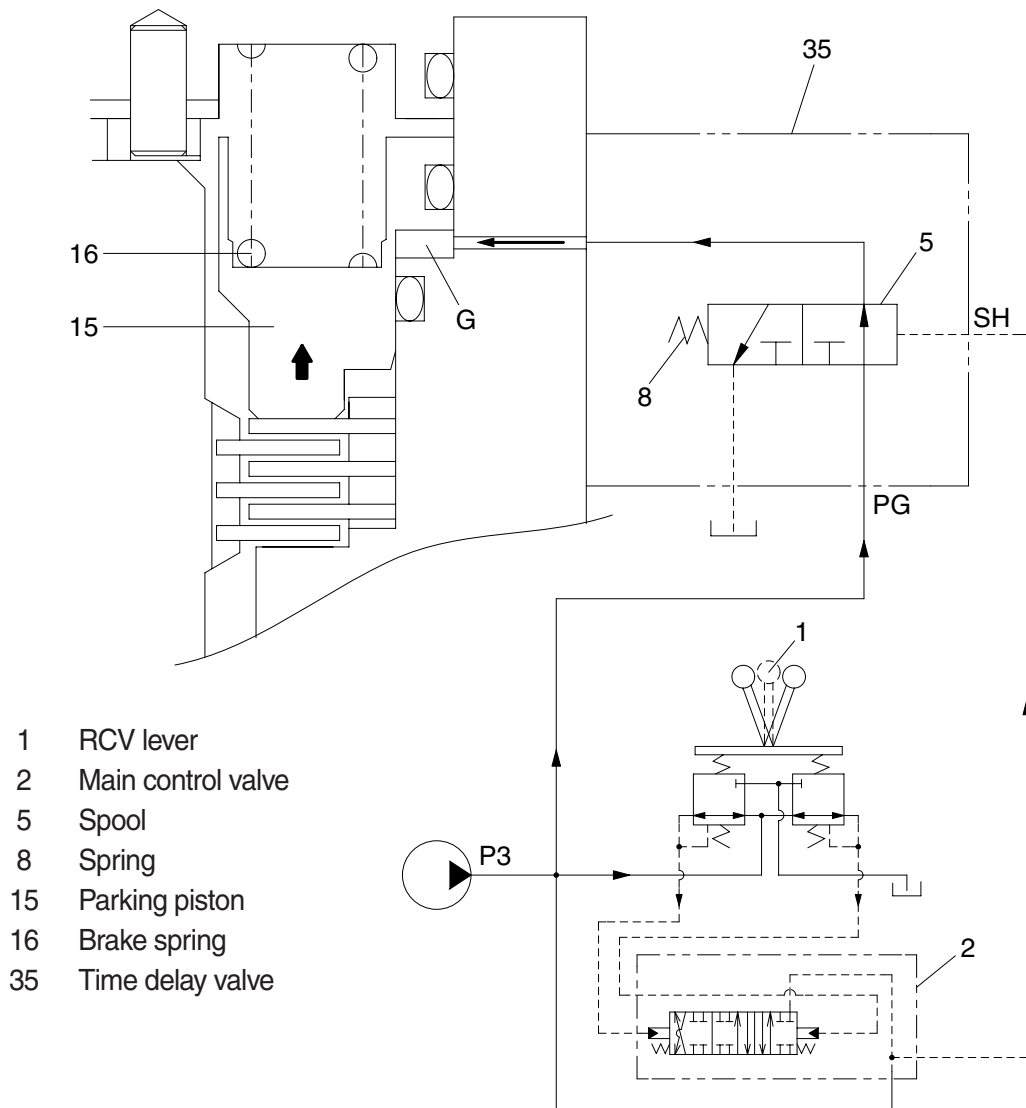


2209A2SM35

| | | | |
|----|----------------|----|----------------|
| 1 | Casing | 14 | Separate plate |
| 8 | Cylinder block | 15 | Parking piston |
| 13 | Friction plate | 16 | Brake spring |

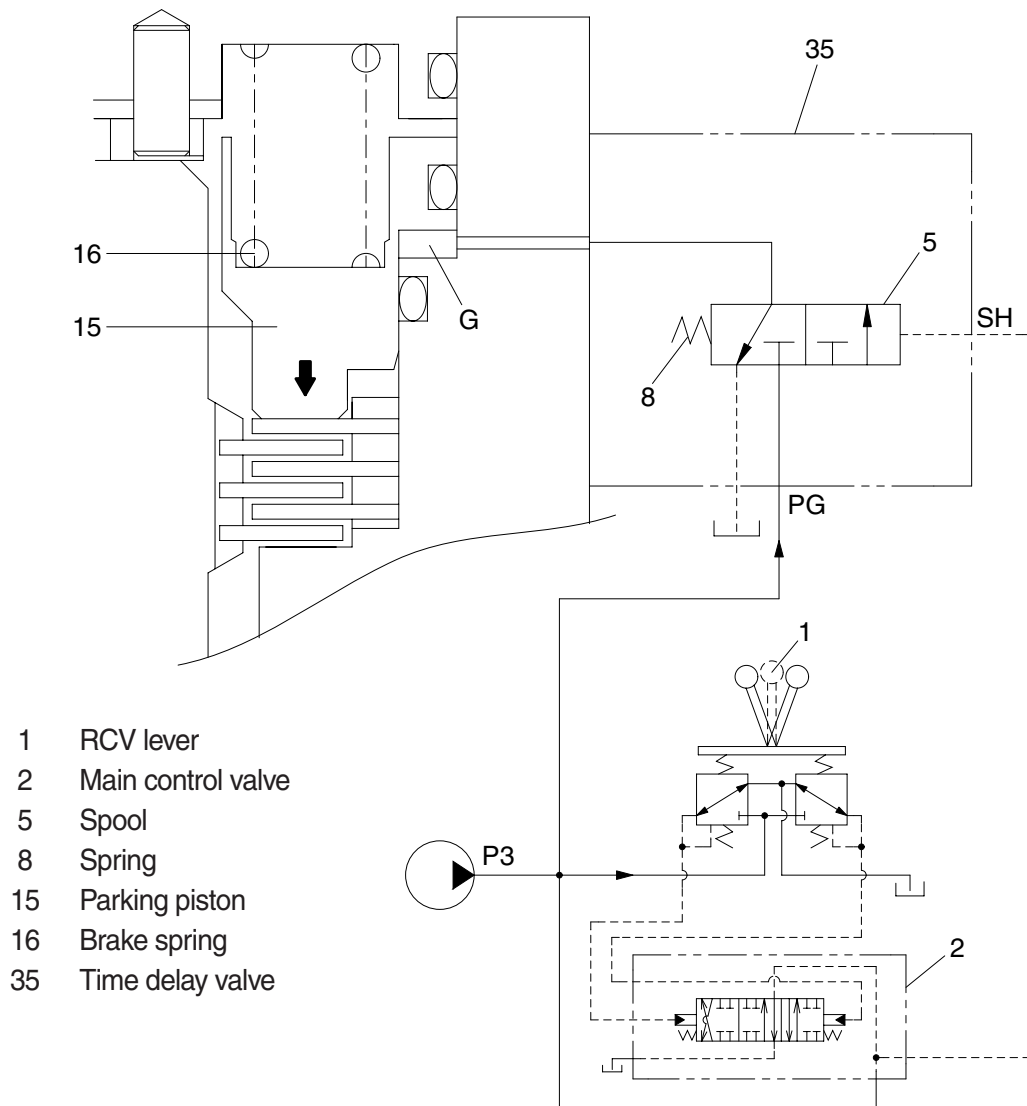
② Operating principle

- a. When one of the RCV lever (1) is set to the operation position, the each spool is shifted to left or right and the pilot oil flow is blocked. Then the pilot oil go to SH of the time delay valve (35). This pressure moves spool (5) to the leftward against the force of the spring(8), so pilot pump charged oil (P3) goes to the chamber G through port PG. This pressure is applied to move the parking piston (15) to the upward against the force of the brake spring (16). Thus, it releases the brake force.



2209A2SM36

- b. When all of the RCV lever (1) are set the neutral position, the spool (5) returns to right. Then, the parking piston (15) is moved lower by spring force and the return oil from the chamber G flows back to tank port. At this time, the brake works.



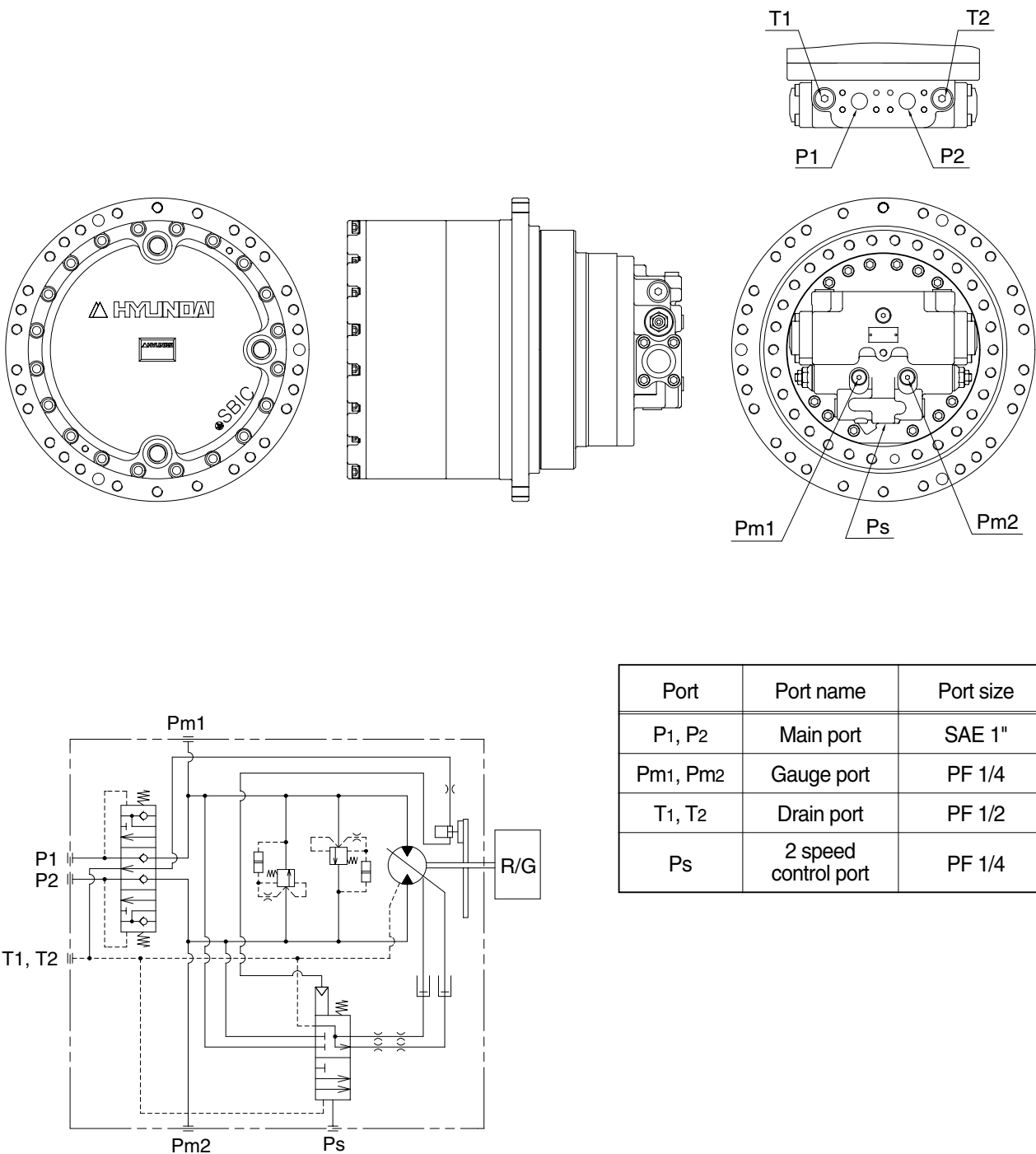
2209A2SM37

GROUP 4 TRAVEL DEVICE

1. STRUCTURE

A hydraulic motor includes followings.

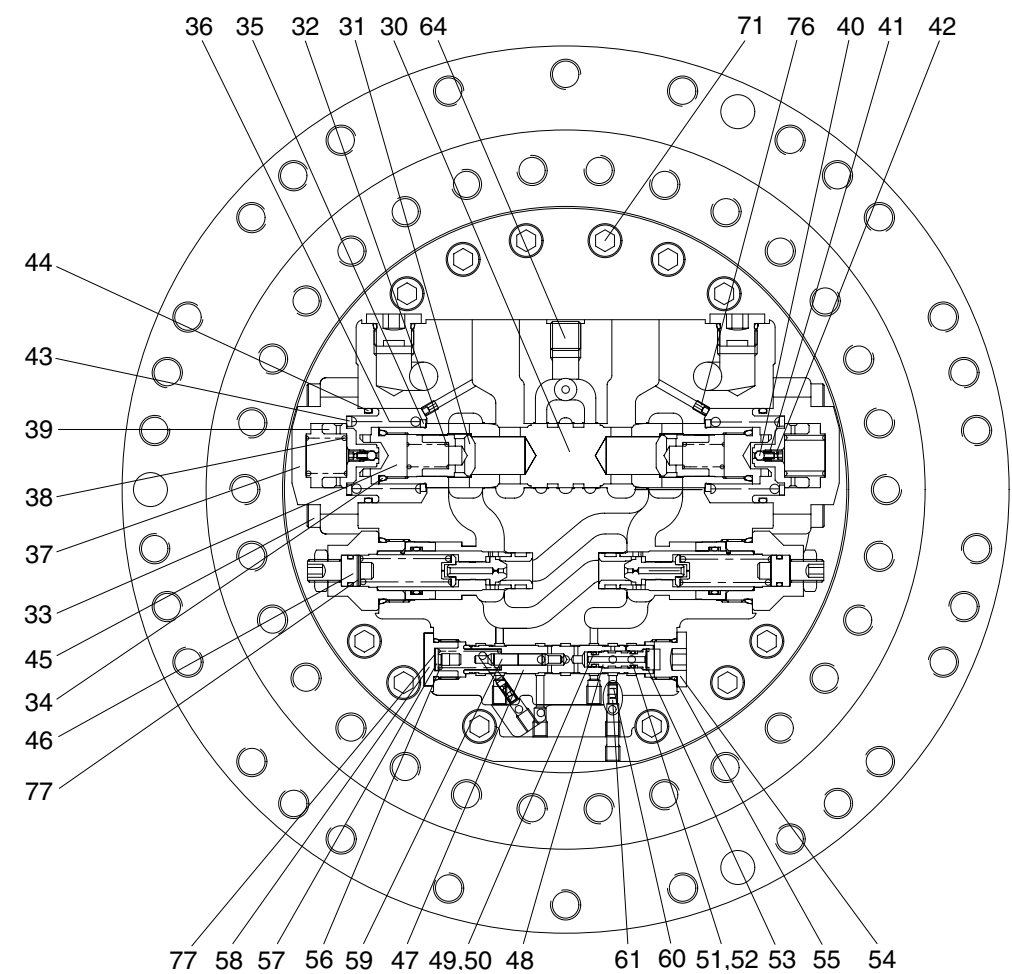
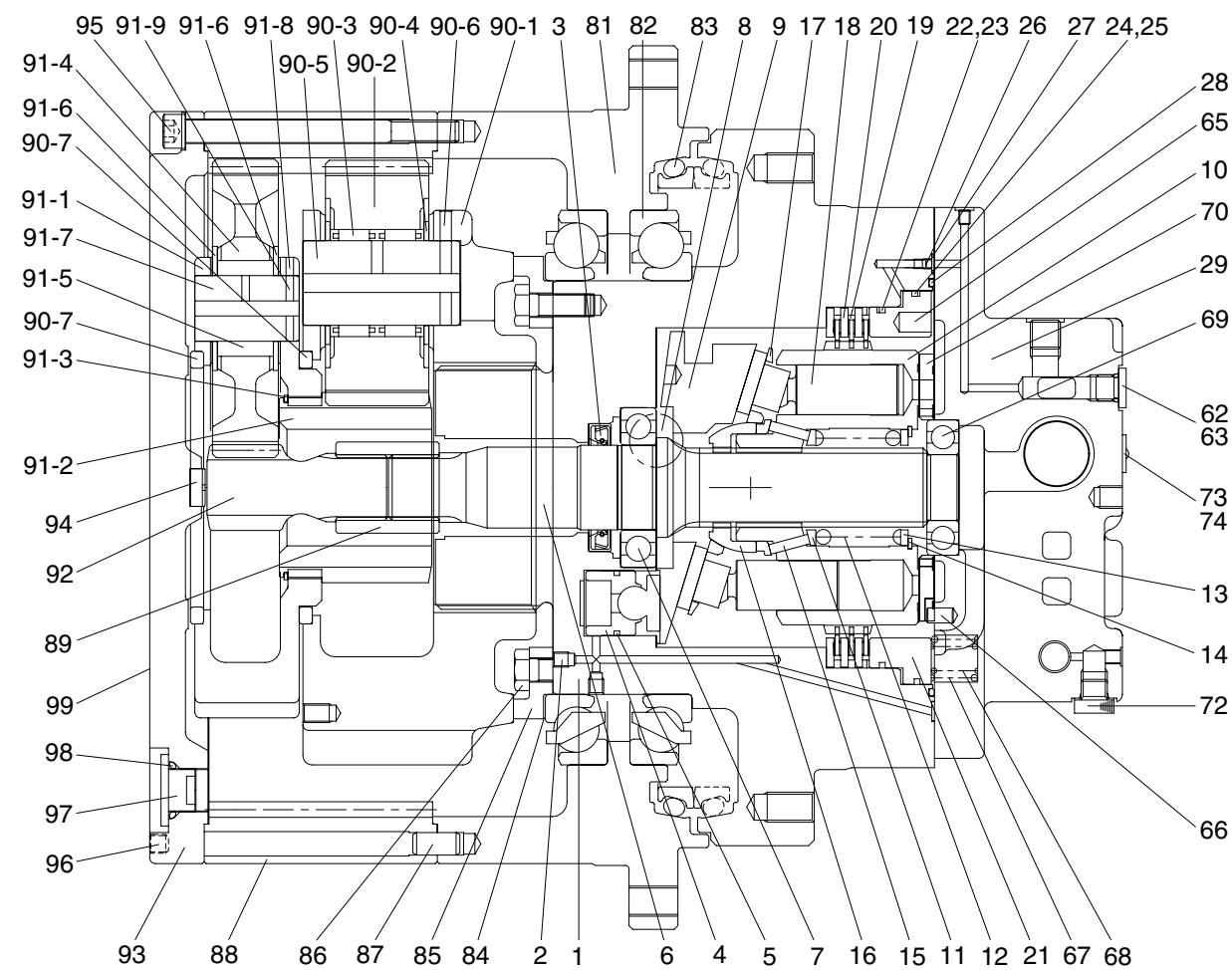
- Part of rotary generating turning force
- Part of a valve of relief
- Part of Brake
- Part of a valve of counterbalance
- Part of flowing changeover
- Part of auto changeover



| Port | Port name | Port size |
|----------|----------------------|-----------|
| P1, P2 | Main port | SAE 1" |
| Pm1, Pm2 | Gauge port | PF 1/4 |
| T1, T2 | Drain port | PF 1/2 |
| Ps | 2 speed control port | PF 1/4 |

RD21072TM12

1) STRUCTURE



| | | | | | | | | | | | |
|----|----------------|----|----------------|----|-------------------|----|-------------|------|---------------------|------|----------------------|
| 1 | Shaft casing | 20 | Plate | 39 | Spool | 58 | Plug | 77 | Shim | 91-1 | Carrier No.1 |
| 2 | Plug | 21 | Packing piston | 40 | Steel ball | 59 | Spool | 81 | Housing | 91-2 | Sun-gear No.2 |
| 3 | Oil seal | 22 | O-ring | 41 | Spring | 60 | Orifice | 82 | Main bearing | 91-3 | Retaining ring |
| 4 | Swash piston | 23 | Back up ring | 42 | Plug | 61 | Orifice | 83 | Floating seal | 91-4 | Planetary gear No.1 |
| 5 | Piston ring | 24 | O-ring | 43 | Spring seat | 62 | Plug | 84 | Shim | 91-5 | Needle bearing No.1 |
| 6 | Shaft | 25 | Back up ring | 44 | O-ring | 63 | O-ring | 85 | Retainer | 91-6 | Thrust washer |
| 7 | Bearing | 26 | Orifice | 45 | Wrench bolt | 64 | Plug | 86 | Hex head bolt | 91-7 | Pin No.1 |
| 8 | Steel ball | 27 | O-ring | 46 | Relief valve assy | 65 | Pin | 87 | Parallel pin | 91-8 | Spring pin |
| 9 | Swash plate | 28 | O-ring | 47 | Spool | 66 | Pin | 88 | Ring gear | 91-9 | Spring pin |
| 10 | Cylinder block | 29 | Rear cover | 48 | Guide | 67 | Spring | 89 | Coupling | 92 | Sun gear No.1 |
| 11 | Spring seat | 30 | Spool | 49 | O-ring | 68 | Spring | 90 | Carrier assy No.2 | 93 | Cover |
| 12 | Spring | 31 | Check | 50 | Back up ring | 69 | Bearing | 90-1 | Carrier No.2 | 94 | Pad |
| 13 | End plate | 32 | Spring | 51 | O-ring | 70 | Valve plate | 90-2 | Planetary gear No.2 | 95 | Hex socket head bolt |
| 14 | Snap ring | 33 | Plug | 52 | Back up ring | 71 | Wrench bolt | 90-3 | Needle bearing No.2 | 96 | Hex socket Screw |
| 15 | Pin | 34 | O-ring | 53 | Snap ring | 72 | Plug | 90-4 | Thrust washer | 97 | Hydraulic plug |
| 16 | Ball guide | 35 | Spring seat | 54 | plug | 73 | Name plate | 90-5 | Pin No.2 | 98 | O-ring |
| 17 | Set plate | 36 | Spring | 55 | O-ring | 74 | Rivet | 90-6 | Spring pin | 99 | Name plate |
| 18 | Piston assy | 37 | Cover | 56 | Spring | 75 | Seal kit | 90-7 | Thrust ring | | |
| 19 | Friction plate | 38 | Spring | 57 | Spring seat | 76 | Orifice | 91 | Carrier assy No.1 | | |

2107V2TM02

2. PRINCIPLE OF DRIVING

2.1 Generating the turning force

The high hydraulic supplied from a hydraulic pump flows into a cylinder(10) through valve casing of motor(29), and valve plate(77).

The high hydraulic is built as flowing on one side of Y-Y line connected by the upper and lower sides of piston(18).

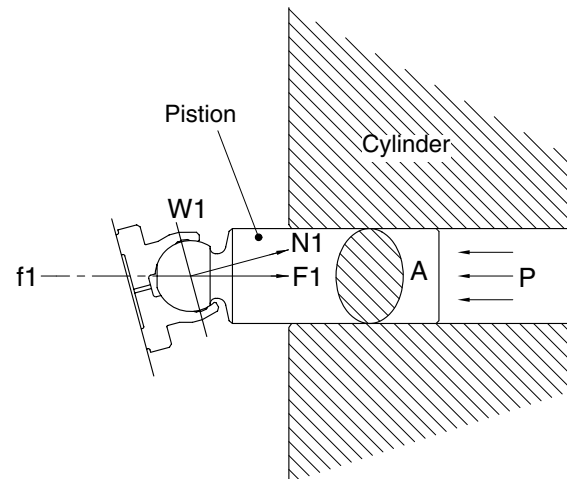
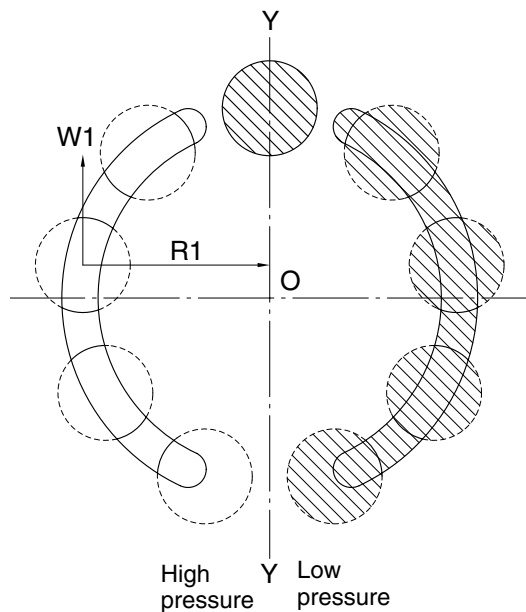
The high hydraulic can generate the force, $F1 = P \times A$ (P : Supplied pressure, A : water pressure area), like following pictures, working on a piston.

This force, F1, is divided as N1 thrust partial pressure and W1 radial partial pressure, in case of the plate(09) of a tilt angle, α .

W1 generates torque, $T = W1 \times R1$, for Y-Y line connected by the upper and lower sides of piston as following pictures.

The sum of torque ($\sum W1 \times R1$), generated from each piston(4~5pieces) on the side of a high hydraulic, generates the turning force.

This torque transfers the turning force to a cylinder(10) through a piston; because a cylinder is combined with a turning axis and spline, a turning axis rotates and a turning force is sent.



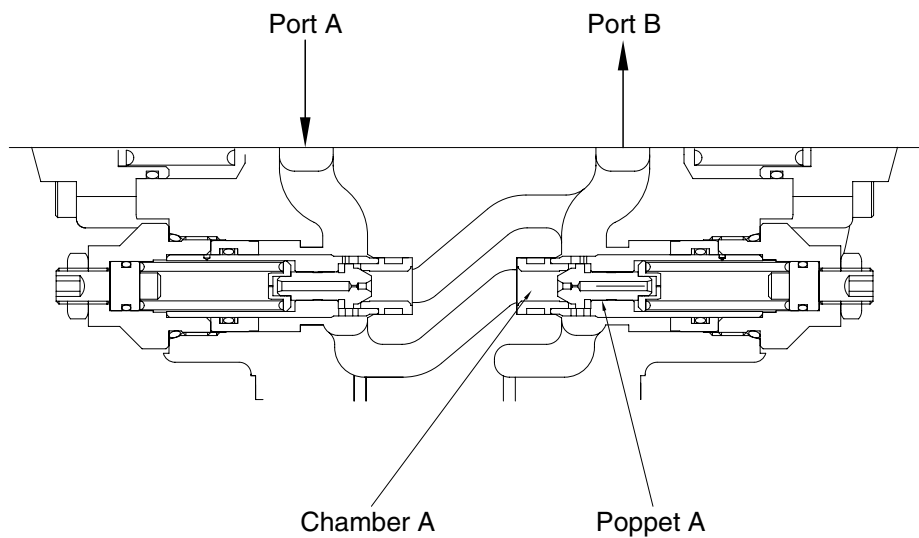
21078TM05

2.2 Working of relief valve

Relief valve carries on two functions of followings.

- 1) It standardizes a pressure in case of driving a hydraulic motor ; bypasses and extra oil in a motor inlet related to acceleration of an inertia to an outlet.
- 2) In case of an inertia stopped, it forces an equipment stopped, according to generating the pressure of a brake on the projected side.

Room A is always connected with port A of a motor. If the pressure of port is increased, press poppet A. And if it is higher than the setting pressure of a spring, the oil of an hydraulic flows from room A to port B, because poppet A is detached from the contact surface of seat A.



21078TM06A

2.3 Working of negative brake

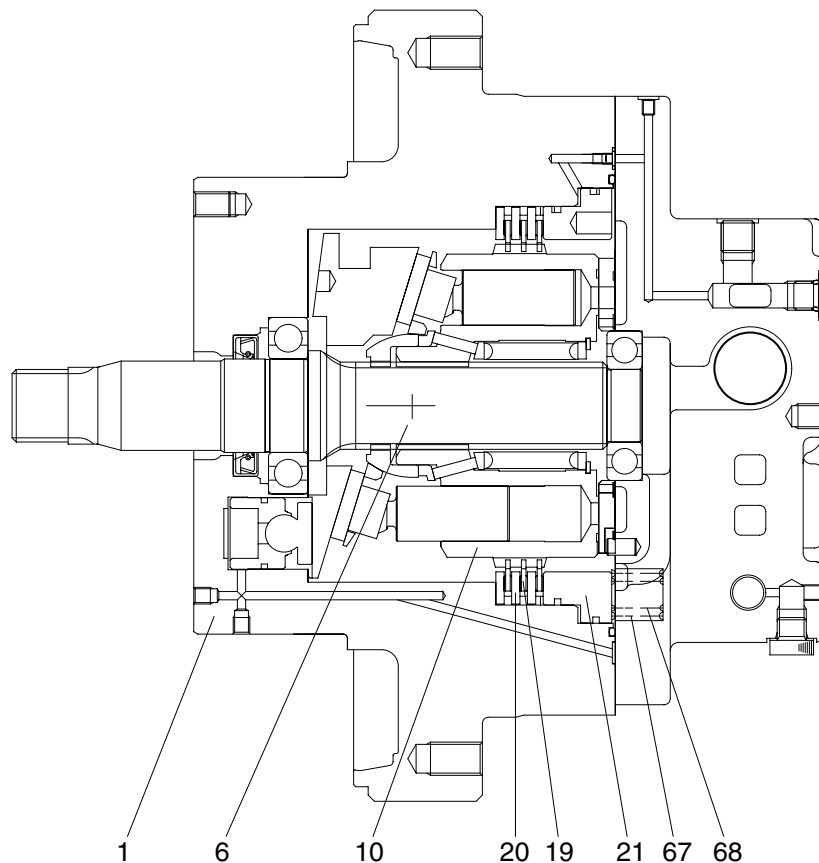
When the operating pressure is supplied to the brake piston (21) through the spool (simultaneous peripheral operation online) built in the valve casing (29), the negative brake is released.

When the pressure does not work, the brake always runs.

The force of a brake is generated by the frictional force among a separate plate (20) fixed by shaft casing, parking piston (21) and a frictional plate (19) connected through spline outside a cylinder block (10).

When a pressure does not work on the part of piston, brake spring presses brake piston; oil in a brake room flows into the drain of a motor through an orifice; in that time, brake piston compresses a frictional plate and a detached plate in the middle of shaft casing and brake piston according to the force that presses 10 pieces of brake springs (67, 68); finally, it makes a frictional force.

This frictional force helps the brake fixing a turning shaft (6) connected by a cylinder and spline operated.



21092TM07

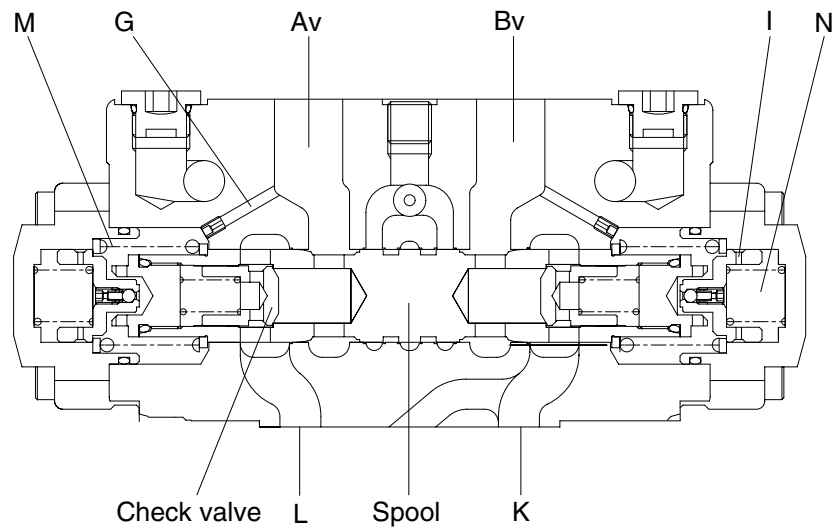
2.4 Counterbalance valve

Av port is connected to a hydraulic pump; Bv port is connected to a tank.

An oil supplied from a hydraulic pump presses check valve and flows into L port. It makes a hydraulic motor circulated. The oil pressure out of a pump is increased and transferred to spring room M through the path G because negative brake is working on. When the pressure of room M exceeds the force of spring that keeps spool at its neutral position, the spool begins to move the right side.

An oil in room N is sent to room M by orifice I and discharged from G line to a tank.

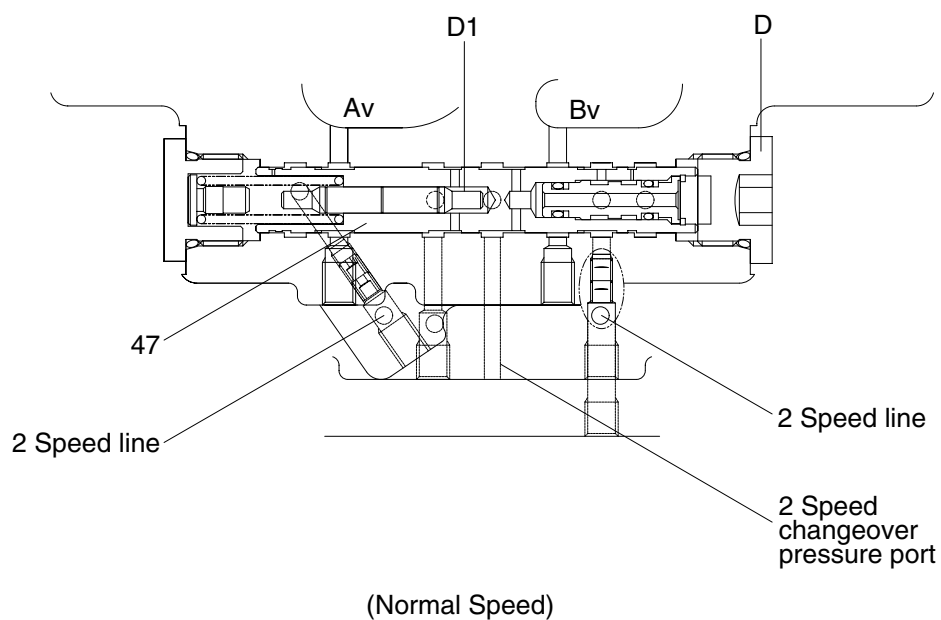
Then the spool moves to the right and the oil flows from K to Bv.



21078TM08

2.5 Working description of automatic switch(at normal speed)

Due to no pressure on pilot now, spool(47) is not working.

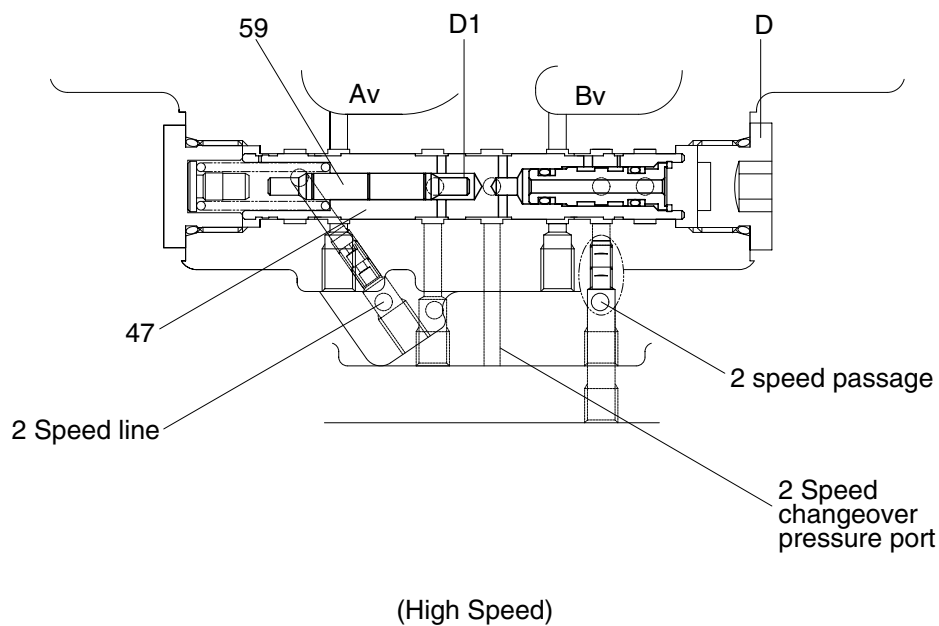


21078TM09

2.6 Working description of automatic switch(at high speed)

At normal speed, once the hydraulic oil which is through the inner path of spool(47) flows into high speed switching pressure port(The pressure of external pilot : $P_i = 35\text{kgf/cm}^2$) spool(47) moves from right to left.

At high speed, turning pressure of motor(D1) is over 250kgf/cm^2 , when the power forcing to spool(59) (pressure, P_1) is stronger than spool(47) and spool(59) is pushed out, after then spool(47) moves from left to right. So it is switched.

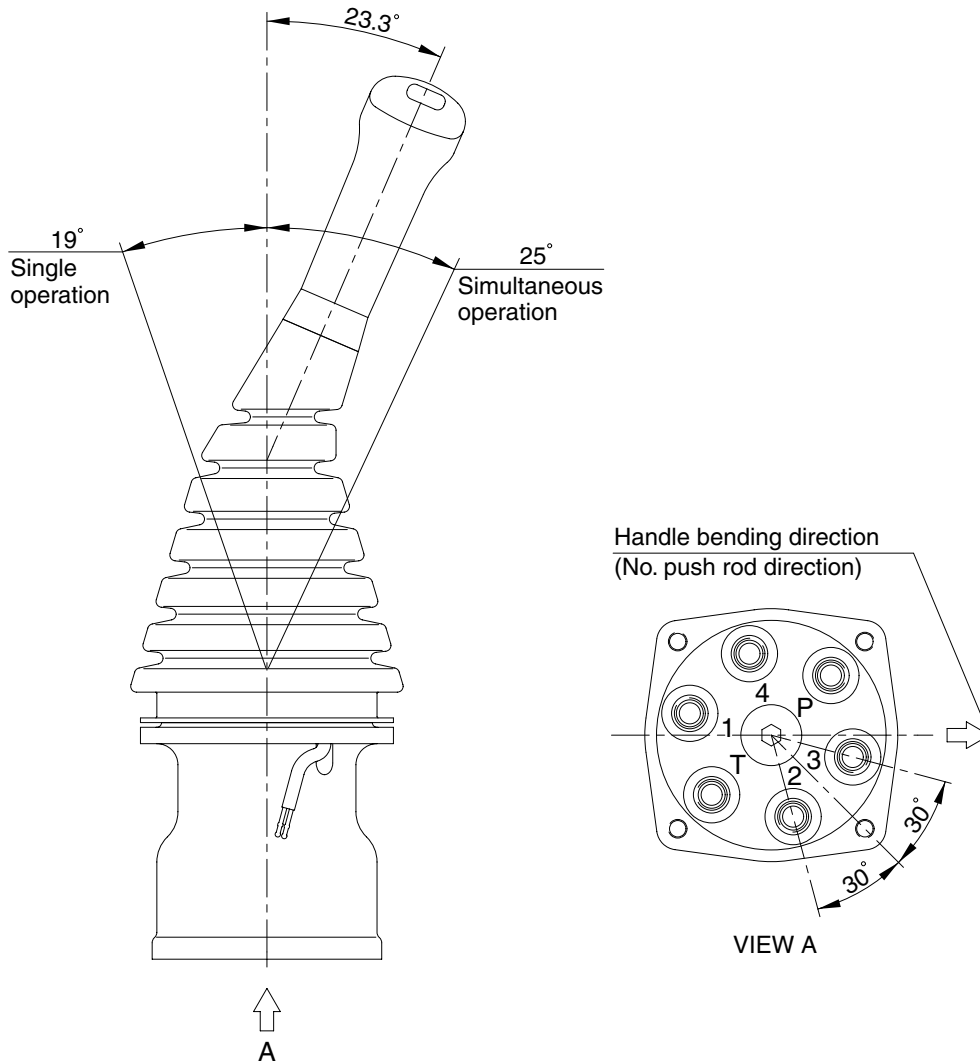


21078TM10

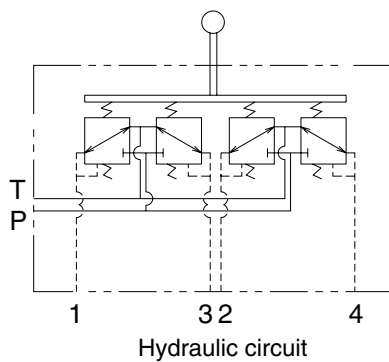
GROUP 5 RCV LEVER

1. STRUCTURE

The casing has the oil inlet port P(primary pressure) and the oil outlet port T(tank). In addition the secondary pressure is taken out through ports 1,2,3 and 4 provided at the bottom face.



25032RL01A



| Port | LH | RH | Port size |
|------|-----------------------|-----------------------|-----------|
| P | Pilot oil inlet port | Pilot oil inlet port | PF 1/4 |
| T | Pilot oil return port | Pilot oil return port | |
| 1 | Left swing port | Bucket out port | |
| 2 | Arm in port | Boom down port | |
| 3 | Right swing port | Bucket in port | |
| 4 | Arm out port | Boom up port | |

CROSS SECTION

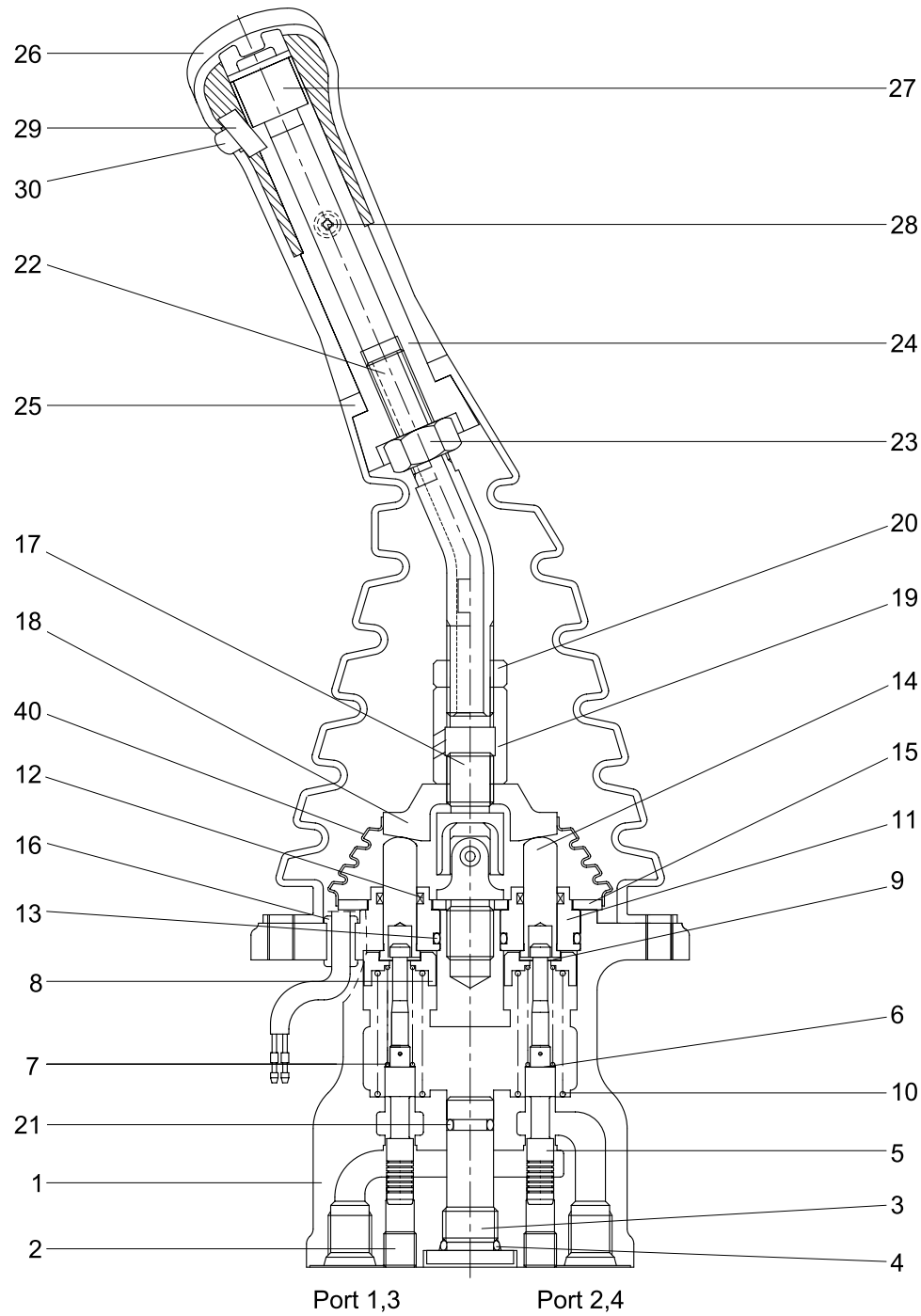
The construction of the pilot valve is shown in the attached cross section drawing. The casing has vertical holes in which reducing valves are assembled.

The pressure reducing section is composed of the spool(5), spring(7) for setting secondary pressure, return spring(10), stopper(9), spring seat(8) and shim(6). The spring for setting the secondary pressure has been generally so preset that the secondary pressure is 5 to 20.5kgf/cm²(Depending on the type). The spool is pushed against the push rod(14) by the return spring.

When the push rod is pushed down by tilting the handle, the spring seat comes down simultaneously and changes setting of the secondary pressure spring.

| | | | | | |
|----|-------------|----|------------------|----|-----------------|
| 1 | Case | 12 | Rod seal | 23 | Nut |
| 2 | Plug | 13 | O-ring | 24 | Insert |
| 3 | Plug | 14 | Push rod | 25 | Boot |
| 4 | O-ring | 15 | Plate | 26 | Handle |
| 5 | Spool | 16 | Bushing | 27 | Switch assembly |
| 6 | Shim | 17 | Joint assembly | 28 | Screw |
| 7 | Spring | 18 | Swash plate | 29 | Switch assembly |
| 8 | Spring seat | 19 | Adjusting nut | 30 | Switch cover |
| 9 | Stopper | 20 | Lock nut | 40 | Boot |
| 10 | Spring | 21 | O-ring | | |
| 11 | Plug | 22 | Handle connector | | |

CROSS SECTION



14072SF80

2. FUNCTIONS

1) FUNDAMENTAL FUNCTIONS

The pilot valve is a valve that controls the spool stroke, direction, etc of a main control valve. This function is carried out by providing the spring at one end of the main control valve spool and applying the output pressure(Secondary pressure) of the pilot valve to the other end.

For this function to be carried out satisfactorily, the pilot valve is composed of the following elements.

- (1) Inlet port(P) where oil is supplied from hydraulic pump.
- (2) Output ports(1,2,3 & 4) to apply pressure supplied from inlet port to ends of control valve spools.
- (3) Tank port(T) necessary to control the above output pressure.
- (4) Spool to connect output port to inlet port or tank port.
- (5) Mechanical means to control output pressure, including springs that work on the above spools.

2) FUNCTIONS OF MAJOR SECTIONS

The functions of the spool(5) are to receive the supply oil pressure from the hydraulic pump at its port P, and to change over oil paths to determine whether the pressure oil of port P is led to output ports 1,2,3 & 4 or the output port pressure oil to tank port T.

The spring(7) works on this spool to determine the output pressure.

The change the deflection of this spring, the push rod(14) is inserted and can slide in the plug(11).

For the purpose of changing the displacement of the push rod through the switch plate(19) and adjusting nut(20) are provided the handle(27) that can be tilted in any direction around the fulcrum of the universal joint(18) center.

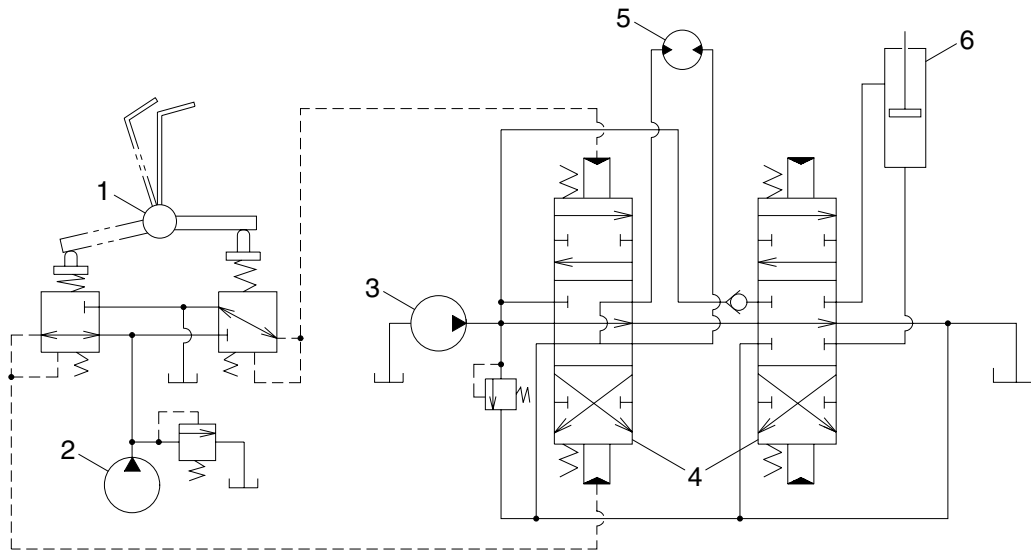
The spring(10) works on the case(1) and spring seat(8) and tries to return the push rod(14) to the zero-displacement position irrespective of the output pressure, securing its resetting to the center position.

This also has the effect of a reaction spring to give appropriate control feeling to the operator.

3) OPERATION

The operation of the pilot valve will be described on the basis of the hydraulic circuit diagram shown below and the attached operation explanation drawing.

The diagram shown below is the typical application example of the pilot valve.



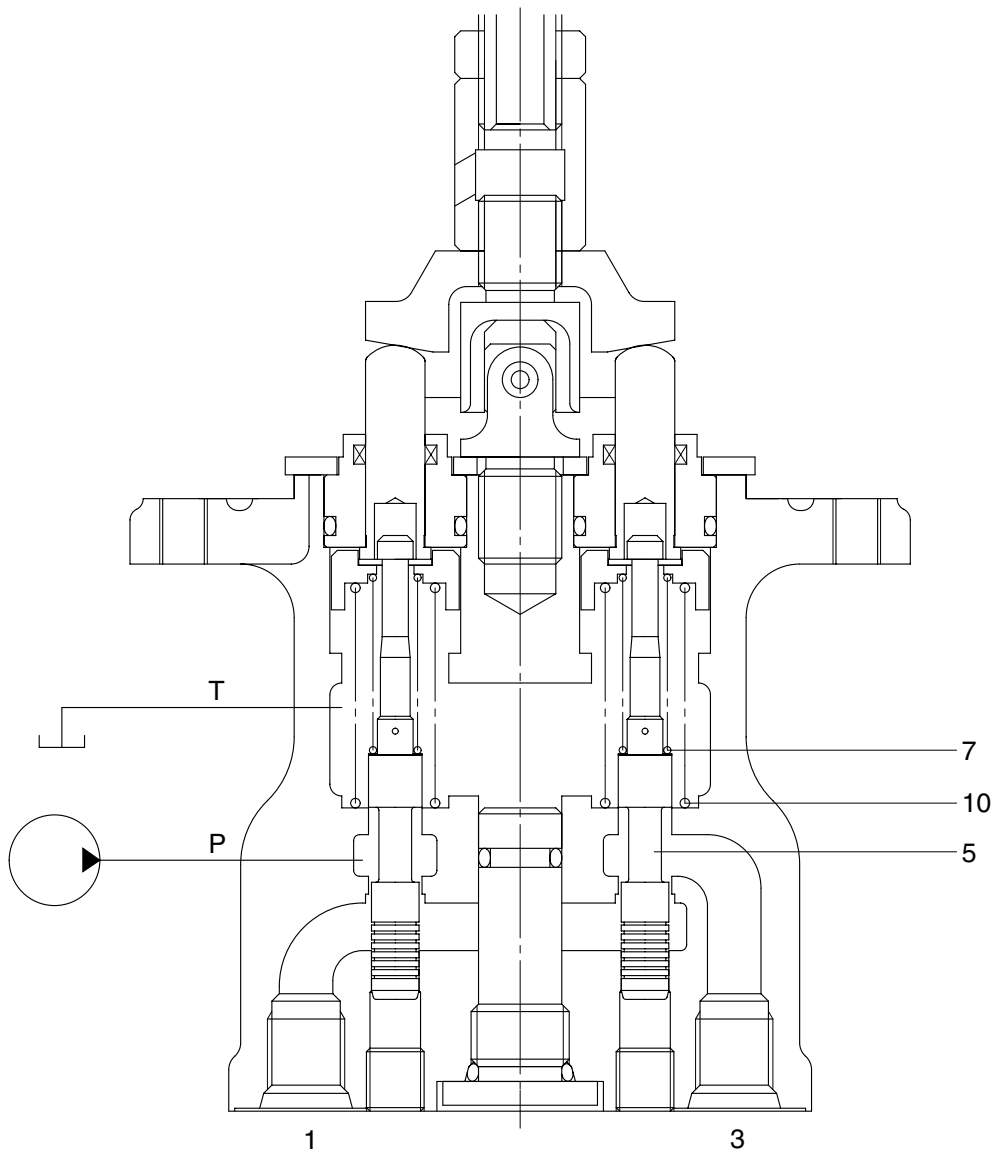
36072SF01

- 1 Pilot valve
- 2 Pilot pump

- 3 Main pump
- 4 Main control valve

- 5 Hydraulic motor
- 6 Hydraulic cylinder

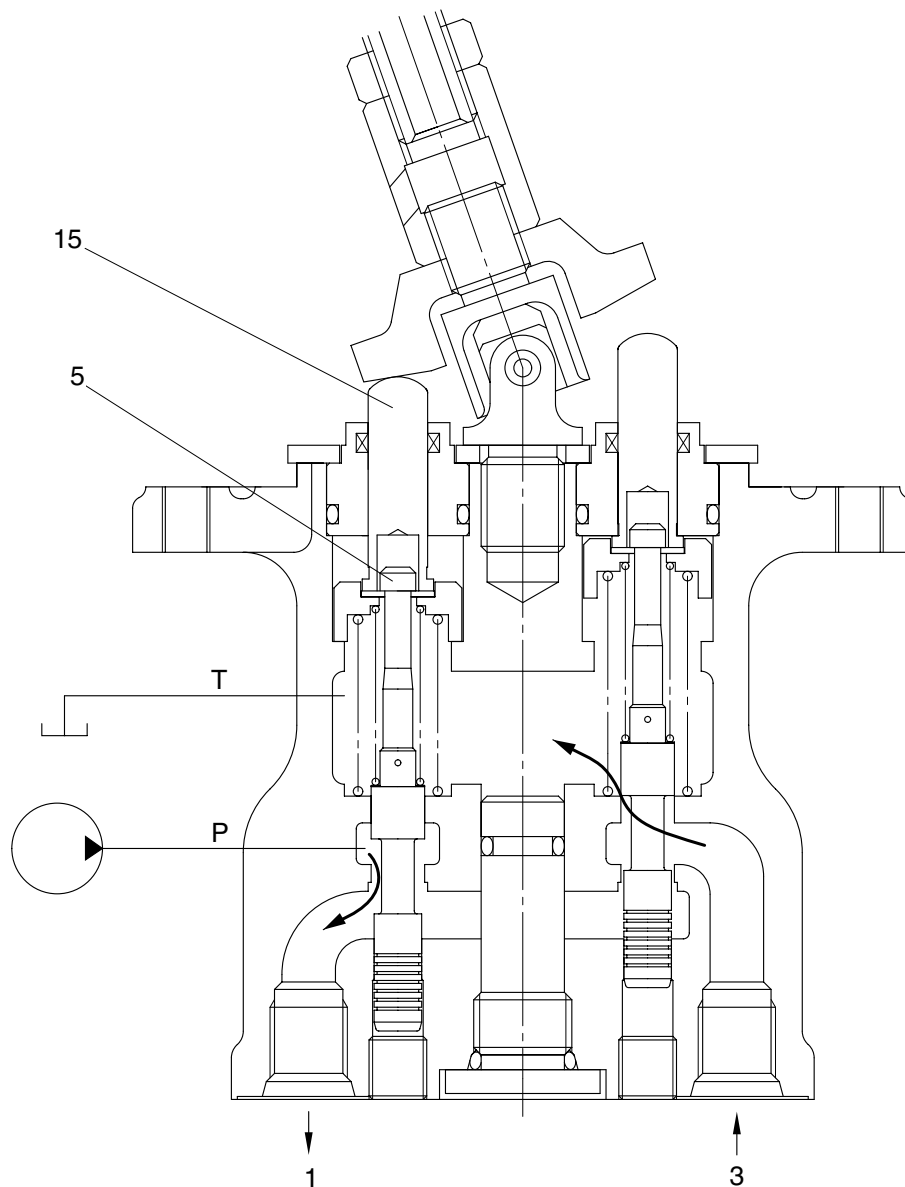
(1) Case where handle is in neutral position



25032RL03

The force of the spring(7) that determines the output pressure of the pilot valve is not applied to the spool(5). Therefore, the spool is pushed up by the spring(10) to the position of port(1, 3) in the operation explanation drawing. Then, since the output port is connected to tank port T only, the output port pressure becomes equal to tank pressure.

(2) Case where handle is tilted



25032RL04

When the push rod(14) is stroked, the spool(5) moves downwards.

Then port P is connected with port(1) and the oil supplied from the pilot pump flows through port(1) to generate the pressure.

When the pressure at port(1) increases to the value corresponding to the spring force set by tilting the handle, the hydraulic pressure force balances with the spring force. If the pressure at port(1) increases higher than the set pressure, port P is disconnected from port(1) and port T is connected with port(1). If it decreases lower than the set pressure, port P is connected with port(1) and port T is disconnected from port 1.

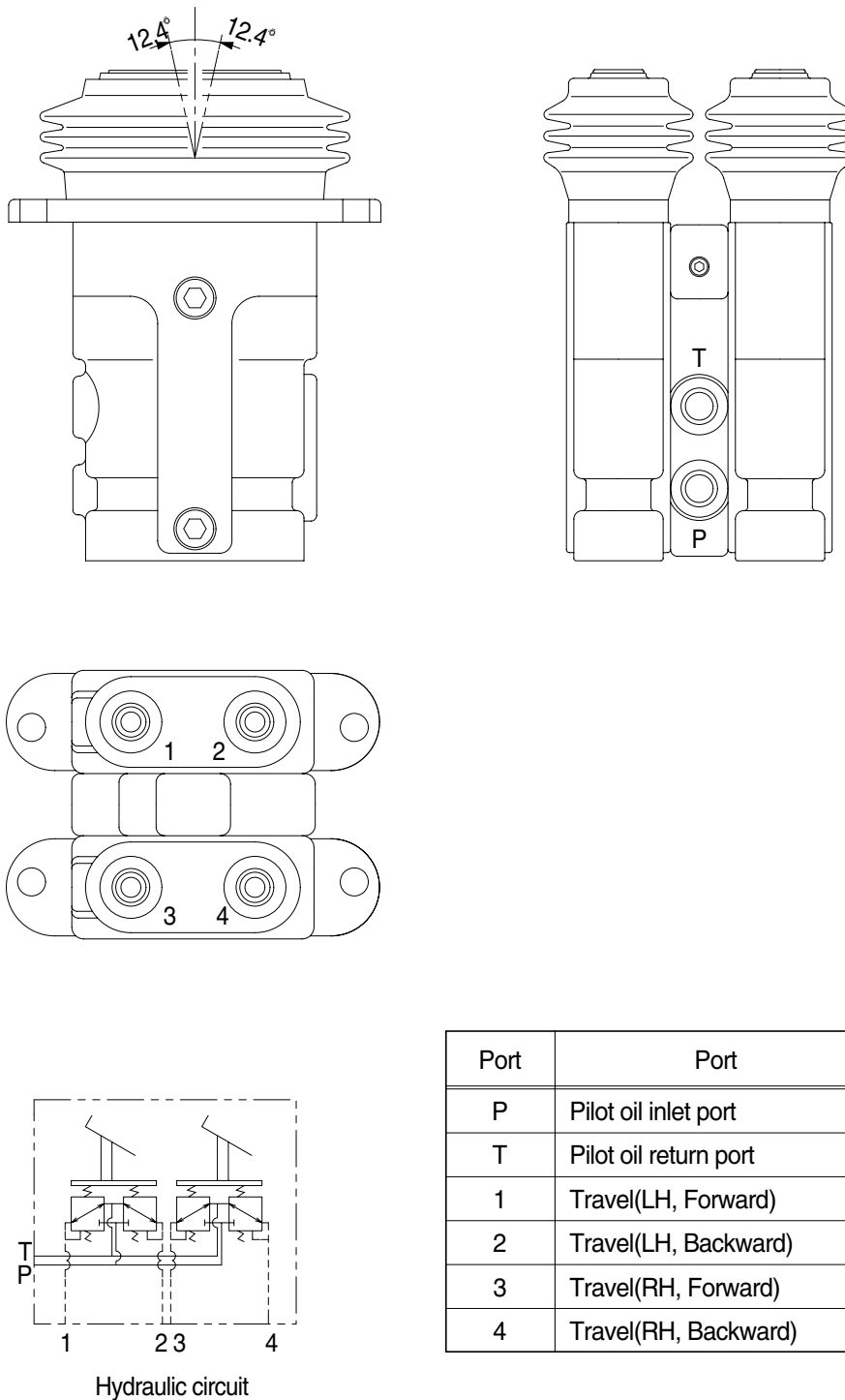
In this manner the secondary pressure is kept at the constant value.

Besides, in some type, when the handle is tilted more than a certain angle, the upper end of the spool contacts with the inside bottom of the push rod and the output pressure is left to be connected with port P.

GROUP 6 RCV PEDAL

1. STRUCTURE

The casing(Spacer) has the oil inlet port P(primary pressure), and the oil outlet port T(tank). In addition the secondary pressure is taken out through ports 1, 2, 3 and 4 provided at the bottom face.



| Port | Port | Port size |
|------|-----------------------|-----------|
| P | Pilot oil inlet port | PF 1/4 |
| T | Pilot oil return port | |
| 1 | Travel(LH, Forward) | |
| 2 | Travel(LH, Backward) | |
| 3 | Travel(RH, Forward) | |
| 4 | Travel(RH, Backward) | |

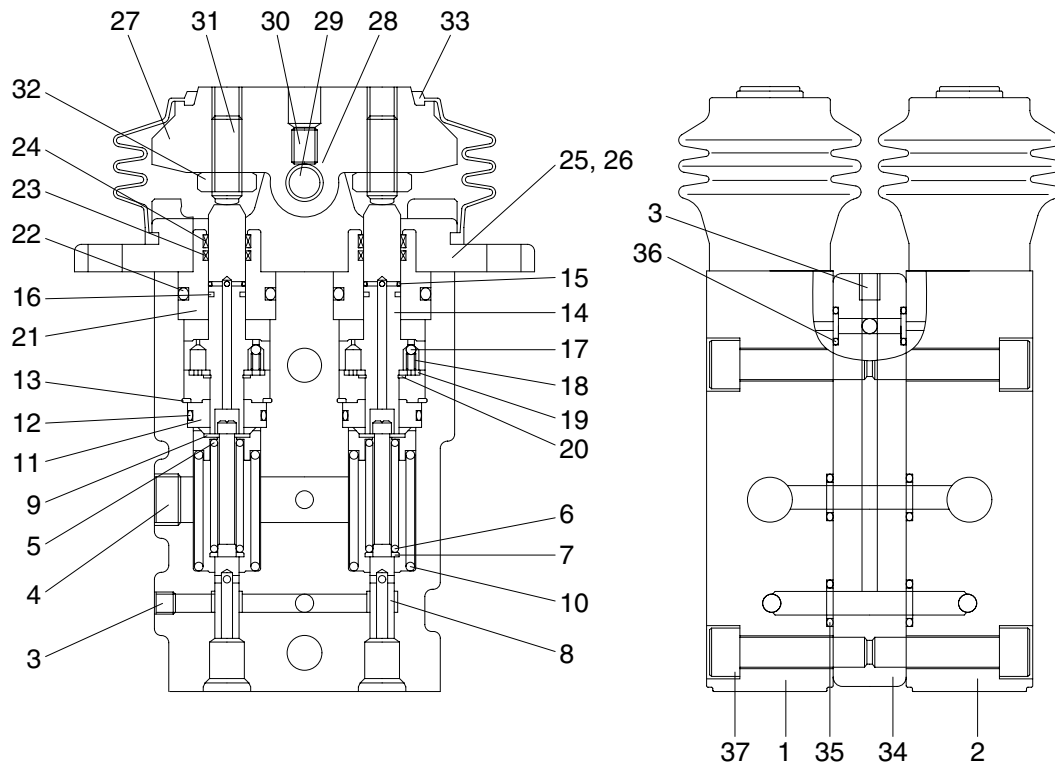
14072SF73

CROSS SECTION

The construction of the RCV pedal is shown in the below drawing. The casing has vertical holes in which reducing valves are assembled.

The pressure reducing section is composed of the spool(8), spring(6) for setting secondary pressure, return spring(10), stopper(9), and spring seat(7). The spring for setting the secondary pressure has been generally so preset that the secondary pressure is 5 to 19kgf/cm² (depending on the type). The spool is pushed against the push rod(14) by the return spring.

When the push rod is pushed down by tilting pedal, the spring seat comes down simultaneously and changes setting of the secondary pressure spring.



14072SF70

| | | | | | |
|----|-------------|----|------------|----|-------------|
| 1 | Body(1) | 13 | Snap ring | 25 | Cover |
| 2 | Body(2) | 14 | Push rod | 26 | Socket bolt |
| 3 | Plug | 15 | Spring pin | 27 | Cam |
| 4 | Plug | 16 | Seal | 28 | Bushing |
| 5 | Spring seat | 17 | Steel ball | 29 | Cam shaft |
| 6 | Spring | 18 | Spring | 30 | Set screw |
| 7 | Spring seat | 19 | Plate | 31 | Set screw |
| 8 | Spool | 20 | Snap ring | 32 | Nut |
| 9 | Stopper | 21 | Plug | 33 | Bellows |
| 10 | Spring | 22 | O-ring | 34 | Space |
| 11 | Rod guide | 23 | Rod seal | 35 | O-ring |
| 12 | O-ring | 24 | Dust seal | 36 | O-ring |
| | | | | 37 | Socket bolt |

2. FUNCTION

1) FUNDAMENTAL FUNCTIONS

The pilot valve is a valve controls the spool stroke, direction, etc of a main control valve. This function is carried out by providing the spring at one end of the main control valve spool and applying the output pressure(Secondary pressure) of the pilot valve to the other end.

For this function to be carried out satisfactorily, the pilot valve is composed of the following elements.

- (1) Inlet port(P) where oil is supplied from hydraulic pump.
- (2) Output port(1, 2, 3 & 4) to apply pressure supplied from inlet port to ends of control valve spools.
- (3) Tank port(T) necessary to control the above output pressure.
- (4) Spool to connect output port to inlet port tank port.
- (5) Mechanical means to control output pressure, including springs that work on the above spools.

2) FUNCTIONS OF MAJOR SECTIONS

The functions of the spool(8) are to receive the supply oil pressure from the hydraulic pump at its port P, and to change over oil paths to determine whether the pressure oil of port P is led to output ports 1, 2, 3 & 4 or the output spool to determine the output pressure.

The spring(6) works on this spool to determine the output pressure.

The change the deflection of this spring, the push rod(14) is inserted and can slide in the plug(21).

For the purpose of changing th displacement of the push rod through the cam(27) and adjusting nut(32) are provided the pedal that can be tilted in any direction around the fulcrum of the cam(27) center.

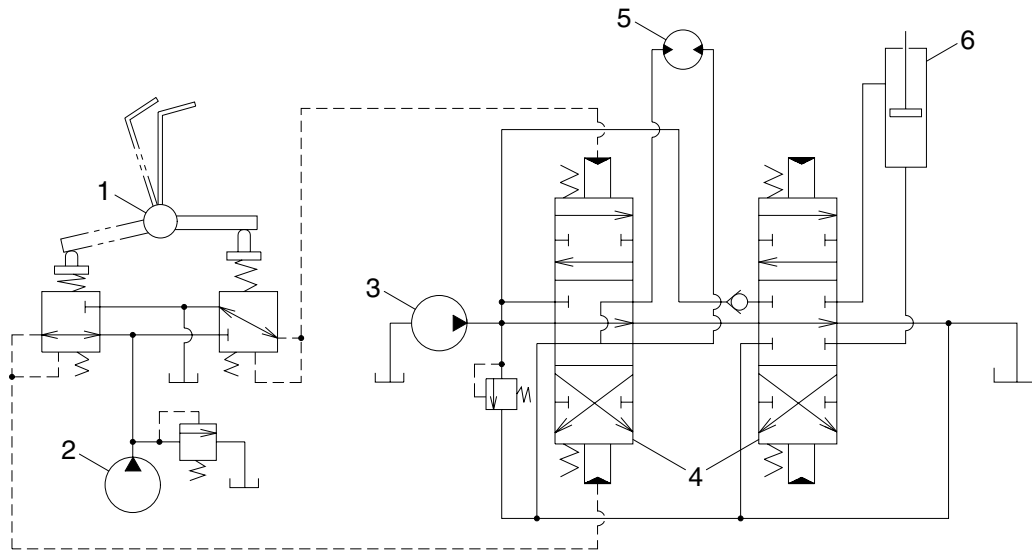
The spring(10) works on the casing(1) and spring seat(7) and tries to return the push rod(14) to the zero-displacement position irrespective of the output pressure, securing its resetting to the center position.

This also has the effect of a reaction spring to give appropriate control feeling to the operator.

3) OPERATION

The operation of the pilot valve will be described on the basis of the hydraulic circuit diagram shown below and the attached operation explanation drawing.

The diagram shown below is the typical application example of the pilot valve.



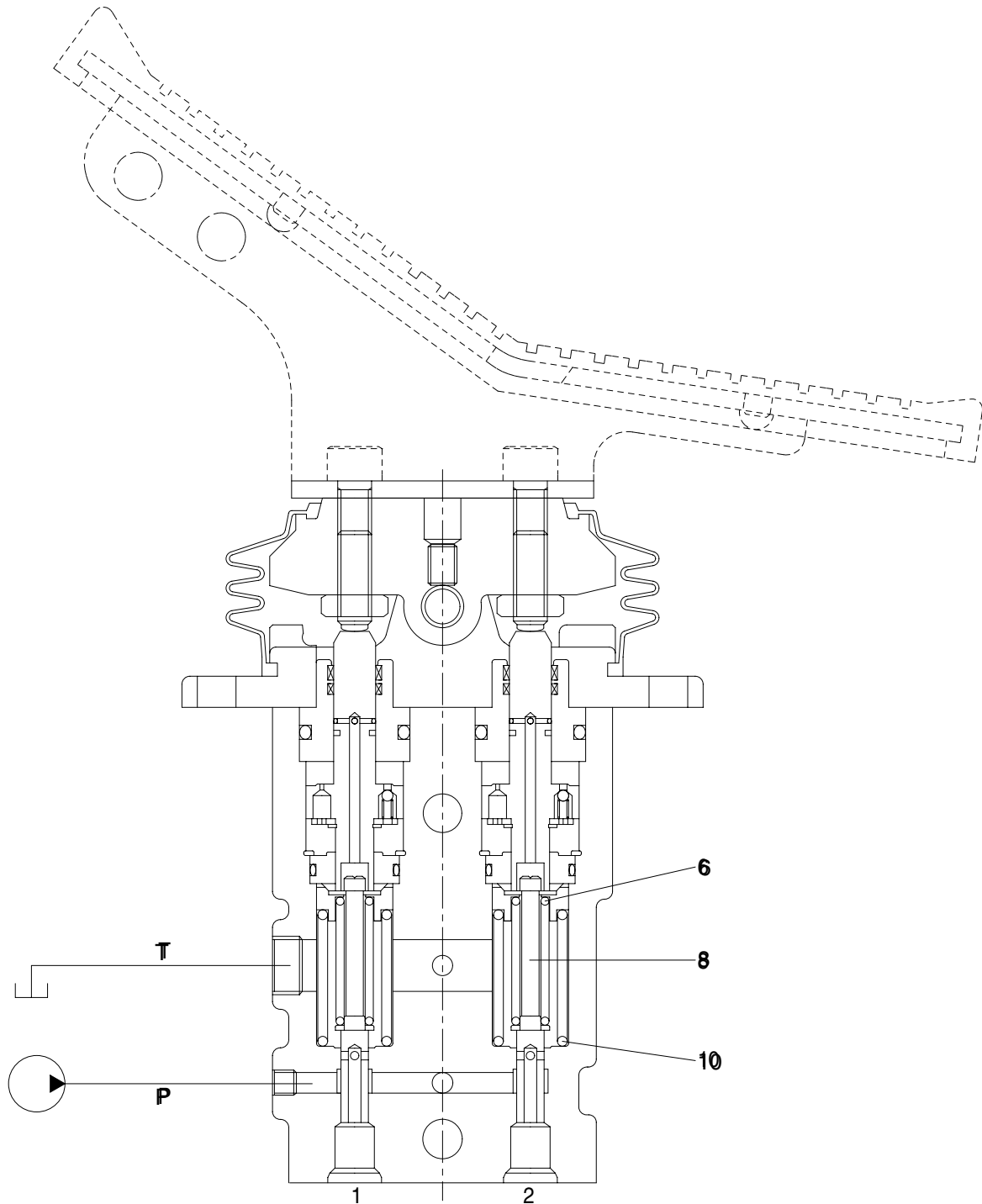
36072SF01

- 1 Pilot valve
- 2 Pilot pump

- 3 Main pump
- 4 Main control valve

- 5 Hydraulic motor
- 6 Hydraulic cylinder

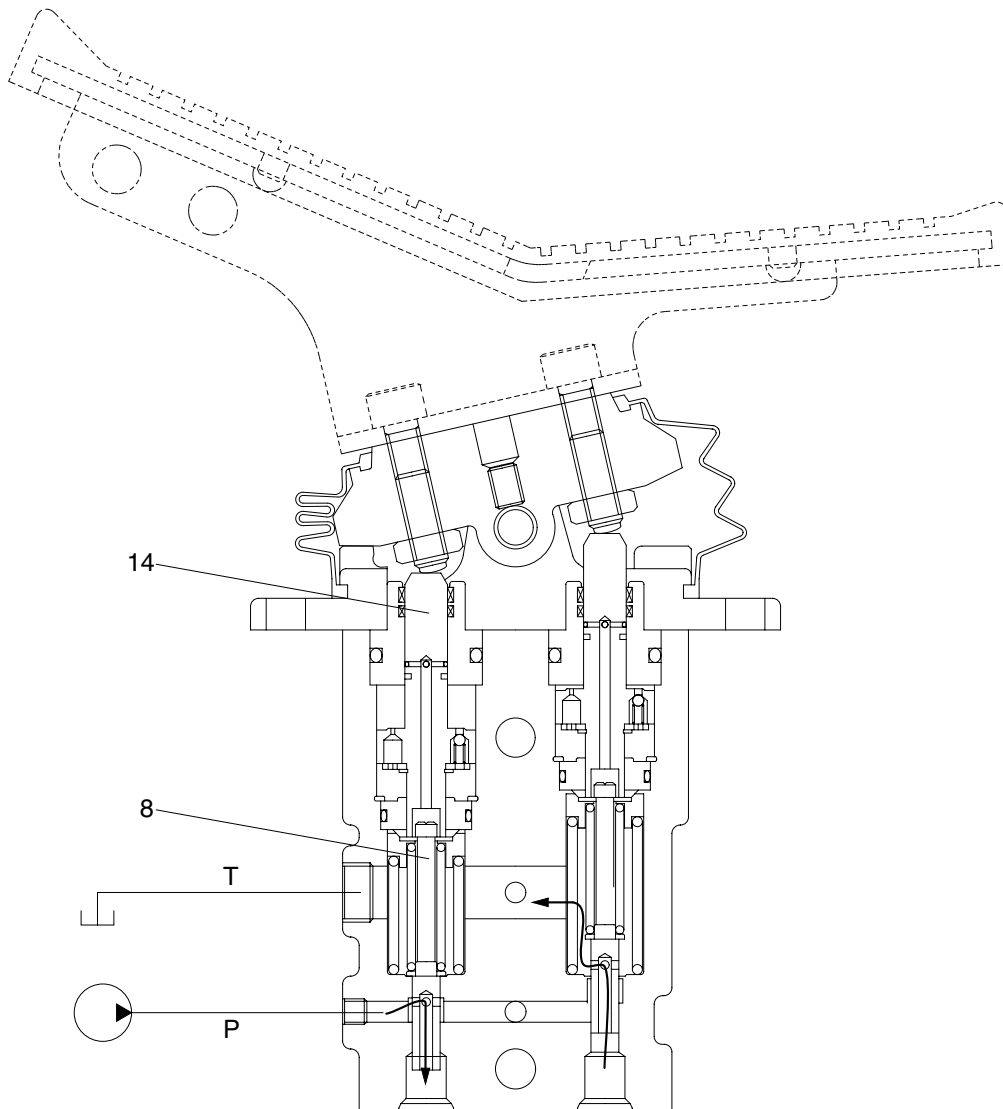
(1) Case where pedal is in neutral position



14072SF74

The force of the spring(6) that determines the output pressure of the pilot valve is not applied to the spool(8). Therefore, the spool is pushed up by the spring(10) to the position of port 2 in the operation explanation drawing. Then, since the output port is connected to tank port T only, the output port pressure becomes equal to tank pressure.

(2) Case where pedal is tilted



14072SF75

When the push rod(14) is stroked, the spool(8) moves downwards.

Then port P is connected with port 1, and the oil supplied from the pilot pump flows through port 1 to generate the pressure.

When the pressure at port 1 increases to the value corresponding to the spring force set by tilting the handle, the hydraulic pressure force balances with the spring force. If the pressure at port 1 increases higher than the set pressure, port P is disconnected from port 1 and port T is connected with port 1. If it decreases lower than the set pressure, port P is connected with port 1 and port T is disconnected from port 1.

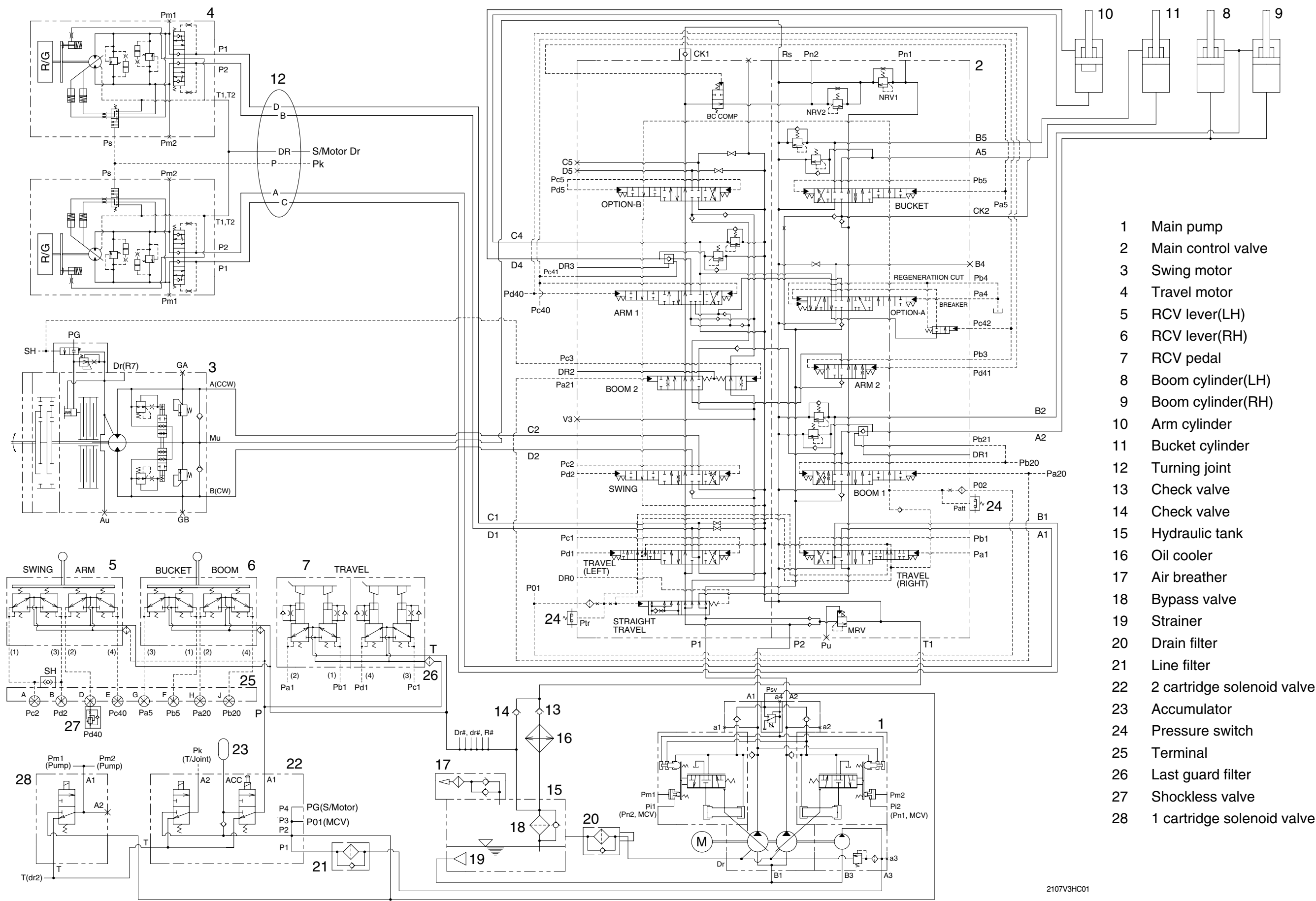
In this manner the secondary pressure is kept at the constant value.

Besides, in some type, when the handle is tilted more than a certain angle, the upper end of the spool contacts with inside bottom of the push rod and the output pressure is left to be connected with port P.

SECTION 3 HYDRAULIC SYSTEM

| | | |
|---------|--------------------------|------|
| Group 1 | Hydraulic Circuit | 3-1 |
| Group 2 | Main Circuit | 3-2 |
| Group 3 | Pilot Circuit | 3-5 |
| Group 4 | Single Operation | 3-12 |
| Group 5 | Combined Operation | 3-22 |

GROUP 1 HYDRAULIC CIRCUIT



2107V3HC01

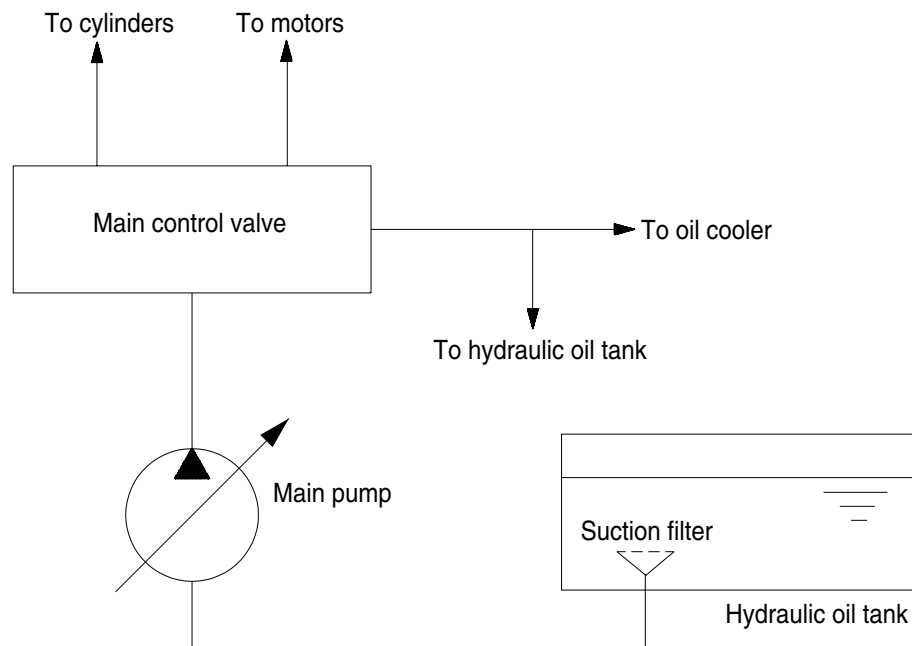
GROUP 2 MAIN CIRCUIT

The main hydraulic circuit consists of suction circuit, delivery circuit, return circuit and drain circuit.

The hydraulic system consists of one main pump, one control valve, one swing motor, four cylinders and two travel motors.

The swash plate type variable displacement axial piston pump is used as the main pump and is driven by the engine at ratio 1.0 of engine speed.

1. SUCTION AND DELIVERY CIRCUIT



(210-7) 3-03

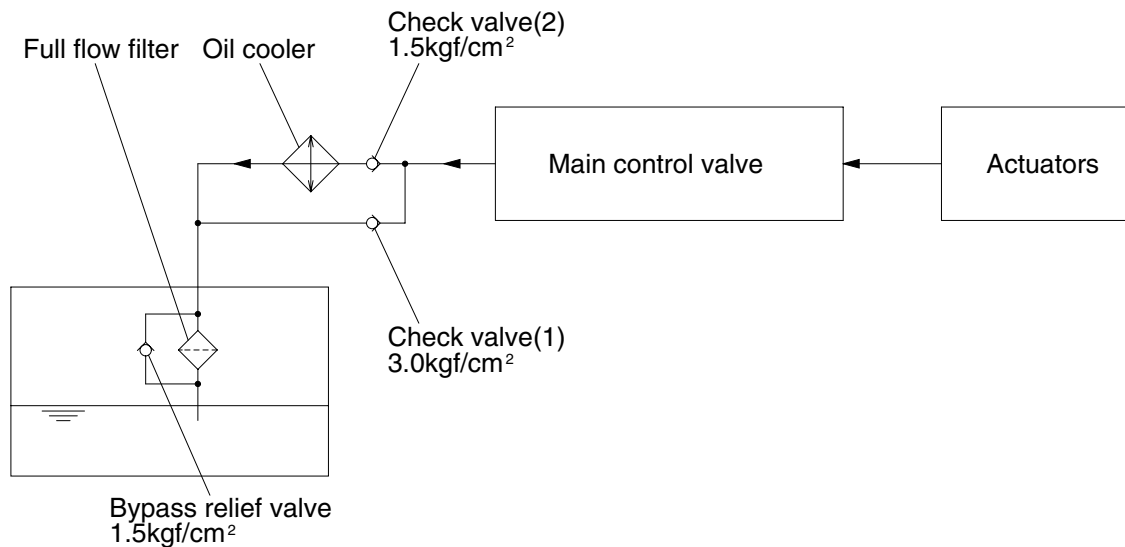
The pumps receive oil from the hydraulic tank through a suction filter. The discharged oil from the pump flows into the control valve and goes out the tank ports.

The oil discharged from the main pump flows to the actuators through the control valve.

The control valve controls the hydraulic functions.

The return oil from the actuators flows to the hydraulic tank through the control valve and the oil cooler.

2. RETURN CIRCUIT



21073CI01

All oil returned from each actuator returns to the hydraulic tank through the control valve.

The bypass check valves are provided in the return circuit.

The setting pressure of bypass check valves are 1.5kgf/cm²(21psi) and 3.0kgf/cm²(43psi). Usually, oil returns to the hydraulic tank from the left side of control valve through oil cooler.

When oil temperature is low, viscosity becomes higher and flow resistance increases when passing through the oil cooler. When the oil pressure exceeds 3.0kgf/cm²(43psi), the oil returns directly to the hydraulic tank, resulting in the oil temperature being raised quickly at an appropriate level.

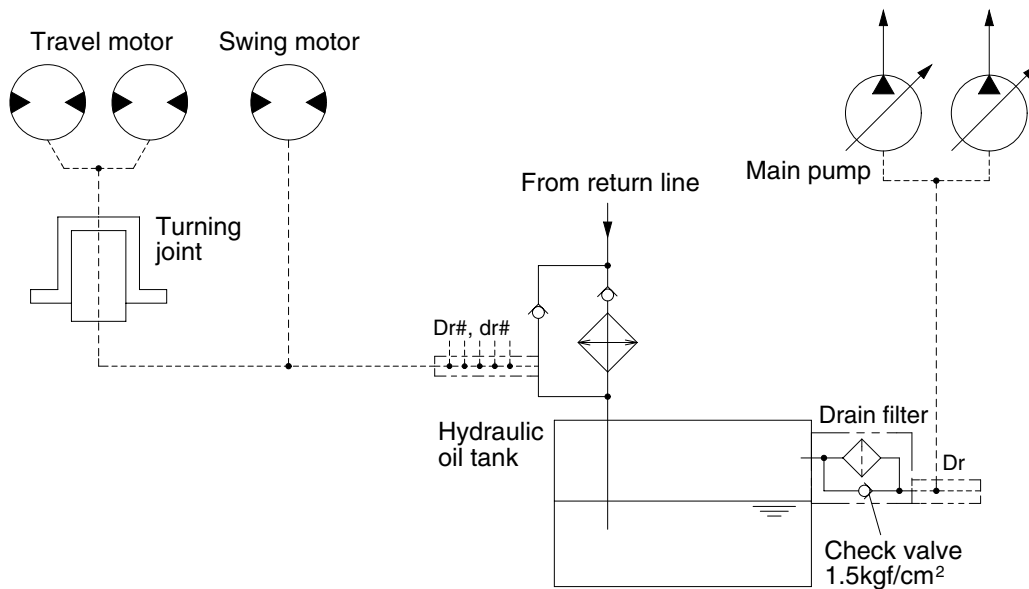
When the oil cooler is clogged, the oil returns directly to the hydraulic tank through bypass check valve(1).

The full-flow filter and bypass relief valve are provided in the hydraulic tank.

The oil returned from right and left side of control valve is combined and filtered by the full-flow filter. A bypass relief valve is provided in the full-flow filter.

When the filter element is clogged, the bypass relief valve opens at 1.5kgf/cm²(21psi) differential pressure.

3. DRAIN CIRCUIT



21073CI02

Besides internal leaks from the motors and main pump, the oil for lubrication circulates. These oil have to be fed to the hydraulic tank passing through drain filter.

When the drain oil pressure exceed 1.5kgf/cm^2 (21psi), the oil returns to the hydraulic tank directly.

1) TRAVEL MOTOR DRAIN CIRCUIT

Oil leaked from the right and left travel motors comes out of the drain ports provided in the respective motor casing and join with each other. These oils pass through the turning joint and return to the hydraulic tank.

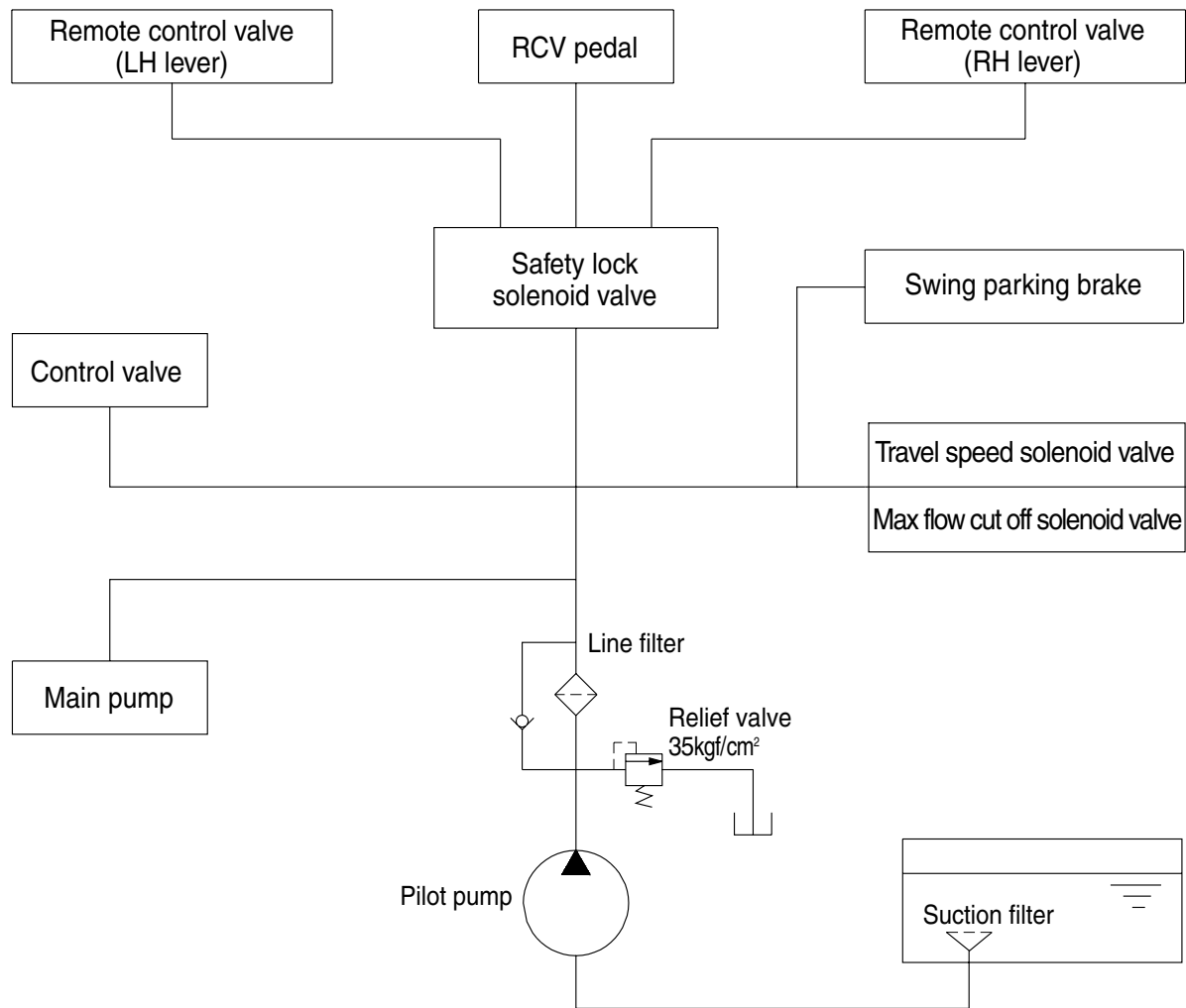
2) SWING MOTOR DRAIN CIRCUIT

Oil leaked from the swing motor returns to the hydraulic tank with oil drained from the travel circuit .

3) MAIN PUMP DRAIN CIRCUIT

Oil leaked from main pump returns to the hydraulic tank passing through drain filter.

GROUP 3 PILOT CIRCUIT



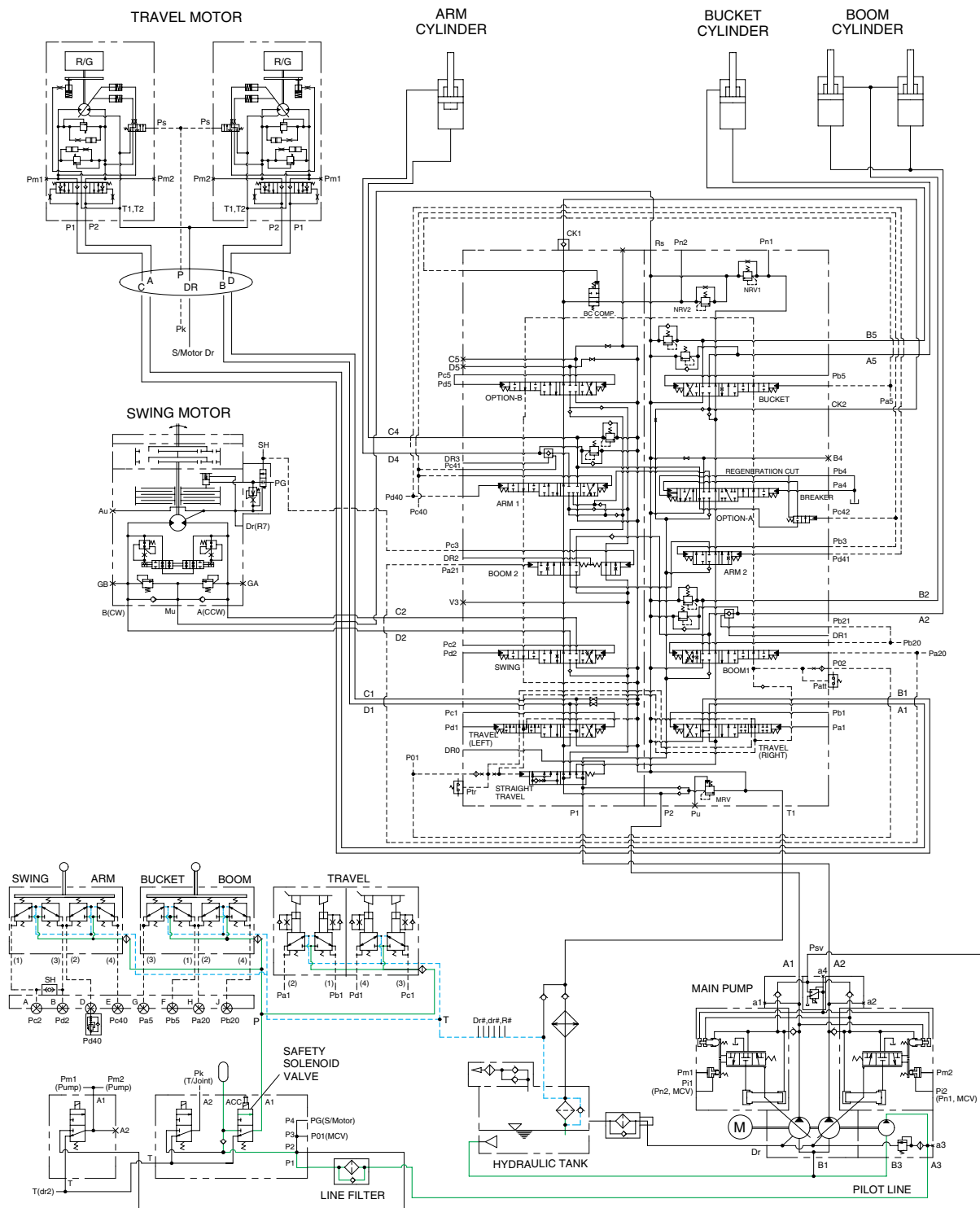
D21073CI05

The pilot circuit consists of suction circuit, delivery circuit and return circuit.

The pilot pump is provided with relief valve, receives the oil from the hydraulic tank through the suction filter.

The discharged oil from the pilot pump flows to the remote control valve through line filter, EPPR valve, solenoid valve assemblies, swing parking brake, main control valve and safety lock solenoid valve.

1. SUCTION, DELIVERY AND RETURN CIRCUIT



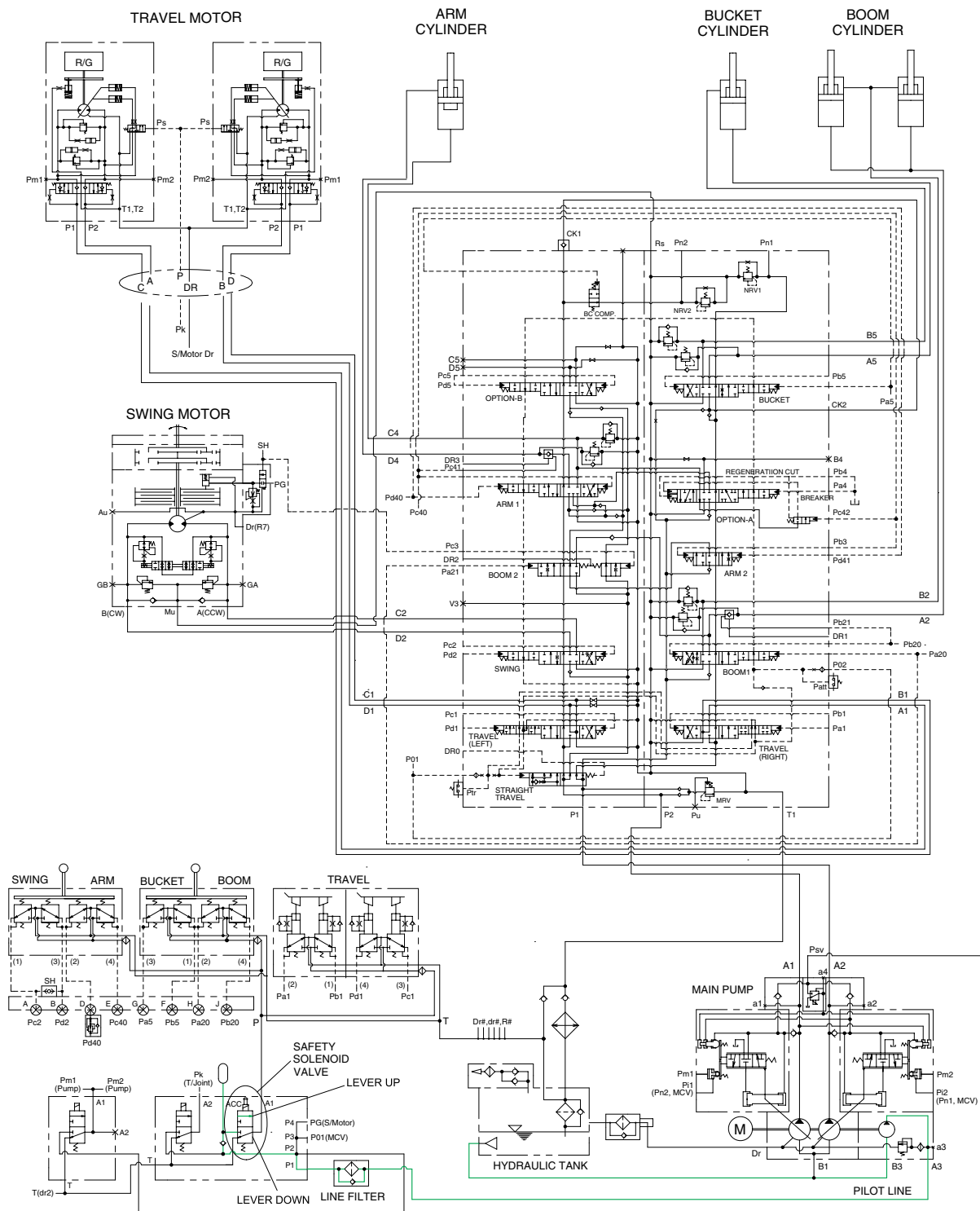
2107V3HC02

The pilot pump receive oil from the hydraulic tank. The discharged oil from the pilot pump flows to the safety solenoid valve through the line filter. The oil is filtered by the line filter. The pilot relief valve is provided in the pilot pump for limiting the pilot circuit pressure.

The oil filtered by line filter flows remote control valve through safety solenoid valve.

The return oil flow into the hydraulic tank.

2. SAFETY VALVE(SAFETY LEVER)

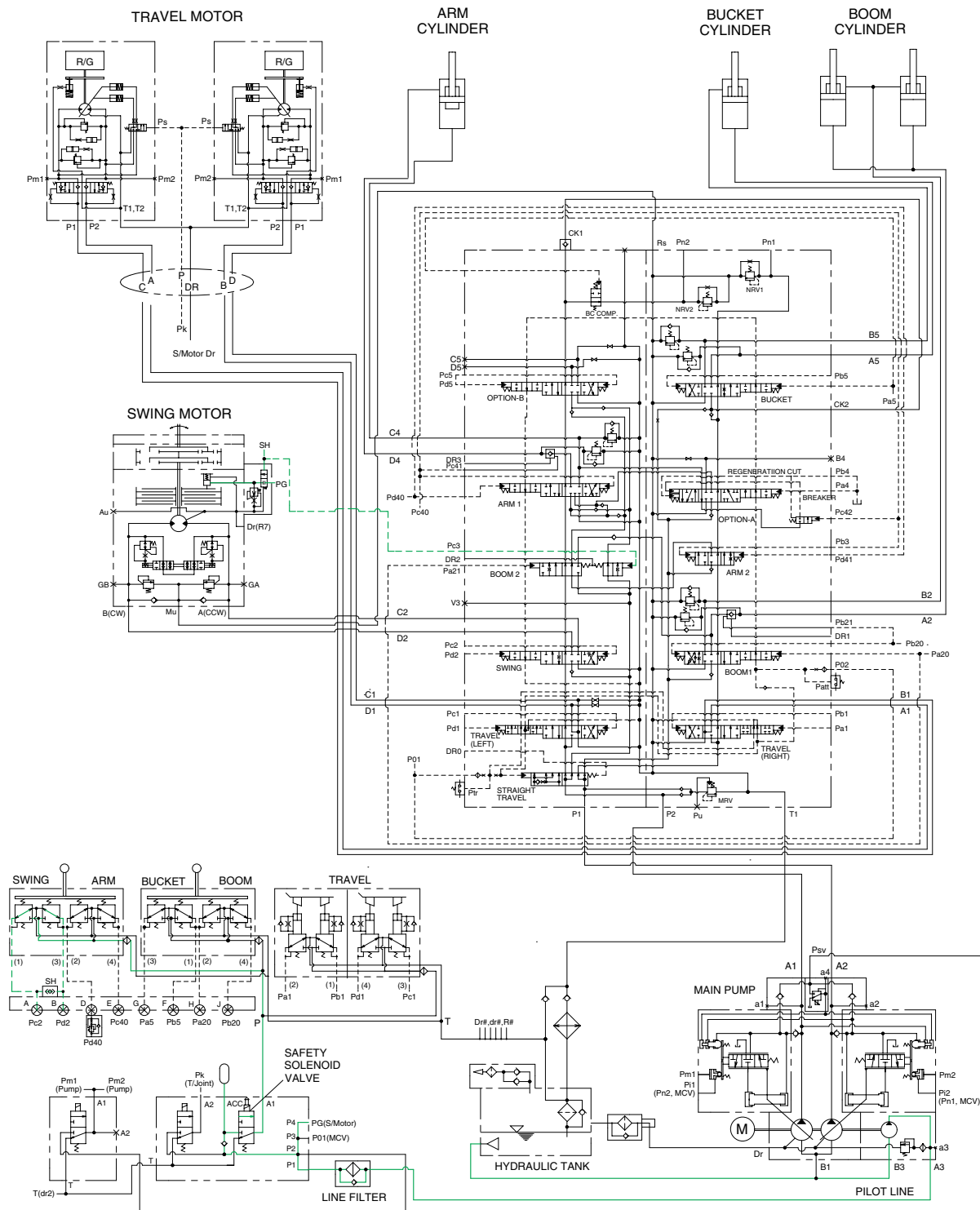


2107V3HC03

When the lever of the safety solenoid valve is moved upward, oil flows into the remote control valve through solenoid valve and line filter.

When the lever of the safety solenoid valve is moved downward, oil does not flows into the remote control valve, because of the blocked port.

3. SWING PRIORITY SYSTEM



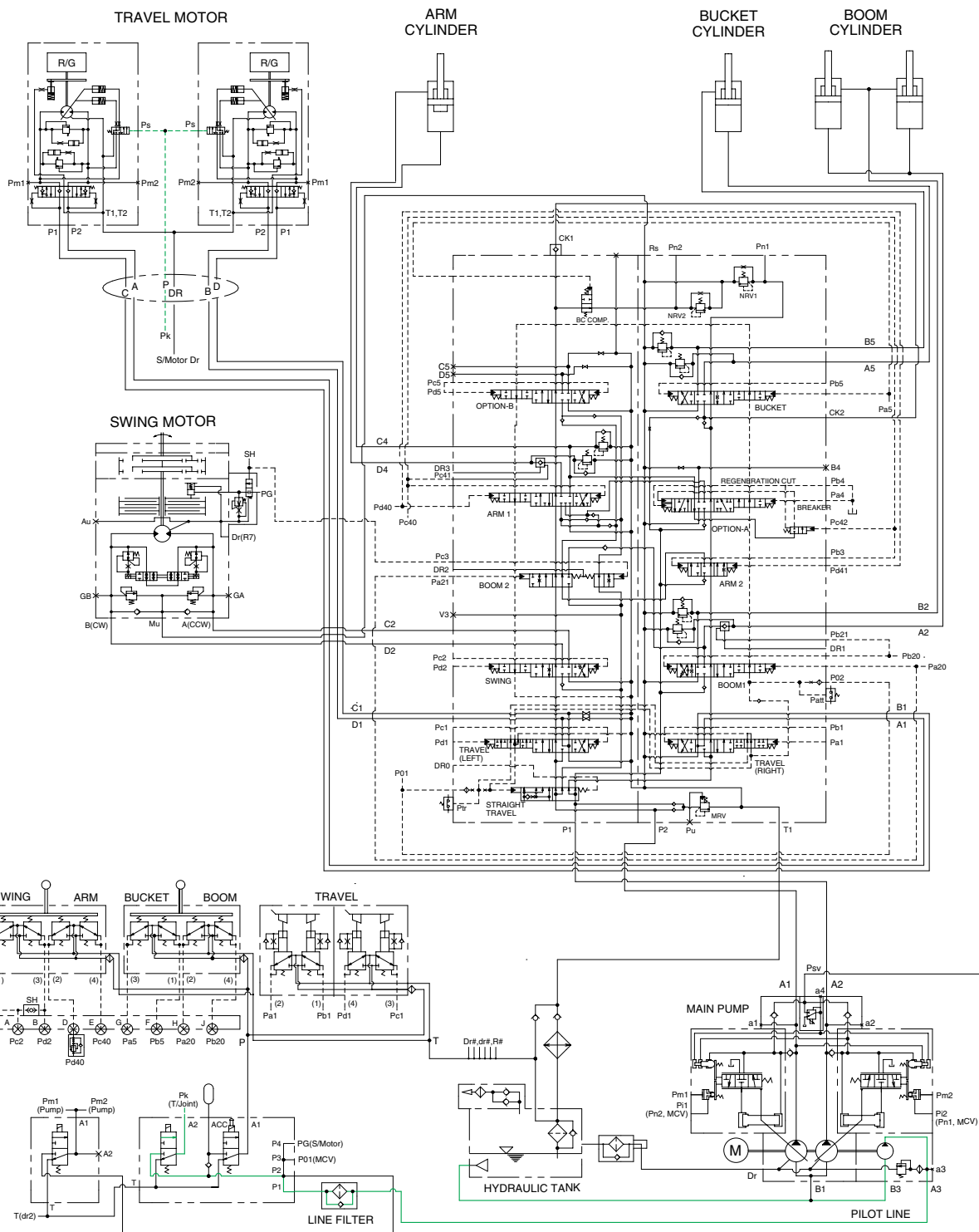
2107V3HC04

When carrying out the combined operation of swing and arm of the left control valve, the swing speed can be lower than operating speed of arm.

Pc3 pressure from the swing shuttle block change the swing priority spool and decreases the oil flow rate to the next section to make the swing operation most preferential.

This is called the swing priority system. For details, refer to page 2-45.

4. TRAVEL SPEED CONTROL SYSTEM



2107V3HC05

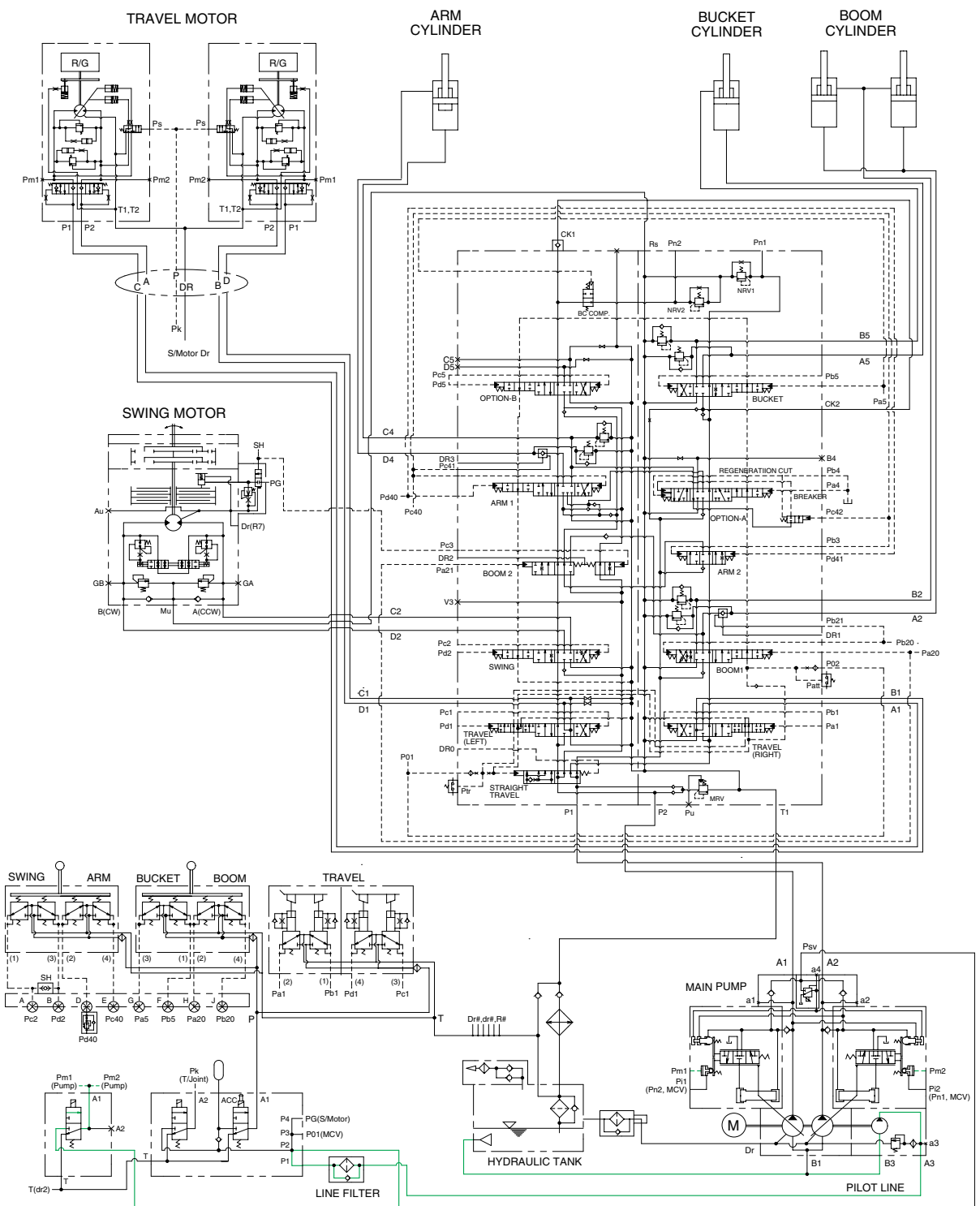
When the travel speed switch is pushed, the travel speed solenoid valve is actuated and the discharged oil from the pilot pump flows to the **Pk** port of pilot valve in the travel motors.

As a result, the control piston is pushed by the main oil flow, thus the displacement is minimized.

When the travel speed switch is pushed once more, the travel speed solenoid valve is return to original position by the force of spring, the hydraulic oil of **Pk** port returns to the hydraulic tank.

As a result, the control piston is returned by the main oil flow, thus the displacement is maximized.

5. MAX FLOW CUT OFF SYSTEM

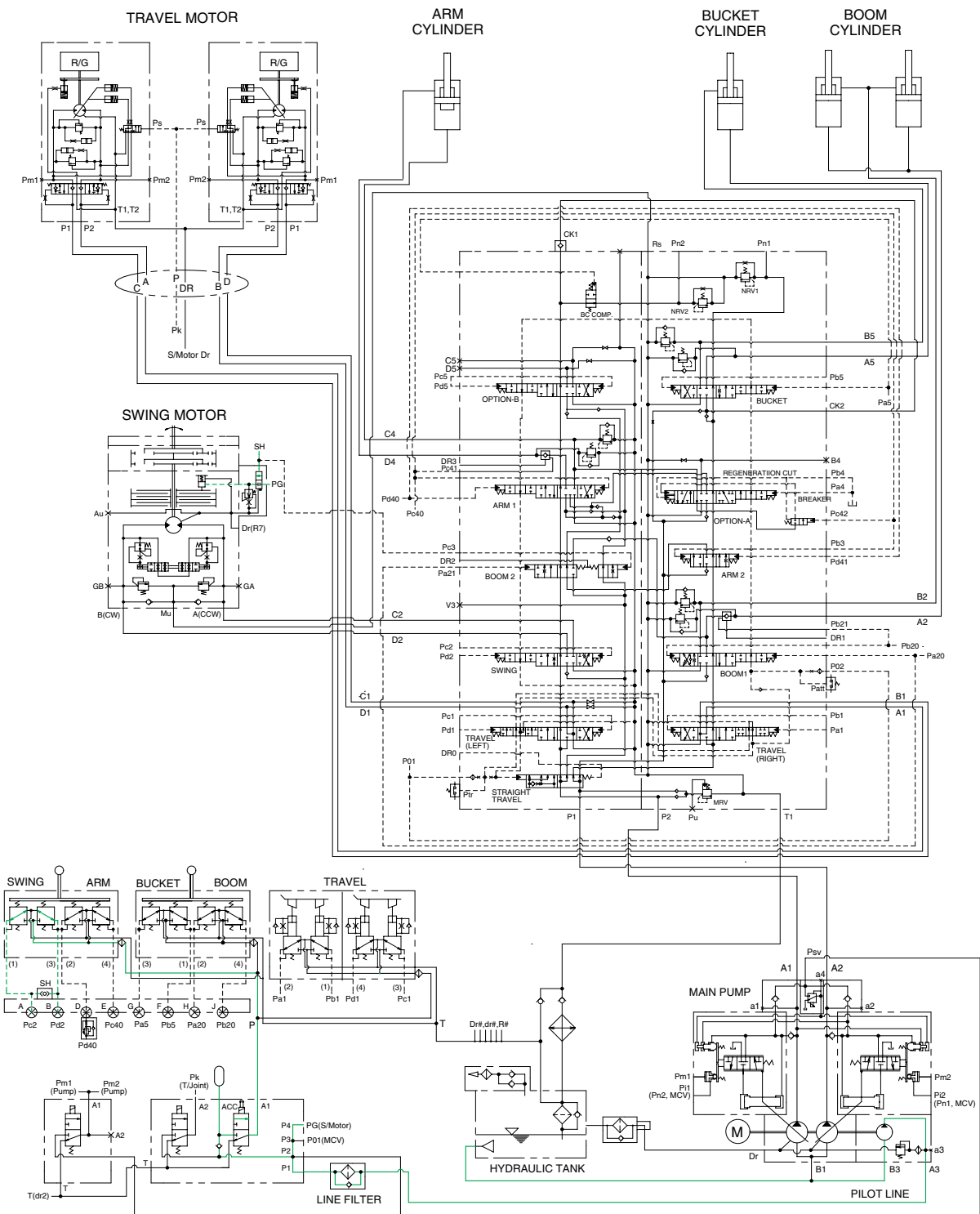


2107V3HC07

When the breaker operation mode is selected on the cluster, max flow cut off solenoid valve actuates automatically.

Thus pilot pressure(Pm1, Pm2) is sent to the regulator and pump discharge volume is decreased.

6. SWING PARKING BRAKE RELEASE



2107V3HC08

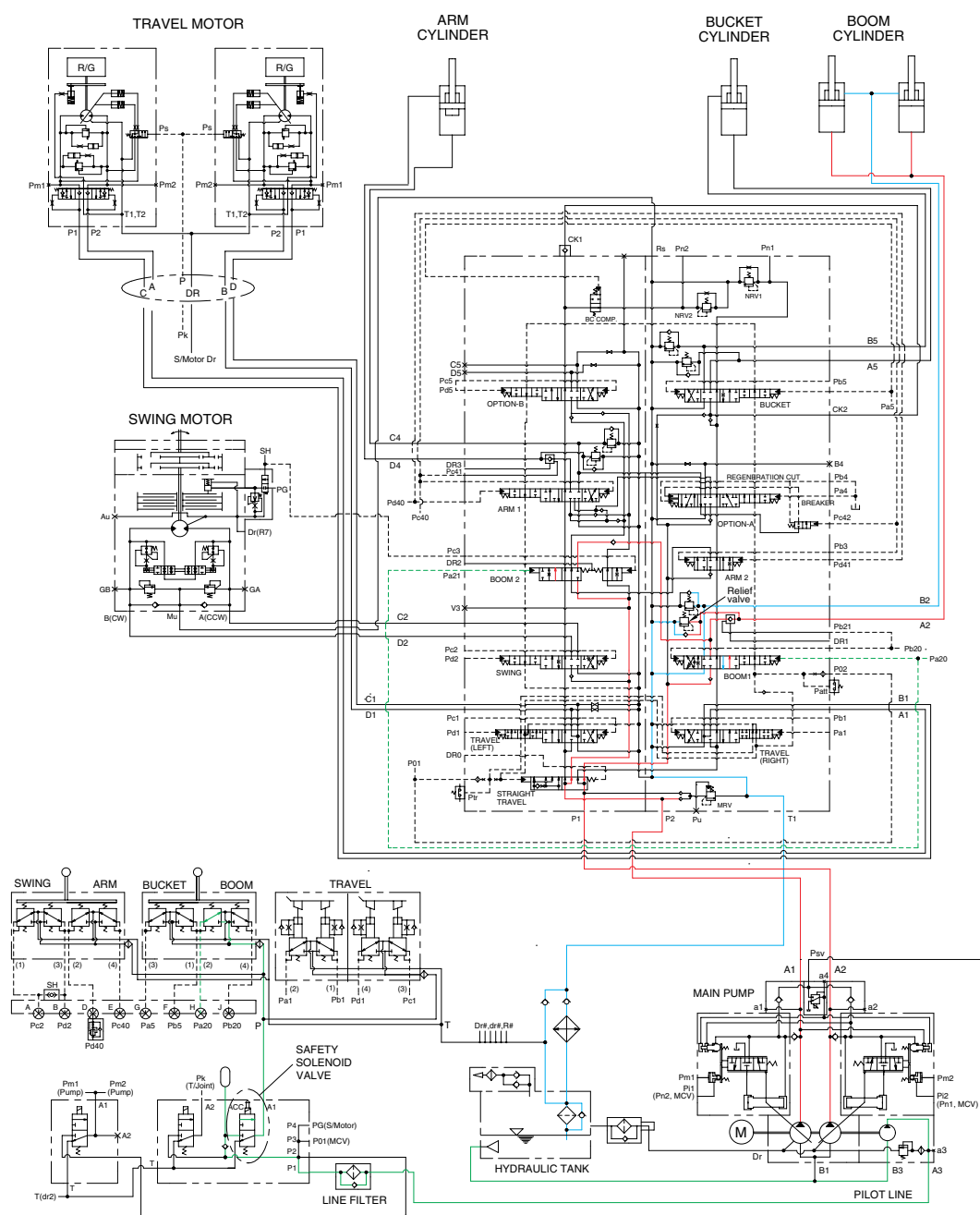
When the swing control lever is tilted, the pilot oil flow into SH port of shuttle valve, this pressure move spool so, discharged oil from pilot valve flow into PG port.

This pressure is applied to swing motor disc, thus the brake is released.

When the swing control lever is set in the neutral position, oil in the swing motor disc cylinder is drained, thus the brake is applied.

GROUP 4 SINGLE OPERATION

1. BOOM UP OPERATION



2107V3HC09

When the right control lever is pulled back, the boom spools in the main control valve are moved to the up position by the pilot oil pressure from the remote control valve.

The oil from the front and rear pump flows into the main control valve and then goes to the large chamber of boom cylinders.

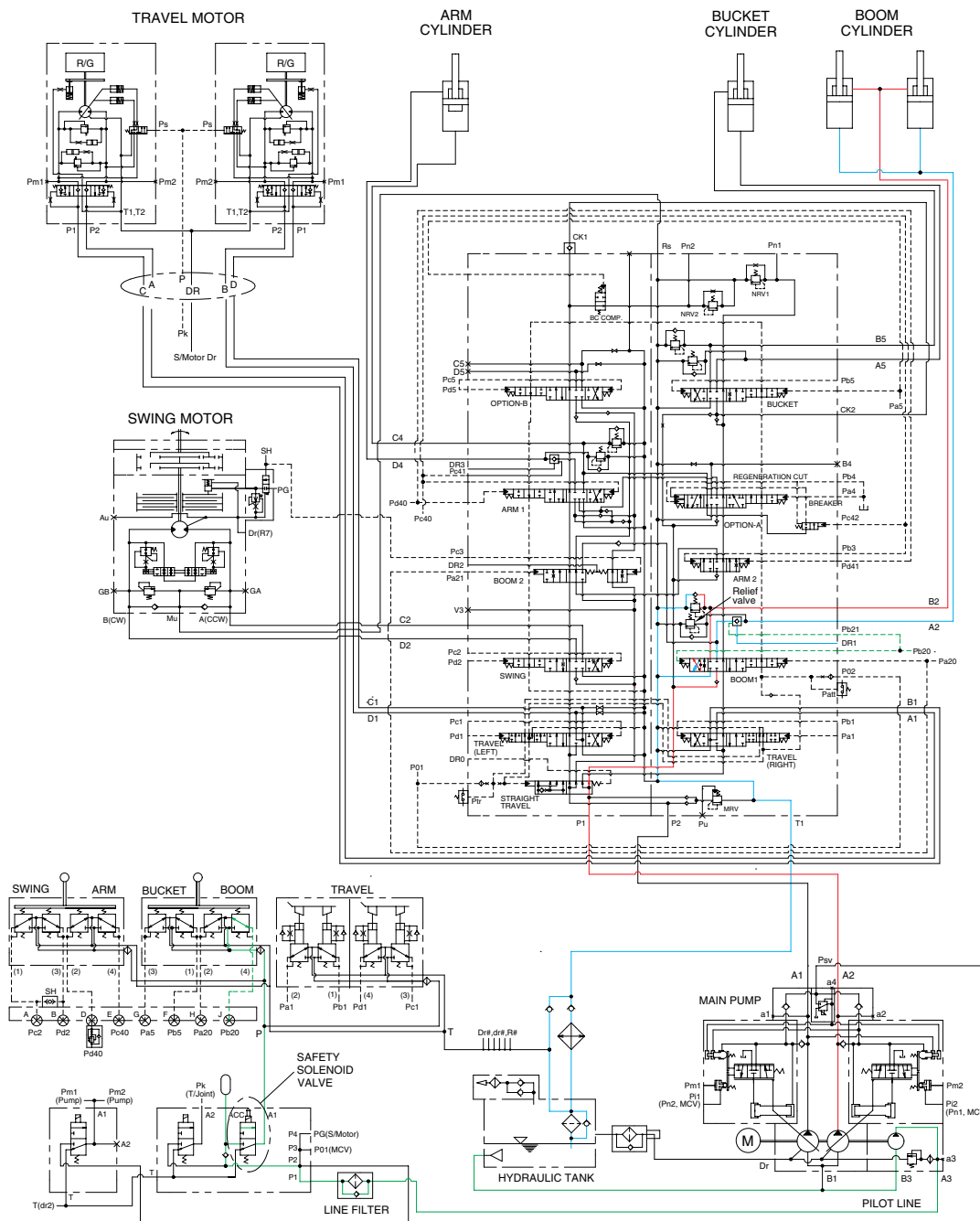
At the same time, the oil from the small chamber of boom cylinders returns to the hydraulic oil tank through the boom spool in the main control valve. When this happens, the boom goes up.

The excessive pressure in the boom cylinder head side circuit is prevented by relief valve.

When the boom is up and the control lever is returned to neutral position, the circuit for the holding pressure at the bottom end of the boom cylinder is closed by the boom holding valve.

This prevents the hydraulic drift of boom cylinder.

2. BOOM DOWN OPERATION



2107V3HC10

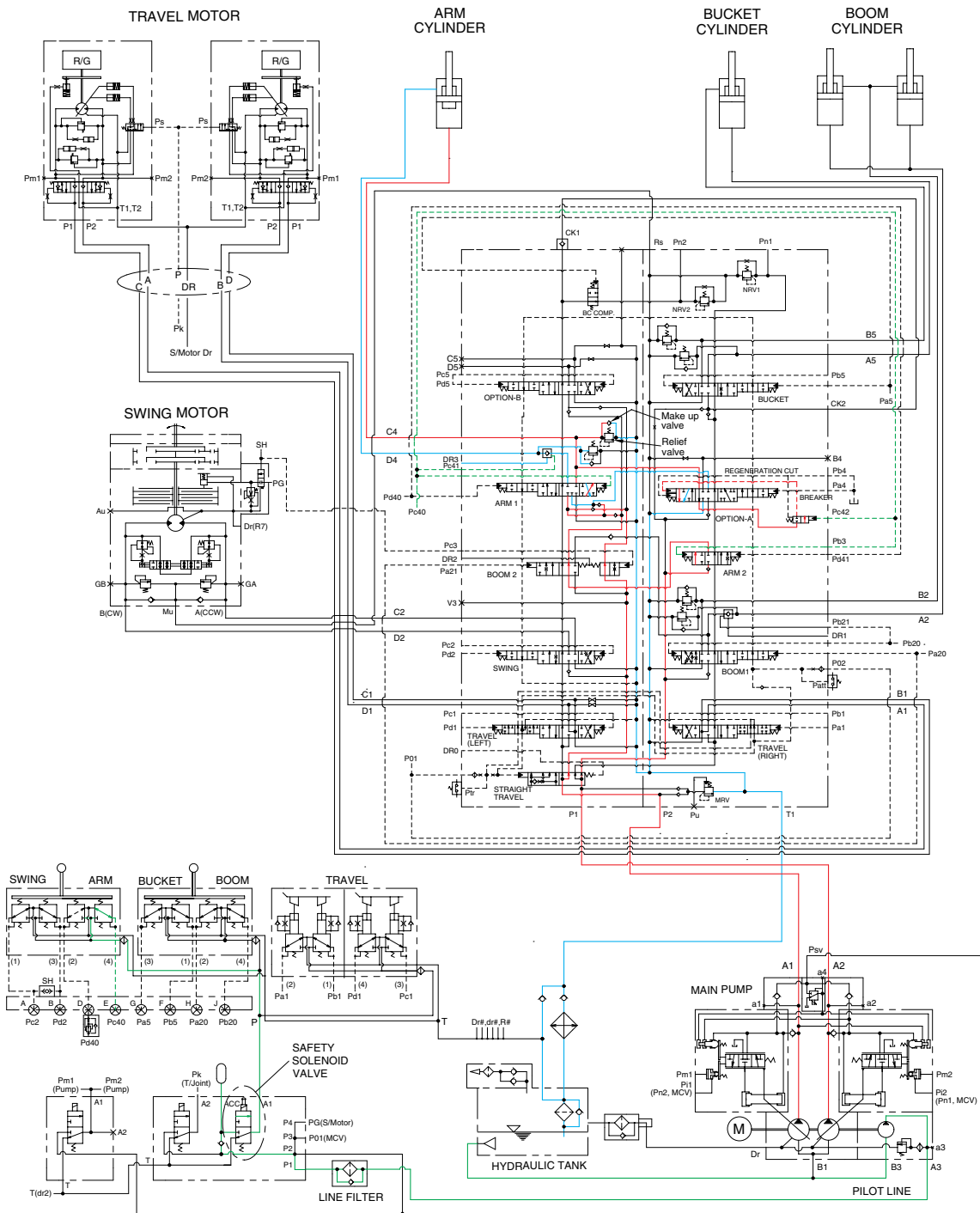
When the right control lever is pushed forward, the boom 1 spool in the main control valve is moved to the down position by the pilot oil pressure from the remote control valve.

The oil from the rear pump flows into the main control valve and then goes to the small chamber of boom cylinders. At the same time, the oil from the large chamber of boom cylinders returns to the hydraulic tank through the boom 1 spool in the main control valve.

When the down speed of boom is faster, the oil returned from the large chamber of boom cylinder combines with the oil from the rear pump, and flows into the small chamber of the cylinder.

This prevents cylinder cavitation by the negative pressure when the rear pump flow can not match the boom down speed. And the excessive pressure in the boom cylinder rod side is prevented by the relief valve.

3. ARM IN OPERATION



2107V3HC11

When the left control lever is pulled back, the arm spools in the main control valve are moved to the roll in position by the pilot oil pressure from the remote control valve.

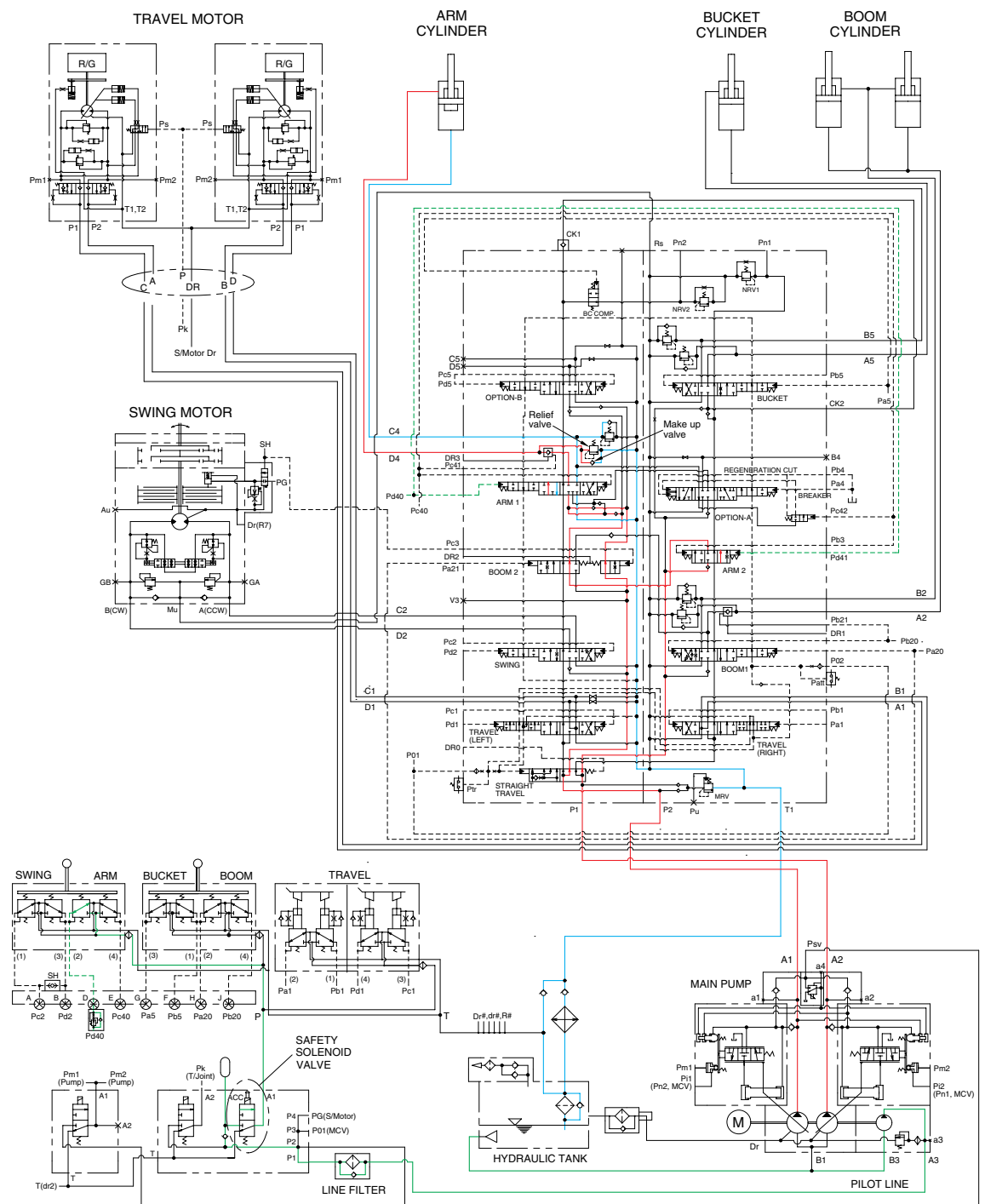
The oil from the front and rear pump flows into the main control valve and then goes to the large chamber of arm cylinder.

At the same time, the oil from small chamber of arm cylinder returns to the hydraulic oil tank through the arm spool in the main control valve. When this happens, the arm rolls in.

The excessive pressure in the arm cylinder head side is prevented by relief valve.

The cavitation which will happen to the head side of the arm cylinder is also prevented by the make-up valve in the main control valve.

4. ARM OUT OPERATION



2107V3HC12

When the left control lever is pushed forward, the arm spool in the main control valve are moved to the roll out position by the pilot oil pressure from the remote control valve.

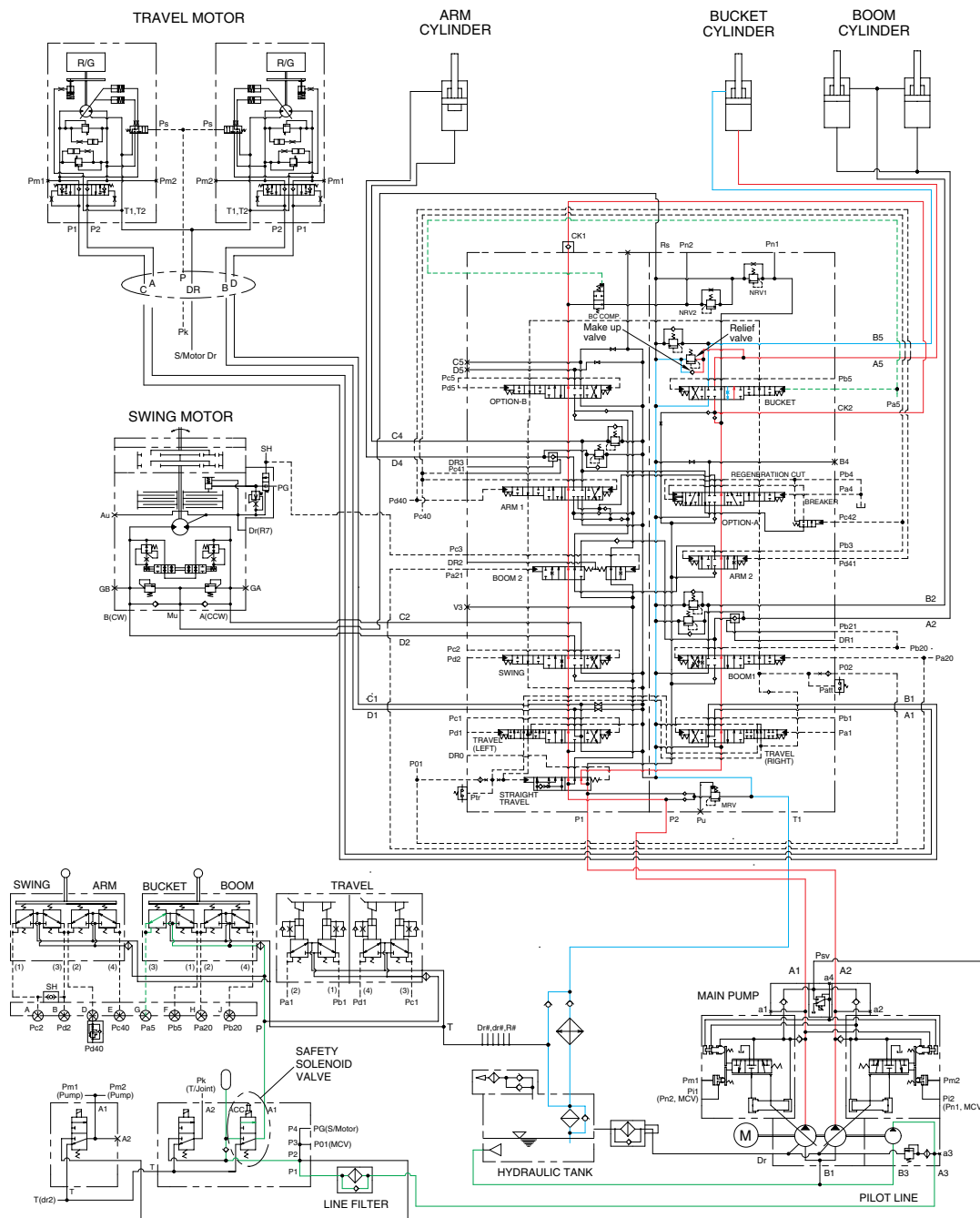
The oil from the front and rear pump flows into the main control valve and then goes to the small chamber of arm cylinder.

At the same time, the oil from the large chamber of arm cylinder returns to the hydraulic oil tank through the arm spools in the main control valve. When this happens, the arm rolls out.

The excessive pressure in the arm cylinder rod side is prevented by relief valve.

The cavitation which will happen to the rod side of the arm cylinder is also prevented by the make-up valve in the main control valve.

5. BUCKET IN OPERATION



2107V3HC13

When the right control lever is pulled left, the bucket spool in the main control valve is moved to the roll in position by the pilot oil pressure from the remote control valve.

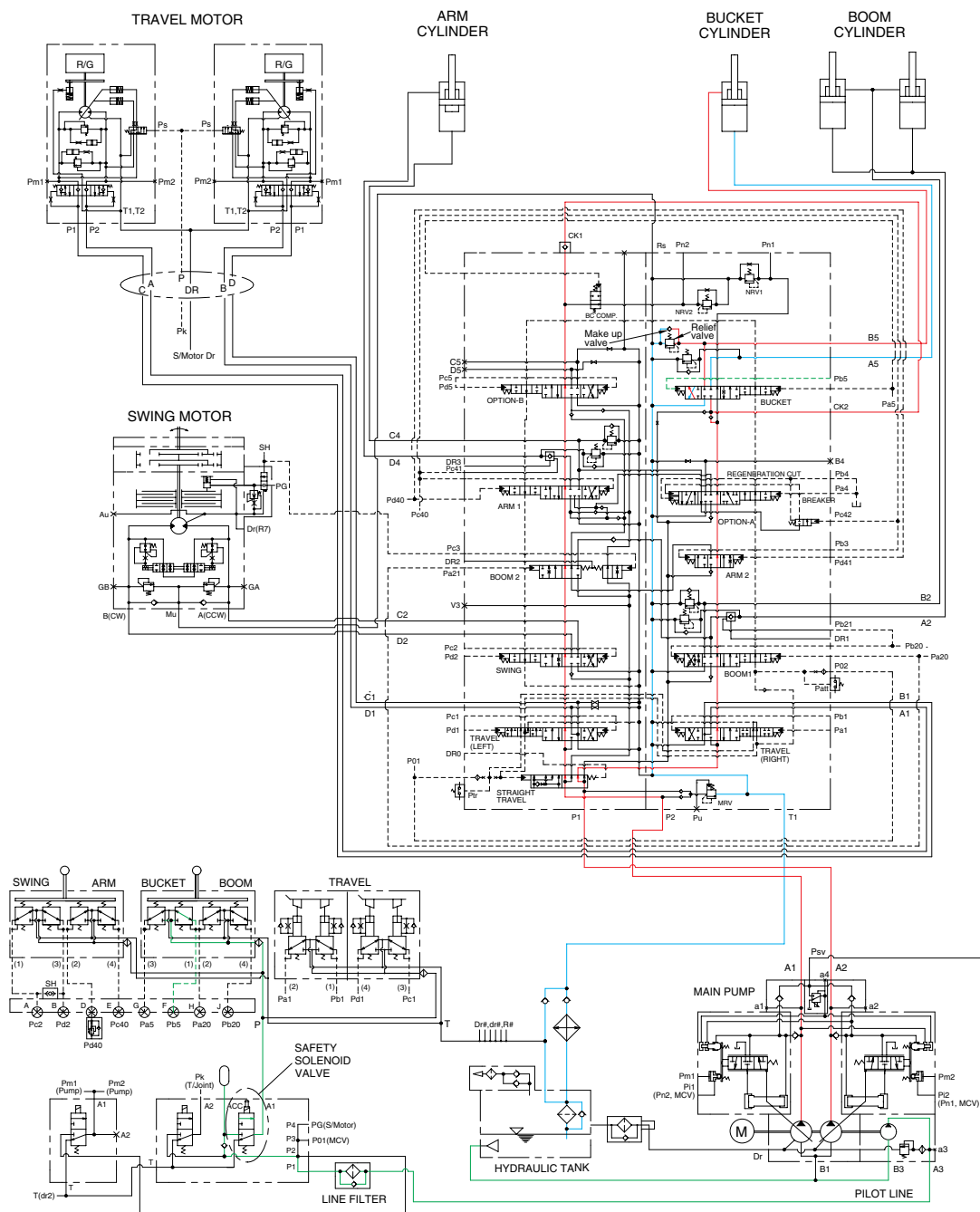
The oil from the rear pump flows into the main control valve and then goes to the large chamber of bucket cylinder. The oil from the front pump flows into the large chamber of bucket cylinder through bucket confluence oil passage.

At the same time, the oil from the small chamber of bucket cylinder returns to the hydraulic oil tank through the bucket spool in the main control valve. When this happens, the bucket rolls in.

The excessive pressure in the bucket cylinder head side is prevented by relief valve.

The cavitation which will happen to the bottom of the bucket cylinder is also prevented by the make-up valve in the main control valve.

6. BUCKET OUT OPERATION



2107V3HC14

When the right control lever is pushed right, the bucket spool in the main control valve is moved to the roll out position by the pilot oil pressure from the remote control valve.

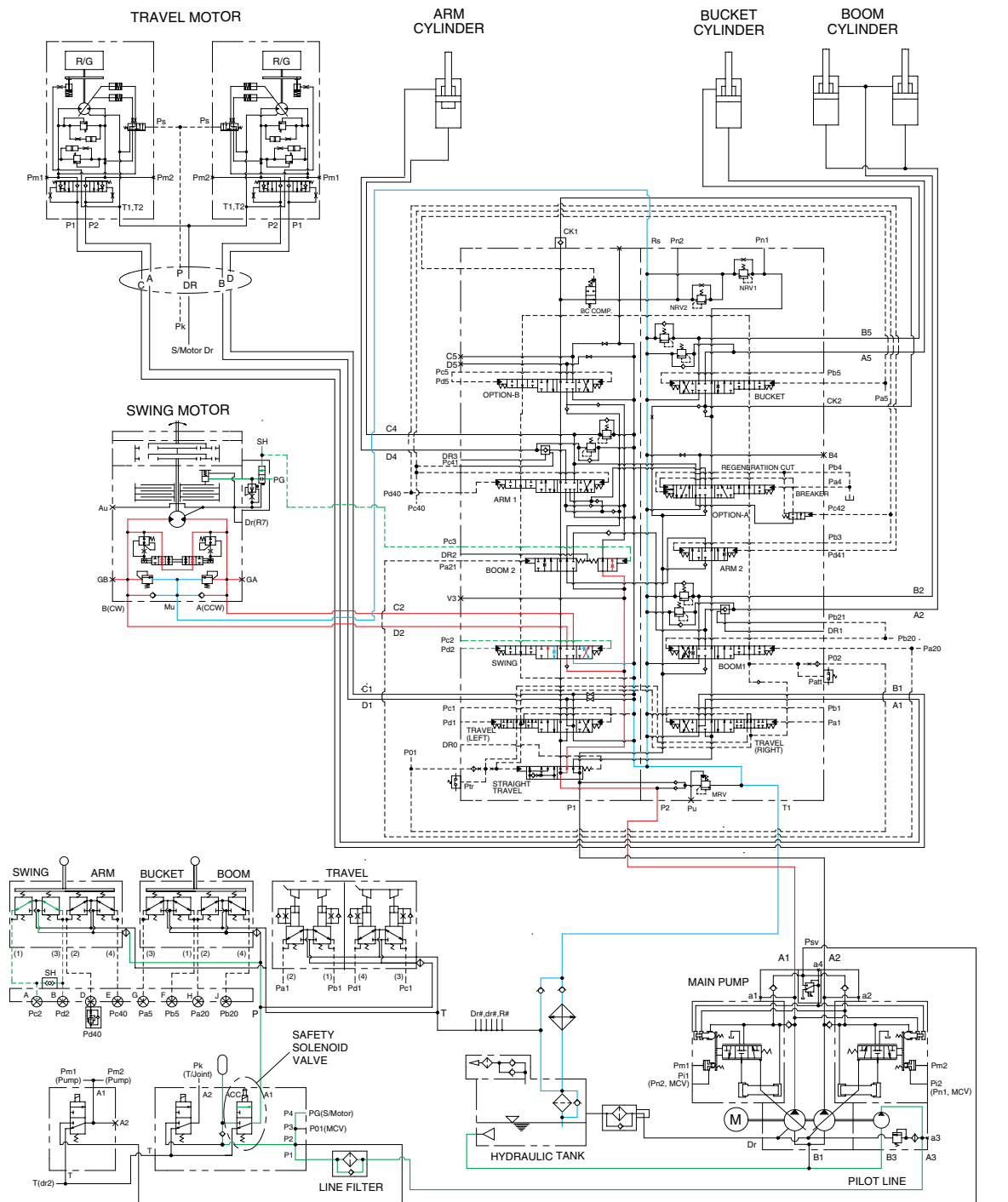
The oil from the rear pump flows into the main control valve and then goes to the small chamber of bucket cylinder. The oil from the front pump flows into the small chamber of bucket cylinder through bucket confluence oil passage.

At the same time, the oil from the large chamber of bucket cylinder returns to the hydraulic oil tank through the bucket spool in the main control valve. When this happens, the bucket rolls out.

The excessive pressure in the bucket cylinder rod side is prevented by relief valve.

The cavitation which will happen to the rod side of the bucket cylinder is also prevented by the make-up valve in the main control valve.

7. SWING OPERATION



2107V3HC15

When the left control lever is pushed left or right, the swing spool in the main control valve is moved to the left or right swing position by the pilot oil pressure from the remote control valve.

The oil from the front pump flows into the main control valve and then goes to the swing motor.

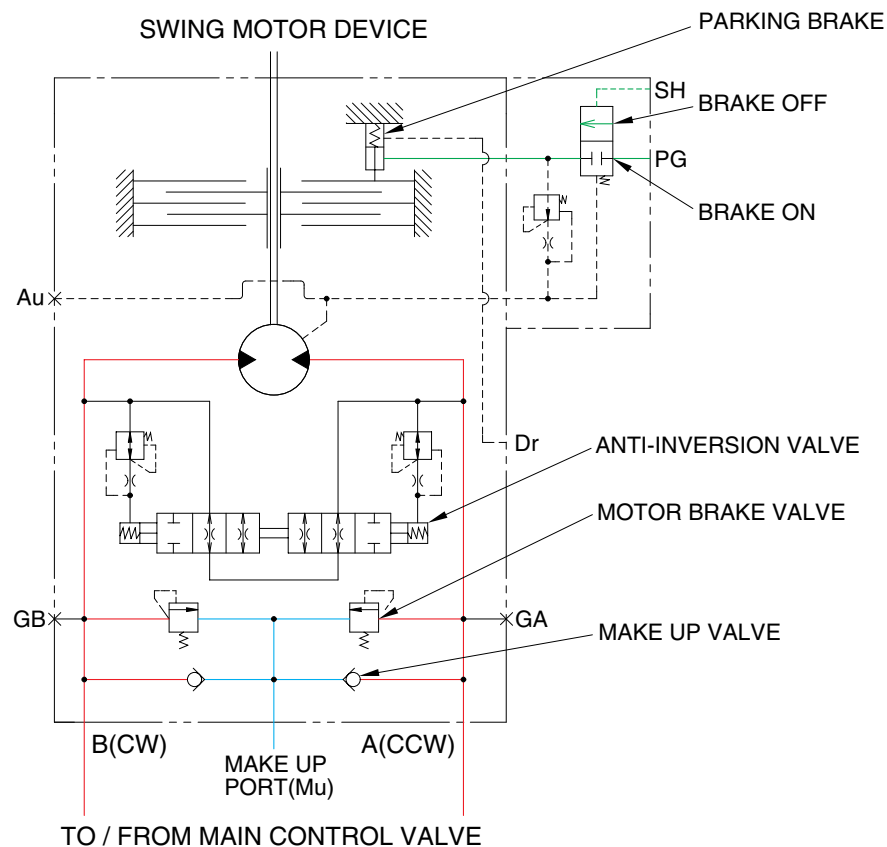
At the same time, the return oil from the swing motor returns to the hydraulic oil tank through the swing spool in the main control valve.

When this happens, the upper structure swings to the left or right.

The swing parking brake, make up valve and the motor brake valve are provided in the swing motor.

The cavitation which will happen to the swing motor is also prevented by the make up valve in the swing motor itself.

SWING CIRCUIT OPERATION



21073HS15A

1) MOTOR BRAKE VALVE

Motor brake valve for the swing motor limits to cushion the starting and stopping pressure of swing operation and controls the swing motor operating pressure.

2) MAKE UP VALVE

The make up valves prevent cavitation by supplying return oil to the vacuum side of the motor.

3) PARKING BRAKE

In case that the parking, of the machine at slope is required during operation, there is the danger of involuntary swing caused by the self weight of the machine. The brake is connected to prevent this involuntary swing.

PARKING BRAKE "OFF" OPERATION

The parking brake is released by the pilot pressure oil from the pilot pump.

When the left control lever placed in the swing position, the pilot pressure at the shuttle valve is transferred to the brake release valve and the brake release valve is change over. Then the pilot pressure lift the brake piston and release the parking brake.

PARKING BRAKE "ON" OPERATION

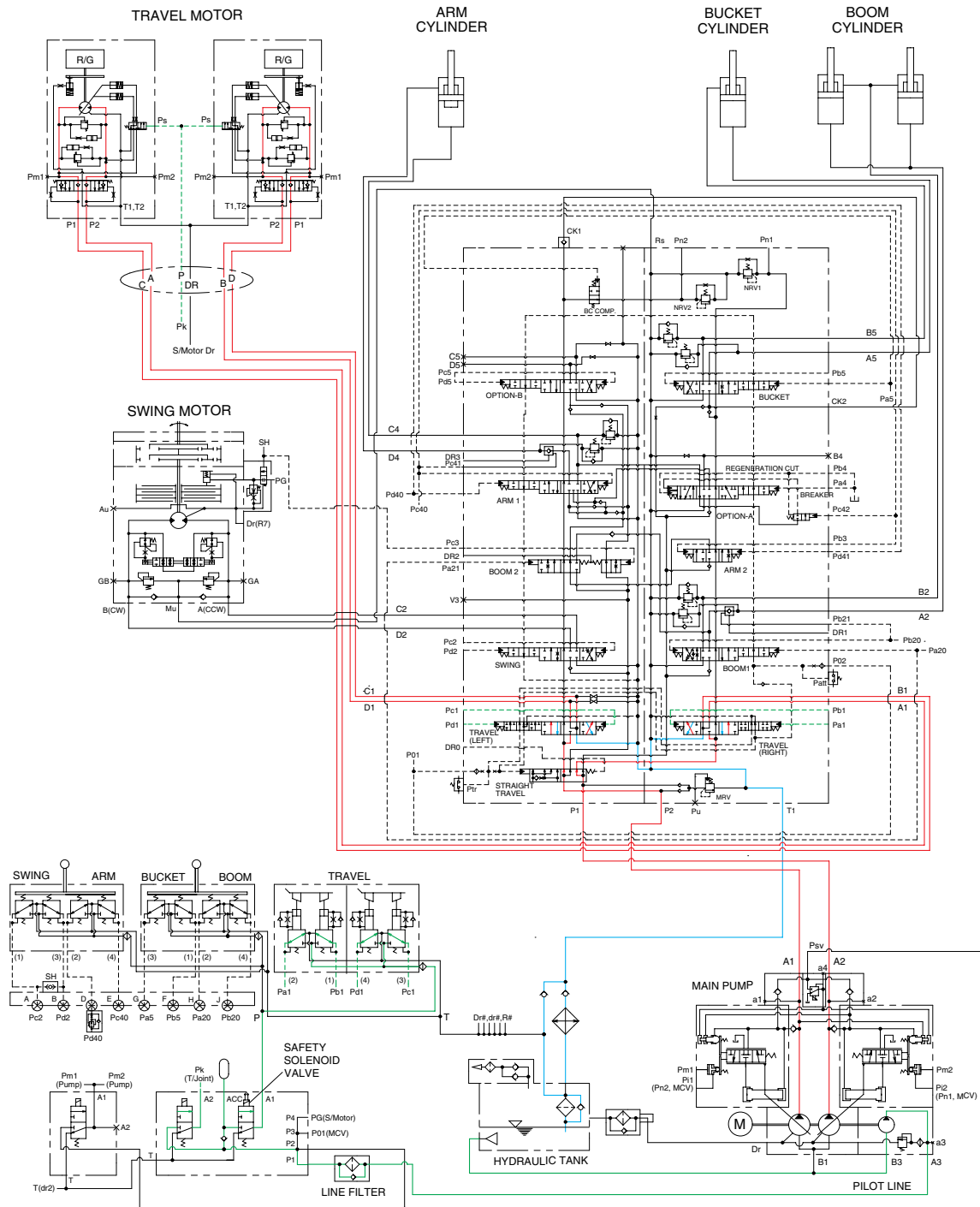
When the control lever placed in the neutral position, the pressure of the pilot oil passage down.

Then the brake release valve returned to the neutral position and the oil is returned from the brake piston to the tank. And the brake is set to 'ON'.

4) ANTI-INVERSION VALVE

This anti-inversion valve absorbs shocks produced as swing motion stops and reduced oscillation cause by swing motion.

8. TRAVEL FORWARD AND REVERSE OPERATION



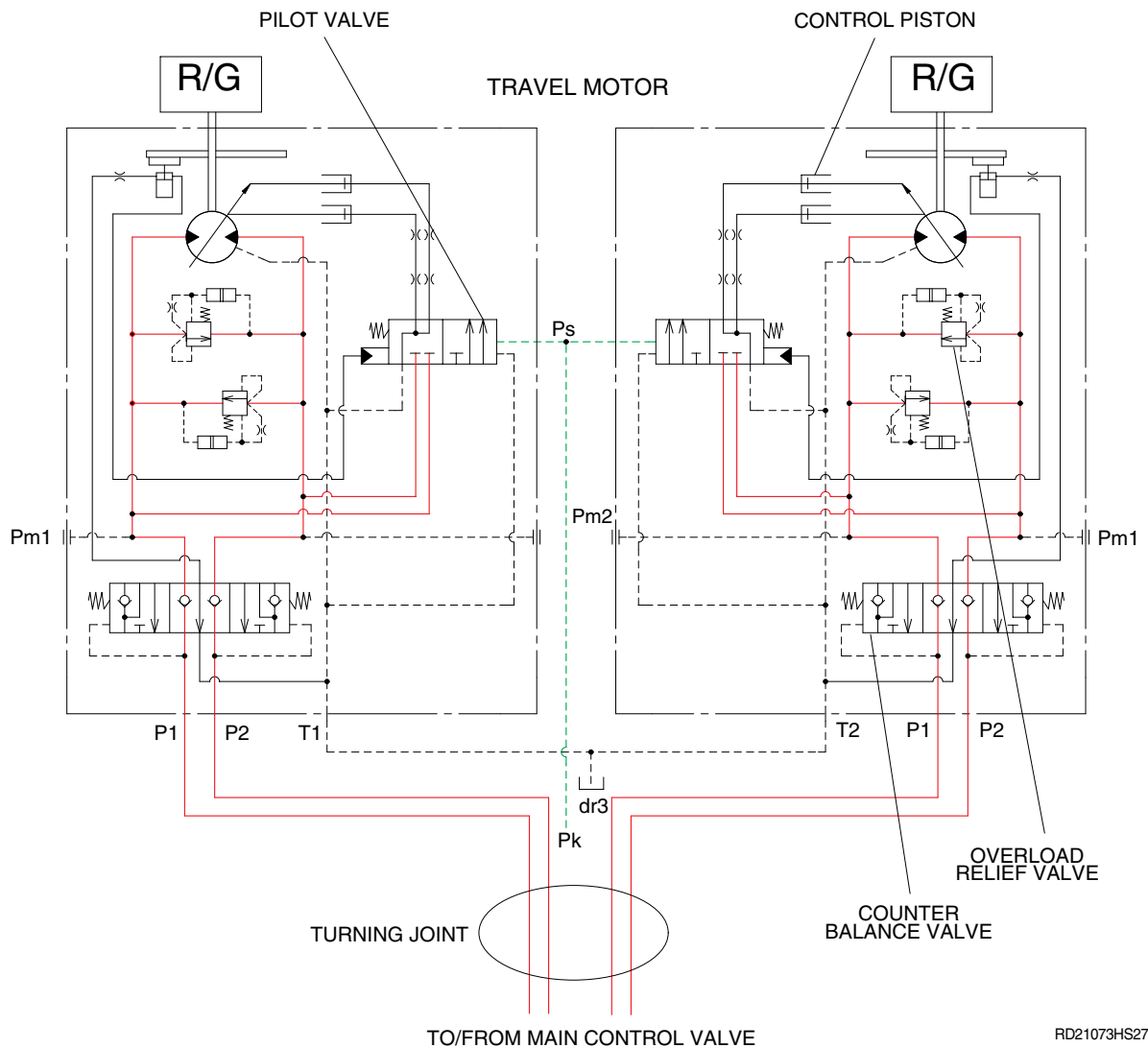
2107V3HC16

When the travel levers are pushed forward or reverse position, the travel spools in the main control valve are moved to the forward or reverse travel position by the pilot oil pressure from the remote control valve.

The oil from the each pump flows into the main control valve and then goes to the each travel motor through the turning joint.

The return oil from both travel motors returns to the hydraulic oil tank through the turning joint and the travel spools in the main control valve.

When this happens, the machine moves to the forward or reverse.



Valves are provided on travel motors to offer the following functions.

1) COUNTER BALANCE VALVE

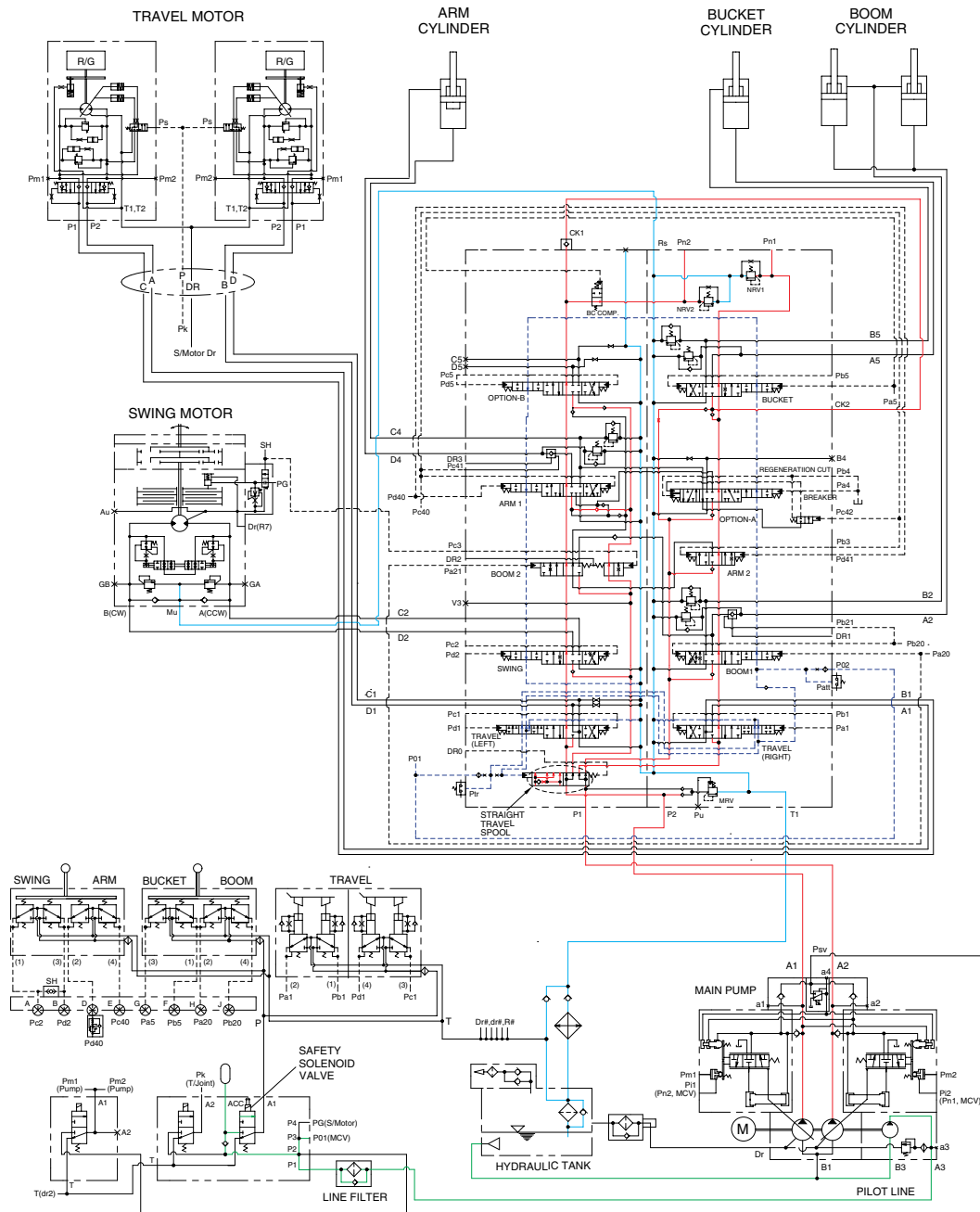
When stopping the motor of slope descending, this valve to prevent the motor over run.

2) OVERLOAD RELIEF VALVE

Relief valve limit the circuit pressure below 360kgf/cm² to prevent high pressure generated at at time of stopping the machine. Stopping the motor, this valve sucks the oil from lower pressure passage for preventing the negative pressure and the cavitation of the motor.

GROUP 5 COMBINED OPERATION

1. OUTLINE



2107V3HC17

The oil from the front and rear pump flows through the neutral oil passage, bypass oil passage and confluence oil passage in the main control valve. Then the oil goes to each actuator and operates them. Check valves and orifices are located on these oil passage in the main control valve. These control the oil from the main pumps so as to correspond to the operation of each actuator and smooth the combined operation.

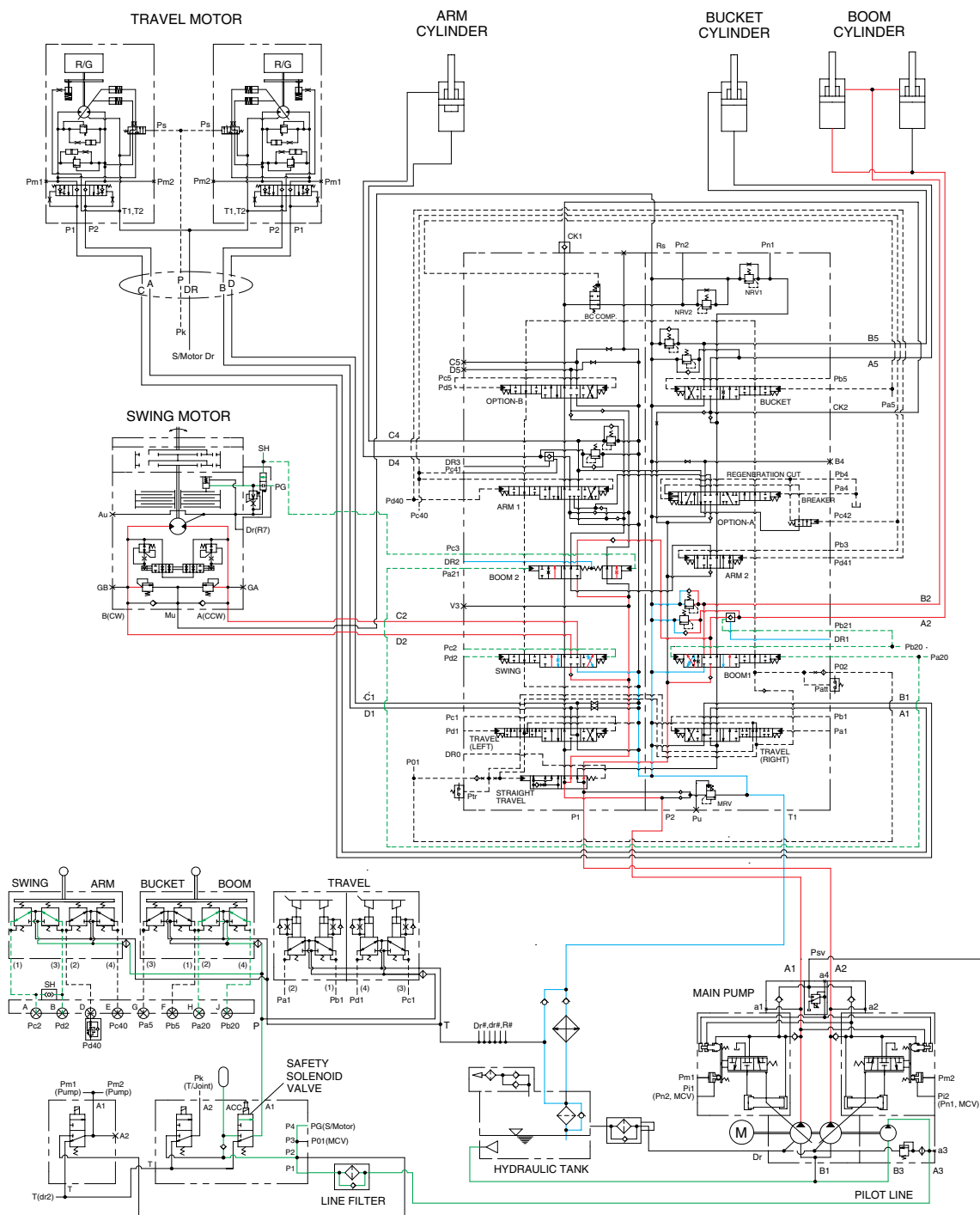
STRAIGHT TRAVEL SPOOL

This straight travel spool for straight travel is provided in the main control valve.

If any actuator is operated when traveling, the straight travel spool is pushed to the right by the pilot oil pressure.

Consequently, the left and right travel oil supply passage are connected, and equivalent amount of oil flows into the left and right travel motors. This keeps the straight travel.

2. COMBINED SWING AND BOOM OPERATION



2107V3HC18

When the swing and boom functions are operated, simultaneously the swing spool and boom spools in the main control valve are moved to the functional position by the pilot oil pressure from the remote control valve.

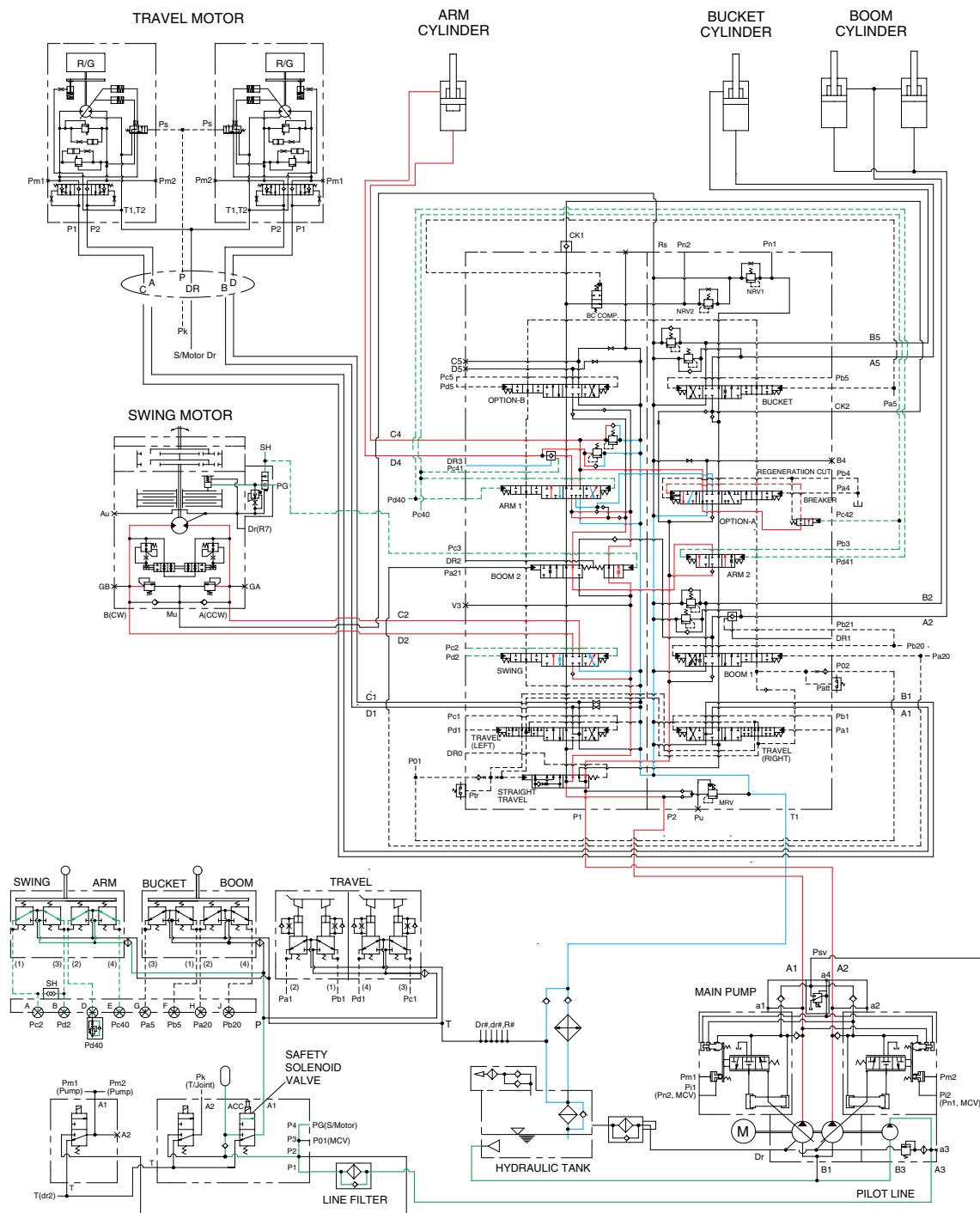
The oil from the front pump flows into the swing motor through swing spool and the boom cylinder through boom 2 spool.

The oil from the rear pump flows into the boom cylinders through the boom 1 spool in the right control valve.

The upper structure swings and the boom is operated.

Refer to page 3-8 for the swing priority system.

3. COMBINED SWING AND ARM OPERATION



2107V3HC19

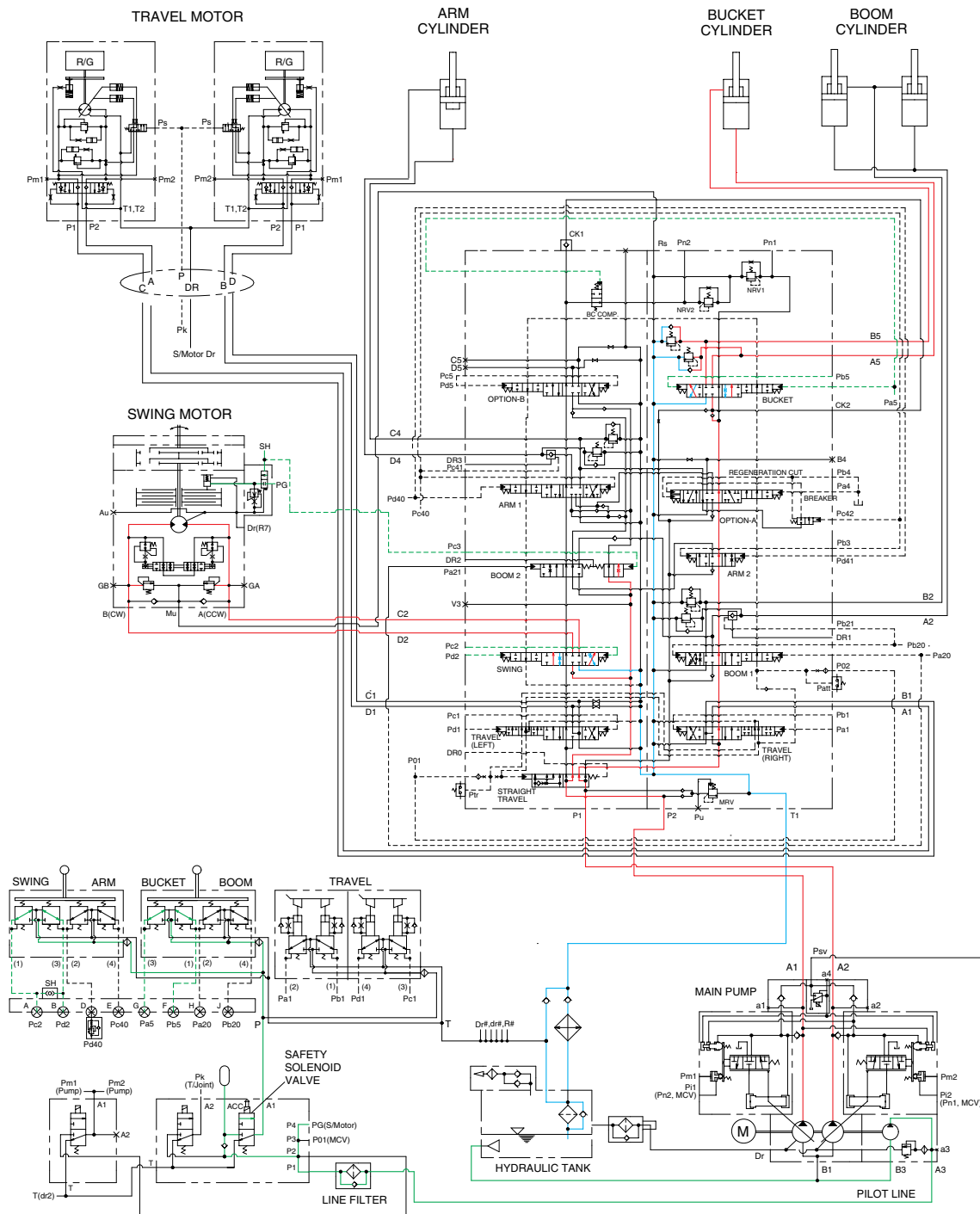
When the swing and arm functions are operated, simultaneously the swing spool and arm spools in the main control valve are moved to the functional position by the pilot oil pressure from the remote control valve.

The oil from the front pump flows into the swing motor through swing spool and the arm cylinder through arm 1 spool.

The oil from the rear pump flows into the arm cylinder through the arm 2 spool of the right control valve.

The upper structure swings and the arm is operated.

4. COMBINED SWING AND BUCKET OPERATION



2107V3HC20

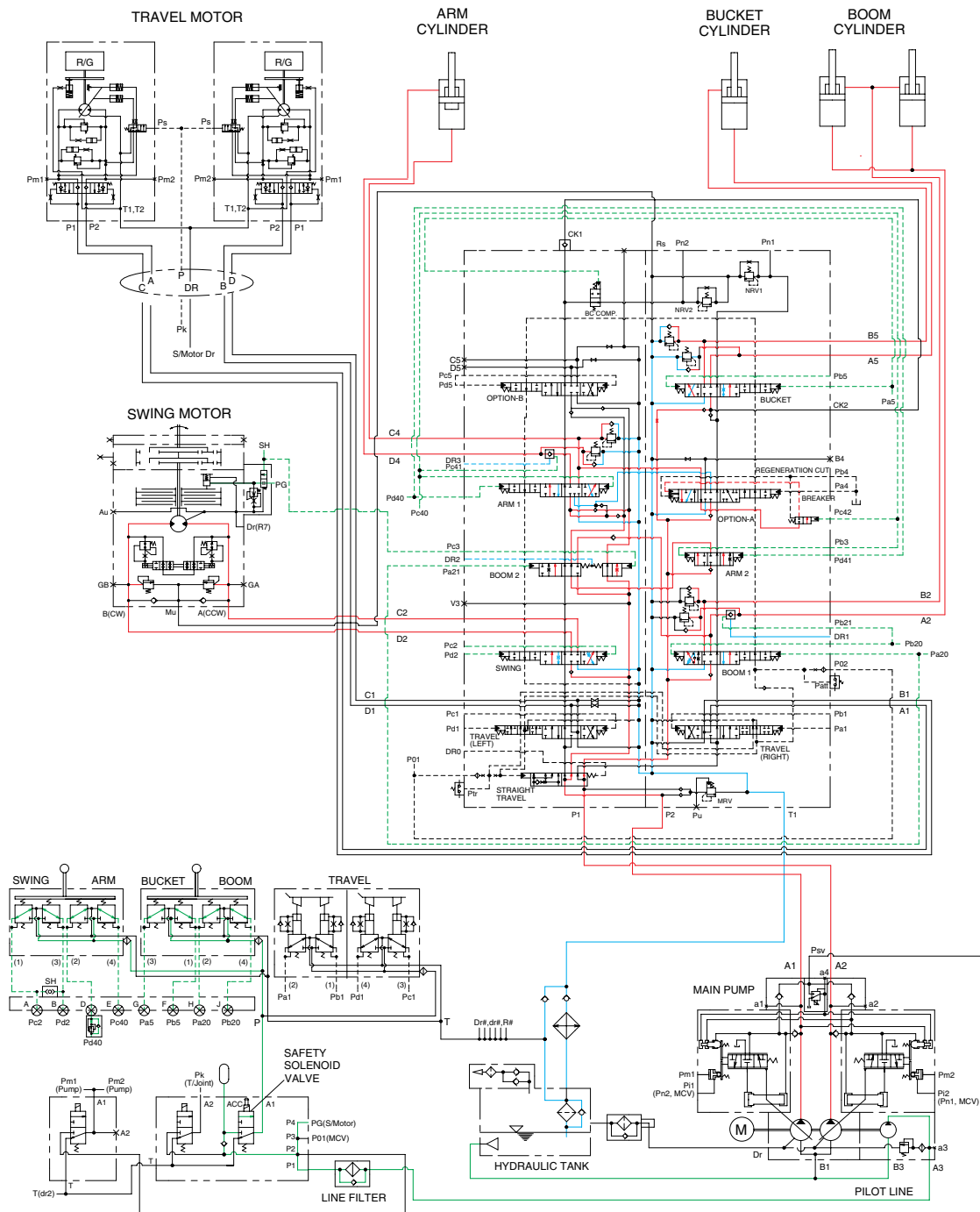
When the swing and bucket functions are operated, simultaneously the swing spool and bucket spool in the main control valve are moved to the functional position by the pilot oil pressure from the remote control valve.

The oil from the front pump flows into the swing motor through the swing spool in the left control valve.

The oil from the rear pump flows into the bucket cylinder through the bucket spool in the right control valve.

The upper structure swing and the bucket is operated.

5. COMBINED SWING, BOOM, ARM AND BUCKET OPERATION



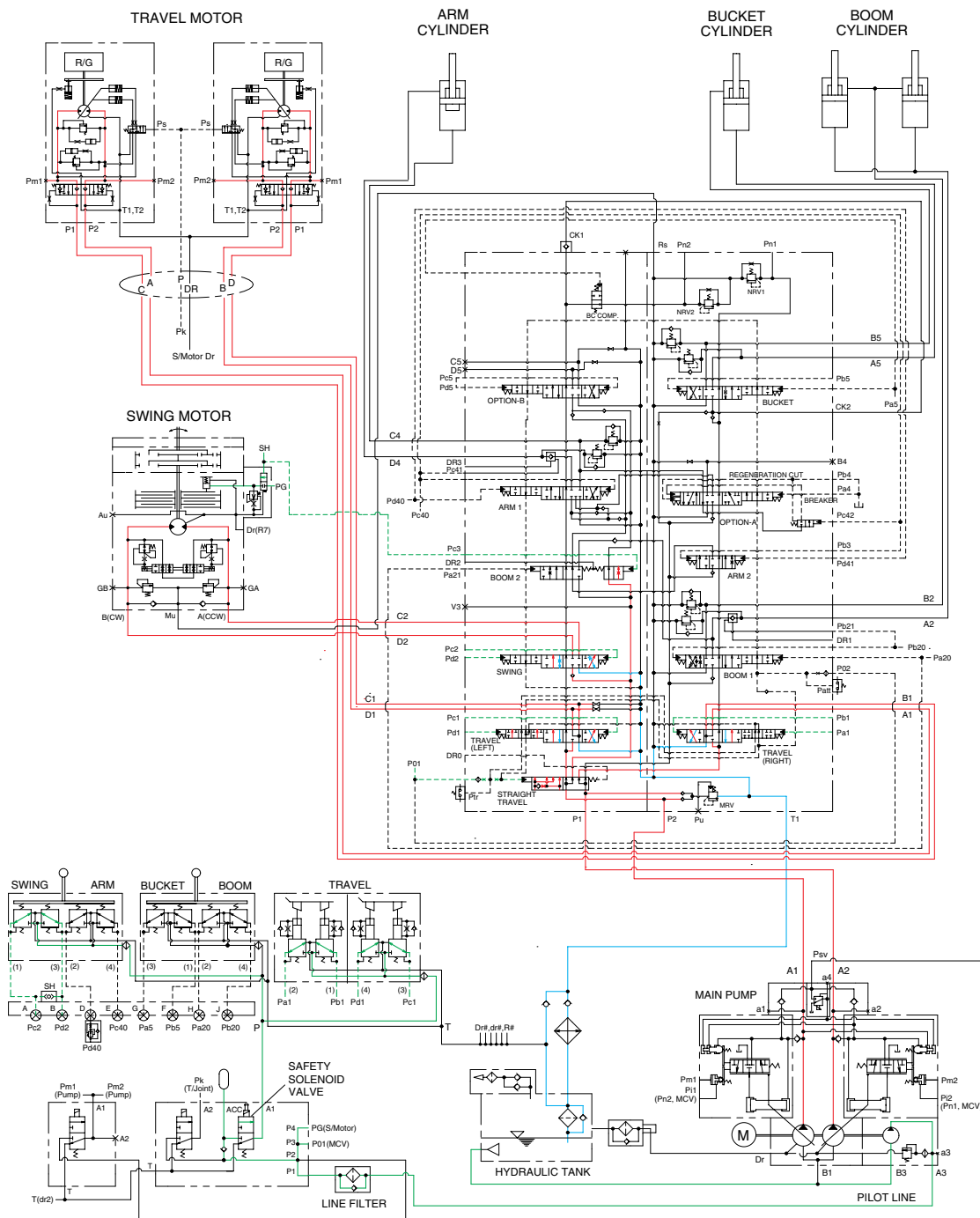
2107V3HC21

When the swing, boom, arm and bucket functions are operated, simultaneously each spool in the main control valve is moved to the functional position by the pilot oil pressure from the remote control valve.

The oil from the front pump flows into the swing motor, boom cylinders and arm cylinder through the swing spool, boom 2 spool, arm 1 spool, and the parallel and confluence oil passage in the left control valve. The oil from the rear pump flows into the boom cylinders, arm cylinder and bucket cylinder through the boom 1 spool, arm 2 spool, bucket spool and the parallel and confluence oil passage in the right control valve.

The upper structure swings and the boom, arm and bucket are operated.

6. COMBINED SWING AND TRAVEL OPERATION



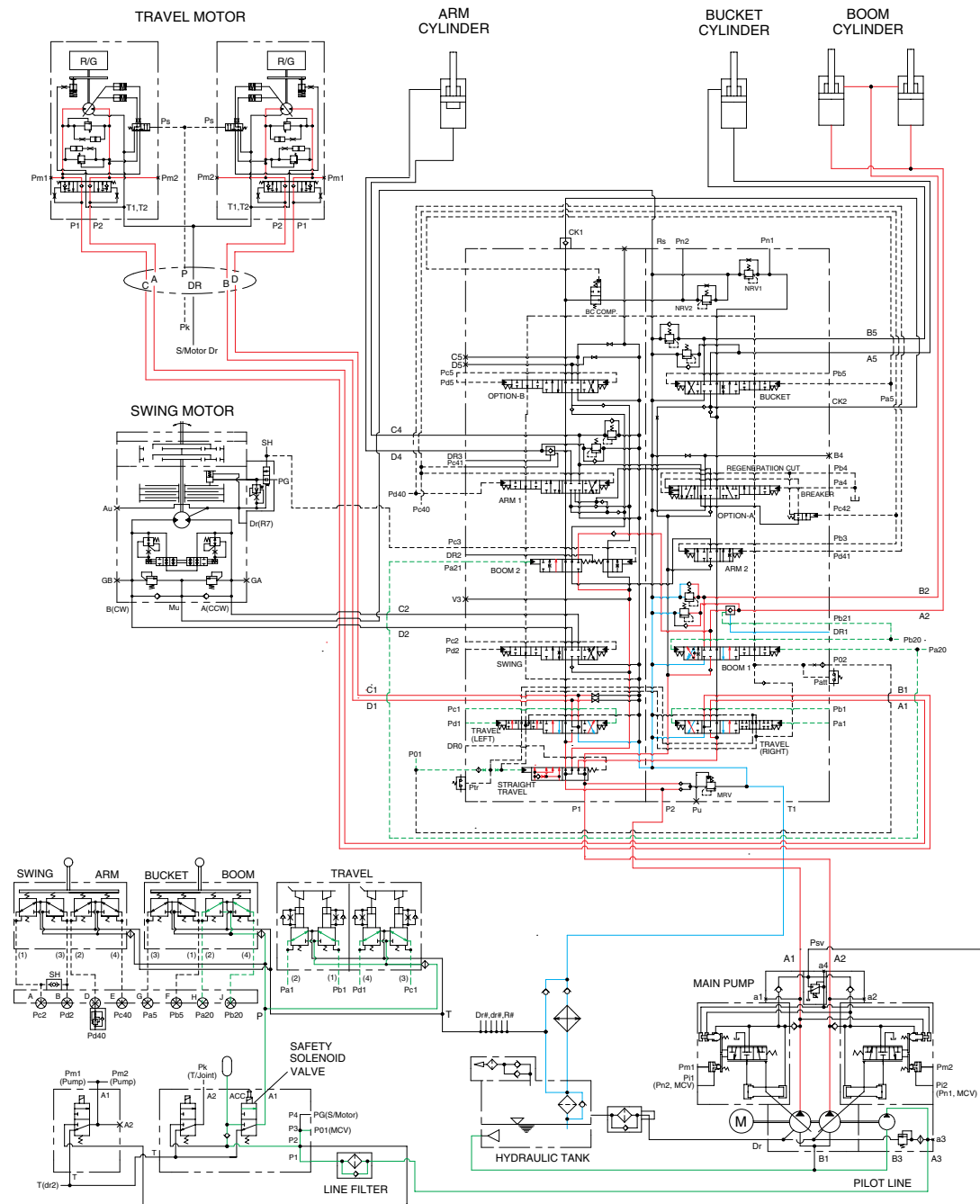
2107V3HC22

When the swing and travel functions are operated, simultaneously the swing spool and travel spools in the main control valve are moved to the functional position by the pilot oil pressure from the remote control valve and straight travel spool is pushed to the right by the pilot oil pressure from the pilot pump.

The oil from the front pump flows into the travel motors through the RH travel spool of the right control valve and the LH travel spool of the left control valve via the straight travel spool. The oil from the rear pump flows into the swing motor through the swing spool.

The upper structure swings and the machine travels straight.

7. COMBINED BOOM AND TRAVEL OPERATION

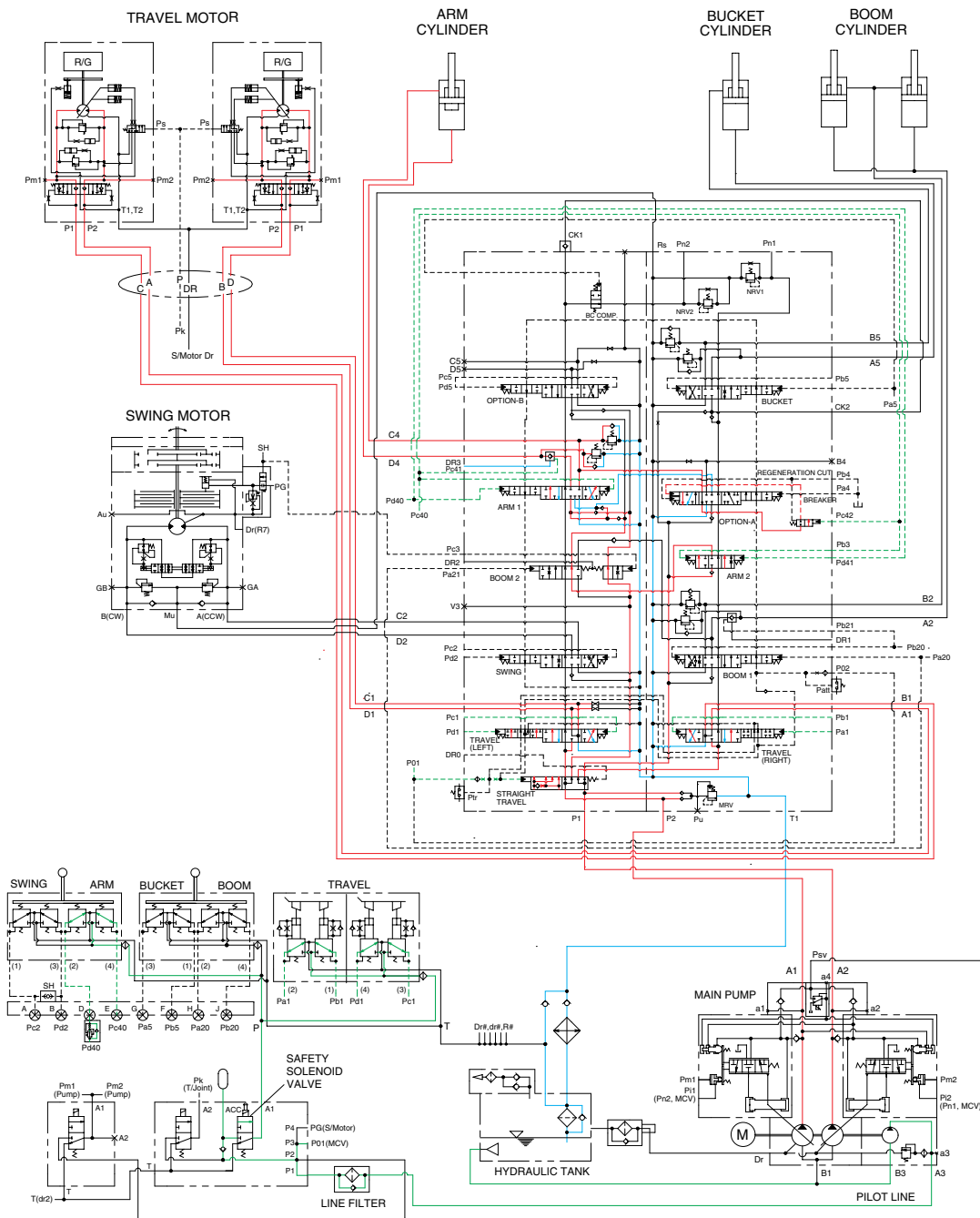


2107V3HC23

When the boom and travel functions are operated, simultaneously the boom spools and travel spools in the main control valve are moved to the functional position by the pilot oil pressure from the remote control valve and the straight travel spool is pushed to the right by the oil pressure from pilot pump. The oil from the front pump flows into the travel motors through the RH travel spool of the right control valve and the LH travel spool of the left control valve via the straight travel spool. The oil from the rear pump flows into the boom cylinders through the boom 2 spool and boom 1 spool via the parallel and confluence oil passage in case boom up operation. Also, the oil from the rear pump flows into the travel motors through the LH travel spool via the check valve and orifice in the straight travel spool.

The boom is operated and the machine travels straight.

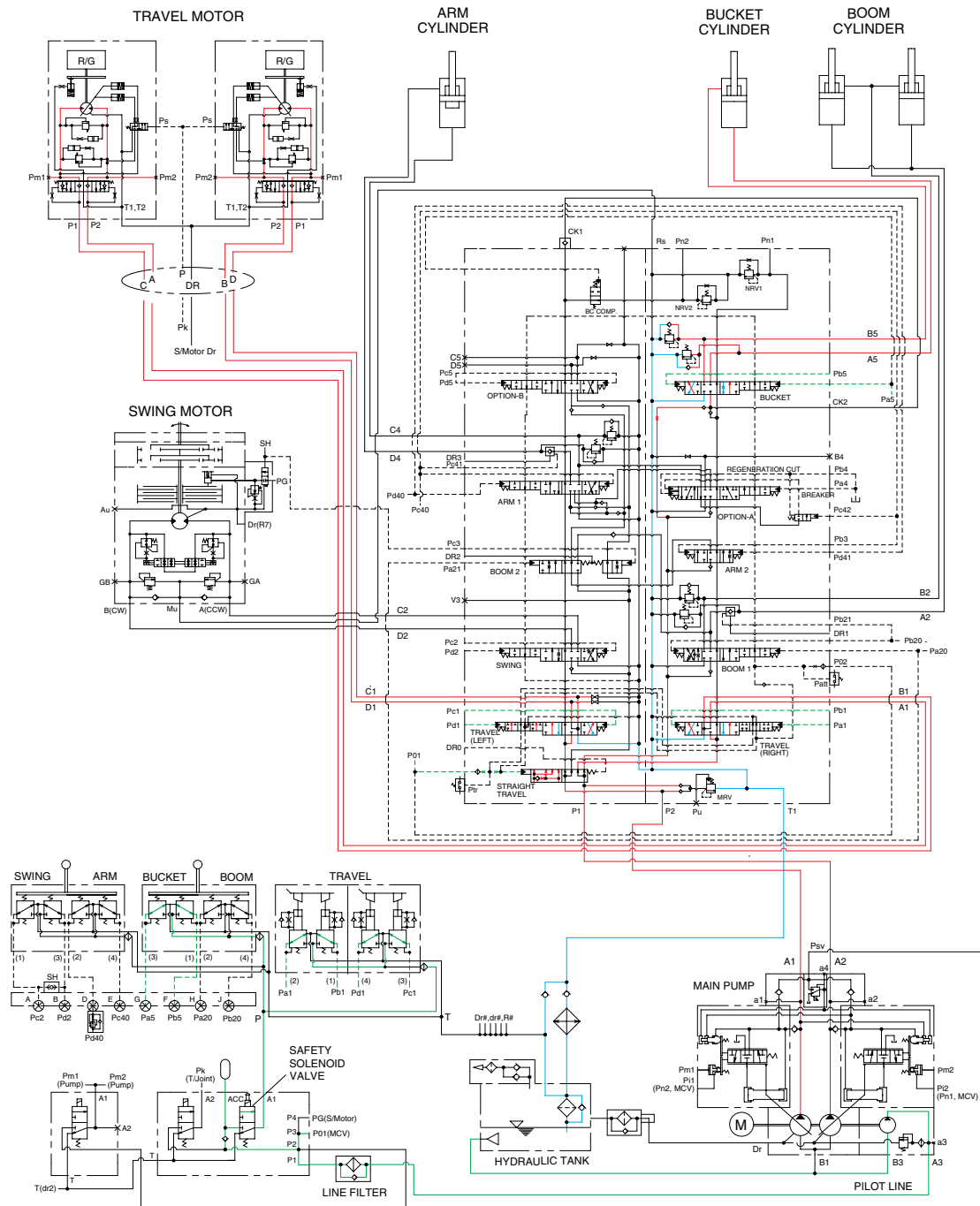
8. COMBINED ARM AND TRAVEL OPERATION



D21073HS24

When the arm and travel functions are operated, simultaneously the arm spools and travel spools in the main control valve are moved to the functional position by the pilot oil pressure from the remote control valve and the straight travel spool is pushed to the right by the oil pressure from pilot pump. The oil from the front pump flows into the travel motors through the RH travel spool of the right control valve and the LH travel spool of the left control valve via the straight travel spool. The oil from the rear pump flows into the arm cylinder through the arm 1 spool and arm 2 spool via the parallel and confluence oil passage. Also, the oil from the rear pump flows into the travel motors through the LH travel spool via the check valve and orifice in the straight travel spool. The arm is operated and the machine travels straight.

9. COMBINED BUCKET AND TRAVEL OPERATION



2107V3HC25

When the bucket and travel functions are operated, simultaneously the bucket spool and travel spools in the main control valve are moved to the functional position by the pilot oil pressure from the remote control valve, and the straight travel spool is pushed to the right by the oil pressure from pilot pump. The oil from the front pump flows into the travel motors through the RH travel spool of the right control valve and the LH travel spool of the left control valve via the straight travel spool of the control valve. The oil from the rear pump flows into the bucket cylinder through the bucket spool via the confluence oil passage. Also, the oil from the rear pump flows into the travel motors through the LH travel spool via the check valve and orifice in the straight travel spool. The bucket is operated and the machine travels straight.

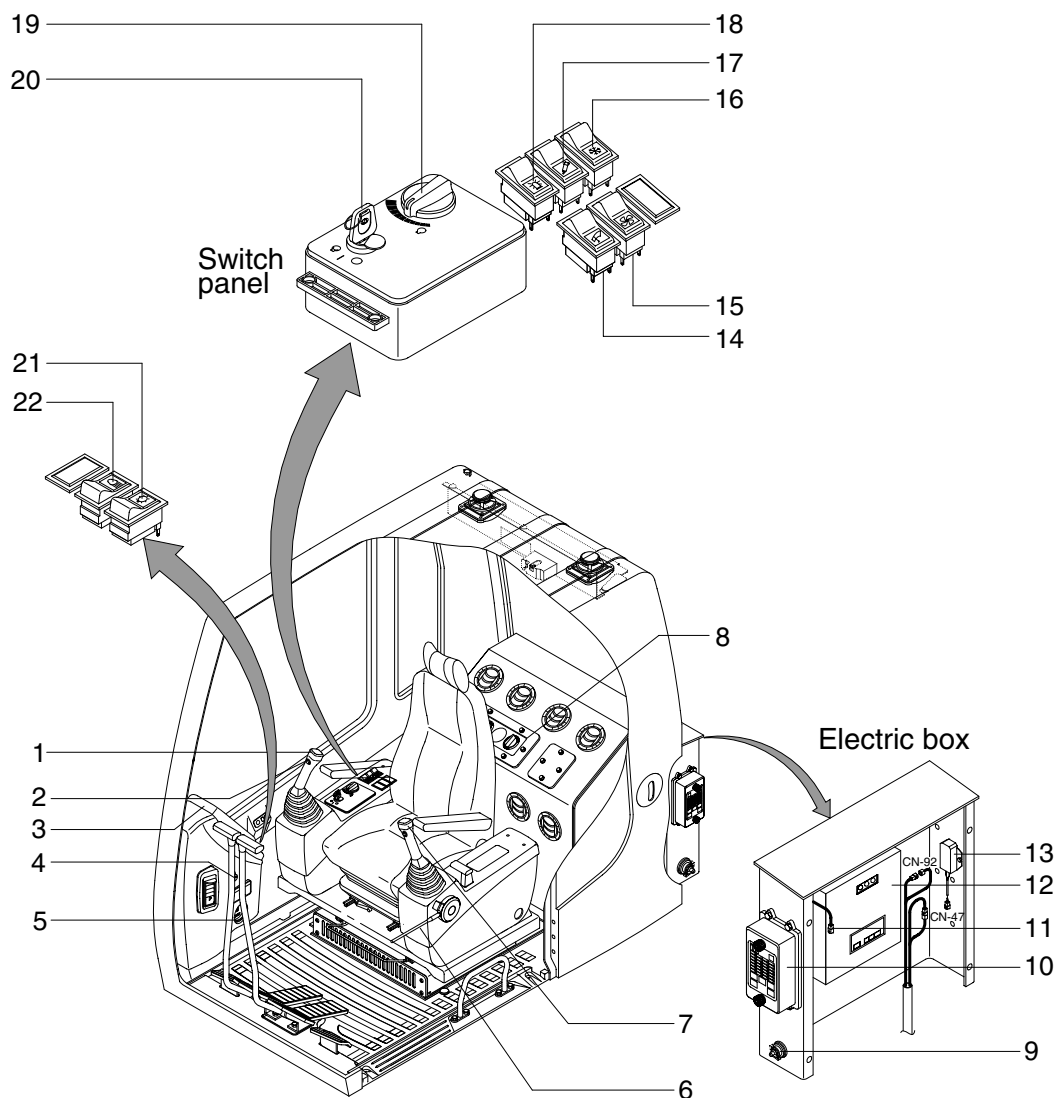
SECTION 4 ELECTRICAL SYSTEM

| | |
|--|------|
| Group 1 Component Location | 4-1 |
| Group 2 Electrical Circuit | 4-3 |
| Group 3 Electrical Component Specification | 4-23 |
| Group 4 Connectors | 4-31 |

SECTION 4 ELECTRICAL SYSTEM

GROUP 1 COMPONENT LOCATION

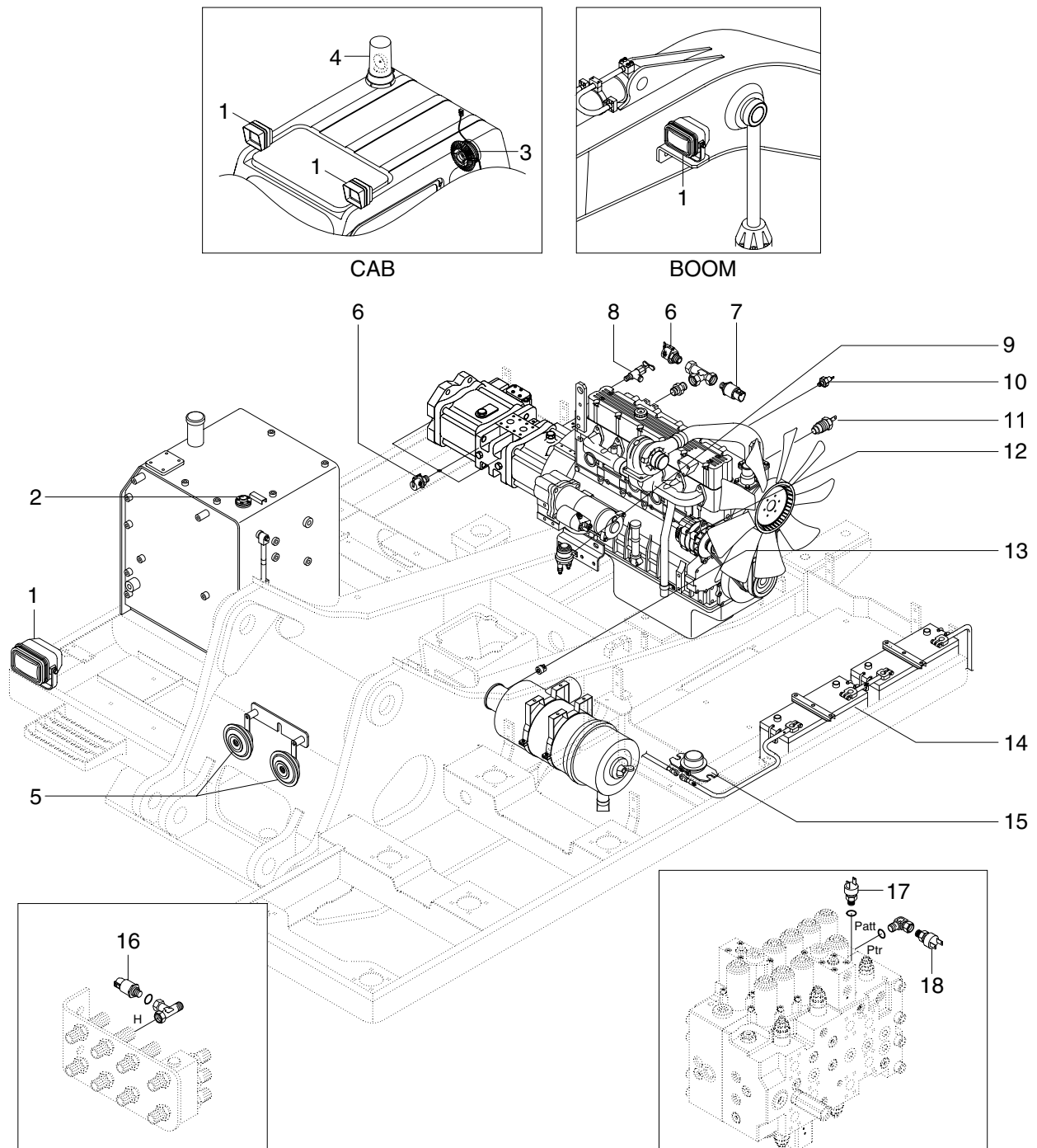
1. LOCATION 1



2107V4EL01

- | | | | | | |
|---|----------------------------|----|-------------------------|----|--------------------------|
| 1 | Horn switch | 9 | Master switch | 17 | Breaker selection switch |
| 2 | Breaker operation switch | 10 | Fuse box | 18 | Beacon switch |
| 3 | Cluster | 11 | RS232 serial connector | 19 | Accel dial switch |
| 4 | Power socket | 12 | CPU controller | 20 | Start switch |
| 5 | Hour meter | 13 | Prolux resistor | 21 | Main light switch |
| 6 | Safety lever | 14 | Wiper and washer switch | 22 | Cab light switch |
| 7 | One touch decel switch | 15 | Fan switch | | |
| 8 | Air conditioner controller | 16 | Air conditioner switch | | |

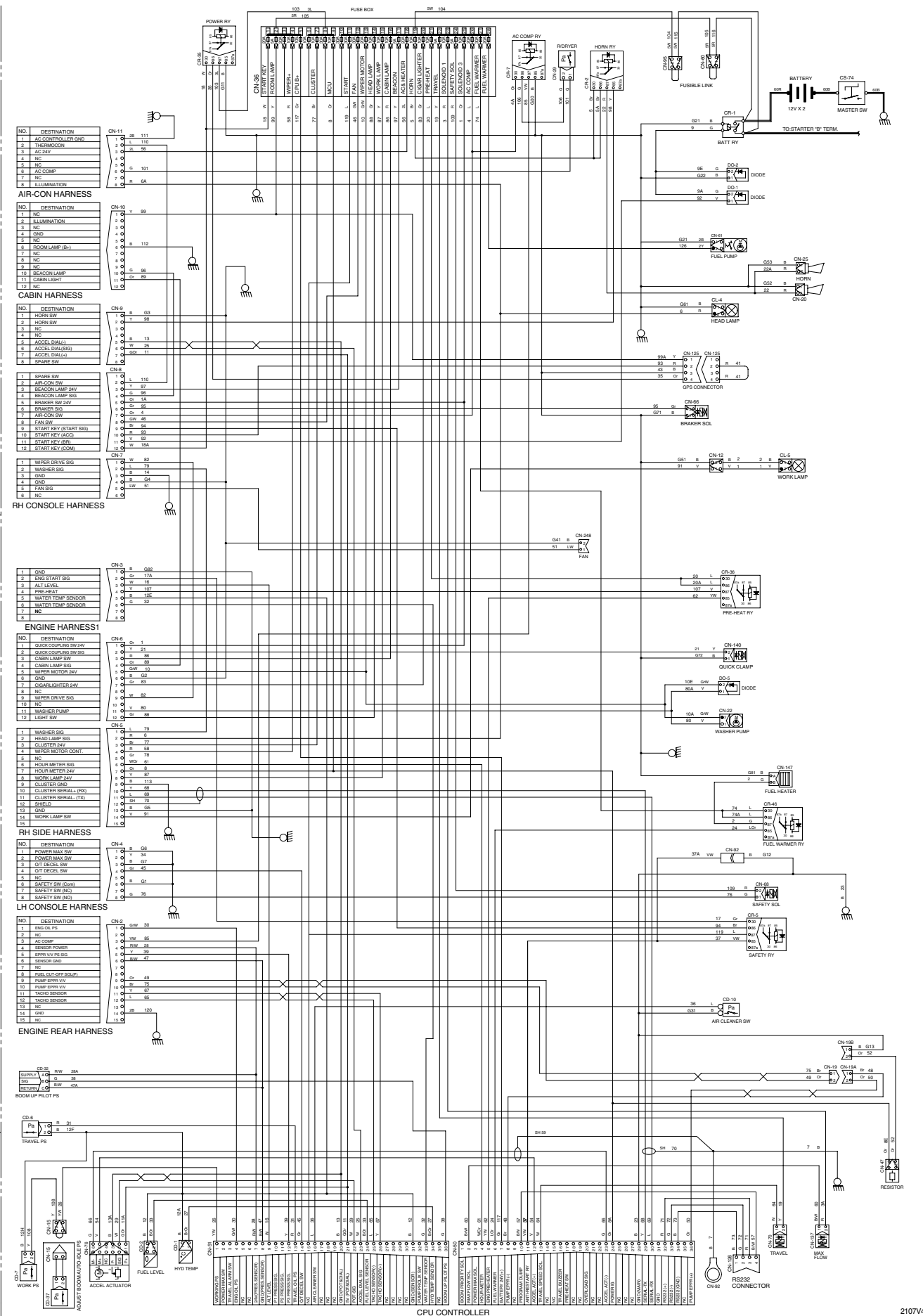
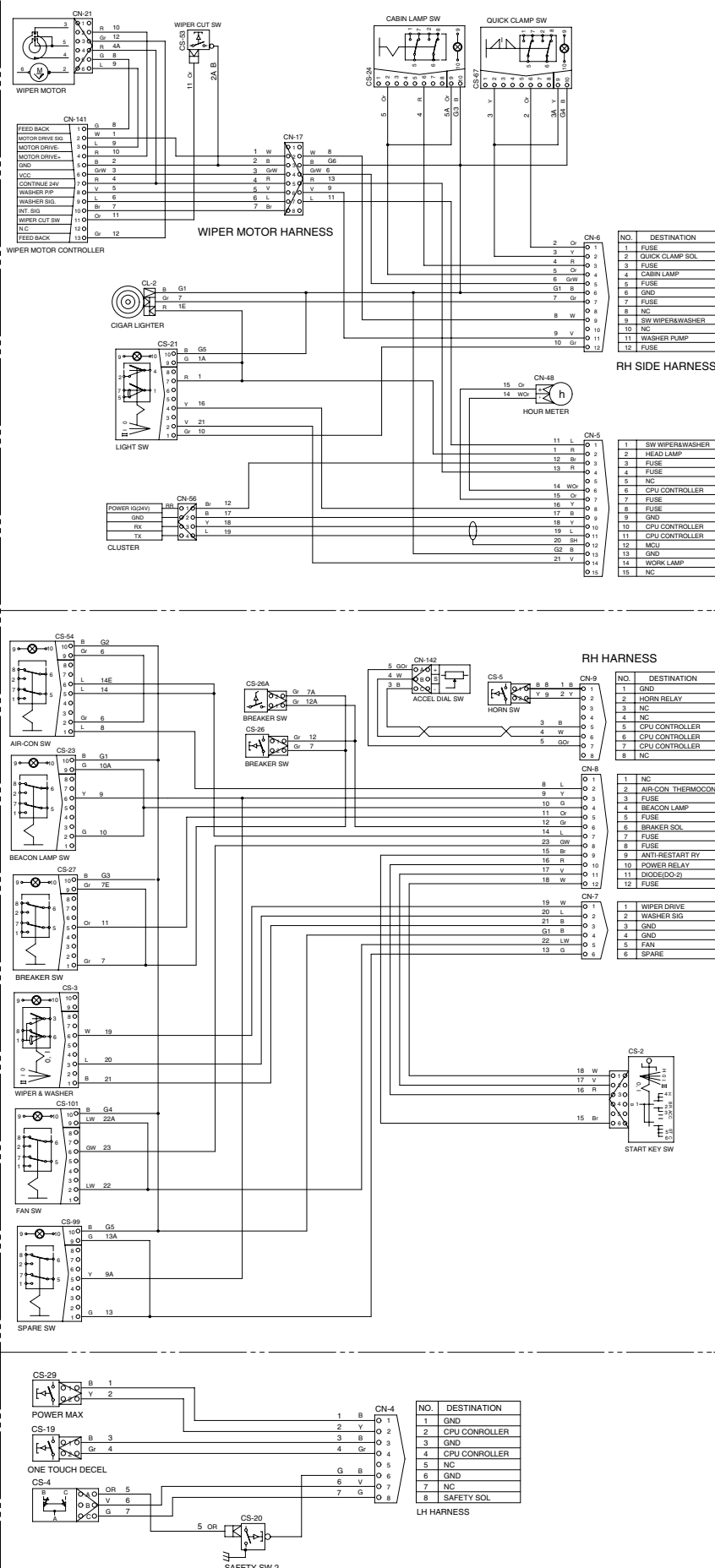
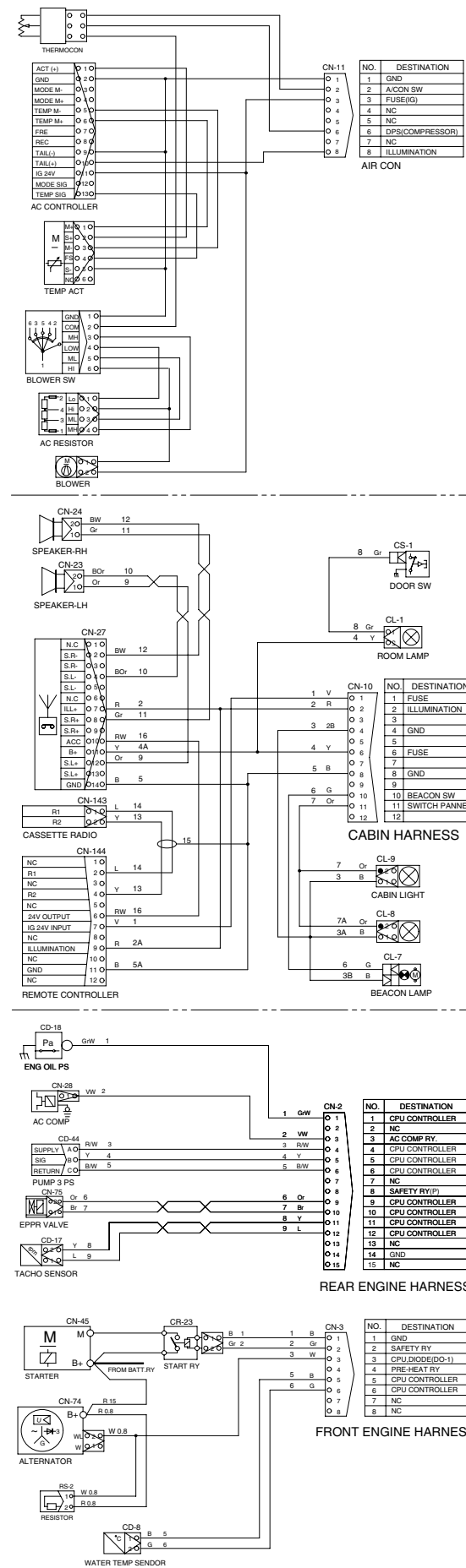
2. LOCATION 2



2107V4EL02

- | | | |
|------------------|-------------------------------|-------------------------------|
| 1 Lamp | 7 EPPR pressure sender | 13 Air cleaner switch |
| 2 Fuel sender | 8 Heater valve | 14 Battery |
| 3 Fan | 9 Start relay | 15 Battery relay |
| 4 Beacon lamp | 10 Engine oil pressure switch | 16 Boom up pressure sender |
| 5 Horn | 11 Temp sender | 17 Attachment pressure sender |
| 6 Screw coupling | 12 Alternator | 18 Travel pressure sender |

GROUP 2 ELECTRICAL CIRCUIT

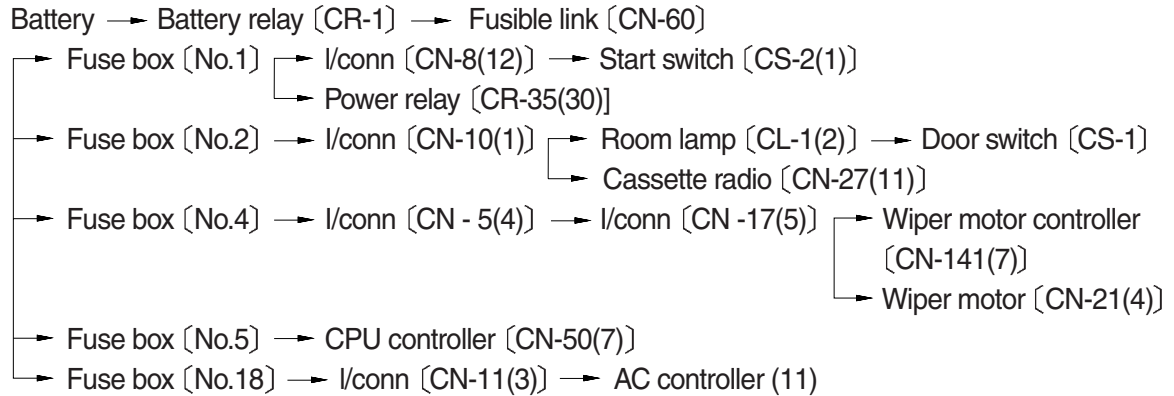


1. POWER CIRCUIT

The negative terminal of battery is grounded to the machine chassis through master switch.

When the start switch is in the OFF position, the current flows from the positive battery terminal as shown below.

1) OPERATING FLOW

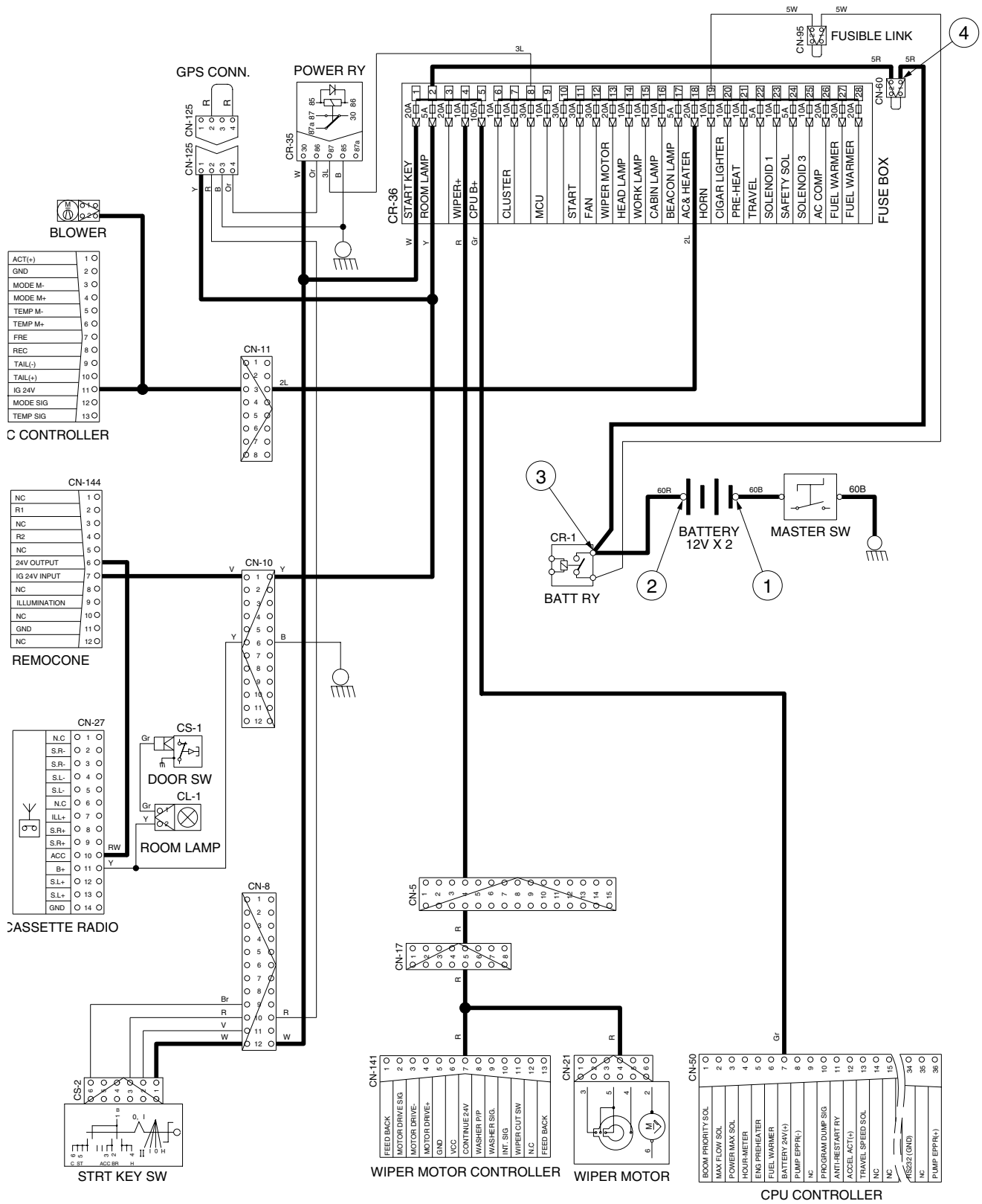


2) CHECK POINT

| Engine | Start switch | Check point | Voltage |
|--------|--------------|------------------------|----------|
| OFF | OFF | ① - GND (Battery 1EA) | 10~12.5V |
| | | ② - GND (Battery 2EA) | 20~25V |
| | | ③ - GND (Battery 2EA) | 20~25V |
| | | ④ - GND (Fusible link) | 20~25V |

※ GND : Ground

POWER CIRCUIT



2. STARTING CIRCUIT

1) OPERATING FLOW

Battery(+) terminal → Battery relay[CR-1] → Fusible link[CN-60] → Fuse box [No.1]
 → I/conn [CN-8(12)] → Start key [CS-2(1)]

※ Start switch : ON

→ Start switch ON [CS-2(2)] → I/conn [CN-8(11)] → Diode[DO-2] →
 Battery relay [CR-1]:Battery relay operating(All power is supplied with the electric component)
 → Start switch ON [CS-2(3)] → I/conn [CN-8(10)] → Power relay [CR-35(86)→(87)]
 → Fuse box [No.11] → Safety relay [CR-5(87)]

※ Start switch : START

Start switch START[CS-2(6)] → I/conn[CN-8(9)] → Safety relay [CR-5(86) → (30)]
 → I/conn [CN-3(2)] → Start relay [CR-23]

2) CHECK POINT

| Engine | Start switch | Check point | Voltage |
|-----------|--------------|---|----------|
| Operating | Start | ① - GND (Battery) ② - GND (Start key) ③ - GND (Battery relay M4) ④ - GND (Starter B) ⑤ - GND (Starter M) ⑥ - GND (Start relay) ⑦ - GND (Battery relay M8) | 20 ~ 25V |

※ GND : Ground

3. CHARGING CIRCUIT

When the starter is activated and the engine is started, the operator releases the key switch to the ON position.

Charging current generated by operating alternator flows into the battery through the Battery relay [CR-1].

The current also flows from alternator to each electrical component and controller through the fuse box.

1) OPERATING FLOW

(1) Warning flow

Alternator "2" terminal → I/conn [CN-3(3)] → CPU Controller [CN-51(9)] →
Cluster warning lamp (via serial interface)

(2) Charging flow

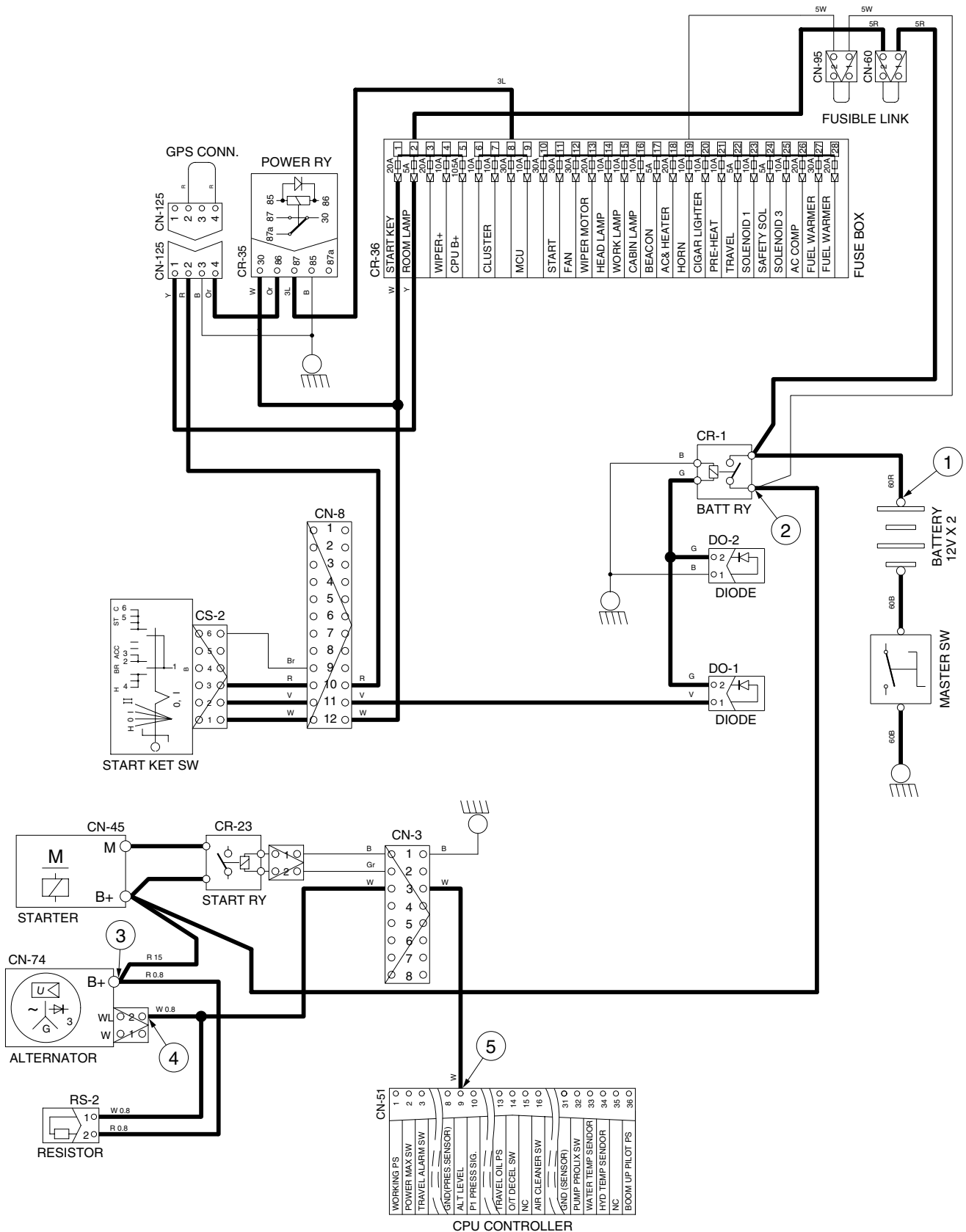
Alternator "B+" terminal → Battery relay(M8) → Battery(+) terminal
→ Fusible link[CN-60] → Fuse box

2) CHECK POINT

| Engine | Start switch | Check point | Voltage |
|--------|--------------|--|-----------|
| ON | ON | ① - GND (Battery voltage) ② - GND (Battery relay) ③ - GND (Alternator B terminal) ④ - GND (Alternator I terminal) ⑤ - GND (CPU controller) | 20 ~ 275V |

※ GND : Ground

CHARGING CIRCUIT



2107V4EC06

4. HEAD LAMP CIRCUIT

1) OPERATING FLOW

Fuse box (No.14) → I/conn [CN-6(12)] → CS-21(1)

※ When light switch ON

Light switch [CS-21(7)]

└→ I/conn[CN-5(2)] → Head lamp ON [CL-4(2)] : Head lamp ON

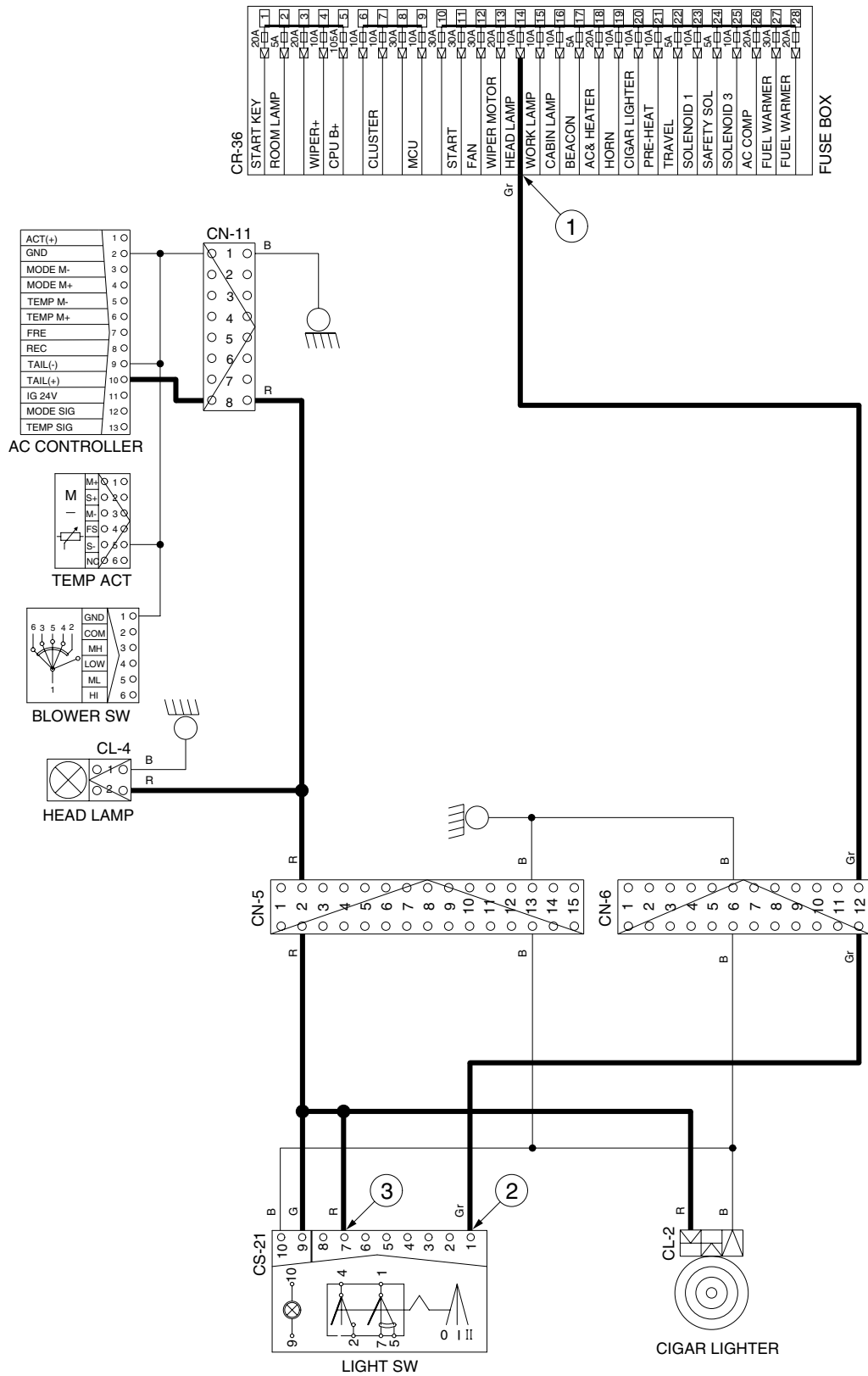
└→ Switch indicator lamp ON [CS-21(9)] → Cigar lighter [CL-2]

2) CHECK POINT

| Engine | Key switch | Check point | Voltage |
|--------|------------|---|---------|
| STOP | ON | ① - GND (Fuse box) ② - GND (Switch power input) ③ - GND (Switch power output) | 20~25V |

※ GND : Ground

HEAD LAMP CIRCUIT



5. WORK LAMP CIRCUIT

1) OPERATING FLOW

Fuse box (No.15) → I/conn [CN-5(8)] → Light switch [CS-21(4)]

※ When work light switch ON

Work lamp switch ON [CS-21(2)] → I/conn [CN-5(14)] → I/conn [CN-12(1)]

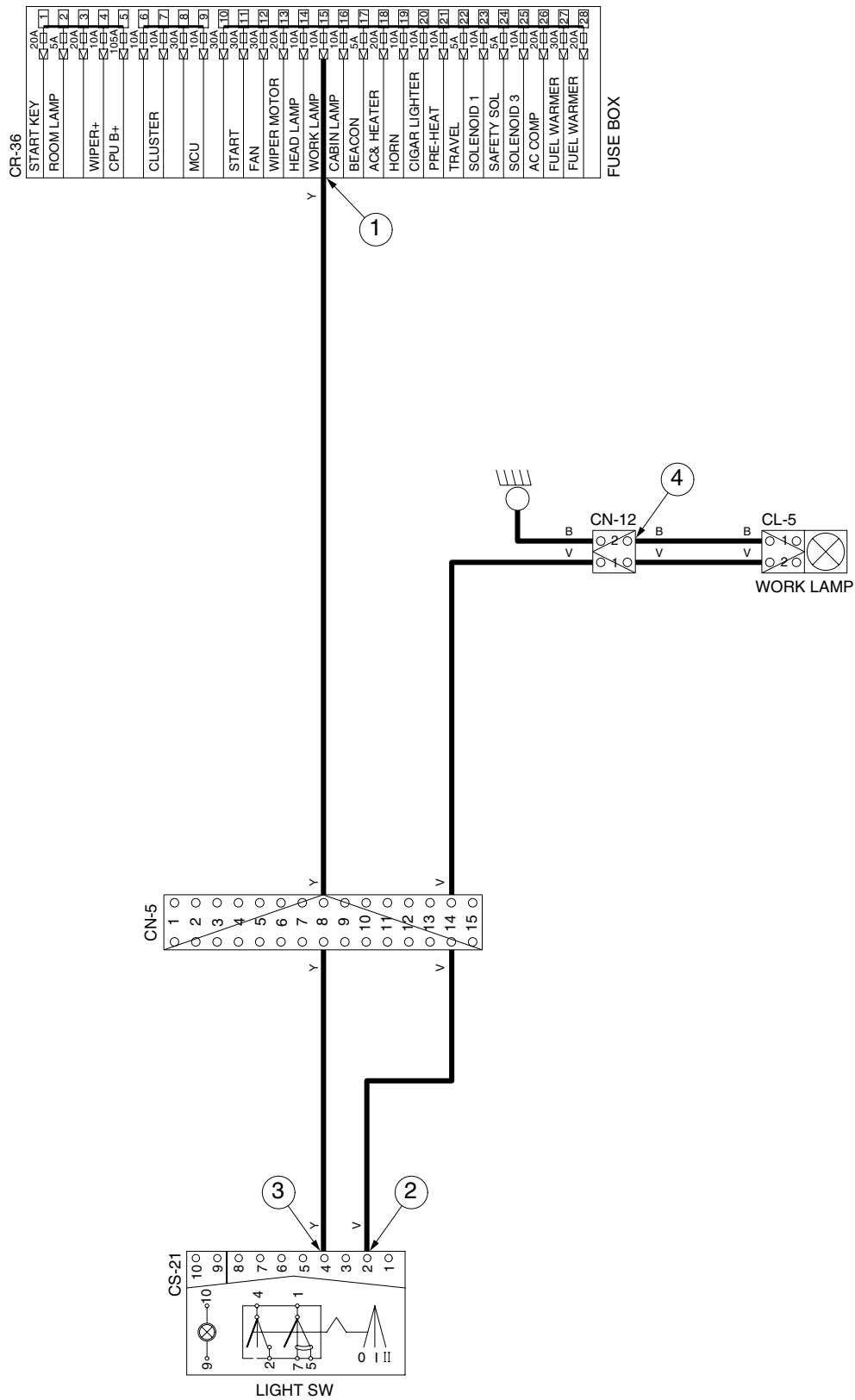
→ Work lamp ON [CL-5(2)]

2) CHECK POINT

| Engine | Start switch | Check point | Voltage |
|--------|--------------|--|---------|
| STOP | ON | ① - GND (Fuse box) ② - GND (Switch power input) ③ - GND (Switch power output) ④ - GND (Work lamp) | 20~25V |

※ GND : Ground

WORK LAMP CIRCUIT



6. CAB LAMP CIRCUIT

1) OPERATING FLOW

Fuse box (No.16) → I/conn [CN-6(3)] → Cabin lamp switch[CS-24(6)]

※ When Lamp switch ON

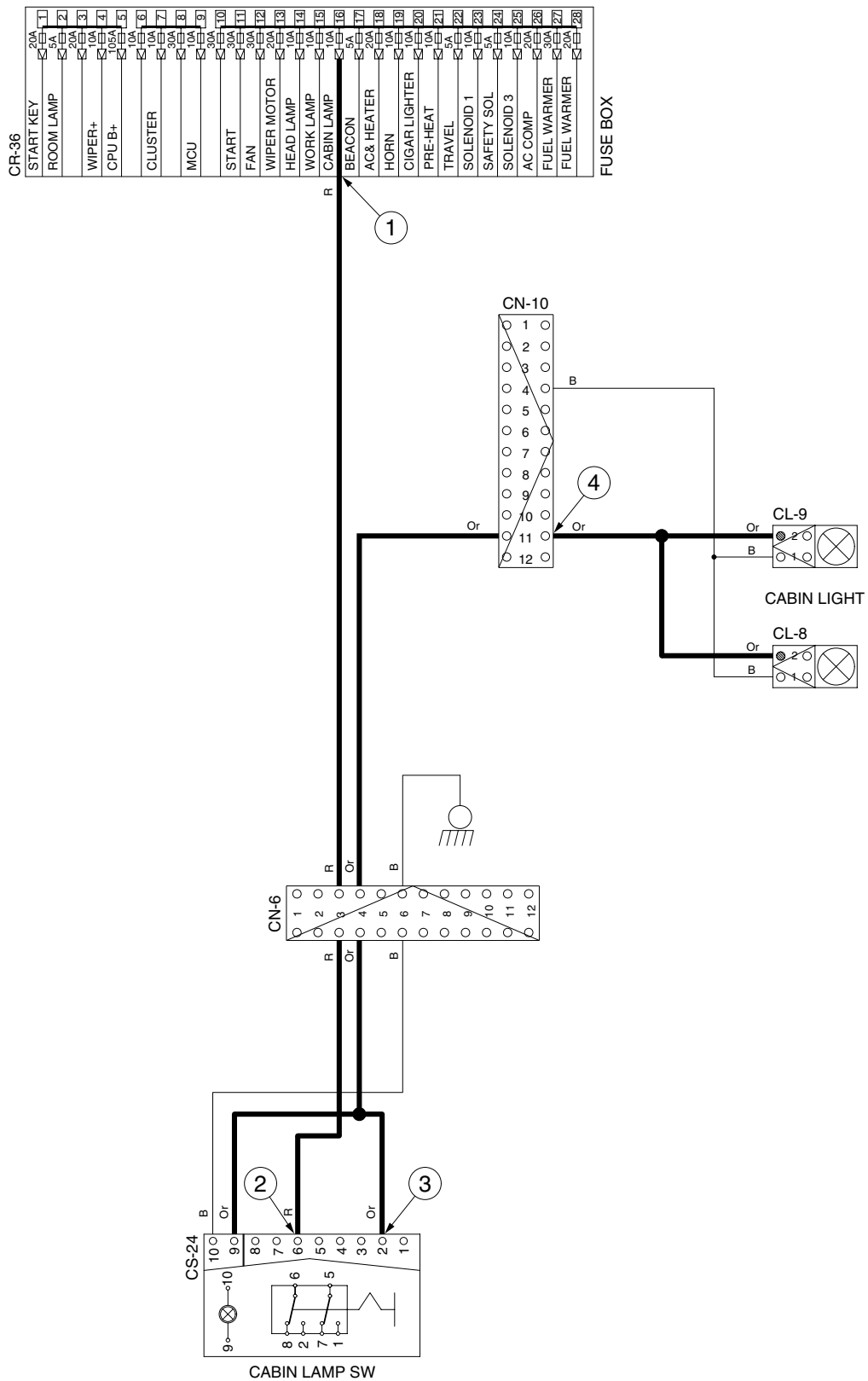
Lamp switch ON [CS-24(2)] → Switch indicator lamp ON [CS-24(9)]
→ I/conn [CN-6(4)] → I/conn [CN-10(11)] → Cab light ON [CL-8(2), CL-9(2)]

2) CHECK POINT

| Engine | Start switch | Check point | Voltage |
|--------|--------------|---|----------|
| STOP | ON | ① - GND (Fuse box) ② - GND (Switch power input) ③ - GND (Switch power output) ④ - GND (Cab lamp) | 20 ~ 25V |

※ GND : Ground

CAB LAMP CIRCUIT



7. BEACON LAMP CIRCUIT

1) OPERATING FLOW

Fuse box (No.17) → I/conn [CN-8(3)] → Beacon lamp switch [CS-23(6)]

※ When beacom lamp switch ON

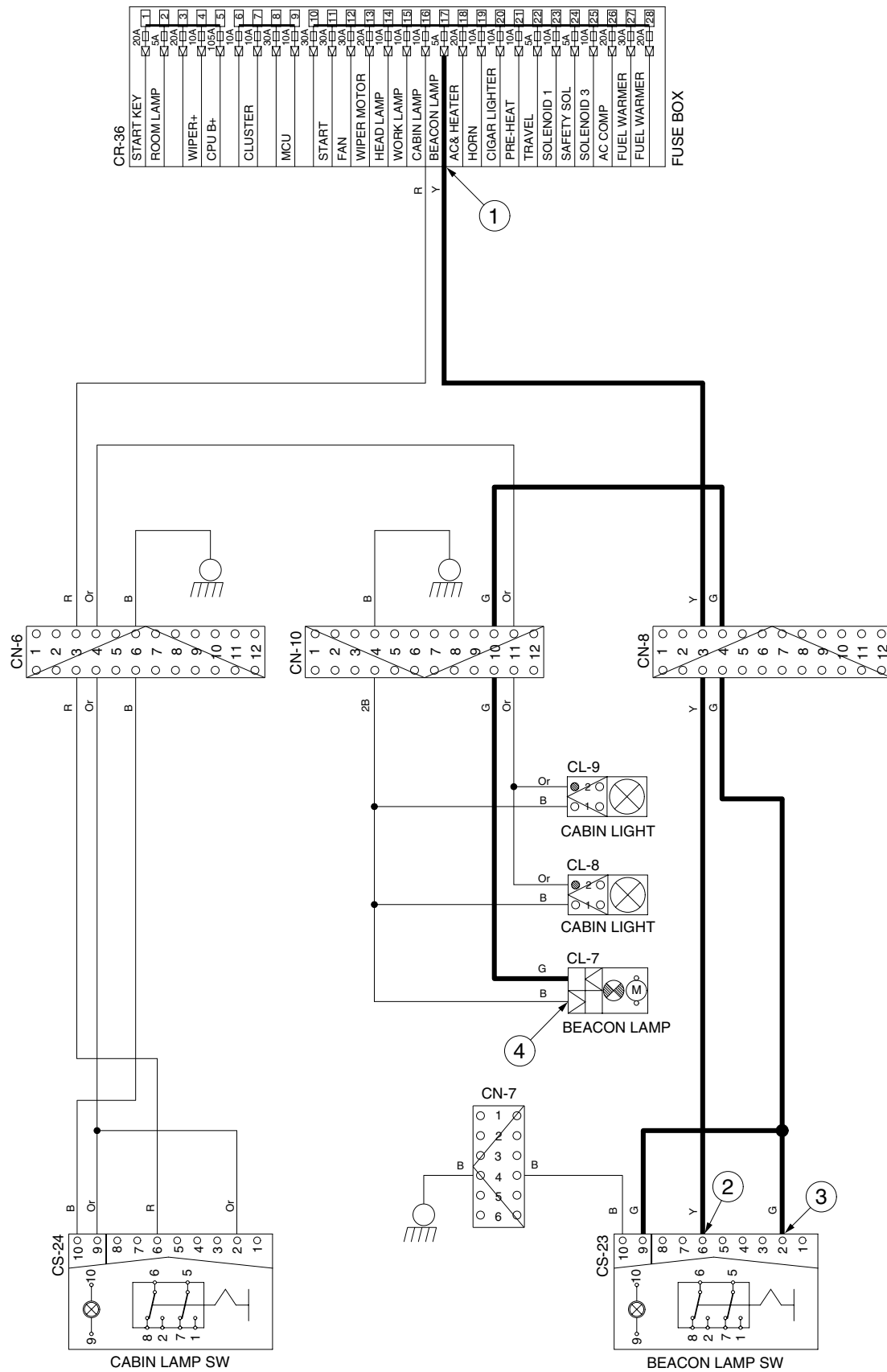
Beacon lamp switch ON [CS-23(2)]
→ Switch Indicator lamp ON [CS-23(9)]
→ I/conn [CN-8(4)] → I/conn [CN-10(10)]
→ Beacon lamp ON [CL-7]

2) CHECK POINT

| Engine | Start switch | Check point | Voltage |
|--------|--------------|--|---------|
| STOP | ON | ① - GND(Fuse box) ② - GND(Switch power input) ③ - GND(Switch power output) ④ - GND(Beacon lamp) | 20~25V |

※ GND : Ground

BEACON LAMP CIRCUIT



2107V4EC10

8. WIPER AND WASHER CIRCUIT

1) OPERATING FLOW

(1) Key switch ON

Fuse box (No.4) → I/conn [CN-5(4)] → I/conn [CN-17(5)] → Wiper motor controller [CN-141(7)]
→ Wiper motor [CN-21(4)]

Fuse box (No.13) → I/conn [CN-6(5)] → I/conn [CN-17(4)] → Wiper motor controller [CN-141(6)]
→ Washer pump [CN-22(2)]

(2) Wiper switch ON : 1st step

Wiper switch ON [CS-3(6)] → I/conn [CN-7(1)] → I/conn [CN-6(9)] → I/conn [CN-17(2)] →
Wiper motor controller [CN-141(2) → (4)] → Wiper motor operating [CN-21(2)]

(3) Washer switch ON : 2nd step(washer)

Washer switch ON [CS-3(3)] → I/conn [CN-7(2)] → I/conn [CN-5(1)] → I/conn [CN-17(7)]
→ Wiper motor controller [CN-141(9) → (8)] → I/conn [CN-17(6)] → I/conn [CN-6(11)]
→ Washer pump [CN-22(1)] → Washer operating.

(4) Auto parking(When switch OFF)

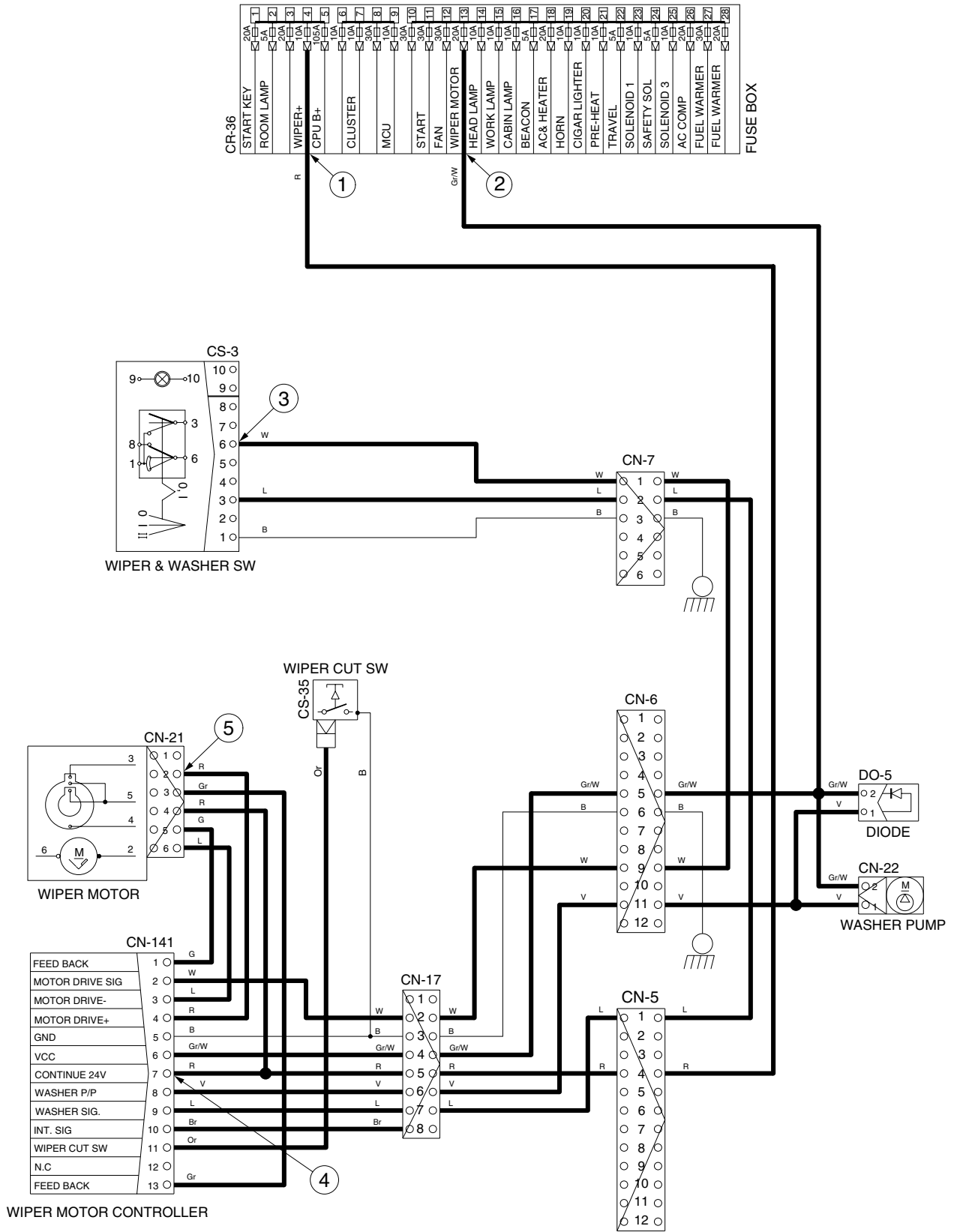
Switch OFF [CS-3(6)] → Wiper motor parking position by wiper motor controller

2) CHECK POINT

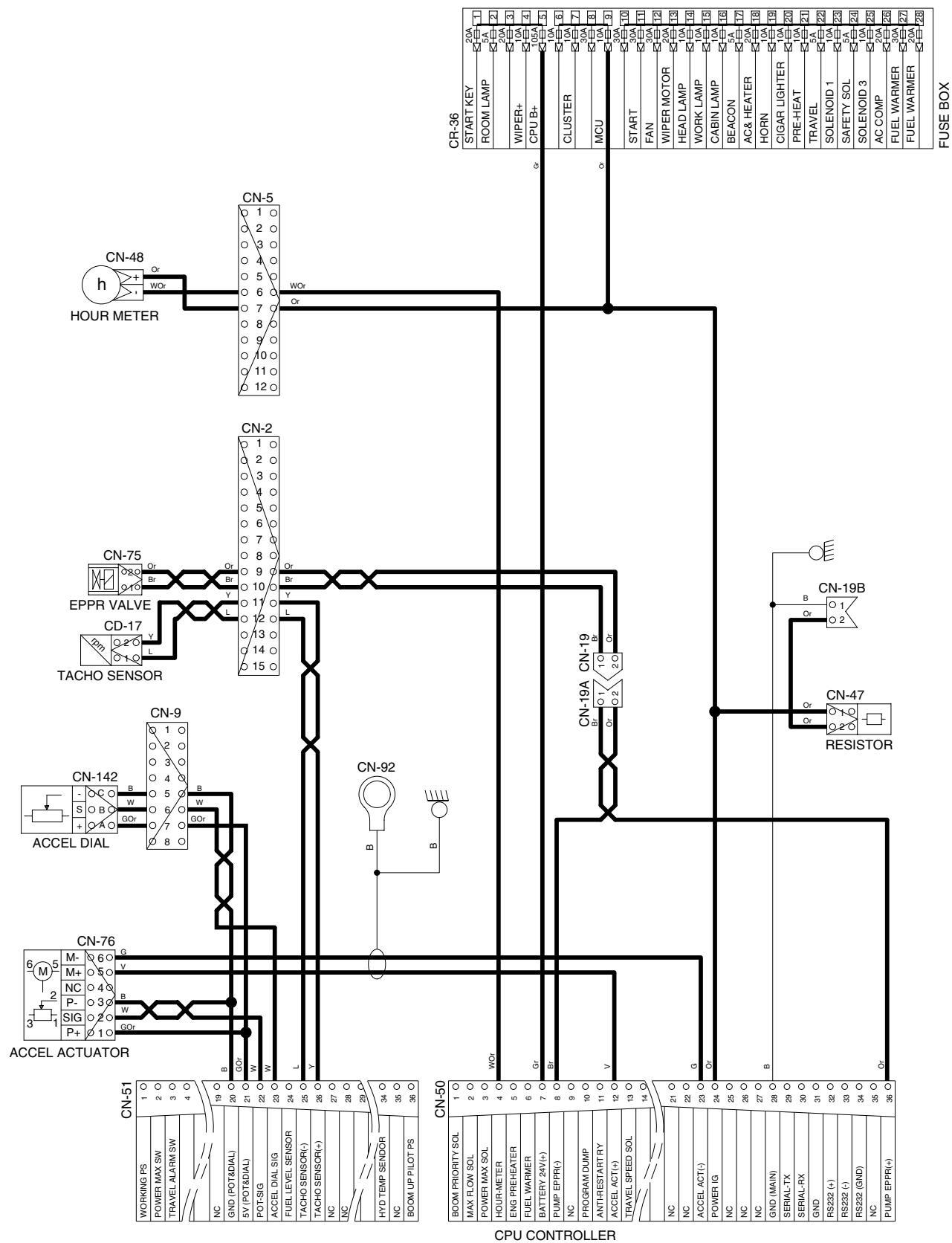
| Engine | Start switch | Check point | Voltage |
|--------|--------------|--|---------|
| STOP | ON | ① - GND(Fuse box) ② - GND(Switch power output) ③ - GND(Wiper Power input) ④ - GND(Wiper power output) ⑤ - GND(Wiper motor) | 20~25V |

※ GND : Ground

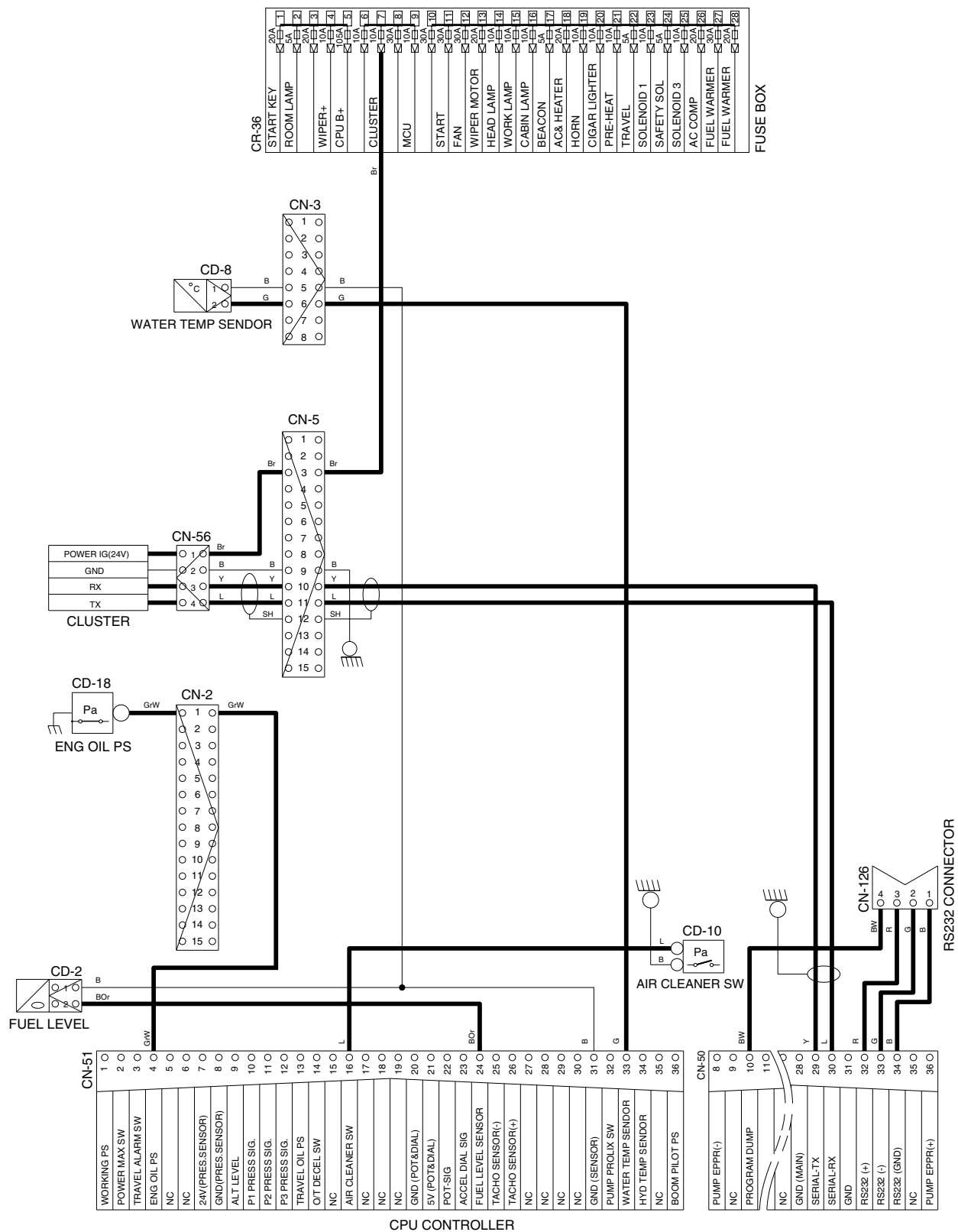
WIPER AND WASHER CIRCUIT



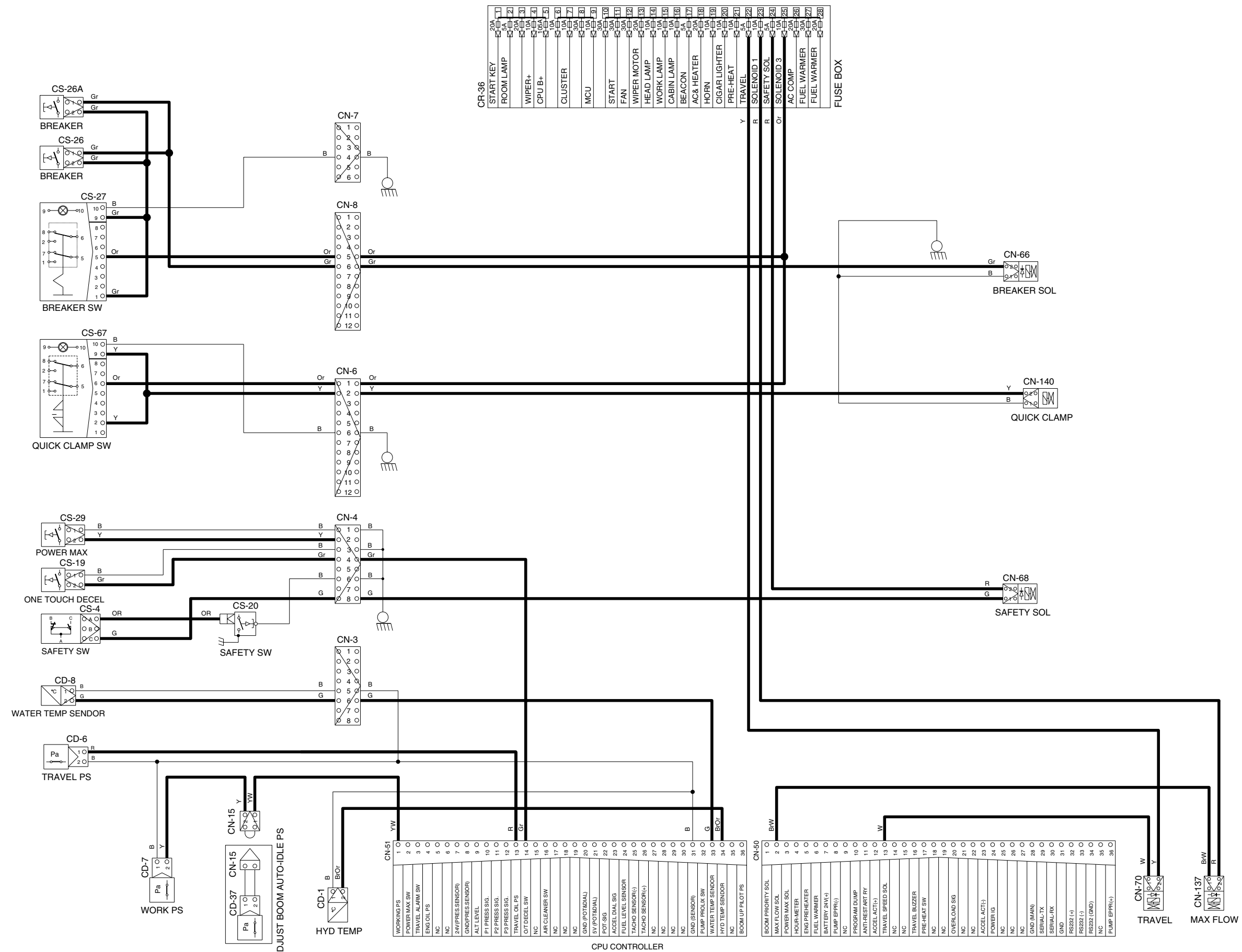
CONTROLLER CIRCUIT



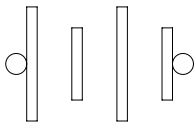
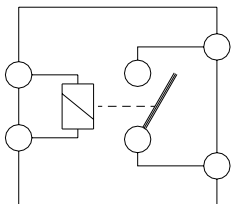
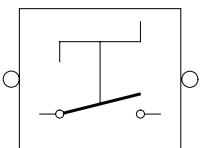
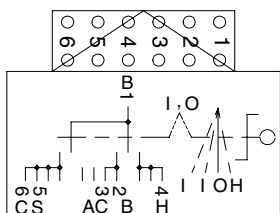
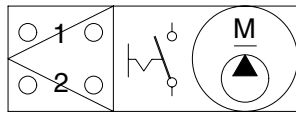
MONITORING CIRCUIT

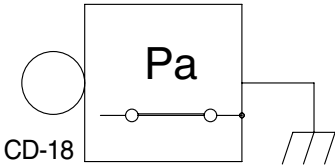
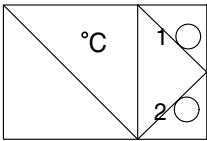
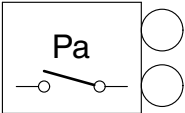
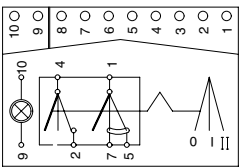
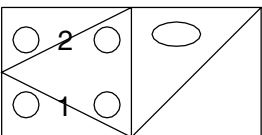
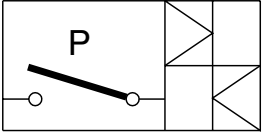


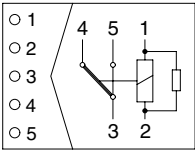
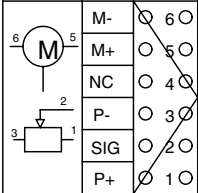
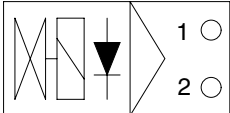
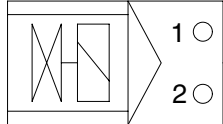
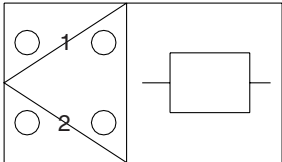
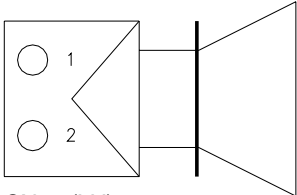
ELECTRIC CIRCUIT FOR HYDRAULIC

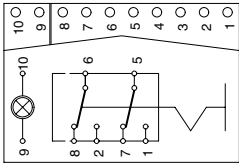
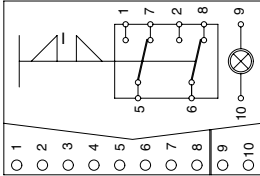
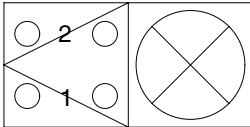
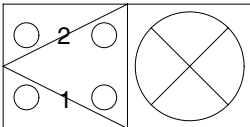
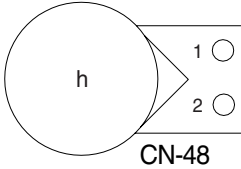
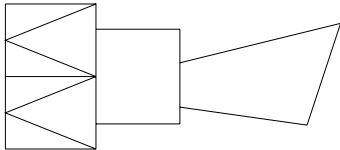


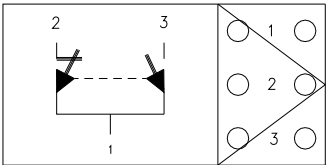
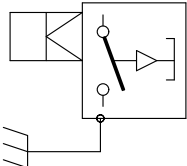
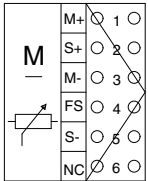
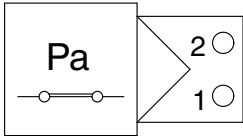
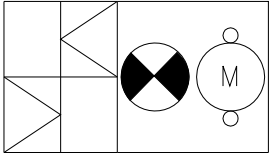
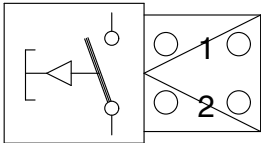
GROUP 3 ELECTRICAL COMPONENT SPECIFICATION

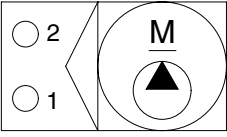
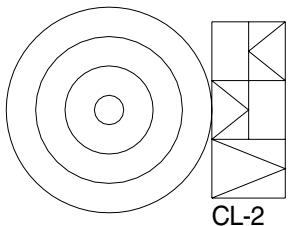
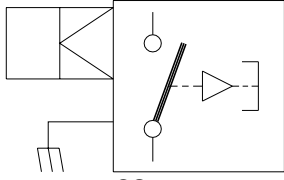
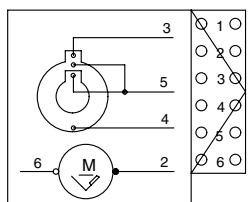
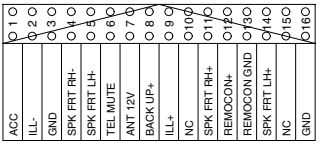
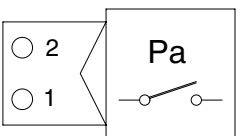
| Part name | Symbol | Specification | Check |
|------------------|--|--|---|
| Battery |  | 12V × 100Ah (2EA) | ※ Check specific gravity 1.280 over : Over charged 1.280 ~ 1.250 : Normal 1.250 below : Recharging |
| Battery relay |  CR-1 | Rated load : 24V 100A(continuity) 1000A(30seconds) | ※ Check coil resistance (M4 to M4) Normal : About 50 Ω ※ Check contact Normal : ∞ Ω |
| Master switch |  CS-74 | 6~36V | ※ Check disconnection Normal : 0.1 Ω |
| Start key |  CS-2 | B-BR : 24V 1A B-ACC : 24V 10A B-ST : 24V 40A | ※ Check contact OFF : ∞ Ω (For each terminal) ON : 0 Ω (For terminal 1-3 and 1-2) START : 0 Ω (For terminal 1-5) |
| Fuel filler pump |  CN-61 | 24V 10A 35 l /min | ※ Check contact Normal : 1.0 Ω |

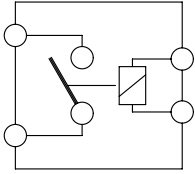
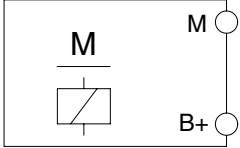
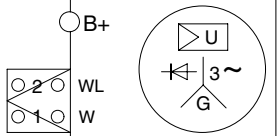
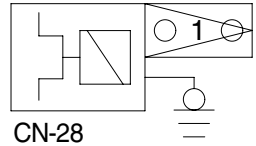
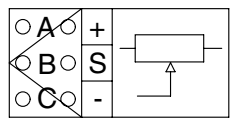
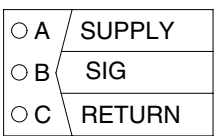
| Part name | Symbol | Specification | Check |
|-----------------------------------|--|--|---|
| Pressure switch (engine oil) |  <p>CD-18</p> | 0.5 kgf/cm ² (N.C TYPE) | ※ Check resistance Normal : 0 Ω (CLOSE) |
| Temperature sensor (hydraulic) |  <p>CD-1</p> | - | ※ Check resistance 50° C : 804 Ω 80° C : 310 Ω 100° C : 180 Ω |
| Air cleaner pressure switch |  <p>CD-10</p> | Pressure: 635mmH ₂ O (N.O TYPE) | ※ Check contact Normal : ∞ Ω |
| Switch (locking type) |  <p>CS-21</p> | 24V 8A | ※ Check contact ON : 0 Ω (For terminal 1-5, 2-4) OFF : ∞ Ω (For terminal 1-5, 2-4) |
| Fuel level sender |  <p>CD-2</p> | - | ※ Check resistance Full : 50 Ω 6/12 : 350 Ω 11/12 : 100 Ω 5/12 : 400 Ω 10/12 : 150 Ω 4/12 : 450 Ω 9/12 : 200 Ω 3/12 : 500 Ω 8/12 : 250 Ω 2/12 : 550 Ω 7/12 : 300 Ω 1/12 : 600 Ω Empty warning : 700 Ω |
| Tacho sensor |  <p>CD-17</p> | - | ※ Check resistance Normal : 300 Ω (For terminal 1,2) |

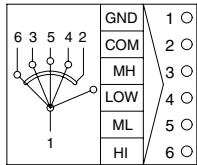
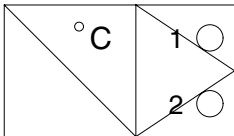
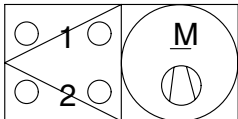
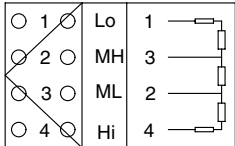
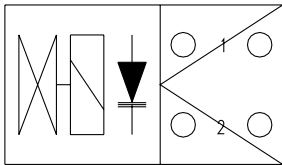
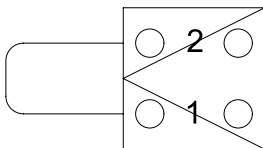
| Part name | Symbol | Specification | Check |
|--|--|---------------|---|
| Relay (Horn, Safety, Ac comp, Power, Preheat, Fuel warmer) |  CR-2 CR-5 CR-7 CR-35 CR-36 CR-46 | 24V 16A0 | ※ Check resistance Normal : About 160 Ω (For terminal 85-86) : 0 Ω (For terminal 30-87a) : ∞ Ω (For terminal 30-87) |
| Accel actuator |  CN-76 | - | ※ Check resistance Normal : 1-2 Ω (For terminal 5-6) 0.8-1.2kΩ (For terminal 1-3) |
| Solenoid valve |  CN-66 CN-68 CN-70 CN-137 | 24V 1A | ※ Check resistance Normal : 15~25 Ω (For terminal 1-2) |
| EPPR valve |  CN-75 | 700mA | ※ Check resistance Normal : 18~25 Ω (For terminal 1-2) |
| Resistor |  CN-47 | 50 Ω 20W± 5% | ※ Check resistance Normal : 50 Ω |
| Speaker |  CN-23(LH) CN-24(RH) | 4 Ω 20W | ※ Check resistance Normal : 4 Ω |

| Part name | Symbol | Specification | Check |
|--------------------------------------|---|-----------------------|--|
| Switch (locking type) |  <p>CS-23 CS-24 CS-27 CS-54 CS-99 CS-101</p> | 24V 8A | ※ Check contact Normal ON - 0 Ω (For terminal 1-5,2-6) - ∞ Ω (For terminal 5-7,6-8) OFF - ∞ Ω (For terminal 1-5,2-6) - 0 Ω (For terminal 5-7,6-8) |
| Switch (quick clamp) |  <p>CS-67</p> | 24V 8A | ※ Check contact Normal ON - 0 Ω (For terminal 1-5,2-6) - ∞ Ω (For terminal 5-7,6-8) OFF - ∞ Ω (For terminal 1-5,2-6) - 0 Ω (For terminal 5-7,6-8) |
| Head lamp, Work lamp, Cab lamp |  <p>CL-4 CL-5 CL-8 CL-9</p> | 24V 70W (H3 TYPE) | ※ Check disconnection Normal : 1.2 Ω |
| Room lamp |  <p>CL-1</p> | 24V 10W | ※ Check disconnection Normal : A few Ω |
| Hour meter |  <p>CN-48</p> | 16V ~ 32V | ※ Check operation · Supply power(24V) to terminal No. 2 and connect terminal No. 1 and ground. |
| Horn |  <p>CN-20 CN-25</p> | DC 22.0 ~ 28.0V 2A | ※ Check operation · Supply power(24V) to each terminal and connect ground. |

| Part name | Symbol | Specification | Check |
|--|--|-----------------------|--|
| Safety switch 1 |  <p>CS-4</p> | 24V 15A (N.C TYPE) | ※ Check contact Normal : 0 Ω (For terminal 1-2) : ∞ Ω (For terminal 1-3) Operating : ∞ Ω (For terminal 1-2) : 0 Ω (For terminal 1-3) |
| Safety switch 2 Wiper cut sw |  <p>CS-20 CS-53</p> | 24V (N.C TYPE) | ※ Check contact Normal : 0 Ω (one pin to ground) |
| Temp actuator |  | 9~16V 300mA max | - |
| Pressure switch (travel, work, adjust boom auto idle) |  <p>CD-6 CD-7 CD-37</p> | 10bar (N.C type) | ※ Check contact Normal : 0.1 Ω |
| Beacon lamp |  <p>CL-7</p> | 24V 70W | ※ Check disconnection Normal : 1.1 Ω |
| Switch (power max, one touch decel, breaker, horn) |  <p>CS-5 CS-19 CS-26 CS-26A CS-29</p> | 24V 6A | ※ Check contact Normal : ∞ Ω |

| Part name | Symbol | Specification | Check |
|----------------|--|---------------|--|
| Washer tank |  <p>CN-22</p> | 24V 3.8A | ※ Check contact Normal : 10.7 Ω (For terminal 1-2) |
| Cigar lighter |  <p>CL-2</p> | 24V 5A 1.4W | ※ Check coil resistance Normal : About 1MΩ ※ Check contact Normal : ∞ Ω Operating time : 5~15sec |
| Door switch |  <p>CS-1</p> | 24V 2W | ※ Check resistance Normal : About 5MΩ |
| Wiper motor |  <p>CN-21</p> | 24V 2A | ※ Check contact Normal : 7 Ω (For terminal 2-6) |
| Cassette radio |  <p>CN-27</p> | 24V 2A | ※ Check voltage 20 ~ 25V (For terminal 10-14,11-14) |
| Receiver dryer |  <p>CN-29</p> | 24V 2.5A | ※ Check contact Normal : 0 Ω |

| Part name | Symbol | Specification | Check |
|---|--|---------------------|--|
| Start relay |  CR-23 | 24V 300A | ※ Check contact Normal : 0.94 Ω (For terminal 1-2) |
| Starter |  CN-45 | Lucas 4.5KW, 24V | ※ Check contact Normal : 0.1 Ω |
| Alternator |  CN-74 | 24V 55A | ※ Check contact Normal : 0 Ω (For terminal B Ⓟ1) Normal : 24 ~ 27.5V |
| Aircon compressor |  CN-28 | 24V 79W | ※ Check contact Normal : 13.4 Ω |
| Accel dial switch |  CN-142 | - | ※ Check resistance Normal : About 5kΩ (For terminal A-C) ※ Check voltage Normal : About 5V (For terminal A-C) : 2 ~ 4.5V (For terminal C-B) |
| Pressure sensor (boom up, EPPR valve) |  CD-32 CD-44 | 8~30V | ※ Check contact Normal : 0.1 Ω |

| Part name | Symbol | Specification | Check |
|------------------------------|--|---------------|---|
| Blower switch |  <p>CS-58</p> | - | ※ Check resistance Low : 0 Ω (For terminal 1-4) ML : 0 Ω (For terminal 1-5) MH : 0 Ω (For terminal 1-3) MI : 0 Ω (For terminal 1-6) COM : 0 Ω (For terminal 1-2) |
| Temperature sensor (coolant) |  <p>CD-08</p> | - | ※ Check resistance 50°C : 800 Ω 80°C : 310 Ω 100°C : 180 Ω |
| Blower motor |  | 24V 9.5A | ※ Check resistance 2.5 Ω (For terminal 1-2) |
| Aircon resistor |  | - | ※ Check resistance 1.12 Ω (For terminal 4-2) 2.07 Ω (For terminal 2-3) 3.17 Ω (For terminal 3-1) |
| Quick clamp |  <p>CN-140</p> | 24V 6A | ※ Check contact Normal : 28.9MΩ (For terminal 1-2) |
| Fusible link |  <p>CN-60 CN-95</p> | 60A | ※ Check disconnection Normal : 0 Ω (Connect ring terminal and check resist between terminal 1 and 2) |

GROUP 4 CONNECTORS

1. CONNECTOR DESTINATION

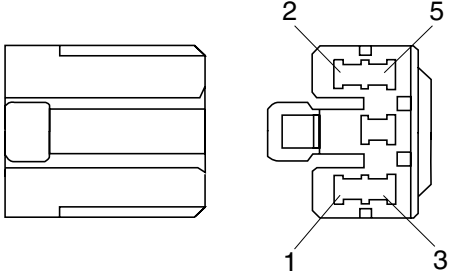
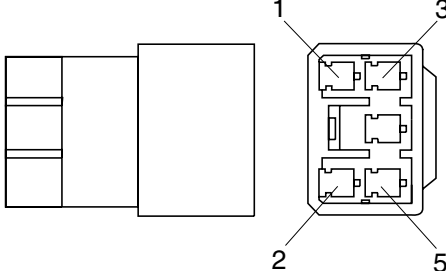
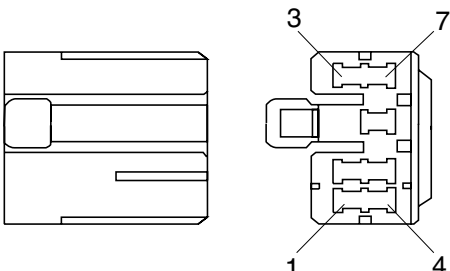
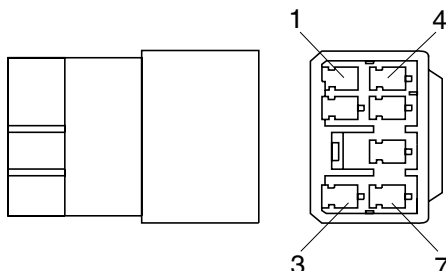
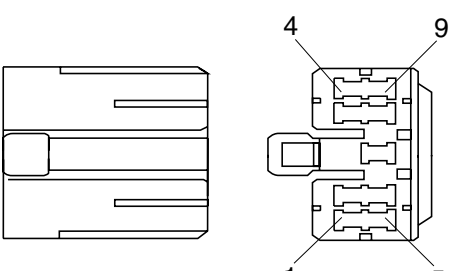
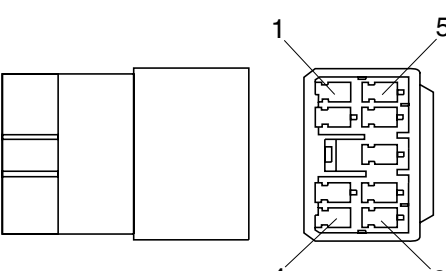
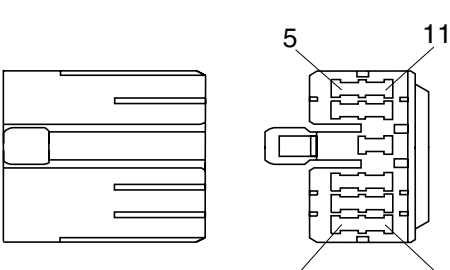
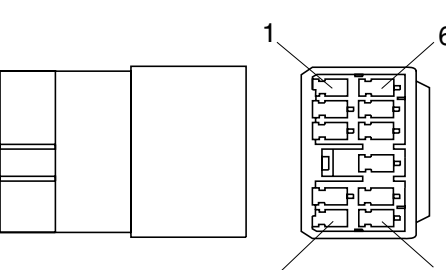
| Connector number | Type | No. of pin | Destination | Connector part No. | |
|------------------|-------------|------------|--------------------------------|--------------------|--------------|
| | | | | Female | Male |
| CN-2 | AMP | 15 | Engine rear harness | 2-85262-1 | 368301-1 |
| CN-3 | AMP | 8 | Engine harness | S816-008002 | S816-108002 |
| CN-4 | AMP | 8 | Cabin LH wire harness | S816-008002 | S816-108002 |
| CN-5 | AMP | 15 | RH side harness | 2-85262-1 | - |
| CN-6 | AMP | 12 | RH side harness | S816-012002 | S816-112002 |
| CN-7 | AMP | 6 | Cabin RH console harness | S816-006002 | S816-106002 |
| CN-8 | AMP | 12 | Cabin RH console harness | S816-012002 | S816-112002 |
| CN-9 | AMP | 8 | Cabin RH console harness | S816-008002 | S816-108002 |
| CN-10 | DEUTSCH | 12 | Frame harness | DT06-12S | DT04-12P |
| CN-11 | DEUTSCH | 8 | Aircon harness | DT06-8S | DT04-08P |
| CN-12 | DEUTSCH | 2 | Work lamp harness | DT06-2S | DT04-2P-E005 |
| CN-15 | KET | 2 | Adjust boom auto idle pressure | S814-002100 | S814-102100 |
| CN-17 | DEUTSCH | 8 | Wiper harness | DT06-8S | DT04-8P |
| CN-20 | MOLEX | 2 | Horn | 35215-0200 | - |
| CN-21 | AMP | 6 | Wiper motor | 925276-0 | - |
| CN-22 | KET | 2 | Washer tank | MG640605 | - |
| CN-23 | KET | 2 | LH speaker | MG610070 | - |
| CN-24 | KET | 2 | RH speaker | MG610070 | - |
| CN-25 | MOLEX | 2 | Horn | 35215-0200 | - |
| CN-27 | AMP | 14 | Cassette radio | 173852 | - |
| CN-28 | MWP | 1 | Air-con compressor | NMWP01F-B | - |
| CN-29 | KET | 2 | Receiver dryer | HG640795 | - |
| CN-36 | DEUTSCH | 3 | Fuse box | 21N8-20191 | - |
| CN-45 | RING TERM | - | Start motor B ⁺ | ST710264-2 | - |
| CN-47 | AMP | 2 | Resistor | S810-002202 | S810-102202 |
| CN-48 | AMP | 2 | Hour meter | S810-002202 | - |
| CN-50 | AMP | 36 | CPU controller | 3441110 | - |
| CN-51 | AMP | 36 | CPU controller | 3441110 | - |
| CN-56 | DEUTSCH | 4 | Cluster | - | DT04-4P |
| CN-60 | YAZAKI | 2 | Fusible link | 7123-412S-50 | 7122-412S-50 |
| CN-66 | DEUTSCH | 2 | Breaker solenoid | DT06-2S-EP06 | DT04-2P-E005 |
| CN-68 | DEUTSCH | 2 | Safety solenoid | DT06-2S-EP06 | DT04-2P-E005 |
| CN-70 | DEUTSCH | 2 | Travel speed solenoid | DT06-2S-EP06 | DT04-2P-E005 |
| CN-74 | RING-TERM | 1 | Alternator "1" term | S820-408000 | - |
| CN-75 | Econoseal J | 2 | EPPR valve | S816-002002 | - |
| CN-76 | DEUTSCH | 6 | Accel actuator | DT06-6S | - |
| CN-92 | AMP | 1 | Safety | S814-001100 | S814-101100 |
| CN-95 | KET | 2 | Fusible link | S813-030201 | S813-130200 |

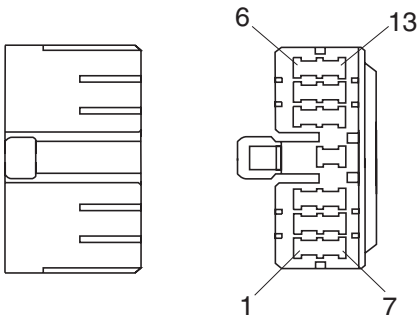
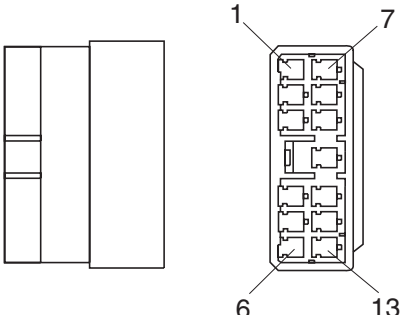
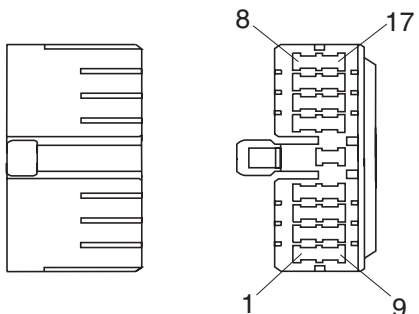
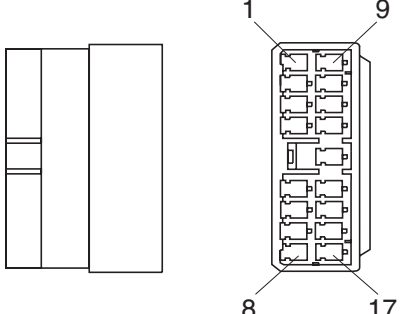
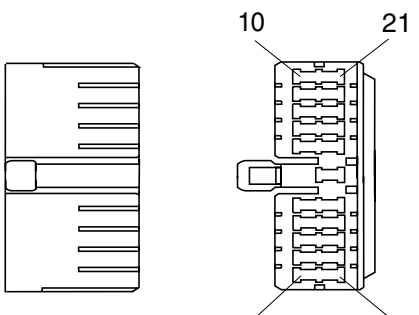
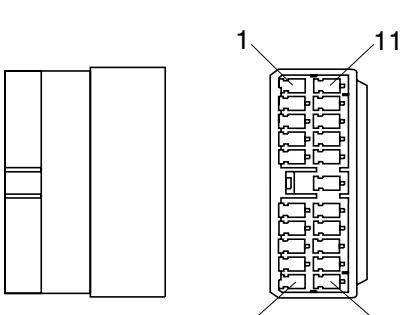
| Connector number | Type | No. of pin | Destination | Connector part No. | |
|------------------|-------------|------------|------------------------------|--------------------|--------------|
| | | | | Female | Male |
| CN-125 | Econoseal J | 4 | GPS connector | S816-004002 | S816-104002 |
| CN-126 | DEUTSCH | 4 | RS232 connector | DT06-4S | DT04-4P-E004 |
| CN-137 | DEUTSCH | 2 | Max flow solenoid valve | DT06-2S-EP06 | DT04-2P-E005 |
| CN-140 | DEUTSCH | 2 | Quick clamp solenoid | DT06-2S-EP06 | DT04-2P-E005 |
| CN-141 | AMP | 13 | Wiper motor control unit | 172498-1 | - |
| CN-142 | DEUTSCH | 3 | Accel dial | DT06-3S | - |
| CN-143 | KET | 14 | Cassette radio(with remocon) | MG610406 | - |
| CN-144 | AMP | 12 | Remocon-cassette radio | 174045-2 | - |
| CN-147 | - | 2 | Fuel heater | 1530-0027 | - |
| CN-248 | - | 2 | Fan | - | S816-102002 |
| RELAY | | | | | |
| CR-1 | RING TERM | 1 | Battery relay | S820-104002 | - |
| CR-2 | - | 5 | Horn relay | - | - |
| CR-5 | - | 5 | Safety relay | - | - |
| CR-7 | - | 5 | Ac comp relay | - | - |
| CR-23 | KET | 2 | Start relay | S814-002001 | S814-102001 |
| CR-35 | - | 5 | Power relay | - | - |
| CR-36 | - | 5 | Pre-heat relay | - | - |
| CR-46 | - | 5 | Fuel warmer relay | - | - |
| SWITCH | | | | | |
| CS-1 | SHUR | 1 | Door switch | S822-014004 | - |
| CS-2 | - | 6 | Start key switch | S814-006000 | S814-106000 |
| CS-3 | SWF | 10 | Wiper switch | SWF593757 | - |
| CS-4 | DEUTSCH | 3 | Safety switch | DT06-3S | DT04-3P |
| CS-5 | DEUTSCH | 2 | Horn switch | DT06-2S | DT04-2P |
| CS-19 | DEUTSCH | 2 | One touch decel | DT06-2S | DT04-2P |
| CS-20 | AMP | 1 | Safety switch | S822-014002 | - |
| CS-21 | SWF | 10 | Lamp switch | SWF593757 | - |
| CS-23 | SWF | 10 | Beacon lamp switch | SWF593757 | - |
| CS-24 | SWF | 10 | Cabin lamp switch | SWF593757 | - |
| CS-26 | DEUTSCH | 2 | Breaker switch | DT06-2S | DT04-2P |
| CS-27 | SWF | 10 | Breaker switch | SWF593757 | - |
| CS-53 | SHUR | 1 | Wiper cut switch | S822-014002 | - |
| CS-54 | SWF | 10 | Aircon switch | SWF593757 | - |
| CS-58 | AMP | 6 | Blower switch | S810-006202 | - |
| CS-67 | SWF | 10 | Quick clamp switch | SWF593757 | - |
| CS-74 | AMP | 2 | Master switch | S813-030201 | - |
| CS-99 | SWF | 10 | Spare switch | SWF593757 | - |
| CS-101 | SWF | 10 | Fan switch | SWF593757 | - |

| Connector number | Type | No. of pin | Destination | Connector part No. | |
|------------------|-------------|------------|---------------------------------------|--------------------|-------------|
| | | | | Female | Male |
| LAMP | | | | | |
| CL-1 | KET | 2 | Cabin room lamp | MG610406 | - |
| CL-2 | AMP | 1 | Cigar lighter | S822-014002 | - |
| CL-4 | DEUTSCH | 2 | Head lamp | DT06-2S | DT04-2P |
| CL-5 | DEUTSCH | 2 | Work lamp | DT06-2S | DT04-2P |
| CL-7 | SHUR | 1 | Beacon lamp | S822-014004 | S822-114004 |
| CL-8 | DEUTSCH | 2 | Cabin light-LH | DT06-2S | DT04-2P |
| CL-9 | DEUTSCH | 2 | Cabin light-RH | DT06-2S | DT04-2P |
| SENDER | | | | | |
| CD-1 | AMP | 2 | Hydraulic oil temp sender | 85202-1 | - |
| CD-2 | DEUTSCH | 2 | Fuel level sender | DT06-2S | DT04-2P |
| CD-6 | KET | 3 | Travel pressure switch | MG640795 | - |
| CD-7 | KET | 3 | Working pressure switch | MG640795 | - |
| CD-8 | AMP | 2 | Water temp sender | 85202-1 | - |
| CD-10 | RING TERM | 1 | Air cleaner pressure switch | S820-104002 | - |
| CD-17 | - | 2 | Tacho sensor | - | S818-120221 |
| CD-18 | RING TERM | 1 | Engine oil pressure switch | S820-104000 | - |
| CD-32 | Econoseal J | 3 | Boom up sensor | S816-003002 | S816-103002 |
| CD-37 | KET | 3 | Adjust boom auto idle pressure switch | MG640795 | - |
| CD-44 | Econoseal J | 3 | Pump pressure 3 | S816-003002 | S816-103002 |
| DIODE | | | | | |
| DO-1 | AMP | 2 | - | 21EA-50550 | - |
| DO-2 | AMP | 2 | - | 21EA-50550 | - |
| DO-5 | AMP | 2 | - | 21EA-50550 | - |

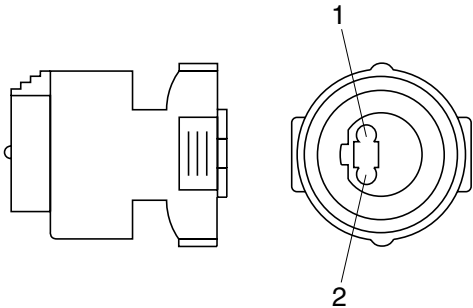
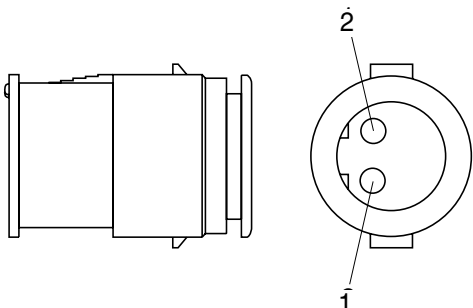
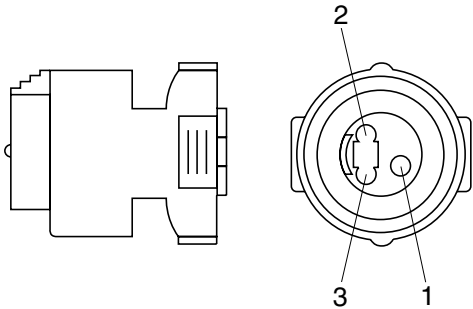
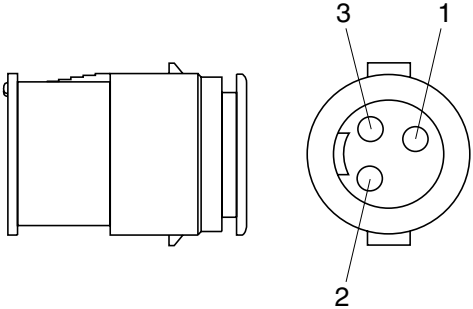
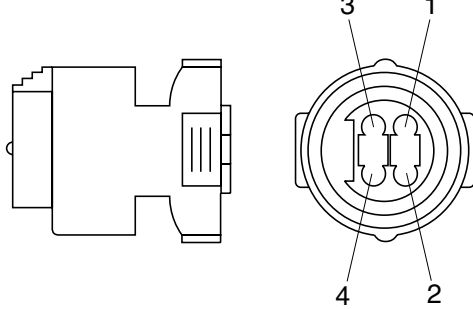
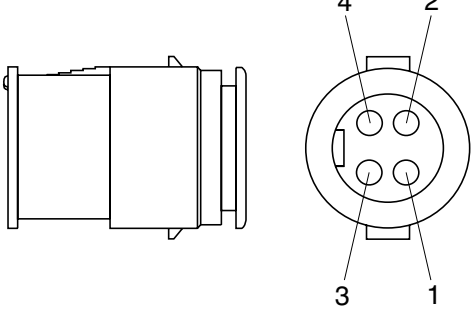
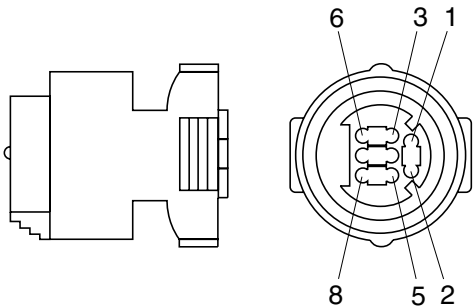
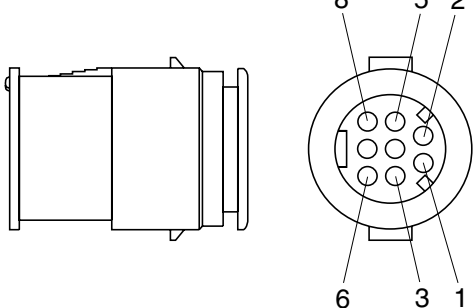
2. CONNECTION TABLE FOR CONNECTORS

1) PA TYPE CONNECTOR

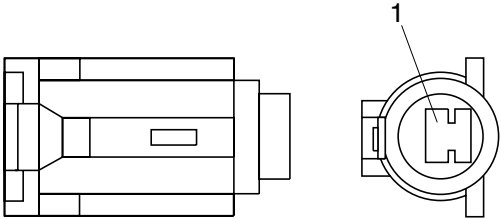
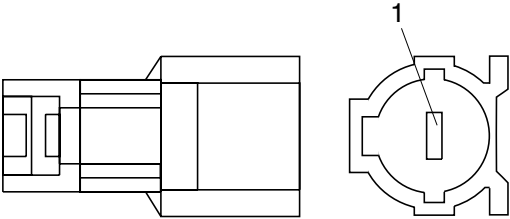
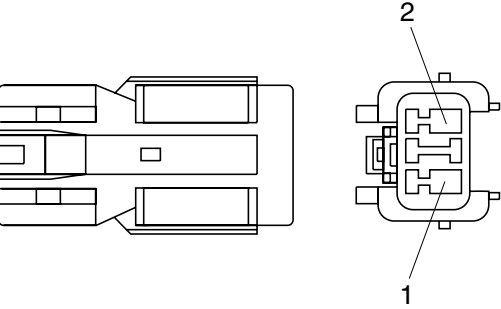
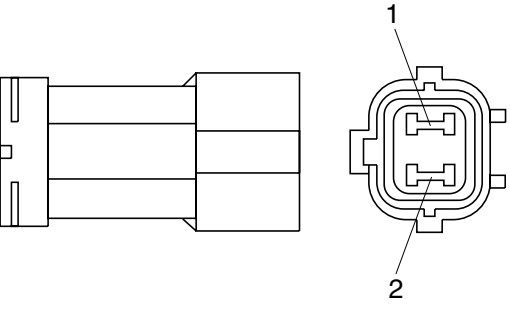
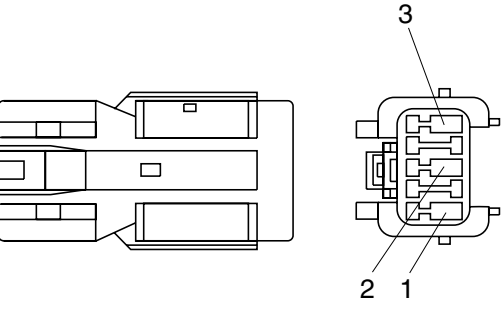
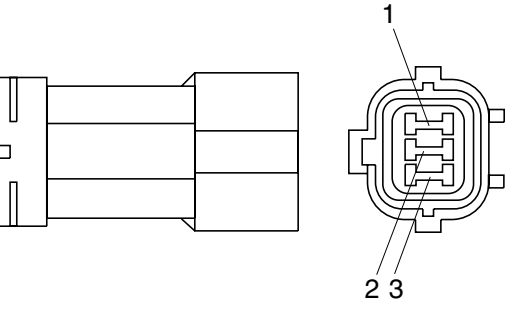
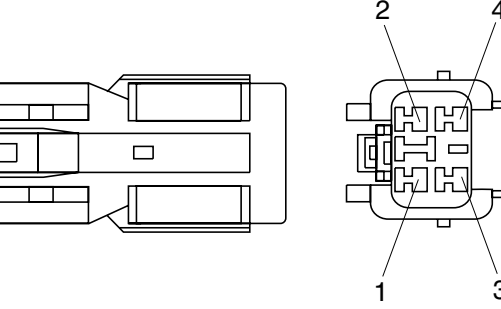
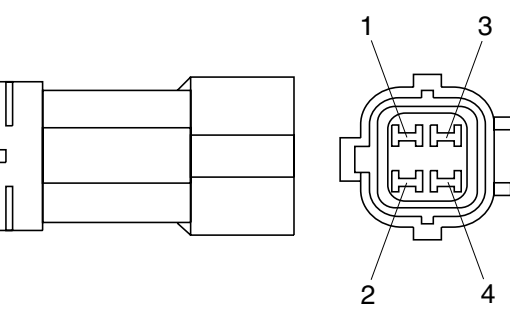
| No. of pin | Receptacle connector(Female) | Plug connector(Male) |
|------------|--|--|
| 5 |  <p>S811-005002</p> |  <p>S811-105002</p> |
| 7 |  <p>S811-007002</p> |  <p>S811-107002</p> |
| 9 |  <p>S811-009002</p> |  <p>3S811-109002</p> |
| 11 |  <p>S811-011002</p> |  <p>S811-111002</p> |

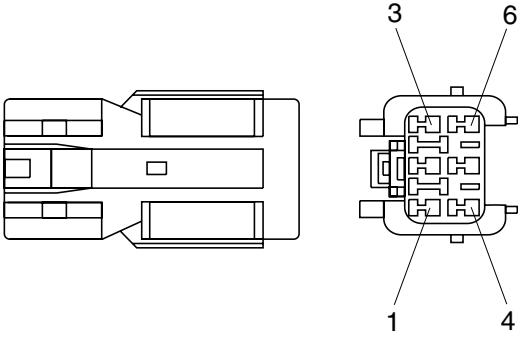
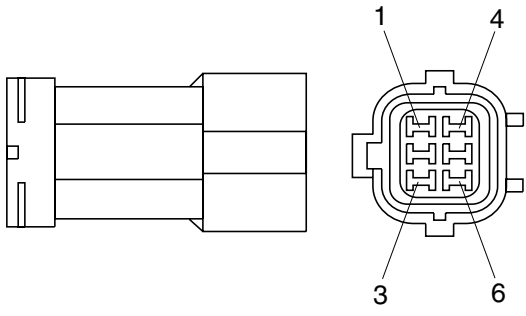
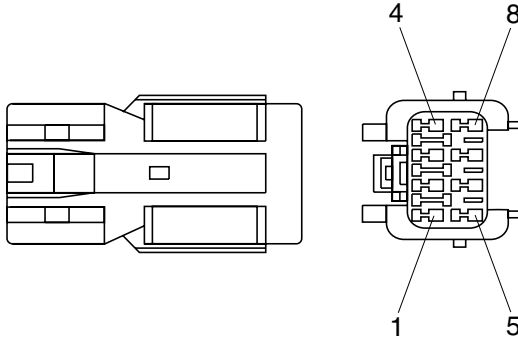
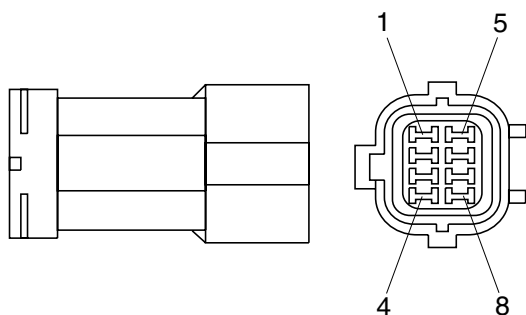
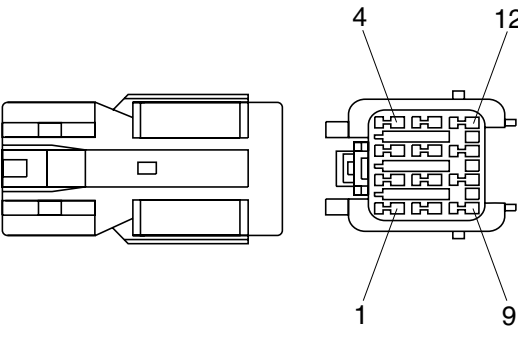
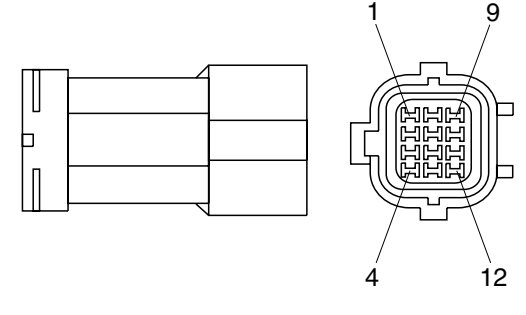
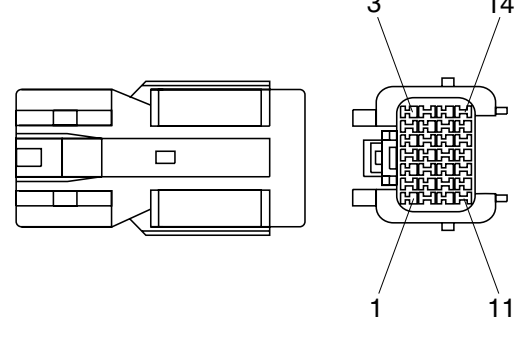
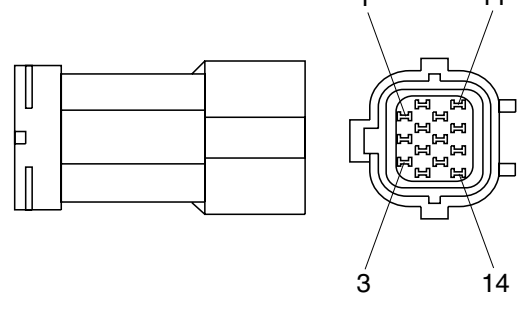
| No. of pin | Receptacle connector(Female) | Plug connector(Male) |
|------------|--|---|
| 13 |  <p>S811-013002</p> |  <p>S811-113002</p> |
| 17 |  <p>S811-017002</p> |  <p>S811-117002</p> |
| 21 |  <p>S811-021002</p> |  <p>S811-121002</p> |
| | | |

2) J TYPE CONNECTOR

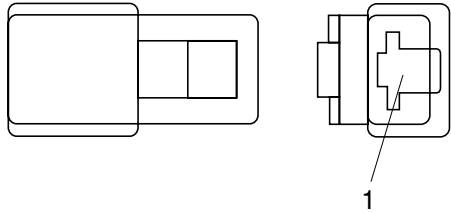
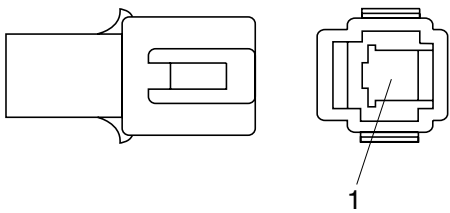
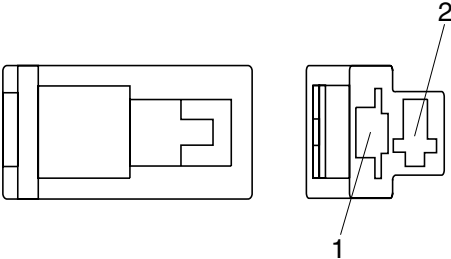
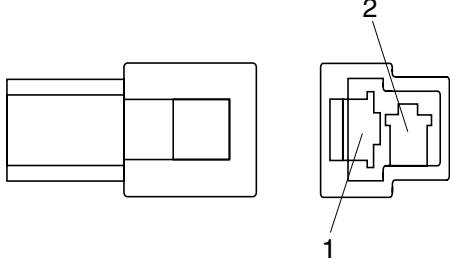
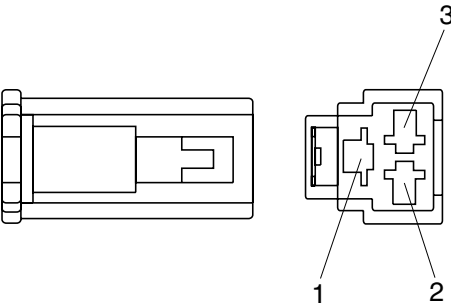
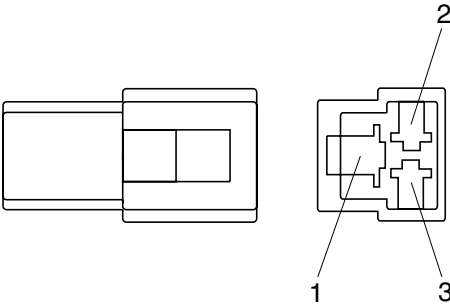
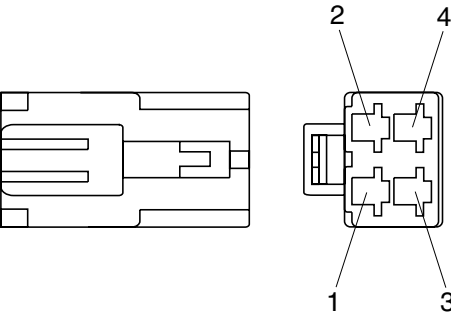
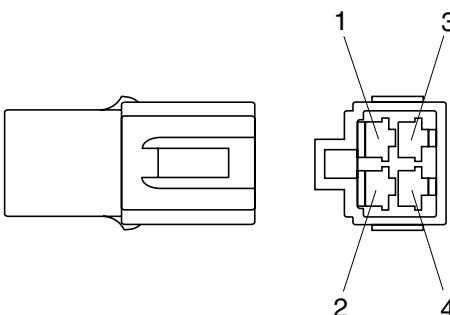
| No. of pin | Receptacle connector(Female) | Plug connector(Male) |
|------------|--|---|
| 2 |  <p>S816-002001</p> |  <p>S816-102001</p> |
| 3 |  <p>S816-003001</p> |  <p>S816-103001</p> |
| 4 |  <p>S816-004001</p> |  <p>S816-104001</p> |
| 8 |  <p>S816-008001</p> |  <p>S816-108001</p> |

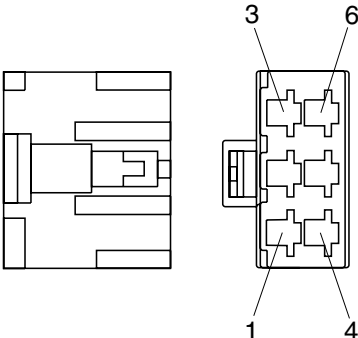
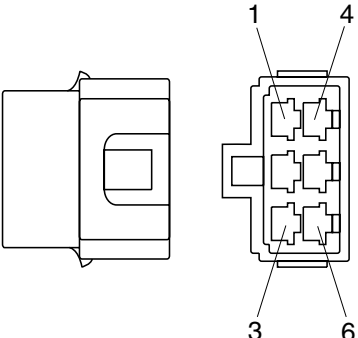
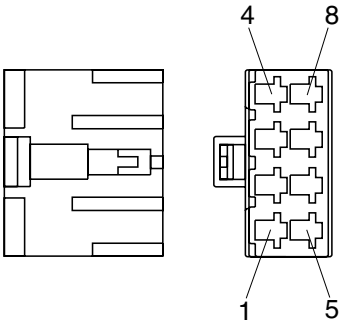
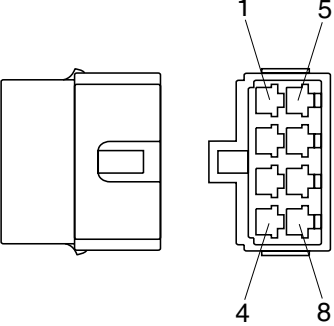
3) SWP TYPE CONNECTOR

| No. of pin | Receptacle connector(Female) | Plug connector(Male) |
|------------|--|---|
| 1 |  <p>S814-001000</p> |  <p>S814-101000</p> |
| 2 |  <p>S814-002000</p> |  <p>S814-102000</p> |
| 3 |  <p>S814-003000</p> |  <p>S814-103000</p> |
| 4 |  <p>S814-004000</p> |  <p>S814-104000</p> |

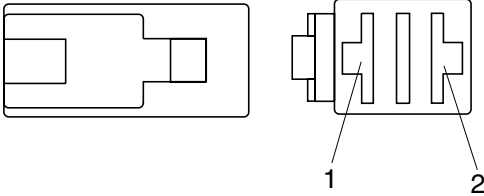
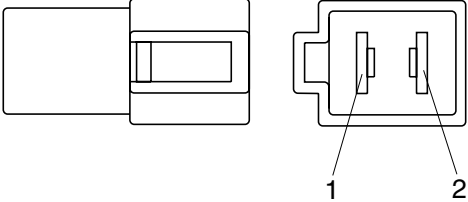
| No. of pin | Receptacle connector(Female) | Plug connector(Male) |
|------------|--|---|
| 6 |  <p>S814-006000</p> |  <p>S814-106000</p> |
| 8 |  <p>S814-008000</p> |  <p>S814-108000</p> |
| 12 |  <p>S814-012000</p> |  <p>S814-112000</p> |
| 14 |  <p>S814-014000</p> |  <p>S814-114000</p> |

4) CN TYPE CONNECTOR

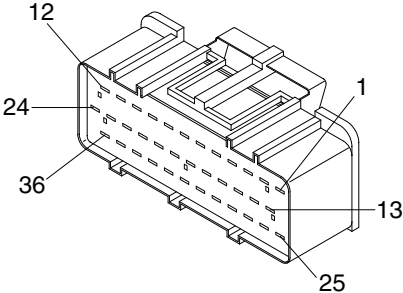
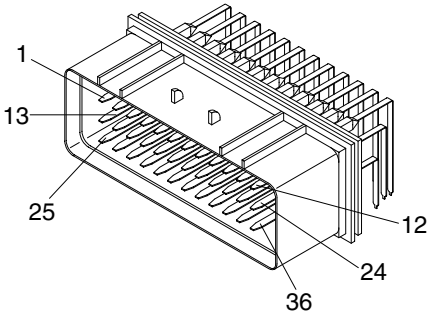
| No. of pin | Receptacle connector(Female) | Plug connector(Male) |
|------------|--|---|
| 1 |  <p>S810-001202</p> |  <p>S810-101202</p> |
| 2 |  <p>S810-002202</p> |  <p>S810-102202</p> |
| 3 |  <p>S810-003202</p> |  <p>S810-103202</p> |
| 4 |  <p>S810-004202</p> |  <p>S810-104202</p> |

| No. of pin | Receptacle connector(Female) | Plug connector(Male) |
|------------|---|--|
| 6 |  S810-006202 |  S810-106202 |
| 8 |  S810-008202 |  S810-108202 |
| | | |
| | | |

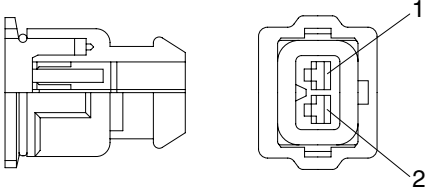
5) 375 FASTEN TYPE CONNECTOR

| No. of pin | Receptacle connector(Female) | Plug connector(Male) |
|------------|---|--|
| 2 |  <p style="text-align: right;">S810-002402</p> |  <p style="text-align: right;">S810-102402</p> |

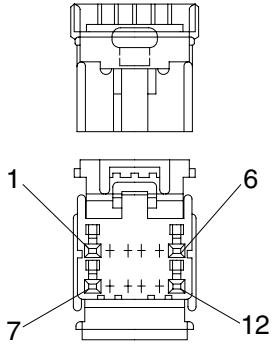
6) AMP ECONOSEAL CONNECTOR

| No. of pin | Receptacle connector(Female) | Plug connector(Male) |
|------------|---|--|
| 36 |  <p style="text-align: right;">344111-1</p> |  <p style="text-align: right;">344108-1</p> |

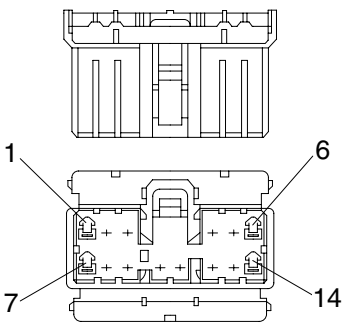
7) AMP TIMER CONNECTOR

| No. of pin | Receptacle connector(Female) | Plug connector(Male) |
|------------|---|----------------------|
| 2 |  <p style="text-align: right;">85202-1</p> | |

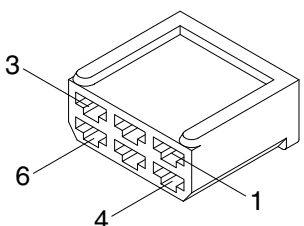
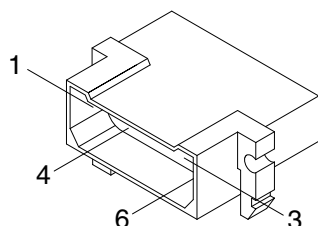
8) AMP 040 MULTILOCK CONNECTOR

| No. of pin | Receptacle connector(Female) | Plug connector(Male) |
|------------|---|----------------------|
| 12 |  <p>174045-2</p> | |

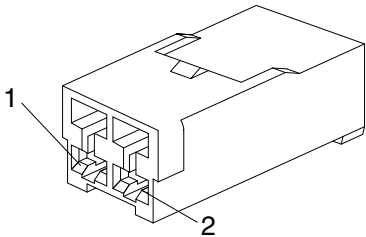
9) AMP 070 MULTILOCK CONNECTOR

| No. of pin | Receptacle connector(Female) | Plug connector(Male) |
|------------|--|----------------------|
| 14 |  <p>173852</p> | |

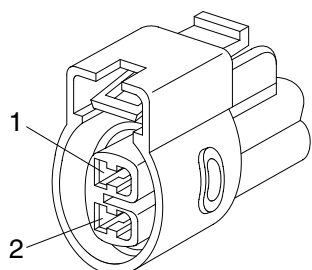
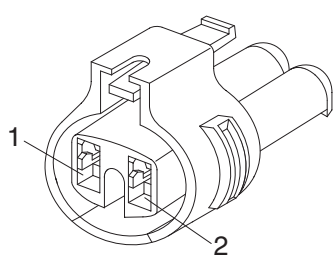
10) AMP FASTIN - FASTON CONNECTOR

| No. of pin | Receptacle connector(Female) | Plug connector(Male) |
|------------|---|--|
| 6 |  <p>925276-0</p> |  <p>480003-9</p> |

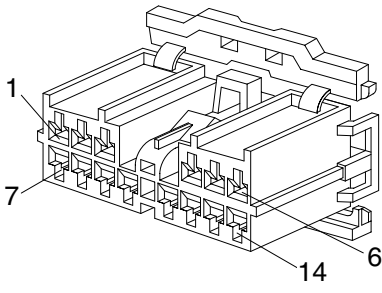
11)KET 090 CONNECTOR

| No. of pin | Receptacle connector(Female) | Plug connector(Male) |
|------------|---|----------------------|
| 2 |  <p>MG610070</p> | |

12)KET 090 WP CONNECTORS

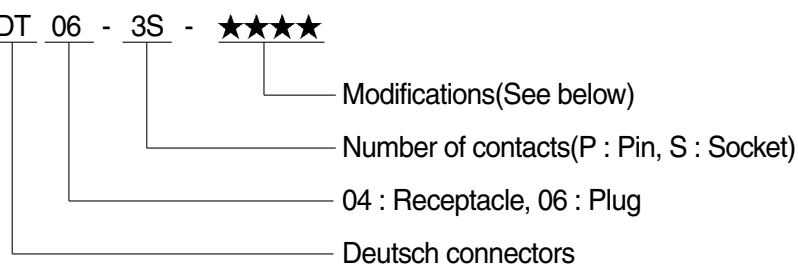
| No. of pin | Receptacle connector(Female) | Plug connector(Male) |
|------------|---|----------------------|
| 2 |  <p>MG640605</p> | |
| 2 |  <p>MG640795</p> | |

13)KET SDL CONNECTOR

| No. of pin | Receptacle connector(Female) | Plug connector(Male) |
|------------|---|----------------------|
| 14 | <div><p>MG610406</p></div> | |

14) DEUTSCH DT CONNECTORS

DT 06 - 3S - ★★★★★



※ Modification

E003 : Standard end cap - gray

E004 : Color of connector to be black

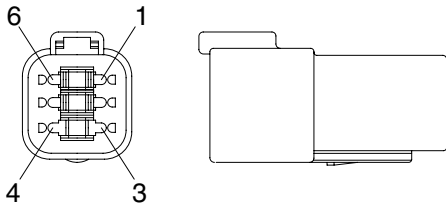
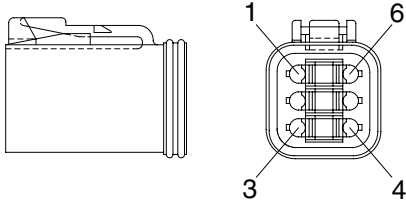
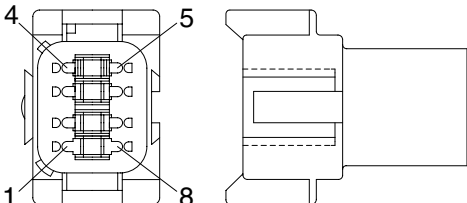
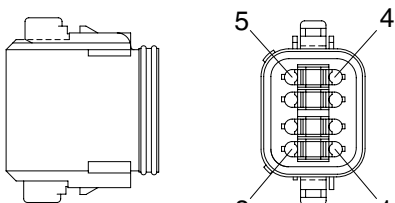
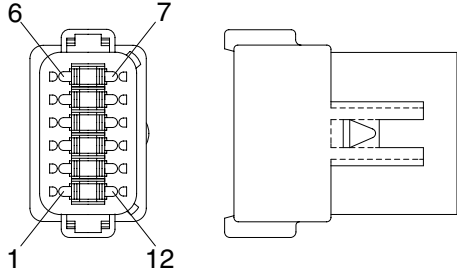
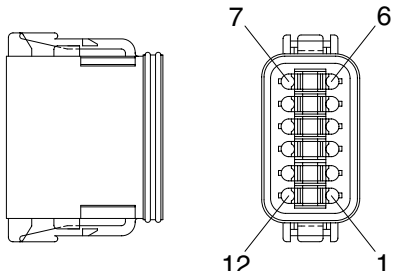
E005 : Combination - E004 & E003

EP04 : End cap

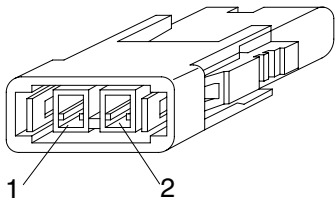
EP06 : Combination P012 & EP04

P012 : Front seal enhancement - connectors color to black for 2, 3, 4 & 6pin

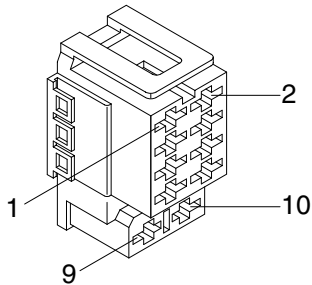
| No. of pin | Receptacle connector(Female) | Plug connector(Male) |
|------------|------------------------------|----------------------|
| 2 | <p>DT06-2S</p> | <p>DT04-2P</p> |
| 3 | <p>DT06-3S</p> | <p>DT04-3P</p> |
| 4 | <p>DT06-4S</p> | <p>DT04-4P</p> |

| No. of pin | Receptacle connector(Female) | Plug connector(Male) |
|------------|---|--|
| 6 |  <p>DT06-6S</p> |  <p>DT04-6P</p> |
| 8 |  <p>DT06-8S</p> |  <p>DT04-8P</p> |
| 12 |  <p>DT06-12S</p> |  <p>DT04-12P</p> |

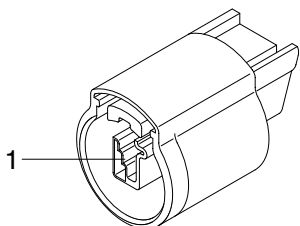
15) MOLEX 2CKTS CONNECTOR

| No. of pin | Receptacle connector(Female) | Plug connector(Male) |
|------------|---|----------------------|
| 2 |  <p>35215-0200</p> | |

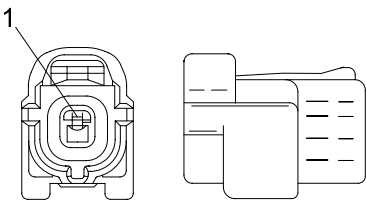
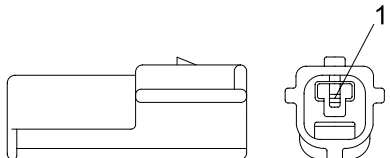
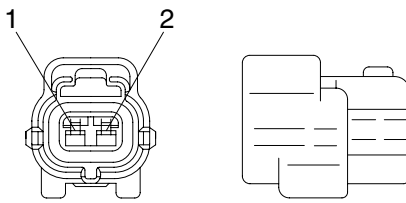
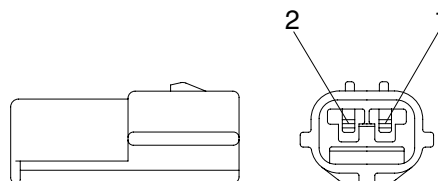
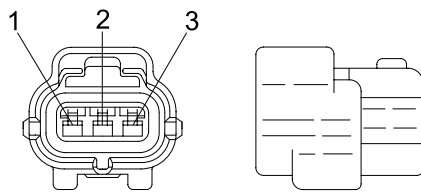
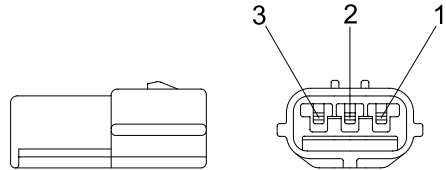
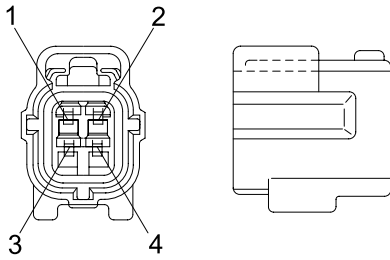
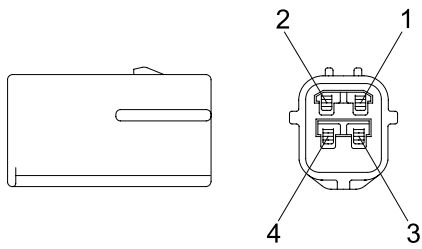
16)ITT SWF CONNECTOR

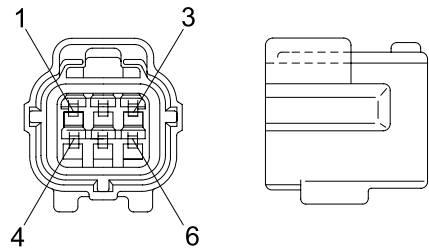
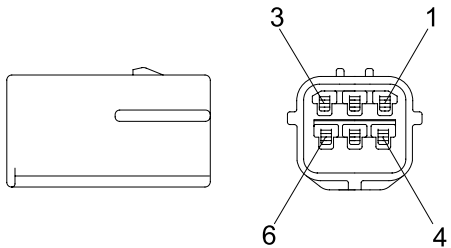
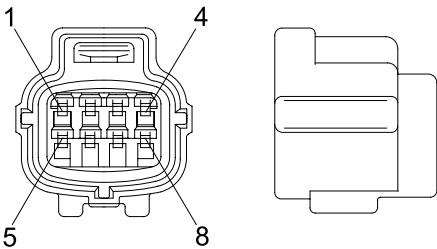
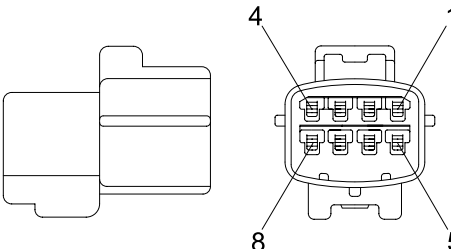
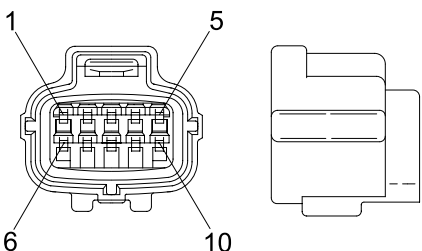
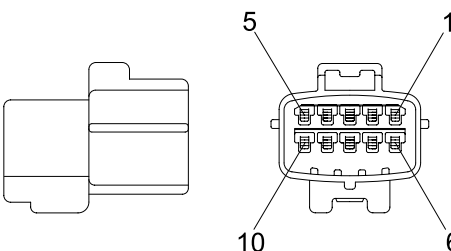
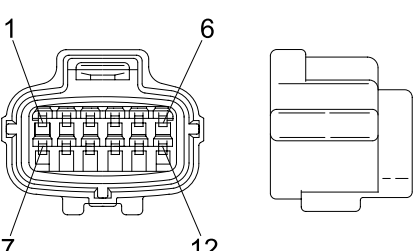
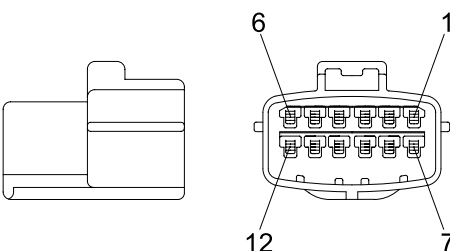
| No. of pin | Receptacle connector(Female) | Plug connector(Male) |
|------------|---|----------------------|
| 10 |  <p>SWF593757</p> | |

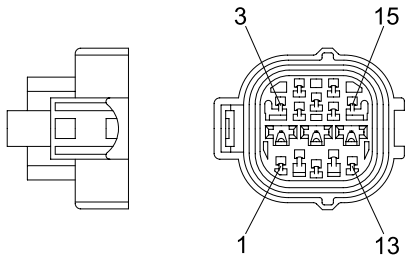
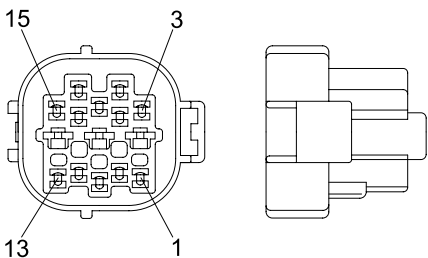
17)MWP NMWP CONNECTOR

| No. of pin | Receptacle connector(Female) | Plug connector(Male) |
|------------|--|----------------------|
| 1 |  <p>NMWP01F-B</p> | |

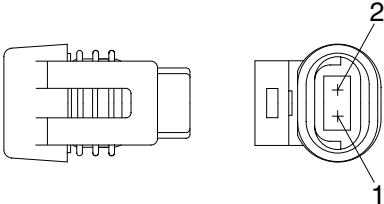
18)ECONOSEAL J TYPE CONNECTORS

| No. of pin | Receptacle connector(Female) | Plug connector(Male) |
|------------|--|---|
| 1 |  <p>S816-001002</p> |  <p>S816-101002</p> |
| 2 |  <p>S816-002002</p> |  <p>S816-102002</p> |
| 3 |  <p>S816-003002</p> |  <p>S816-103002</p> |
| 4 |  <p>S816-004002</p> |  <p>S816-104002</p> |

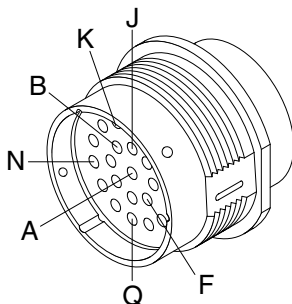
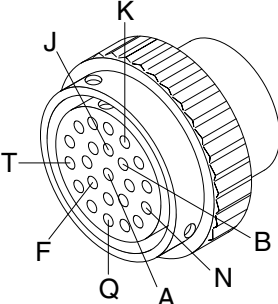
| No. of pin | Receptacle connector(Female) | Plug connector(Male) |
|------------|--|---|
| 6 |  <p>S816-006002</p> |  <p>S816-106002</p> |
| 8 |  <p>S816-008002</p> |  <p>S816-108002</p> |
| 10 |  <p>S816-010002</p> |  <p>S816-110002</p> |
| 12 |  <p>S816-012002</p> |  <p>S816-112002</p> |

| No. of pin | Receptacle connector(Female) | Plug connector(Male) |
|------------|---|---|
| 15 |  <p>368301-1</p> |  <p>2-85262-1</p> |

19)METRI-PACK TYPE CONNECTOR

| No. of pin | Receptacle connector(Female) | Plug connector(Male) |
|------------|--|----------------------|
| 2 |  <p>12040753</p> | |

20)DEUTSCH HD30 CONNECTOR

| No. of pin | Receptacle connector(Female) | Plug connector(Male) |
|------------|---|--|
| 23 |  <p>HD36-24-23SN</p> |  <p>HD34-24-23PN</p> |

SECTION 5 MECHATRONICS SYSTEM

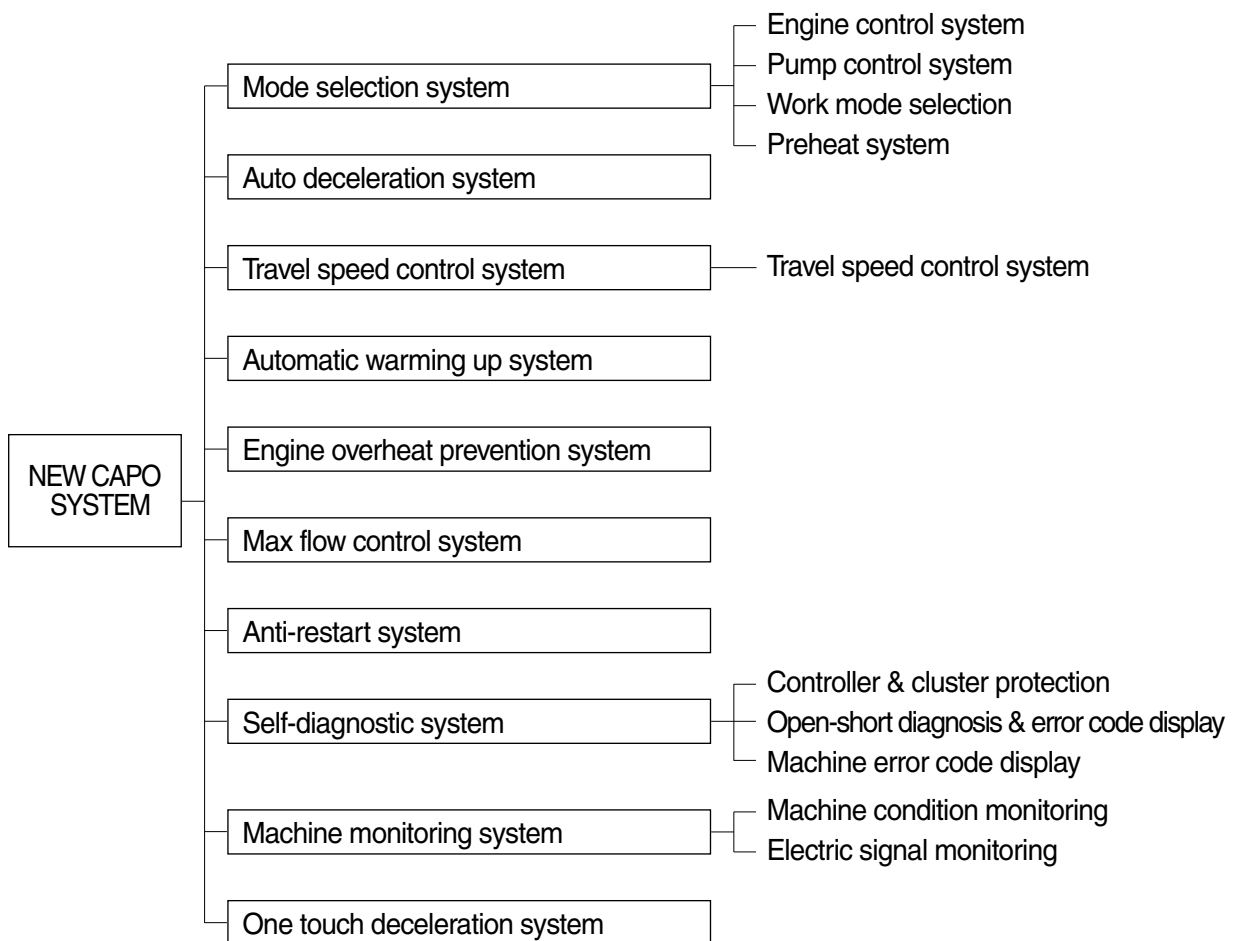
| | |
|---|------|
| Group 1 Outline | 5-1 |
| Group 2 Mode Selection System | 5-3 |
| Group 3 Automatic Deceleration System | 5-5 |
| Group 4 Travel Speed Control System | 5-6 |
| Group 5 Automatic Warming Up Function | 5-7 |
| Group 6 Engine Overheat Prevention Function | 5-8 |
| Group 7 Anti-Restart System | 5-9 |
| Group 8 Self-Diagnostic System | 5-10 |
| Group 9 Engine Control System | 5-14 |
| Group 10 EPPR(Electro Proportional Pressure Reducing) Valve | 5-21 |
| Group 11 Monitoring System | 5-24 |

SECTION 5 MECHATRONICS SYSTEM

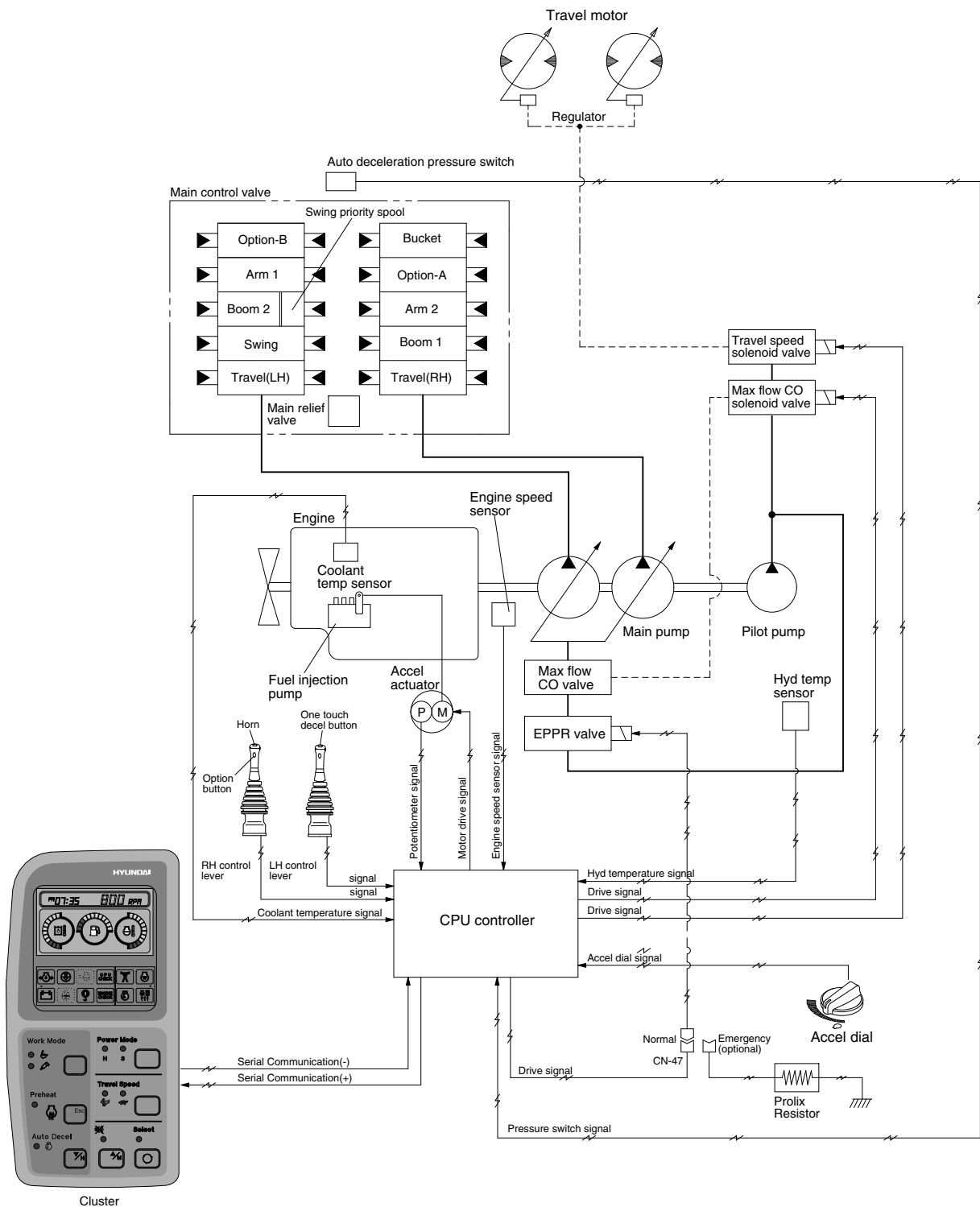
GROUP 1 OUTLINE

The NEW CAPO(Computer Aided Power Optimization) system controls engine and pump mutual power at an optimum and less fuel consuming state for the selected work by mode selection, auto-deceleration, power boost function, etc. It monitors machine conditions, for instance, engine speed, coolant temperature, hydraulic oil temperature, and hydraulic oil pressure, etc.

It consists for a CPU controller, a cluster, an accel actuator, an EPPR valve, and other components. The CPU controller and the cluster protect themselves from over-current and high voltage input, and diagnose malfunctions caused by short or open circuit in electric system, and display error codes on the cluster.



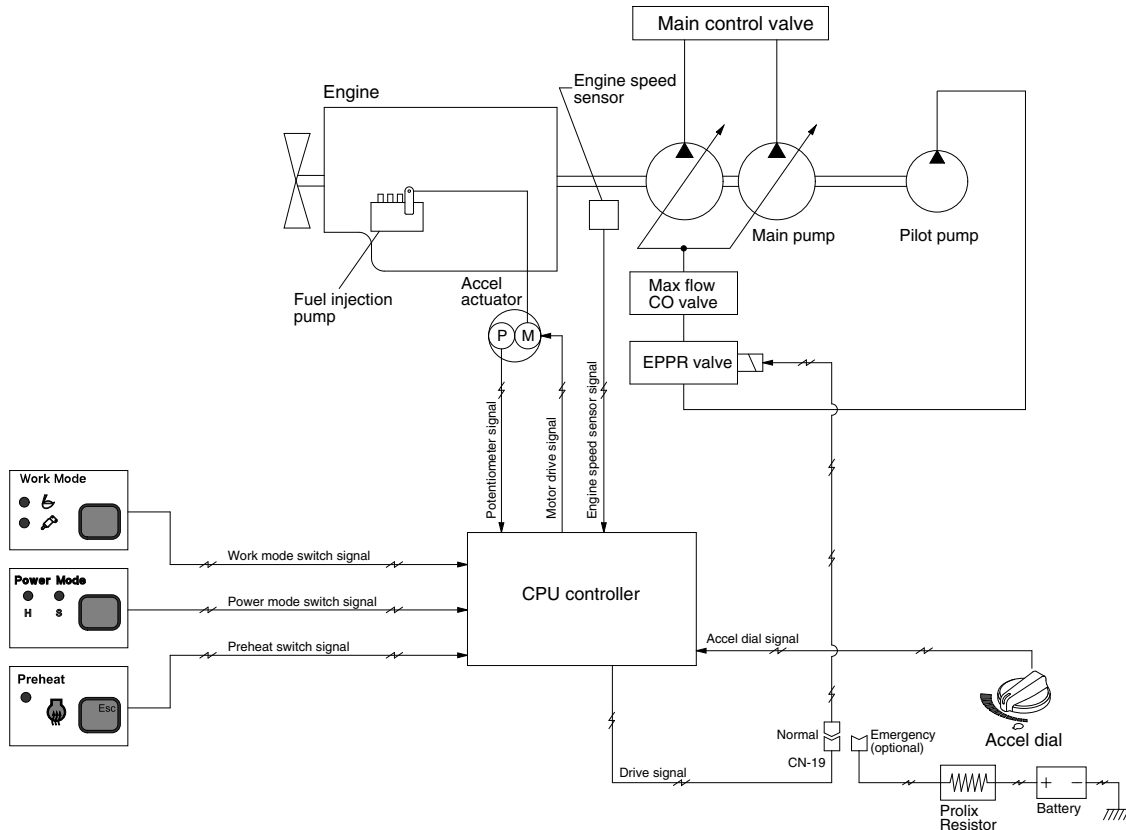
SYSTEM DIAGRAM



2107V5MS01

GROUP 2 MODE SELECTION SYSTEM

1. POWER MODE SELECTION SYSTEM



21075VMS02

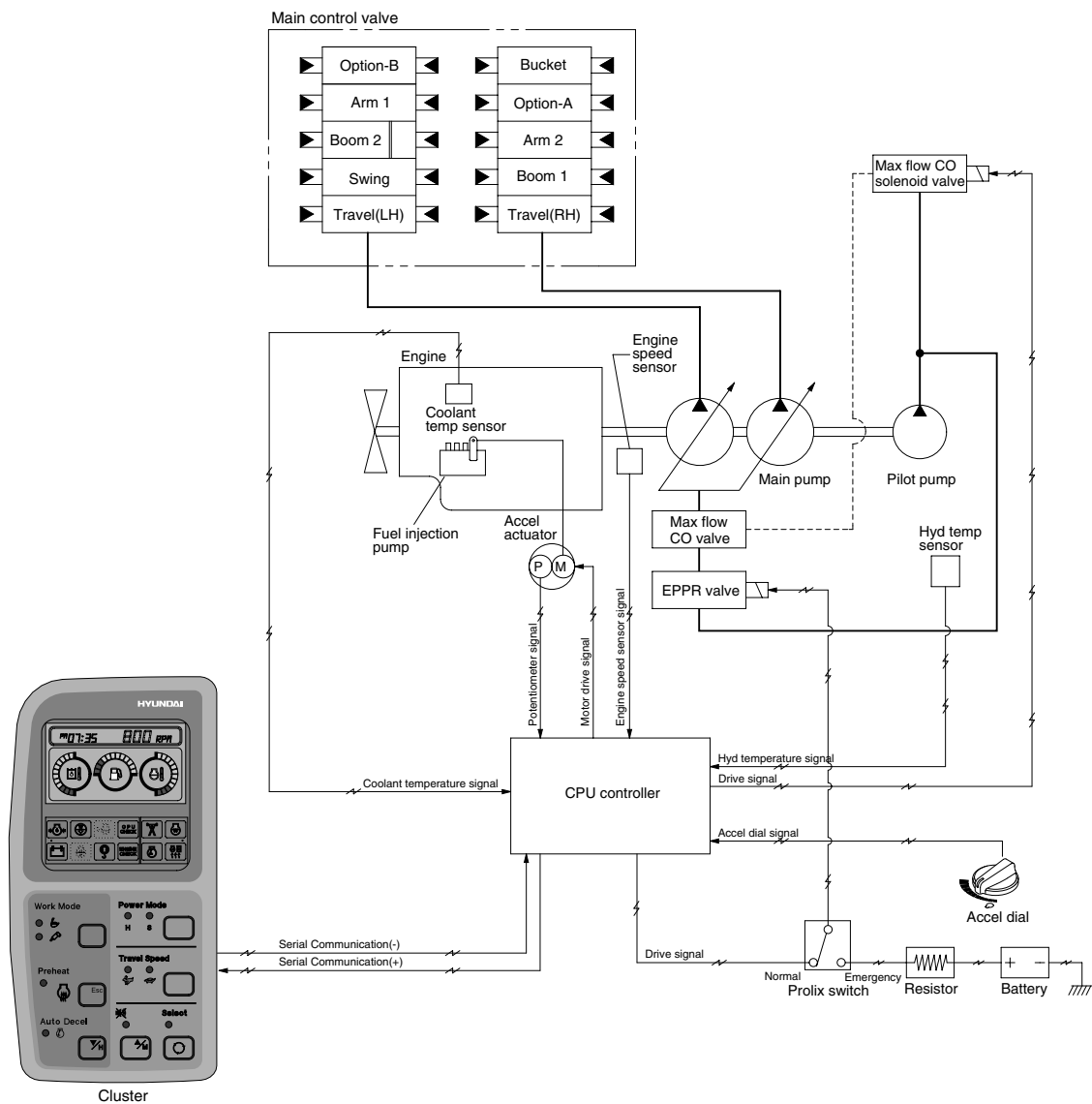
Mode selection system(Micro computer based electro-hydraulic pump and engine mutual control system) optimizes the engine and pump performance.

The combination of 2 power modes(H, S) and accel dial position(10 set) makes it possible to use the engine and pump power more effectively corresponding to the work conditions from a heavy and great power requesting work to a light and precise work.

| Mode | Application | Power set (%) | Engine rpm | | Power shift by EPPR valve | | | |
|-----------------|---------------------------|---------------|------------|------|---------------------------|---------------------------------|--------------|---------------------------------|
| | | | Unload | Load | Default | | Other case | |
| | | | | | Current (mA) | Pressure (kgf/cm ²) | Current (mA) | Pressure (kgf/cm ²) |
| H | High power | 100 | 1950±50 | - | 330±30 | 10 | 330 | 10 |
| S | Standard power | 85 | 1750±50 | - | 400±30 | 15 | 400 | 15 |
| AUTO DECEL | Engine deceleration | - | 1200±100 | - | 700±30 | 38 | 700±30 | 38 |
| One touch decel | Engine quick deceleration | - | 1000±100 | - | 700±30 | 38 | 700±30 | 38 |
| KEY START | Key switch start position | - | 1000±100 | - | 700±30 | 38 | 700±30 | 38 |

2. WORK MODE SELECTION SYSTEM

2 work modes can be selected for the optional work speed of the machine operation.



2107V5MS03

1) GENERAL WORK MODE

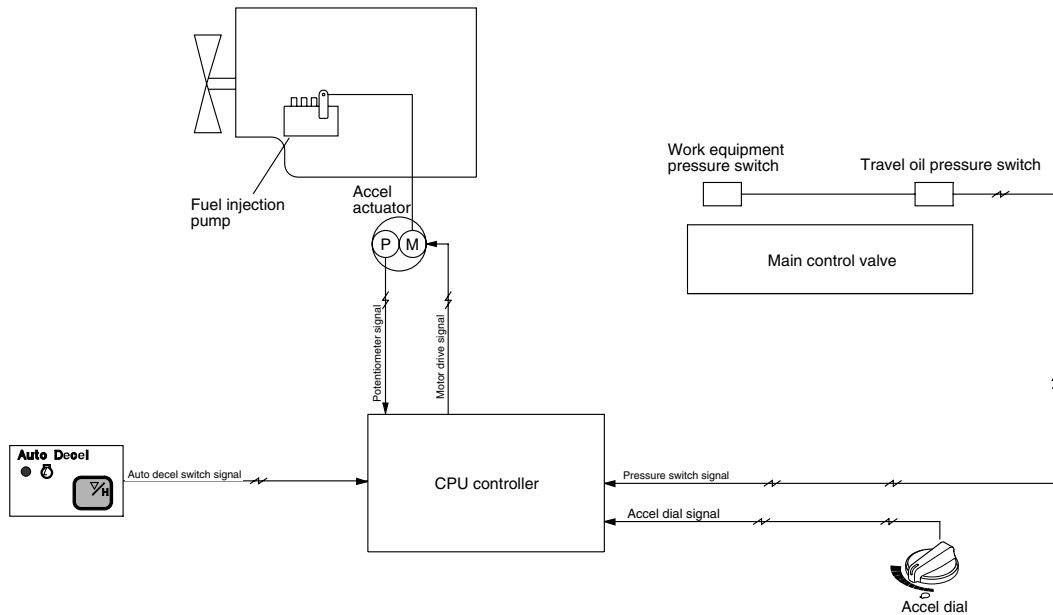
When key switch is turned ON, this mode is selected and swing operation speed is faster than heavy duty work mode.

2) BREAKER OPERATION MODE

It sets the pump flow to the optimal operation of breaker by activating the max flow cut-off solenoid.

| Work mode | Max flow cut-off solenoid |
|-----------|---------------------------|
| General | OFF |
| Breaker | ON |

GROUP 3 AUTOMATIC DECELERATION SYSTEM

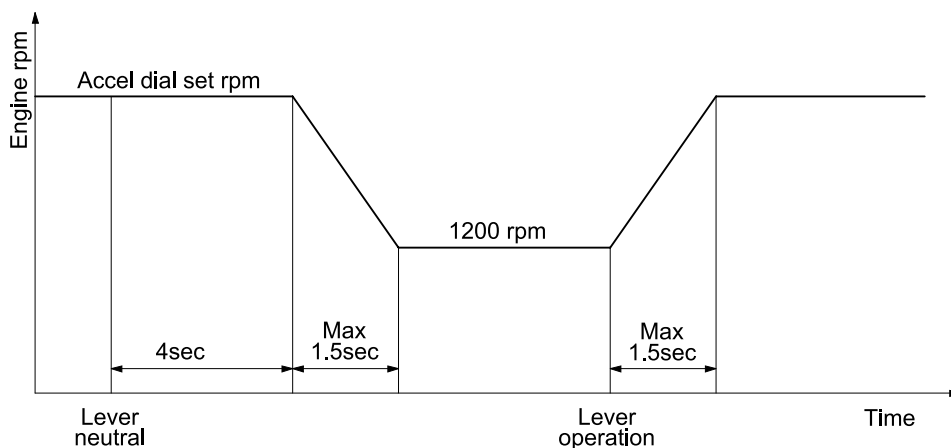


21075MS04

1. WHEN AUTO DECEL LAMP ON

If all the work equipment control levers including swing and travel levers are at neutral for at least 4 seconds, CPU controller drives the governor motor to reduce the engine speed to 1200rpm. As the result of reducing the engine speed, fuel consumption and noise are effectively cut down during non-operation of the control levers.

When the Auto decel lamp is turned off by pressing the switch or any control lever is operated, the reduced engine speed rises up to the speed set before deceleration in a second.



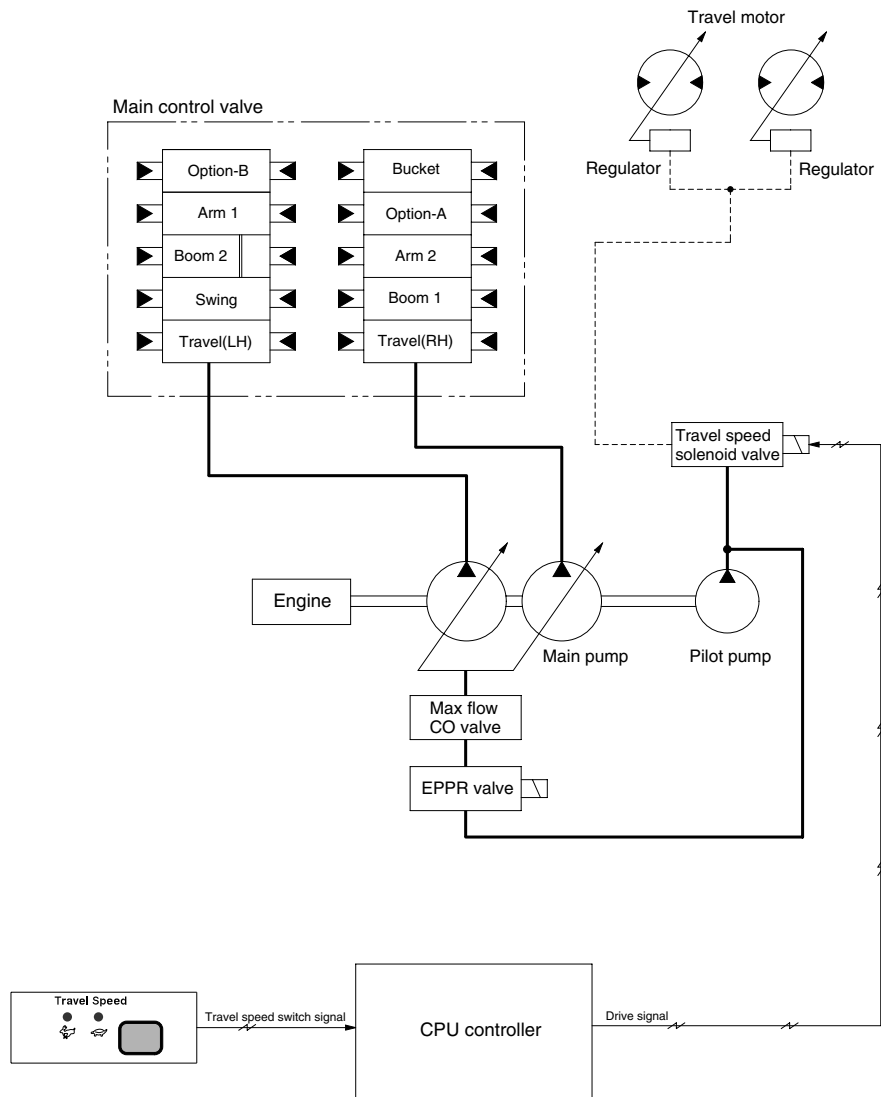
21075MS05

2. WHEN AUTO DECEL LAMP OFF

The engine speed can be set as desired using the engine speed switch, and even if the control levers are neutral, the engine speed is not reduced.

Note : Auto decel function can be activated when accel dial position is over 4.

GROUP 4 TRAVEL SPEED CONTROL SYSTEM



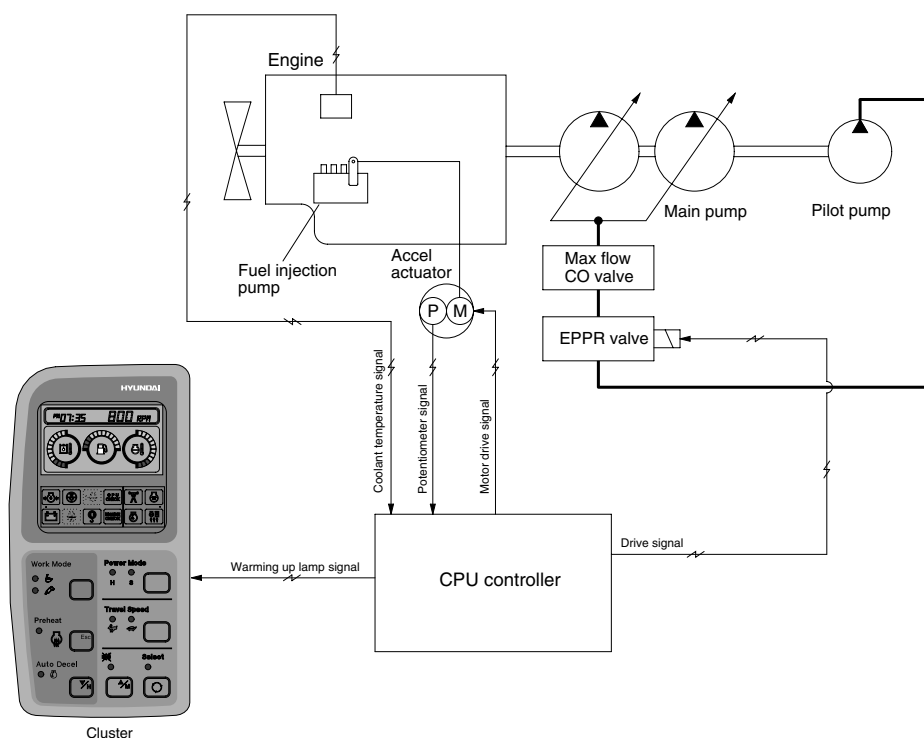
2107V5MS07

Travel speed can be switched manually by pressing the travel speed switch on the cluster.

| Speed | Travel speed solenoid valve | Lamp on cluster | Operation |
|-------|-----------------------------|-----------------|--|
| Lo | OFF | Turtle | Low speed, high driving torque in the travel motor |
| Hi | ON | Rabbit | High speed, low driving torque in the travel motor |

※ Default : Turtle(Lo)

GROUP 5 AUTOMATIC WARMING UP FUNCTION



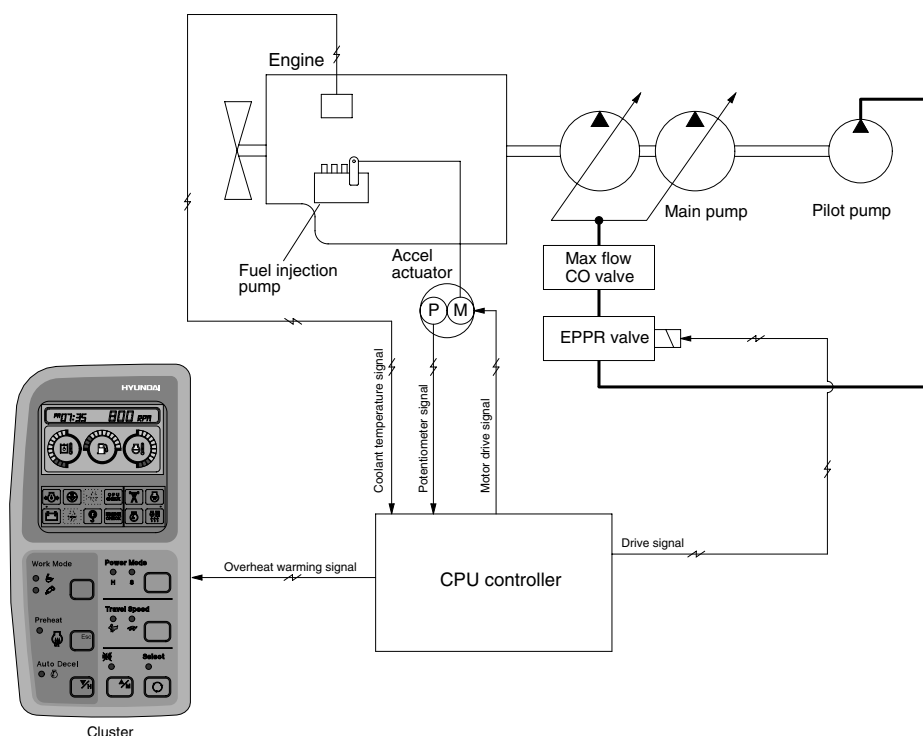
2107V5MS08

1. CPU controller reads engine coolant temperature through the temperature sensor, and if the coolant temperature is less than 30°C, it increases the engine speed from key start rpm to 1200rpm. At this time the mode does not change.
2. In case of the coolant temperature increases up to 30°C, the engine speed is decreased to key start speed. And if an operator changes mode set during the warming up function, the CPU controller cancels the automatic warming up function.

3. LOGIC TABLE

| Description | Condition | Function |
|-----------------|---|---|
| Actuated | <ul style="list-style-type: none"> - Coolant temperature : Less than 30°C(after engine run) - Accel dial position is under 3 | <ul style="list-style-type: none"> - Mode : Default(S mode) - Warming up time : 10 minutes(max) - Warming up lamp : ON |
| Canceled | <ul style="list-style-type: none"> - Coolant temperature : Above 30°C - Warming up time : Above 10 minutes - Changed mode set by operator - Increase engine speed by rotating accel dial clockwise ※ If any of the above conditions is applicable, the automatic warming up function is canceled | <ul style="list-style-type: none"> - Default mode - Default mode - Changed mode |
| Warming up lamp | - Coolant temperature : Above 30°C | - Warming up lamp : OFF |

GROUP 6 ENGINE OVERHEAT PREVENTION FUNCTION



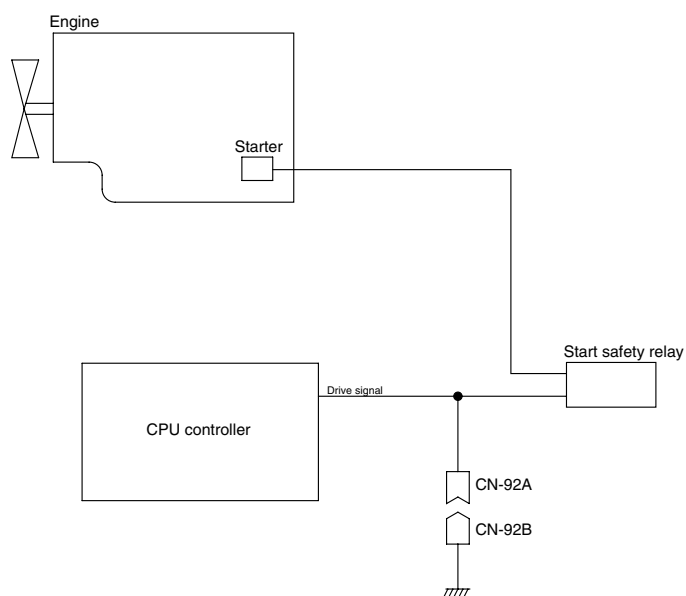
2107V5MS09

1. CPU controller reads engine coolant temperature through the temperature sensor and when the engine coolant boils up to 110°C, it sends overheating warning signal to the cluster and decrease the engine speed same as accel dial 7 position.
2. If the coolant temperature drops less than 100°C, the CPU controller returns the mode to the mode set before. And if mode set is changed during the function, the CPU controller cancels the function. Even if the overheating prevention function is canceled by mode change, the overheating warning lamp turns OFF only when the coolant temperature is less than 100°C.

3. LOGIC TABLE

| Description | Condition | Function |
|-----------------------|---|---|
| Actuated | <ul style="list-style-type: none"> - Coolant temperature : Above 110°C - Accel dial set : Above 8 | <ul style="list-style-type: none"> - Engine rpm drop to accel dial 7 position - Overheat warning lamp & buzzer : ON |
| Canceled | <ul style="list-style-type: none"> - Coolant temperature : Less than 100°C - Changed mode set by operator ※ If any of the above conditions is applicable, engine overheating prevention function is canceled | <ul style="list-style-type: none"> - Return to the mode and accel dial set before - Hold on the changed set |
| Overheat warning lamp | - Coolant temperature : Less than 100°C | - Overheat warning lamp : OFF |

GROUP 7 ANTI-RESTART SYSTEM



21075MS10

1. ANTI-RESTART FUNCTION

After 10 seconds from the engine starts to run, CPU controller turns off the start safety relay to protect the starter from inadvertent restarting.

2. When a replacement or taking-off of the CPU controller is needed, connect CN-92A and CN-92B to ensure the engine start without the CPU controller.

GROUP 8 SELF-DIAGNOSTIC SYSTEM

1. OUTLINE

When any abnormality occurs in the NEW CAPO system caused by electric parts malfunction and by open or short circuit, the CPU controller diagnoses the problem and sends the error codes to the cluster and also stores them in the memory.

The current or recorded error codes are displayed at the error display mode selected by touching **SELECT** switch 2 times while pressing **BUZZER STOP** switch.

2. CURRENT ERROR DISPLAY

Cluster displays **Co : Er** and makes buzzer sound itself to warn the communication error when communication problem caused by wire-cut or malfunction of the CPU controller occurs.

Cluster displays real time error codes received from CPU controller through communication. In case of no problem it displays **CHECK Er : 00**.

If there are more than 2 error codes, each one can be displayed by pressing ▲ and ▼ switch respectively.

Examples :

1) Communication Error

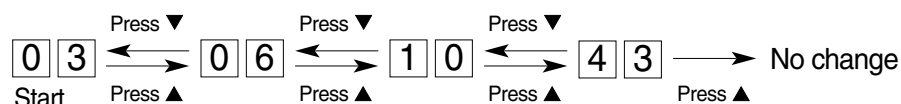
Co : Er & Buzzer sound

2) No problem

CHECK Er : 00

3) 4 Error codes(03, 06, 10, 43) display

CHECK Er : 03

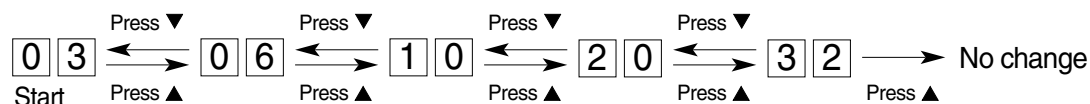


3. RECORDED ERROR DISPLAY



The recorded error can be displayed only when the key switch is at ON position.

Examples : 5 Recorded error codes(03, 06, 10, 20, 32) display

TIME Er : 03



4. DELETE ALL RECORDED ERROR CODES

Select recorded error(**TIME Er**) display and press engine  and select switch  at the same time for 2 seconds or more. Cluster display changes to **TIME Er : 00**, which shows that CPU controller deleted all the recorded error codes in the memory.

5. MACHINE ERROR CODES TABLE

| Fault code No. | Description |
|----------------|--|
| 1 | Short circuit in governor motor system |
| 2 | Potentiometer circuit is shorted to Vcc(5V) or battery + |
| 3 | Short circuit in pump EPPR valve system |
| 4 | Short circuit in boom down EPPR valve system |
| 5 | Short circuit in travel speed solenoid system |
| 7 | Short circuit in max flow solenoid system |
| 10 | Short circuit in hour-meter system |
| 11 | Accel dial circuit is shorted to Vcc(5V) or battery + |
| 12 | P1 pressure sensor circuit is shorted to power supply(24V) line |
| 13 | P2 pressure sensor circuit is shorted to power supply(24V) line |
| 14 | P3 pressure sensor circuit is shorted to power supply(24V) line |
| 15 | Boom down pressure circuit is shorted to power supply(24V) line |
| 16 | Governor motor circuit is open or shorted to ground |
| 17 | Potentiometer circuit is open or shorted to ground |
| 18 | Pump EPPR valve circuit is open or shorted to ground |
| 19 | Boom down EPPR valve circuit is open or shorted to ground |
| 20 | Travel speed solenoid circuit is open or shorted to ground |
| 22 | Max flow solenoid circuit is open or shorted to ground |
| 25 | Hour-meter circuit is open or shorted to ground |
| 26 | Accel dial circuit is open or shorted to ground |
| 27 | P1 pressure sensor circuit is open or shorted to ground |
| 28 | P2 pressure sensor circuit is open or shorted to ground |
| 29 | P3 pressure sensor circuit is open or shorted to ground |
| 30 | Boom down pressure sensor circuit is open or shorted to ground |
| 31 | Engine preheater circuit is open or shorted to ground |
| 33 | Alternator circuit is open or shorted to ground |
| 34 | Controller input voltage is below 18V |
| 35 | Controller input voltage is over 38V |
| 36 | Communication error with cluster |
| 37 | Engine speed sensor circuit is open or shorted to ground |
| 38 | Anti-restart relay circuit is open or shorted to ground |
| 39 | Accel actuator does not stop at a target position |
| 40 | There is more than 500rpm difference between target speed and actual speed |
| 41 | Hydraulic oil temperature sensor circuit is shorted to ground |
| 42 | Fuel level sensor circuit is shorted to ground |
| 43 | Coolant temperature sensor circuit is shorted to ground |

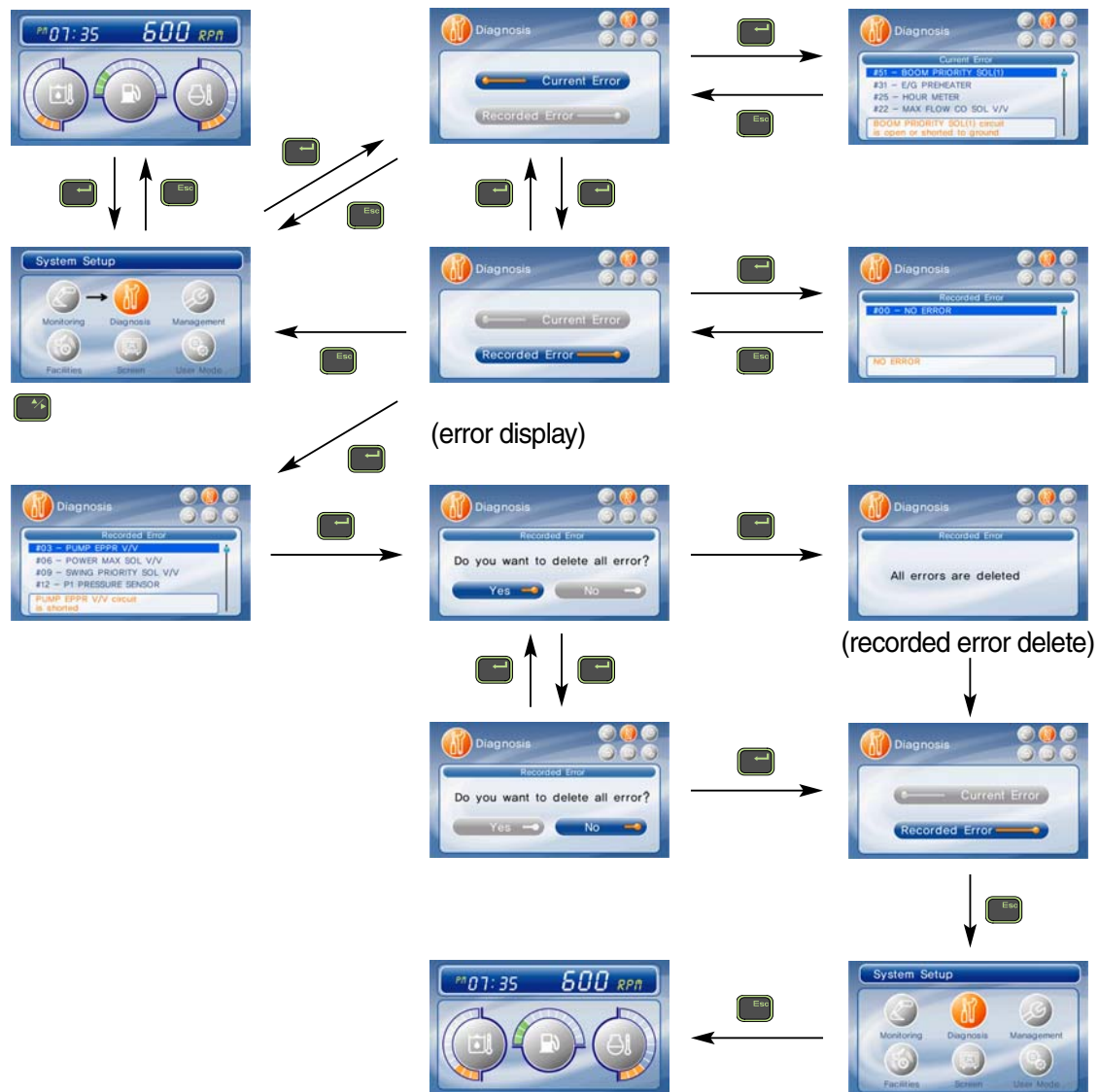
| Fault code No. | Description |
|----------------|--|
| 44 | Boom up pressure sensor circuit is shorted to power supply(24V) line |
| 45 | Hydraulic oil temperature sensor circuit is open or shorted to battery + |
| 46 | Fuel level sensor circuit is open or shorted to battery + |
| 47 | Coolant temperature sensor circuit is open or shorted to battery + |
| 48 | Boom up pressure sensor circuit is open or shorted to ground |
| 49 | Engine preheater circuit is shorted to battery + |

6. SELF-DIAGNOSTIC SYSTEM

1) OUTLINE

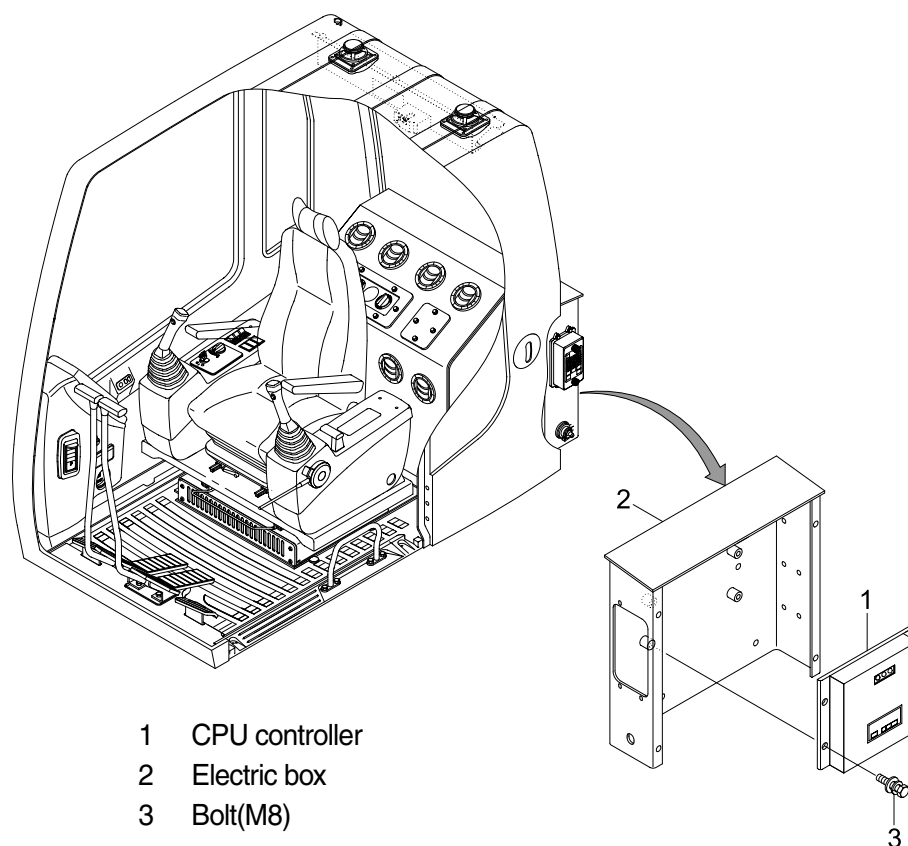
When any abnormality occurs in the NEW CAPO system caused by electric parts malfunction and by open or short circuit, the MCU diagnoses the problem and sends the error codes to the cluster and also stores them in the memory.

2) CURRENT ERROR DISPLAY



GROUP 9 ENGINE CONTROL SYSTEM

1. CPU CONTROLLER MOUNTING



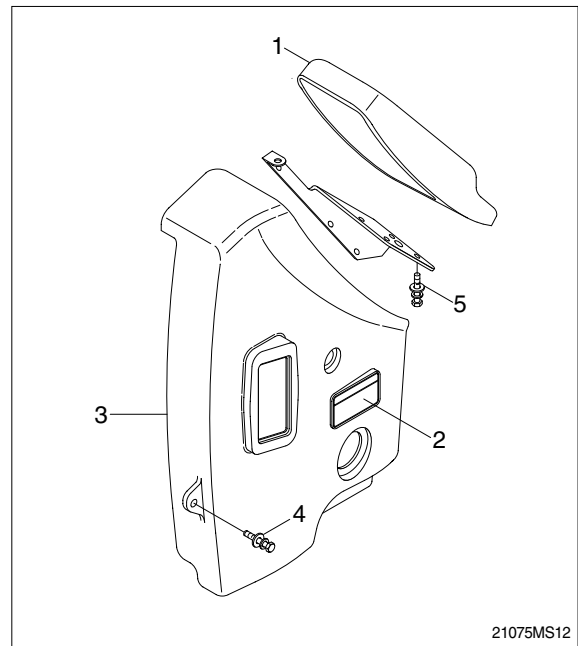
RD21075MS11A

2. CPU CONTROLLER ASSEMBLY

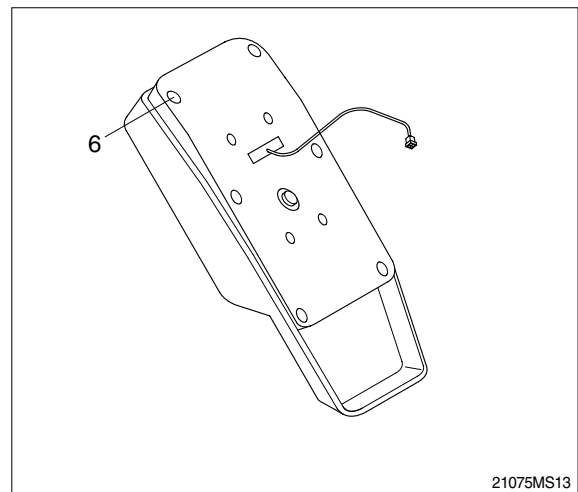
- 1) Remove four pieces of bolt(3) of electric box(2).
- 2) Disconnect 2 connectors from CPU controller.
- 3) Remove 6 pieces of screw and open the cover of CPU controller.
- 4) Inspection : Check PCB(Printed Circuit Board)
 - (1) If any damage is found, replace CPU controller assembly.
 - (2) If not, but CAPO system does not work please report it to HHI dealer or A/S department.

3. EXCHANGE METHOD OF THE ROM

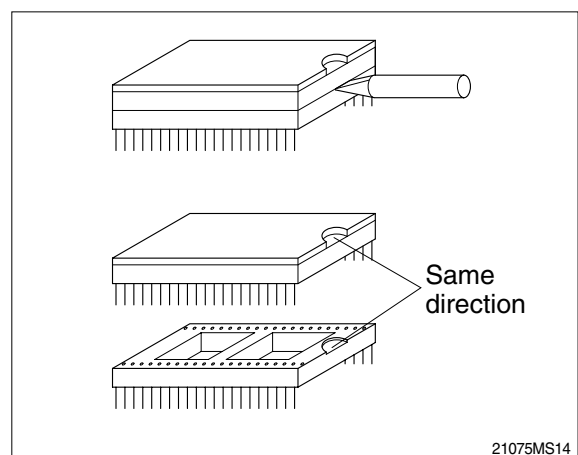
- 1) Disassemble the ash tray(2).
- 2) Disassemble the wiper motor cover(3).
- 3) Disassemble the cluster(1).



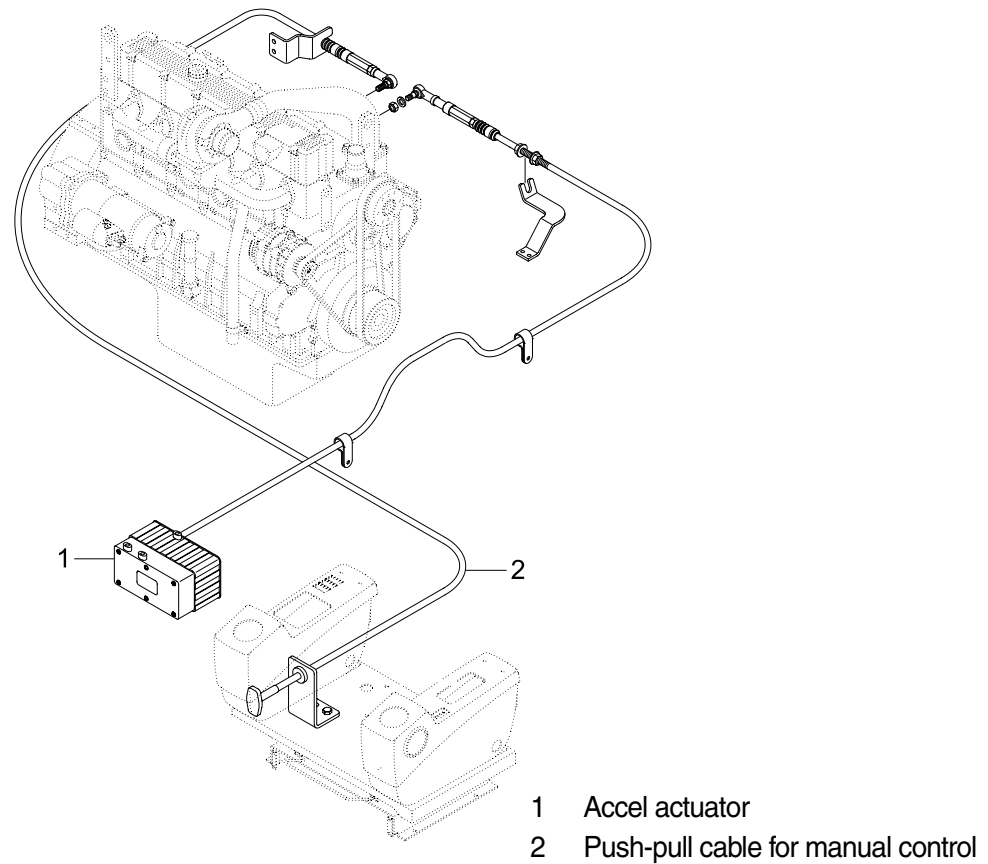
- 4) Loosen the screws(6EA) located back of the cluster.
- 5) Then you can open the upper case of the cluster easily.



- 6) Install the new ROM.(Be careful of direction and assemble the cluster in the reverse order to removal).

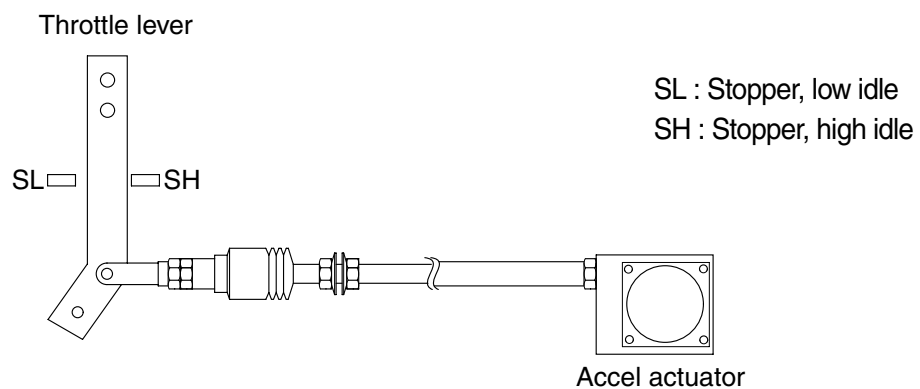


4. ENGINE ACCEL ACTUATOR



2107V5MS60

1) ENGINE THROTTLE LEVER



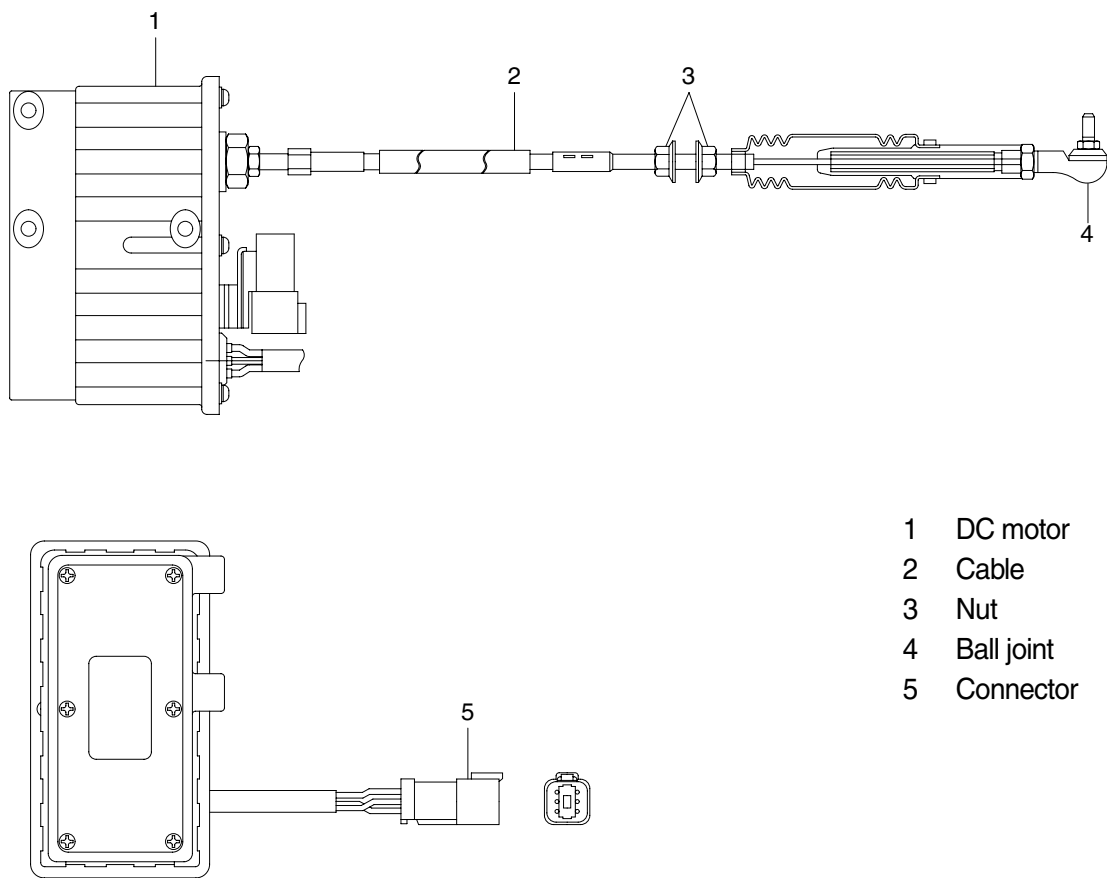
(210-7) 5-18(2)

2) ENGINE STOP CABLE (pull cable)

It controls engine speed by connecting onto the lever of the injection pump when the malfunction of the CPU controller or the accel actuator happen.

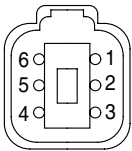
It controls engine stop. This cable pulls stop lever of the injection pump and engine will stop.

3) ACCEL ACTUATOR



- 1 DC motor
- 2 Cable
- 3 Nut
- 4 Ball joint
- 5 Connector

2107V5MS61

| Connector | |  |
|--------------------------|---|---|
| Type | | 6P, female |
| Line color & description | 1 | White(Potentiometer 5V) |
| | 2 | Blue(Potentiometer SIG) |
| | 3 | Black(Potentiometer GND) |
| | 4 | - |
| | 5 | Green(Motor+) |
| | 6 | Yellow(Motor -) |
| Inspection | | Check resistance Spec : 1~2 Ω (Between No.5-6) 0.8~1.2kΩ (Between No.1-3) |

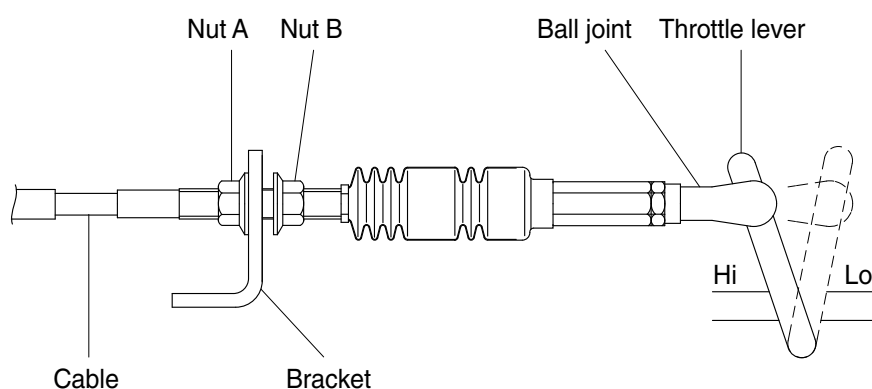
4) ACCEL ACTUATOR CABLE SETTING PROCEDURE

(1) Key OFF

- ① Connect the ball joint of cable to engine throttle lever.
- ② Pull the cable to high stopper and put nut **A** edge to yoke of the bracket.
 - ※ Make throttle lever not contact to the edge of high stopper.
- ③ Turn nut **A** to clockwise until touching to the edge of high stopper.
- ④ Make 1 turn more to clockwise in condition of the nut **A** contact to the edge of high stopper.

(2) Key START

- ⑤ Confirm if the engine speed on cluster is same as each mode specification.
- ⑥ If the engine speed displayed on cluster is higher than each mode specification, then turn the nut **A** to counter clockwise and make the engine speed same to each mode specification.
- ⑦ If the engine speed displayed on cluster is lower than each mode specification, then turn the nut **A** to clockwise and make the engine speed same to each mode specification.
- ⑧ Turn nut **B** to clockwise and fix the cable to bracket.

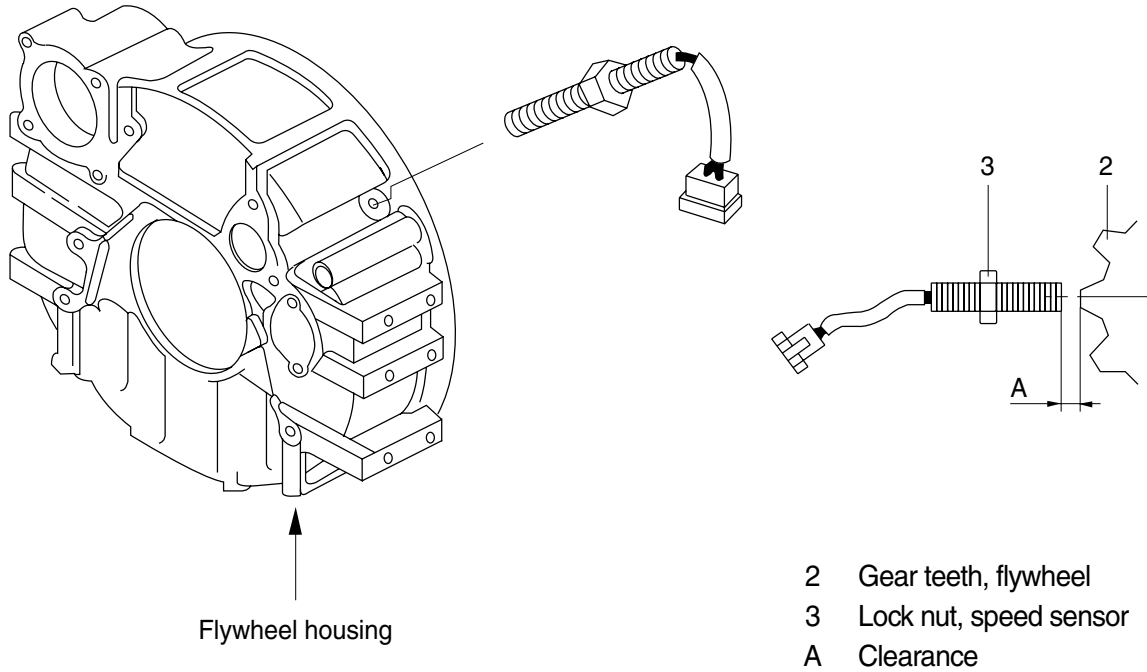


130W5MS05

| Mode | RPM |
|------------|----------|
| H | 1950±50 |
| S | 1750±50 |
| Auto decel | 1200±100 |
| Key start | 1000±100 |

5. ENGINE SPEED SENSOR

1) DETECT ACTUAL ENGINE RPM AND SEND SIGNAL TO TACHOMETER



5-20 (210-7)

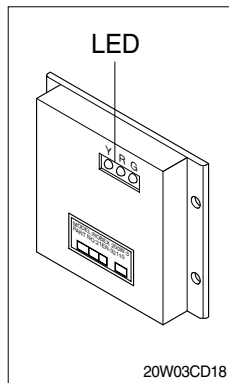
2) INSTALLATION

- (1) Clean contacting point of sensor.
- (2) Loosen lock nut.
- (3) Screw speed sensor into flywheel housing.
- (4) Turn it back 135° when it contacts with gear teeth.
- (5) Tight lock nut and connect wiring.

3) INSPECTION

- (1) Check resistance
 - SPEC : $300 \pm 30K\Omega$
- (2) Check voltage while engine run.
 - SPEC : 2~28Vac, dependent on the engine speed(rpm)

6. CPU CONTROLLER



(1) To match the engine torque with the pump absorption torque, CPU controller varies EPPR valve output pressure, which control pump discharge amount whenever feedbacked engine speed drops under the reference rpm of each mode set.

(2) Three LED lamps on the CPU controller display as below.

| LED lamp | Trouble | Service |
|--------------------------|--------------------------------------|--|
| G is turned ON | Normal | - |
| G and R are turned ON | Trouble on CPU or ROM | <ul style="list-style-type: none"> • Change the controller |
| G and Y are turned ON | Trouble on serial communication line | <ul style="list-style-type: none"> • Check if serial communication lines between controller and cluster are disconnected |
| Three LED are turned OFF | Trouble on CPU controller power | <ul style="list-style-type: none"> • Check if the input power wire (24V, GND) of controller is disconnected • Check the fuse |

G : green, R : red, Y : yellow

GROUP 10 EPPR VALVE

1. COMPOSITION OF EPPR VALVE

EPPR(Electro Proportional Pressure Reducing) valve consists of electro magnet and spool valve installed at main hydraulic pump.

1) ELECTRO MAGNET VALVE

Receive electric current from CPU controller and move the spool proportionally according to the specific amount of electric current value.

2) SPOOL VALVE

Is the two way direction control valve for pilot pressure to reduce hydraulic pump flow.

When the electro magnet valve is activated, pilot pressure enters into flow regulator of hydraulic pump.

So, pump flow decreases to prevent engine stall.

3) PRESSURE AND ELECTRIC CURRENT VALUE FOR EACH MODE

| Mode | | Pressure | | Electric current (mA) | Engine rpm (At accel dial 10) |
|----------------------|---|---------------------|----------|-----------------------|-------------------------------|
| | | kgf/cm ² | psi | | |
| Standard (Ver : 1.x) | H | 10 ± 3 | 142 ± 40 | 330 ± 30 | 1950 ± 50 |
| | S | 15 ± 3 | 213 ± 40 | 400 ± 30 | 1750 ± 50 |
| Option (Ver : 2.x) | H | 10 ± 3 | 142 ± 40 | 330 ± 30 | 2050 ± 50 |
| | S | 15 ± 3 | 213 ± 40 | 400 ± 30 | 1850 ± 50 |

2. HOW TO SWITCH THE VERSION(1.0↔2.0) ON THE CLUSTER

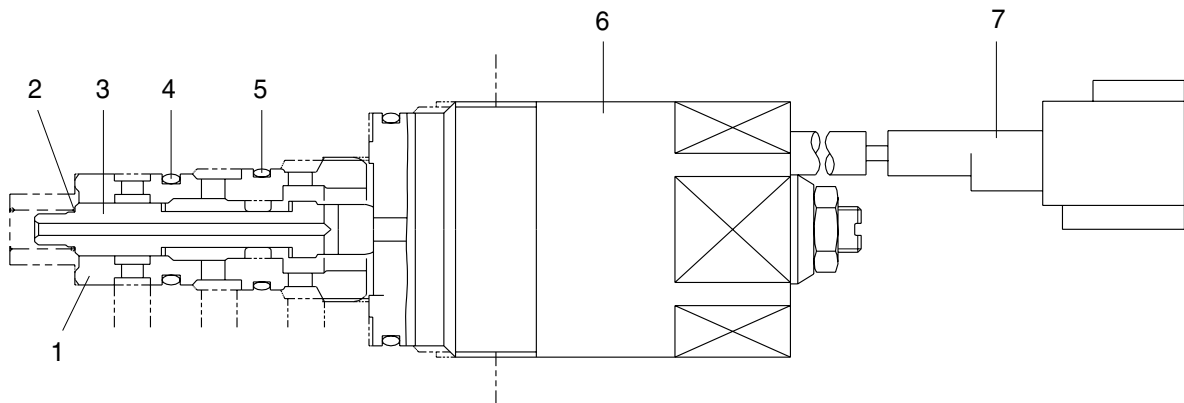
You can switch the EPPR valve pressure set by selecting the version(1.0↔2.0).

- Dual mode
 - Changing the MCU mode



2. OPERATING PRINCIPLE (pump EPPR valve)

1) STRUCTURE

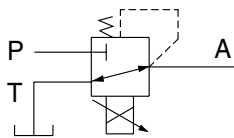


5-22(1) (290-7)

- 1 Sleeve
- 2 Spring
- 3 Spool

- 4 O-ring
- 5 O-ring

- 6 Solenoid valve
- 7 Connector

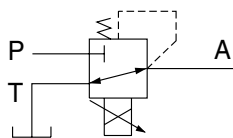


5-22A (290-7)

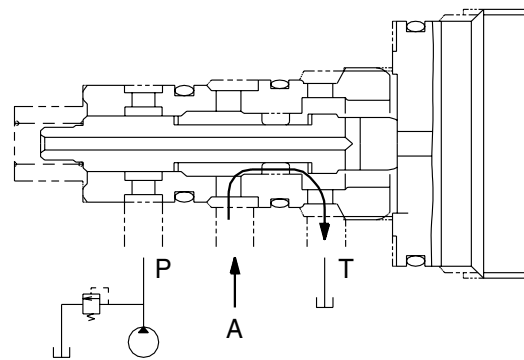
- P Pilot oil supply line(Pilot pressure)
- T Return to tank
- A Secondary pressure to flow regulator at hydraulic pump

2) NEUTRAL

Pressure line is blocked and A oil returns to tank.

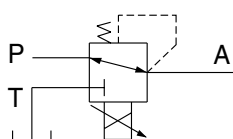


5-22B (290-7)

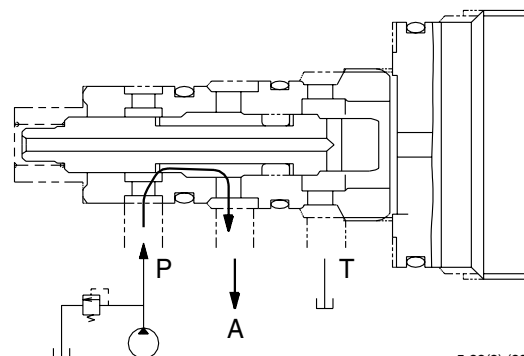


3) OPERATING

Secondary pressure enters into A.



5-22C (290-7)



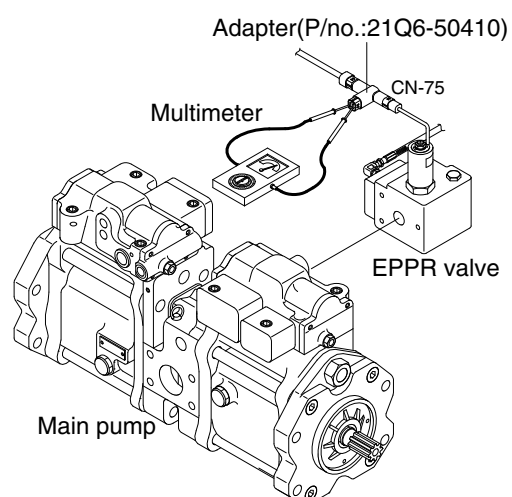
5-22(2) (290-7)

3. EPPR VALVE CHECK PROCEDURE

1) CHECK ELECTRIC CURRENT VALUE AT EPPR VALVE

- (1) Disconnect connector CN-75 from EPPR valve.
- (2) Insert the adapter to CN-75 and install multimeter as figure.
- (3) Start engine.
- (4) Set S-mode and cancel auto decel mode.
- (5) Position the accel dial at 10.
- (6) If tachometer show approx 1750 ± 50 rpm disconnect one wire harness from EPPR valve.
- (7) Check electric current at bucket circuit relief position.

Spec : 100~700 mA

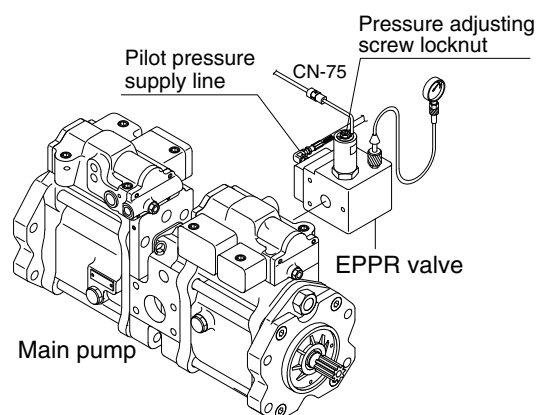


21095MS21

2) CHECK PRESSURE AT EPPR VALVE

- (1) Remove plug and connect pressure gauge as figure.
 - Gauge capacity : 0 to 50kgf/cm²
(0 to 725psi)
- (2) Start engine.
- (3) Set S-mode and cancel auto decel mode.
- (4) Position the accel dial at 10.
- (5) If tachometer show approx 1750 ± 50 rpm, check pressure at relief position of bucket circuit by operating bucket control lever.
- (6) If pressure is not correct, adjust it.
- (7) After adjust, test the machine.

Spec : 10~38 kgf/cm² (142~540 psi)



2107A5MS13

GROUP 11 MONITORING SYSTEM

1. OUTLINE

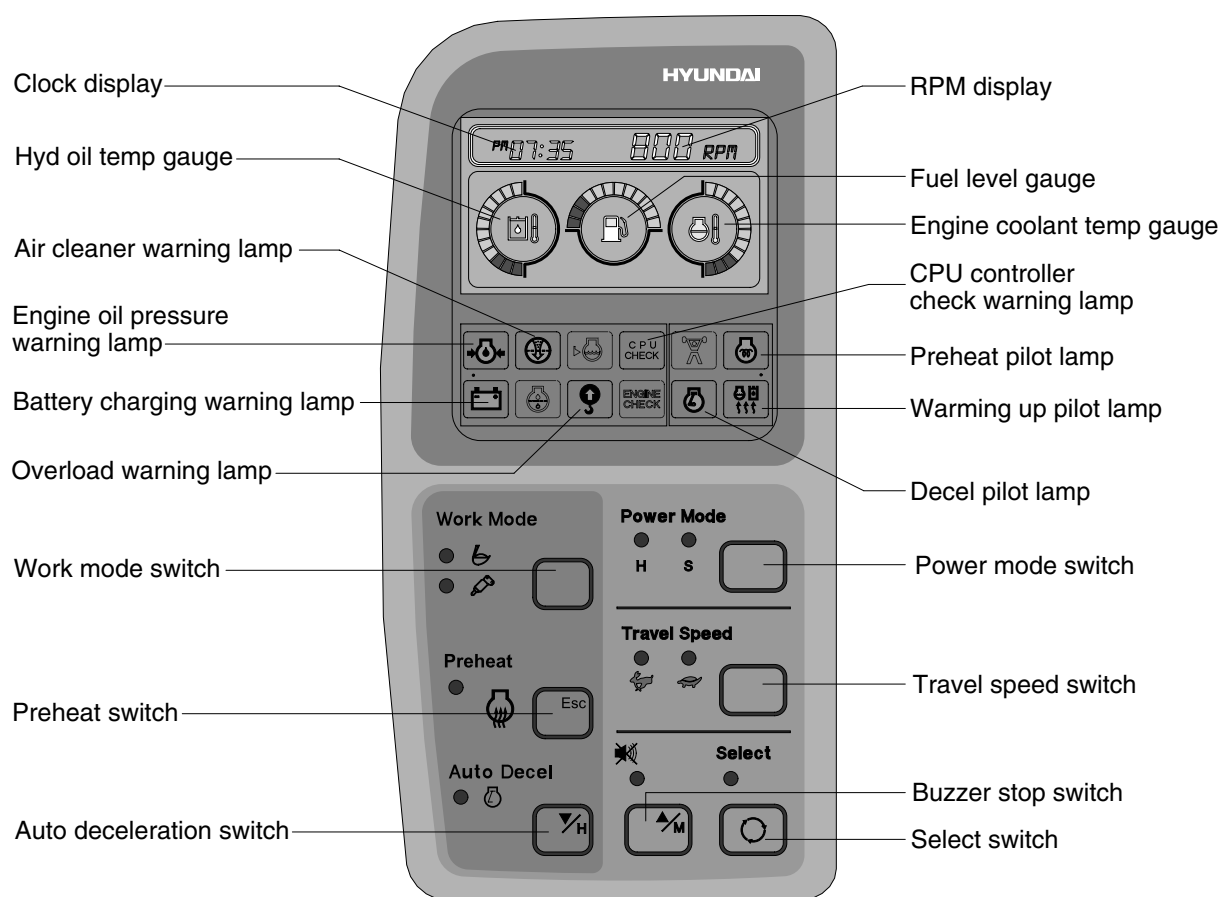
Monitoring system consists of the monitor part and switch part.

The monitor part gives warnings when any abnormality occurs in the machine and informs the condition of the machine.

Various select switches are built into the monitor panel, which act as the control portion of the machine control system.

2. CLUSTER

1) MONITOR PANEL



2107V5MS65

2) CLUSTER CHECK PROCEDURE

(1) Start key : ON

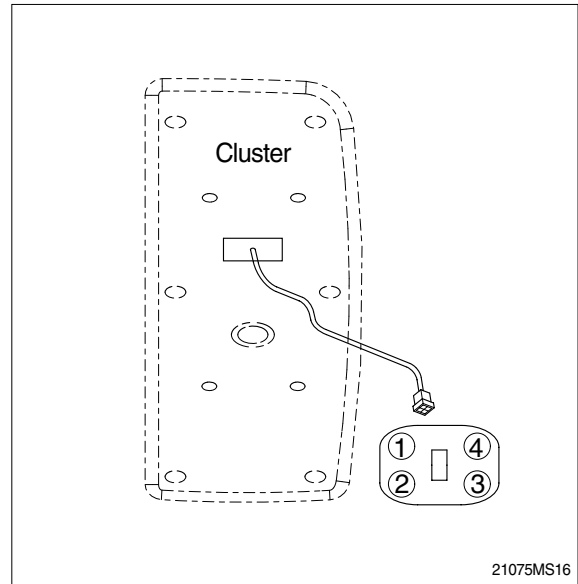
- ① Check monitor initial 5 seconds
 - a. All lamps light up.
 - b. Buzzer sound.
- ② Check monitor after 2 seconds : Indicate cluster version and machine condition
 - a. Cluster program version : CL : 2.2 ← Indicates program version 2.2 for 2 seconds.
 - b. Tachometer : 0rpm
 - c. Fuel gauge : All light up below appropriate level
 - d. Hydraulic temperature : All light up below appropriate level
 - e. Engine coolant temperature gauge : All light up below appropriate level
 - f. Warning lamp
 - ※ During start key **ON** the engine oil pressure lamp and battery charging lamp go on, but it is not abnormal.
 - ※ When engine coolant temperature below 30°C, the warming up lamp lights up.
- ③ Indicating lamp state
 - a. Work mode selection : General work
 - b. Power mode selection : S mode
 - c. User mode selection : No LED ON
 - d. Auto decel LED : ON
 - e. Travel speed pilot lamp : Low (turtle)

(2) Start of engine

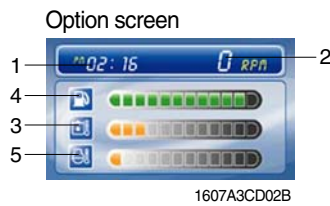
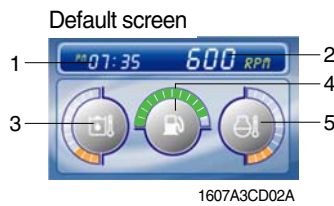
- ① Check machine condition
 - a. Tachometer indicates at present rpm
 - b. Gauge and warning lamp : Indicate at present condition.
 - ※ When normal condition : All warning lamp OFF
 - c. Work mode selection : General work
 - d. Power mode selection : S mode
 - e. User mode selection : No LED ON
 - f. Auto decel LED : ON
 - g. Travel speed pilot lamp : Low (turtle)
- ② When warming up operation
 - a. Warming up lamp : ON
 - b. 10 seconds after engine started, engine speed increases to 1200rpm (auto decel LED : ON)
 - ※ Others same as above ①.
- ③ When abnormal condition
 - a. The lamp lights up and the buzzer sounds.
 - b. If **BUZZER STOP** switch is pressed, buzzer sound is canceled but the lamp light up until normal condition.

3. CLUSTER CONNECTOR

| No. | Signal | Input / Output |
|-----|---------------|----------------|
| 1 | Power IG(24V) | Input(20~32V) |
| 2 | GND | Input(0V) |
| 3 | Serial-(RX) | Input(Vpp=12V) |
| 4 | Serial+(TX) | Output(Vpp=4V) |



4. LCD MAIN OPERATION DISPLAY



- 1 Time display
- 2 RPM display
- 3 Hydraulic oil temperature gauge
- 4 Fuel level gauge
- 5 Engine coolant temperature gauge

1) Time display



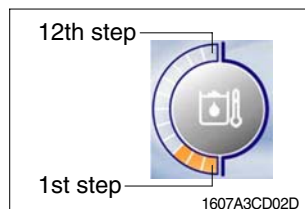
- ① This displays the current time.

2) RPM display



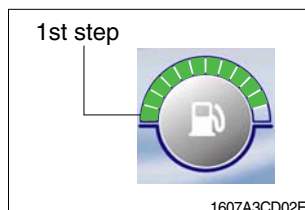
- ① This displays the engine rpm.

3) Hydraulic oil temperature gauge



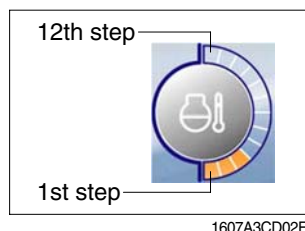
- ① This gauge indicates the temperature of hydraulic oil in 12 step gauge.
 - 1st step : Below 30°C(86°F)
 - 2nd~10th step : 30-105 °C(86-221°F)
 - 11th~12th step : Above 105°C(221°F)
- ② The gauge between 2nd and 10th steps illuminates when operating.
- ③ Keep idling engine at low speed until the gauge between 2nd and 10th steps illuminates, before operation of machine.
- ④ When the gauge of 11th and 12th steps illuminates, reduce the load on the system. If the gauge stays in the 11th~12th steps, stop the machine and check the cause of the problem.

4) Fuel level gauge



- ① This gauge indicates the amount of fuel in the fuel tank.
- ② Fill the fuel when the 1st step or fuel icon blinks in red.
- ※ **If the gauge illuminates the 1st step or fuel icon blinks in red even though the machine is on the normal condition, check the electric device as that can be caused by the poor connection of electricity or sensor.**

5) Engine coolant temperature gauge



- ① This gauge indicates the temperature of coolant in 12 step gauge.
 - 1st step : Below 30°C(86°F)
 - 2nd~10th step : 30-105 °C(86-221°F)
 - 11th~12th step : Above 105°C(221°F)
- ② The gauge between 2nd and 10th steps illuminates when operating.
- ③ Keep idling engine at low speed until the gauge between 2nd and 10th steps illuminates, before operation of machine.
- ④ When the gauge of 11th and 12th steps illuminates, turn OFF the engine, check the radiator and engine.

5. WARNING OF MAIN OPERATION SCREEN

1) WARNING DISPLAY

(1) Engine coolant temperature



- This lamp blinks and the buzzer sounds when the temperature of coolant is over the normal temperature 105°C(221°F).
- Check the cooling system when the lamp blinks.

(2) Fuel level



- This lamp blinks and the buzzer sounds when the level of fuel is below 31 l (8.2 U.S. gal).
- Fill the fuel immediately when the lamp blinks.

(3) Hydraulic oil temperature



- This warning lamp operates and the buzzer sounds when the temperature of hydraulic oil is over 105 °C(221°F).
- Check the hydraulic oil level when the lamp blinks.
- Check for debris between oil cooler and radiator.

(4) All gauge



- This lamp blinks and the buzzer sounds when the all gauge is abnormal.
- Check the each system when the lamp blinks.

(5) Communication error



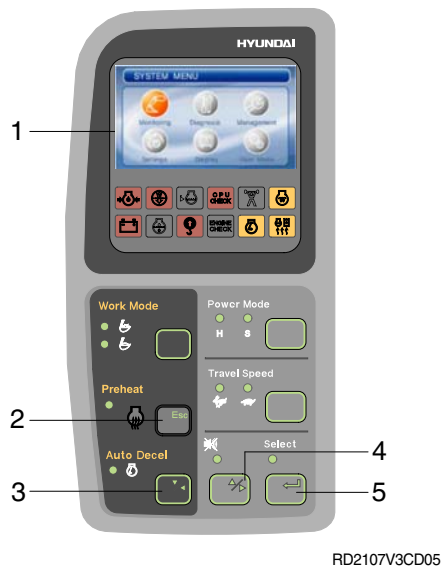
- Communication problem between CPU controller and cluster makes the lamp blinks and the buzzer sounds.
- Check if any fuse for CPU burnt off.
If not check the communication line between them.






2) POP-UP ICON DISPLAY

| No | Switch | Selected mode | Display |
|----|-------------------|--------------------------|---------|
| 1 | Work mode switch | General work mode | |
| | | Heavy duty work mode | |
| | | Breaker operation mode | |
| 2 | Power mode switch | High power work mode | |
| | | Standard power work mode | |

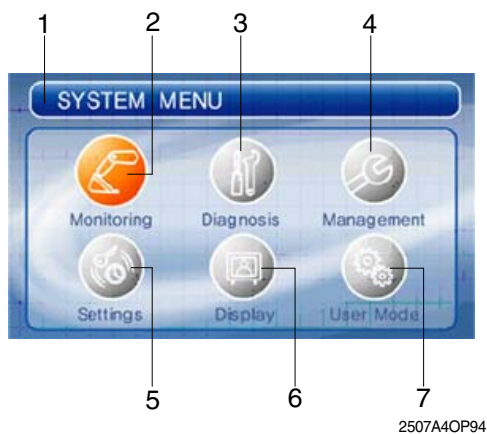
| No | Switch | Selected mode | Display |
|----|-----------------------------|---------------|---------|
| 3 | Auto deceleration switch | Light ON | |
| | | Light OFF | |
| 4 | Travel speed control switch | Low speed | |
| | | High speed | |


6. LCD



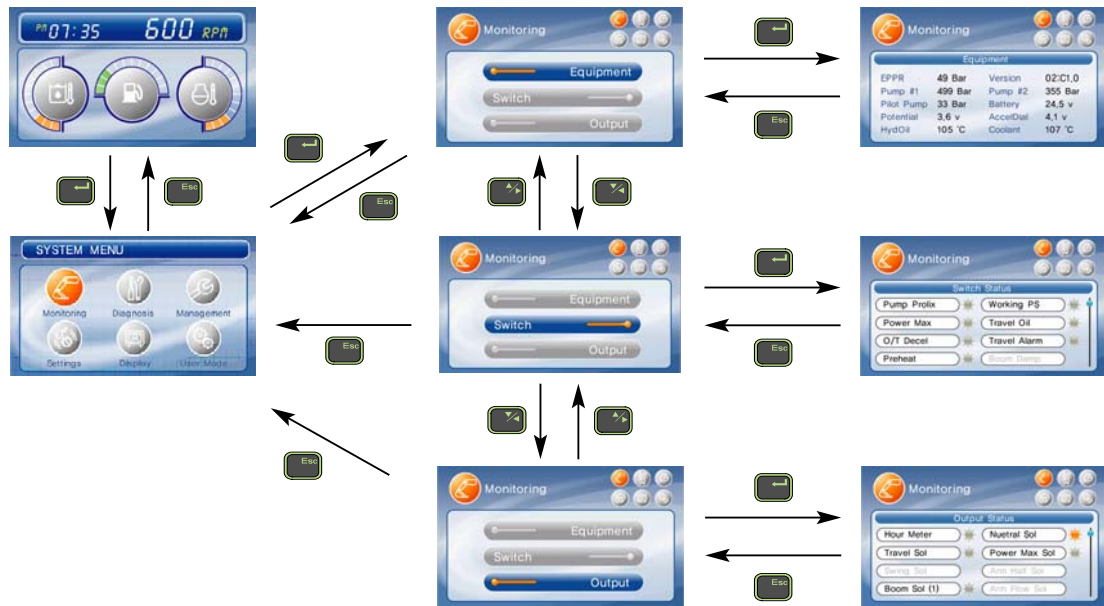
- 1  : LCD
- 2  : Escape,
Return to the previous menu
- 3  : Down/Left Direction
- 4  : Up/Right Direction
- 5  : Select(Enter)
Activate the currently chosen item

1) MAIN MENU

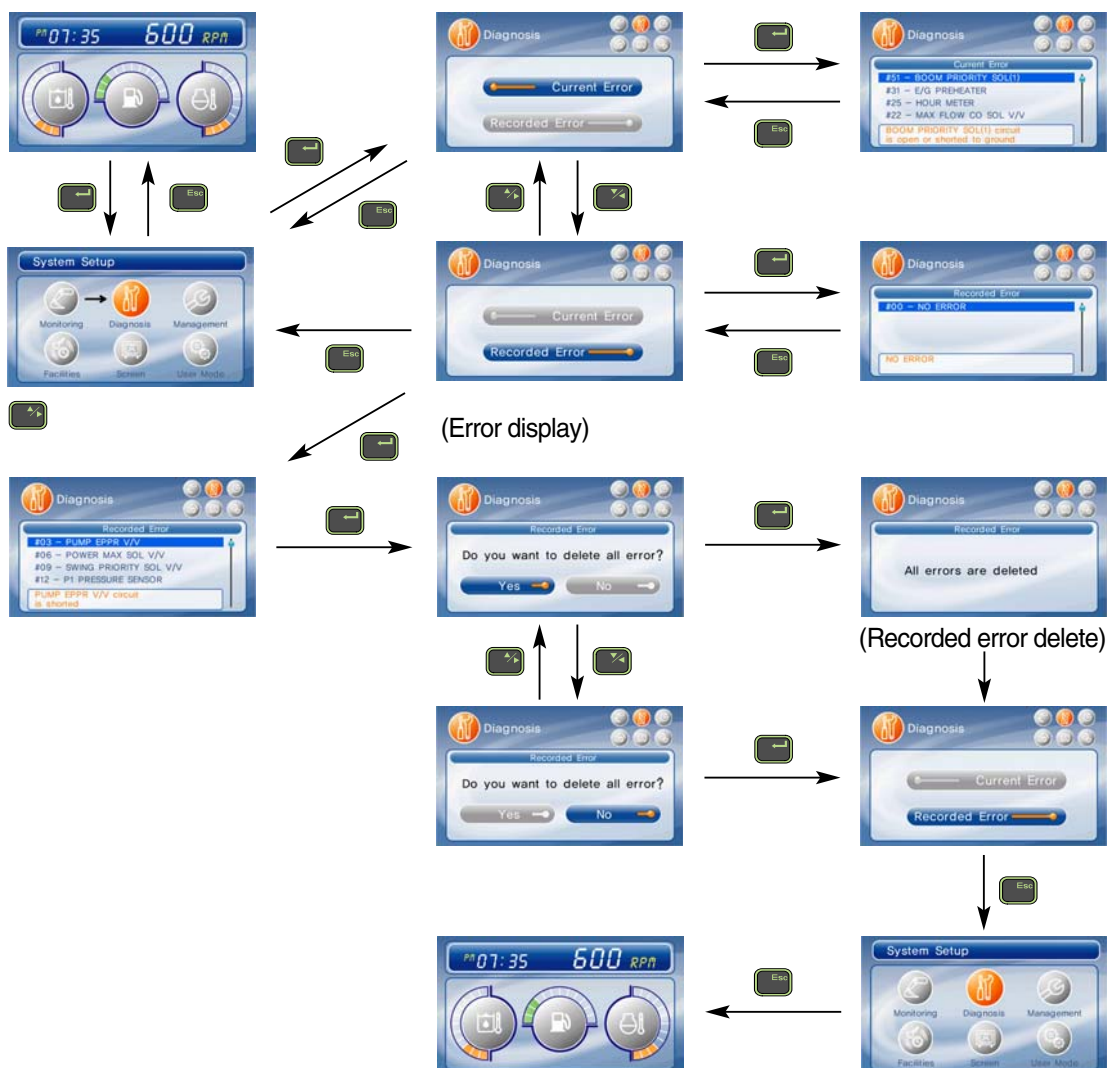


- 1  : Menu information
- 2  : Monitoring
- Equipment, Switch, Output
- 3  : Diagnosis
- Current error, Recorded error
- 4  : Maintenance
- 5  : Settings
- Time set, Dual mode
- System lock(Reserved)
- 6  : Display
- Operation skin, Brightness, Language
- 7  : User mode

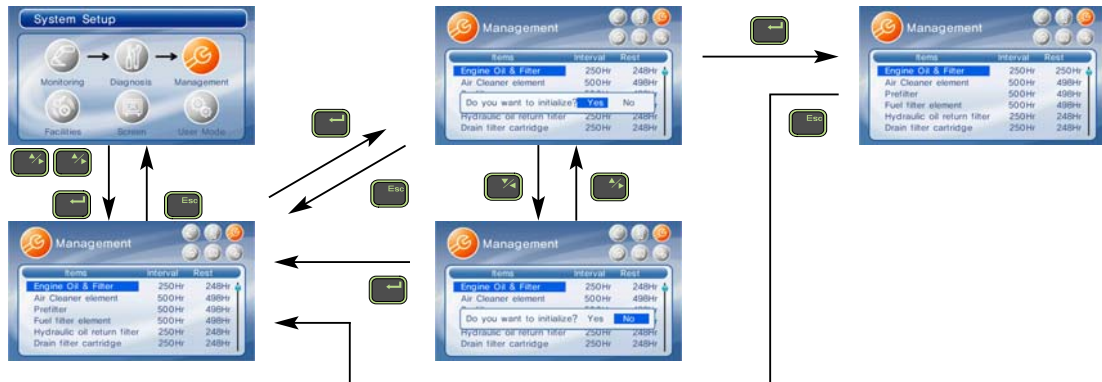
(1) Monitoring



(2) Diagnosis



(3) Maintenance



(4) Setting

① Time set



② System lock - Reserved

③ Dual mode - Changing the MCU mode

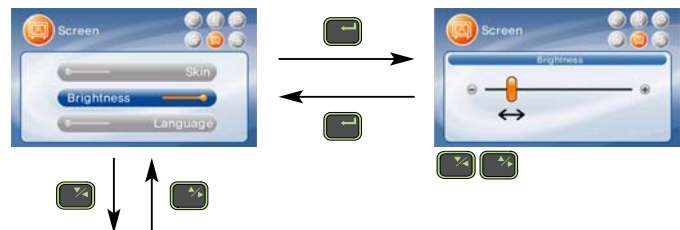


(5) Display

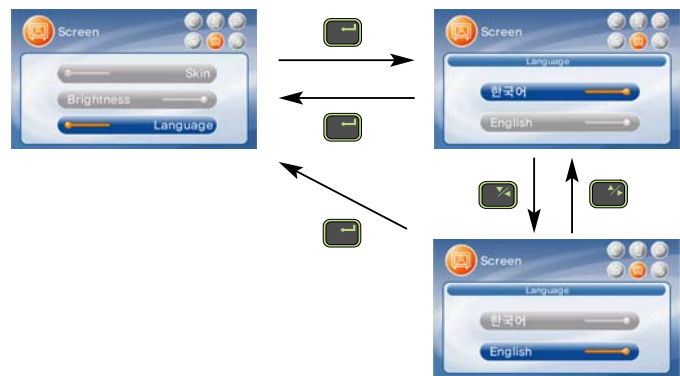
① Operation skin



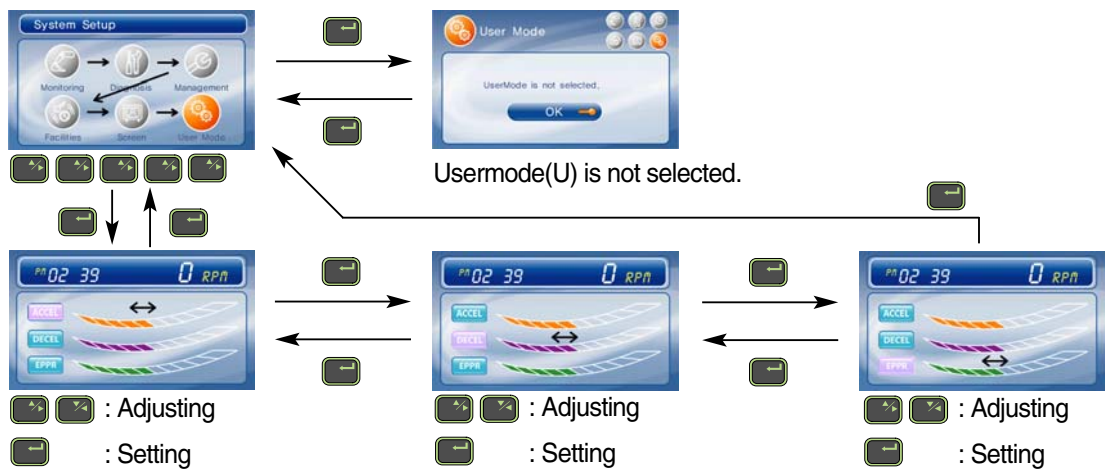
② Brightness



③ Language

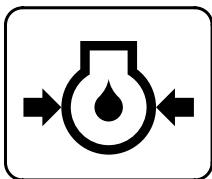


(6) User mode



7. WARNING AND PILOT LAMP

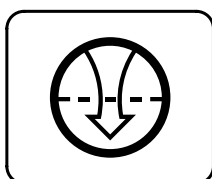
1) Engine oil pressure warning lamp



21073CD07

- ① This lamp blinks and the buzzer sounds after starting the engine because of the low oil pressure.
- ② If the lamp blinks during engine operation, shut OFF engine immediately. Check oil level.

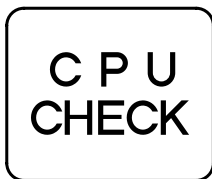
2) Air cleaner warning lamp



21073CD08

- ① This lamp blinks and the buzzer sounds when the filter of air cleaner is clogged.
- ② Check the filter and clean or replace it.

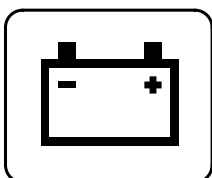
3) CPU controller check warning lamp



21073CD10

- ① If any fault code is received from CPU controller, this lamp blinks and the buzzer sounds.
- ② Check the communication line between CPU controller and cluster.

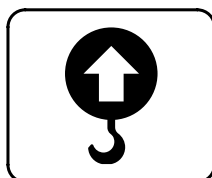
4) Battery charging warning lamp



21073CD13

- ① This lamp blinks and the buzzer sounds when the starting switch is ON, it is turned OFF after starting the engine.
- ② Check the battery charging circuit when this lamp blinks during engine operation.

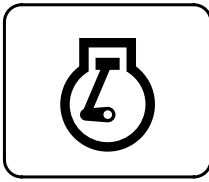
5) Overload warning lamp



21073CD15

- ① When the machine is overload, the overload warning lamp blinks during the overload switch is ON.

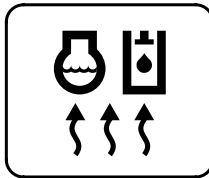
6) Decel pilot lamp



21073CD17

- ① Operating auto decel or one touch decel makes the lamp ON.
- ② The lamp will be ON when pushing one touch decel switch on the LH RCV lever.

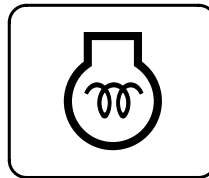
7) Warming up pilot lamp



21073CD18

- ① This lamp is turned ON when the coolant temperature is below 30°C (86 °F).
- ② The automatic warming up is cancelled when the engine coolant temperature is above 30 °C, or when 10 minutes have passed since starting.

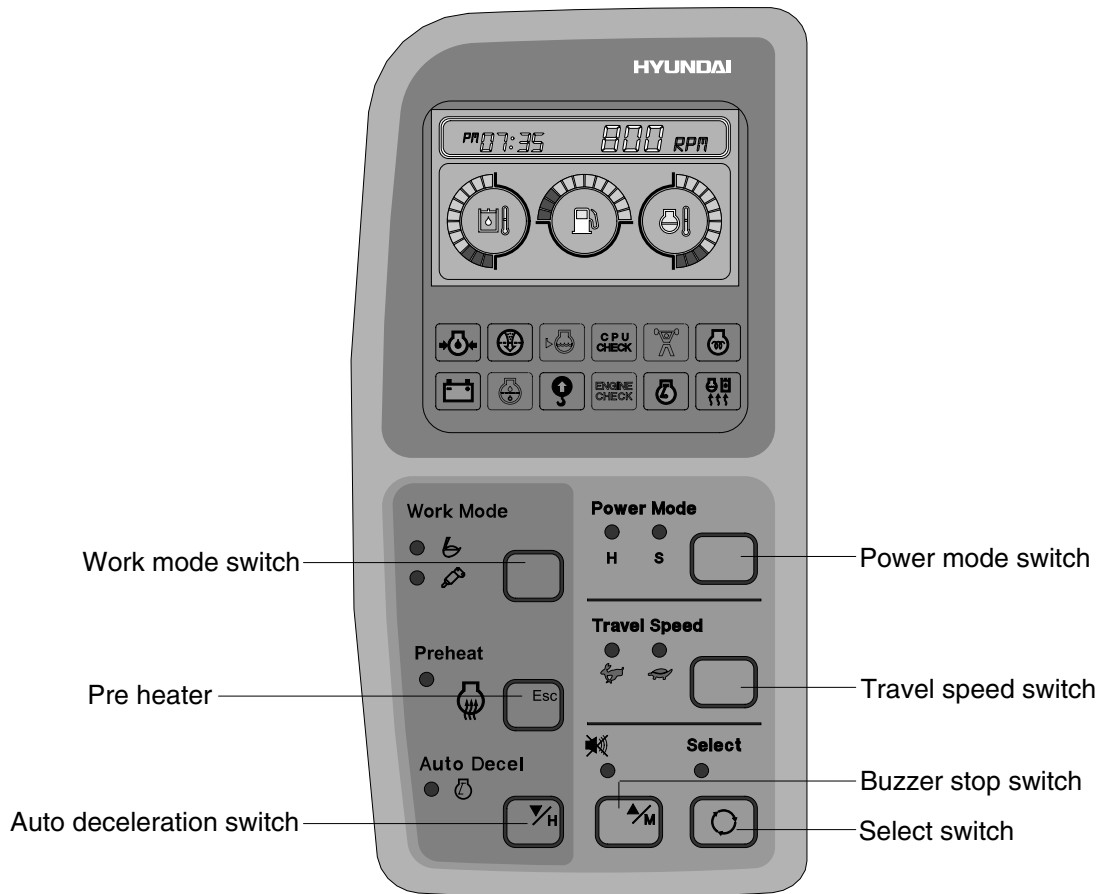
8) Preheat pilot lamp



21073CD12

- ① Turning the start key switch ON position starts preheating in cold weather.
- ② Start the engine as this lamp is OFF.

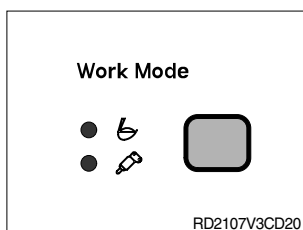
8. SWITCH PANEL



RD2107V3CD19

※ When the switches (Work mode, Power mode, Auto decel, Travel speed control) are selected, the pop-up icon is displayed on the LCD.

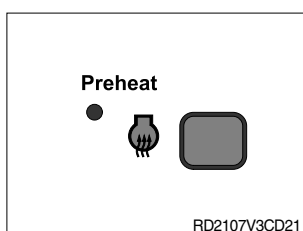
1) Work mode switch



① This switch is to select the machine operation mode, which shifts from general operation mode to breaker mode by pressing the switch.

- : General work mode
- : Breaker operation mode

2) Preheat switch



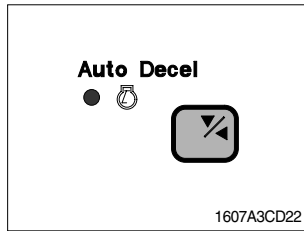
① This switch is used for starting the engine in cold weather.

If pressed, grid heater is activated to get easier engine starting.

※ **Never hold the push button switch in for more than 30 seconds, as this can damage the grid heater.**

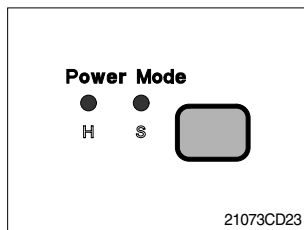
② The indicator lamp is turned ON when operating this switch.


3) Auto deceleration switch



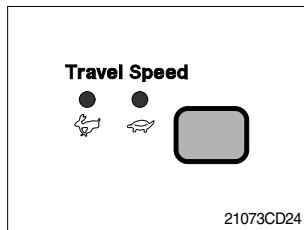
- ① This switch is used to actuate or cancel the auto deceleration function.
- ② When the switch actuated and all control levers and pedals are at neutral position, engine speed will be lowered automatically to save fuel consumption.
 - Light ON : Auto deceleration function is selected.
 - Light OFF : a. Auto deceleration function is cancelled so that the engine speed increased to previous setting value.
b. One touch decel function is available.

4) Power mode switch



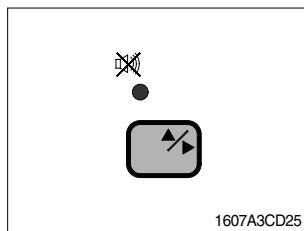
- ① The lamp of selected mode is turned ON by pressing the switch().
 - H : High power work.
 - S : Standard power work.

5) Travel speed control switch



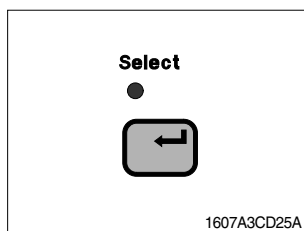
- ① This switch is to control the travel speed which is changed to high speed(Rabbit mark) by pressing the switch and low speed(Turtle mark) by pressing it again.

6) Buzzer stop switch



- ① When the starting switch is turned ON first, normally the alarm buzzer sounds for 2 seconds during lamp check operation.
- ② The red lamp lights ON and the buzzer sounds when the machine has a problem.
In this case, press this switch and buzzer stops, but the red lamp lights until the problem is cleared.

7) Select switch



- ① This switch is used to enter main menu and sub menu of LCD.

SECTION 6 TROUBLESHOOTING

| | |
|---|------|
| Group 1 Before Troubleshooting | 6-1 |
| Group 2 Hydraulic and Mechanical System | 6-4 |
| Group 3 Electrical System | 6-24 |
| Group 4 Mechatronics System | 6-40 |

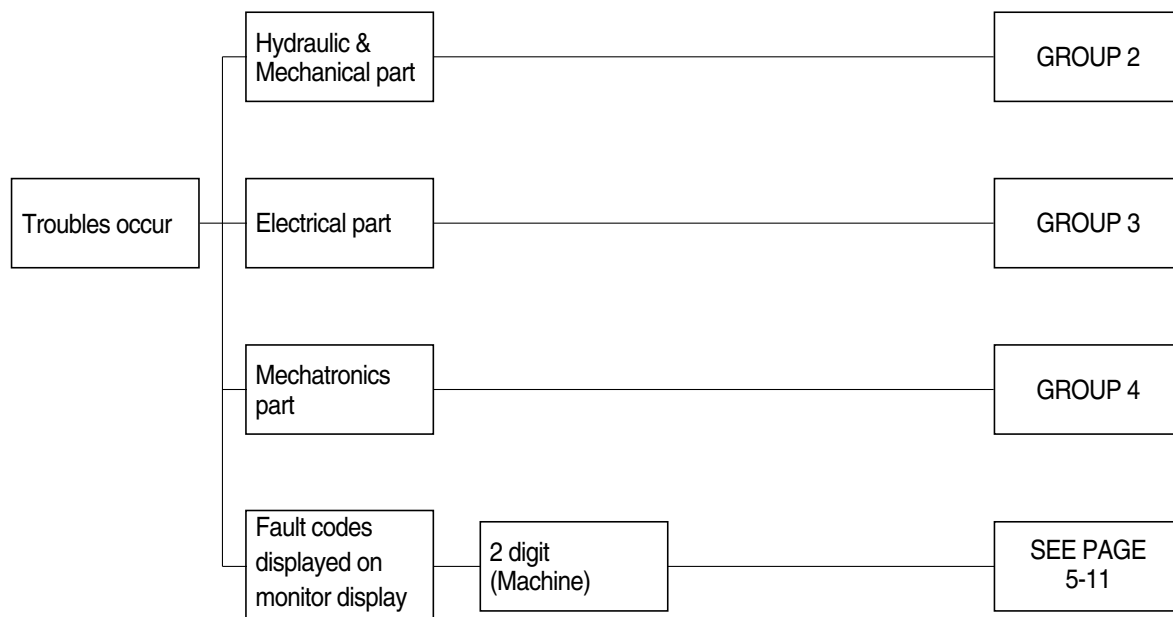
SECTION 6 TROUBLESHOOTING

GROUP 1 BEFORE TROUBLESHOOTING

1. INTRODUCTION

When a trouble is occurred in the machine, this section will help an operator to maintain the machine with easy.

The trouble of machine is parted Hydraulic & Mechanical system, Electrical system and Mechatronics system. At each system part, an operator can check the machine according to the troubleshooting process diagram.



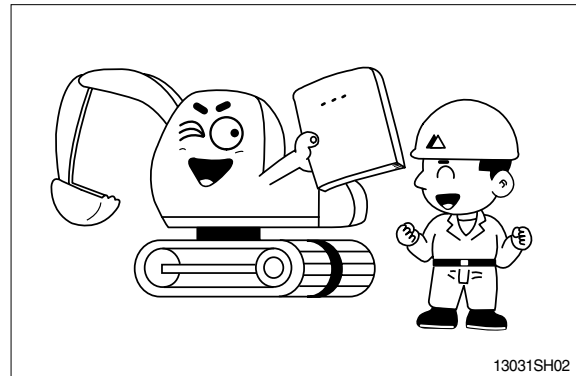
2. DIAGNOSING PROCEDURE

To carry out troubleshooting efficiently, the following steps must be observed.

STEP 1. Study the machine system

Study and know how the machine is operating, how the system is composing, what kinds of function are installed in the machine and what are specifications of the system components by the machine service manual.

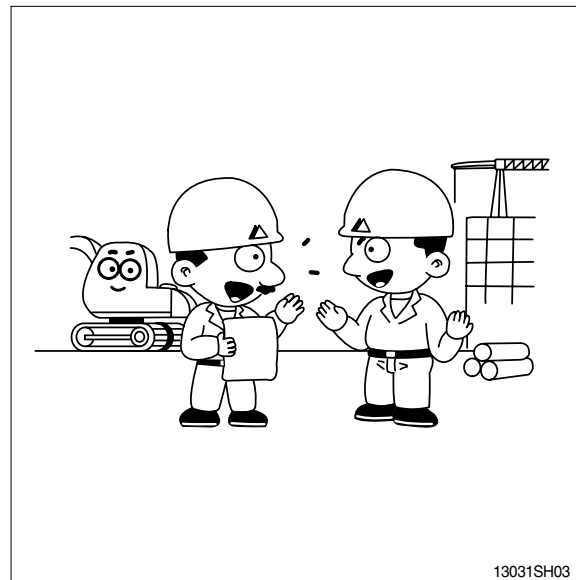
Especially, deepen the knowledge for the related parts of the trouble.



STEP 2. Ask the operator

Before inspecting, get the full story of malfunctions from a witness --- the operator.

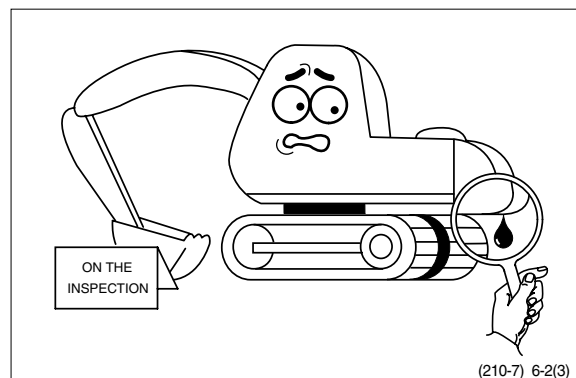
- 1) How the machine is used and when it is serviced?
- 2) When the trouble was noticed and what work the machine was doing at that time?
- 3) What is the phenomenon of the trouble?
Was the trouble getting worse, or did it come out suddenly for the first time?
- 4) Did the machine have any troubles previously? If so, which parts were repaired before.



STEP 3. Inspect the machine

Before starting troubleshooting, check the machine for the daily maintenance points as shown in the operator's manual.

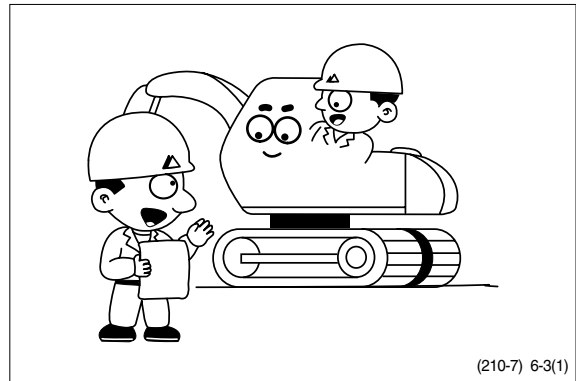
And also check the electrical system including batteries, as the troubles in the electrical system such as low battery voltage, loose connections and blown out fuses will result in malfunction of the controllers causing total operational failures of the machine.



STEP 4. Inspect the trouble actually on the machine

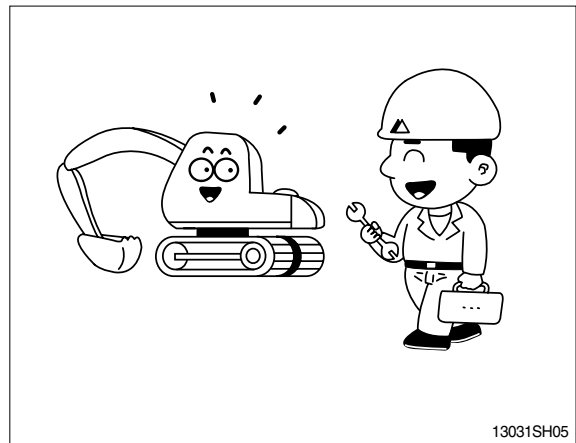
In case that some trouble cannot be confirmed, obtain the details of the malfunction from the operator.

Also, check if there are any in complete connections of the wire harnesses are or not.



STEP 5. Perform troubleshooting

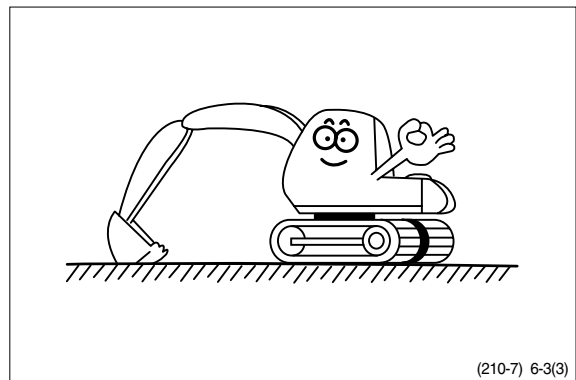
According to where the trouble parts are located, hydraulic & mechanical system part or electrical system part or mechatronics system part, perform troubleshooting the machine refer to the each system part's troubleshooting process diagram.



STEP 6. Trace a cause

Before reaching a conclusion, check the most susceptible causes again. Try to trace what the real cause of the trouble is.

Make a plan of the appropriate repairing procedure to avoid consequential malfunctions.



GROUP 2 HYDRAULIC AND MECHANICAL SYSTEM

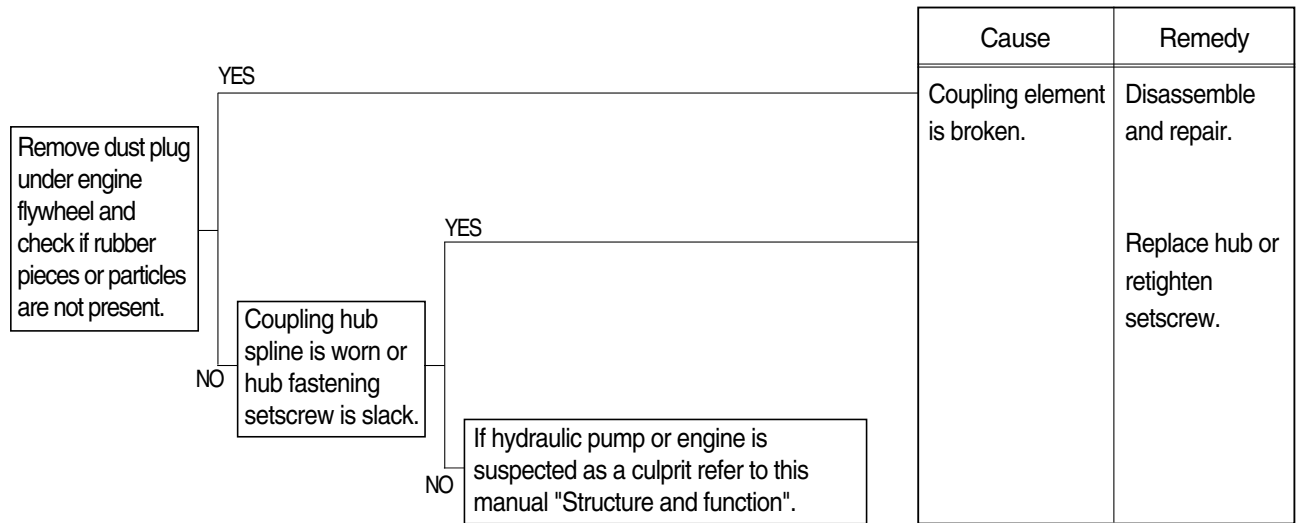
1. INTRODUCTION

1) MACHINE IN GENERAL

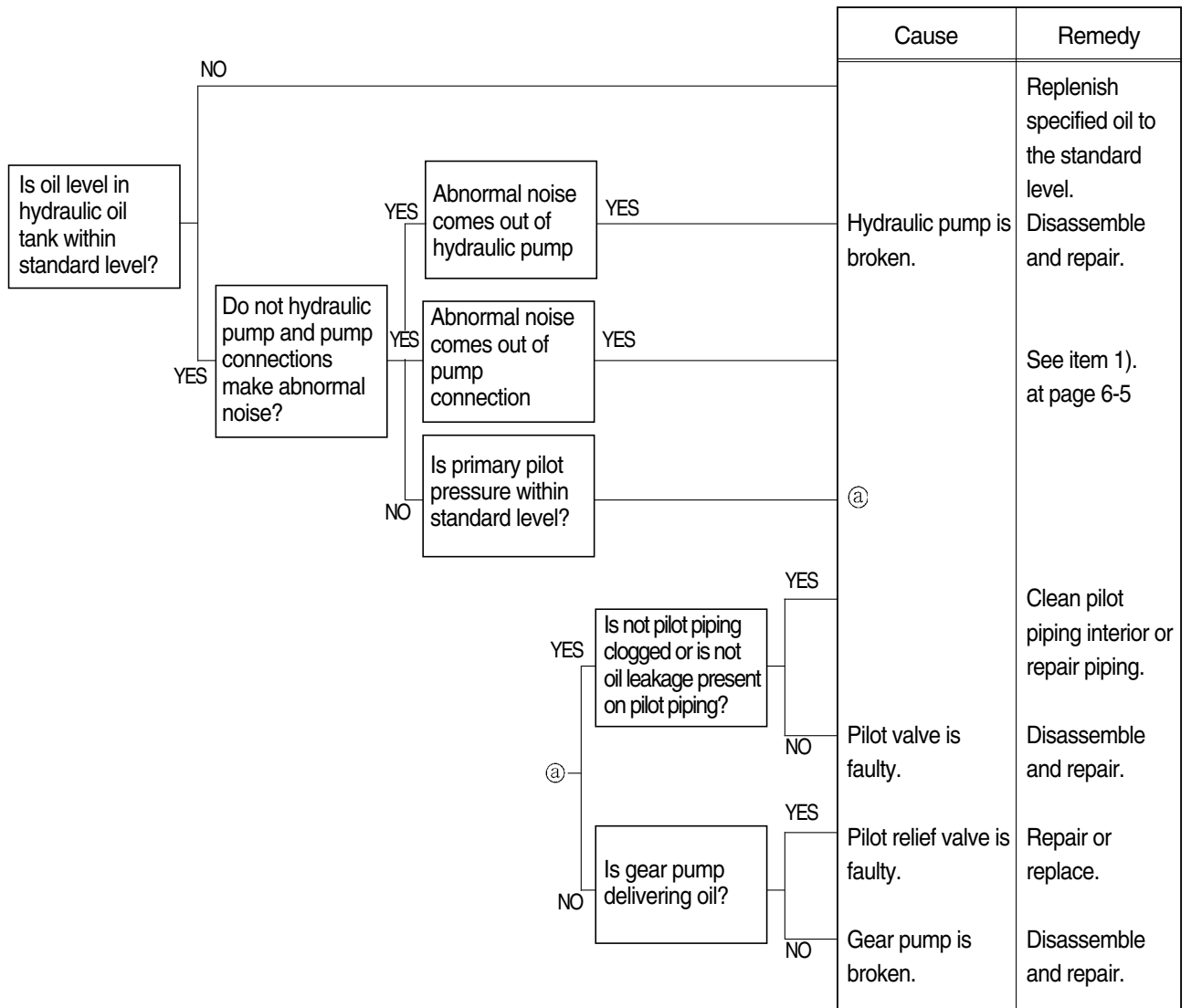
- (1) If even a minor fault is left intact and operation is continued, a fatal failure may be caused, entailing a large sum of expenses and long hours of restoration.
Therefore when even a small trouble occurs, do not rely on your intuition and experience, but look for the cause based on the troubleshooting principle and perform maintenance and adjustment to prevent major failure from occurring. Keep in mind that a fault results from a combination of different causes.
- (2) The following lists up commonly occurring faults and possible causes with this machine. For the troubleshooting of the engine, refer to the coming troubleshooting and repair.
- (3) When carrying out troubleshooting, do not hurry to disassemble the components.
It will become impossible to find the cause of the problem.
- (4) Ask user or operator the following.
 - ① Was there any strange thing about machine before failure occurred?
 - ② Under what conditions did the failure occur?
 - ③ Have any repairs been carried out before the failure?
- (5) Check before troubleshooting.
 - ① Check oil and fuel level.
 - ② Check for any external leakage of oil from components.
 - ③ Check for loose or damage of wiring and connections.

2. DRIVE SYSTEM

1) UNUSUAL NOISE COMES OUT OF PUMP CONNECTION



2) ENGINE STARTS BUT MACHINE DOES NOT OPERATE AT ALL



3. HYDRAULIC SYSTEM

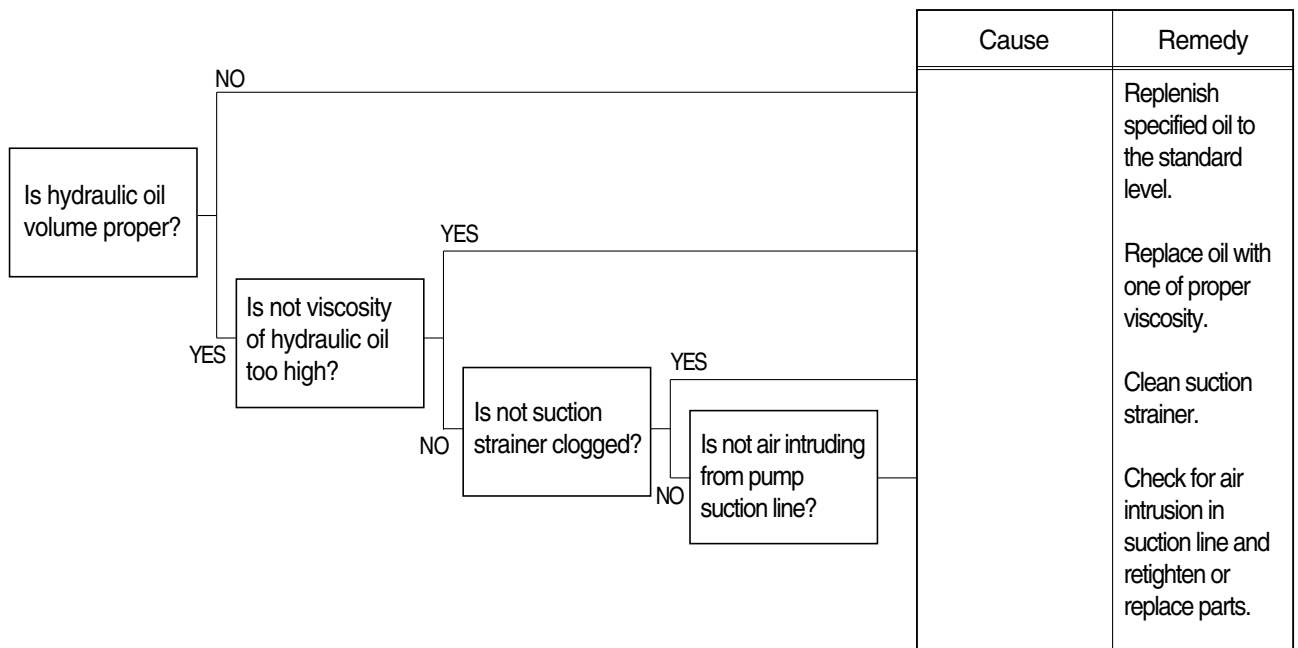
1) HYDRAULIC OIL IS CLOUDY

| | | Cause | Remedy |
|---|-----|------------------|--|
| <div>Drop hydraulic oil sample on hot plate and check if foams come up.</div> | YES | Water is mixed. | Put hydraulic oil still, separate water and dispose it or replace hydraulic oil. |
| | NO | Air is intruded. | Check suction line and return line and eliminate the air intruding source. |

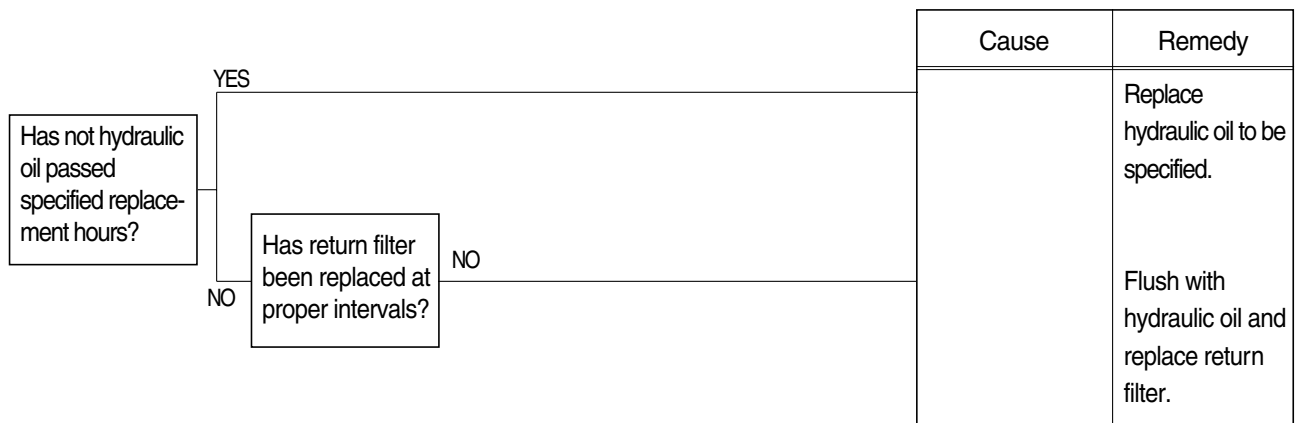
2) HYDRAULIC OIL TEMPERATURE HAS RISEN ABNORMALLY

| | | Cause | Remedy |
|--|--|--|--|
| <div>Is hydraulic oil volume proper?</div> | NO | <div>①</div> | Replenish specified oil to the standard level. Clean oil cooler. Secure air circulation route. |
| | YES | | Adjust belt tension or replace belt. |
| | <div>Is not oil cooler clogged and is anything blocking air circulation?</div> | | |
| | YES | | Readjust set pressure. |
| | NO | | |
| | <div>Is fan belt tension proper?</div> | | Reduce load. |
| <div>①</div> | YES | | |
| | NO | | |
| <div>Is not the set pressure of main relief, relief and travel relief valve lower than the standard level?</div> | YES | <div>Is main relief valve used very often?</div> | |
| | NO | YES | |

3) CAVITATION OCCURS WITH PUMP



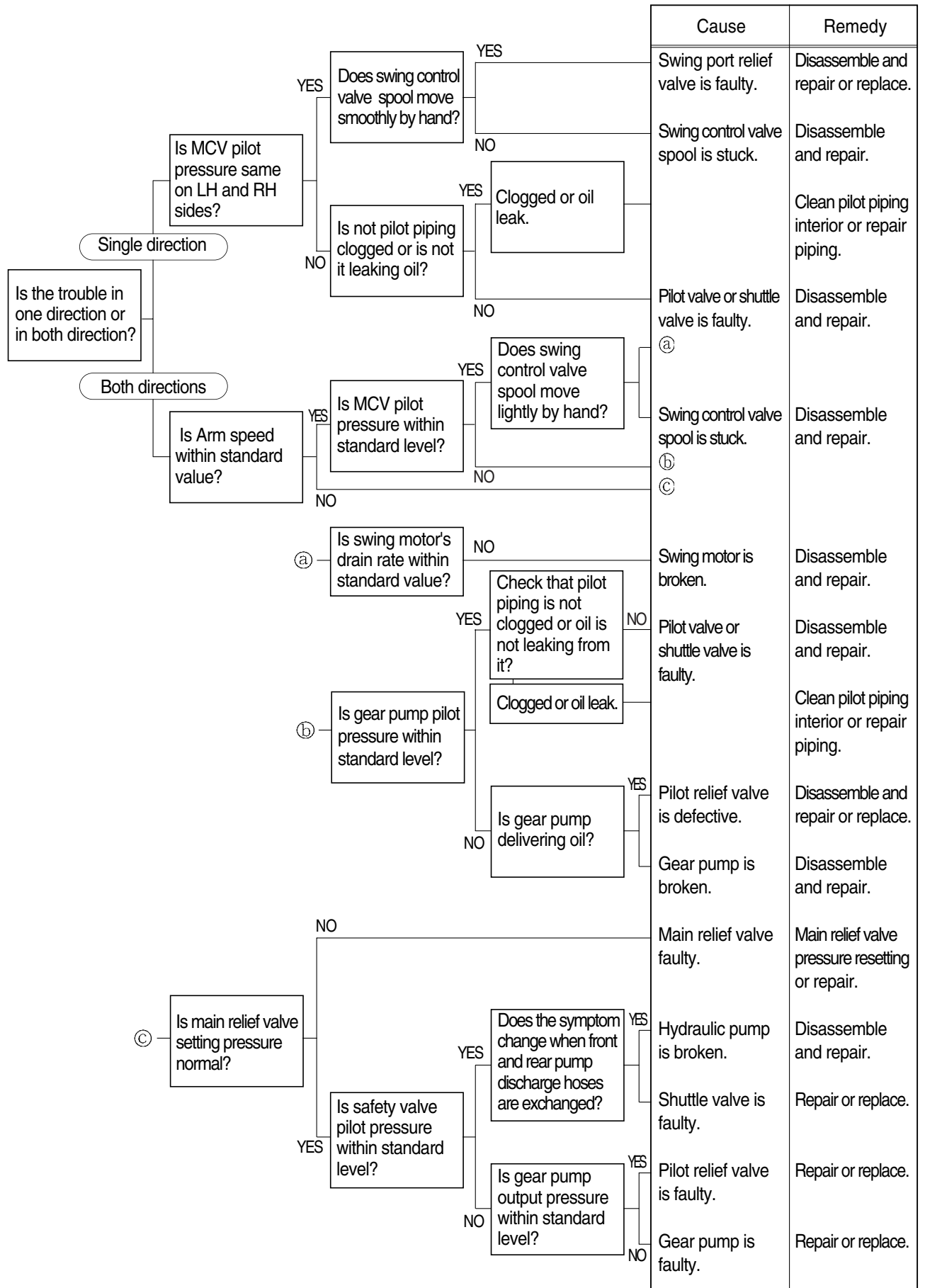
4) HYDRAULIC OIL IS CONTAMINATED



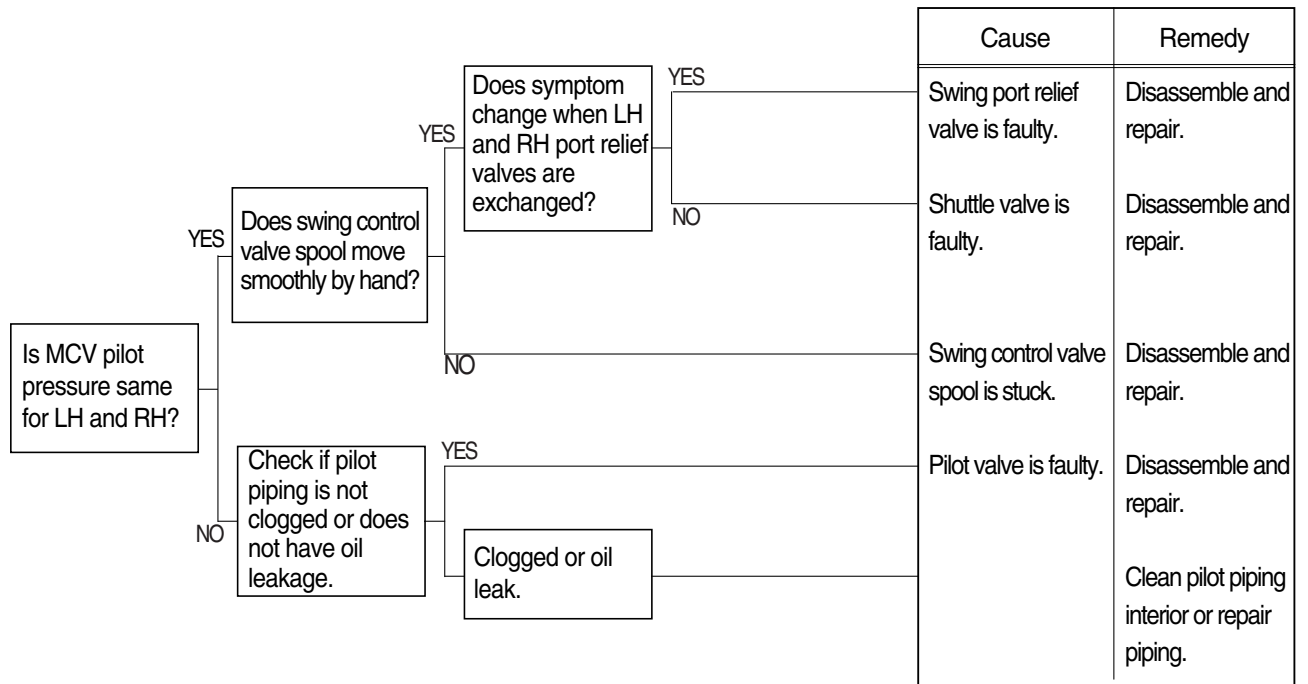
1) BOTH LH AND RH SWING ACTIONS ARE IMPOSSIBLE



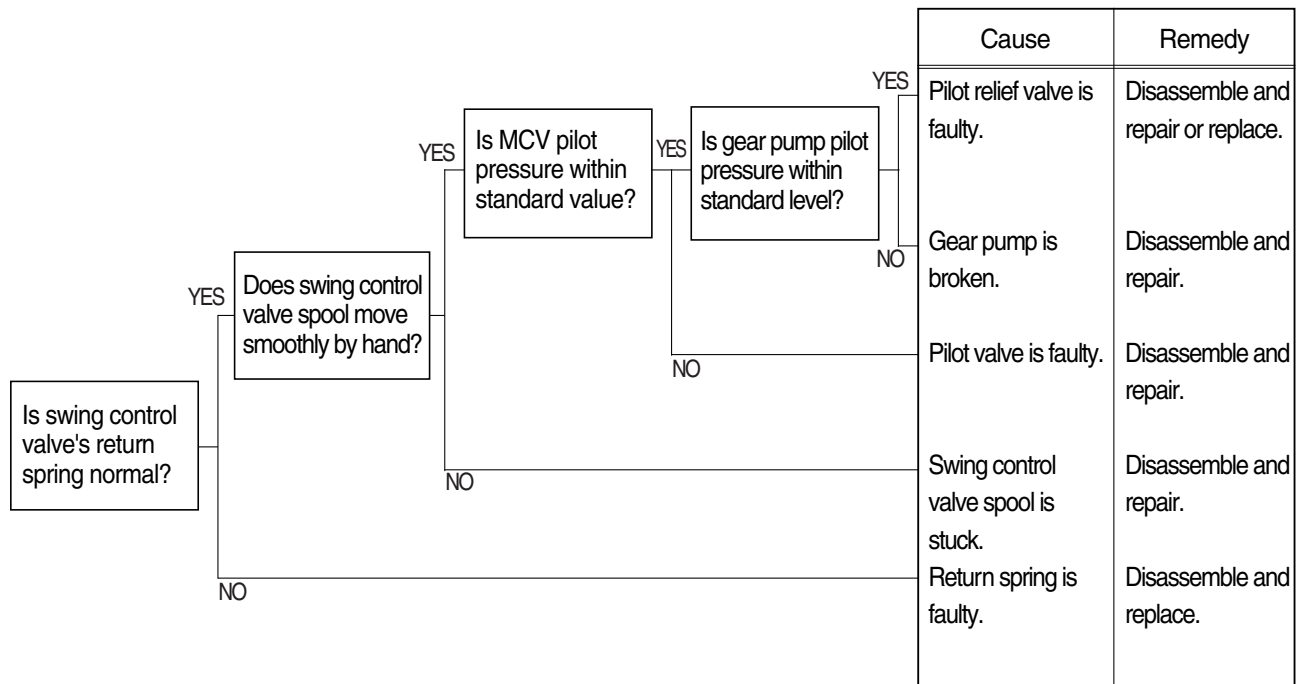
2) SWING SPEED IS LOW



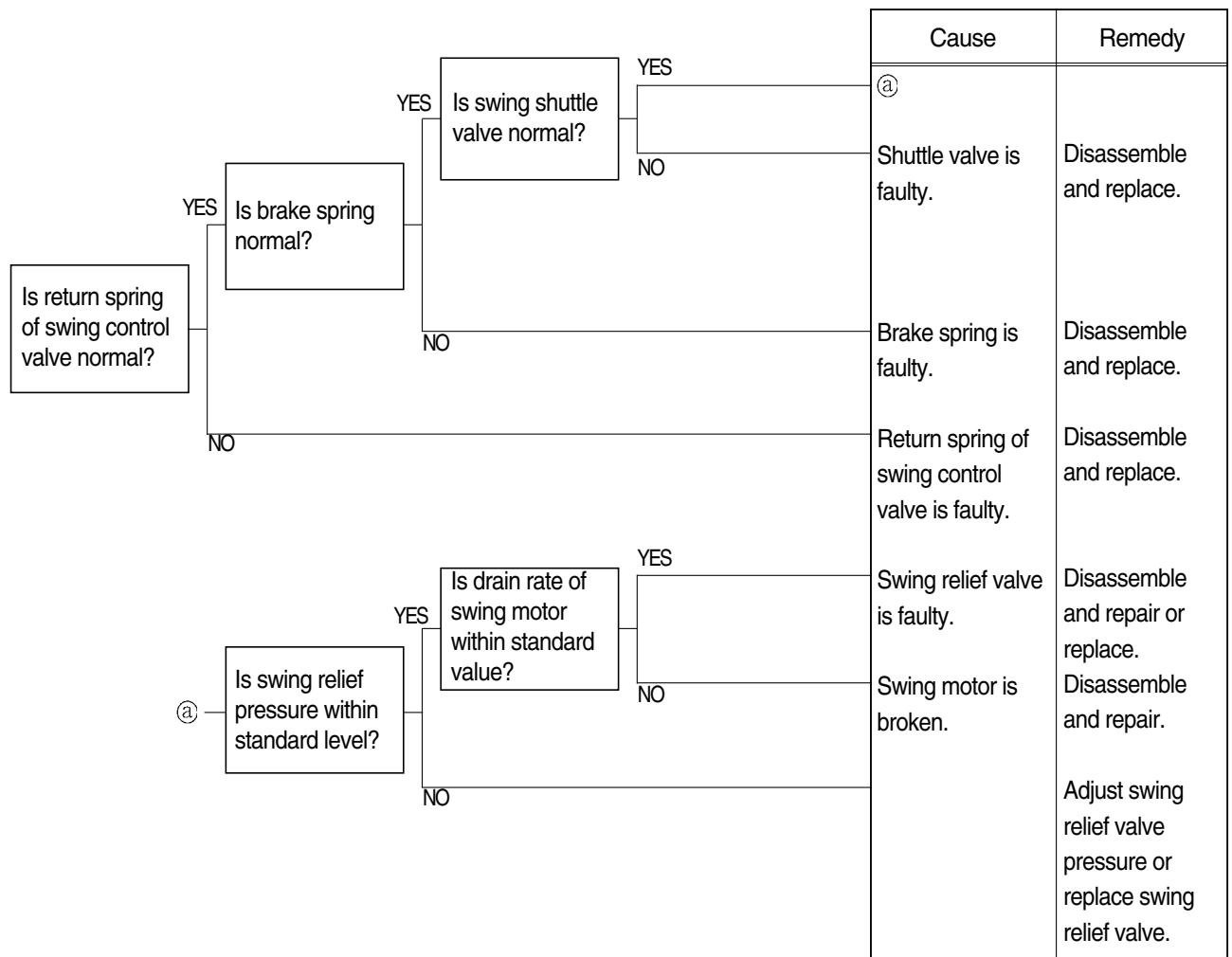
3) SWING MOTION IS IMPOSSIBLE IN ONE DIRECTION



4) MACHINE SWINGS BUT DOES NOT STOP

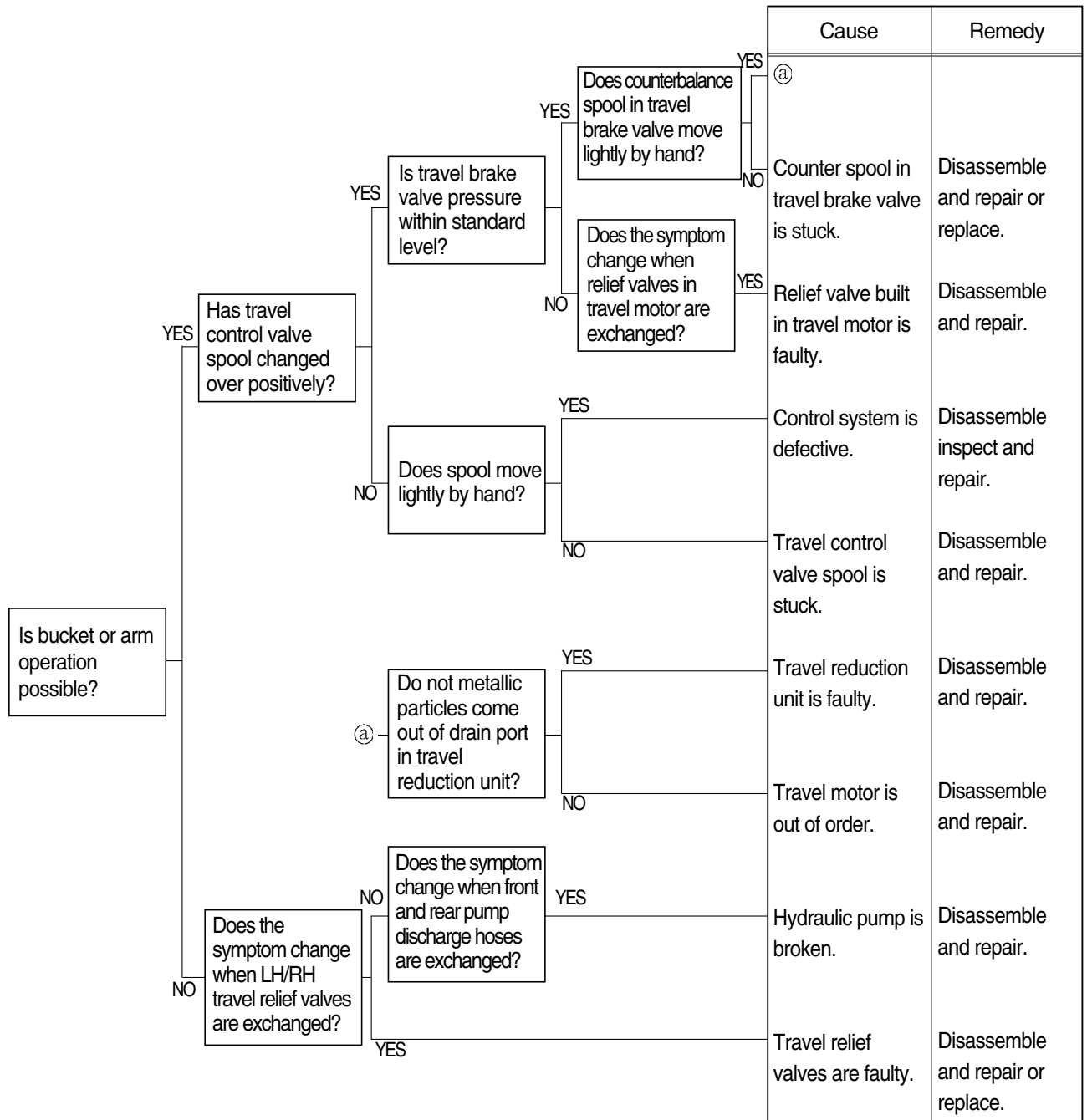


5) THE SWING UNIT DRIFTS WHEN THE MACHINE IS AT REST ON A SLOPE

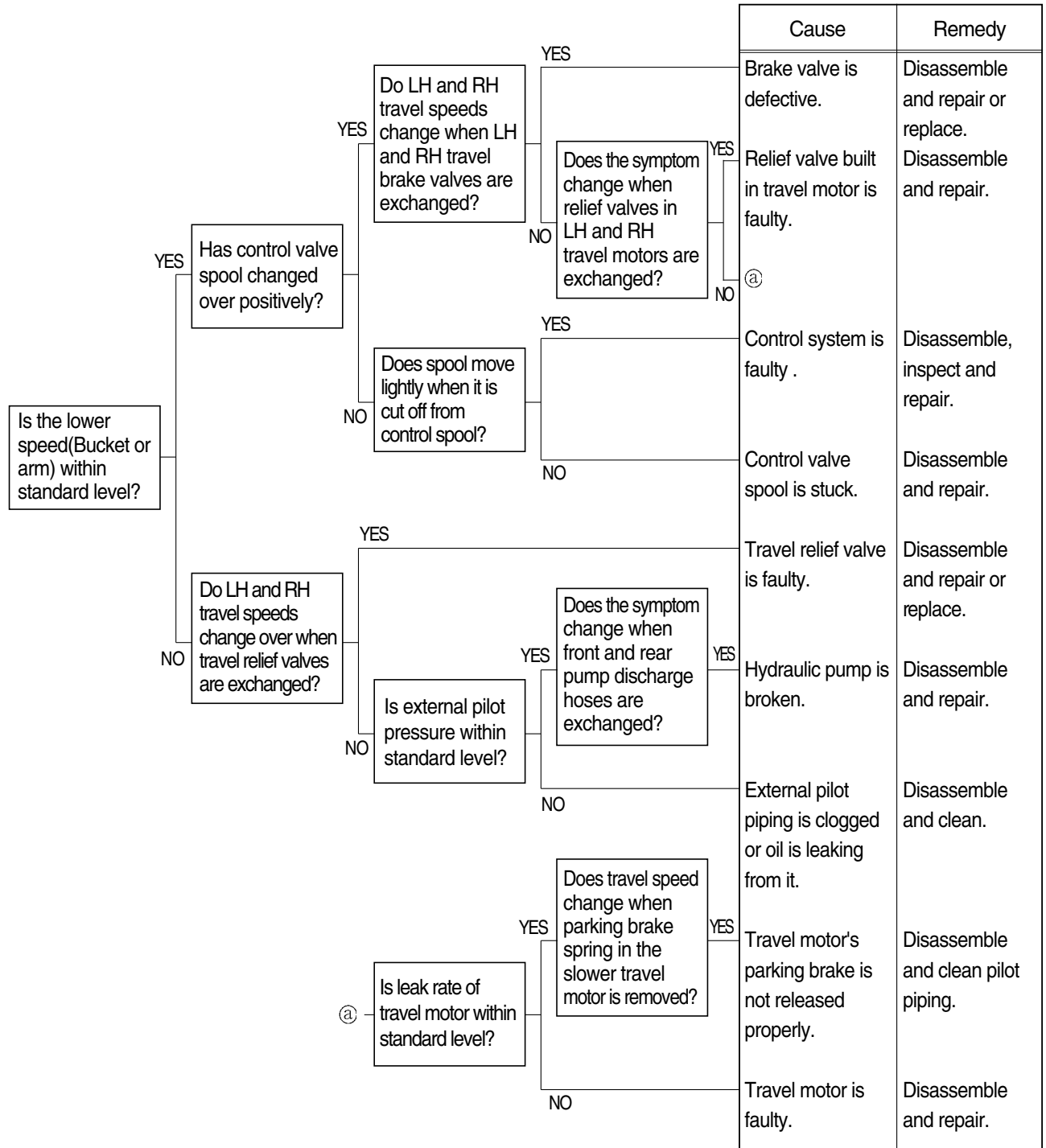


5. TRAVEL SYSTEM

1) TRAVEL DOES NOT FUNCTION AT ALL ON ONE SIDE

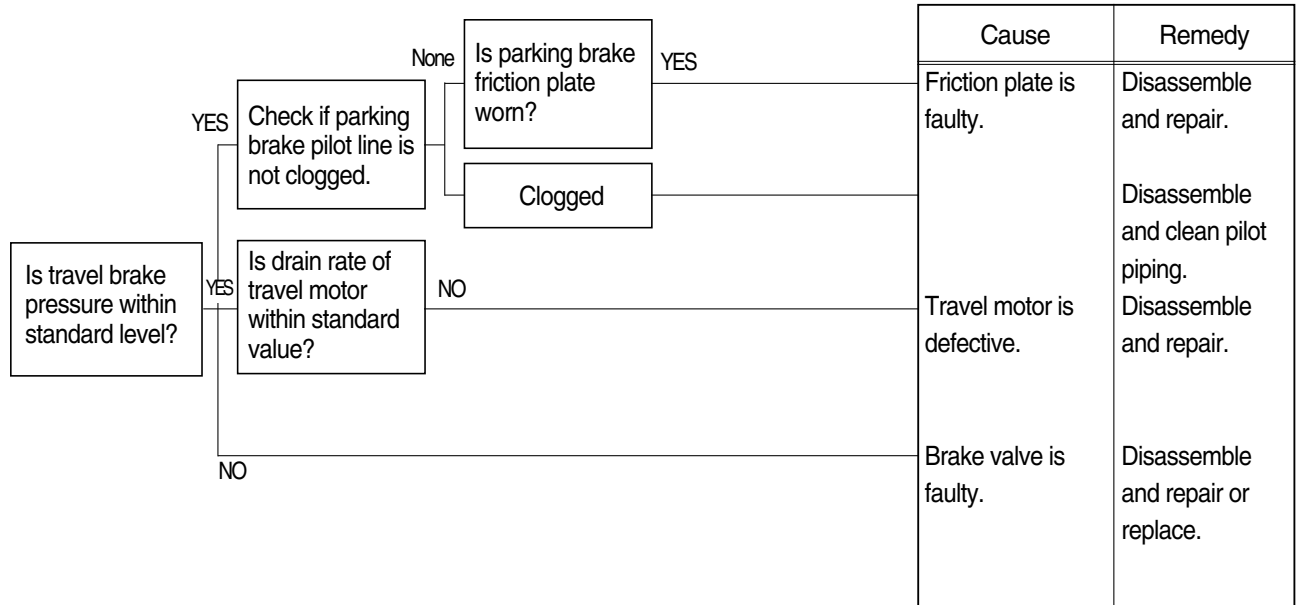


2) SPEED ON ONE SIDE FALLS AND THE MACHINE CURVES

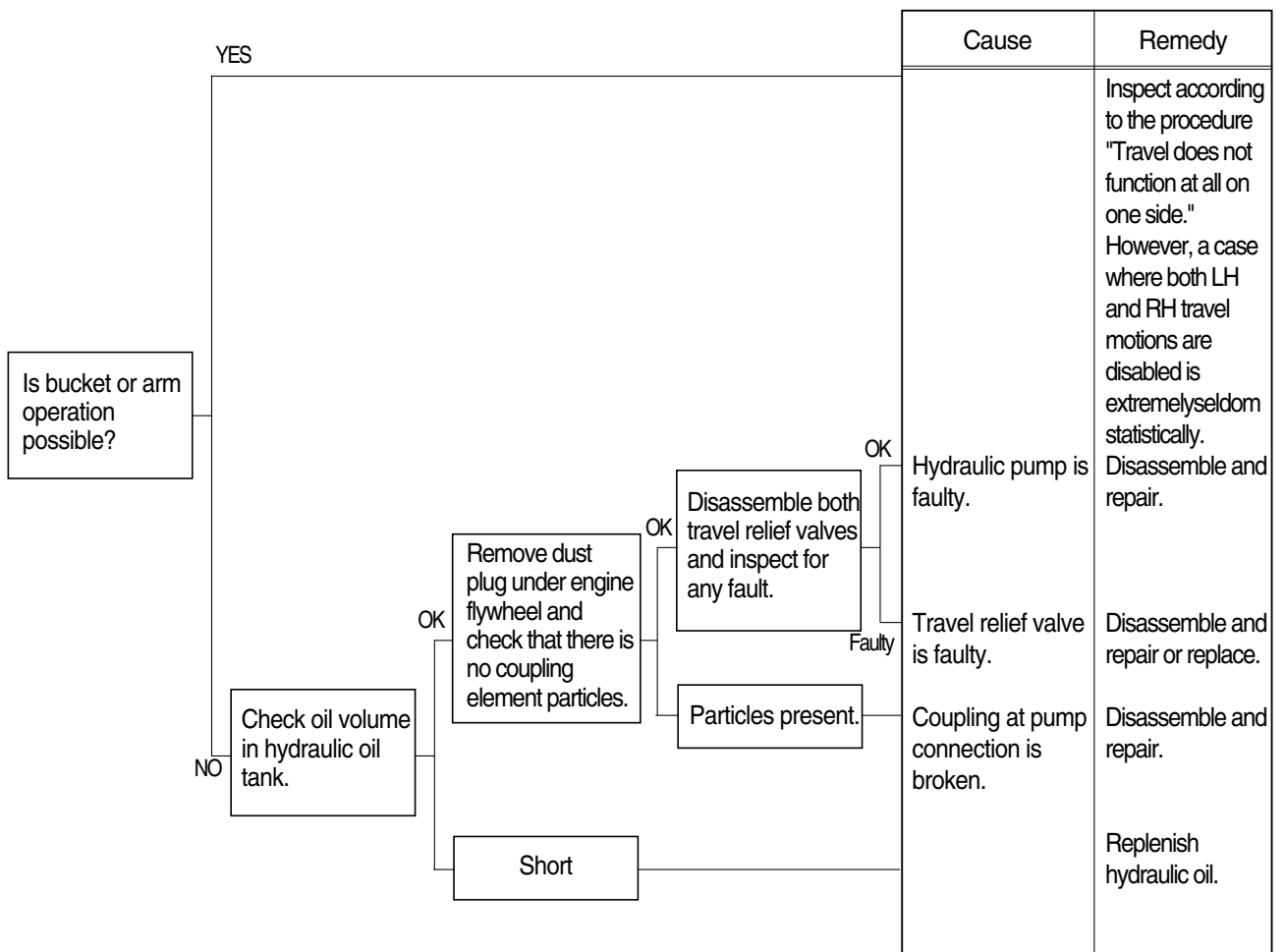


3) MACHINE DOES NOT STOP ON A SLOPE

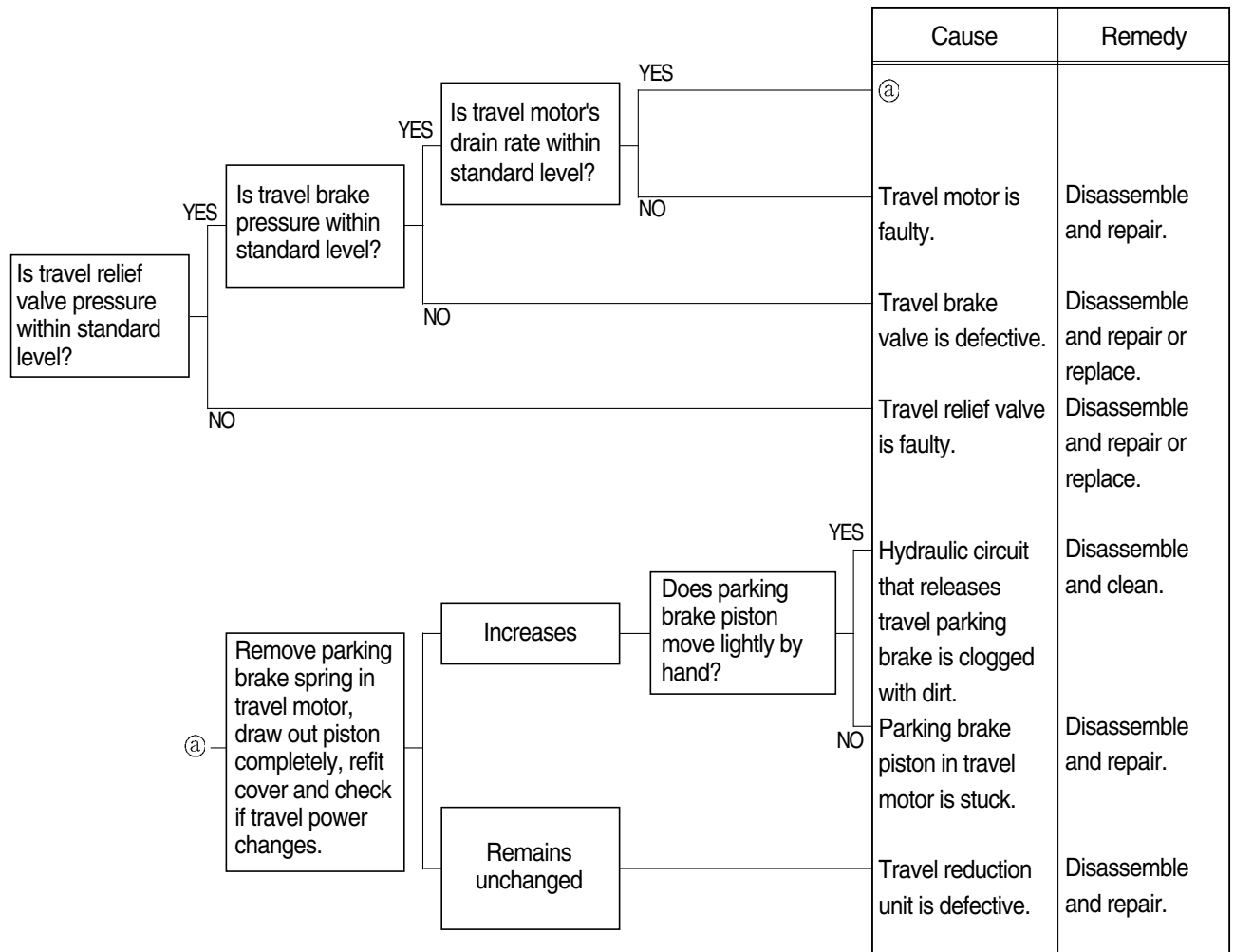
Machine is pulled forward as sprocket rotates during digging operation.



4) LH AND RH TRAVEL MOTIONS ARE IMPOSSIBLE



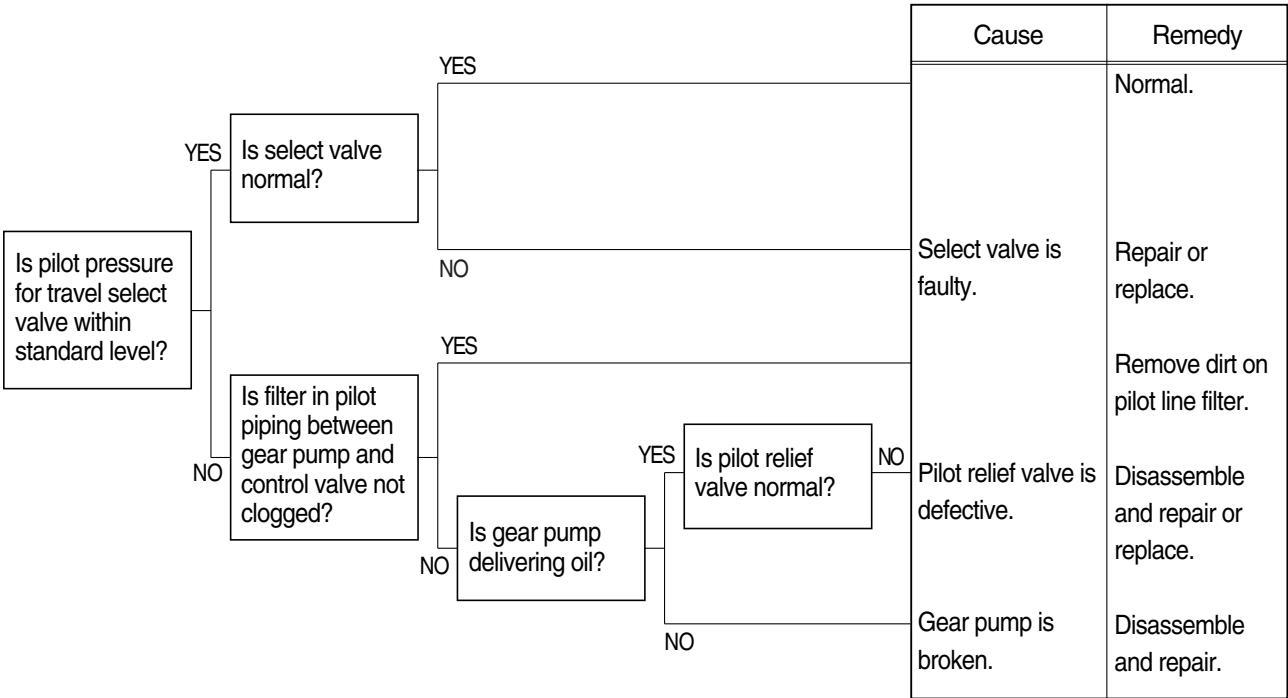
5) TRAVEL ACTION IS POWERLESS(Travel only)



6) MACHINE RUNS RECKLESSLY ON A SLOPE

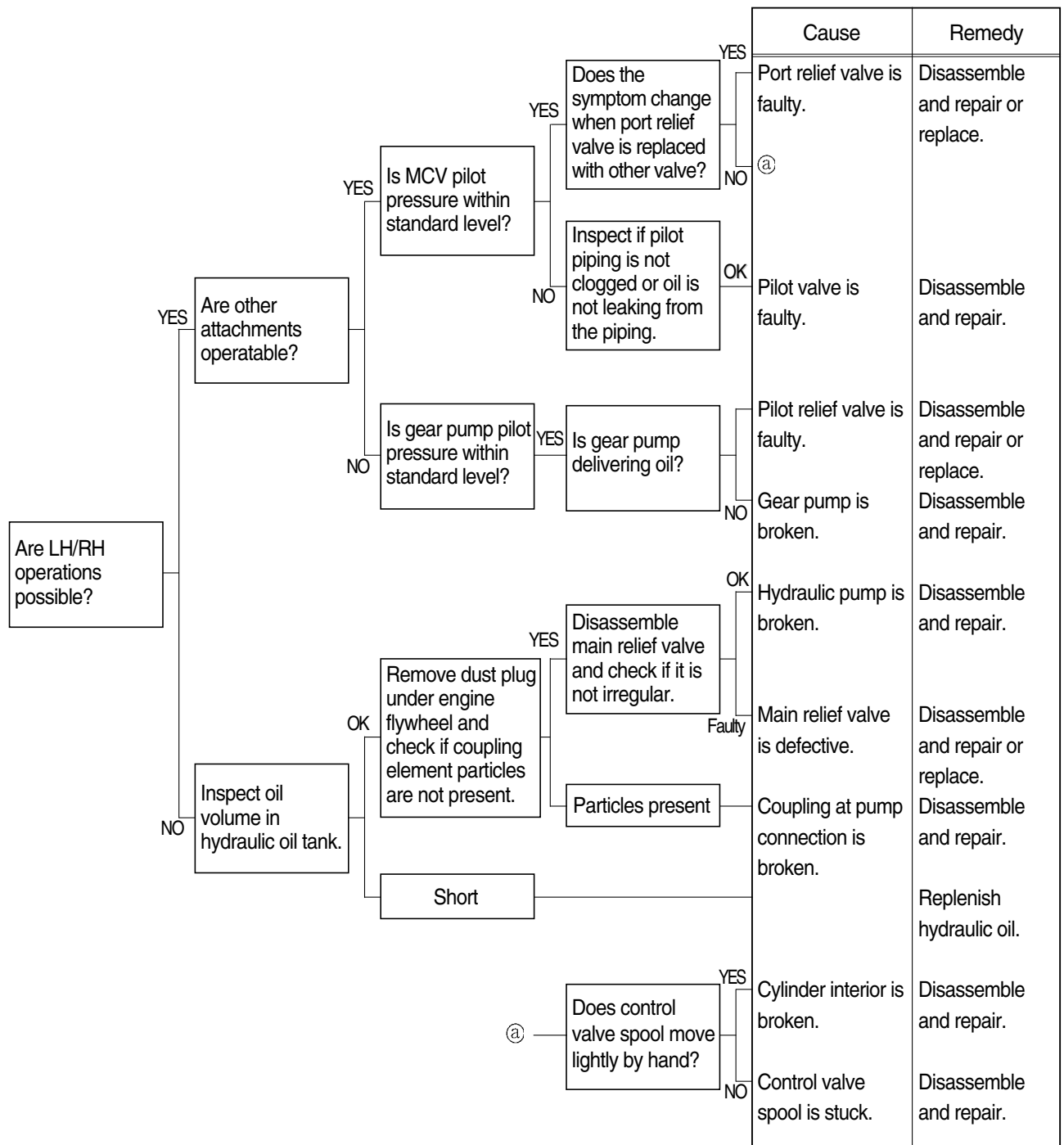


7) MACHINE MAKES A CURVED TRAVEL OR DOES NOT TRAVEL AT ALL WHEN TRAVEL AND ATTACHMENT OPERATIONS ARE EXECUTED AT THE SAME TIME

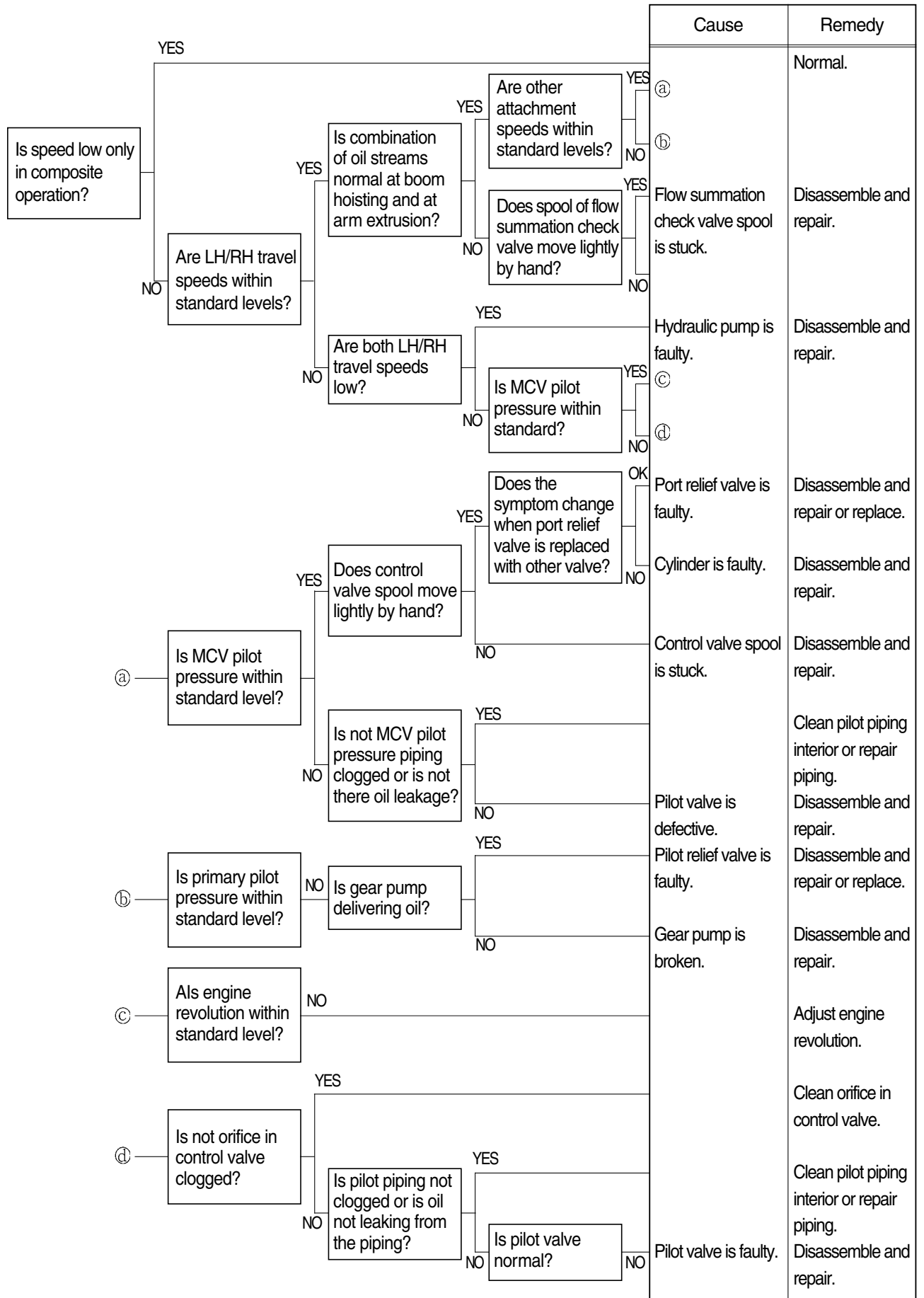


6. ATTACHMENT SYSTEM

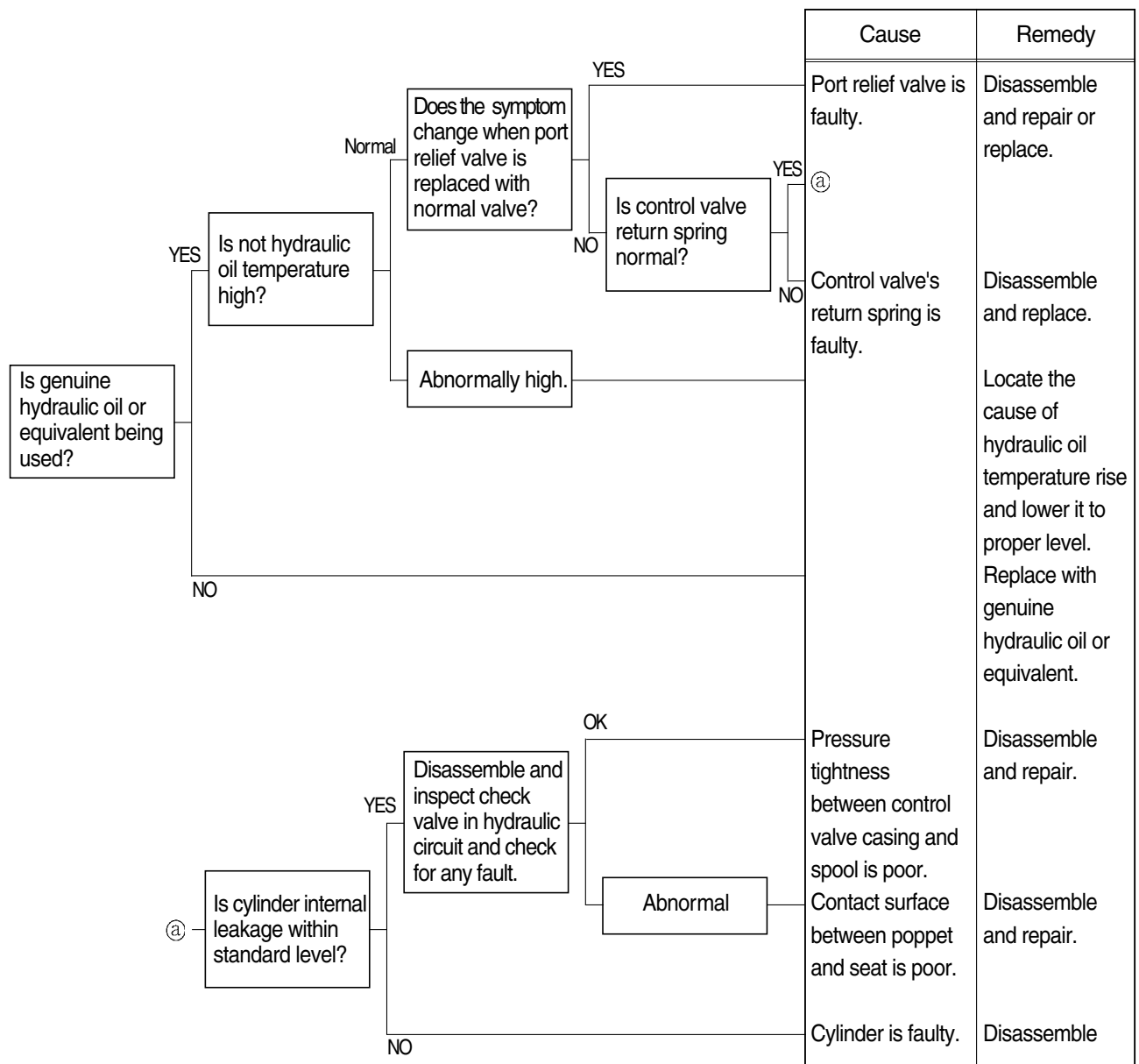
1) BOOM OR ARM ACTION IS IMPOSSIBLE AT ALL



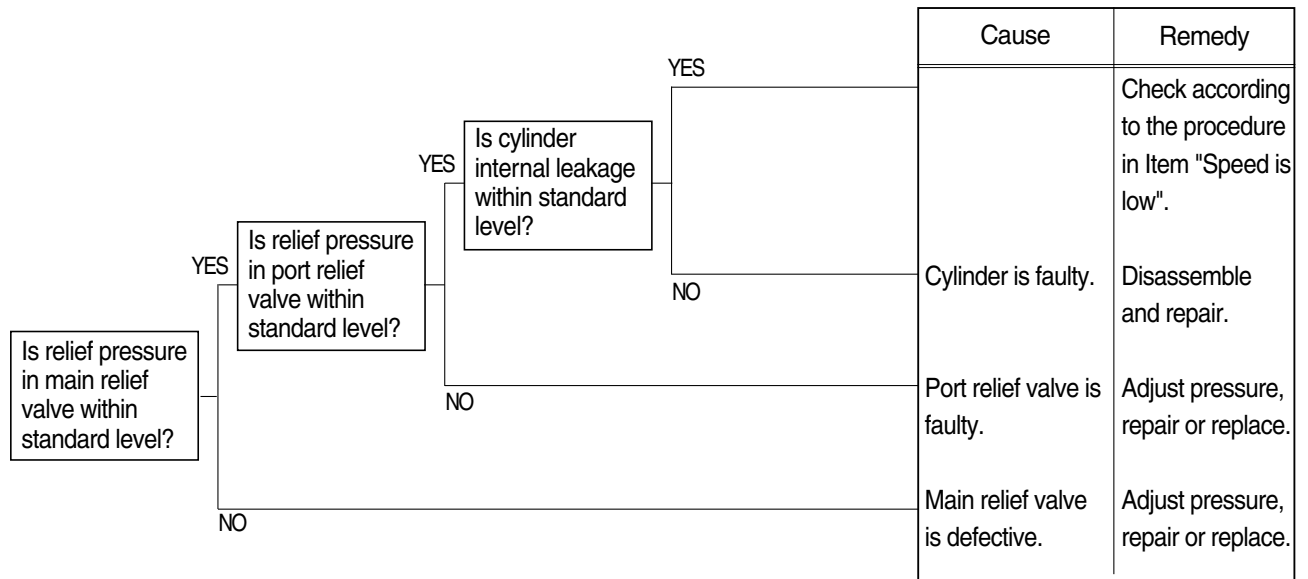
2) BOOM, ARM OR BUCKET SPEED IS LOW



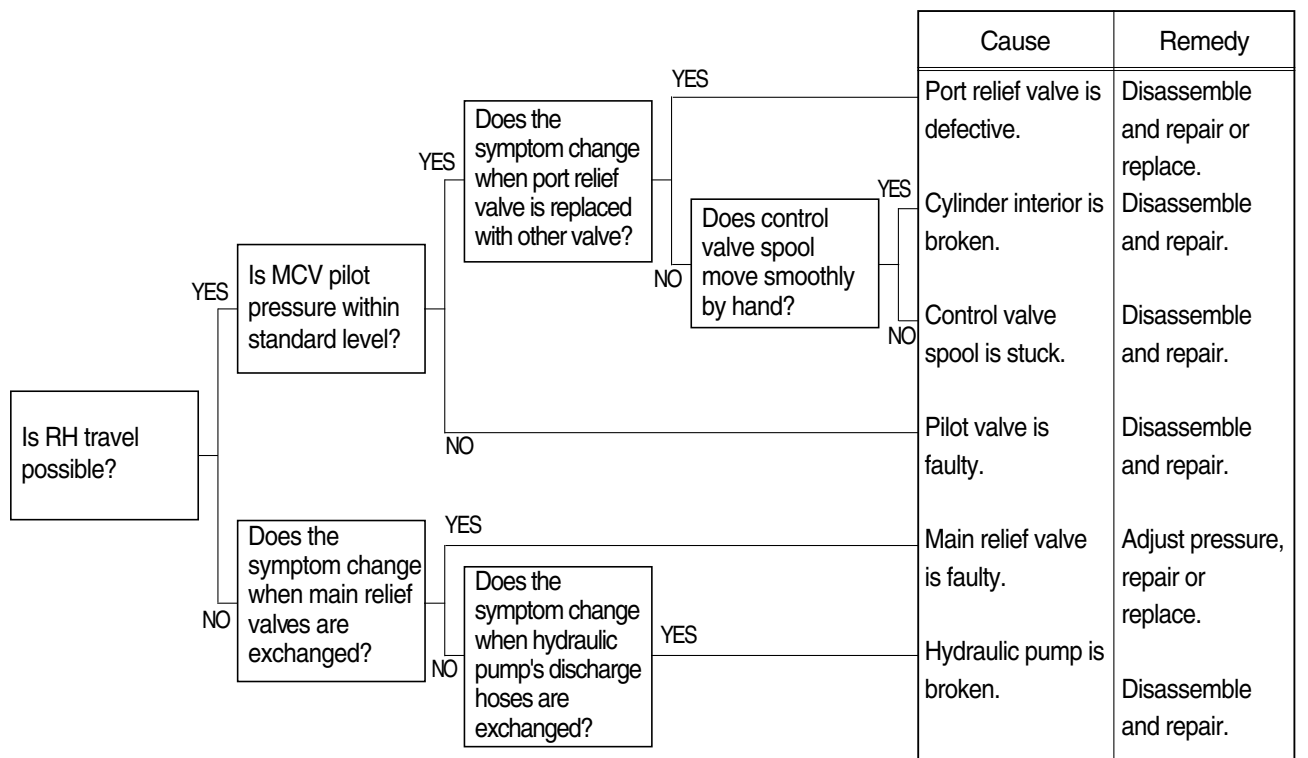
3) BOOM, ARM OR BUCKET CYLINDER EXTENDS OR CONTRACTS ITSELF AND ATTACHMENT



4) BOOM, ARM OR BUCKET POWER IS WEAK



5) ONLY BUCKET OPERATION IS TOTALLY IMPOSSIBLE

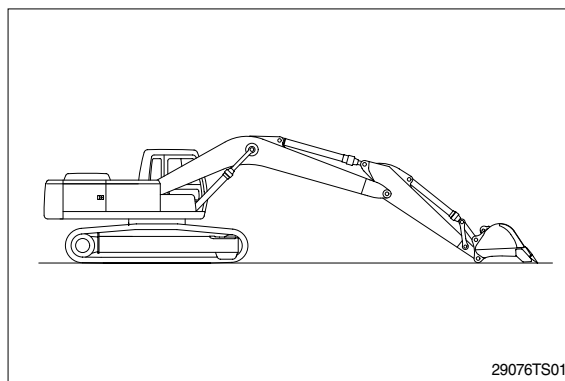


6) BOOM MAKES A SQUEAKING NOISE WHEN BOOM IS OPERATED

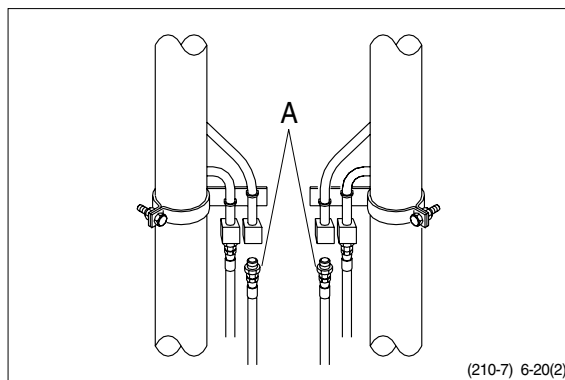
| | | Cause | Remedy |
|---|-----|--------------------------------------|--|
| <div>Is boom foot pin greased sufficiently?</div> | YES | | Frictional noise occurs between the sliding faces of boom cylinder's oil seal and boom proper. ※ Frictional noise will disappear if they are kept used. |
| | NO | Boom foot pin has run out of grease. | Supply grease to it. ※ If seizure is in an initial stage, supply sufficient grease. If seizure is in a grown state, correct it by paper lapping or with an oil stone. |

※ HOW TO CHECK INTERNAL BOOM CYLINDER LEAKAGE

1. Lower the bucket teeth to the ground with bucket cylinder fully retracted and arm cylinder rod retracted almost in full.



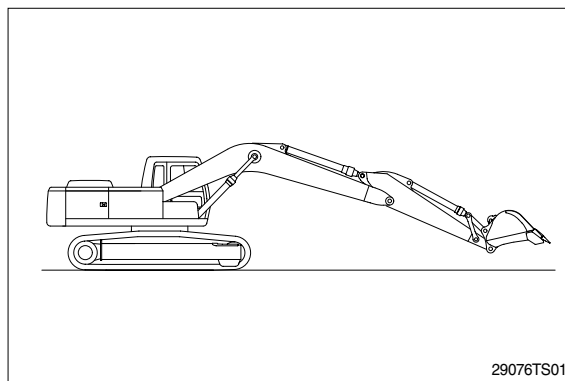
2. Disconnect hose(A) from rod side of boom cylinder and drain oil from cylinders and hose.(put cups on piping and hose ends)



3. Raise bucket OFF the ground by retracting the arm cylinder rod.

If oil leaks from piping side and boom cylinder rod is retracted there is an internal leak in the cylinder.

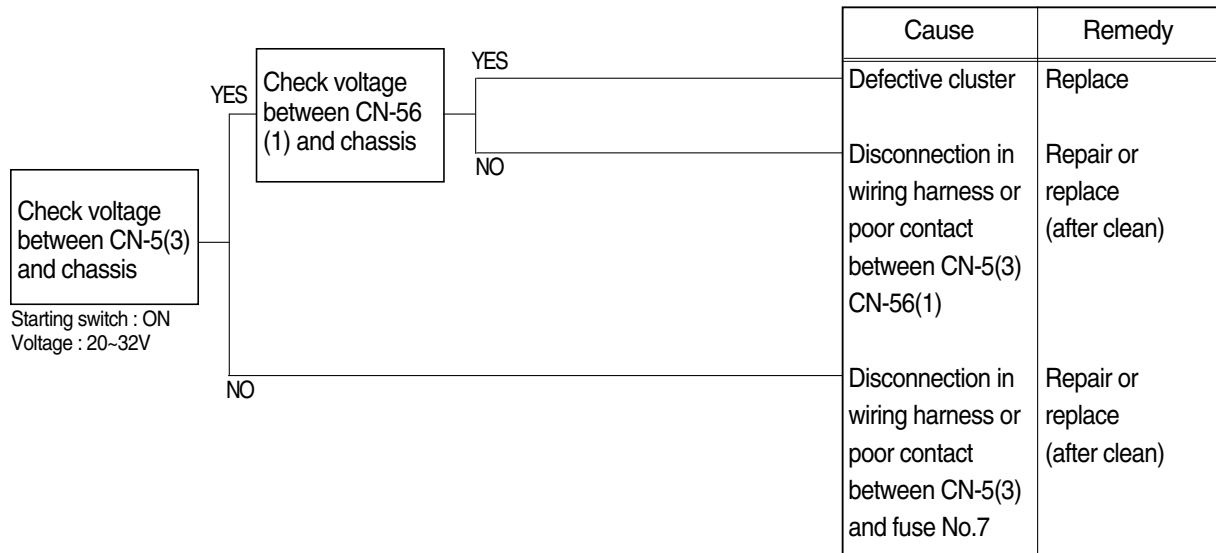
If no oil leaks from piping side and boom cylinder rod is retracted, there is an internal leak in the control valve.



GROUP 3 ELECTRICAL SYSTEM

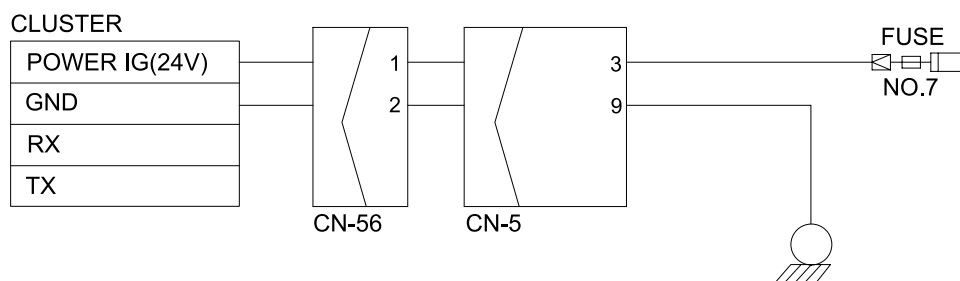
1. WHEN STARTING SWITCH IS TURNED ON, MONITOR PANEL DISPLAY DOES NOT APPEAR

- Before disconnecting the connector, always turn the starting switch OFF.
- Before carrying out below procedure, check all the related connectors are properly inserted and short of fuse No.7.
- After checking, insert the disconnected connectors again immediately unless otherwise specified.



Check voltage

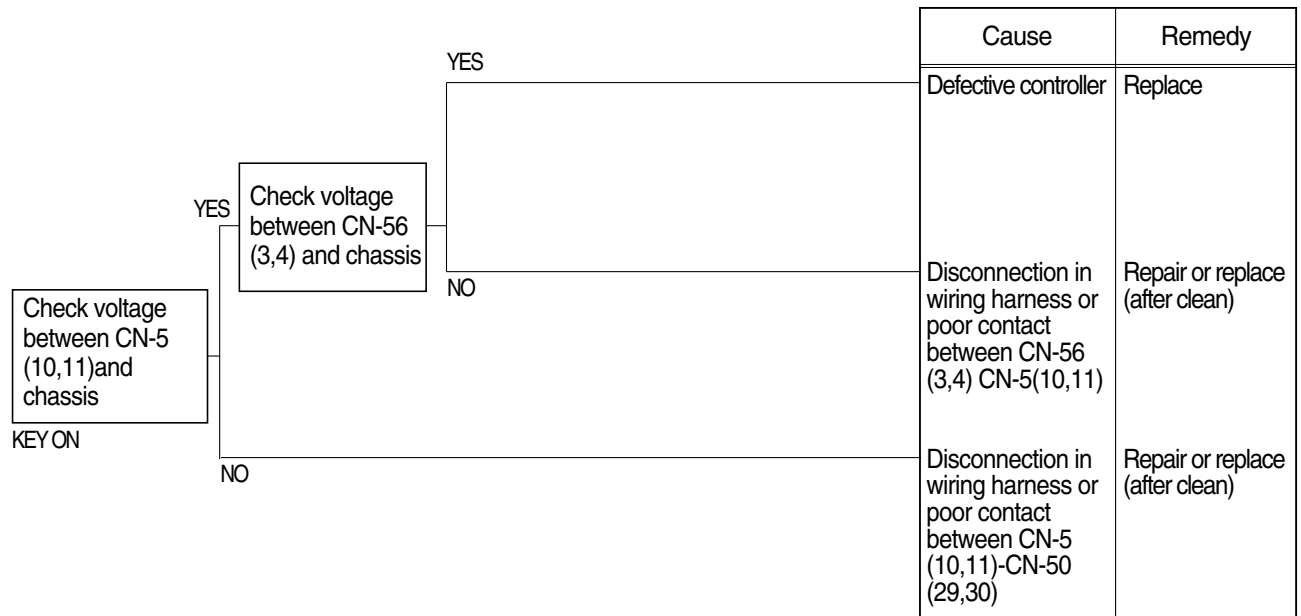
| | |
|-----|----------|
| YES | 20 ~ 32V |
| NO | 0V |



RD21076ES51

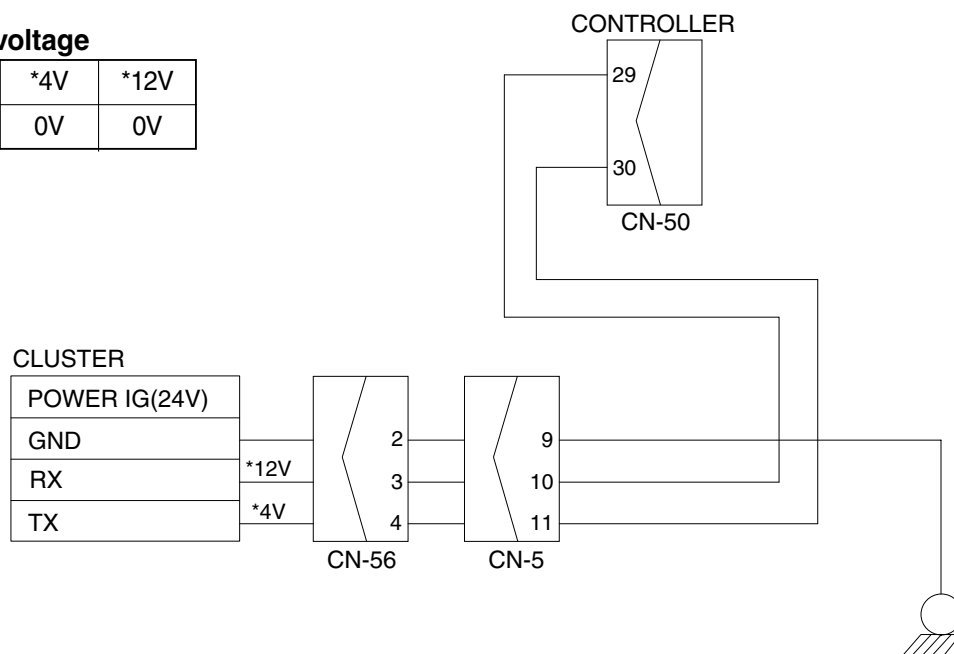
2. COMMUNICATION ERROR "Co : Er" FLASHES ON THE CLUSTER

- Before disconnecting the connector, always turn the starting switch OFF.
- Before carrying out below procedure, check all the related connectors are properly inserted.
- After checking, insert the disconnected connectors again immediately unless otherwise specified.



Check voltage

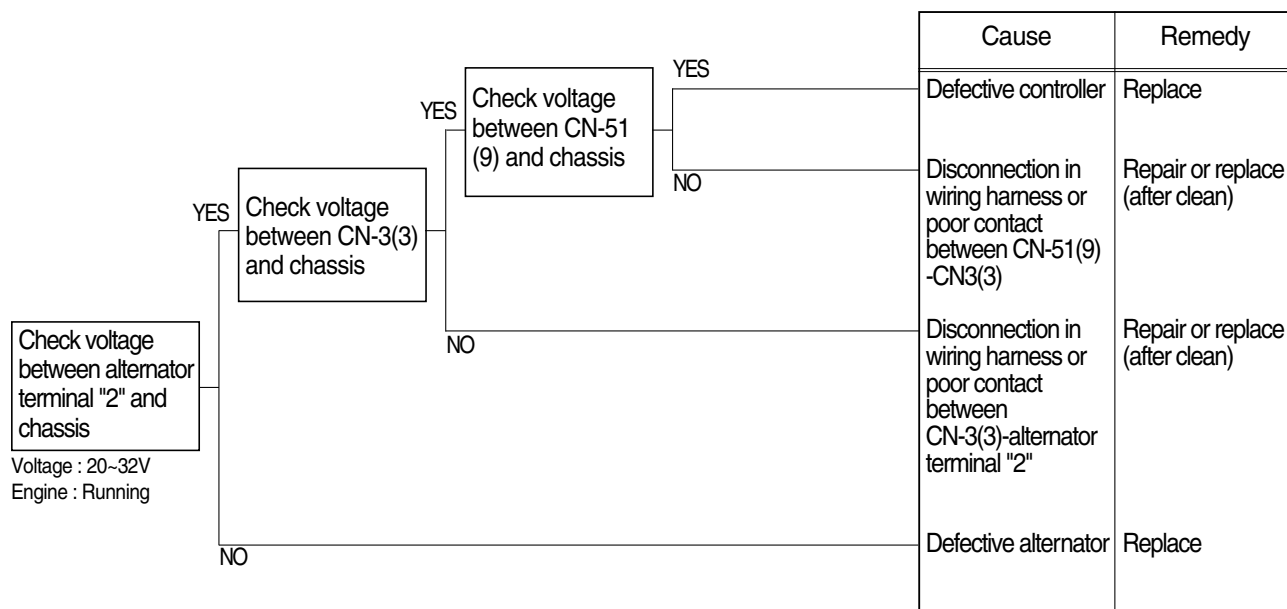
| | | |
|-----|-----|------|
| YES | *4V | *12V |
| NO | 0V | 0V |



2107V6ES02

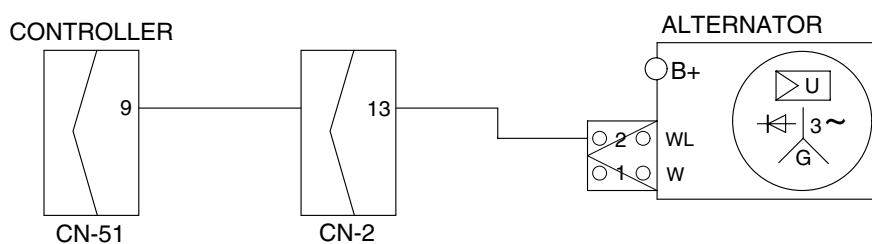
3. **BATTERY CHARGING WARNING LAMP LIGHTS UP**(starting switch : ON)

- Before disconnecting the connector, always turn the starting switch OFF.
- Before carrying out below procedure, check all the related connectors are properly inserted.
- After checking, insert the disconnected connectors again immediately unless otherwise specified.



Check voltage

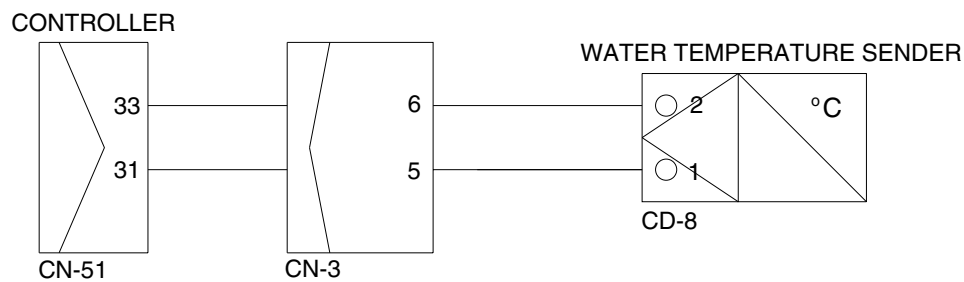
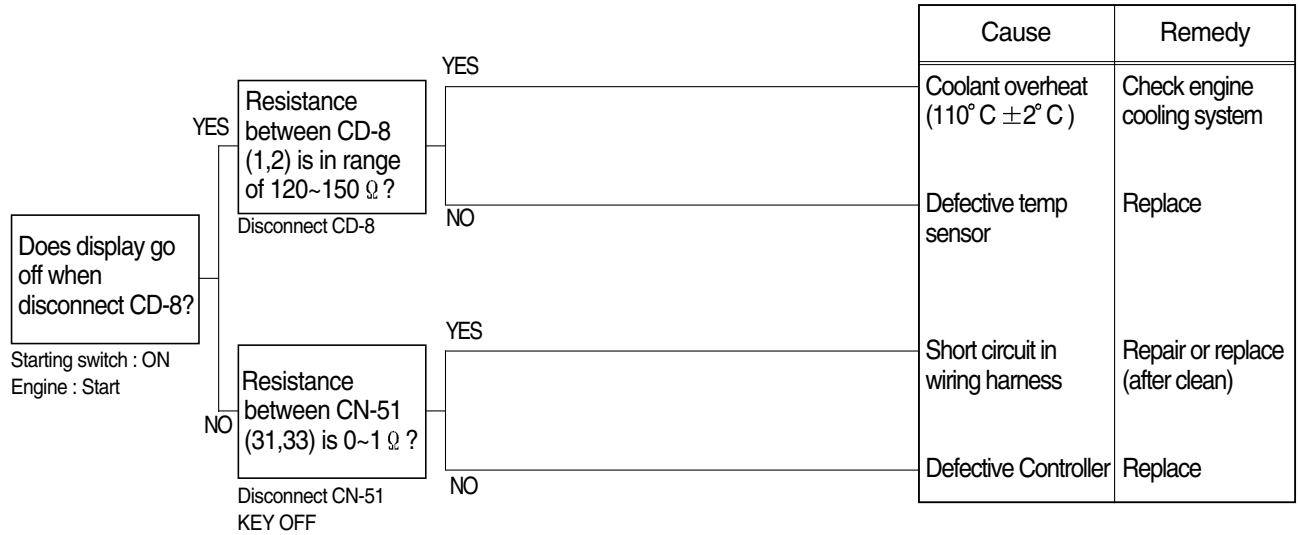
| | |
|-----|---------|
| YES | 20 ~32V |
| NO | 0V |



2107V6ES52

4. WHEN COOLANT OVERHEAT WARNING LAMP LIGHTS UP(Engine is started)

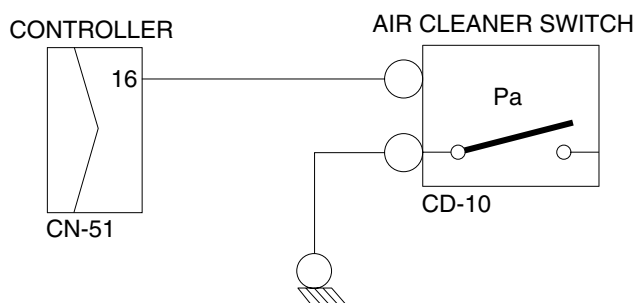
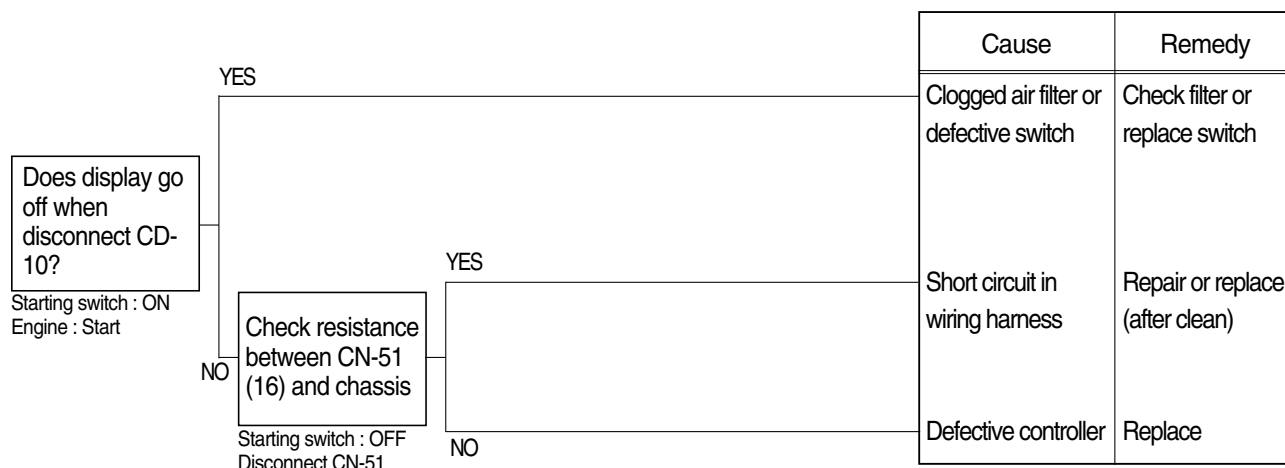
- Before disconnecting the connector, always turn the starting switch OFF.
- Before carrying out below procedure, check all the related connectors are properly inserted.
- After checking, insert the disconnected connectors again immediately unless otherwise specified.



RD21076ES53

5. WHEN AIR CLEANER WARNING LAMP LIGHTS UP (Engine is started)

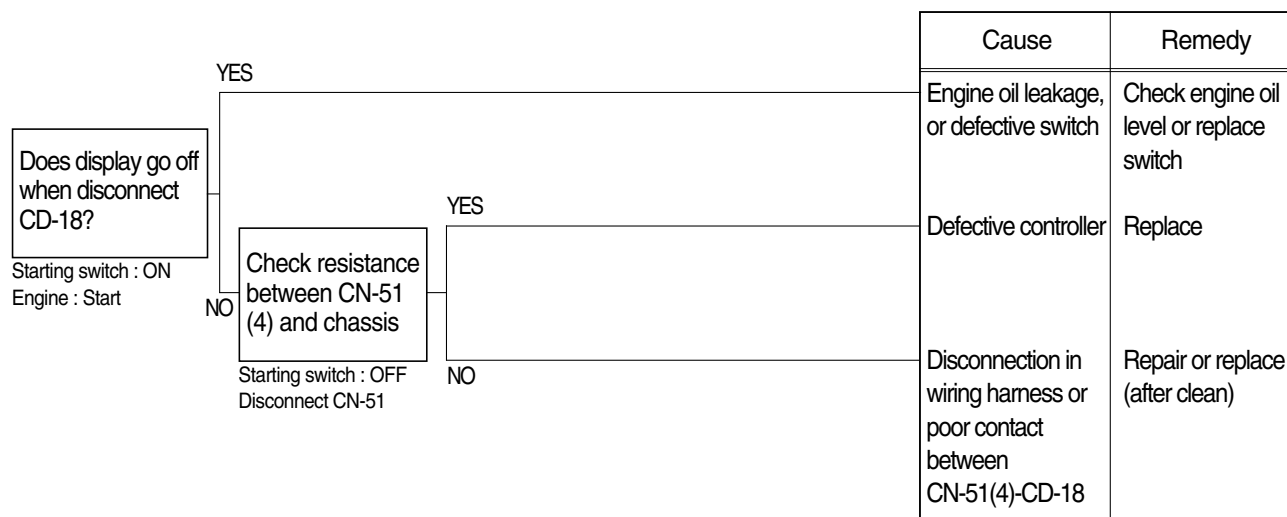
- Before disconnecting the connector, always turn the starting switch OFF.
- Before carrying out below procedure, check all the related connectors are properly inserted.
- After checking, insert the disconnected connectors again immediately unless otherwise specified.



21076ES55

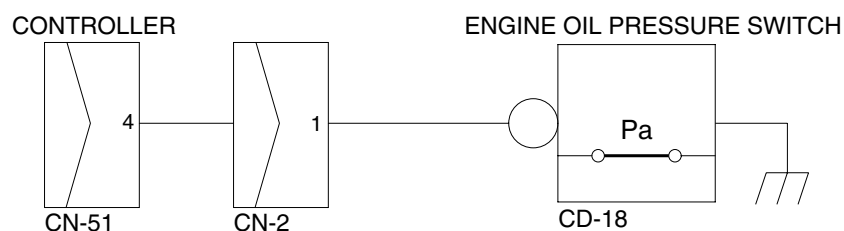
6. WHEN ENGINE OIL PRESSURE WARNING LAMP LIGHTS UP (Engine is started)

- Before disconnecting the connector, always turn the starting switch OFF.
- Before carrying out below procedure, check all the related connectors are properly inserted.
- After checking, insert the disconnected connectors again immediately unless otherwise specified.



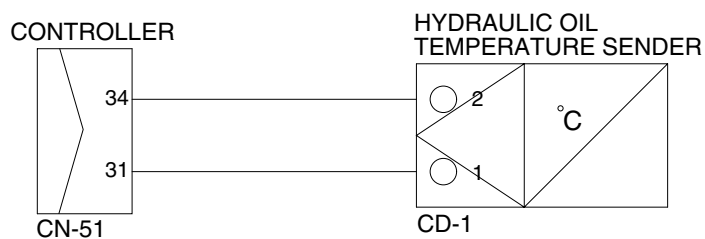
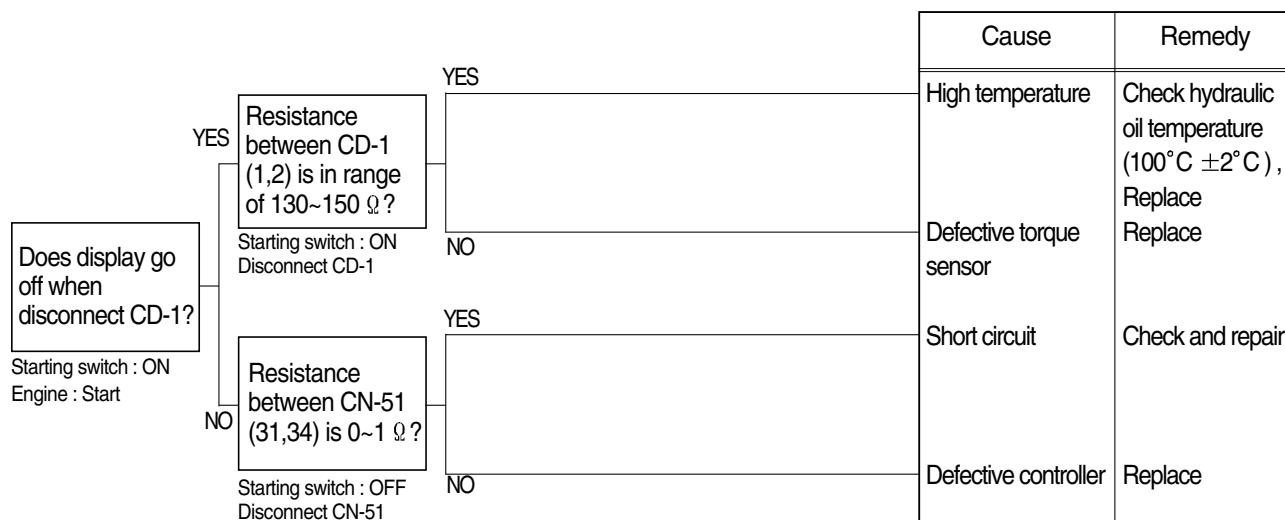
Check resistance

| | |
|-----|---------|
| YES | MAX 1Ω |
| NO | MIN 1MΩ |



7. WHEN HYDRAULIC OIL TEMPERATURE WARNING LAMP LIGHTS UP(Engine is started)

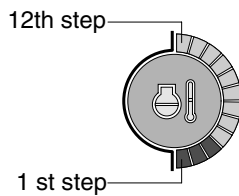
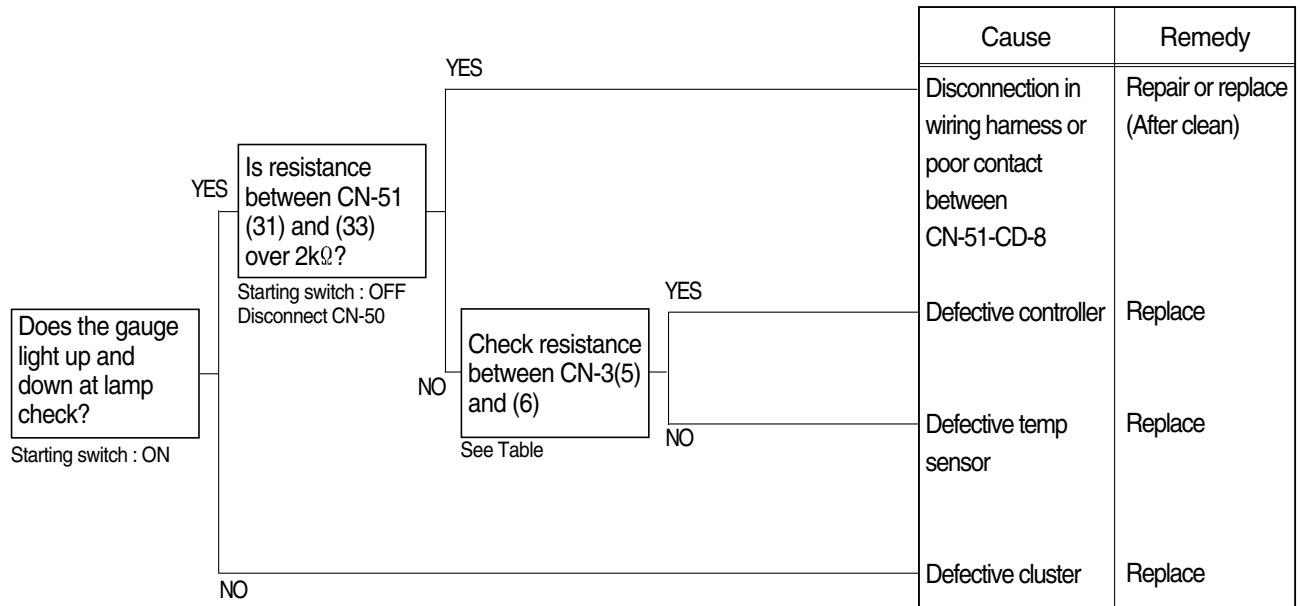
- Before disconnecting the connector, always turn the starting switch OFF.
- Before carrying out below procedure, check all the related connectors are properly inserted.



29076ES04

8. WHEN COOLANT TEMPERATURE GAUGE DOES NOT OPERATE

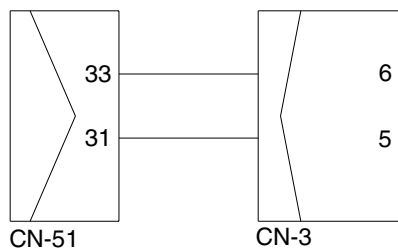
- Before disconnecting the connector, always turn the starting switch OFF.
- Before carrying out below procedure, check all the related connectors are properly inserted.
- After checking, insert the disconnected connectors again immediately unless otherwise specified.



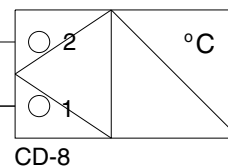
Check Table

| Range | 1st step | 2nd~10th step | 11th~12th step |
|-------------|----------|---------------|----------------|
| Temperature | ~29° C | 30~105°C | 105°C ~ |

CONTROLLER

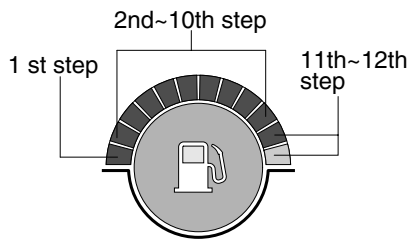
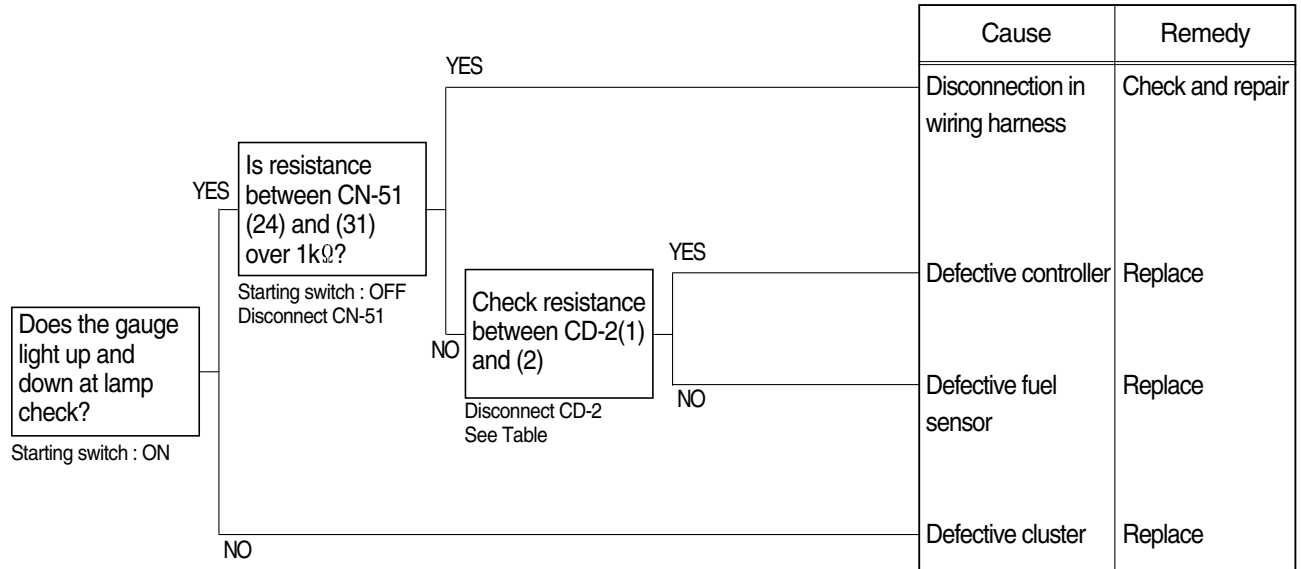


WATER TEMPERATURE SENDER



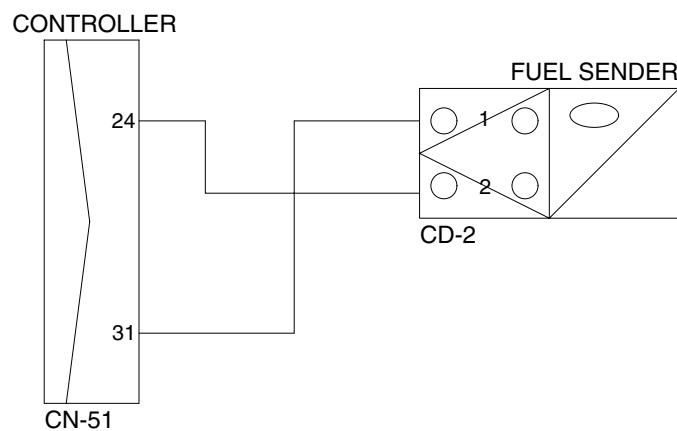
9. WHEN FUEL GAUGE DOES NOT OPERATE (Check warning lamp ON/OFF)

- Before disconnecting the connector, always turn the starting switch OFF.
- Before carrying out below procedure, check all the related connectors are properly inserted.
- After checking, insert the disconnected connectors again immediately unless otherwise specified.



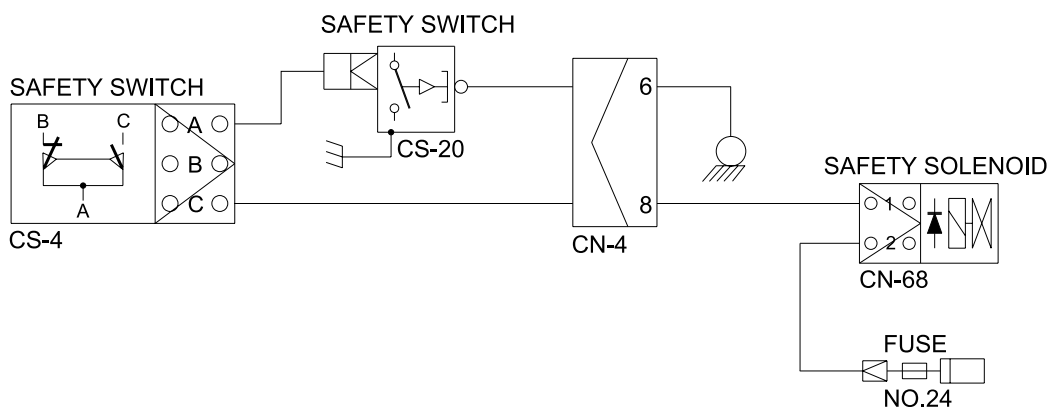
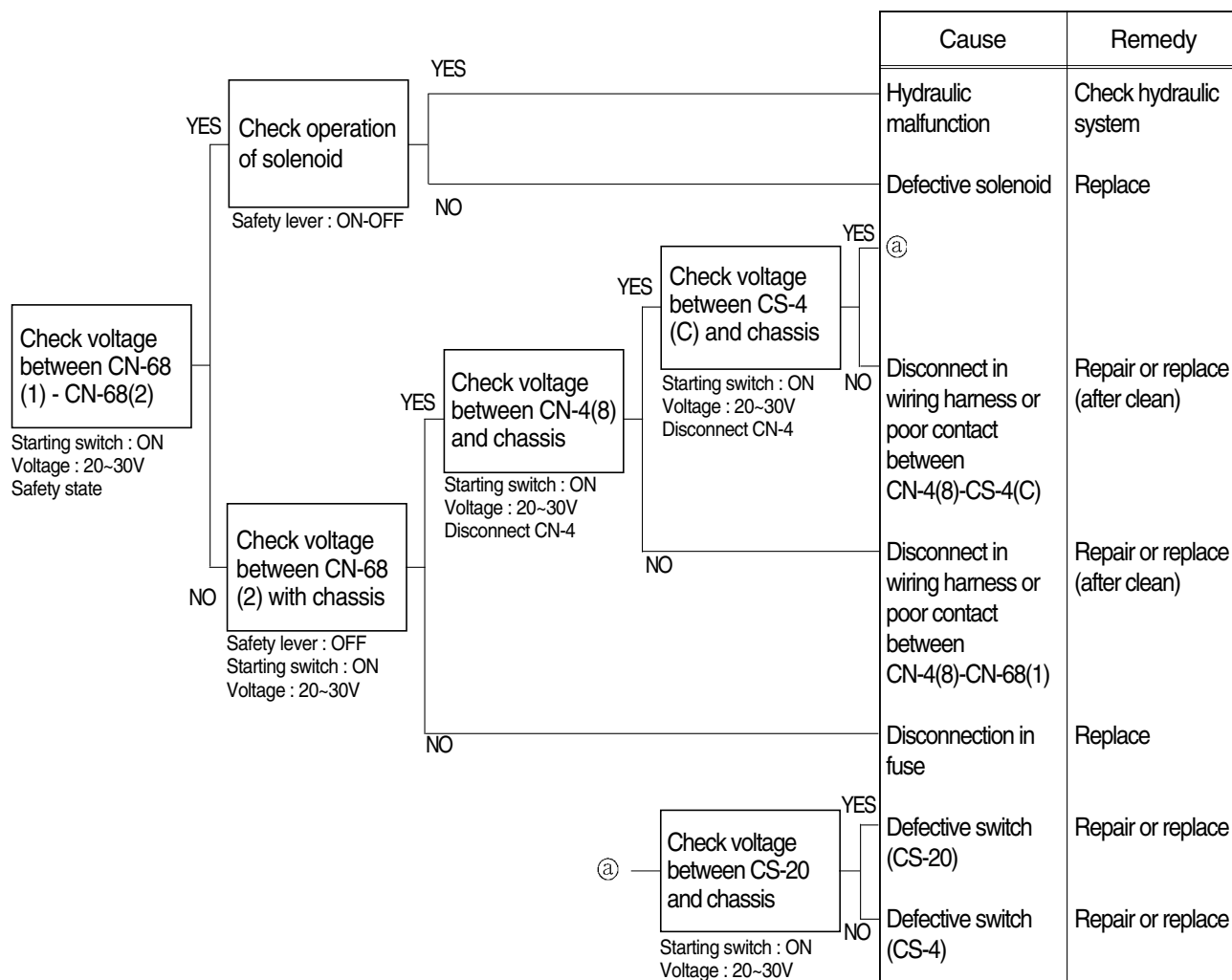
Check Table

| Item | Range | 1st step | 2nd~10th step | 11th~12th step |
|-----------------------------|-------|----------|---------------|----------------|
| Unit Resistance(Ω) | | 700~601 | 600~101 | ~100 |
| Tolerance(%) | | ± 5 | ± 5 | ± 5 |



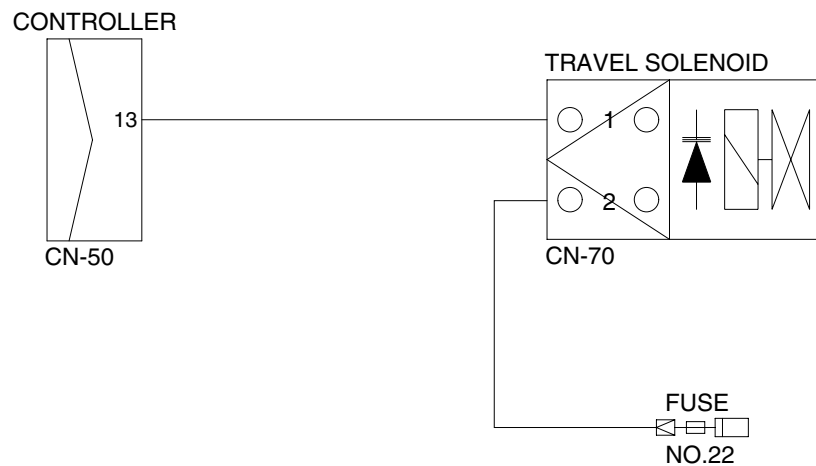
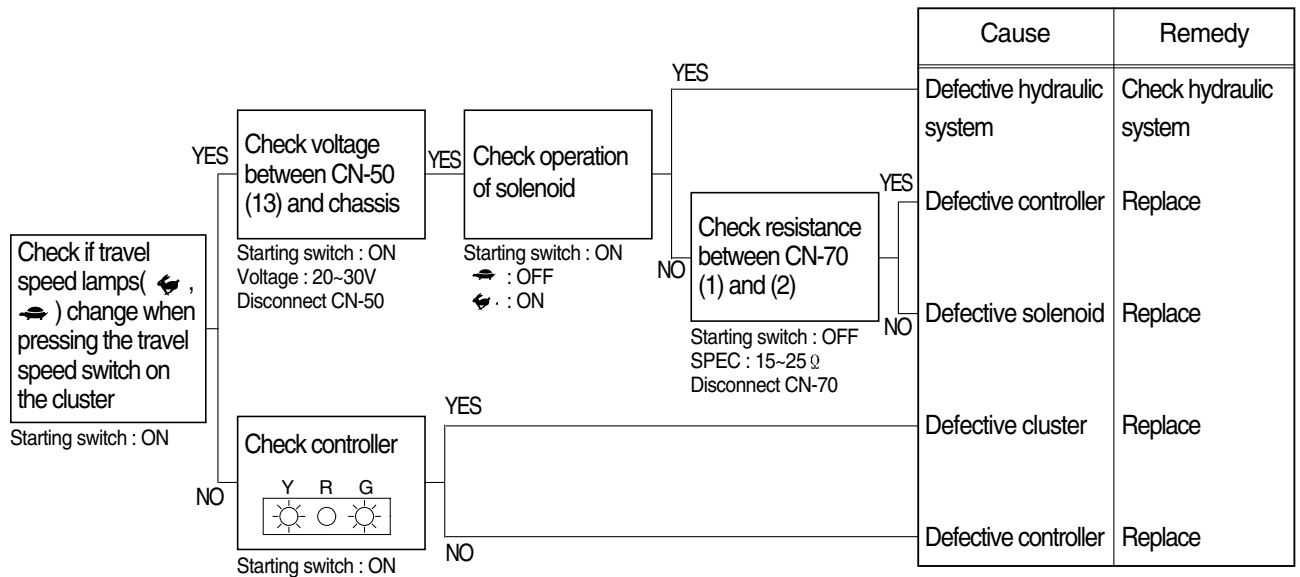
10. WHEN SAFETY SOLENOID DOES NOT OPERATE

- Before disconnecting the connector, always turn the starting switch OFF.
- Before carrying out below procedure, check all the related connectors are properly inserted and short of fuse No.24.
- After checking, insert the disconnected connectors again immediately unless otherwise specified.



11. WHEN TRAVEL SPEED 1, 2 DOES NOT OPERATE

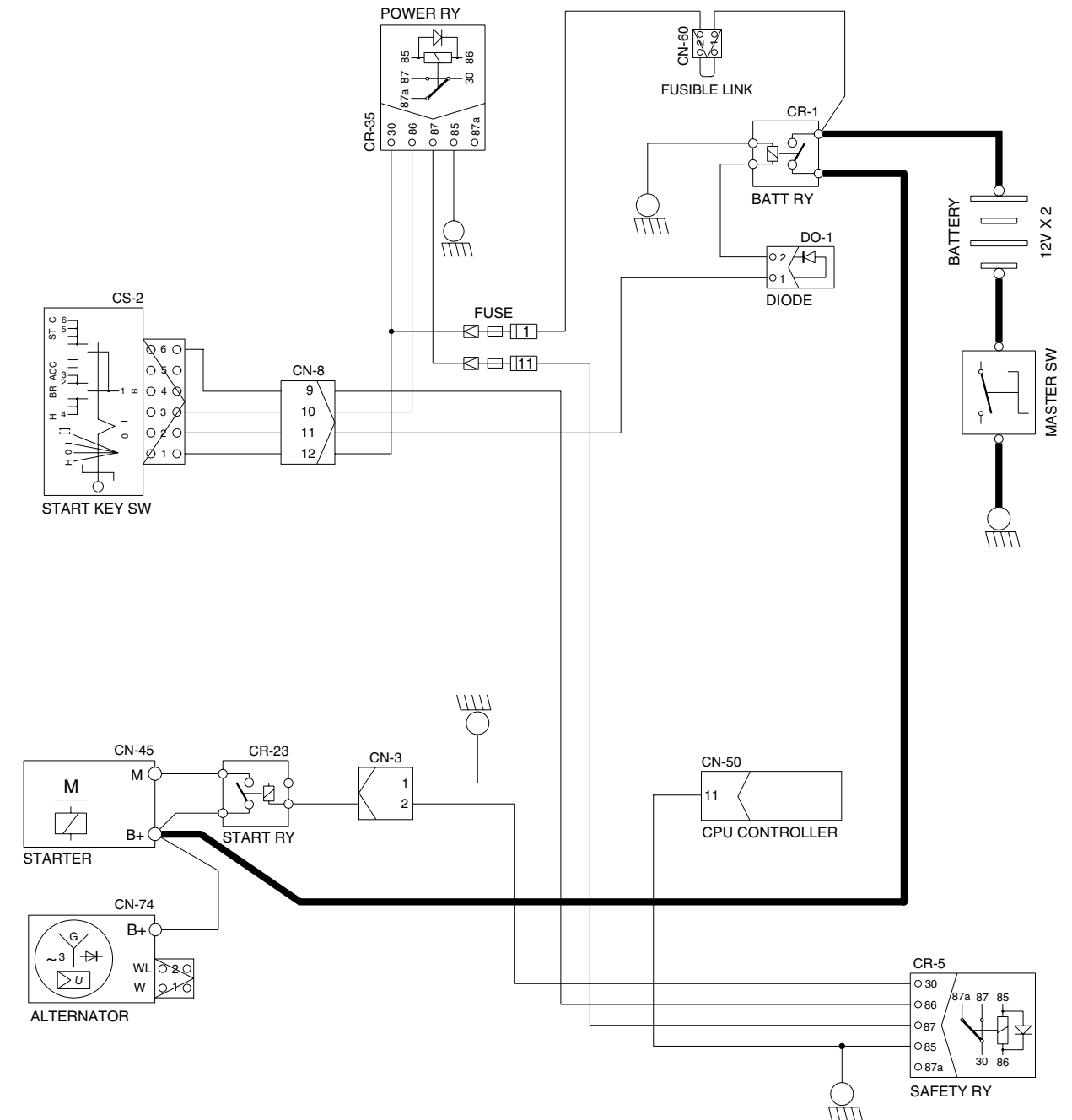
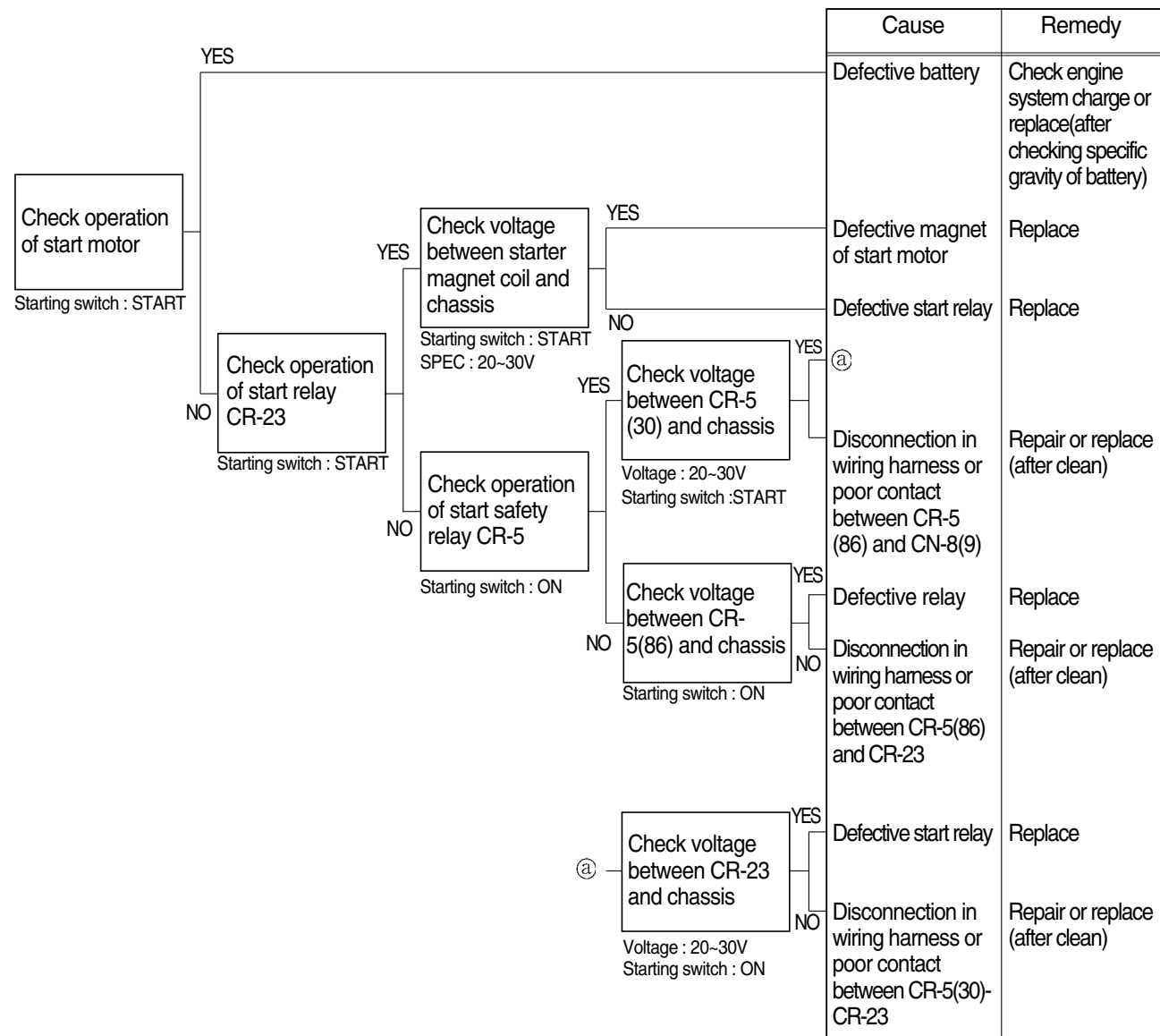
- Before disconnecting the connector, always turn the starting switch OFF.
- Before carrying out below procedure, check all the related connectors are properly inserted and short of fuse No.22 .
- After checking, insert the disconnected connectors again immediately unless otherwise specified.



RD21076ES55

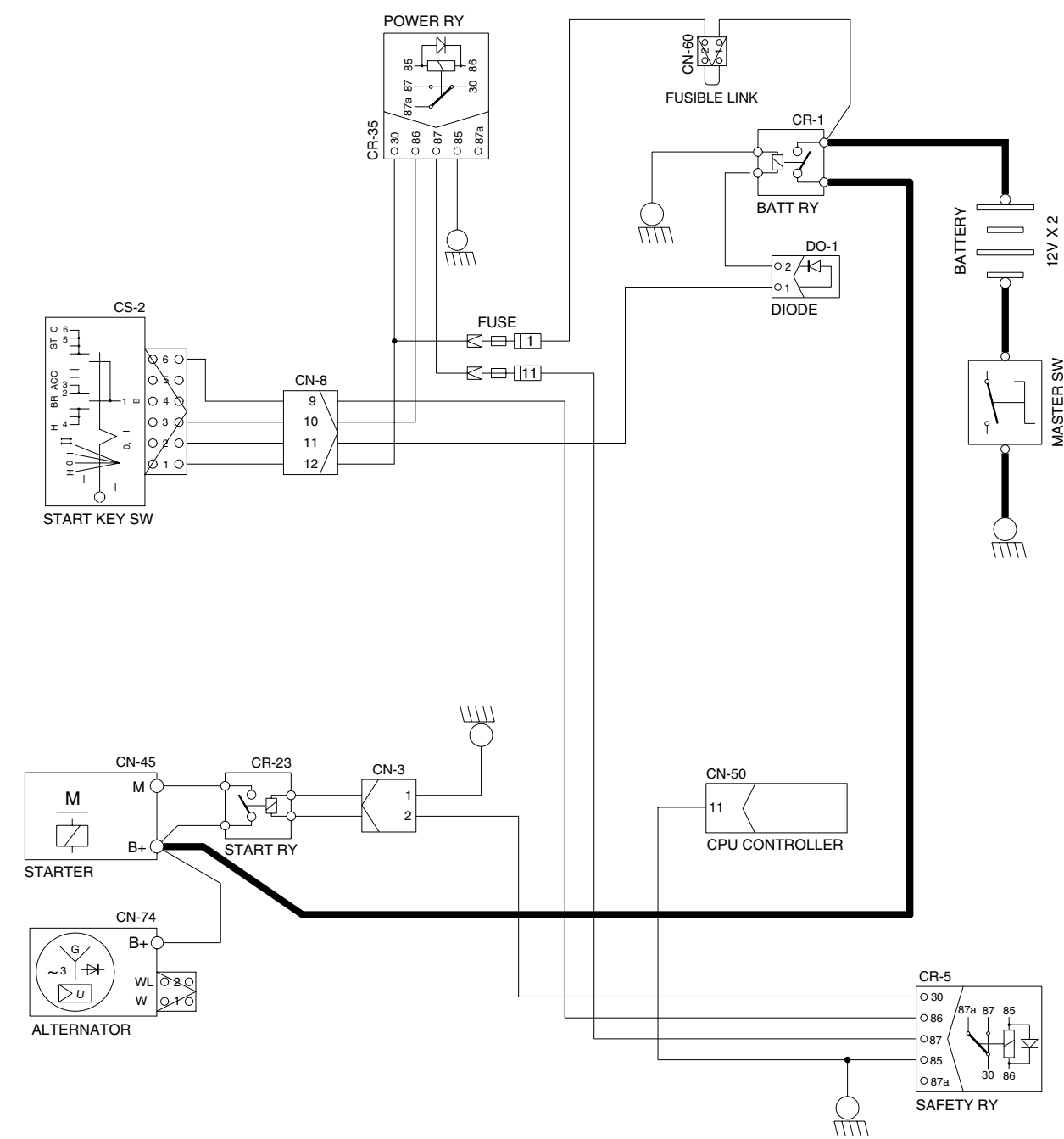
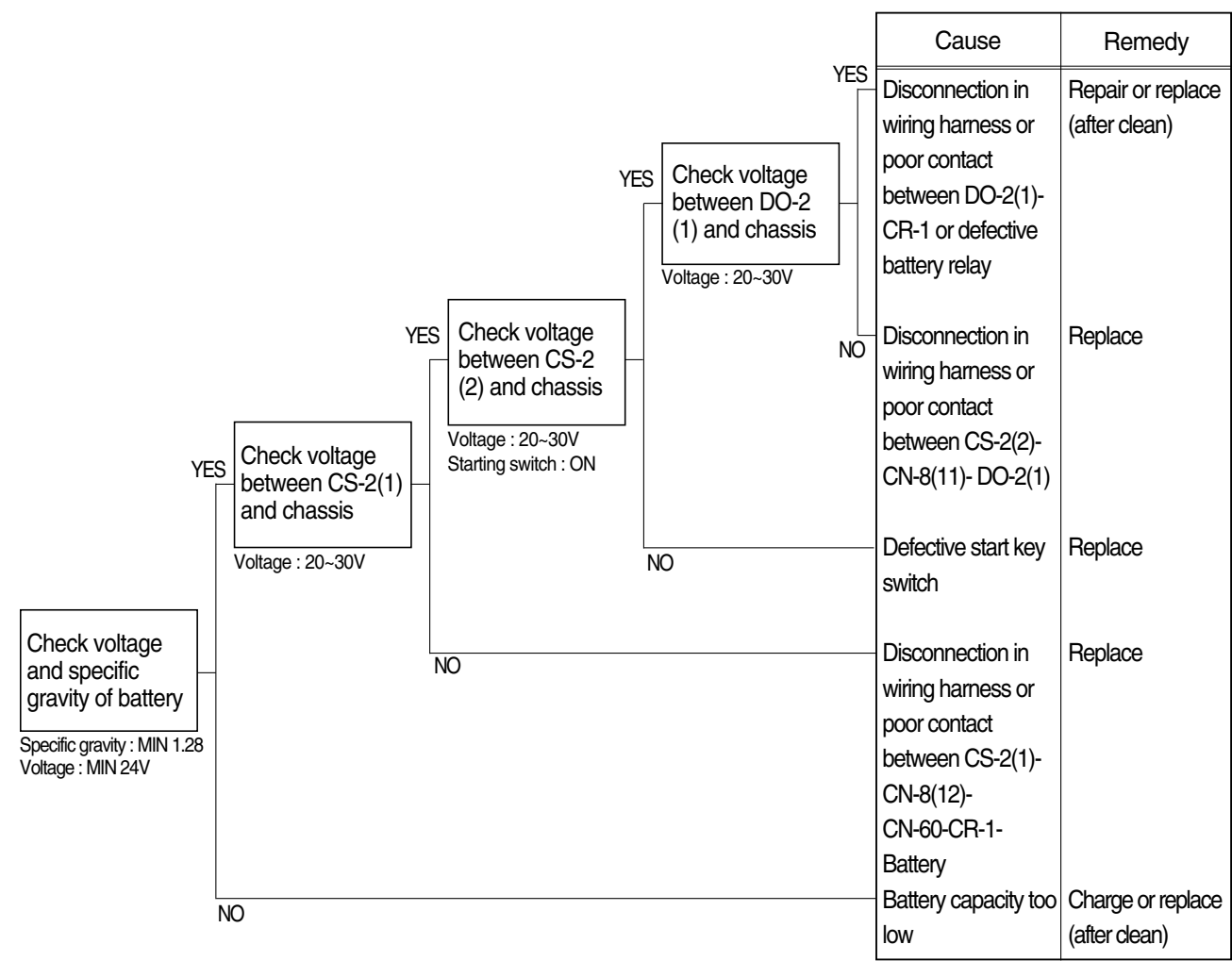
12. WHEN ENGINE DOES NOT START

- Check supply of the power at engine stop solenoid while starting switch is ON.
- Before disconnecting the connector, always turn the starting switch OFF.
- Before carrying out below procedure, check all the related connectors are properly inserted.
- After checking, insert the disconnected connectors again immediately unless otherwise specified.



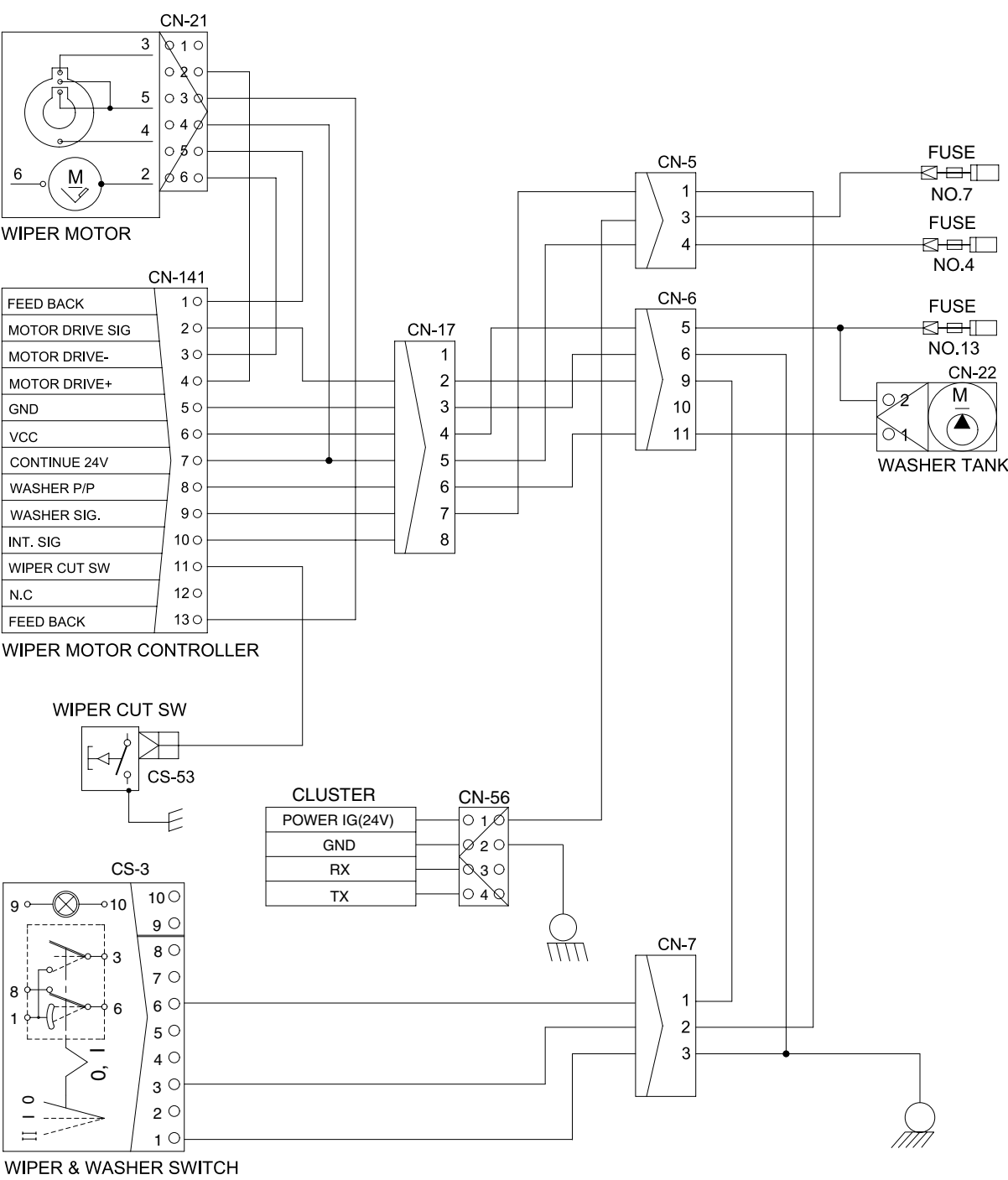
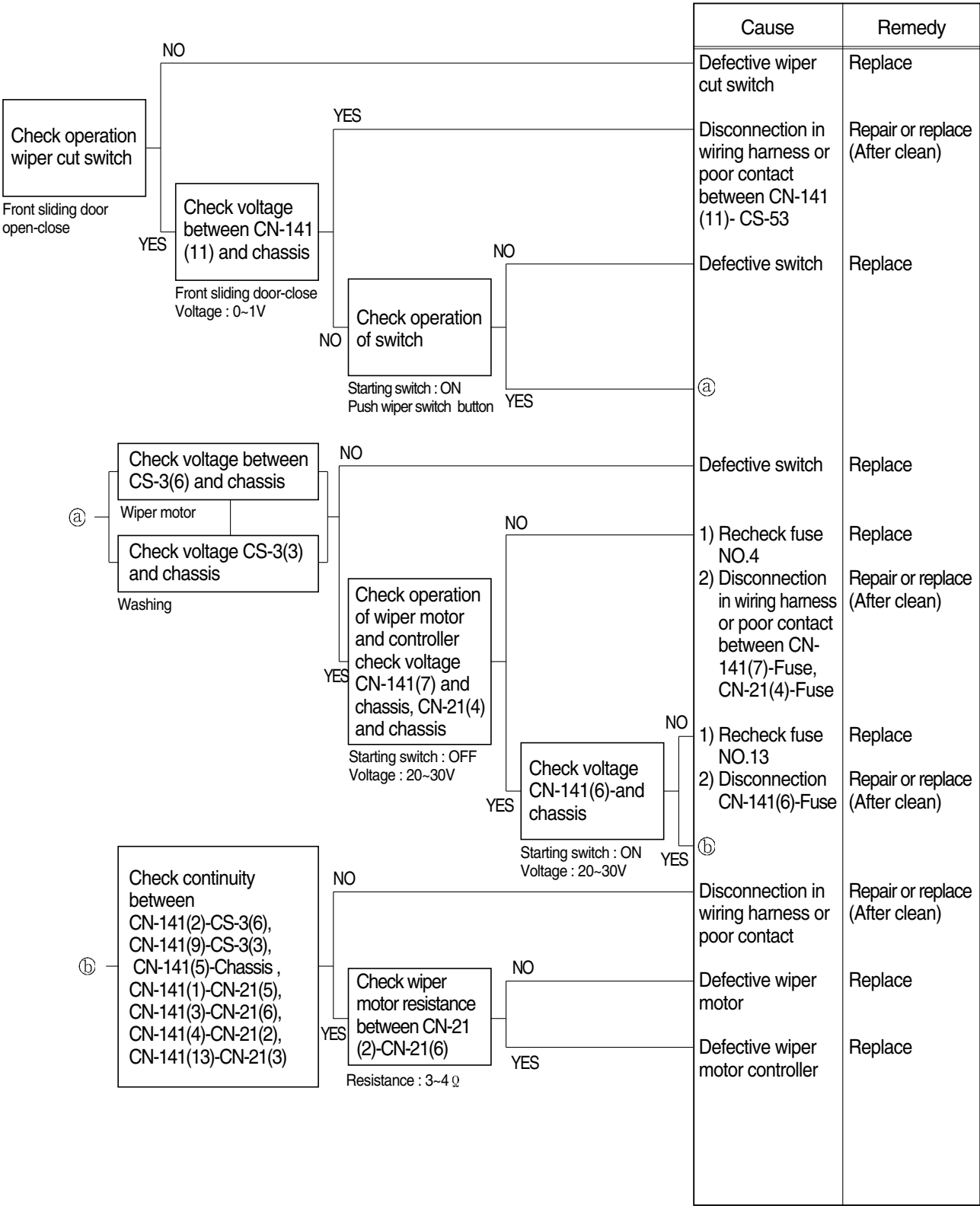
13. WHEN STARTING SWITCH “ON” ELECTRIC PART DOES NOT OPERATE

- Before disconnecting the connector, always turn the starting switch OFF.
- Before carrying out below procedure, check all the related connectors are properly inserted and master switch ON
- After checking, insert the disconnected connectors again immediately unless otherwise specified.



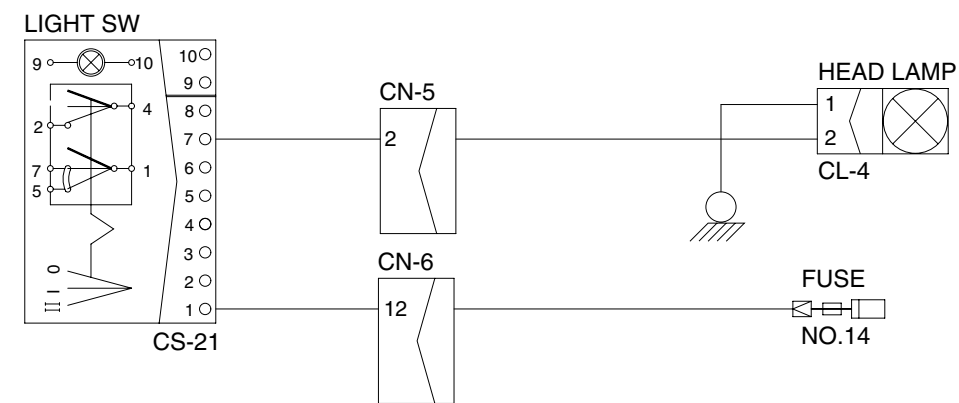
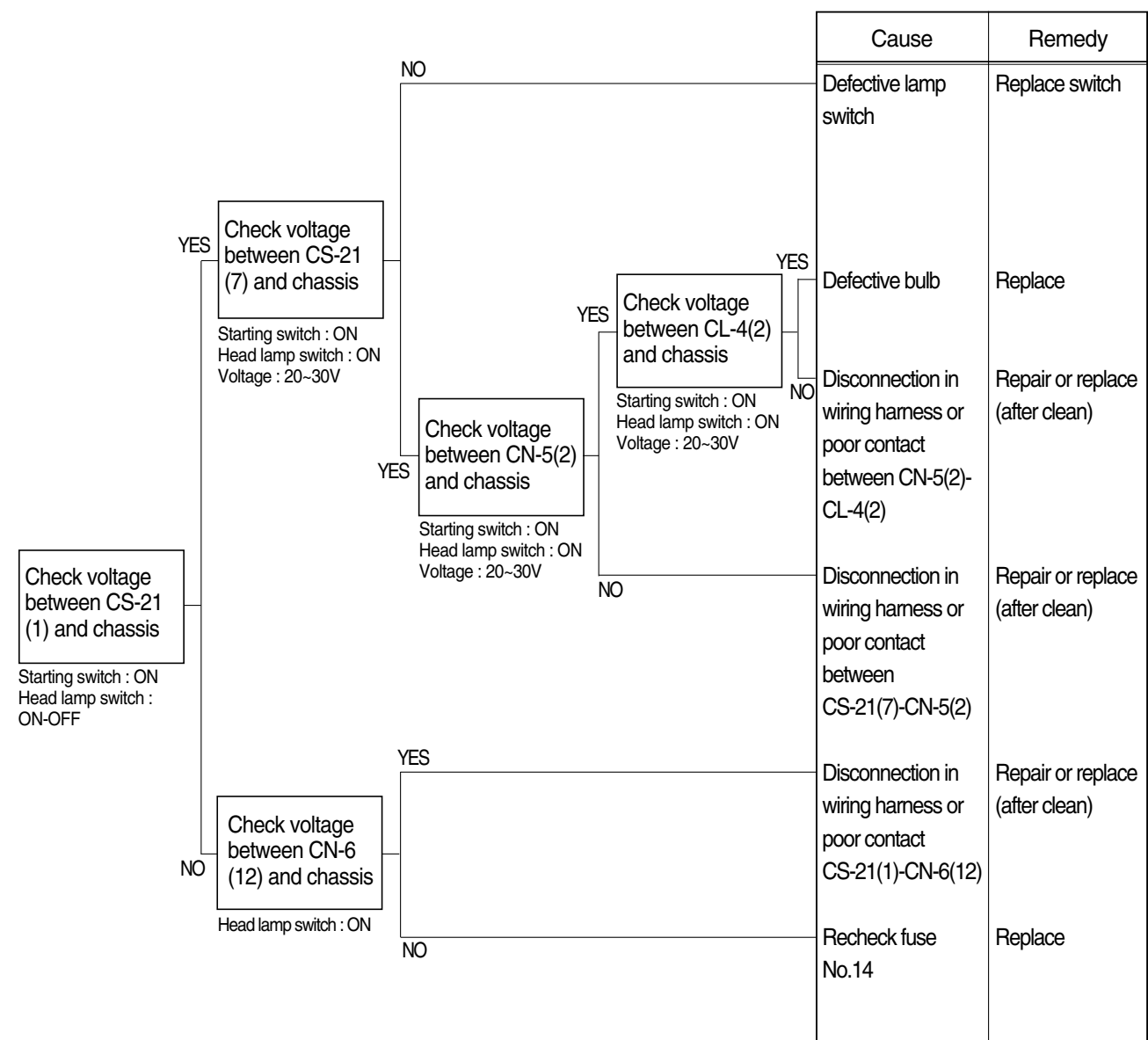
14. WHEN STARTING SWITCH IS TURNED ON, WIPER MOTOR DOES NOT OPERATE

- Before disconnecting the connector, always turn the starting switch OFF.
- Before carrying out below procedure, check all the related connectors are properly inserted and the fuse No.4, 7 and 13 is not blown out.
- After checking, insert the disconnected connectors again immediately unless otherwise specified.



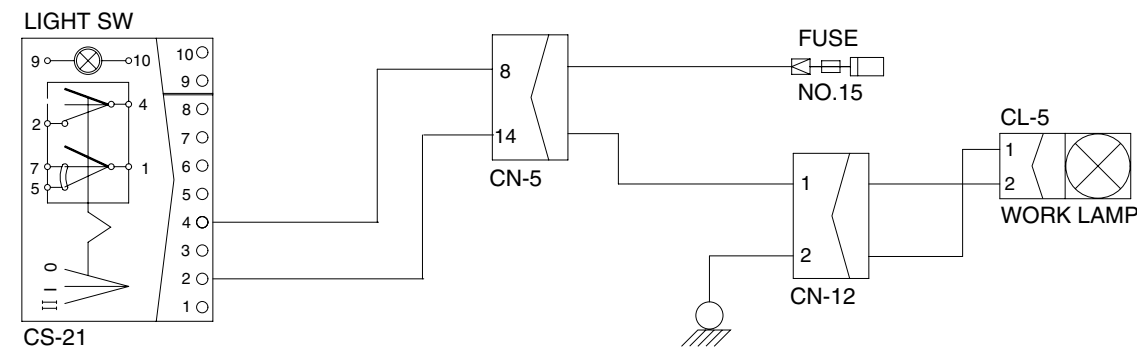
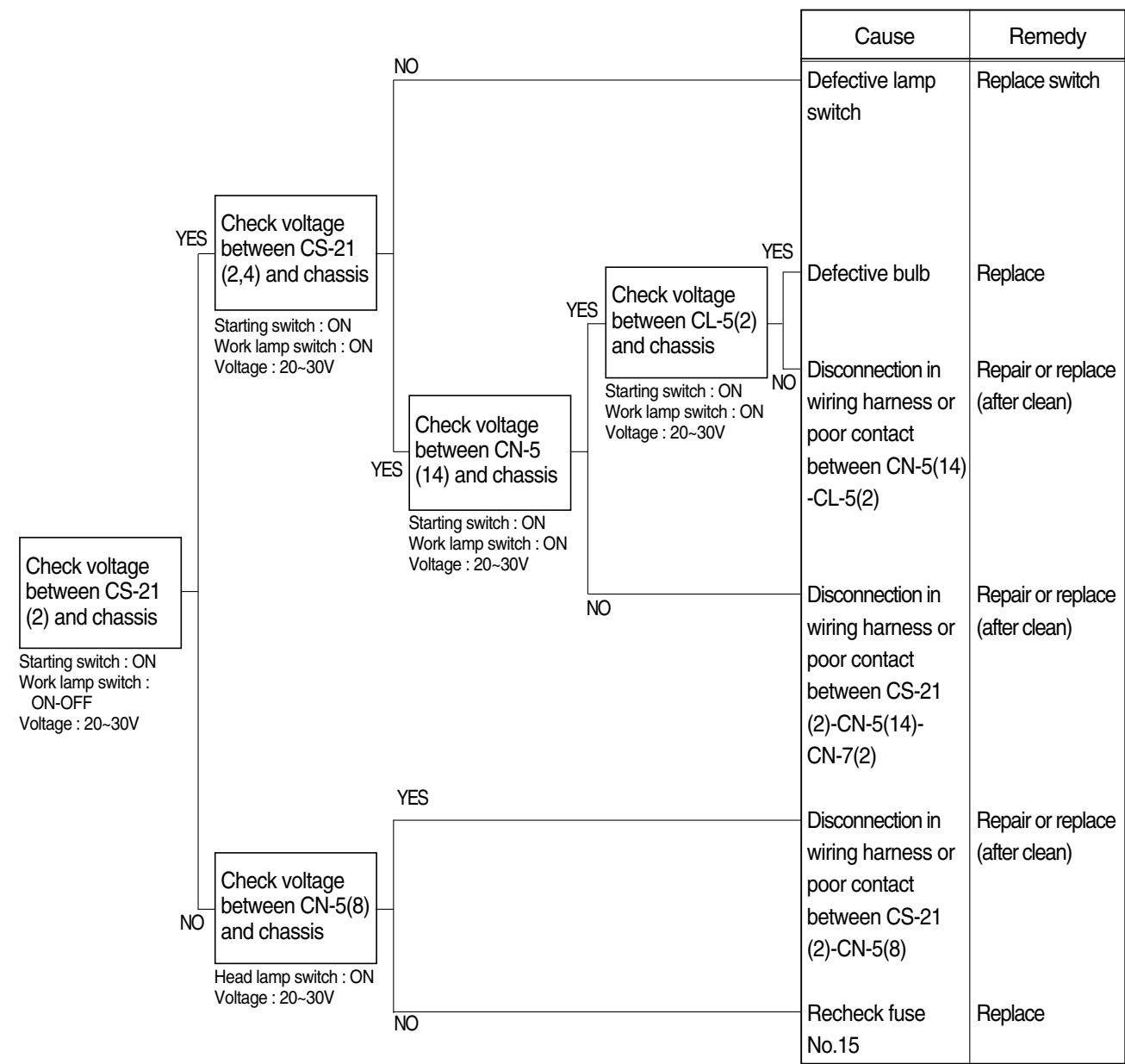
15. WHEN STARTING SWITCH IS TURNED ON, HEAD LAMP DOES NOT LIGHTS UP

- Before disconnecting the connector, always turn the starting switch OFF.
- Before carrying out below procedure, check all the related connectors are properly inserted and short of fuse No.14.
- After checking, insert the disconnected connectors again immediately unless otherwise specified.



16. WHEN STARTING SWITCH IS TURNED ON, WORK LAMP DOES NOT LIGHTS UP

- Before disconnecting the connector, always turn the starting switch OFF.
- Before carrying out below procedure, check all the related connectors are properly inserted and short of fuse No.15.
- After checking, insert the disconnected connectors again immediately unless otherwise specified.

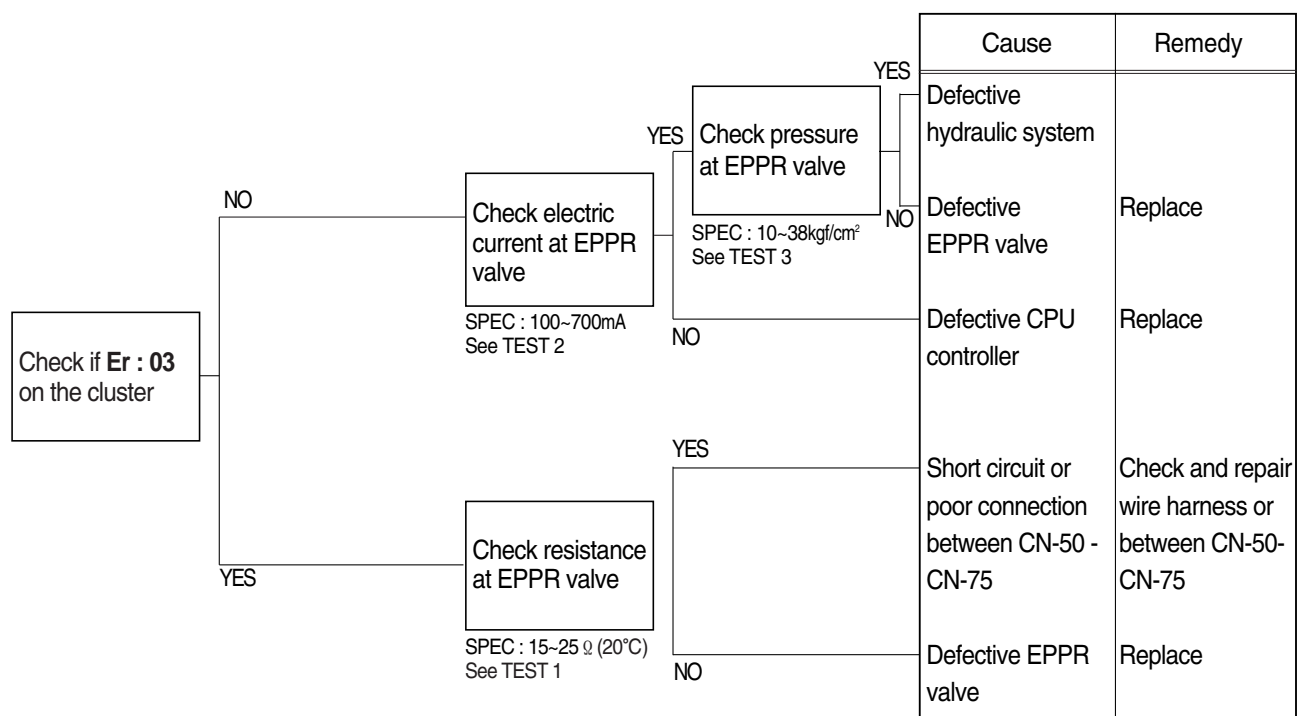


GROUP 4 MECHATRONICS SYSTEM

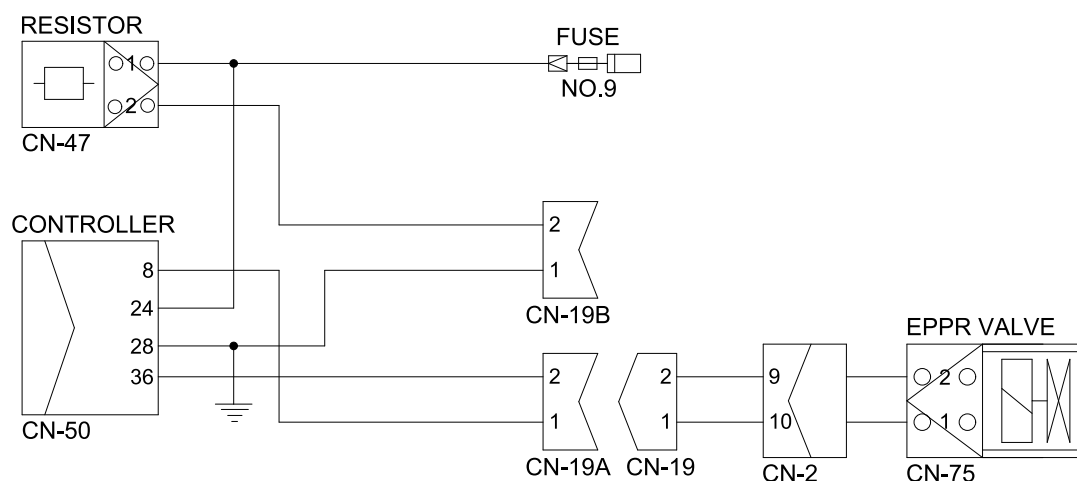
1. ALL ACTUATORS SPEED ARE SLOW

- ※ Boom, Arm, Bucket, Swing and travel speed are slow, but engine speed is good.
- ※ Spec : H-mode $1950 \pm 50\text{rpm}$ S-mode $1750 \pm 50\text{rpm}$
- ※ Before carrying out below procedure, check all the related connectors are properly inserted.

1) INSPECTION PROCEDURE



Wiring diagram



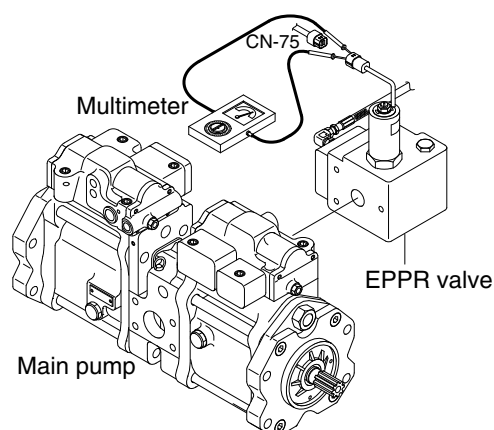
21076MS51

2) TEST PROCEDURE

(1) **Test 1** : Check resistance at connector CN-75.

- ① Starting key OFF.
- ② Disconnect connector CN-75 from EPPR valve at main hydraulic pump.
- ③ Check resistance between 2 lines as figure.

SPEC : 15~25 Ω (20° C)

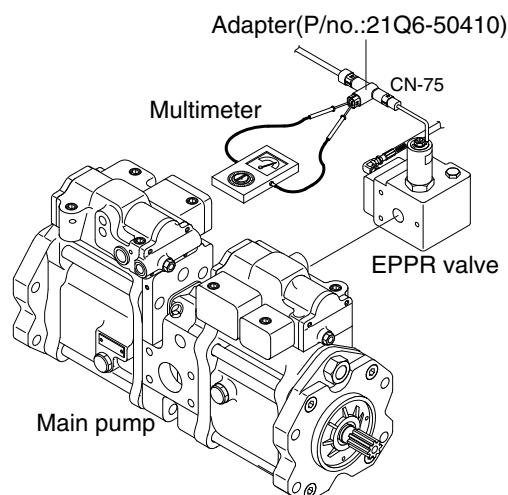


2107A5MS15

(2) **Test 2** : Check electric current at EPPR valve.

- ① Disconnect connector CN-75 from EPPR valve.
- ② Insert the adapter to CN-75 and install multimeter as figure.
- ③ Start engine.
- ④ Set S-mode and cancel auto decel mode.
- ⑤ Position the accel dial at 10.
- ⑥ If tachometer show approx 1750 ± 50 rpm disconnect one wire harness from EPPR valve.
- ⑦ Check electric current at bucket circuit relief position.

Spec : 100~700 mA

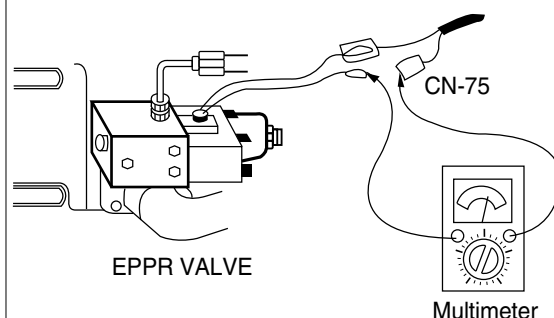


21095MS21

(3) **Test 3** : Check pressure at EPPR valve.

- ① Remove plug and connect pressure gauge as figure.
 - Gauge capacity : 0 to 50 kgf/cm² (0 to 725 psi)
- ② Start engine.
- ③ Set S-mode and cancel auto decel mode.
- ④ Position the accel dial at 10.
- ⑤ If tachometer show approx 1750 ± 50 rpm check pressure at relief position of bucket circuit by operating bucket control lever.
- ⑥ If pressure is not correct, adjust it.
- ⑦ After adjust, test the machine.

Spec : 10~38 kgf/cm² (142~540 psi)

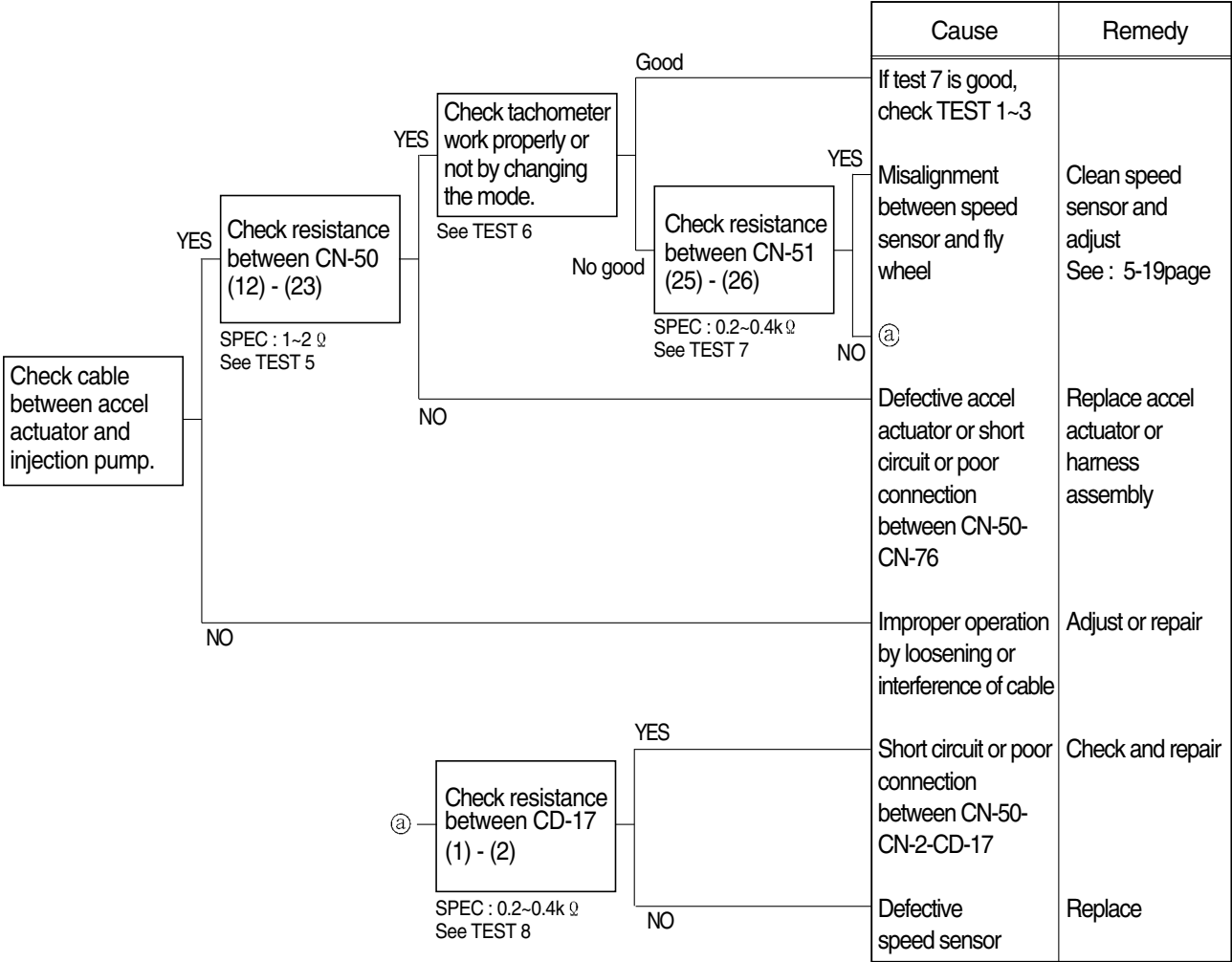


(210-7) 6-38(3)

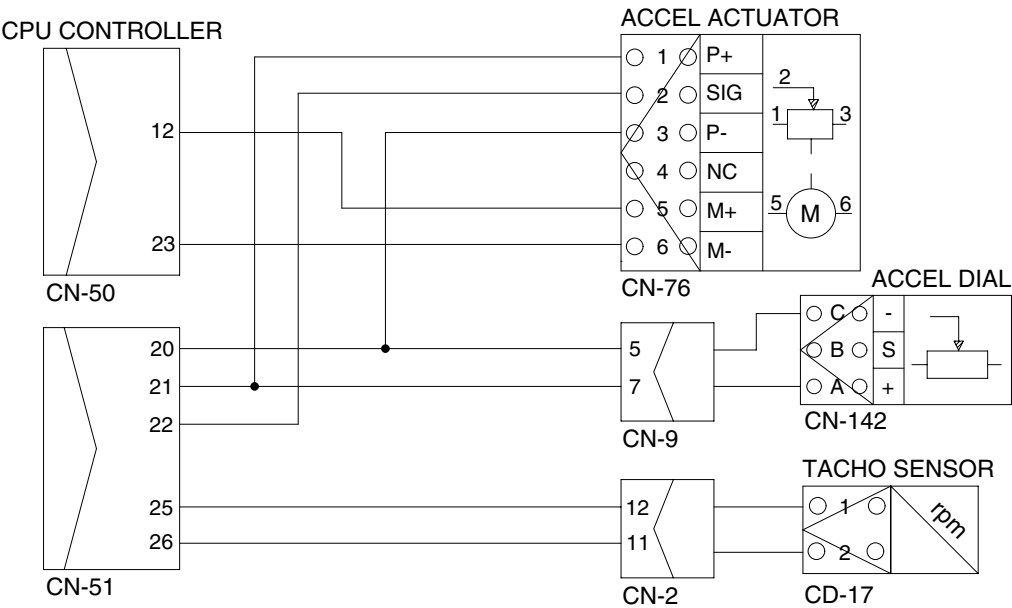
2. ENGINE SPEED IS SLOW AT ALL MODE

※ Before carrying out below procedure, check all the related connectors are properly inserted.

1) INSPECTION PROCEDURE

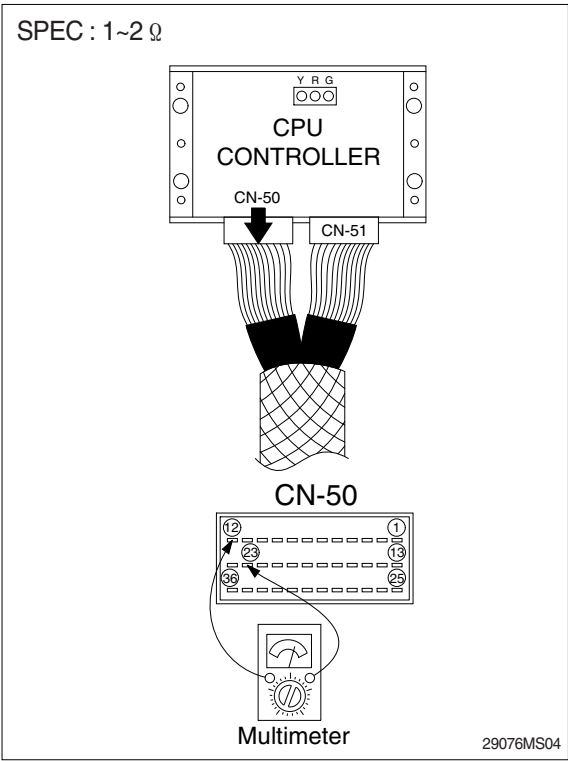


Wiring diagram



2) TEST PROCEDURE

- (1) **Test 5** : Check resistance between CN-50 (12)-(23).
- ① Starting key OFF.
 - ② Disconnect connector CN-50 from CPU controller.
 - ③ Check resistance as figure.



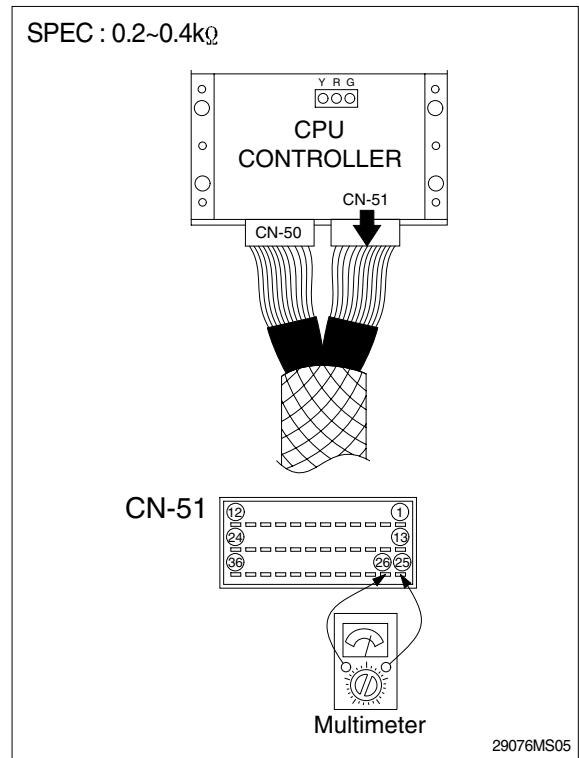
- (2) **Test 6** : Check tachometer(work properly or not)
- ① Start engine.
 - ② Check tachometer reading.

Unit : rpm

| Spec | | Remark |
|------|---------------|---|
| H | 1950 \pm 50 | Check rpm after cancel the Auto decel mode. |
| S | 1750 \pm 50 | |

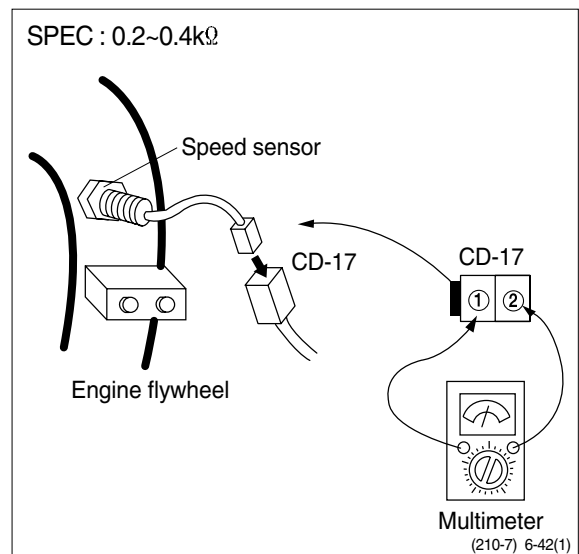
(3) **Test 7** : Check resistance between CN-51 (25) and CN-51(26).

- ① Starting key OFF.
- ② Disconnect connector CN-51 from CPU controller.
- ③ Check resistance as figure.



(4) **Test 8** : Check resistance at speed sensor.

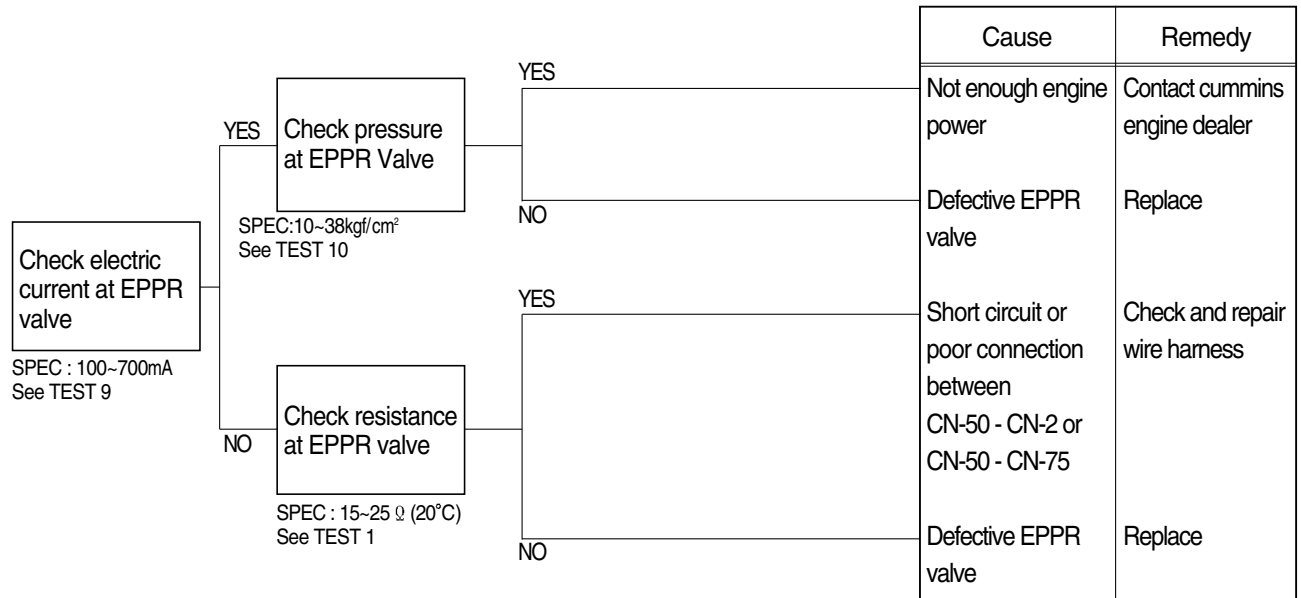
- ① Starting key OFF.
- ② Disconnect connector CD-17 of speed sensor at engine flywheel housing.
- ③ Check resistance as figure.



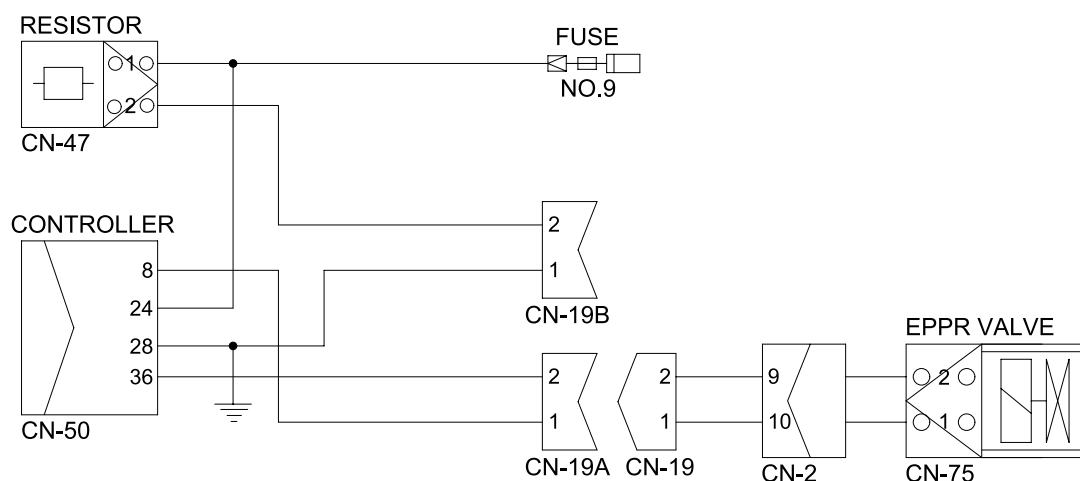
3. ENGINE STALL

※ Before carrying out below procedure, check all the related connectors are properly inserted.

1) INSPECTION PROCEDURE



Wiring diagram

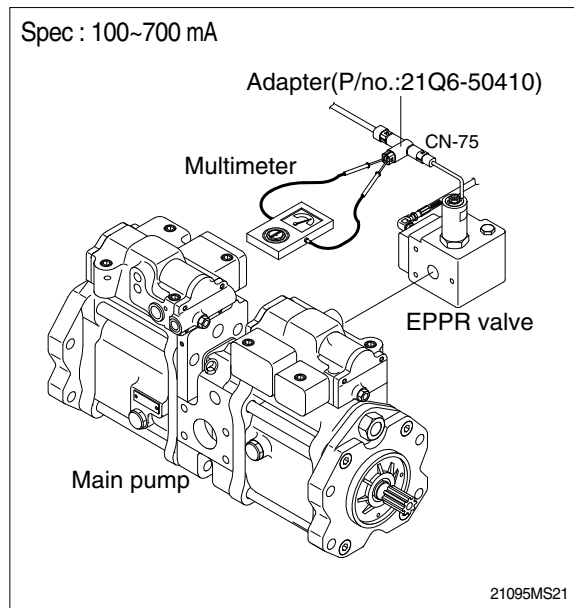


21076MS51

2) TEST PROCEDURE

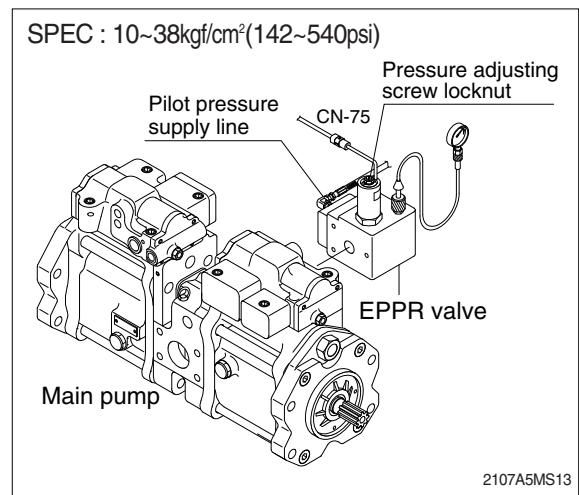
(1) **Test 9** : Check electric current at EPPR valve at S-mode

- ① Install multimeter as figure.
- ② Start engine.
- ③ Set the accel dial at "10"(max)
- ④ Set S-mode with 1750 ± 50 rpm.
- ⑤ Check electric current.



(2) **Test 10** : Check pressure at EPPR valve at S-mode

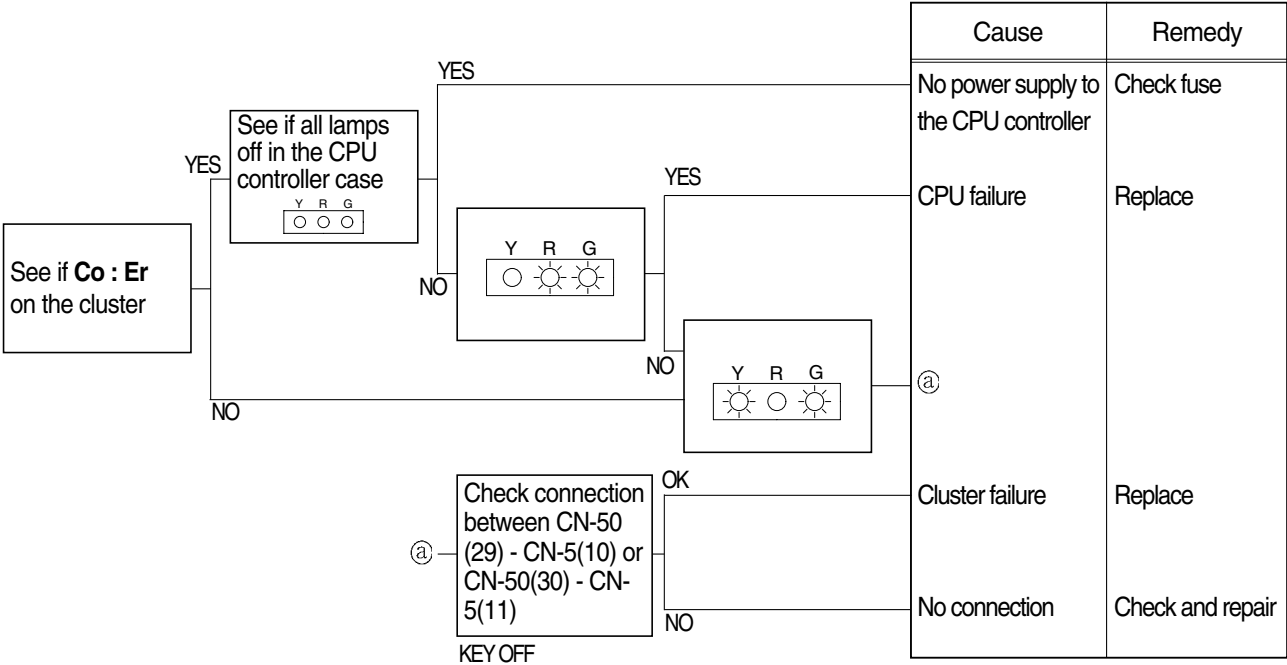
- ① Connect pressure gauge at EPPR valve.
- ② Start engine.
- ③ Set the accel dial at "10"(max)
- ④ Set S-mode with 1750 ± 50 rpm.
- ⑤ Operate bucket lever completely push or pull.
- ⑥ Hold arm lever at the end of stroke.
- ⑦ Check pressure at relief position.



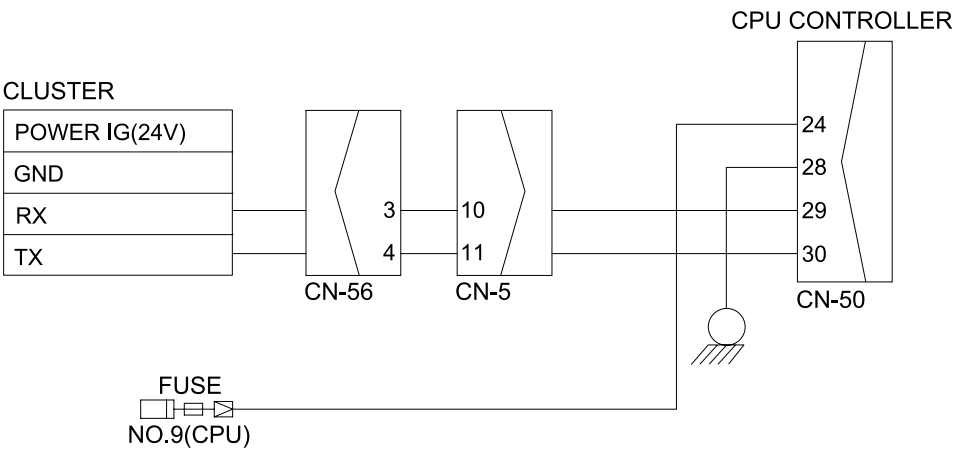
4. MALFUNCTION OF CLUSTER OR MODE SELECTION SYSTEM

※ Before carrying out below procedure, check all the related connectors are properly inserted.

1) INSPECTION PROCEDURE



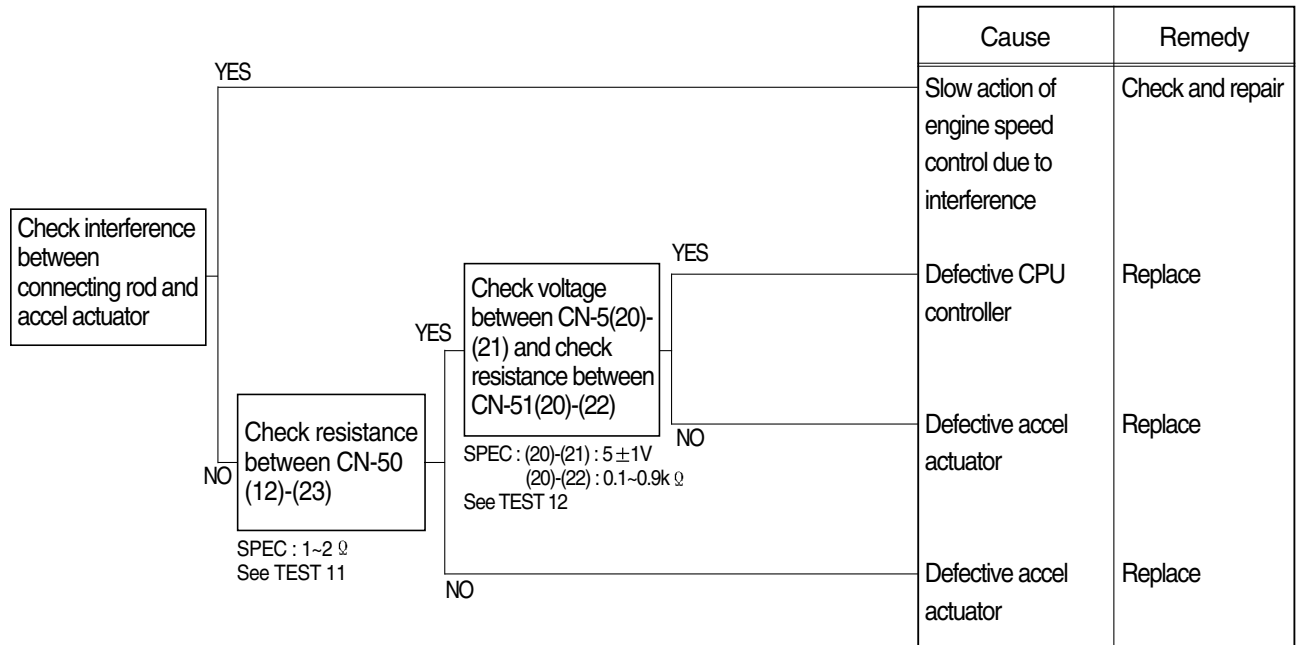
Wiring diagram



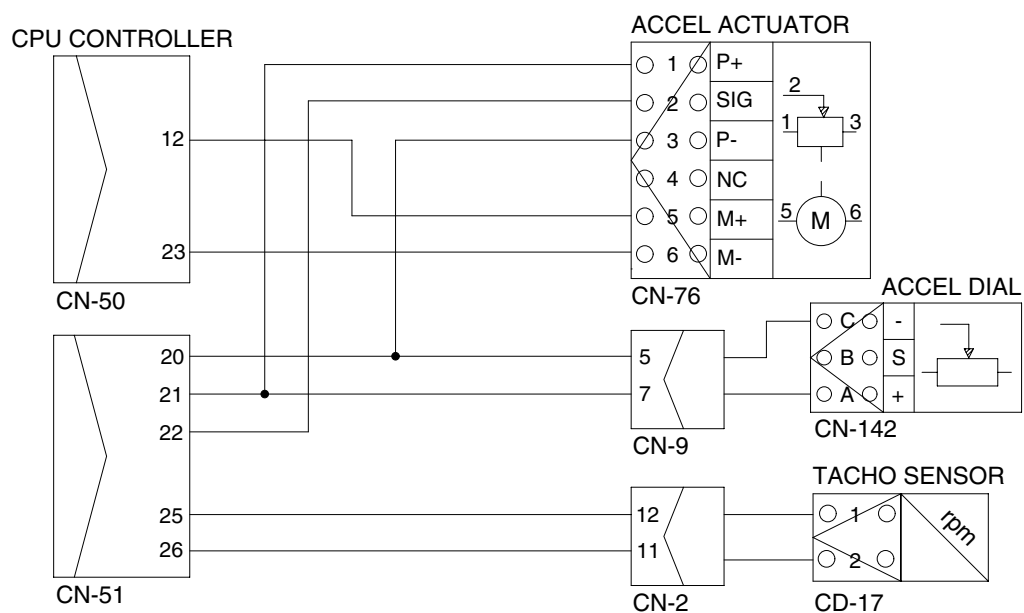
5. SLOW ACTION OF ENGINE SPEED CHANGE WHEN CHANGE THE MODE

※ Before carrying out below procedure, check all the related connectors are properly inserted.

1) INSPECTION PROCEDURE



Wiring diagram



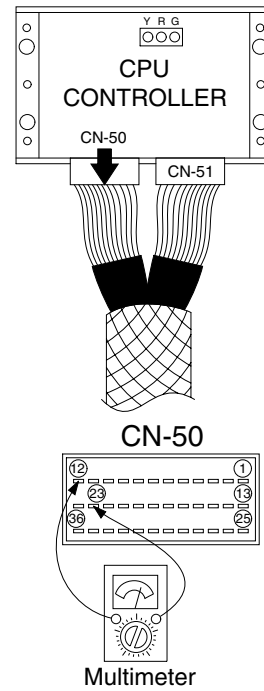
29076MS03

2) TEST PROCEDURE

(1) **Test 11** : Check resistance.

- ① Starting key OFF.
- ② Disconnect connector CN-50 from CPU controller.
- ③ Check resistance between CN-50(12)-(23) as figure.

SPEC : 1~2 Ω



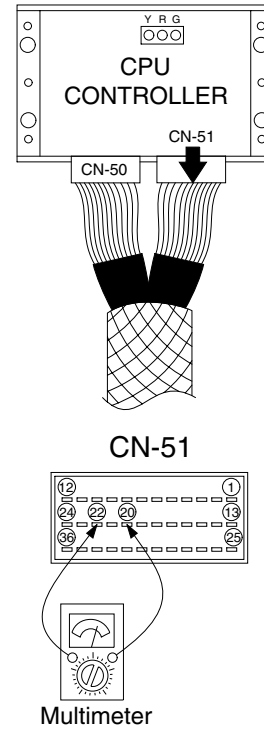
29076MS04

(2) **Test 12** : Check voltage and resistance.

① Check resistance between CN-51(20)-(22).

- Starting key OFF.
- Disconnect connector CN-51 from CPU controller.
- Check resistance value with multimeter as figure.

SPEC : 0.1~0.9k Ω

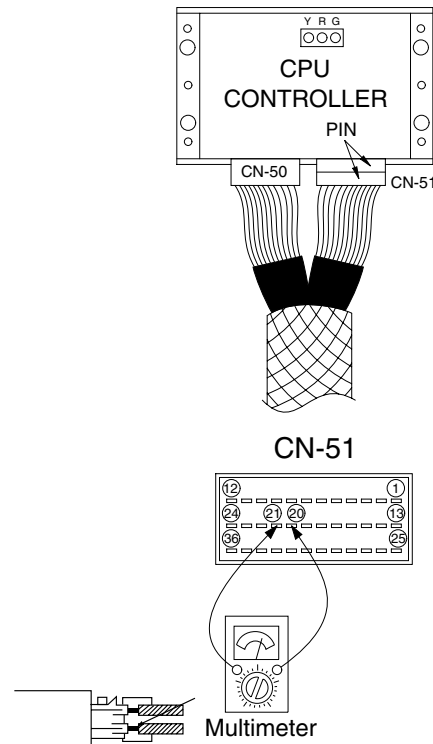


29076MS08

② Check voltage between CN-51(20) and CN-51(21).

- Prepare 2 pieces of thin sharp pin, steel or copper.
- Starting key ON.
- Insert prepared pins to rear side of connectors : One pin to CN-51(20)
Other pin to CN-51(21)
- Check voltage.

SPEC : 5 \pm 1V



29076MS09

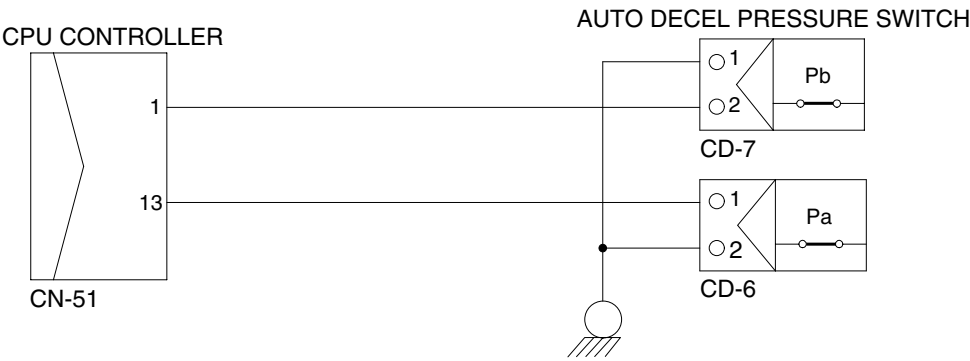
6. AUTO DECEL SYSTEM DOES NOT WORK

※ Before carrying out below procedure, check all the related connectors are properly inserted.

1) INSPECTION PROCEDURE

| | | Cause | Remedy |
|---|-----|--|-------------------|
| <div>Check resistance between CN-51 (1)-GND and CN-51(13)-GND</div> <div>SPEC : Actuator operating : 4~5V Actuator stop :0~1V See TEST 13 See TEST 14</div> | YES | Defective CPU controller | Replace |
| | NO | Short circuit or poor connection between CN-51(1), (13)- pressure switches | Replace or repair |
| | NO | Defective auto decel pressure switch | Replace |

Wiring diagram



29076MS10

2) TEST PROCEDURE

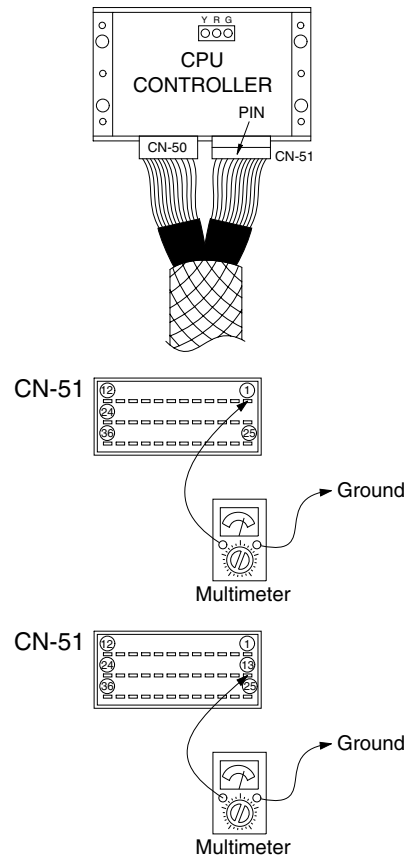
(1) **Test 13** : Check voltage at CN-51(1) and ground.

- ① Prepare 1 piece of thin sharp pin, steel or copper.
- ② Starting key ON.
- ③ Insert prepared pin to rear side of connectors : One pin to (1) of CN-51.
- ④ Check voltage as figure.

(2) **Test 14** : Check voltage at CN-51(13) and ground.

- ① Prepare 1 piece of thin sharp pin, steel or copper
- ② Starting key ON.
- ③ Insert prepared pin to rear side of connectors : One pin to (13) of CN-51.
- ④ Check voltage as figure.

SPEC : Actuator stop : 0~1V
Actuator operating : 4~5V

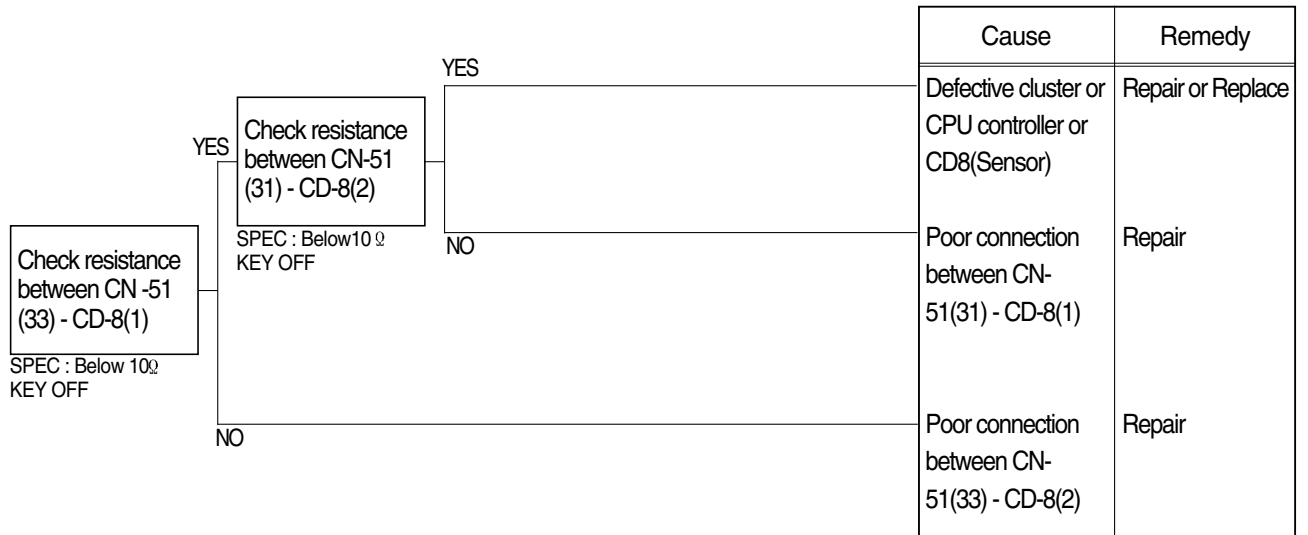


29076MS11

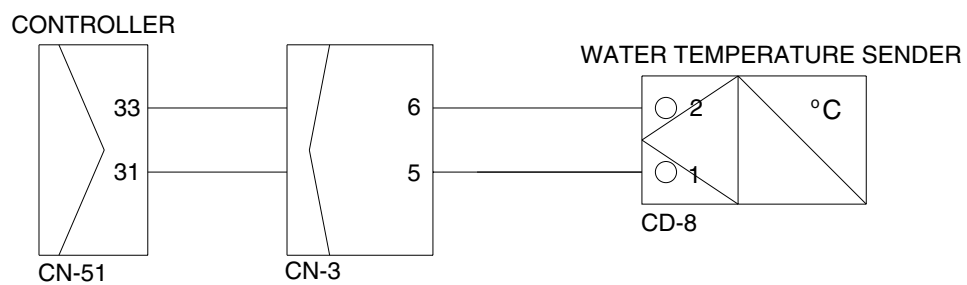
7. MALFUNCTION OF WARMING UP

※ Before carrying out below procedure, check all the related connectors are properly inserted.

1) INSPECTION PROCEDURE



Wiring diagram



RD21076ES53

SECTION 7 MAINTENANCE STANDARD

| | | |
|---------|------------------------------------|------|
| Group 1 | Operational Performance Test | 7-1 |
| Group 2 | Major Components | 7-21 |
| Group 3 | Track and Work Equipment | 7-30 |

SECTION 7 MAINTENANCE STANDARD

GROUP 1 OPERATIONAL PERFORMANCE TEST

1. PURPOSE

Performance tests are used to check:

1) OPERATIONAL PERFORMANCE OF A NEW MACHINE

Whenever a new machine is delivered in parts and reassembled at a customer's site, it must be tested to confirm that the operational performance of the machine meets **Hyundai spec.**

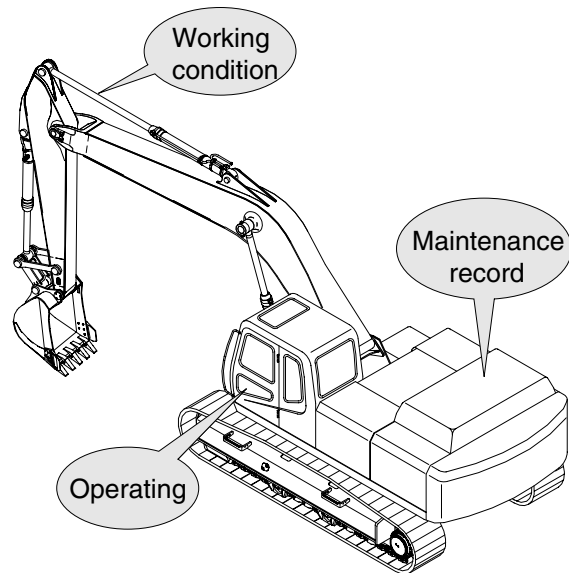
2) OPERATIONAL PERFORMANCE OF A WORKING MACHINE

With the passage of time, the machine's operational performance deteriorates, so that the machine needs to be serviced periodically to restore it to its original performance level.

Before servicing the machine, conduct performance tests to check the extent of deterioration, and to decide what kind of service needs to be done (by referring to the "Service Limits" in this manual).

3) OPERATIONAL PERFORMANCE OF A REPAIRED MACHINE

After the machine is repaired or serviced, it must be tested to confirm that its operational performance was restored by the repair and/or service work done.

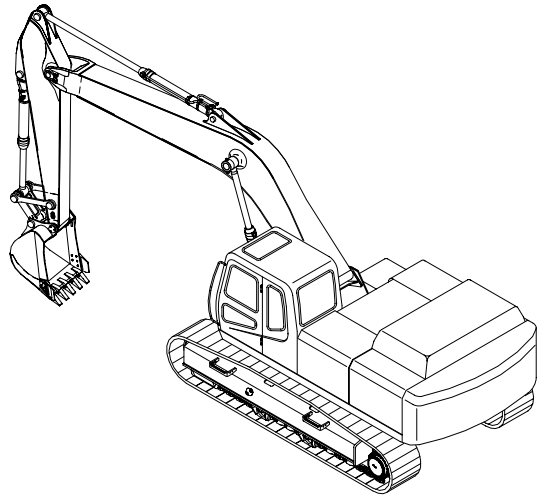


21077MS01

2. TERMINOLOGY

1) STANDARD

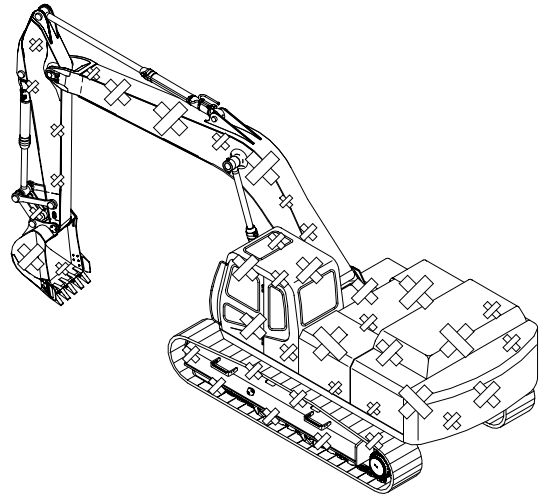
Specifications applied to the brand-new machine, components and parts.



21077MS02

2) SERVICE LIMIT

The lowest acceptable performance level. When the performance level of the machine falls below this level, the machine must be removed from work and repaired. Necessary parts and components must be replaced.



21077MS03

3. OPERATION FOR PERFORMANCE TESTS

- 1) Observe the following rules in order to carry out performance tests accurately and safely.

(1) The machine

Repair any defects and damage found, such as oil or water leaks, loose bolts, cracks and so on, before starting to test.

(2) Test area

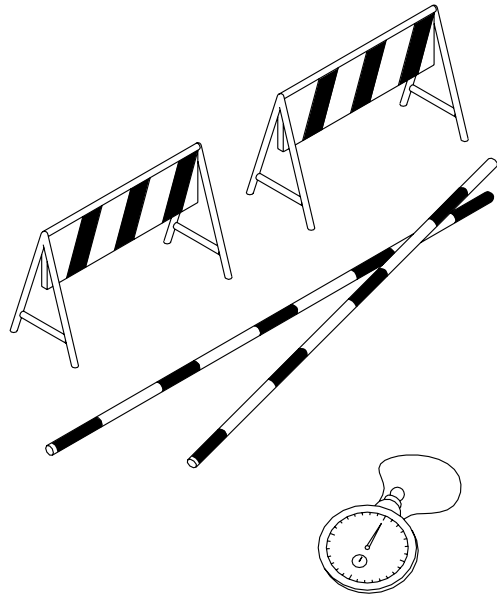
- ① Select a hard, flat surface.
- ② Secure enough space to allow the machine to run straight more than 20m, and to make a full swing with the front attachment extended.
- ③ If required, rope off the test area and provide signboards to keep unauthorized personnel away.

(3) Precautions

- ① Before starting to test, agree upon the signals to be employed for communication among coworkers. Once the test is started, be sure to communicate with each other using these signals, and to follow them without fail.
- ② Operate the machine carefully and always give first priority to safety.
- ③ While testing, always take care to avoid accidents due to landslides or contact with high voltage power lines. Always confirm that there is sufficient space for full swings.
- ④ Avoid polluting the machine and the ground with leaking oil. Use oil pans to catch escaping oil. Pay special attention to this when removing hydraulic pipings.

(4) Make precise measurements

- ① Accurately calibrate test instruments in advance to obtain correct data.
- ② Carry out tests under the exact test conditions prescribed for each test item.
- ③ Repeat the same test and confirm that the test data obtained can be procured repeatedly. Use mean values of measurements if necessary.



(210-7) 7-3

2) ENGINE SPEED

(1) Measure the engine speed at each power mode

- ※ The engine speed at each power mode must meet standard RPM; if not, all other operational performance data will be unreliable. It is essential to perform this test first.

(2) Preparation

- ① Warm up the machine, until the engine coolant temperature reaches 50°C or more, and the hydraulic oil is $50 \pm 5^\circ\text{C}$.
- ② Set the accel dial at 10(Max) position.
- ③ Push the H-mode switch and confirm that the fuel injection pump governor lever comes into contact with the high-idle stopper.
- ④ Measure the engine RPM.

(3) Measurement

- ① Start the engine. The engine will run at start idle speed. Measure engine speed with a tachometer.
- ② Measure and record the engine speed at each mode(H, S).
- ③ Select the H-mode.
- ④ Lightly operate the bucket control lever a few times, then return the control lever to neutral; The engine will automatically enter the auto-idle speed after 4 seconds.
- ⑤ Measure and record the auto deceleration speed.

(4) Evaluation

The measured speeds should meet the following specifications.

Unit : rpm

| Model | Engine speed | Standard | Remarks |
|---------|--------------|----------------|---------|
| R210-7V | Start idle | 1000 ± 100 | |
| | H mode | 1950 ± 50 | |
| | S mode | 1750 ± 50 | |
| | Auto decel | 1200 ± 100 | |

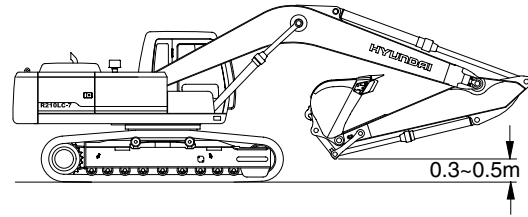
Condition : Set the accel dial at 10(Max) position.

3) TRAVEL SPEED

- (1) Measure the time required for the excavator to travel a 20m test track.

(2) Preparation

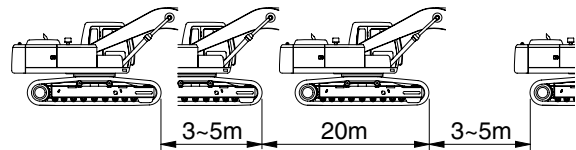
- ① Adjust the tension of both tracks to be equal.
- ② Prepare a flat and solid test track 20m in length, with extra length of 3 to 5m on both ends for machine acceleration and deceleration.
- ③ Hold the bucket 0.3 to 0.5m above the ground with the arm and bucket rolled in.
- ④ Keep the hydraulic oil temperature at $50 \pm 5^{\circ}\text{C}$.



21077MS04

(3) Measurement

- ① Measure both the low and high speeds of the machine.
- ② Before starting either the low or high speed tests, adjust the travel mode switch to the speed to be tested, then select the following switch positions.
 - Mode selector : H mode
- ③ Start traveling the machine in the acceleration zone with the travel levers at full stroke.
- ④ Measure the time required to travel 20m.
- ⑤ After measuring the forward travel speed, turn the upperstructure 180° and measure the reverse travel speed.
- ⑥ Repeat steps ④ and ⑤ three times in each direction and calculate the average values.



21077MS05

(4) Evaluation

The average measured time should meet the following specifications.

Unit : Seconds / 20m

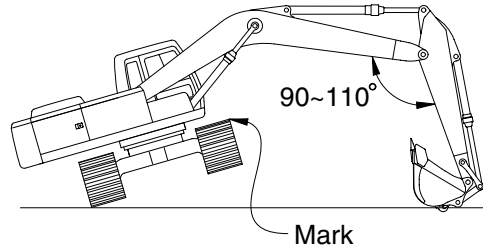
| Model | Travel speed | Standard | Maximum allowable | Remarks |
|---------|--------------|----------------|-------------------|---------|
| R210-7V | 1 Speed | 20.6 ± 2.0 | 25.7 | |
| | 2 Speed | 13.8 ± 1.0 | 17.3 | |

4) TRACK REVOLUTION SPEED

- (1) Measure the track revolution cycle time with the track raised off ground.

(2) Preparation

- ① Adjust the tension of both side tracks to be equal.
- ② On the track to be measured, mark one shoe with chalk.
- ③ Swing the upperstructure 90° and lower the bucket to raise the track off ground. Keep the boom-arm angle between 90 to 110° as shown. Place blocks under machine frame.
- ④ Keep the hydraulic oil temperature at $50 \pm 5^{\circ}\text{C}$.



21077MS06

(3) Measurement

- ① Select the following switch positions.
 - Travel mode switch : 1 or 2 speed
 - Mode selector : H mode
 - Auto decel switch : OFF
- ② Operate the travel control lever of the raised track in full forward and reverse.
- ③ Rotate 1 turn, then measure time taken for next 3 revolutions.
- ④ Raise the other side of machine and repeat the procedure.
- ⑤ Repeat steps ③ and ④ three times and calculate the average values.

(4) Evaluation

The revolution cycle time of each track should meet the following specifications.

Unit : Seconds / 3 revolutions

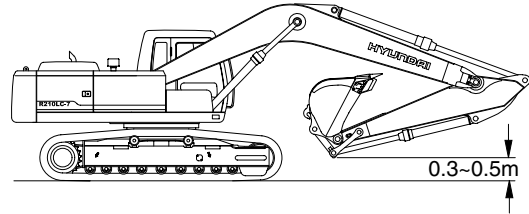
| Model | Travel speed | Standard | Maximum allowable |
|---------|--------------|----------------|-------------------|
| R210-7V | 1 Speed | 28.0 ± 2.0 | 35.0 |
| | 2 Speed | 18.0 ± 2.0 | 22.5 |

5) TRAVEL DEVIATION

- (1) Measure the deviation by the tracks from a 20m straight line.

(2) Preparation

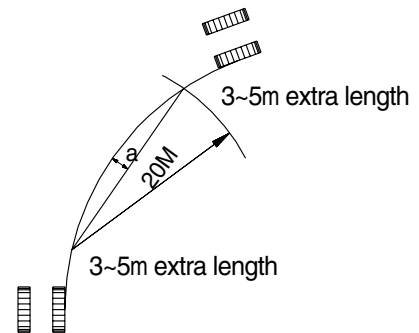
- ① Adjust the tension of both tracks to be equal.
- ② Provide a flat, solid test yard 20m in length, with extra length of 3 to 5m on both ends for machine acceleration and deceleration.
- ③ Hold the bucket 0.3 to 0.5m above the ground with the arm and bucket rolled in.
- ④ Keep the hydraulic oil temperature at $50 \pm 5^{\circ}\text{C}$.



21077MS04

(3) Measurement

- ① Measure the amount of mistracking at high and low travel speeds.
- ② Before beginning each test, select the following switch positions.
 - Mode selector : H mode
- ③ Start traveling the machine in the acceleration zone with the travel levers at full stroke.
- ④ Measure the distance between a straight 20m line and the track made by the machine.(Dimension a)
- ⑤ After measuring the tracking in forward travel, turn the upperstructure 180° and measure that in reverse travel.
- ⑥ Repeat steps ④ and ⑤ three times and calculate the average values.



(210-7) 7-7(2)

(4) Evaluation

Mistrack should be within the following specifications.

Unit : mm / 20m

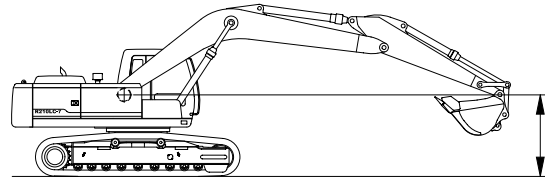
| Model | Standard | Maximum allowable | Remarks |
|---------|-----------|-------------------|---------|
| R210-7V | 200 below | 240 | |

6) SWING SPEED

- (1) Measure the time required to swing three complete turns.

(2) Preparation

- ① Check the lubrication of the swing gear and swing bearing.
- ② Place the machine on flat, solid ground with ample space for swinging. Do not conduct this test on slopes.
- ③ With the arm rolled out and bucket rolled in, hold the bucket so that the height of the bucket pin is the same as the boom foot pin. The bucket must be empty.
- ④ Keep the hydraulic oil temperature at $50 \pm 5^{\circ}\text{C}$.



21077MS07

(3) Measurement

- ① Select the following switch positions.
 - Mode selector : H mode
- ② Operate swing control lever fully.
- ③ Swing 1 turn and measure time taken to swing next 3 revolutions.
- ④ Repeat steps ② and ③ three times and calculate the average values.

(4) Evaluation

The time required for 3 swings should meet the following specifications.

Unit : Seconds / 3 revolutions

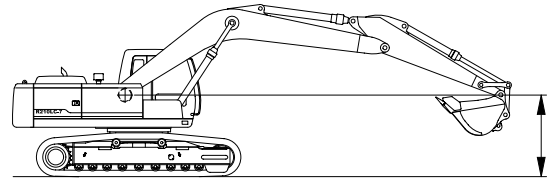
| Model | Power selector switch | Standard | Maximum allowable |
|---------|-----------------------|----------------|-------------------|
| R210-7V | H mode | 14.6 ± 1.5 | 19.0 |

7) SWING FUNCTION DRIFT CHECK

- (1) Measure the swing drift on the bearing outer circumference when stopping after a 360° full speed swing.

(2) Preparation

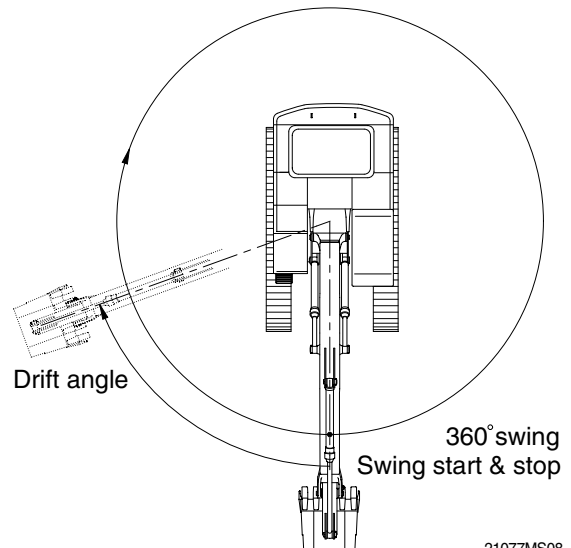
- ① Check the lubrication of the swing gear and swing bearing.
- ② Place the machine on flat, solid ground with ample space for swinging. Do not conduct this test on slopes.
- ③ With the arm rolled out and bucket rolled in, hold the bucket so that the height of the bucket pin is the same as the boom foot pin. The bucket must be empty.
- ④ Make two chalk marks: one on the swing bearing and one directly below it on the track frame.
- ⑤ Swing the upperstructure 360°.
- ⑥ Keep the hydraulic oil temperature at $50 \pm 5^{\circ}\text{C}$.



21077MS07

(3) Measurement

- ① Conduct this test in the H mode.
- ② Select the following switch positions.
 - Mode selector : H mode
- ③ Operate the swing control lever fully and return it to the neutral position when the mark on the upperstructure aligns with that on track frame after swinging 360°
- ④ Measure the distance between the two marks.
- ⑤ Align the marks again, swing 360°, then test the opposite direction.
- ⑥ Repeat steps ④ and ⑤ three times each and calculate the average values.



21077MS08

(4) Evaluation

The measured drift angle should be within the following specifications.

Unit : Degree

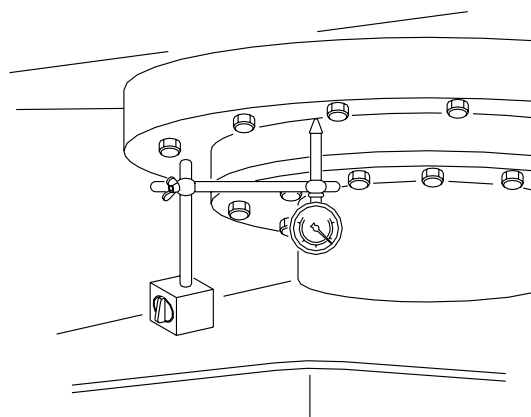
| Model | Mode select switch | Standard | Maximum allowable | Remarks |
|---------|--------------------|----------|-------------------|---------|
| R210-7V | H mode | 90 below | 157.5 | |

8) SWING BEARING PLAY

- (1) Measure the swing bearing play using a dial gauge to check the wear of bearing races and balls.

(2) Preparation

- ① Check swing bearing mounting cap screws for loosening.
- ② Check the lubrication of the swing bearing. Confirm that bearing rotation is smooth and without noise.
- ③ Install a dial gauge on the track frame as shown, using a magnetic base.
- ④ Position the upperstructure so that the boom aligns with the tracks facing towards the front idlers.
- ⑤ Position the dial gauge so that its needle point comes into contact with the bottom face of the bearing outer race.
- ⑥ Bucket should be empty.



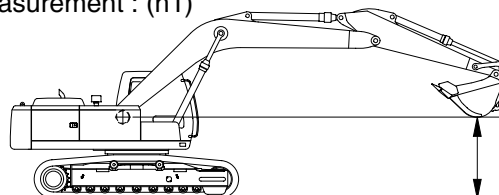
(210-7) 7-10(1)

(3) Measurement

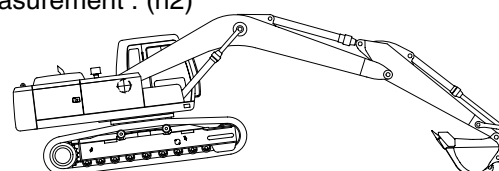
- ① With the arm rolled out and bucket rolled in, hold the bottom face of the bucket to the same height of the boom foot pin. Record the dial gauge reading(h1).
- ② Lower the bucket to the ground and use it to raise the front idler 50cm. Record the dial gauge reading(h2).
- ③ Calculate bearing play(H) from this data(h1 and h2) as follows.

$$H = h2 - h1$$

Measurement : (h1)



Measurement : (h2)



21077MS09

(4) Evaluation

The measured drift should be within the following specifications.

Unit : mm

| Model | Standard | Maximum allowable | Remarks |
|---------|-----------|-------------------|---------|
| R210-7V | 0.5 ~ 1.5 | 3.0 | |

9) HYDRAULIC CYLINDER CYCLE TIME

- (1) Measure the cycle time of the boom, standard arm, and standard bucket cylinders.

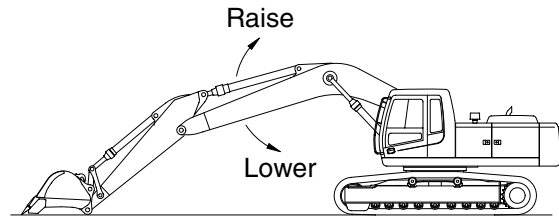
(2) Preparation

- ① To measure the cycle time of the boom cylinders:
With the arm rolled out and the empty bucket rolled out, lower the bucket to the ground, as shown.
- ② To measure the cycle time of the arm cylinder:
With the empty bucket rolled in, position the arm so that it is vertical to the ground. Lower the boom until the bucket is 0.5m above the ground.
- ③ To measure the cycle time of the bucket cylinder:
The empty bucket should be positioned at midstroke between roll-in and roll-out, so that the sideplate edges are vertical to the ground.
- ④ Keep the hydraulic oil temperature at $50 \pm 5^\circ\text{C}$.

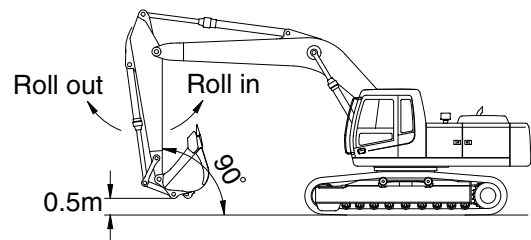
(3) Measurement

- ① Select the following switch positions.
 - Mode selector : H mode
- ② To measure cylinder cycle times.
 - Boom cylinders.
Measure the time it takes to raise the boom, and the time it takes to lower the boom. To do so, position the boom at one stroke end then move the control lever to the other stroke end as quickly as possible.
 - Arm cylinder.
Measure the time it takes to roll in the arm, and the time it takes to roll out the arm. To do so, position the bucket at one stroke end, then move the control lever to the other stroke end as quickly as possible.

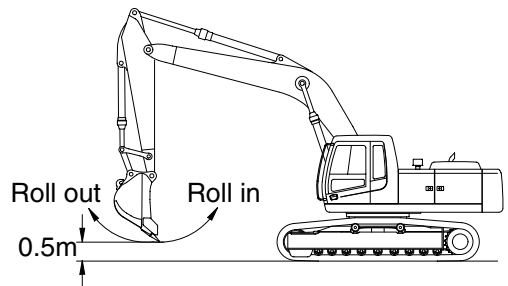
Boom cylinder



Arm cylinder



Bucket cylinder



21077MS10

- Bucket cylinders

Measure the time it takes to roll in the bucket, and the time it takes to roll out the bucket. To do so, position the bucket at one stroke end, then move the control lever to the other stroke end as quickly as possible.

- Repeat each measurement 3 times and calculate the average values.

(4) Evaluation

The average measured time should meet the following specifications.

Unit : Seconds

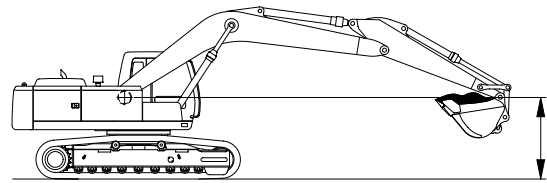
| Model | Function | Standard | Maximum allowable | Remarks |
|---------|-------------|---------------|-------------------|---------|
| R210-7V | Boom raise | 3.4 ± 0.4 | 4.5 | |
| | Boom lower | 2.9 ± 0.4 | 3.6 | |
| | Arm in | 3.6 ± 0.4 | 4.1 | |
| | Arm out | 2.9 ± 0.3 | 3.6 | |
| | Bucket load | 3.6 ± 0.4 | 4.4 | |
| | Bucket dump | 2.3 ± 0.3 | 3.0 | |

10) DIG FUNCTION DRIFT CHECK

- (1) Measure dig function drift, which can be caused by oil leakage in the control valve and boom, standard arm, and standard bucket cylinders, with the loaded bucket. When testing the dig function drift just after cylinder replacement, slowly operate each cylinder to its stroke end to purge air.

(2) Preparation

- ① Load bucket fully. Instead of loading the bucket, weight(W) of the following specification can be used.
 - $W = M^3 \times 1.5$
 - Where :
 - M^3 = Bucket heaped capacity(m^3)
 - 1.5 = Soil specific gravity
- ② Position the arm cylinder with the rod 20 to 30mm extended from the fully retracted position.
- ③ Position the bucket cylinder with the rod 20 to 30mm retracted from the fully extended position.
- ④ With the arm rolled out and bucket rolled in, hold the bucket so that the height of the bucket pin is the same as the boom foot pin.
- ⑤ Keep the hydraulic oil temperature at $50 \pm 5^\circ\text{C}$.



21077MS11

(3) Measurement

- ① Stop the engine.
- ② Five minutes after the engine has been stopped, measure the changes in the positions of the boom, arm and bucket cylinders.
- ③ Repeat step ② three times and calculate the average values.

- (4) The measured drift should be within the following specifications.

Unit : mm / 5min

| Model | Drift to be measured | Standard | Maximum allowable | Remarks |
|---------|----------------------|----------|-------------------|---------|
| R210-7V | Boom cylinder | 10 below | 20 | |
| | Arm cylinder | 10 below | 20 | |
| | Bucket cylinder | 40 below | 50 | |

11) CONTROL LEVER OPERATING FORCE

- (1) Use a spring scale to measure the maximum resistance of each control lever at the middle of the grip.

(2) Preparation

- ① Keep the hydraulic oil temperature at $50 \pm 5^{\circ}\text{C}$.

(3) Measurement

- ① Start the engine.
- ② Select the following switch positions.
- Mode selector : H mode
- ③ Operate each boom, arm, bucket and swing lever at full stroke and measure the maximum operating force for each.
- ④ Lower the bucket to the ground to raise one track off the ground. Operate the travel lever at full stroke and measure the maximum operating force required. When finished, lower the track and then jack-up the other track.
- ⑤ Repeat steps ③ and ④ three times and calculate the average values.

(4) Evaluation

The measured operating force should be within the following specifications.

Unit : kgf

| Model | Kind of lever | Standard | Maximum allowable | Remarks |
|---------|---------------|--------------|-------------------|---------|
| R210-7V | Boom lever | 1.6 or below | 2.0 | |
| | Arm lever | 1.6 or below | 2.0 | |
| | Bucket lever | 1.6 or below | 2.0 | |
| | Swing lever | 1.6 or below | 2.0 | |
| | Travel lever | 2.1 or below | 3.15 | |

12) CONTROL LEVER STROKE

- (1) Measure each lever stroke at the lever top using a ruler.

※ When the lever has play, take a half of this value and add it to the measured stroke.

(2) Preparation

Keep the hydraulic oil temperature at $50 \pm 5^{\circ}\text{C}$.

(3) Measurement

- ① Stop the engine.
- ② Measure each lever stroke at the lever top from neutral to the stroke end using a ruler.
- ③ Repeat step ② three times and calculate the average values.

(4) Evaluation

The measured drift should be within the following specifications.

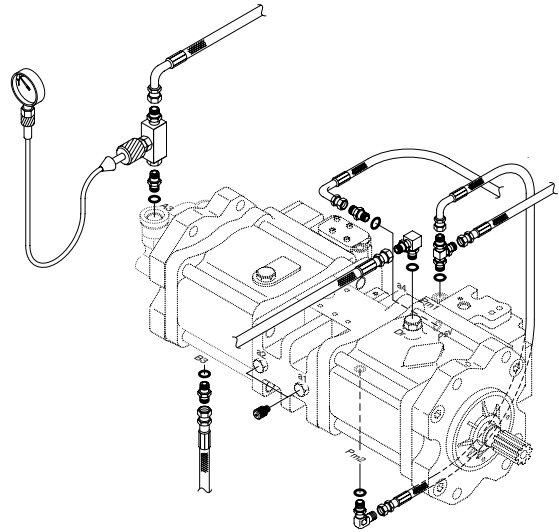
Unit : mm

| Model | Kind of lever | Standard | Maximum allowable | Remarks |
|---------|---------------|--------------|-------------------|---------|
| R210-7V | Boom lever | 87 ± 10 | 109 | |
| | Arm lever | 87 ± 10 | 109 | |
| | Bucket lever | 87 ± 10 | 109 | |
| | Swing lever | 87 ± 10 | 109 | |
| | Travel lever | 142 ± 10 | 178 | |

13)PILOT PRIMARY PRESSURE

(1) Preparation

- ① Stop the engine.
- ② Remove the top cover of the hydraulic tank oil supply port with a wrench.
- ③ Loosen and remove plug on the pilot pump delivery port and connect pressure gauge.
- ④ Start the engine and check for oil leakage from the port.
- ⑤ Keep the hydraulic oil temperature at $50 \pm 5^{\circ}\text{C}$.



21077MS12

(2) Measurement

- ① Select the following switch positions.
 - Mode selector : H mode
 - Auto decel switch : OFF
- ② Measure the primary pilot pressure in the M mode.

(3) Evaluation

The average measured pressure should meet the following specifications:

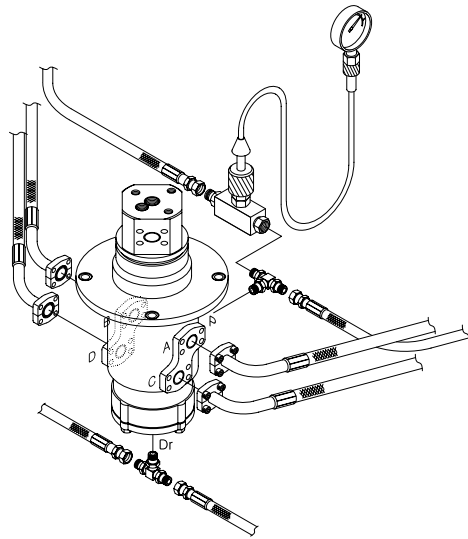
Unit : kgf / cm^2

| Model | Engine speed | Standard | Allowable limits | Remarks |
|---------|--------------|-------------|------------------|---------|
| R210-7V | H mode | 35^{+2}_0 | - | |

14)FOR TRAVEL SPEED SELECTING PRESSURE:

(1) Preparation

- ① Stop the engine.
- ② Remove the top cover of the hydraulic tank oil supply port with a wrench.
- ③ Push the pressure release button to bleed air.
- ④ To measure the speed selecting pressure: Install a connector and pressure gauge assembly to turning joint P port as shown.
- ⑤ Start the engine and check for on leakage from the adapter.
- ⑥ Keep the hydraulic oil temperature at $50 \pm 5^{\circ}\text{C}$.



21077MS13

(2) Measurement

- ① Select the following switch positions.
Travel mode switch : 1 speed
 2 speed
• Mode selector : H mode
- ② Measure the travel speed selecting pressure in the Hi or Lo mode.
- ③ Lower the bucket to the ground to raise the track off the ground. Operate the travel lever at full stroke and measure the fast speed pressure.
- ④ Repeat steps ② and ③ three times and calculate the average values.

(3) Evaluation

The average measured pressure should be within the following specifications.

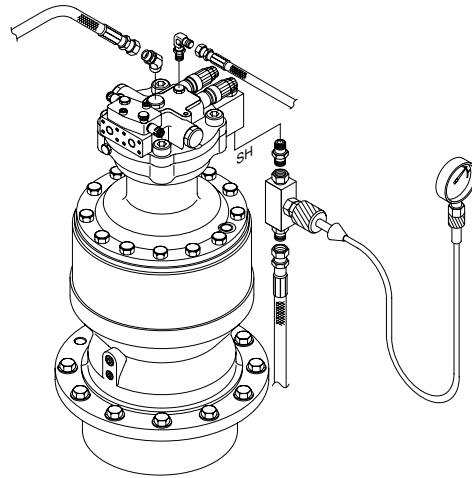
Unit : kgf / cm²

| Model | Travel speed mode | Standard | Maximum allowable | Remarks |
|---------|-------------------|----------|-------------------|---------|
| R210-7V | 1 Speed | 0 | - | |
| | 2 Speed | 35 ±5 | - | |

15) SWING PARKING BRAKE RELEASING PRESSURE

(1) Preparation

- ① Stop the engine.
- ② Remove the top cover of the hydraulic tank oil supply port with a wrench.
- ③ Use the pressure release L wrench to bleed air.
- ④ Install a connector and pressure gauge assembly to swing motor SH port, as shown.
- ⑤ Start the engine and check for oil leakage from the adapter.
- ⑥ Keep the hydraulic oil temperature at $50 \pm 5^{\circ}\text{C}$.



21077MS14

(2) Measurement

- ① Select the following switch positions.
 - Mode selector : H mode
- ② Operate the swing function or arm roll in function and measure the swing brake control pressure with the brake disengaged. Release the control lever to return to neutral and measure the control pressure when the brake is applied.
Repeat step ② three times and calculate the average values.

(3) Evaluation

The average measured pressure should be within the following specifications.

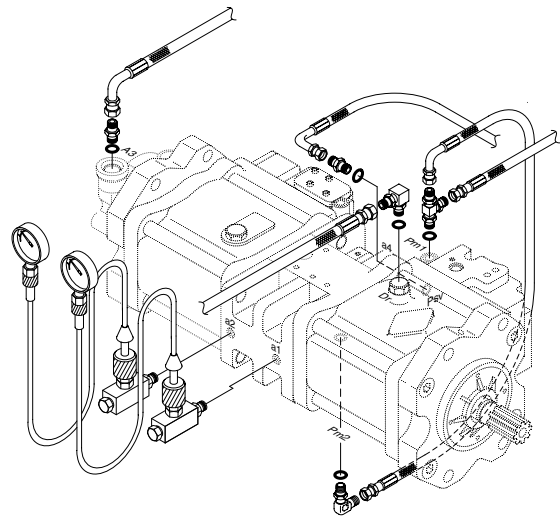
Unit : kgf / cm^2

| Model | Description | Standard | Allowable limits | Remarks |
|---------|------------------|----------|------------------|---------|
| R210-7V | Brake disengaged | 35 | 26~44 | |
| | Brake applied | 0 | - | |

16) MAIN PUMP DELIVERY PRESSURE

(1) Preparation

- ① Stop the engine.
- ② Remove the top cover of the hydraulic tank oil supply port with a wrench.
- ③ Push the pressure release button to bleed air.
- ④ To measure the main pump pressure.
Install a connector and pressure gauge assembly main pump gauge port as shown.
- ⑤ Start the engine and check for oil leakage from the port.
- ⑥ Keep the hydraulic oil temperature at $50 \pm 5^{\circ}\text{C}$.



21077MS15

(2) Measurement

- ① Select the following switch positions.
 - Mode selector : H mode
- ② Measure the main pump delivery pressure in the H mode(High idle).

(3) Evaluation

The average measured pressure should meet the following specifications.

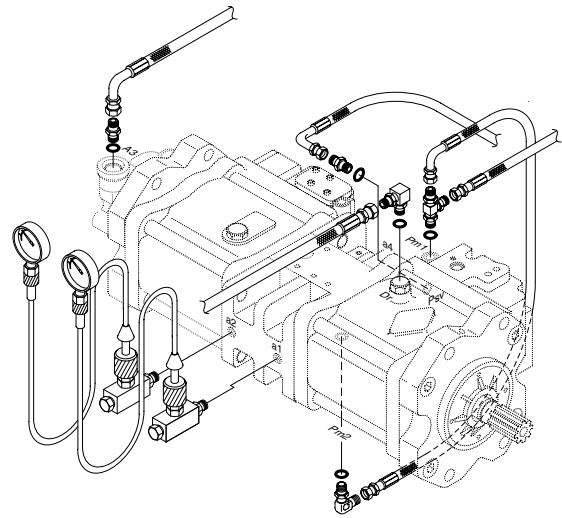
Unit : kgf / cm²

| Model | Engine speed | Standard | Allowable limits | Remarks |
|---------|--------------|--------------|------------------|---------|
| R210-7V | High idle | 330 ± 10 | - | |

17) SYSTEM PRESSURE REGULATOR RELIEF SETTING

(1) Preparation

- ① Stop the engine.
- ② Remove the top cover of the hydraulic tank oil supply port with a wrench.
- ③ Push the pressure release button to bleed air.
- ④ To measure the system relief pressure. Install a connector and pressure gauge assembly main pump gauge port, as shown.
- ⑤ Start the engine and check for oil leakage from the port.
- ⑥ Keep the hydraulic oil temperature at $50 \pm 5^{\circ}\text{C}$.



21077MS15

(2) Measurement

- ① Select the following switch positions.
 - Mode selector : H mode
- ② Slowly operate each control lever of boom, arm and bucket functions at full stroke over relief and measure the pressure.
- ③ In the swing function, place bucket against an immovable object and measure the relief pressure.
- ④ In the travel function, lock undercarriage with an immovable object and measure the relief pressure.

(3) Evaluation

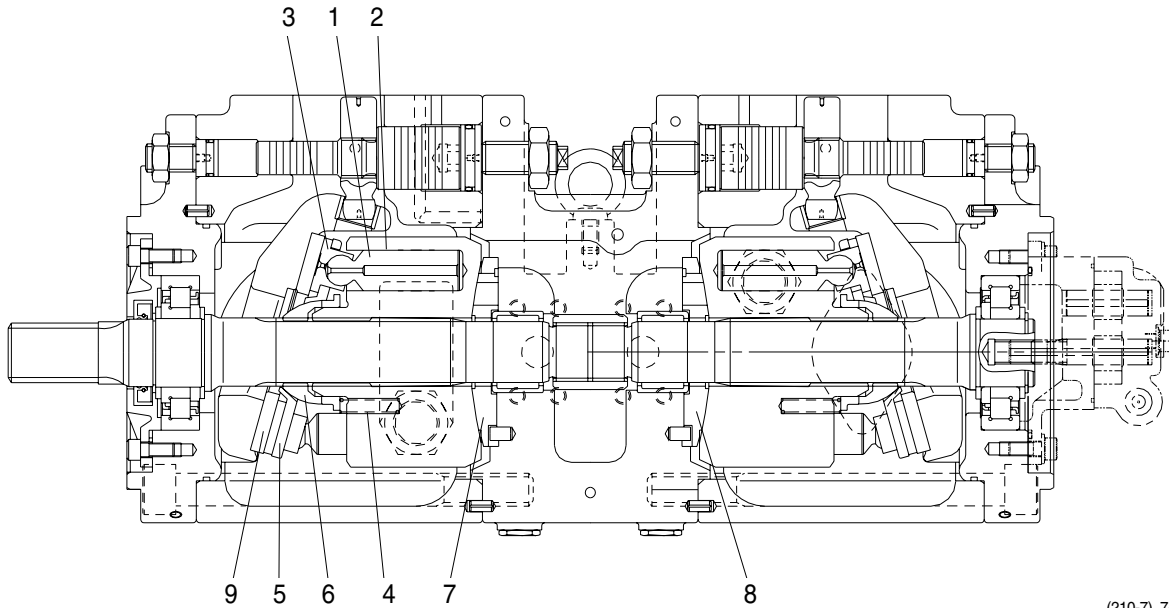
The average measured pressure should be within the following specifications.

Unit : kgf / cm^2

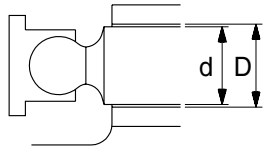
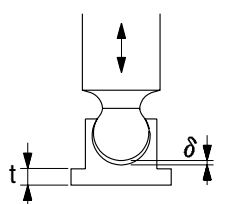
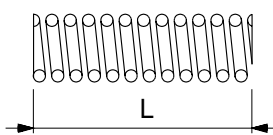
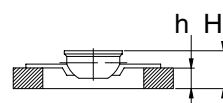
| Model | Function to be tested | Standard | Maximum allowable |
|---------|-----------------------|--------------|-------------------|
| R210-7V | Boom, Arm, Bucket | 330 ± 10 | 390 ± 10 |
| | Travel | 330 ± 10 | - |
| | Swing | 240 ± 10 | - |

GROUP 2 MAJOR COMPONENT

1. MAIN PUMP



(210-7) 7-21

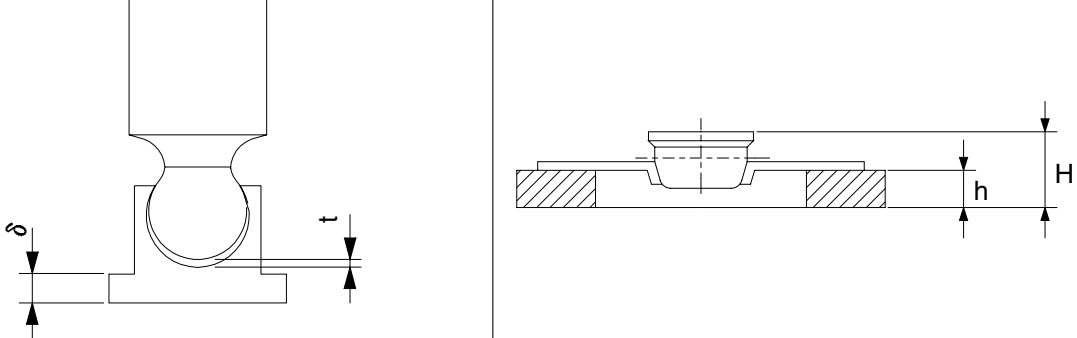
| Part name & inspection item | | Standard dimension | Recommended replacement value | Counter measures |
|---|---|--------------------|-------------------------------|------------------------------------|
| Clearance between piston(1) & cylinder bore(2) (D-d) |  | 0.039 | 0.067 | Replace piston or cylinder. |
| Play between piston(1) & shoe caulking section(3) (δ) |  | 0-0.1 | 0.3 | Replace assembly of piston & shoe. |
| Thickness of shoe (t) | | 4.9 | 4.7 | |
| Free height of cylinder spring(4) (L) |  | 41.1 | 40.3 | Replace cylinder spring. |
| Combined height of set plate(5) & spherical bushing(6) (H-h) |  | 23.0 | 22.0 | Replace retainer or set plate. |
| Surface roughness for valve plate(Sliding face)(7,8), swash plate (shoe plate area)(9), & cylinder(2)(Sliding face) | Surface roughness necessary to be corrected | 3z | | Lapping |
| | Standard surface roughness (Corrected value) | 0.4z or lower | | |

2. MAIN CONTROL VALVE

| Part name | Inspection item | Criteria & measure |
|---|---|---|
| Casing | <ul style="list-style-type: none"> • Existence of scratches, rust or corrosion. | <ul style="list-style-type: none"> • In case of damage in following section, replace casing. - Sliding sections of casing hole and spool, especially land sections applied with held pressure. - Seal pocket section where spool is inserted. - Sealing section of port where O-ring contacts. - Sealing section of each relief valve for main and port. - Sealing section of plug. - Other damages that may damage normal function. |
| Spool | <ul style="list-style-type: none"> • Existence of scratch, gnawing, rusting or corrosion. • O-ring seal sections at both ends. • Insert spool into casing hole, rotate and reciprocate it. | <ul style="list-style-type: none"> • Replacement when its outside sliding section has scratch (especially on seals-contacting section). • Replacement when its sliding section has scratch. • Correction or replacement when O-ring is damaged or when spool does not move smoothly. |
| Poppet | <ul style="list-style-type: none"> • Damage of spring • Damage of poppet • Insert poppet into casing and function it. | <ul style="list-style-type: none"> • Replacement. • Correction or replacement when sealing is incomplete. • Normal when it can function lightly and smoothly without sticking. |
| Spring and related parts | <ul style="list-style-type: none"> • Rusting, corrosion, deformation or breakage of spring, spring seat, plug or cover. | <ul style="list-style-type: none"> • Replacement for significant damage. |
| Around seal for spool | <ul style="list-style-type: none"> • External oil leakage. • Rusting, corrosion or deformation of seal plate. | <ul style="list-style-type: none"> • Correction or replacement. • Correction or replacement. |
| Main relief valve, port relief valve & posi-nega conversion valve | <ul style="list-style-type: none"> • External rusting or damage. • Contacting face of valve seat. • Contacting face of poppet. • O-rings and back up rings. | <ul style="list-style-type: none"> • Replacement. • Replacement when damaged. • Replacement when damaged. • Replacement in principle. |

3. SWING DEVICE (TYPE 1)

1) WEARING PARTS

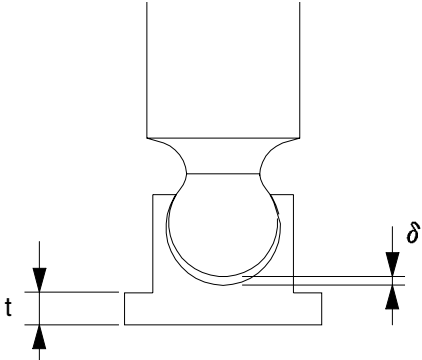
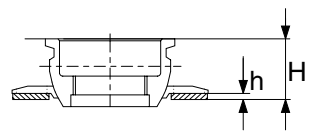
| Inspection item | Standard dimension | Recommended replacement value | Counter measures |
|---|--------------------|-------------------------------|---|
| Clearance between piston and cylinder block bore | 0.028 | 0.058 | Replace piston or cylinder block |
| Play between piston and shoe caulking section(δ) | 0 | 0.3 | Replace assembly of piston and shoe |
| Thickness of shoe(t) | 5.5 | 5.3 | Replace assembly of piston and shoe |
| Combined height of retainer plate and spherical bushing (H) | 6.5 | 6.0 | Replace set of retainer plate and spherical bushing |
| Thickness of friction plate(h) | 4.0 | 3.6 | Replace |
|  | | | |

2) SLIDING PARTS

| Part name | Standard roughness | Allowable roughness | Remark |
|-------------|----------------------------|---------------------|--------|
| Shoe | 0.8-Z(Ra=0.2) (LAPPING) | 3-Z(Ra=0.8) | |
| Shoe plate | 0.4-Z(Ra=0.1) (LAPPING) | 3-Z(Ra=0.8) | |
| Cylinder | 1.6-Z(Ra=0.4) (LAPPING) | 12.5-Z(Ra=3.2) | |
| Valve plate | 0.8-Z(Ra=0.2) (LAPPING) | 6.3-Z(Ra=1.6) | |

SWING DEVICE (TYPE 2 & TYPE 3)

1) WEARING PARTS

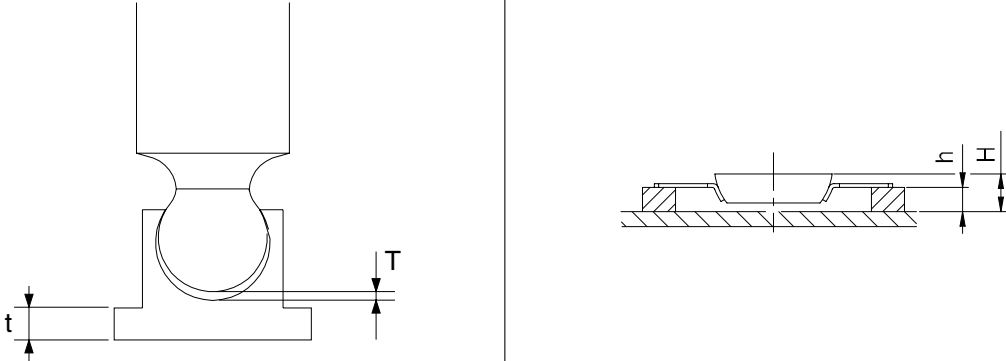
| Inspection item | Standard dimension | Recommended replacement value | Counter measures |
|--|--------------------|-------------------------------|---|
| Clearance between piston and cylinder block bore | 0.041 | 0.060 | Replace piston or cylinder block |
| Thickness of valve plate | 6 | 5.88 | Replace |
| Play between piston and shoe caulking section(δ) | 0.025 | 0.1 | Replace assembly of piston and shoe |
| Thickness of shoe(t) | 6.6 | 6.5 | Replace assembly of piston and shoe |
| Combined height of retainer plate and spherical bushing (H-h) | 17.6 | 17.3 | Replace set of retainer plate and spherical bushing |
| Thickness of friction plate | 2.94 | 2.7 | Replace |
| <div style="display: flex; justify-content: space-around; align-items: center;">   </div> <div style="display: flex; justify-content: space-between; margin-top: 10px;"> 140W77MS12 2609A7MS01 </div> | | | |

2) SLIDING PARTS

| Part name | Standard roughness | Allowable roughness | Remark |
|-------------|----------------------------------|---------------------|--------|
| Shoe | Rmax=1S (Ra=0.2a) (LAPPING) | 4S (Ra=0.1a) | |
| Shoe plate | Rmax=0.4S (Ra=0.1a) (LAPPING) | 3S (Ra=0.8a) | |
| Cylinder | Rmax=0.4S (Ra=0.1a) (LAPPING) | 3S (Ra=0.8a) | |
| Valve plate | Rmax=0.4S (Ra=0.1a) (LAPPING) | 2S (Ra=0.5a) | |

4. TRAVEL MOTOR

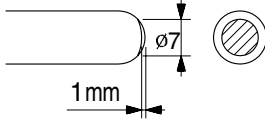
1) WEARING PARTS

| Inspection item | Standard dimension | Recommended replacement value | Counter measures |
|---|--------------------|-------------------------------|---|
| Clearance between piston and cylinder block bore | 0.025 | 0.050 | Replace piston or cylinder block |
| Play between piston and shoe caulking section(T) | 0 | 0.3 | Replace assembly of piston and shoe |
| Thickness of shoe(t) | 4.5 | 4.3 | Replace assembly of piston and shoe |
| Combined height of set plate and ball guide(H) | 7.3 | 7.0 | Replace set of set plate and ball guide |
| Thickness of friction plate | 3.0 | 2.6 | Replace |
|  | | | |

2) SLIDING PARTS

| Part name | Standard roughness | Remark |
|-------------|--------------------|--------|
| Shoe | 0.8S | - |
| Shoe plate | 0.8S | - |
| Cylinder | 0.8S | - |
| Valve plate | 0.8S | - |

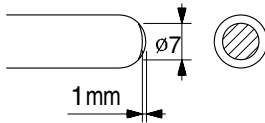
5. RCV LEVER

| Maintenance check item | Criteria | Remark |
|---------------------------|--|---|
| Leakage | The valve is to be replaced when the leakage becomes more than 1000cc/m at neutral handle position, or more than 2000cc/m during operation. | Conditions : Primary pressure : 30kgf/cm ² Oil viscosity : 23cSt |
| Spool | This is to be replaced when the sliding surface has worn more than 10 μ m, compared with the non-sliding surface. | The leakage at the left condition is estimated to be nearly equal to the above leakage. |
| Push rod |  <p>This is to be replaced when the top end has worn more than 1mm.</p> | |
| Play at operating section | The pin, shaft, and joint of the operating section are to be replaced when their plays become more than 2mm due to wears or so on. | When a play is due to looseness of a tightened section, adjust it. |
| Operation stability | When abnormal noises, hunting, primary pressure drop, etc. are generated during operation, and these cannot be remedied, referring to section 6. Troubleshooting, replace the related parts. | |

Notes

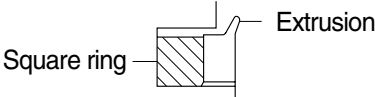
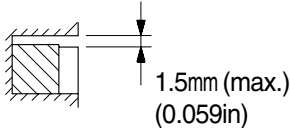
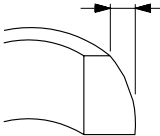
1. It is desirable to replace seal materials, such as O-rings, every disassembling. However, they may be reused, after being confirmed to be free of damage.
2. When loosening the hexagon socket head cap screw(125), replace the seal washers(121) without fail.

6. RCV PEDAL

| Maintenance check item | Criteria | Remark |
|---------------------------|--|---|
| Leakage | The valve is to be replaced when the leakage effect to the system. For example, the primary pressure drop. | Conditions : Primary pressure : 30kgf/cm ² Oil viscosity : 23cSt |
| Spool | This is to be replaced when the sliding surface has worn more than 10μm, compared with the non-sliding surface. | The leakage at the left condition is estimated to be nearly equal to the above leakage. |
| Push rod |  <p>This is to be replaced when the top end has worn more than 1mm.</p> | |
| Play at operating section | The pin, shaft, and joint of the operating section are to be replaced when their plays become more than 2mm due to wears or so on. | When a play is due to looseness of a tightened section, adjust it. |
| Operation stability | When abnormal noises, hunting, primary pressure drop, etc. are generated during operation, and these cannot be remedied, referring to section 6. Troubleshooting, replace the related parts. | |

Notes 1. It is desirable to replace seal materials, such as O-rings, every disassembling. However, they may be reused, after being confirmed to be free of damage.

7. TURNING JOINT

| Part name | | Maintenance standards | Remedy |
|---------------|---|---|-----------------------|
| Body, Stem | Sliding surface with sealing sections. | Plating worn or peeled due to seizure or contamination. | Replace |
| | Sliding surface between body and stem other than sealing section. | • Worn abnormality or damaged more than 0.1mm (0.0039in) in depth due to seizure contamination. | Replace |
| | | • Damaged more than 0.1mm(0.0039in) in depth. | Smooth with oilstone. |
| | Sliding surface with thrust plate. | • Worn more than 0.5mm(0.02in) or abnormality. | Replace |
| | | • Worn less than 0.5mm(0.02in). | Smooth |
| | | • Damage due to seizure or contamination remediable within wear limit (0.5mm)(0.02in). | Smooth |
| Cover | Sliding surface with thrust plate. | • Worn more than 0.5mm(0.02in) or abnormality. | Replace |
| | | • Worn less than 0.5mm(0.02in). | Smooth |
| | | • Damage due to seizure or contamination remediable within wear limit (0.5mm)(0.02in). | Replace |
| Seal set | - | <ul style="list-style-type: none"> Extruded excessively from seal groove square ring.  | Replace |
| | - | <ul style="list-style-type: none"> Slipper ring 1.5mm(0.059in) narrower than seal groove, or narrower than back ring.  | Replace |
| | - | <ul style="list-style-type: none"> Worn more than 0.5mm(0.02in) ~ 1.5mm(MAX.) (0.059in)  | Replace |

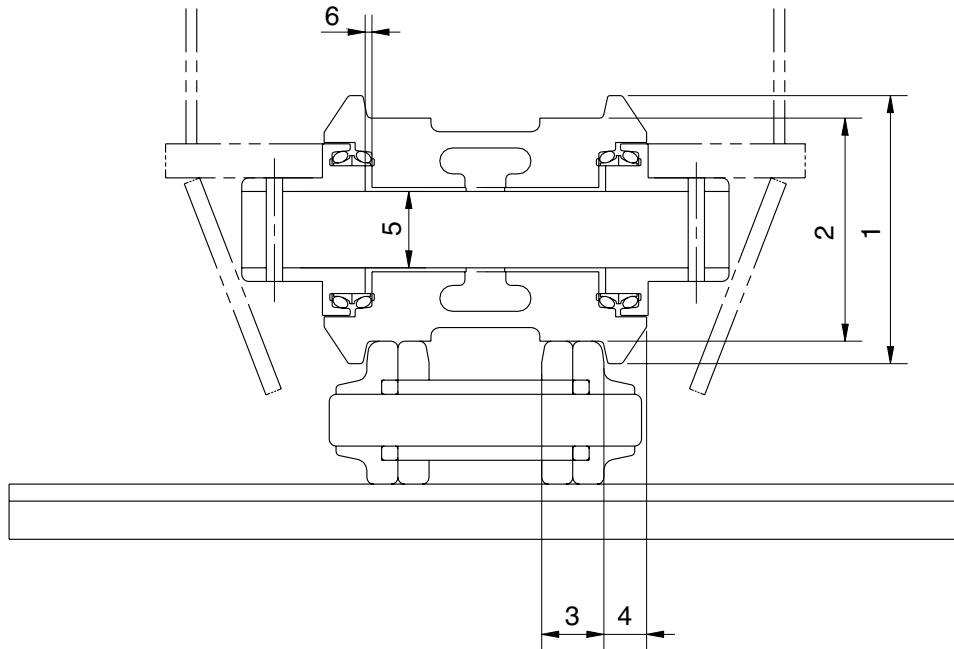
8. CYLINDER

| Part name | Inspecting section | Inspection item | Remedy |
|---------------|---|--|--|
| Piston rod | • Neck of rod pin | • Presence of crack | • Replace |
| | • Weld on rod hub | • Presence of crack | • Replace |
| | • Stepped part to which piston is attached. | • Presence of crack | • Replace |
| | • Threads | • Presence of crack | • Recondition or replace |
| | • Plated surface | • Plating is not worn off to base metal. | • Replace or replate |
| | | • Rust is not present on plating. | • Replace or replate |
| | | • Scratches are not present. | • Recondition, replate or replace |
| Cylinder tube | • Rod | • Wear of O.D. | • Recondition, replate or replace |
| | • Bushing at mounting part | • Wear of I.D. | • Replace |
| | • Weld on bottom | • Presence of crack | • Replace |
| | • Weld on head | • Presence of crack | • Replace |
| | • Weld on hub | • Presence of crack | • Replace |
| Gland | • Tube interior | • Presence of faults | • Replace if oil leak is seen |
| | • Bushing at mounting part | • Wear on inner surface | • Replace |
| Gland | • Bushing | • Flaw on inner surface | • Replace if flaw is deeper than coating |

GROUP 3 TRACK AND WORK EQUIPMENT

1. TRACK

1) TRACK ROLLER

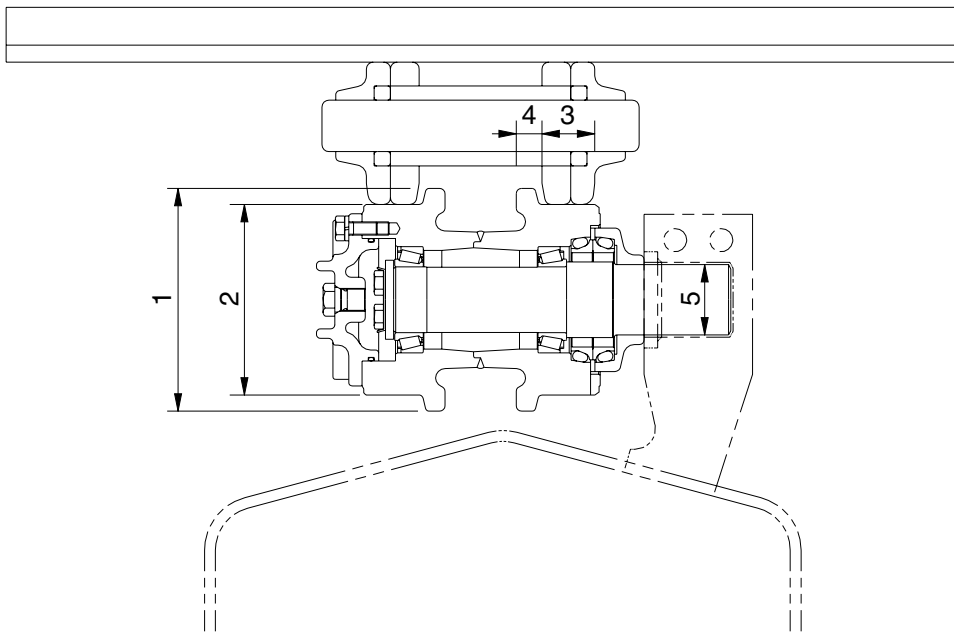


21037MS01

Unit : mm

| No. | Check item | Criteria | | | | Remedy |
|-----|--------------------------------------|--|------|---------------------------------------|-----------------|--------------------|
| 1 | Outside diameter of flange | Standard size | | Repair limit | | Rebuild or replace |
| | | ø 200 | | - | | |
| 2 | Outside diameter of tread | ø 160 | | ø 148 | | |
| 3 | Width of tread | 48 | | 54 | | |
| 4 | Width of flange | 21.5 | | - | | Replace bushing |
| 5 | Clearance between shaft and bushing | Standard size & tolerance | | Standard clearance | Clearance limit | |
| | | Shaft | Hole | | | |
| | | ø 70 ^{-0.29} _{-0.33} | | ø 70.1 ^{+0.046} ₀ | 0.39 to 0.476 | |
| 6 | Side clearance of roller (Both side) | Standard clearance | | Clearance limit | | Replace |
| | | 0.2 to 1.2 | | 2.0 | | |

2) CARRIER ROLLER

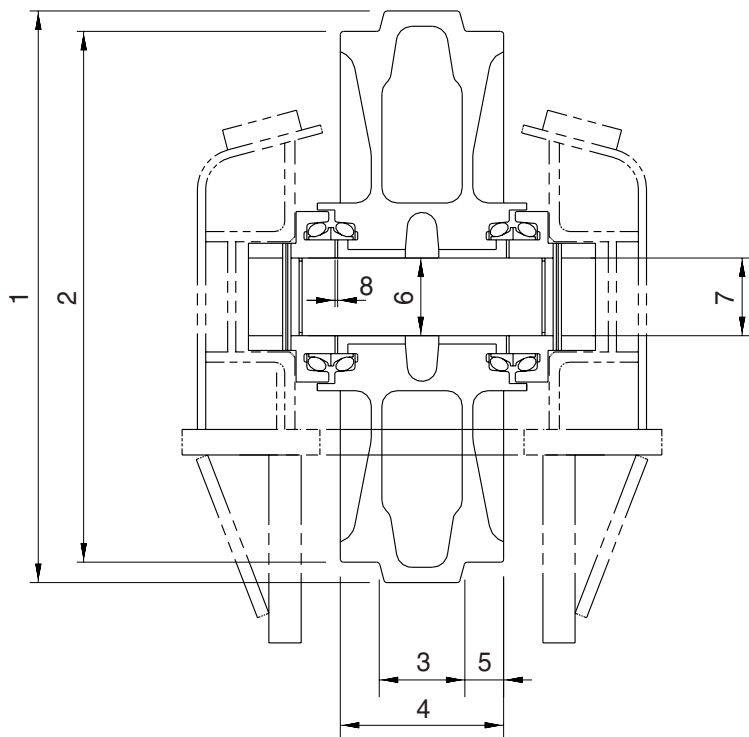


21037MS02

Unit : mm

| No. | Check item | Criteria | | | | | Remedy |
|-----|-------------------------------------|---------------|---------------|--------------|--------------------|-----------------|--------------------|
| 1 | Outside diameter of flange | Standard size | | | Repair limit | | Rebuild or replace |
| | | ø 169 | | | - | | |
| 2 | Outside diameter of tread | ø 144 | | | ø 134 | | |
| 3 | Width of tread | 44 | | | 49 | | |
| 4 | Width of flange | 17 | | | - | | |
| 5 | Clearance between shaft and bushing | Standard size | Tolerance | | Standard clearance | Clearance limit | Replace bushing |
| | | | Shaft | Hole | | | |
| | | ø 55 | -0.05 -0.1 | +0.3 +0.1 | 0.15 to 0.4 | 1.2 | |

3) IDLER

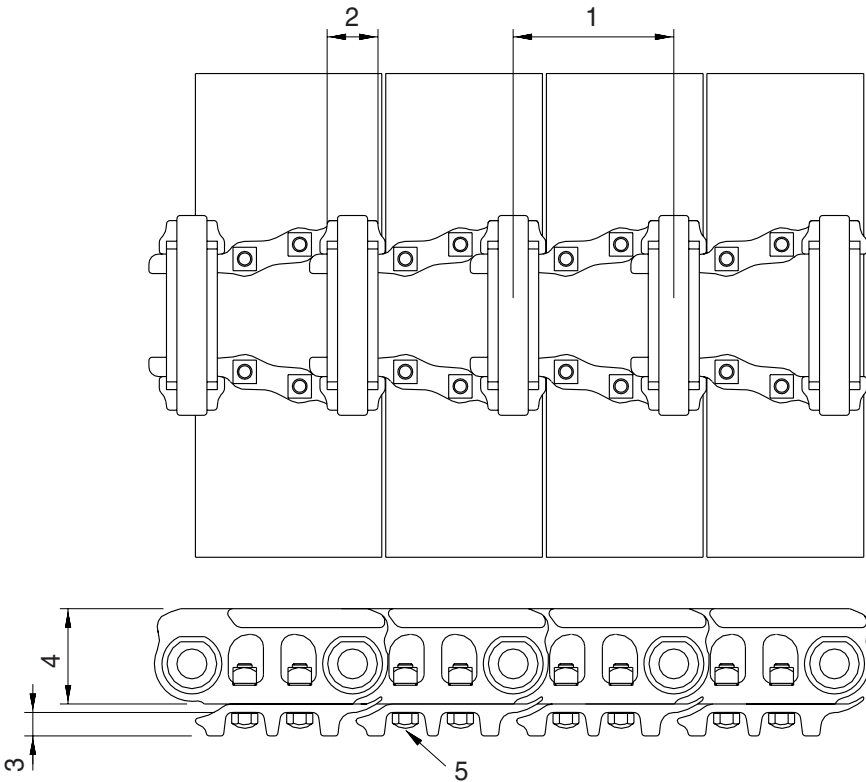


21037MS03

Unit : mm

| No. | Check item | Criteria | | | | Remedy |
|-----|-------------------------------------|------------------------------------|--|--------------------|-----------------|--------------------|
| 1 | Outside diameter of protrusion | Standard size | | Repair limit | | Rebuild or replace |
| | | ø 560 | | - | | |
| 2 | Outside diameter of tread | ø 520 | | ø 510 | | |
| 3 | Width of protrusion | 84 | | - | | |
| 4 | Total width | 160 | | - | | |
| 5 | Width of tread | 38 | | 43 | | |
| 6 | Clearance between shaft and bushing | Standard size & tolerance | | Standard clearance | Clearance limit | Replace bushing |
| | | Shaft | Hole | | | |
| | | ø 75 ⁰ _{-0.03} | ø 75.35 ^{+0.05} ₀ | 0.35 to 0.43 | 2.0 | |
| 7 | Clearance between shaft and support | ø 75 ⁰ _{-0.03} | ø 75 ^{+0.07} _{+0.03} | 0.03 to 0.1 | 1.2 | Replace |
| 8 | Side clearance of idler (Both side) | Standard clearance | | Clearance limit | | Replace bushing |
| | | 0.25 to 1.2 | | 2.0 | | |

4) TRACK

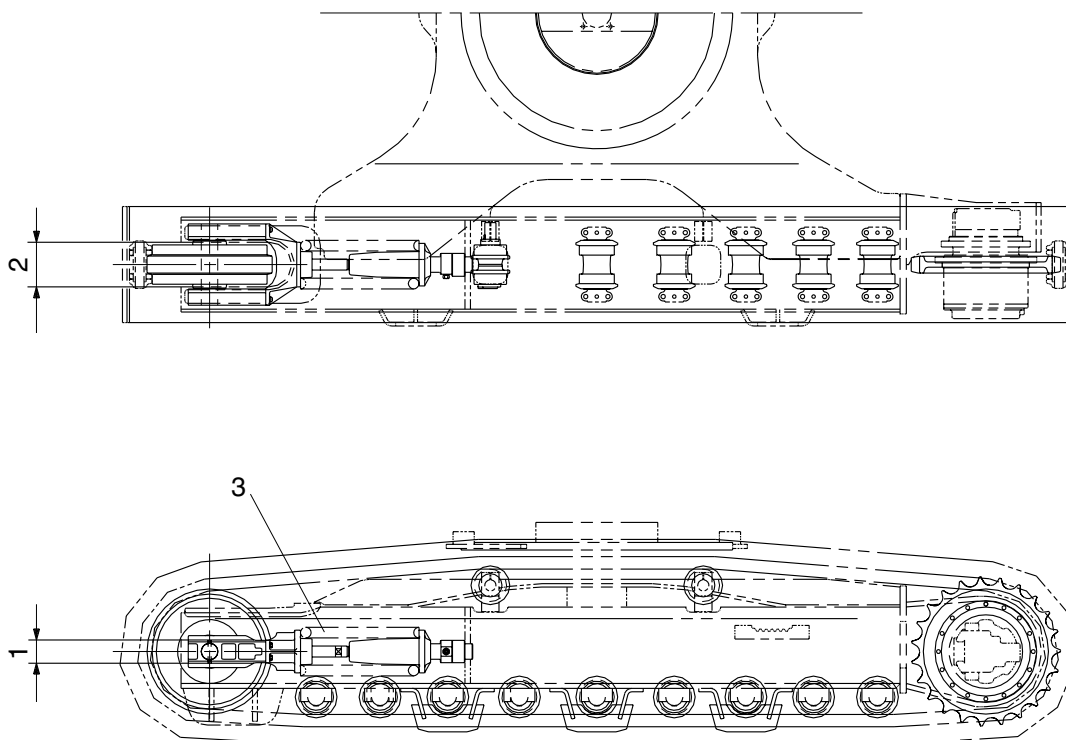


21037MS04

Unit : mm

| No. | Check item | Criteria | | Remedy |
|-----|-----------------------------|---|--------------|--------------------|
| | | Standard size | Repair limit | |
| 1 | Link pitch | 190 | 194.4 | Turn or replace |
| 2 | Outside diameter of bushing | ø 59 | ø 51 | Rebuild or replace |
| 3 | Height of grouser | 26 | 16 | |
| 4 | Height of link | 105 | 97 | |
| 5 | Tightening torque | Initial tightening torque : 78 ± 8kgf · m | | Retighten |

5) TRACK FRAME AND RECOIL SPRING

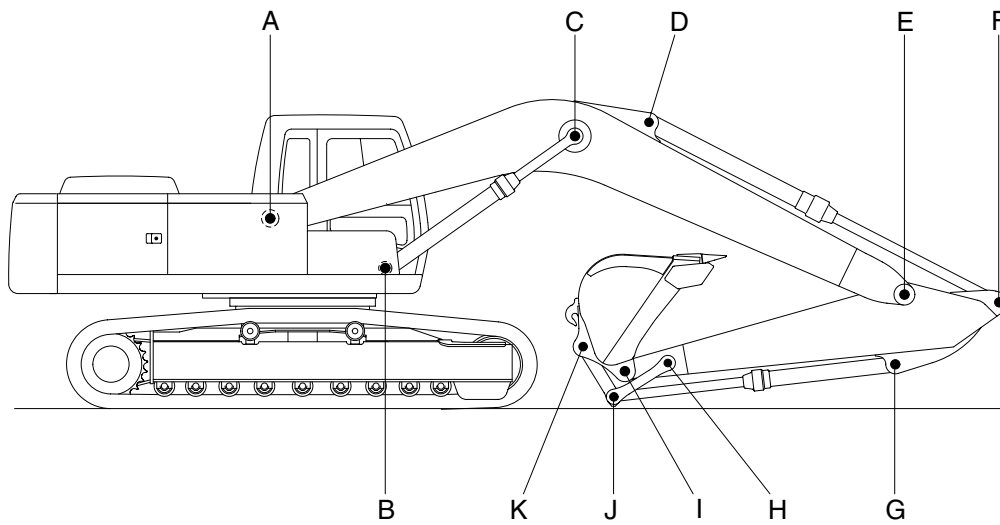


21037MS05

Unit : mm

| No. | Check item | Criteria | | | | Remedy |
|-----|---------------------------------|---------------|---------------------|-------------------|--------------|--------------------|
| | | | Standard size | Tolerance | Repair limit | |
| 1 | Vertical width of idler guide | Track frame | 113 | +2 0 | 117 | Rebuild or replace |
| | | Idler support | 110 | -0.5 -1.0 | 106 | |
| 2 | Horizontal width of idler guide | Track frame | 272 | +2 0 | 276 | |
| | | Idler support | 270 | - | 267 | |
| 3 | Recoil spring | Standard size | | | Repair limit | Replace |
| | | Free length | Installation length | Installation load | Free length | Installation load |
| | | ∅ 235 × 515 | 431 | 13716kg | - | 10973kg |

2. WORK EQUIPMENT



21077MS20

Unit : mm

| Mark | Measuring point (Pin and Bushing) | Normal value | Pin | | Bushing | | Remedy & Remark |
|------|--------------------------------------|-----------------|-----------------------------|-----------------|-----------------------------|-----------------|-----------------------|
| | | | Recomm. service limit | Limit of use | Recomm. service limit | Limit of use | |
| A | Boom Rear | 90 | 89 | 88.5 | 90.5 | 91 | Replace |
| B | Boom Cylinder Head | 80 | 79 | 78.5 | 80.5 | 81 | " |
| C | Boom Cylinder Rod | 80 | 79 | 78.5 | 80.5 | 81 | " |
| D | Arm Cylinder Head | 80 | 79 | 78.5 | 80.5 | 81 | " |
| E | Boom Front | 90 | 89 | 88.5 | 90.5 | 91 | " |
| F | Arm Cylinder Rod | 80 | 79 | 78.5 | 80.5 | 81 | " |
| G | Bucket Cylinder Head | 80 | 79 | 78.5 | 80.5 | 81 | " |
| H | Arm Link | 70 | 69 | 68.5 | 70.5 | 71 | " |
| I | Bucket and Arm Link | 80 | 79 | 78.5 | 80.5 | 81 | " |
| J | Bucket Cylinder Rod | 80 | 79 | 78.5 | 80.5 | 81 | " |
| K | Bucket Link | 80 | 79 | 78.5 | 80.5 | 81 | " |

SECTION 8 DISASSEMBLY AND ASSEMBLY

| | | |
|----------|-------------------------------------|-------|
| Group 1 | Precaution | 8-1 |
| Group 2 | Tightening Torque | 8-4 |
| Group 3 | Pump Device | 8-7 |
| Group 4 | Main Control Valve | 8-30 |
| Group 5 | Swing Device | 8-47 |
| Group 6 | Travel Device | 8-102 |
| Group 7 | RCV Lever | 8-134 |
| Group 8 | Turning Joint | 8-149 |
| Group 9 | Boom, Arm and Bucket Cylinder | 8-154 |
| Group 10 | Undercarriage | 8-171 |
| Group 11 | Work Equipment | 8-183 |

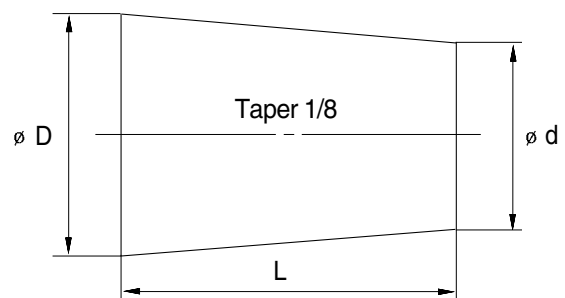
SECTION 8 DISASSEMBLY AND ASSEMBLY

GROUP 1 PRECAUTIONS

1. REMOVAL WORK

- 1) Lower the work equipment completely to the ground.
If the coolant contains antifreeze, dispose of it correctly.
- 2) After disconnecting hoses or tubes, cover them or fit blind plugs to prevent dirt or dust from entering.
- 3) When draining oil, prepare a container of adequate size to catch the oil.
- 4) Confirm the match marks showing the installation position, and make match marks in the necessary places before removal to prevent any mistake when assembling.
- 5) To prevent any excessive force from being applied to the wiring, always hold the connectors when disconnecting the connectors.
- 6) Fit wires and hoses with tags to show their installation position to prevent any mistake when installing.
- 7) Check the number and thickness of the shims, and keep in a safe place.
- 8) When raising components, be sure to use lifting equipment of ample strength.
- 9) When using forcing screws to remove any components, tighten the forcing screws alternately.
- 10) Before removing any unit, clean the surrounding area and fit a cover to prevent any dust or dirt from entering after removal.
- 11) When removing hydraulic equipment, first release the remaining pressure inside the hydraulic tank and the hydraulic piping.
- 12) If the part is not under hydraulic pressure, the following corks can be used.

| Nominal number | Dimensions | | |
|----------------|------------|------|----|
| | D | d | L |
| 06 | 6 | 5 | 8 |
| 08 | 8 | 6.5 | 11 |
| 10 | 10 | 8.5 | 12 |
| 12 | 12 | 10 | 15 |
| 14 | 14 | 11.5 | 18 |
| 16 | 16 | 13.5 | 20 |
| 18 | 18 | 15 | 22 |
| 20 | 20 | 17 | 25 |
| 22 | 22 | 18.5 | 28 |
| 24 | 24 | 20 | 30 |
| 27 | 27 | 22.5 | 34 |



2. INSTALL WORK

- 1) Tighten all bolts and nuts(Sleeve nuts) to the specified torque.
- 2) Install the hoses without twisting or interference.
- 3) Replace all gaskets, O-rings, cotter pins, and lock plates with new parts.
- 4) Bend the cotter pin or lock plate securely.
- 5) When coating with adhesive, clean the part and remove all oil and grease, then coat the threaded portion with 2-3 drops of adhesive.
- 6) When coating with gasket sealant, clean the surface and remove all oil and grease, check that there is no dirt or damage, then coat uniformly with gasket sealant.
- 7) Clean all parts, and correct any damage, dents, burrs, or rust.
- 8) Coat rotating parts and sliding parts with engine oil.
- 9) When press fitting parts, coat the surface with antifriction compound(LM-P).
- 10) After installing snap rings, check that the snap ring is fitted securely in the ring groove(Check that the snap ring moves in the direction of rotation).
- 11) When connecting wiring connectors, clean the connector to remove all oil, dirt, or water, then connect securely.
- 12) When using eyebolts, check that there is no deformation or deterioration, and screw them in fully.
- 13) When tightening split flanges, tighten uniformly in turn to prevent excessive tightening on one side.
- 14) When operating the hydraulic cylinders for the first time after repairing and reassembling the hydraulic cylinders, pumps, or other hydraulic equipment or piping, always bleed the air from the hydraulic cylinders as follows:
 - (1) Start the engine and run at low idling.
 - (2) Operate the control lever and actuate the hydraulic cylinder 4-5 times, stopping 100mm before the end of the stroke.
 - (3) Next, operate the piston rod to the end of its stroke to relieve the circuit. (The air bleed valve is actuated to bleed the air.)
 - (4) After completing this operation, raise the engine speed to the normal operating condition.
 - ※ If the hydraulic cylinder has been replaced, carry out this procedure before assembling the rod to the work equipment.
 - ※ Carry out the same operation on machines that have been in storage for a long time after completion of repairs.

3. COMPLETING WORK

- 1) If the coolant has been drained, tighten the drain valve, and add water to the specified level. Run the engine to circulate the water through the system. Then check the water level again.
- 2) If the hydraulic equipment has been removed and installed again, add engine oil to the specified level. Run the engine to circulate the oil through the system. Then check the oil level again.
- 3) If the piping or hydraulic equipment, such as hydraulic cylinders, pumps, or motors, have been removed for repair, always bleed the air from the system after reassembling the parts.
- 4) Add the specified amount of grease(Molybdenum disulphied grease) to the work equipment related parts.

GROUP 2 TIGHTENING TORQUE

1. MAJOR COMPONENTS

| No. | Descriptions | | Bolt size | Torque | |
|-----|--------------------|--|------------|------------|-------------|
| | | | | kgf · m | lbf · ft |
| 1 | Engine | Engine mounting bolt, nut, rear | M24 × 3.0 | 97 ± 7.0 | 702 ± 51 |
| | | Engine mounting bolt, nut, front | M20 × 2.5 | 55 ± 3.5 | 398 ± 25 |
| 2 | | Radiator mounting bolt | M16 × 2.0 | 29.7 ± 4.5 | 215 ± 32.5 |
| 3 | | Coupling mounting socket bolt | M18 × 2.0 | 32 ± 1.0 | 231 ± 7.2 |
| 4 | | Main pump housing mounting bolt | M10 × 1.5 | 4.8 ± 0.3 | 34.7 ± 2.2 |
| 5 | Hydraulic system | Main pump mounting socket bolt | M20 × 2.5 | 42 ± 4.5 | 304 ± 32.5 |
| 6 | | Main control valve mounting nut | M12 × 1.75 | 12.2 ± 1.3 | 88.2 ± 9.4 |
| 7 | | Fuel tank mounting bolt | M20 × 2.5 | 45 ± 5.1 | 325 ± 36.9 |
| 8 | | Hydraulic oil tank mounting bolt | M20 × 2.5 | 45 ± 5.1 | 325 ± 36.9 |
| 9 | | Turning joint mounting bolt, nut | M12 × 1.75 | 12 ± 1.3 | 86.8 ± 9.4 |
| 10 | Power train system | Swing motor mounting bolt | M20 × 2.5 | 57.9 ± 8.7 | 419 ± 62.9 |
| 11 | | Swing bearing upper part mounting bolt | M20 × 2.5 | 57.8 ± 6.4 | 418 ± 46.3 |
| 12 | | Swing bearing lower part mounting bolt | M20 × 2.5 | 57.8 ± 6.4 | 418 ± 46.3 |
| 13 | | Travel motor mounting bolt | M16 × 2.0 | 23 ± 2.5 | 166 ± 18.1 |
| 14 | | Sprocket mounting bolt | M16 × 2.0 | 26 ± 2.5 | 188 ± 18.1 |
| 15 | Under carriage | Carrier roller mounting bolt, nut | M16 × 2.0 | 29.7 ± 4.4 | 215 ± 31.8 |
| 16 | | Track roller mounting bolt | M20 × 2.5 | 54.7 ± 5.0 | 396 ± 36.2 |
| 17 | | Track tension cylinder mounting bolt | M16 × 2.0 | 29.7 ± 4.5 | 215 ± 32.5 |
| 18 | | Track shoe mounting bolt, nut | M20 × 1.5 | 78 ± 8.0 | 564 ± 57.9 |
| 19 | | Track guard mounting bolt | M20 × 2.5 | 57.9 ± 8.7 | 419 ± 62.9 |
| 20 | Others | Counterweight mounting bolt | M36 × 3.0 | 308 ± 46 | 2228 ± 333 |
| 21 | | Cab mounting bolt | M12 × 1.75 | 12.8 ± 3.0 | 92.6 ± 21.7 |
| 22 | | Operator's seat mounting bolt | M 8 × 1.25 | 4.05 ± 0.8 | 29.3 ± 5.8 |

※ For tightening torque of engine and hydraulic components, see engine maintenance guide and service manual.

2. TORQUE CHART

Use following table for unspecified torque.

1) BOLT AND NUT

(1) Coarse thread

| Bolt size | 8T | | 10T | |
|------------|-------------|-------------|-------------|-------------|
| | kgf · m | lbf · ft | kgf · m | lbf · ft |
| M 6 × 1.0 | 0.85 ~ 1.25 | 6.15 ~ 9.04 | 1.14 ~ 1.74 | 8.2 ~ 12.6 |
| M 8 × 1.25 | 2.0 ~ 3.0 | 14.5 ~ 21.7 | 2.73 ~ 4.12 | 19.7 ~ 29.8 |
| M10 × 1.5 | 4.0 ~ 6.0 | 28.9 ~ 43.4 | 5.5 ~ 8.3 | 39.8 ~ 60 |
| M12 × 1.75 | 7.4 ~ 11.2 | 53.5 ~ 79.5 | 9.8 ~ 15.8 | 71 ~ 114 |
| M14 × 2.0 | 12.2 ~ 16.6 | 88.2 ~ 120 | 16.7 ~ 22.5 | 121 ~ 167 |
| M16 × 2.0 | 18.6 ~ 25.2 | 135 ~ 182 | 25.2 ~ 34.2 | 182 ~ 247 |
| M18 × 2.5 | 25.8 ~ 35.0 | 187 ~ 253 | 35.1 ~ 47.5 | 254 ~ 343 |
| M20 × 2.5 | 36.2 ~ 49.0 | 262 ~ 354 | 49.2 ~ 66.6 | 356 ~ 482 |
| M22 × 2.5 | 48.3 ~ 63.3 | 350 ~ 457 | 65.8 ~ 98.0 | 476 ~ 709 |
| M24 × 3.0 | 62.5 ~ 84.5 | 452 ~ 611 | 85.0 ~ 115 | 615 ~ 832 |
| M30 × 3.5 | 124 ~ 168 | 898 ~ 1214 | 169 ~ 229 | 1223 ~ 1655 |
| M36 × 4.0 | 174 ~ 236 | 1261 ~ 1703 | 250 ~ 310 | 1808 ~ 2242 |

(2) Fine thread

| Bolt size | 8T | | 10T | |
|------------|--------------|-------------|-------------|-------------|
| | kgf · m | lbf · ft | kgf · m | lbf · ft |
| M 8 × 1.0 | 2.17 ~ 3.37 | 15.7 ~ 24.3 | 3.04 ~ 4.44 | 22.0 ~ 32.0 |
| M10 × 1.25 | 4.46 ~ 6.66 | 32.3 ~ 48.2 | 5.93 ~ 8.93 | 42.9 ~ 64.6 |
| M12 × 1.25 | 7.78 ~ 11.58 | 76.3 ~ 83.7 | 10.6 ~ 16.0 | 76.6 ~ 115 |
| M14 × 1.5 | 13.3 ~ 18.1 | 96.2 ~ 130 | 17.9 ~ 24.1 | 130 ~ 174 |
| M16 × 1.5 | 19.9 ~ 26.9 | 144 ~ 194 | 26.6 ~ 36.0 | 193 ~ 260 |
| M18 × 1.5 | 28.6 ~ 43.6 | 207 ~ 315 | 38.4 ~ 52.0 | 278 ~ 376 |
| M20 × 1.5 | 40.0 ~ 54.0 | 289 ~ 390 | 53.4 ~ 72.2 | 386 ~ 522 |
| M22 × 1.5 | 52.7 ~ 71.3 | 381 ~ 515 | 70.7 ~ 95.7 | 512 ~ 692 |
| M24 × 2.0 | 67.9 ~ 91.9 | 491 ~ 664 | 90.9 ~ 123 | 658 ~ 890 |
| M30 × 2.0 | 137 ~ 185 | 990 ~ 1338 | 182 ~ 248 | 1314 ~ 1795 |
| M36 × 3.0 | 192 ~ 260 | 1389 ~ 1879 | 262 ~ 354 | 1893 ~ 2561 |

2) PIPE AND HOSE(FLARE TYPE)

| Thread size(PF) | Width across flat(mm) | kgf · m | lbf · ft |
|-----------------|-----------------------|---------|----------|
| 1/4" | 19 | 4 | 28.9 |
| 3/8" | 22 | 5 | 36.2 |
| 1/2" | 27 | 9.5 | 68.7 |
| 3/4" | 36 | 18 | 130.2 |
| 1" | 41 | 21 | 151.9 |
| 1-1/4" | 50 | 35 | 253.2 |

3) PIPE AND HOSE(ORFS TYPE)

| Thread size(UNF) | Width across flat(mm) | kgf · m | lbf · ft |
|------------------|-----------------------|---------|----------|
| 9/16-18 | 19 | 4 | 28.9 |
| 11/16-16 | 22 | 5 | 36.2 |
| 13/16-16 | 27 | 9.5 | 68.7 |
| 1-3/16-12 | 36 | 18 | 130.2 |
| 1-7/16-12 | 41 | 21 | 151.9 |
| 1-11/16-12 | 50 | 35 | 253.2 |

4) FITTING

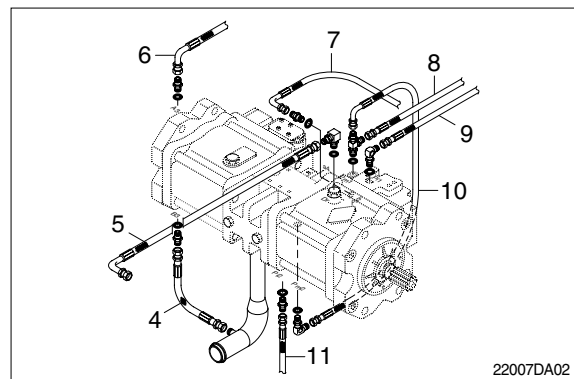
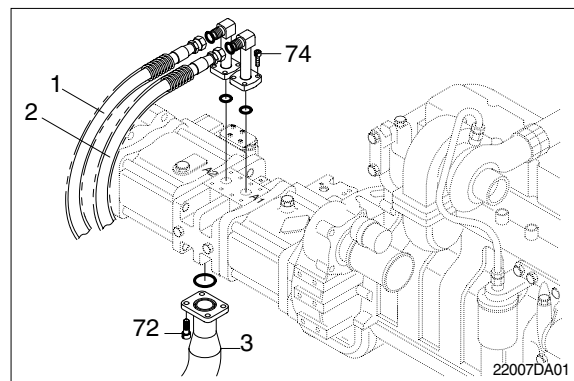
| Thread size | Width across flat(mm) | kgf · m | lbf · ft |
|-------------|-----------------------|---------|----------|
| 1/4" | 19 | 4 | 28.9 |
| 3/8" | 22 | 5 | 36.2 |
| 1/2" | 27 | 9.5 | 68.7 |
| 3/4" | 36 | 18 | 130.2 |
| 1" | 41 | 21 | 151.9 |
| 1-1/4" | 50 | 35 | 253.2 |

GROUP 3 PUMP DEVICE

1. REMOVAL AND INSTALL

1) REMOVAL

- (1) Lower the work equipment to the ground and stop the engine.
- (2) Operate the control levers and pedals several times to release the remaining pressure in the hydraulic piping
- (3) Loosen the breather slowly to release the pressure inside the hydraulic tank.
- ▲ Escaping fluid under pressure can penetrate the skin causing serious injury.
- (4) Loosen the drain plug under the hydraulic tank and drain the oil from the hydraulic tank.
 - Hydraulic tank quantity : 180 l
- (5) Remove socket bolts(74) and disconnect pipe(1, 2).
- (6) Disconnect pilot line hoses(4, 5, 6, 7, 8, 9, 10, 11).
- (7) Remove socket bolts(72) and disconnect pump suction tube(3).
 - ※ When pump suction tube is disconnected, the oil inside the piping will flow out, so catch it in oil pan.
- (8) Sling the pump assembly and remove the pump mounting bolts.
 - Weight : 120kg(265lb)
- ※ Pull out the pump assembly from housing. When removing the pump assembly, check that all the hoses have been disconnected.

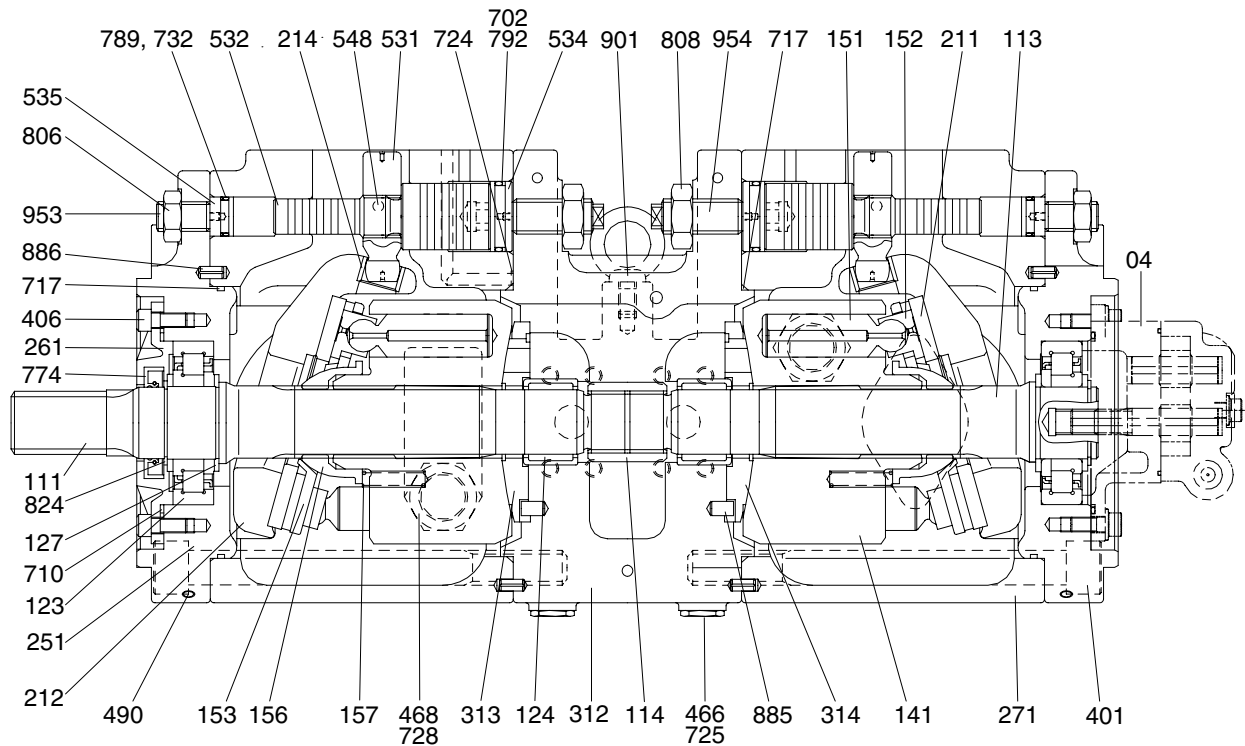


2) INSTALL

- (1) Carry out installation in the reverse order to removal.
- (2) Remove the suction strainer and clean it.
- (3) Replace return filter with new one.
- (4) Remove breather and clean it.
- (5) After adding oil to the hydraulic tank to the specified level.
- (6) Bleed the air from the hydraulic pump.
 - ① Remove the air vent plug(2EA).
 - ② Tighten plug lightly.
 - ③ Start the engine, run at low idling, and check oil come out from plug.
 - ④ Tighten plug.
- (7) Start the engine, run at low idling(3~5 minutes) to circulate the oil through the system.
- (8) Confirm the hydraulic oil level and check the hydraulic oil leak or not.

2. MAIN PUMP(1/2)

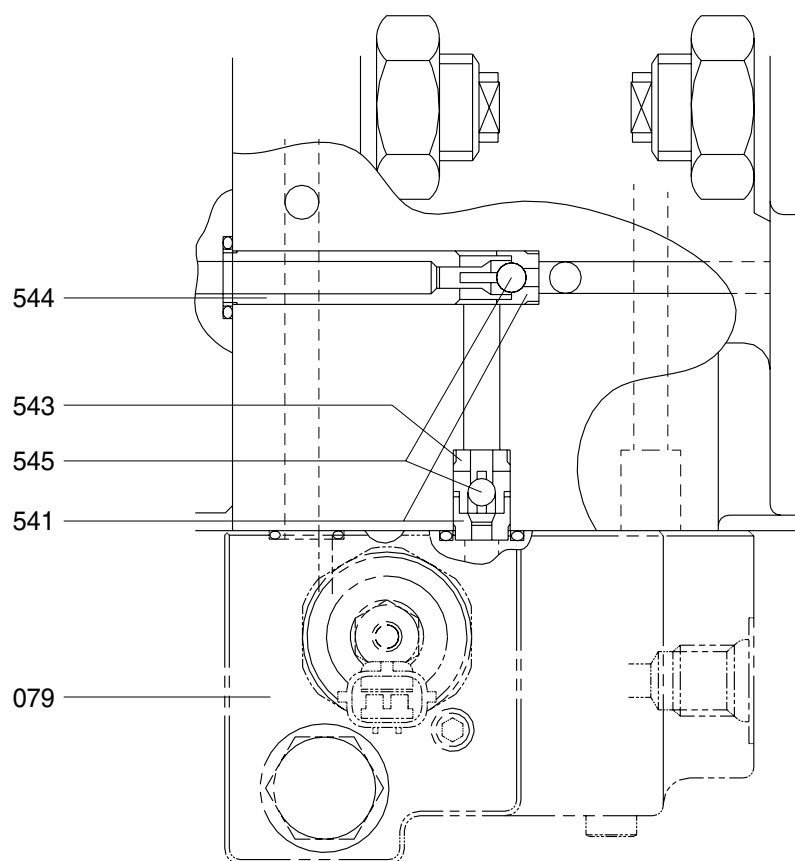
1) STRUCTURE



RD21072SF02

| | | | | | |
|-----|-----------------|-----|---------------------|-----|------------------|
| 04 | Gear pump | 261 | Seal cover(F) | 717 | O-ring |
| 111 | Drive shaft(F) | 271 | Pump casing | 724 | O-ring |
| 113 | Drive shaft(R) | 312 | Valve block | 725 | O-ring |
| 114 | Spline coupling | 313 | Valve plate(R) | 728 | O-ring |
| 123 | Roller bearing | 314 | Valve plate(L) | 732 | O-ring |
| 124 | Needle bearing | 401 | Hexagon socket bolt | 774 | Oil seal |
| 127 | Bearing spacer | 406 | Hexagon socket bolt | 789 | Back up ring |
| 141 | Cylinder block | 466 | VP Plug | 792 | Back up ring |
| 151 | Piston | 468 | VP Plug | 806 | Hexagon head nut |
| 152 | Shoe | 490 | Plug | 808 | Hexagon head nut |
| 153 | Set plate | 531 | Tilting pin | 824 | Snap ring |
| 156 | Bushing | 532 | Servo piston | 885 | Pin |
| 157 | Cylinder spring | 534 | Stopper(L) | 886 | Spring pin |
| 211 | Shoe plate | 535 | Stopper(S) | 901 | Eye bolt |
| 212 | Swash plate | 548 | Pin | 953 | Set screw |
| 214 | Bushing | 702 | O-ring | 954 | Set screw |
| 251 | Support | 710 | O-ring | | |

MAIN PUMP(2/2)



VIEW A

(210-7) 8-10

541 Seat
543 Stopper 1

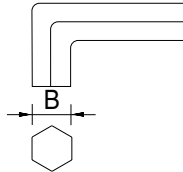

544 Stopper 2
545 Steel ball

079 Proportional reducing valve

2) TOOLS AND TIGHTENING TORQUE

(1) Tools

The tools necessary to disassemble/reassemble the pump are shown in the follow list.

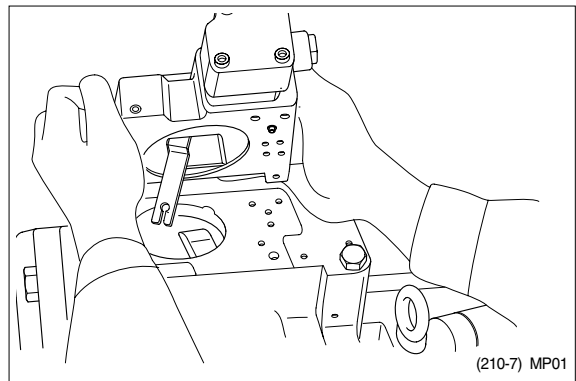
| Tool name & size | | Part name | | | |
|--|----|--|---------------------|---------------------|------------------------------|
| Name | B | Hexagon socket head bolt | PT plug (PT thread) | PO plug (PF thread) | Hexagon socket head setscrew |
| <div>Allen wrench</div>  | 4 | M 5 | BP-1/16 | - | M 8 |
| | 5 | M 6 | BP-1/8 | - | M10 |
| | 6 | M 8 | BP-1/4 | PO-1/4 | M12, M14 |
| | 8 | M10 | BP-3/8 | PO-3/8 | M16, M18 |
| | 17 | M20, M22 | BP-1 | PO-1, 1 1/4, 1 1/2 | - |
| <div>Double ring spanner, socket wrench, double(Single) open end spanner</div>  | - | Hexagon socket head bolt | Hexagon nut | | VP plug (PF thread) |
| | 19 | M12 | M12 | | VP-1/4 |
| | 24 | M16 | M16 | | - |
| | 27 | M18 | M18 | | VP-1/2 |
| | 30 | M20 | M20 | | - |
| | 36 | - | - | | VP-3/4 |
| Adjustable angle wrench | | Medium size, 1 set | | | |
| Screw driver | | Minus type screw driver, Medium size, 2 sets | | | |
| Hammer | | Plastic hammer, 1 set | | | |
| Pliers | | For snap ring, TSR-160 | | | |
| Steel bar | | Steel bar of key material approx. 10×8×200 | | | |
| Torque wrench | | Capable of tightening with the specified torques | | | |

(2) Tightening torque

| Part name | Bolt size | Torque | | Wrench size | |
|---|-----------|---------|----------|-------------|----|
| | | kgf · m | lbf · ft | in | mm |
| Hexagon socket head bolt Material : SCM435) | M 5 | 0.7 | 5.1 | 0.16 | 4 |
| | M 6 | 1.2 | 8.7 | 0.20 | 5 |
| | M 8 | 3.0 | 21.7 | 0.24 | 6 |
| | M10 | 5.8 | 42.0 | 0.31 | 8 |
| | M12 | 10.0 | 72.3 | 0.39 | 10 |
| | M14 | 16.0 | 116 | 0.47 | 12 |
| | M16 | 24.0 | 174 | 0.55 | 14 |
| | M18 | 34.0 | 246 | 0.55 | 14 |
| | M20 | 44.0 | 318 | 0.67 | 17 |
| PT Plug(Material : S45C) ※ Wind a seal tape 1 1/2 to 2 turns round the plug | PT1/16 | 0.7 | 5.1 | 0.16 | 4 |
| | PT 1/8 | 1.05 | 7.59 | 0.20 | 5 |
| | PT 1/4 | 1.75 | 12.7 | 0.24 | 6 |
| | PT 3/8 | 3.5 | 25.3 | 0.31 | 8 |
| | PT 1/2 | 5.0 | 36.2 | 0.39 | 10 |
| PF Plug(Material : S45C) | PF 1/4 | 3.0 | 21.7 | 0.24 | 6 |
| | PF 1/2 | 10.0 | 72.3 | 0.39 | 10 |
| | PF 3/4 | 15.0 | 109 | 0.55 | 14 |
| | PF 1 | 19.0 | 137 | 0.67 | 17 |
| | PF 1 1/4 | 27.0 | 195 | 0.67 | 17 |
| | PF 1 1/2 | 28.0 | 203 | 0.67 | 17 |

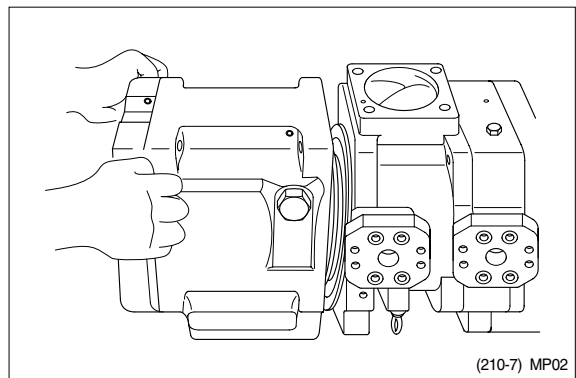
3) DISASSEMBLY

- (1) Select place suitable to disassembling.
 - ※ Select clean place.
 - ※ Spread rubber sheet, cloth or so on on overhaul workbench top to prevent parts from being damaged.
- (2) Remove dust, rust, etc, from pump surfaces with cleaning oil or so on.
- (3) Remove drain port plug(468) and let oil out of pump casing(Front and rear pump).
- (4) Remove hexagon socket head bolts(412, 413) and remove regulator.



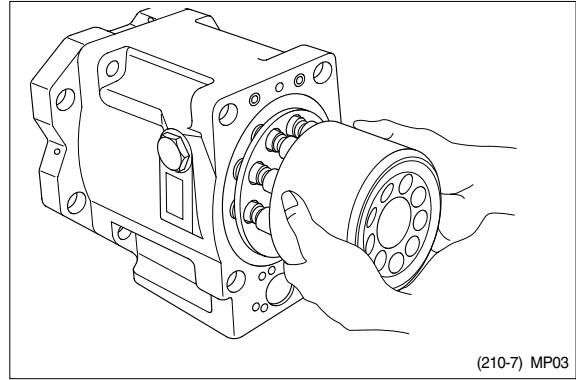
- (5) Loosen hexagon socket head bolts(401) which tighten swash plate support(251), pump casing(271) and valve block(312).
 - ※ If gear pump and so on are fitted to rear face of pump, remove them before starting this work.

- (6) Place pump horizontally on workbench with its regulator-fitting surface down and separate pump casing(271) from valve block(312).
 - ※ Before bringing this surface down, spread rubber sheet on workbench without fail to prevent this surface from being damaged.



- (7) Pull cylinder block(141) out of pump casing(271) straightly over drive shaft(111). Pull out also pistons(151), set plate(153), spherical bush(156) and cylinder springs(157) simultaneously.

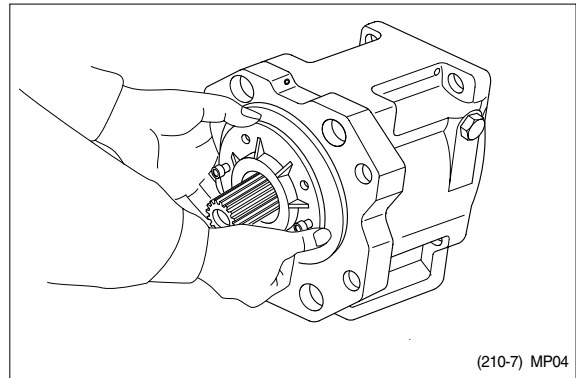
※ Take care not to damage sliding surfaces of cylinder, spherical bushing, shoes, swash plate, etc.



- (8) Remove hexagon socket head bolts(406) and then seal cover(F, 261).

※ Fit bolt into pulling out tapped hole of seal cover(F), and cover can be removed easily.

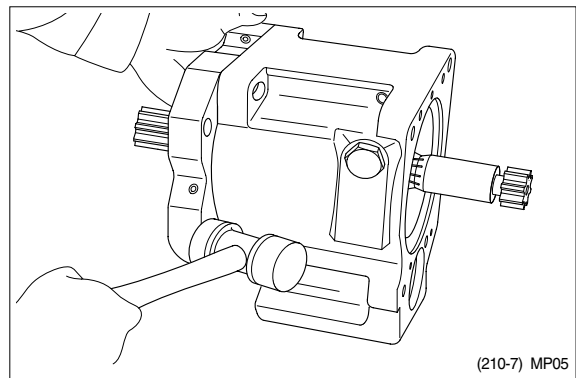
※ Since oil seal is fitted on seal cover(F), take care not to damage it in removing cover.



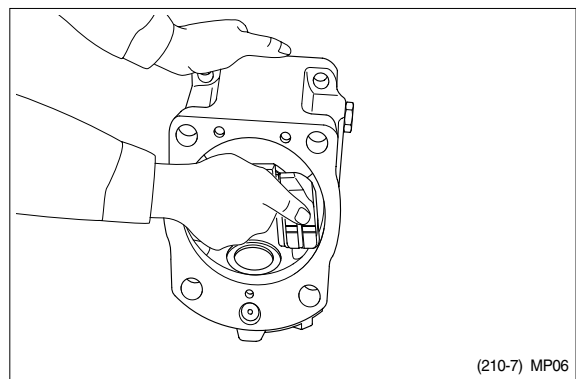
- (9) Remove hexagon socket head bolts(408) and then seal cover(R, 262).

In case fitting a gear pump, first, remove gear pump.

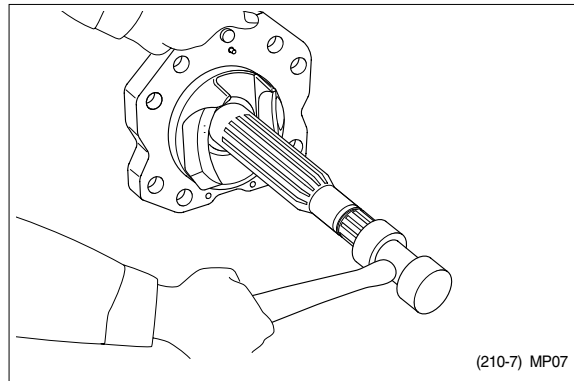
- (10) Tapping lightly fitting flange section of swash plate support(251) on its pump casing side, separate swash plate support from pump casing.



- (11) Remove shoe plate(211) and swash plate(212) from pump casing(271).

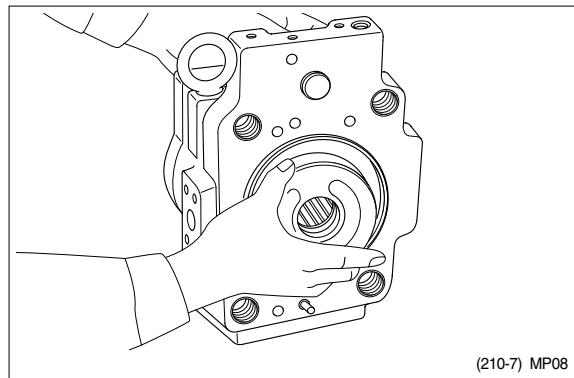


- (12) Tapping lightly shaft ends of drive shafts (111, 113) with plastic hammer, take out drive shafts from swash plate supports.



- (13) Remove valve plates(313, 314) from valve block(312).

※ These may be removed in work(6).



- (14) If necessary, remove stopper(L, 534), stopper(S, 535), servo piston(532) and tilting pin(531) from pump casing(271), and needle bearing(124) and splined coupling(114) from valve block(312).

- ※ In removing tilting pin, use a protector to prevent pin head from being damaged.
- ※ Since loctite is applied to fitting areas of tilting pin and servo piston, take care not to damage servo piston.
- ※ Do not remove needle bearing as far as possible, except when it is considered to be out of its life span.
- ※ Do not loosen hexagon nuts of valve block and swash plate support.
If loosened, flow setting will be changed.

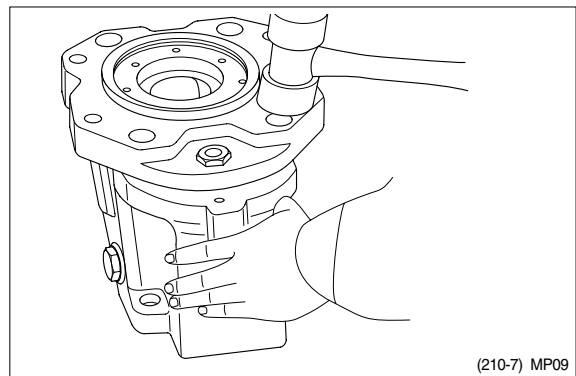
4) ASSEMBLY

(1) For reassembling reverse the disassembling procedures, paying attention to the following items.

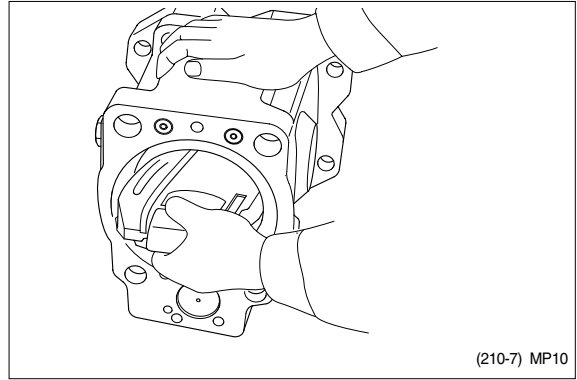
- ① Do not fail to repair the parts damaged during disassembling, and prepare replacement parts in advance.
- ② Clean each part fully with cleaning oil and dry it with compressed air.
- ③ Do not fail to apply clean working oil to sliding sections, bearings, etc. before assembling them.
- ④ In principle, replace seal parts, such as O-rings, oil seals, etc.
- ⑤ For fitting bolts, plug, etc., prepare a torque wrench or so on, and tighten them with torques shown in page 8-11, 12.
- ⑥ For the double-pump, take care not to mix up parts of the front pump with those of the rear pump.

(2) Fit swash plate support(251) to pump casing(271), tapping the former lightly with a hammer.

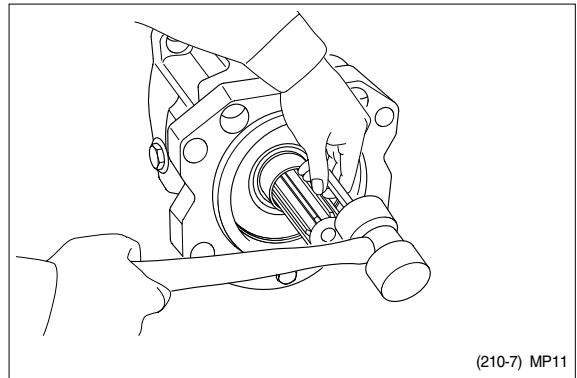
- ※ After servo piston, tilting pin, stopper(L) and stopper(S) are removed, fit them soon to pump casing in advance for reassembling.
- ※ In tightening servo piston and tilting pin, use a protector to prevent tilting pin head and feedback pin from being damaged. In addition, apply loctite(Medium strength) to their threaded sections.



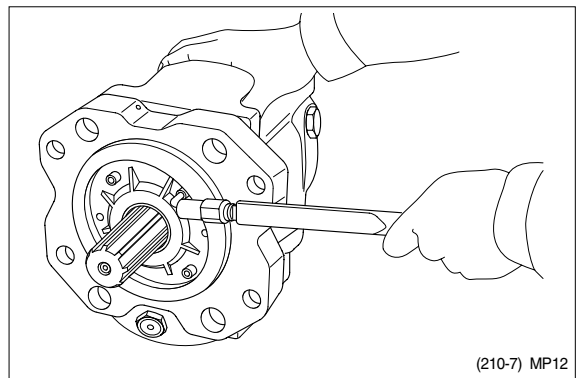
- (3) Place pump casing with its regulator fitting surface down, fit tilting bush of swash plate to tilting pin(531) and fit swash plate (212) to swash plate support(251) correctly.
 Confirm with fingers of both hands that
- ※ swash plate can be removed smoothly.
- Apply grease to sliding sections of swash plate and swash plate support, and drive shaft can be fitted easily.



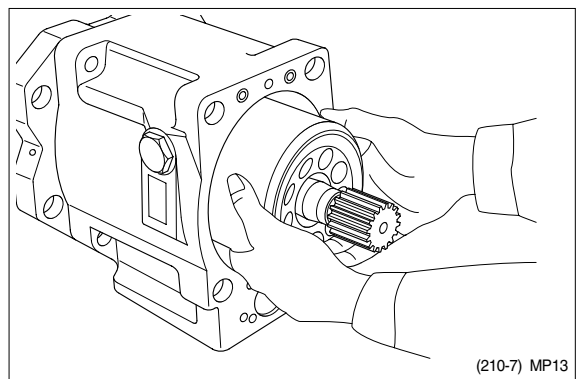
- (4) To swash plate support(251), fit drive shaft(111) set with bearing(123), bearing spacer(127) and snap ring(824).
- ※ Do not tap drive shaft with hammer or so on.
 - ※ Assemble them into support, tapping outer race of bearing lightly with plastic hammer.
- Fit them fully, using steel bar or so on.



- (5) Assemble seal cover(F, 261) to pump casing(271) and fix it with hexagon socket head bolts(406).
- ※ Apply grease lightly to oil seal in seal cover(F).
 - ※ Assemble oil seal, taking full care not to damage it.
 - ※ For tandem type pump, fit rear cover(263) and seal cover(262) similarly.

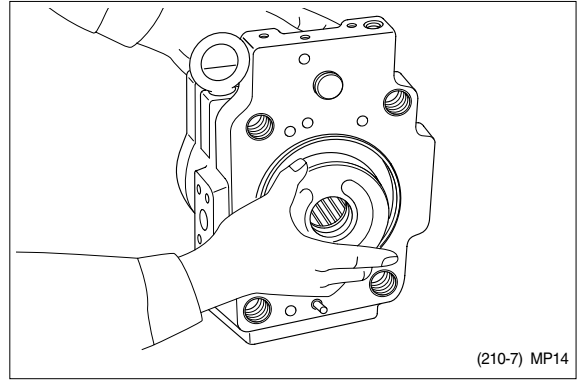


- (6) Assemble piston cylinder subassembly [cylinder block(141), piston subassembly (151, 152), set plate(153), spherical bush (156) and cylinder spring (157)].
 Fit spline phases of retainer and cylinder.
 Then, insert piston cylinder subassembly into pump casing.



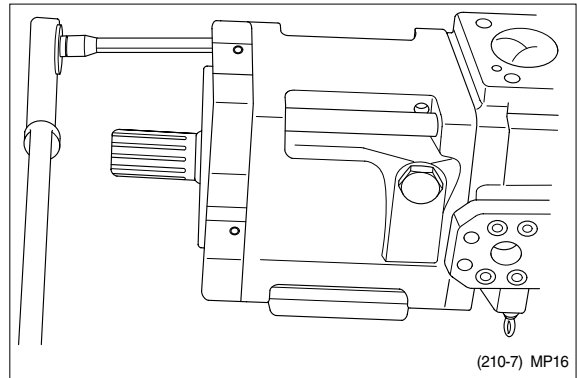
(7) Fit valve plate(313) to valve block(312), entering pin into pin hole.

- ※ Take care not to mistake suction / delivery directions of valve plate.



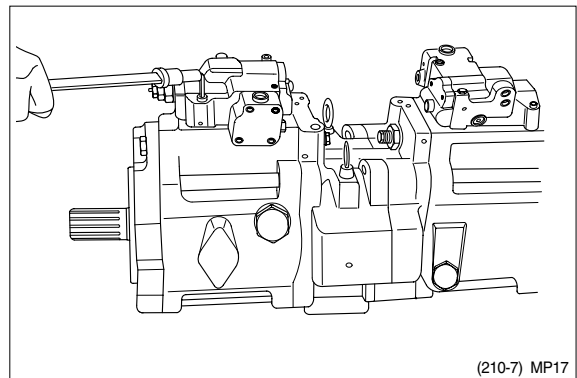
(8) Fit valve block(312) to pump casing(271) and tighten hexagon socket head bolts (401).

- ※ At first assemble this at rear pump side, and this work will be easy.
- ※ Take care not to mistake direction of valve block.
- ※ Clockwise rotation(Viewed from input shaft side) - Fit block with regulator up and with delivery flange left, viewed from front side.
- ※ Counter clockwise rotation(Viewed from input shaft side) - Fit block with delivery flange right, viewed from front side.



(9) Putting feedback pin of tilting pin into feedback lever of regulator, fit regulator and tighten hexagon socket head bolts (412, 413).

- ※ Take care not to mistake regulator of front pump for that of rear pump.

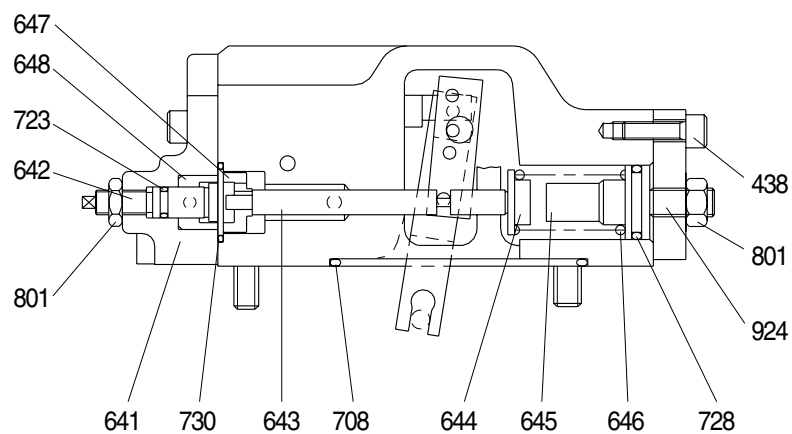
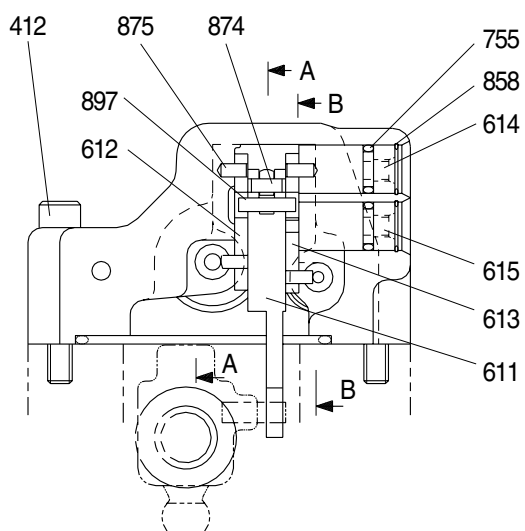


(10) Fit drain port plug(468).

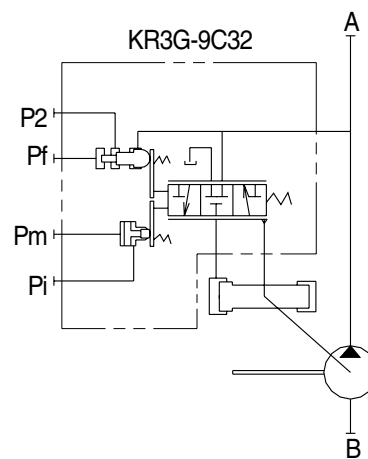
This is the end of reassembling procedures.

3. REGULATOR

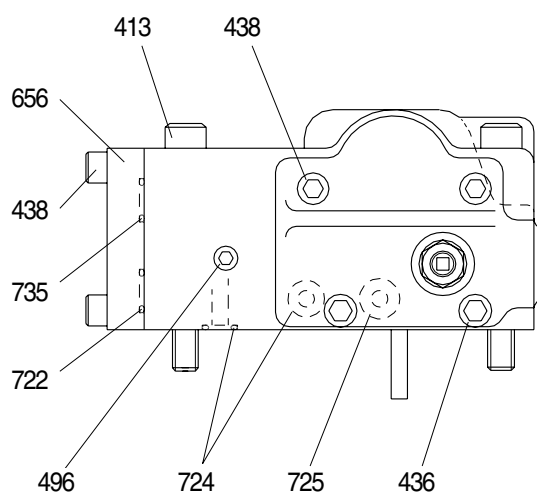
1) STRUCTURE(1/2)



SECTION B-B

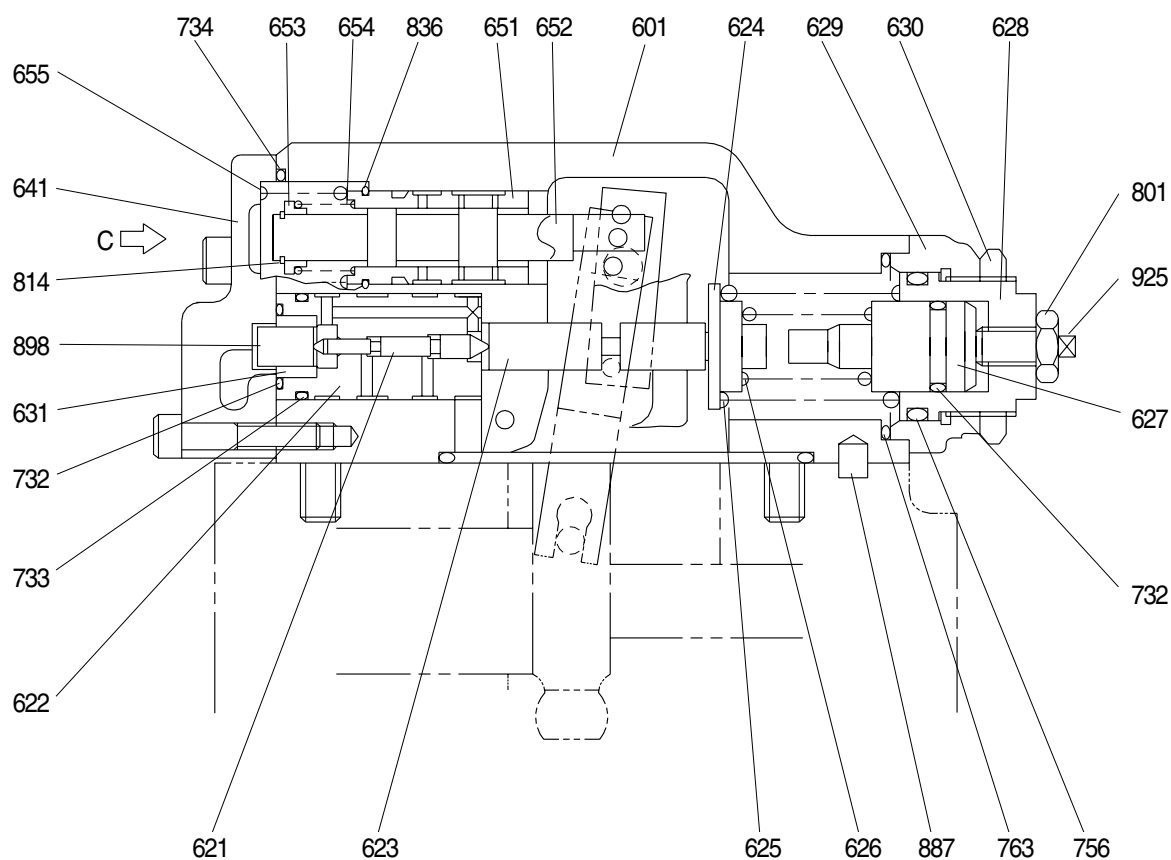


(210-7) 8-19



VIEW C

REGULATOR(2/2)



SECTION A-A

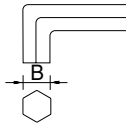

(210-7) 8-20

| | | |
|--------------------------|----------------------|---------------------|
| 412 Hexagon socket screw | 630 Nut | 728 O-ring |
| 413 Hexagon socket screw | 631 Sleeve | 730 O-ring |
| 436 Hexagon socket screw | 641 Pilot cover | 732 O-ring |
| 438 Hexagon socket screw | 642 Pilot cover(QMC) | 733 O-ring |
| 496 Plug | 643 Pilot piston | 734 O-ring |
| 601 Casing | 644 Spring seat(Q) | 735 O-ring |
| 611 Feed back lever | 645 Adjust stem(Q) | 755 O-ring |
| 612 Lever(1) | 646 Pilot spring | 756 O-ring |
| 613 Lever(2) | 647 Stopper | 763 O-ring |
| 614 Fulcrum plug | 648 Piston(QMC) | 801 Nut |
| 615 Adjust plug | 651 Sleeve | 814 Snap ring |
| 621 Compensator rod | 652 Spool | 836 Snap ring |
| 622 Piston case | 653 Spring seat | 858 Snap ring |
| 623 Compensator rod | 654 Return spring | 874 Pin |
| 624 Spring seat(C) | 655 Set spring | 875 Pin |
| 625 Outer spring | 656 Block cover | 887 Pin |
| 626 Inner spring | 708 O-ring | 897 Pin |
| 627 Adjust stem(C) | 722 O-ring | 898 Pin |
| 628 Adjust screw(C) | 724 O-ring | 924 Set screw |
| 629 Cover(C) | 725 O-ring | 925 Adjust screw(Q) |

2) TOOLS AND TIGHTENING TORQUE

(1) Tools

The tools necessary to disassemble/reassemble the pump are shown in the follow list.

| Tool name & size | | Part name | | | |
|--|---|--|---------------------|---------------------|------------------------------|
| Name | B | Hexagon socket head bolt | PT plug (PT thread) | PO plug (PF thread) | Hexagon socket head setscrew |
| Allen wrench  | 4 | M 5 | BP-1/16 | - | M 8 |
| | 5 | M 6 | BP-1/8 | - | M10 |
| | 6 | M 8 | BP-1/4 | PO-1/4 | M12, M14 |
| Double ring spanner, socket wrench, double(Single) open end spanner  | - | Hexagon head bolt | Hexagon nut | VP plug (PF thread) | |
| | 6 | M 8 | M 8 | - | |
| Adjustable angle wrench | | Small size, Max 36mm | | | |
| Screw driver | | Minus type screw driver, Medium size, 2 sets | | | |
| Hammer | | Plastic hammer, 1 set | | | |
| Pliers | | For snap ring, TSR-160 | | | |
| Steel bar | | 4 × 100mm | | | |
| Torque wrench | | Capable of tightening with the specified torques | | | |
| Pincers | | - | | | |
| Bolt | | M4, Length : 50mm | | | |

(2) Tightening torque

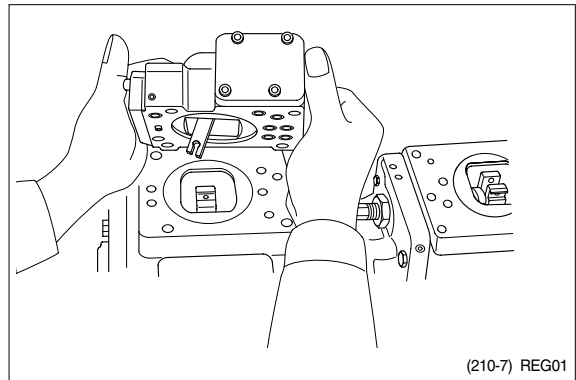
| Part name | Bolt size | Torque | | Wrench size | |
|---|-----------|---------|----------|-------------|----|
| | | kgf · m | lbf · ft | in | mm |
| Hexagon socket head bolt Material : SCM435) | M 5 | 0.7 | 5.1 | 0.16 | 4 |
| | M 6 | 1.2 | 8.7 | 0.20 | 5 |
| | M 8 | 3.0 | 21.7 | 0.24 | 6 |
| | M10 | 5.8 | 42.0 | 0.31 | 8 |
| | M12 | 10.0 | 72.3 | 0.39 | 10 |
| | M14 | 16.0 | 116 | 0.47 | 12 |
| | M16 | 24.0 | 174 | 0.55 | 14 |
| | M18 | 34.0 | 246 | 0.55 | 14 |
| | M20 | 44.0 | 318 | 0.67 | 17 |
| PT Plug(Material : S45C) ※ Wind a seal tape 1 1/2 to 2 turns round the plug | PT1/16 | 0.7 | 5.1 | 0.16 | 4 |
| | PT 1/8 | 1.05 | 7.59 | 0.20 | 5 |
| | PT 1/4 | 1.75 | 12.7 | 0.24 | 6 |
| | PT 3/8 | 3.5 | 25.3 | 0.31 | 8 |
| | PT 1/2 | 5.0 | 36.2 | 0.39 | 10 |
| PF Plug(Material : S35C) | PF 1/4 | 3.0 | 21.7 | 0.24 | 6 |
| | PF 1/2 | 10.0 | 72.3 | 0.39 | 10 |
| | PF 3/4 | 15.0 | 109 | 0.55 | 14 |
| | PF 1 | 19.0 | 137 | 0.67 | 17 |
| | PF 1 1/4 | 27.0 | 195 | 0.67 | 17 |
| | PF 1 1/2 | 28.0 | 203 | 0.67 | 17 |

3) DISASSEMBLY

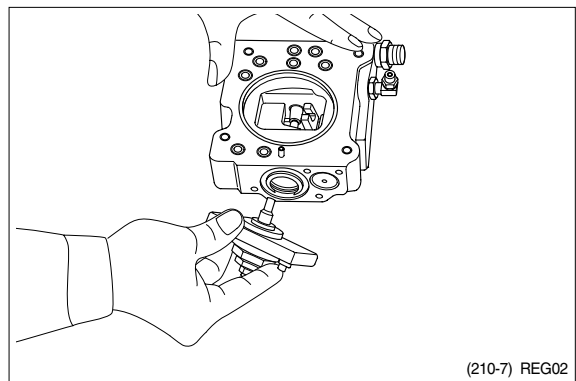
Since the regulator consists of small precision finished parts, disassembly and assembly are rather complicated.

For this reason, replacement of a regulator assembly is recommended, unless there is a special reason, but in case disassembly is necessary for an unavoidable reason, read through this manual to the end before starting disassembly.

- (1) Choose a place for disassembly.
 - ※ Choose a clean place.
 - ※ Spread rubber sheet, cloth, or so on on top of work-bench to prevent parts from being damaged.
- (2) Remove dust, rust, etc. from surfaces of regulator with clean oil.
- (3) Remove hexagon socket head screw (412, 413) and remove regulator main body from pump main body.
 - ※ Take care not to lose O-ring.



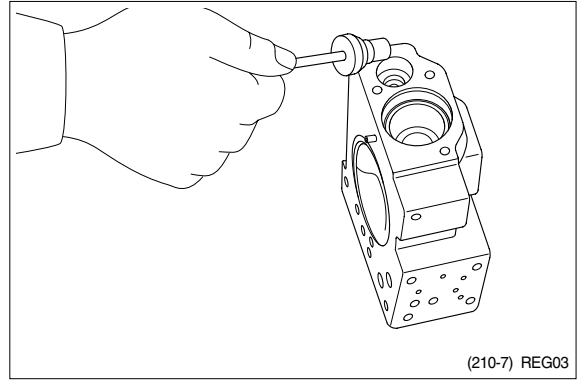
- (4) Remove hexagon socket head screw (438) and remove cover(C,629)
 - ※ Cover(C) is fitted with adjusting screw (C,QI) (628, 925), adjusting ring(C, 627), lock nut(630), hexagon nut(801) and adjusting screw(924).
Do not loosen these screws and nuts.
If they are loosened, adjusted pressure-flow setting will vary.



- (5) After removing cover(C, 629) subassembly, take out outer spring(625), inner spring (626) and spring seat(C, 624) from compensating section.

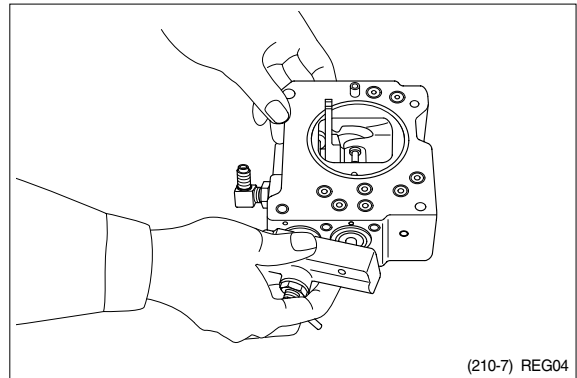
Then draw out adjusting ring(Q, 645), pilot spring(646) and spring seat(644) from pilot section.

- ※ Adjusting ring(Q,645) can easily be drawn out with M4 bolt.



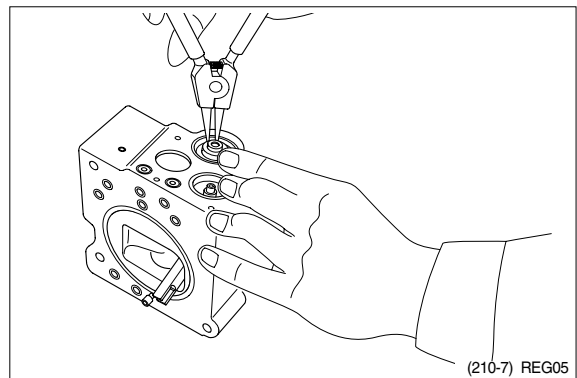
- (6) Remove hexagon socket head screws (436, 438) and remove pilot cover(641).

After removing pilot cover, take out set spring(655) from pilot section.



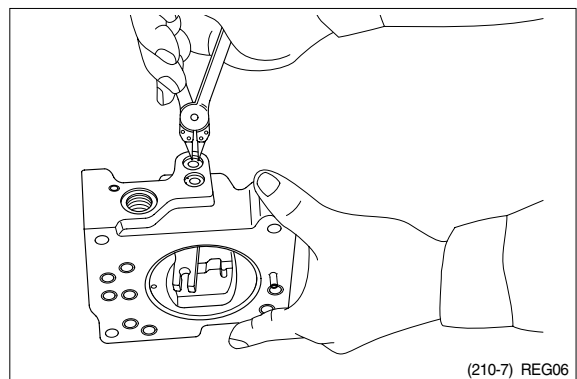
- (7) Remove snap ring(814) and take out spring seat(653), return spring(654) and sleeve(651).

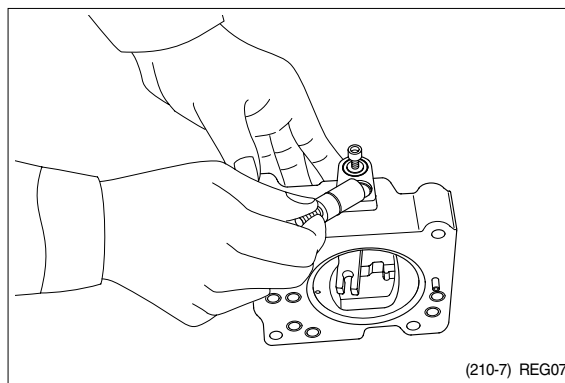
- ※ Sleeve(651) is fitted with snap ring(836).
- ※ When removing snap ring(814), return spring(654) may pop out. Take care not to lose it.



- (8) Remove locking ring(858) and take out fulcrum plug(614) and adjusting plug (615).

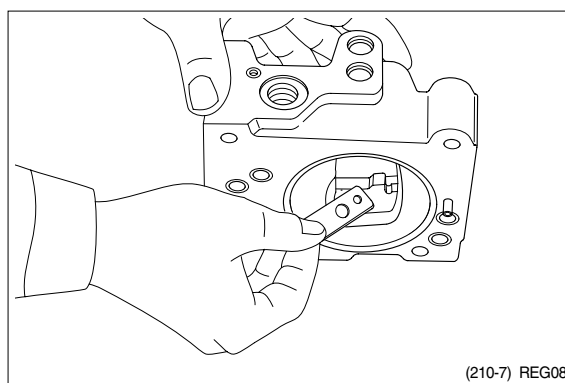
- ※ Fulcrum plug(614) and adjusting plug (615) can easily be taken out with M6 bolt.





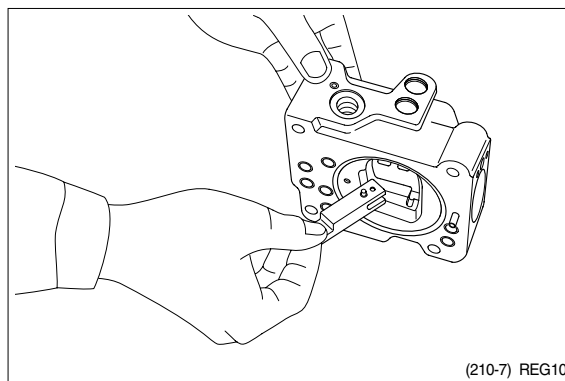
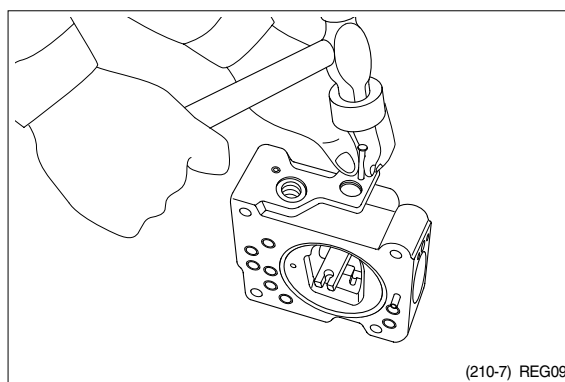
(9) Remove lever(2, 613). Do not draw out pin(875).

※ Work will be promoted by using pincers or so on.



(10) Draw out pin(874) and remove feedback lever(611).

Push out pin(874, 4mm in dia.) from above with slender steel bar so that it may not interfere with lever(1, 612).



(11) Remove lever(1, 612). Do not draw out pin(875).

(12) Draw out pilot piston(643) and spool(652).

(13) Draw out piston case(622), compensating piston(621) and compensating rod(623).

※ Piston case(622) can be taken out by pushing compensating rod(623) at opposite side of piston case.

This completes disassembly.

4) ASSEMBLY

(1) For assembly, reverse disassembly procedures, but pay attention to the following items.

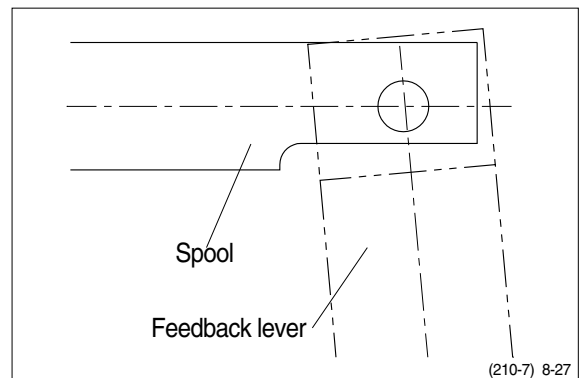
- ① Always repair parts that were scored at disassembly.
- ② Get replacement parts ready beforehand.
Mixing of foreign matter will cause malfunction.
Therefore, wash parts well with cleaning oil, let them dry with jet air and handle them in clean place.
- ③ Always tighten bolts, plugs, etc. to their specified torques.
- ④ Do not fail to coat sliding surfaces with clean hydraulic oil before assembly.
- ⑤ Replace seals such as O-ring with new ones as a rule.

(2) Put compensating rod(623) into compensating hole of casing(601).

(3) Put pin force-fitted in lever(1, 612) into groove of compensating rod and fit lever (1) to pin force-fitted in casing.

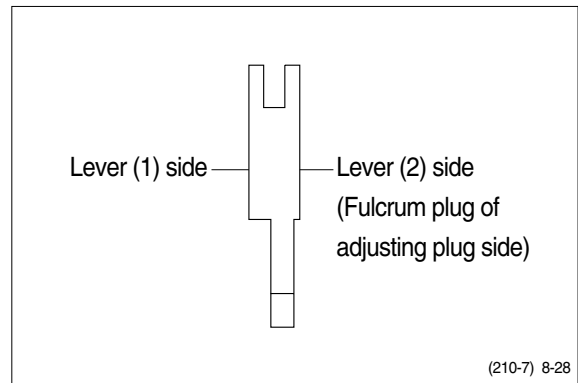
(4) Fit spool(652) and sleeve(651) into hole in spool of casing.

- ※ Confirm that spool and sleeve slide smoothly in casing without binding.
- ※ Pay attention to orientation of spool.



- (5) Fit feedback lever(611), matching its pin hole with pin hole in spool.
Then insert pin(874).

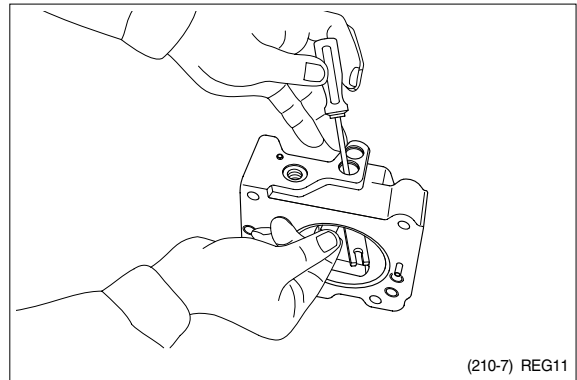
- ※ Insert pin in feedback lever a little to ease operation.
- ※ Take care not to mistake direction of feedback lever.



- (6) Put pilot piston(643) into pilot hole of casing.

- ※ Confirm that pilot piston slides smoothly without binding.

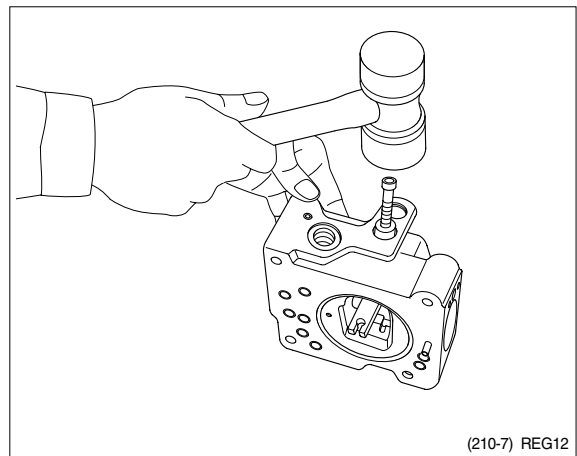
- (7) Put pin force-fitted in lever(2, 613) into groove of pilot piston.
Then fix lever(2).



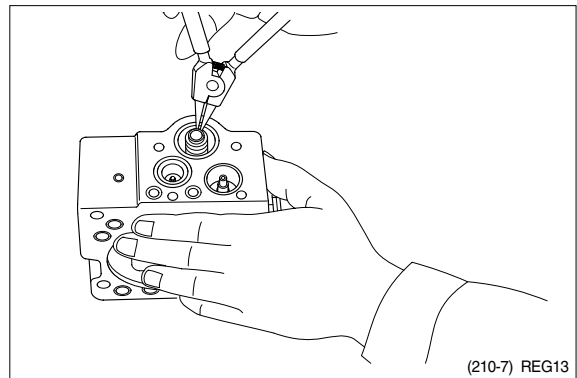
- (8) Fit fulcrum plug(614) so that pin force-fitted in fulcrum plug(614) can be put into pin hole of lever(2).
Then fix locking ring(858).

- (9) Insert adjusting plug(615) and fit locking ring.

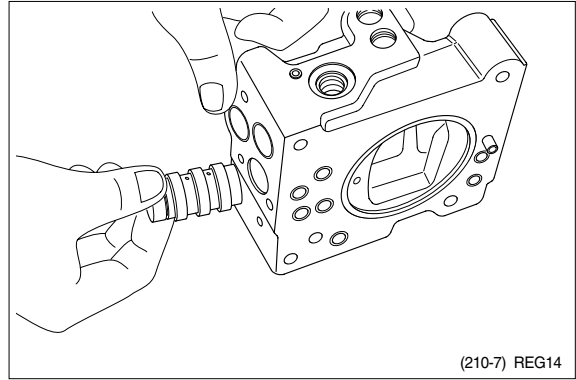
- ※ Take care not to mistake inserting holes for fulcrum plug and adjusting plug.
At this point in time move feedback lever to confirm that it has no large play and is free from binding.



- (10) Fit return spring(654) and spring seat (653) into spool hole and attach snap ring (814).

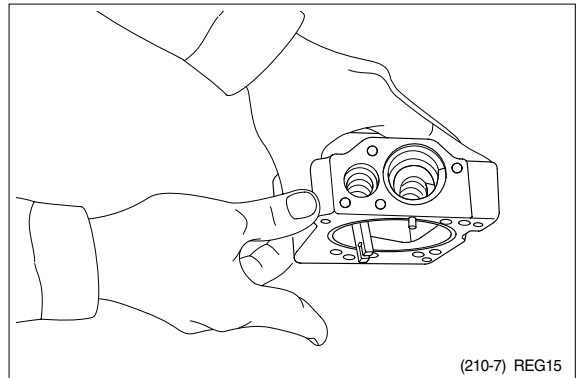


- (11) Fit set spring(655) to spool hole and put compensating piston(621) and piston case(622) into compensating hole.
Fit pilot cover(641) and tighten it with hexagonal socket head screws(436, 438).

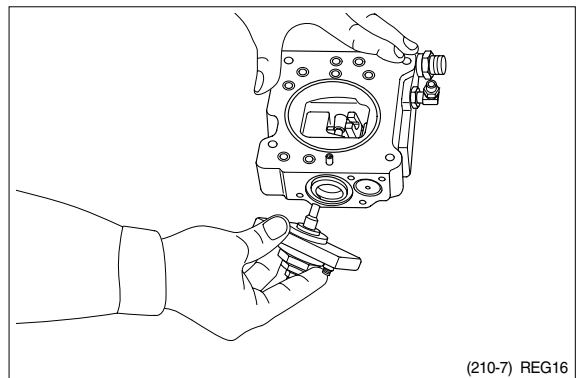


- (12) Put spring seat(644), pilot spring(646) and adjusting ring(Q, 645) into pilot hole.
Then fix spring seat(624), inner spring (626) and outer spring(625) into compensating hole.

※ When fitting spring seat, take care not to mistake direction of spring seat.



- (13) Install cover(C, 629) fitted with adjusting screws(628, 925), adjusting ring(C, 627), lock nut(630), hexagon nut(801) and adjusting screw(924).
Then tighten them with hexagonal socket head screws(438).



This completes assembly.

GROUP 4 MAIN CONTROL VALVE

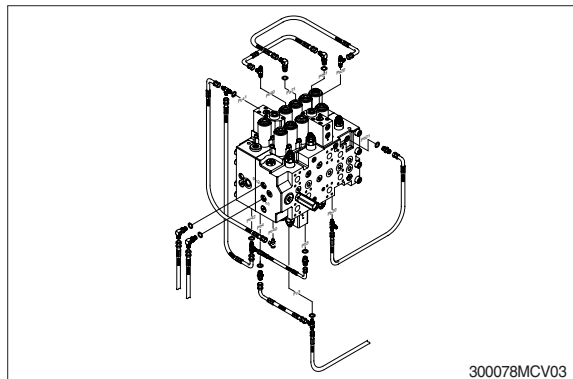
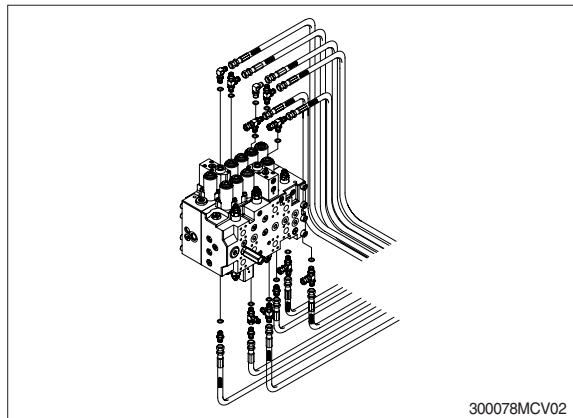
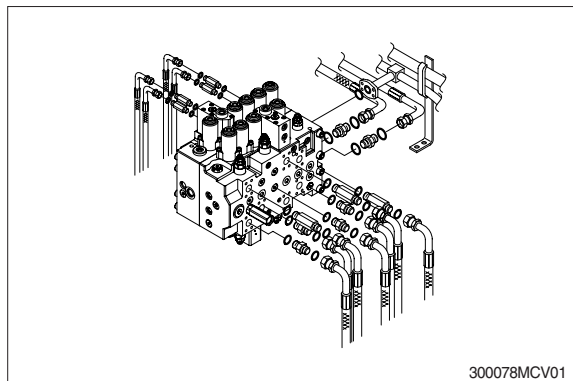
1. REMOVAL AND INSTALL OF MOTOR

1) REMOVAL

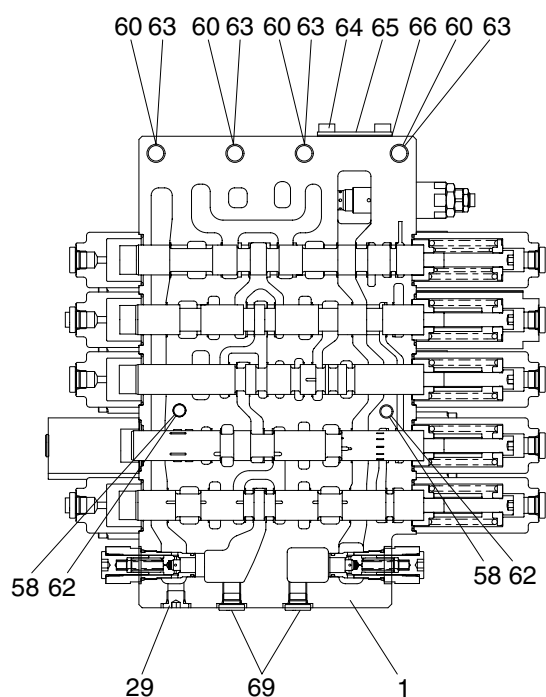
- (1) Lower the work equipment to the ground and stop the engine.
- (2) Operate the control levers and pedals several times to release the remaining pressure in the hydraulic piping.
- (3) Loosen the breather slowly to release the pressure inside the hydraulic tank.
- ▲ **Escaping fluid under pressure can penetrate the skin causing serious injury.**
 - ※ When pipes and hoses are disconnected, the oil inside the piping will flow out, so catch it in oil pan.
- (4) Remove the wirings for the pressure sensor and so on.
- (5) Remove bolts and disconnect pipe.
- (6) Disconnect pilot line hoses.
- (7) Disconnect pilot piping.
- (8) Sling the control valve assembly and remove the control valve mounting bolt.
 - Weight : 200 kg (441lb)
- (9) Remove the control valve assembly.
When removing the control valve assembly, check that all the piping have been disconnected.

2) INSTALL

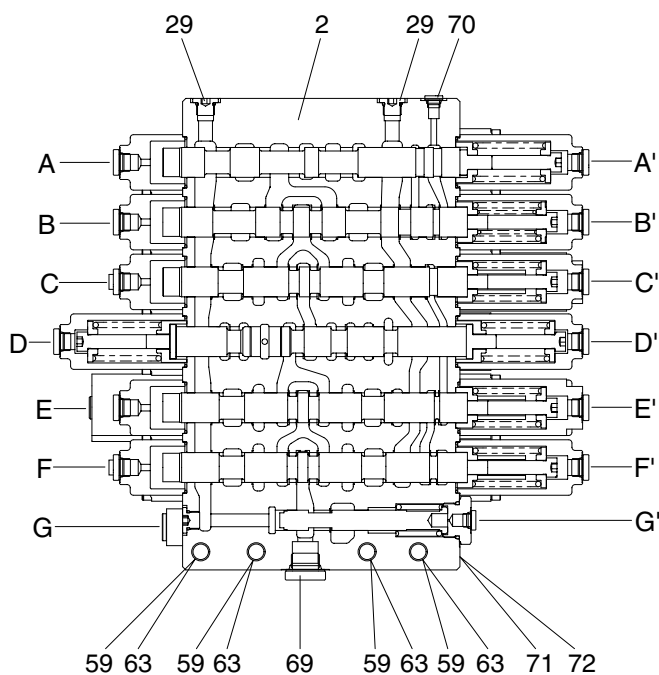
- (1) Carry out installation in the reverse order to removal.
- (2) Bleed the air from below items.
 - ① Cylinder (boom, arm, bucket)
 - ② Swing motor
 - ③ Travel motor
 - ※ See each item removal and install.
- (3) Confirm the hydraulic oil level and recheck the hydraulic oil leak or not.



2. STRUCTURE

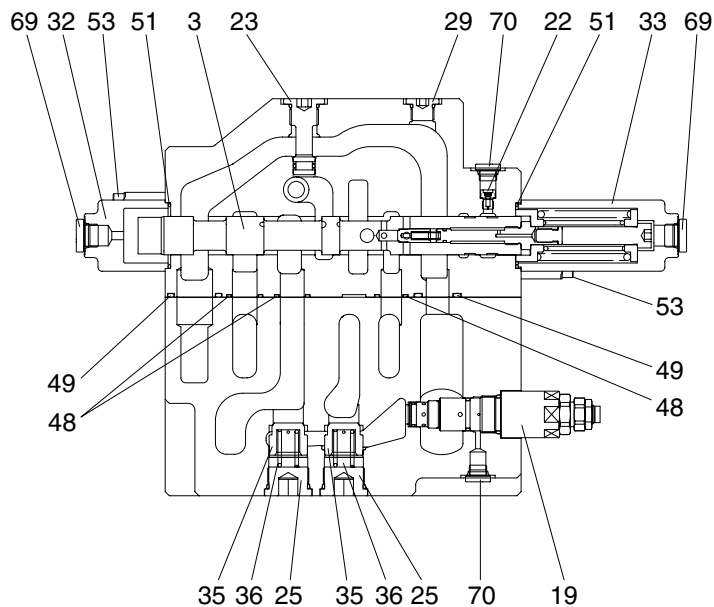


P1 BLOCK SPOOL SECTION



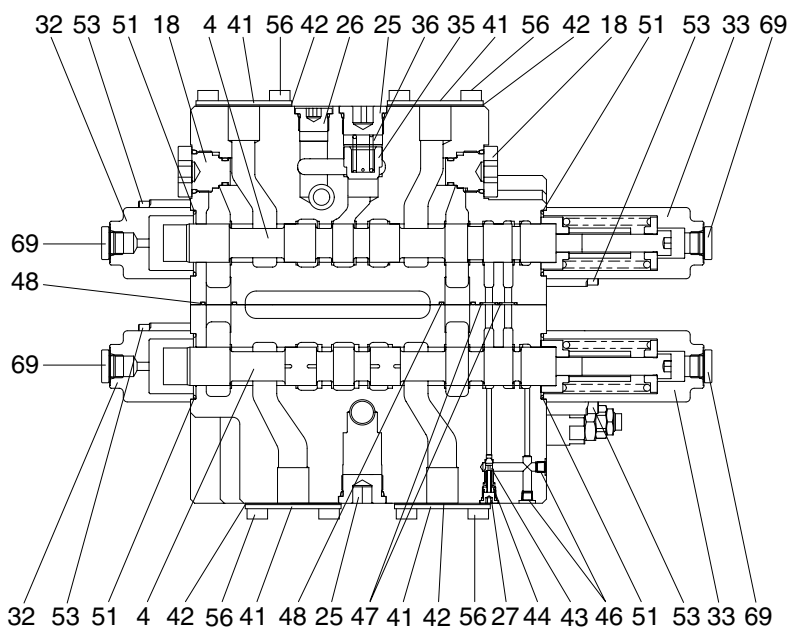
P2 BLOCK SPOOL SECTION

- 1 Housing P1
- 2 Housing P2
- 29 Plug kit
- 58 Socket bolt
- 59 Socket bolt
- 60 Socket bolt
- 62 Spring washer
- 63 Spring washer
- 64 Hexagon bolt
- 65 Cover 2
- 66 Gasket 2
- 69 Dust cap
- 70 Dust cap
- 71 Name plate
- 72 Rivet

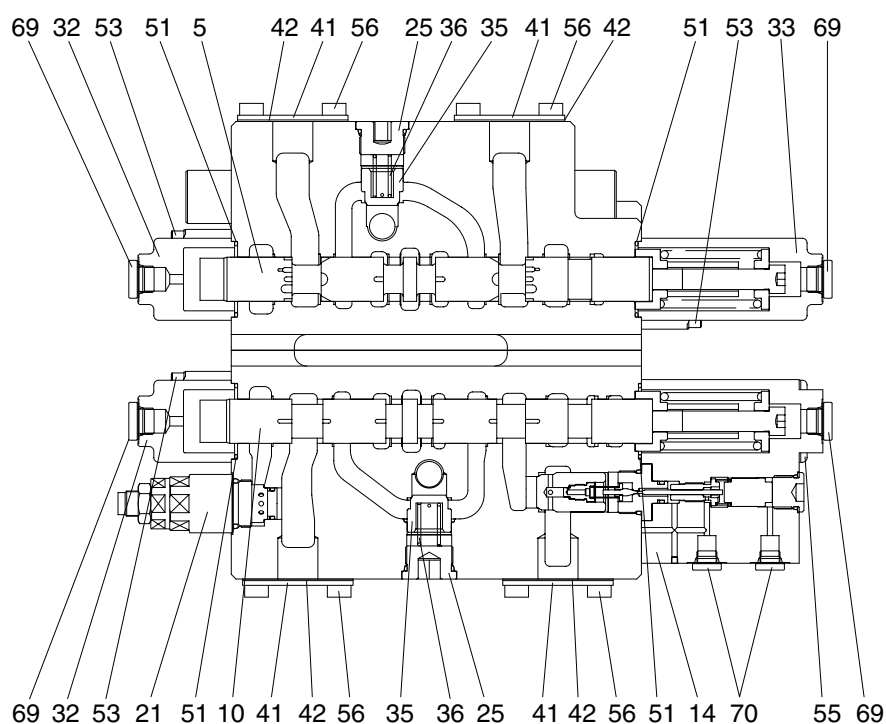


SECTION A-A' (STRAIGHT-TRAVEL & SUPPLY)

- 3 Spool assy
- 4 Spool assy
- 18 Overload R/V plug assy
- 19 Main relief valve assy
- 22 Signal orifice assy
- 23 Parallel block plug assy
- 25 Load check plug kit
- 27 Plug kit
- 29 Plug kit
- 32 Pilot cover A
- 33 Pilot cover B1
- 35 Load check poppet 1
- 36 Load check spring 1
- 41 Cover 1
- 42 Gasket 1
- 43 Poppet signal
- 44 Spring signal
- 46 Plug
- 47 O-ring
- 48 O-ring
- 49 O-ring
- 51 O-ring
- 53 Socket bolt
- 56 Hexagon bolt
- 69 Dust cap
- 70 Dust cap



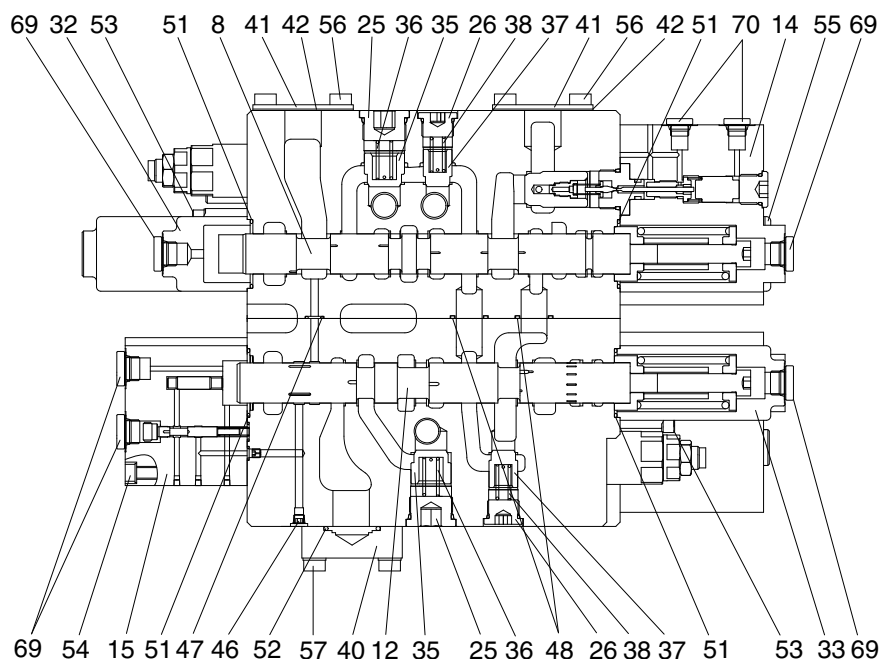
SECTION B-B' (TRAVEL RIGHT & LEFT)



SECTION C-C' (SWING & BOOM 1)

2107V2MC42

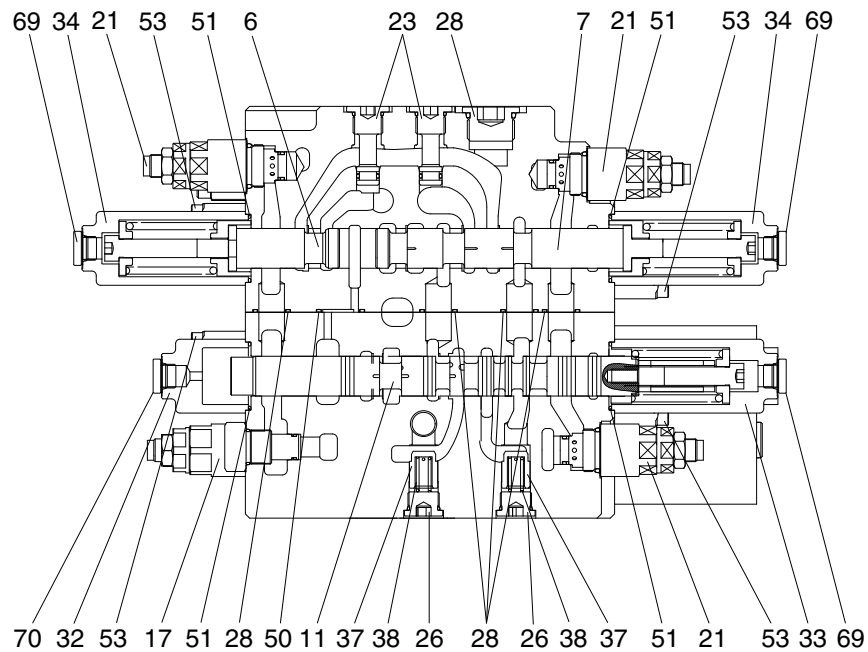
| | | | | | |
|----|----------------------|----|---------------------|----|--------------|
| 5 | Swing spool assy | 33 | Pilot cover B1 | 53 | Socket bolt |
| 10 | Boom 1 spool | 35 | Load check poppet 1 | 55 | Socket bolt |
| 14 | Holding valve assy | 36 | Load check spring 1 | 56 | Haxagon bolt |
| 21 | Overload relief assy | 41 | Cover 1 | 69 | Dust cap |
| 25 | Load check plug kit | 42 | Gasket 1 | 70 | Dust cap |
| 32 | Pilot cover A | 51 | O-ring | | |



SECTION E-E ' (ARM 1 & ARM REGENERATION)

2107V2MC44

| | | | | | |
|----|----------------------|----|---------------------|----|---------------|
| 8 | Arm 1 spool assy | 37 | Load check poppet 1 | 53 | Socket bolt |
| 12 | Arm regen spool assy | 38 | Load check spring 2 | 54 | Socket bolt |
| 14 | Holding valve assy | 40 | Flange | 55 | Socket bolt |
| 15 | Regen valve assy | 41 | Cover 1 | 56 | Hexagon bolt |
| 25 | Load check plug kit | 42 | Gasket 1 | 57 | Socket bolt |
| 26 | Load check plug kit | 46 | Plug | 62 | Spring washer |
| 32 | Pilot cover A | 47 | O-ring | 69 | Dust cap |
| 33 | Pilot cover B1 | 48 | O-ring | 70 | Dust cap |
| 35 | Load check poppet 1 | 51 | O-ring | | |
| 36 | Load check spring 1 | 52 | O-ring | | |



SECTION D-D ' (SWING PRIORITY & BOOM 2 & ARM 2)

D21072MC43

| | | | | | |
|----|---------------------------|----|---------------------|----|---------------------|
| 6 | Swing priority spool assy | 26 | Load check plug kit | 38 | Load check spring 2 |
| 7 | Boom 2 spool assy | 28 | Plug kit | 50 | O-ring |
| 11 | Arm 2 spool assy | 32 | Pilot cover A | 51 | O-ring |
| 17 | Overload relief plug assy | 33 | Pilot cover B1 | 53 | Socket bolt |
| 21 | Overload relief assy | 34 | Pilot cover B2 | 69 | Dust cap |
| 23 | Parallel block plug assy | 37 | Load check poppet 2 | | |

3. DISASSEMBLY AND ASSEMBLY

1) GENERAL PRECAUTIONS

- (1) As hydraulic equipments, not only this valve are constructed precisely with very small clearances, disassembling and assembling must be carefully done in a clean place with preventing dusts and contaminants from entering.
- (2) Prepare the section drawing and study the structure of MCV and then start disassembly work.
- (3) When removing the control valve from the machine, install caps on every ports, and wash the outside of the assembly with confirming the existence of caps before disassembling.
Prepare a suitable table and some clean papers or rubber mat on the table for disassembling.
- (4) If the components are left disassembled, they may get rust. Make sure to measure the greasing and sealing.
- (5) For carrying the control valve, never hold with pilot cover or relief valve and overload relief valve and carefully treat the valves.
- (6) Do not tap the valve even if the spool movement is not smooth.
- (7) Several tests for such as relief characteristics, leakage, overload relief valve setting and flow resistance are required after re-assembling, and the hydraulic test equipments for those tests are needed.
Therefore, do not disassemble what cannot perform test adjustment, even if it can disassemble.

※ Be sure to observe the mark (※) description in the disassembly and assembly procedures.

2) TOOLS

Before disassembling the control valve, prepare the following tools beforehand.

| Name of tool | Quantity | Size (mm) |
|-----------------------------------|--------------|-------------------------------|
| Vice mounted on bench (soft jaws) | 1 unit | |
| Hexagon wrench | Each 1 piece | 5, 6, 10, 12 and 14 |
| Socket wrench | Each 1 piece | 27 and 32 |
| Spanner | Each 1 piece | 26 and 32 (main relief valve) |

3) DISASSEMBLY

(1) Removing spool

① The case of the section without holding valve

Instruction for removing the travel spool (for instance) is follows :

Remove two hex socket bolts by 5 mm allen key wrench, then remove pilot cover.

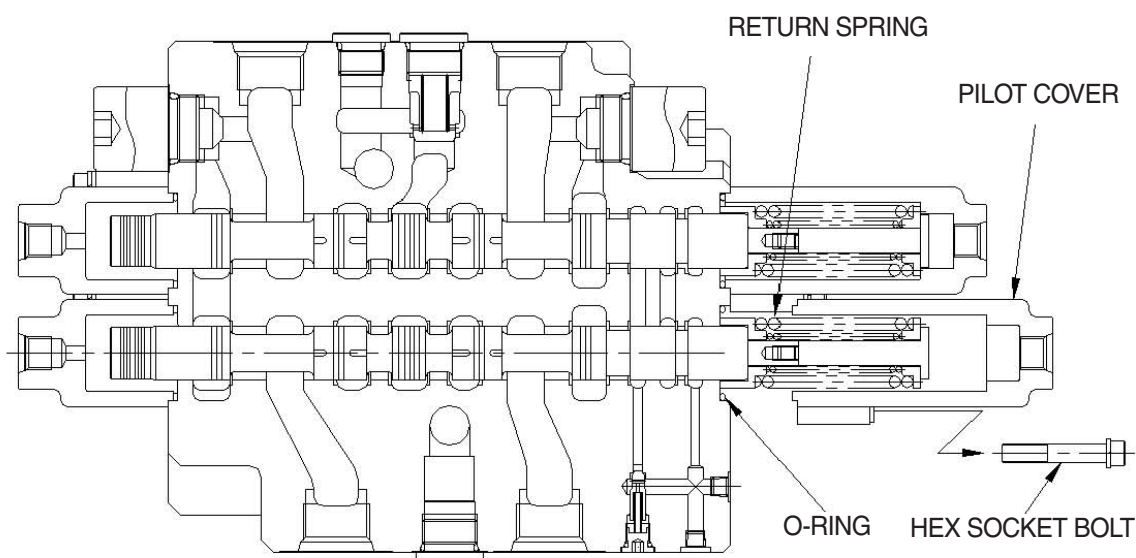
- ※ Pay attention not to lose the O-ring under the pilot cover.

As the return spring portion of travel spool comes out, pull the spring straight slowly, by which spool assembly is removed.

- ※ The spools have to remove from the spring side.

Other spools (no lock valve type) can be removed in the same manner but the swing priority spool is reversed.

- ※ When spool replace, do not disassemble of a spool by any cases. Please replace by spool assembly.
- ※ Please attach using a tag etc. in the case of two or more kinds of spool replace, and understand a position.



D21072MC34

② The case of the section with holding valve

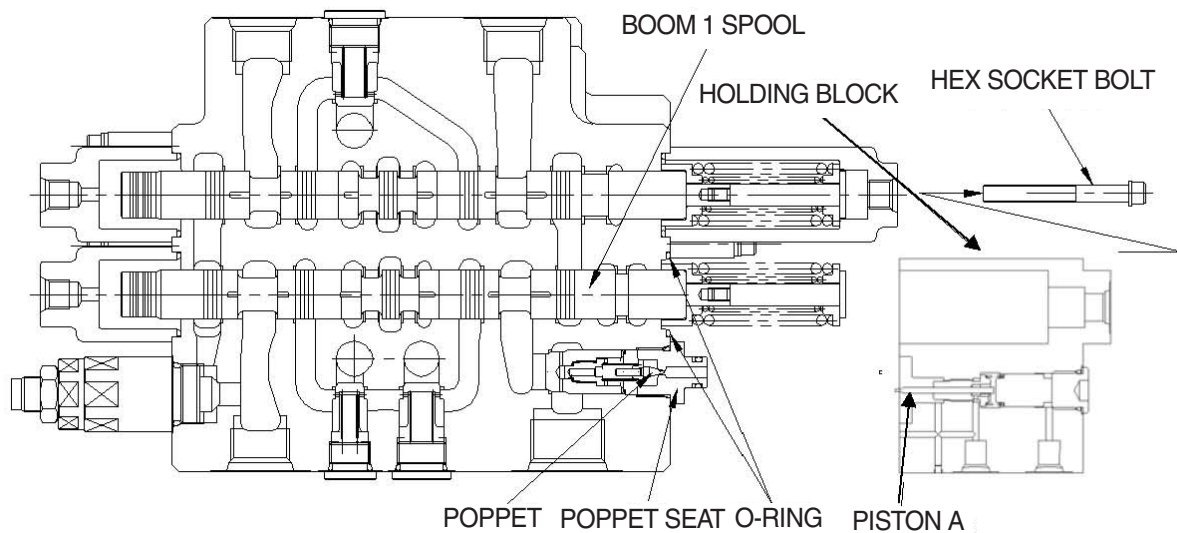
Instruction for removing the boom spool (for instance) is follows :

Remove five hex socket bolts with washer by 5 mm allen key wrench. Then remove pilot cover with internal parts below figure.

- ※ Be careful not to separate O-ring and poppet under pilot cover.
- ※ Pay attention not to damage the exposed piston A under pilot cover.

As the return spring portion of boom 1 spool comes out, pull the spring straight slowly, by which spool assembly is removed.

- ※ The spools have to remove form the spring side.
- ※ When spool replace, do not disassemble of a spool by any cases, please replace by spool assembly.



D21072MC35

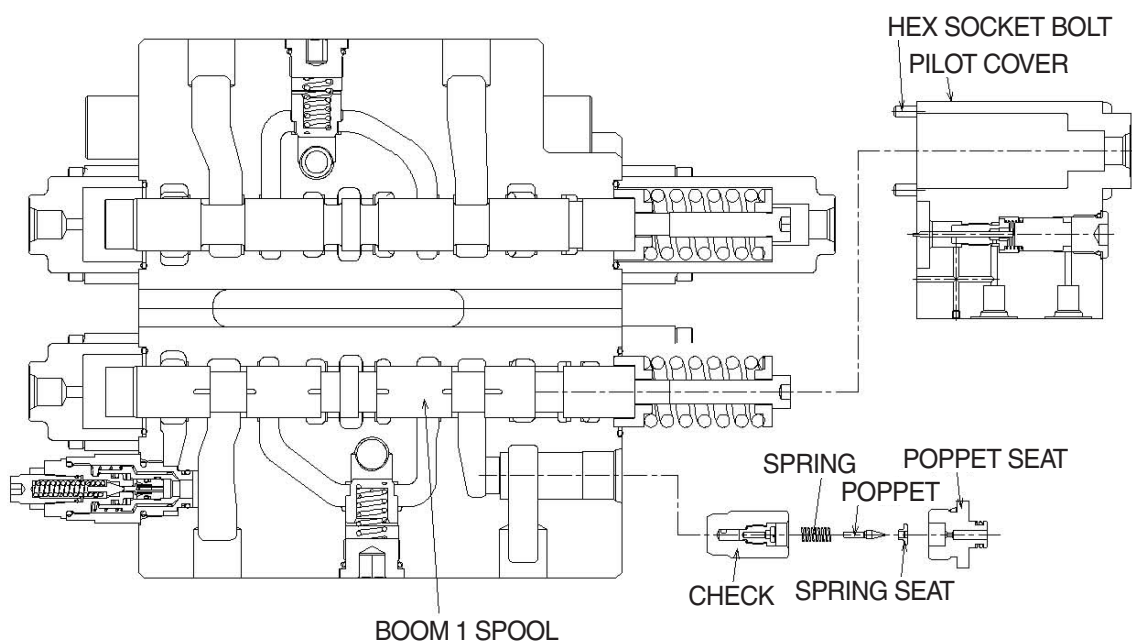
(2) Removing holding valve

Remove the pilot cover with the holding valve as described on previous page.

- ※ Do not disassembled internal parts of the pilot cover.

Loosen the poppet seat by 26 mm spanner and remove the poppet, the spring seat, the spring and the check in order.

- ※ Pay attention not to lose the poppet.
- ※ Do not disassembled internal parts of the check because the plug, functioning orifice, can damage easily.

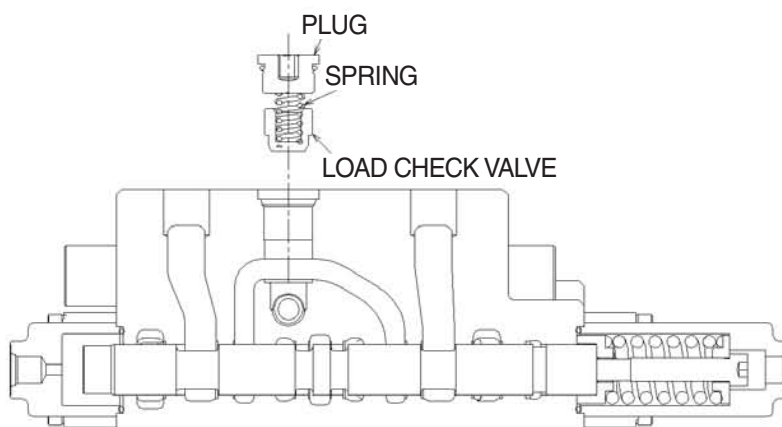


D21072MC36

(3) Removing load check valve and negative relief valve

① The load check valve

- Fix the body to suitable work bench. Loosen the plug by 10 mm allen key wrench.
- Remove the spring and the load check valve with pincers or magnet.

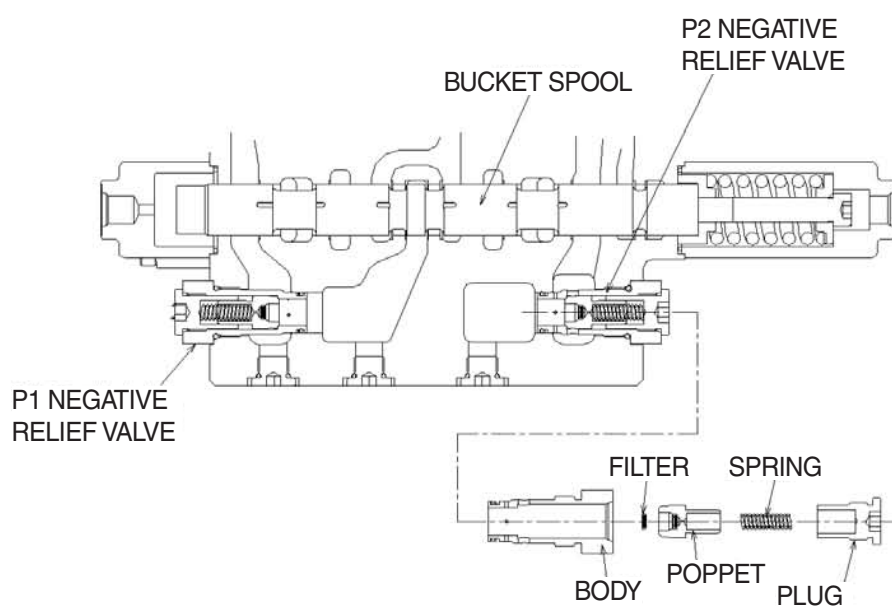


D21072MC37

② The negative relief valve

Loosen the socket by 12 mm allen key wrench.

Remove the spring, the spring holder, the piston and the negative control poppet.



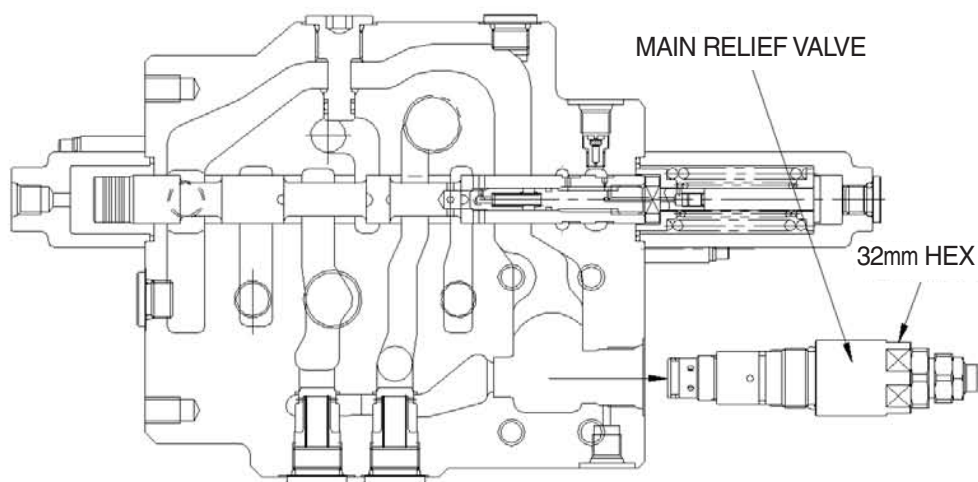
D21072MC38

※ Do not disassemble the coin filter inside the negative control poppet because of forced fit.

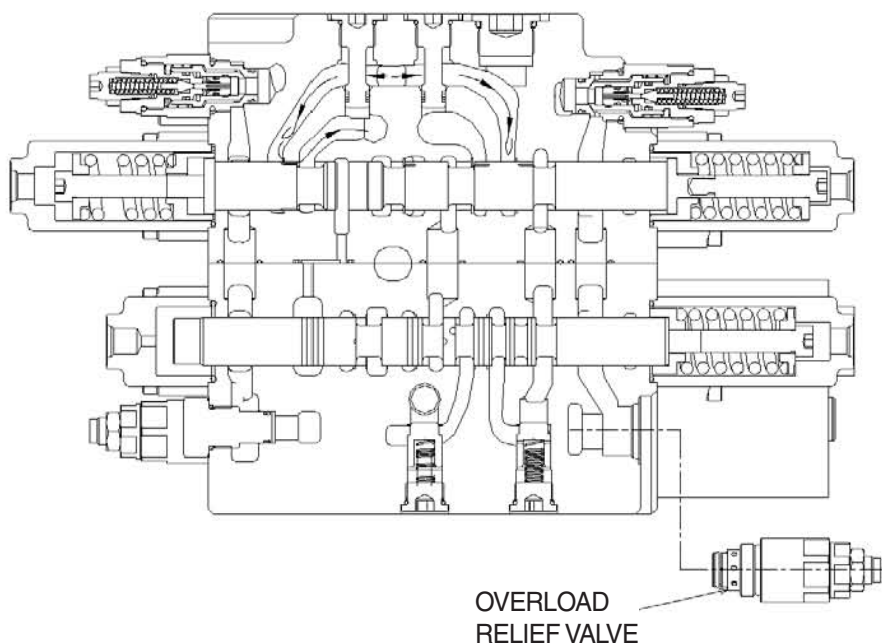
(4) Removing main relief valve and overload relief valve

Fix the valve body to suitable work bench. Remove the main relief valve by 32 mm spanner and remove the overload relief valve 32 mm spanner (standard) or 36 mm spanner (optional).

- ※ When disassembled, tag the relief valve for identification so that they can be reassembled correctly.
- ※ Pay attention not to damage seat face of disassembled main relief and overload relief valve.
- ※ Main relief and overload relief valve are very critical parts for performance and safety of the machine. Also, the pressure set is very difficult. Therefore, any abnormal parts are found, replace it with completely new relief valve assembly.



D21072MC39



D21072MC46

4) ASSEMBLY

(1) Precaution

- ① When you assemble, please wash all parts by pure cleaning liquid.
- ② For re-assembling, basically use only bland new seals for all portions.
- ③ Apply grease or hydraulic oil to the seals and seal fitting section to make the sliding smooth, unless otherwise specified.
- ④ Pay attention not to roll the O-ring when fitting and it may cause oil leakage.
- ⑤ Do not tap the valve even if the spool movement is not smooth.
- ⑥ Prepare the section drawing and study the structure of MCV and then start disassembly work.
- ⑦ Tighten bolt and parts with thread for all section by torque wrench to the respective tightening torque.

(2) Assembly

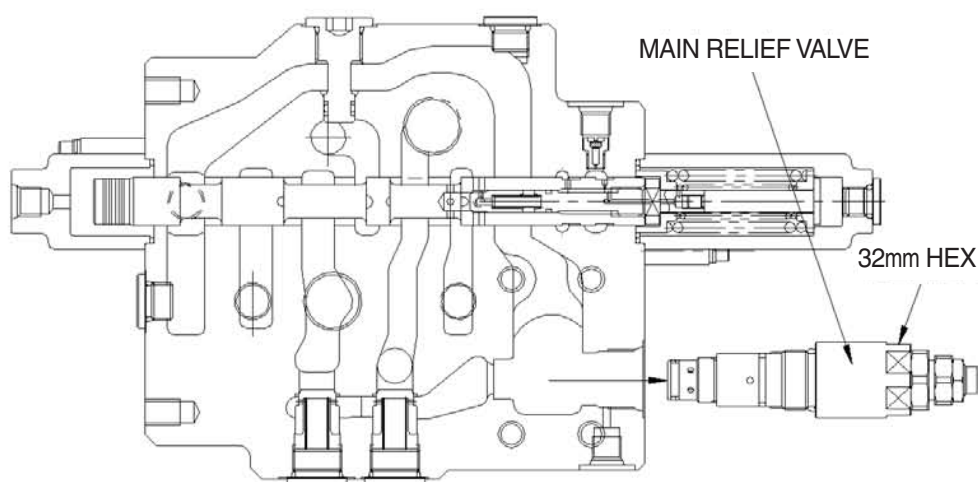
Explanation only is shown for the assembly, refer to the figures shown in the previous disassembly section.

① Main relief and overload relief valve

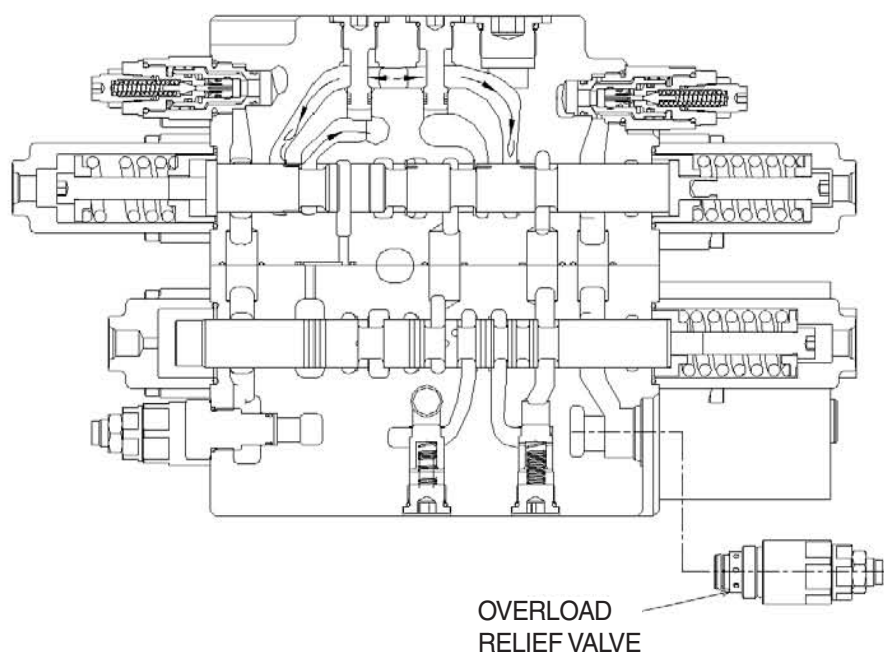
Fix the valve body to suitable work bench.

Install main relief valve and overload relief valve into the body and tighten to the specified torque by 32 mm torque wrench.

· Tightening torque : 8~9 kgf·m (57.8~65.1 lbf·ft)



D21072MC39



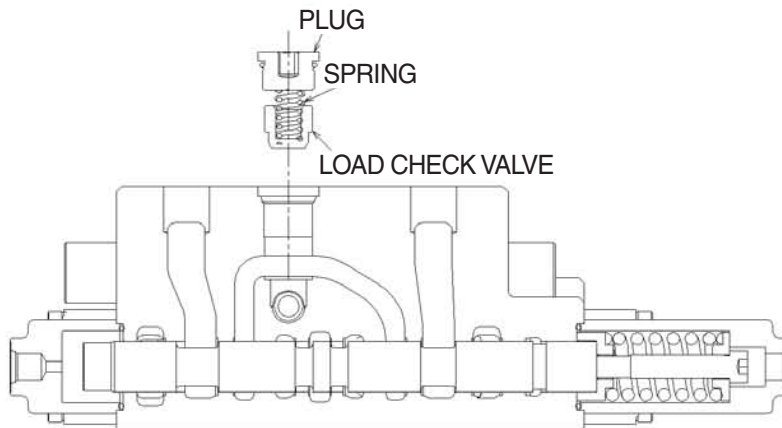
D21072MC46

② Load check valve

Assemble the load check valve and spring.

Put O-rings on to plug and tighten plug to the specified torque by 10 mm torque wrench.

- Tightening torque : 6~7 kgf·m (43.4~50.6 lbf·ft)

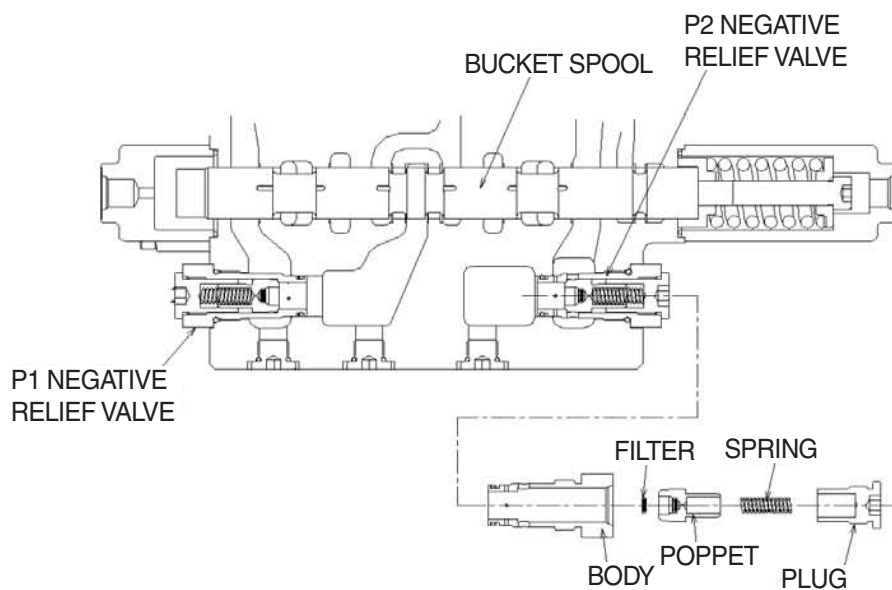


D21072MC37

③ Negative control relief valve

Assemble the nega-con poppet, piston, spring holder and spring into body in order and tighten the socket to the specified torque by 12 mm torque wrench.

- Tightening torque : 8~9 kgf·m (57.8~65.1 lbf·ft)



D21072MC38

④ Holding valves

Assemble the check, spring seat and poppet into the hole of valve body in order.

Tighten the poppet seat to the specified torque by 25 mm torque wrench.

· Tightening torque : 6~7 kgf·m (43.4~50.6 lbf·ft)

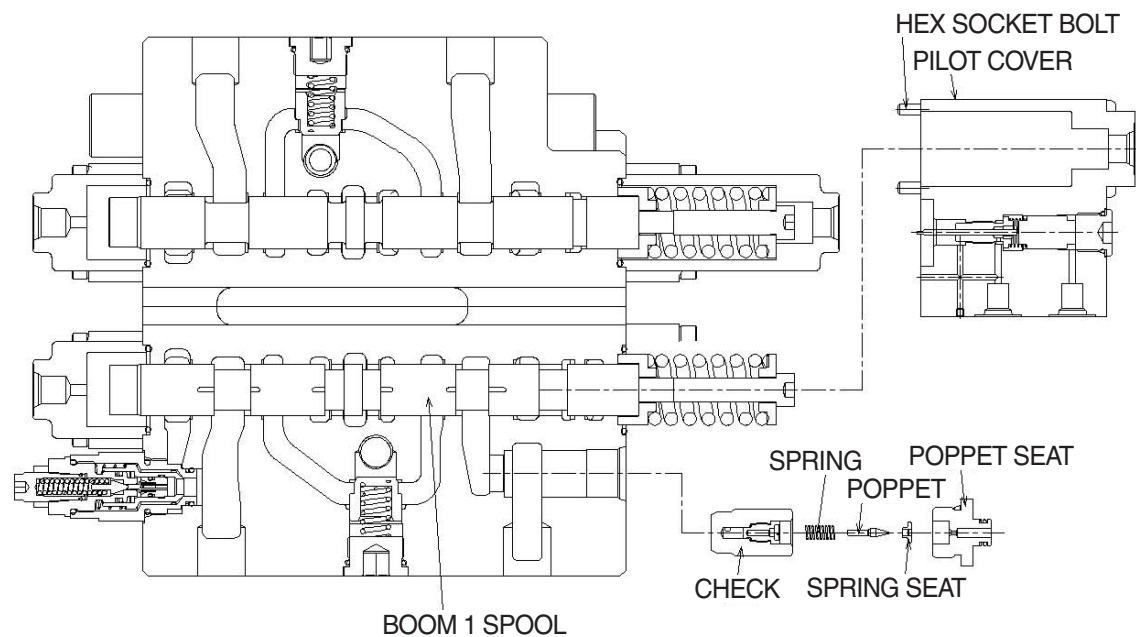
Fit the "piston A" under pilot cover with internal parts into hole on the poppet seat.

Tighten hexagon socket head bolt to specified torque by 5 mm torque wrench.

· Tightening torque : 1~1.1 kgf·m (7.2~7.9 lbf·ft)

※ Pay attention poppet not to separation.

※ Confirm that O-rings have been well fitted on the groove of body. (Apply grease on O-ring)



D21072MC36

⑤ Main spool

Put the spool position upward and fix it to the vise. Carefully insert the previously assembled spool assemblies into their respective bores within of body.

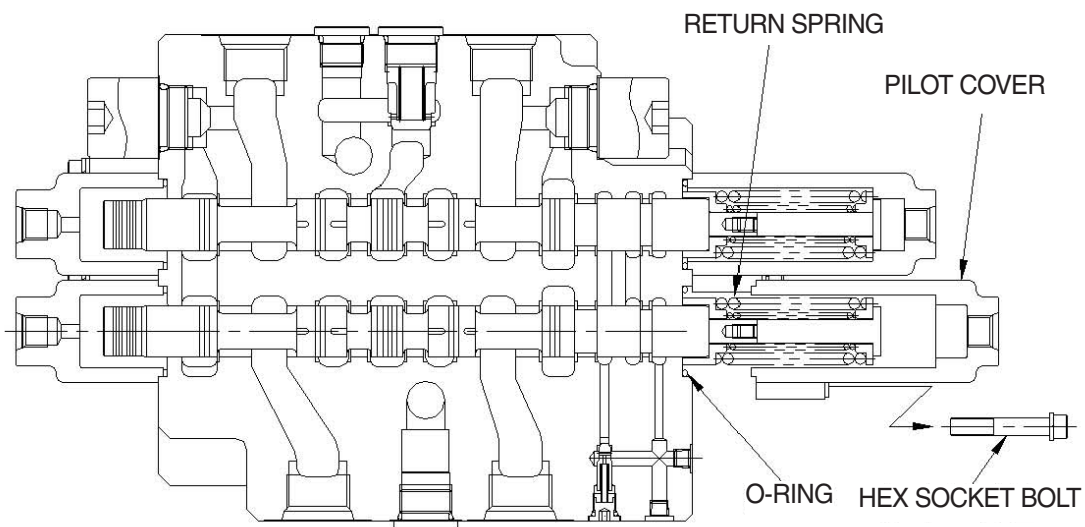
Fit spool assemblies into body carefully and slowly. Do not under any circumstances push them forcibly in.

Fit the pilot cover to the groove of the valve body.

Confirm that O-rings have been fitted on the groove of body. (Apply grease on O-ring)

Tighten the two socket bolt to the specified torque by 5 mm torque wrench.

· Tightening torque : 1~1.1 kgf·m (7.2~7.9 lbf·ft)



D21072MC34

GROUP 5 SWING DEVICE (TYPE 1)

1. REMOVAL AND INSTALL OF MOTOR

1) REMOVAL

- (1) Lower the work equipment to the ground and stop the engine.
- (2) Operate the control levers and pedals several times to release the remaining pressure in the hydraulic piping.
- (3) Loosen the breather slowly to release the pressure inside the hydraulic tank.

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

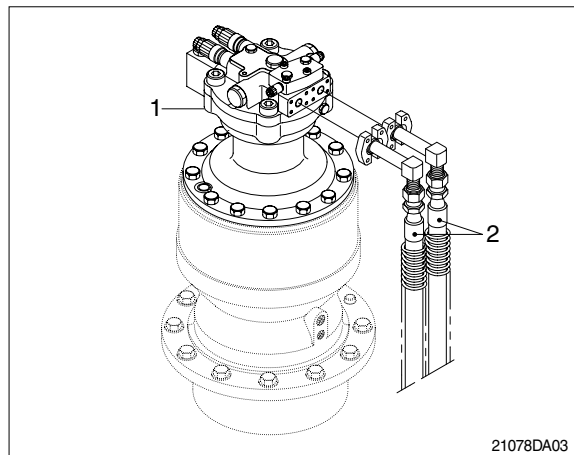
※ When pipes and hoses are disconnected, the oil inside the piping will flow out, so catch it in oil pan.

- (4) Disconnect hose assembly(2).
- (5) Disconnect pilot line hoses(3, 4, 5, 6, 7).
- (6) Sling the swing motor assembly(1) and remove the swing motor mounting bolts (8).

• Motor device weight : 230kg(507lb)

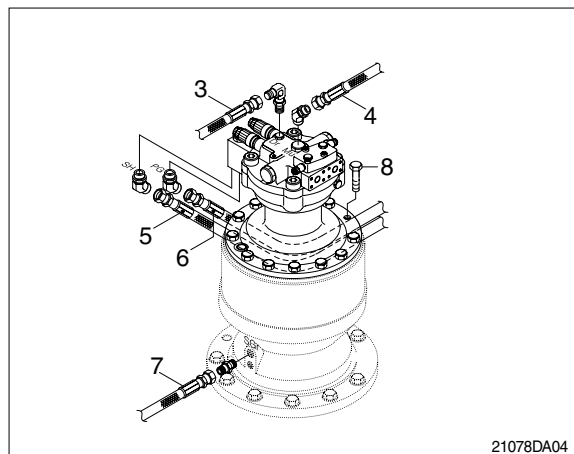
- (7) Remove the swing motor assembly.

※ When removing the swing motor assembly, check that all the piping have been disconnected.



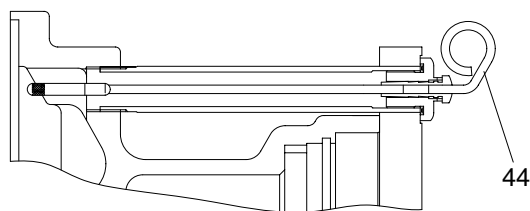
2) INSTALL

- (1) Carry out installation in the reverse order to removal.
- (2) Bleed the air from the swing motor.
 - ① Remove the air vent plug.
 - ② Pour in hydraulic oil until it overflows from the port.
 - ③ Tighten plug lightly.
 - ④ Start the engine, run at low idling and check oil come out from plug.
 - ⑤ Tighten plug fully.
- (3) Confirm the hydraulic oil level and check the hydraulic oil leak or not.

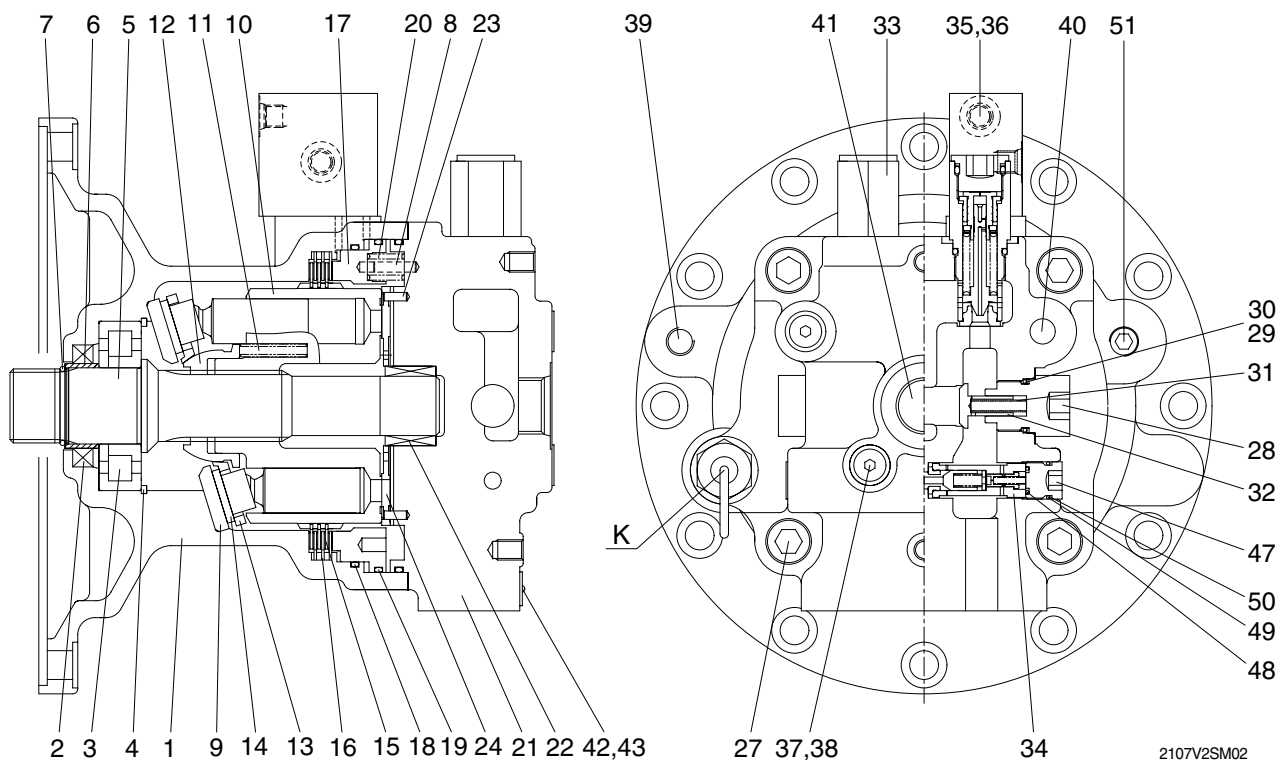


2. DISASSEMBLY AND ASSEMBLY OF SWING MOTOR

1) STRUCTURE



DETAIL K



2107V2SM02

| | | |
|-------------------|------------------------------|--------------------------|
| 1 Body | 18 O-ring | 35 Time delay valve assy |
| 2 Oil seal | 19 O-ring | 36 Wrench bolt |
| 3 Roller bearing | 20 Brake spring | 37 Plug |
| 4 Snap ring | 21 Rear cover | 38 O-ring |
| 5 Shaft | 22 Needle bearing | 39 Plug |
| 6 Bushing | 23 Pin | 40 Plug |
| 7 Stop ring | 24 Valve plate | 41 Plug |
| 8 Pin | 25 O-ring | 42 Name plate |
| 9 Shoe plate | 26 O-ring | 43 Rivet |
| 10 Cylinder block | 27 Wrench bolt | 44 Level gauge |
| 11 Spring | 28 Plug | 45 Flange |
| 12 Ball guide | 29 Back up ring | 46 O-ring |
| 13 Set plate | 30 O-ring | 47 Plug |
| 14 Piston assy | 31 Spring | 48 O-ring |
| 15 Friction plate | 32 Check | 49 O-ring |
| 16 Separate plate | 33 Relief valve assy | 50 Back up ring |
| 17 Brake piston | 34 Anti-inversion valve assy | 51 Plug |

2) DISASSEMBLING

(1) Disassemble the sub of a TURNING AXIS

- ① Unloosing wrench bolt and disassemble time delay valve assy(35) from rear cover(21)



14078SM201/201A

- ② Disassemble level gauge(44) from body (1).



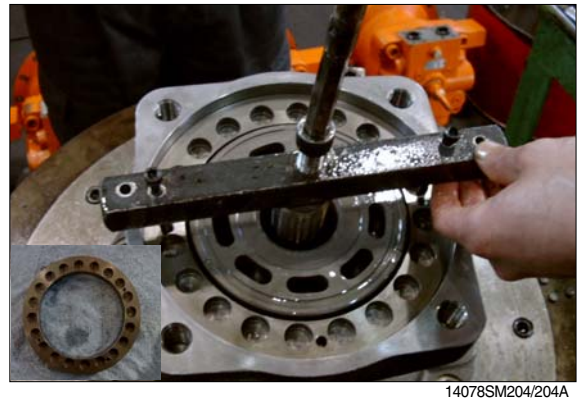
14078SM202/202A

- ③ Hang rear cover(21) on hoist, unloose wrench bolt(27) and disassemble from body(1).



14078SM203/203A

- ④ Using a jig, disassemble break piston(17) from body(1).



- ⑤ Disassemble respectively cylinder block assy, friction plate(15), plate(16) from body(1).



(2) Disassemble cylinder block assy

① sub

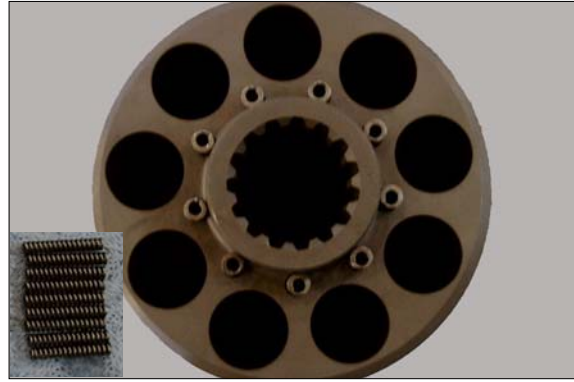
Disassemble piston assy(14), set plate (13) from cylinder block assy.



- ② Disassemble ball guide(12) from cylinder block(10).

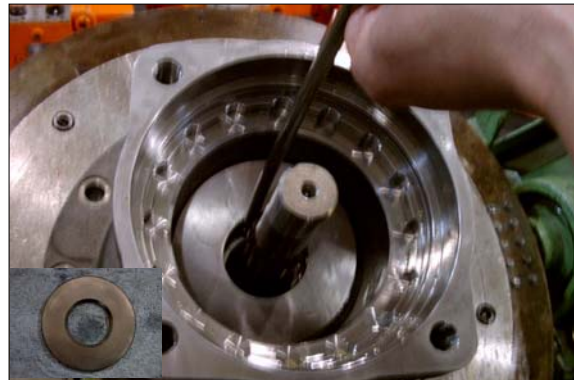


- ③ Disassemble spring(11) from cylinder block(10).



14078SM208/208A

- ④ Disassemble shoe plate(9) from body(1).



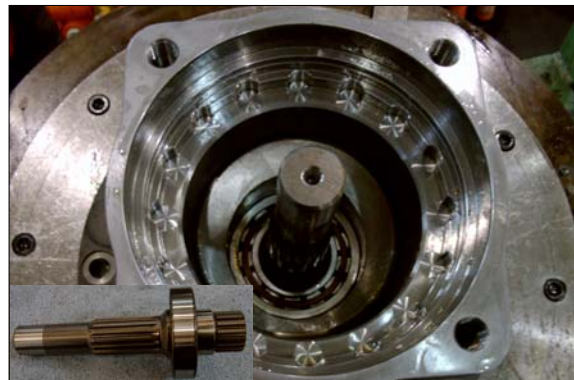
14078SM209/209A

- ⑤ Using a plier jig, disassemble snap ring (4) from shaft(5).



14078SM210/210A

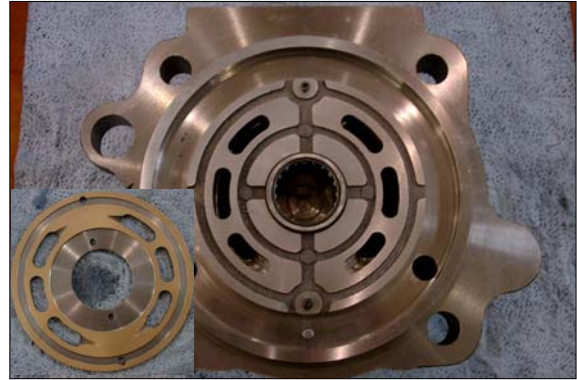
- ⑥ Disassemble shaft assy from body(1).



14078SM211/211A

(3) Disassemble rear cover assy sub

- ① Disassemble pin(8, 23), valve plate(24) from rear cover(21).



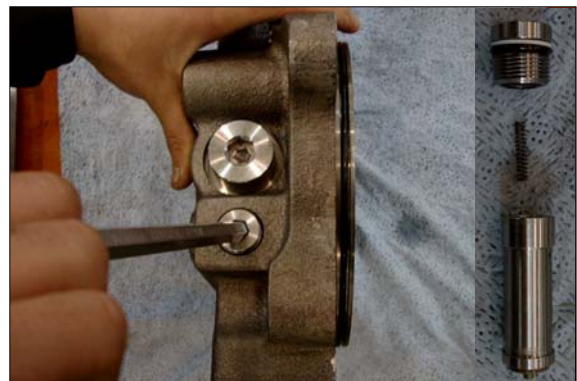
14078SM212/212A

- ② Using a torque wrench, disassemble relief valve assy(33) 2 set from rear cover(21).



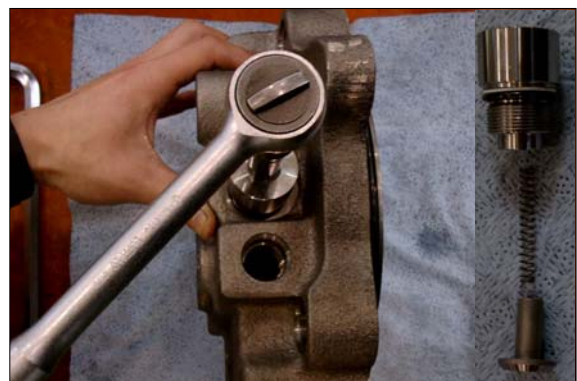
14078SM213/213A

- ③ After disassembling plug with a L-wrench from rear cover(21), disassemble respectively back up ring, O-ring, O-ring, spring, anti-inversion valve assy(34)



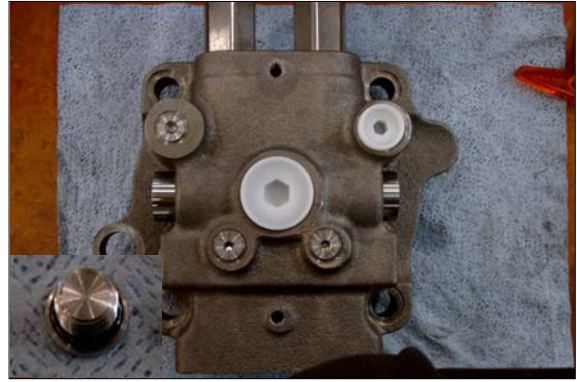
14078SM214/214A

- ④ Disassemble make up check valve assy with a torque wrench from rear cover(21).



14078SM215/215A

- ⑤ Disassemble respectively plug(37, 40, 41), with a L-wrench from rear cover(21).



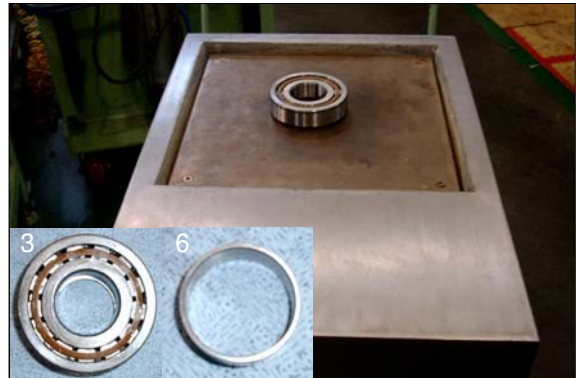
14078SM216/216A

3) ASSEMBLING

(1) Assemble the sub of a turning axles

- ① Put roller bearing(3), bushing(6) on preheater and provide heat to inner wheel(compressing temp : 290°C for 2minutes)

- Roller bearing × 1EA
- Bushing × 1EA



14078SM217/217A/B

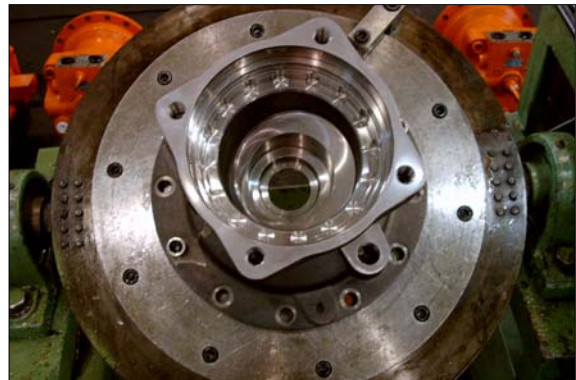
- ② After assembling and compressing preheated roller bearing(3), bushing(6) into shaft(5).

- Stop ring × 1EA
- Shaft × 1EA



14078SM218/218A/B

- ③ Put body(1) on a assembling jig, fix it with bolts to prohibit moving.

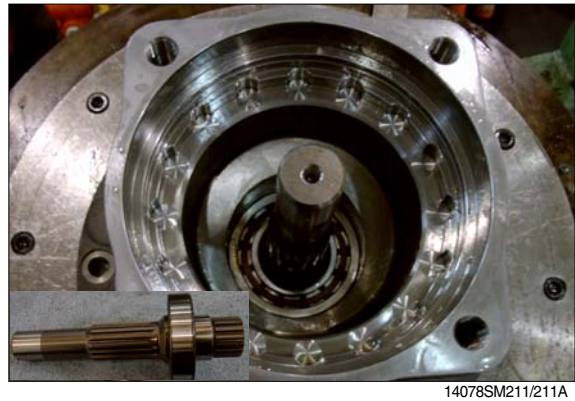


14078SM219

- ④ Using a compressing tool and steel stick, assemble oil seal(2) into body(1).
· Oil seal × 1EA



- ⑤ Insert above shaft sub into body(1) and assemble it with a steel stick.



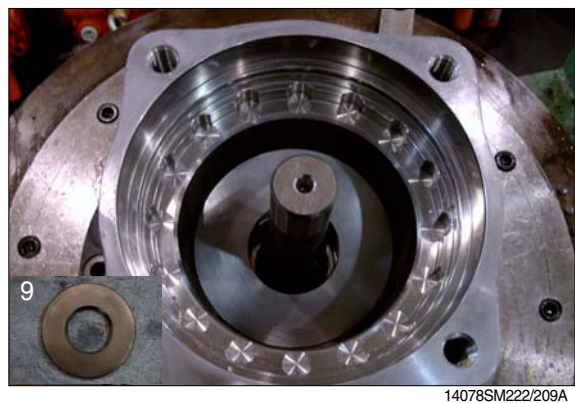
- ⑥ Fix snap ring(4) to shaft with a plier jig.

· Snap ring × 1EA



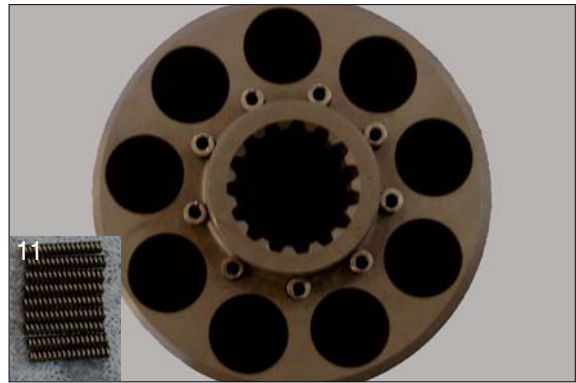
- ⑦ Spread grease on shoe plate(9) and assemble on the body.

· Shoe plate × 1EA

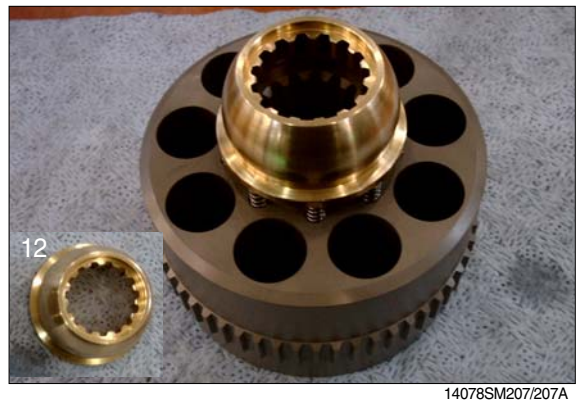


**(2) Assemble the sub of cylinder block
assy**

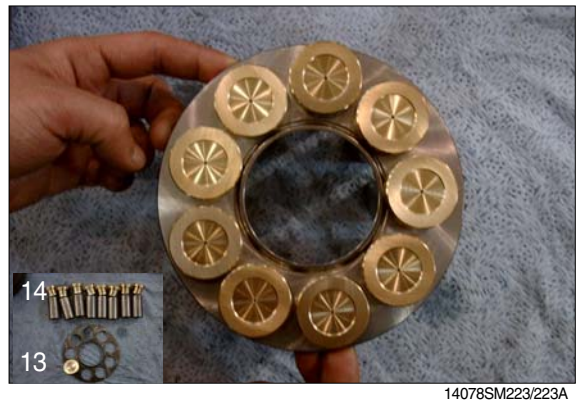
- ① Assemble spring(11) 9 set into cylinder
block(10).
· Spring × 9EA



- ② Assemble ball guide(12) into cylinder.
· Ball guide × 1EA



- ③ Assemble piston assy(14) 9 set into set
plate(13).
· Piston assy × 9EA
· SET plate × 1EA



- ④ Assemble above item ② and ③.

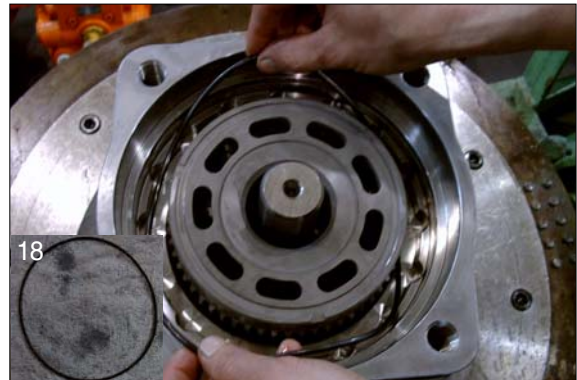


- ⑤ Assemble cylinder block assy into body (1).



14078SM225

- ⑥ Assemble O-ring(18) into body(1).
· O-ring \times 1EA



14078SM226/226A

- ⑦ Assemble 3 set of plate(16), friction plate(15) respectively into body.
· Plate \times 3EA
· Friction plate \times 3EA



14078SM227/205A

- ⑧ Assemble O-ring(19) into break piston (17).
· O-ring \times 2EA



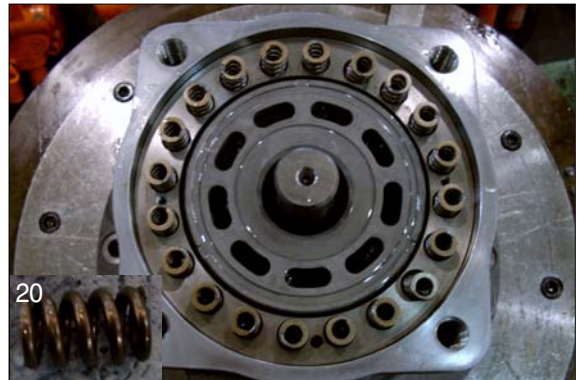
14078SM228/226A

- ⑨ Insert break piston assy into body(1) and compress it with a jig and hammer.



14078SM229/229A

- ⑩ Assemble spring(20)(20EA) into break piston(17).
 · Spring × 20EA



14078SM230/230A

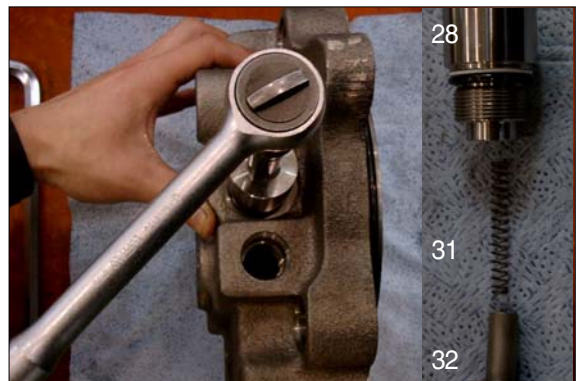
(3) Assemble the sub of rear cover assy sub

- ① Assemble the sub of make up check valve assy.
 Assemble O-ring(30), back up ring(29) into plug(28) with a O-ring assembling jig.
 · Plug × 1EA
 · Back up ring × 1EA
 · O-ring × 1EA



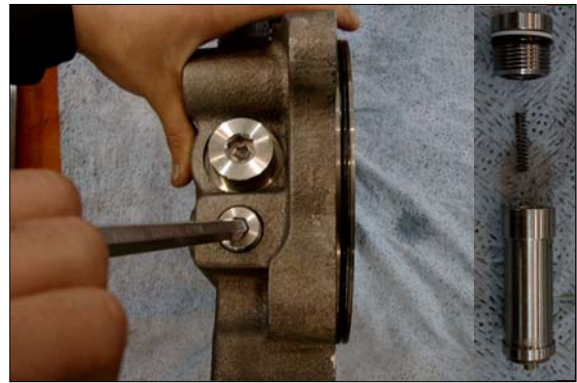
14078SM231/231A/B

- ② Assemble respectively make up check valve assy spring(31), check(32), plug(28) into rear cover(21) after then screw it torque wrench.
 · Make up check sub × 2set
 · Spring × 2EA
 · Check × 3EA



14078SM215/215A

- ③ Assemble respectively plug(47), back up ring, O-ring, O-ring, spring, anti-rotating valve assy(34) into rear cover(21).
(Bilateral symmetry assembling)
- Anti-Inversion v/v assy × 2set
 - O-ring(P12) × 2EA
 - O-ring(P18) × 2EA
 - Back up ring(P18) × 2EA



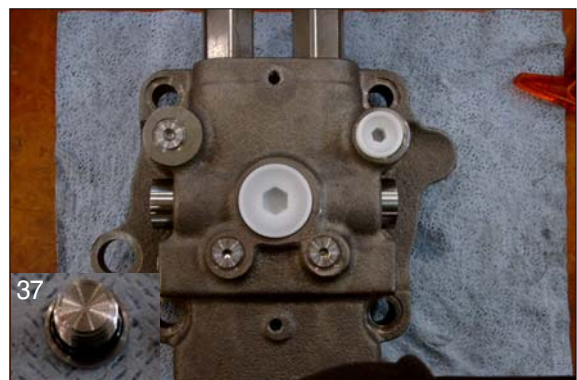
14078SM214/214A

- ④ Assemble relief valve assy(33) 2set into rear cover(21) with a torque wrench.
(Bilateral symmetry assembling)



14078SM213/213A

- ⑤ Assemble plug(37), plug(40, 41) into rear cover(21) with a L-wrench.
* Plug × 3EA(PF1/4)



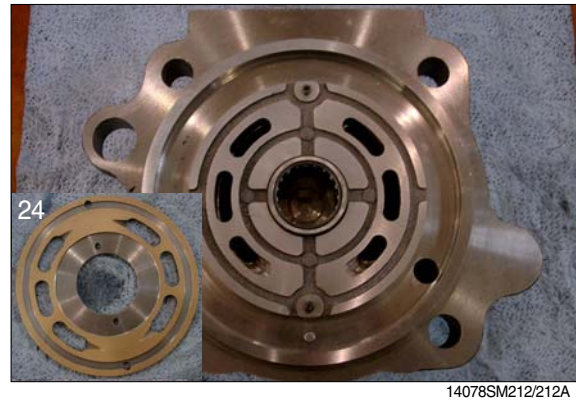
14078SM216/216A

- ⑥ After assembling needle bearing(22) into rear cover(21), with a hammer assemble pin(8, 23).
* Pin × 1EA
* Pin × 2EA



14078SM212

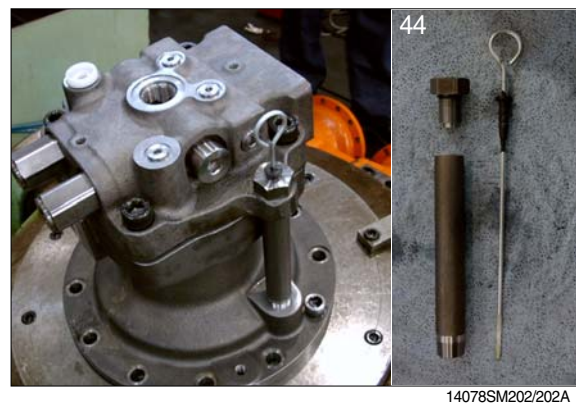
- ⑦ Spreading grease on valve plate(24),
assemble into rear cover(21).
· Valve plate × 1EA



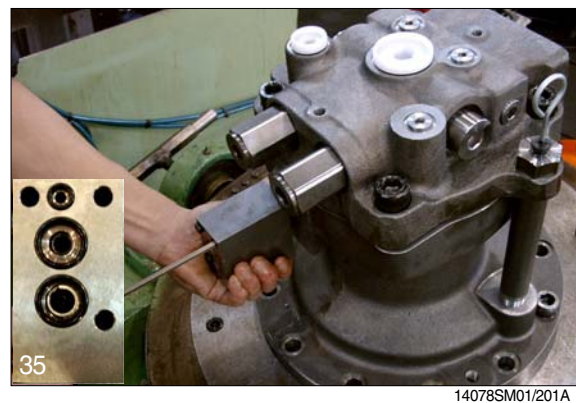
- ⑧ Lift up rear cover assy on body(1) by a crane and assemble it with a wrench bolt(27).



- ⑨ Assemble level gauge(44) into body(1).



- ⑩ Assemble time delay valve assy(35) into rear cover(21) with a wrench bolt(36).



(4) Air pressing test

Be sure of leakage, after press air into assembled motor



14078SM232

(5) Leakage check

After cleaning motor by color check No.1, paint No.3 and be sure of leakage.



14078SM233/233A

(6) Mount test bench

Mounting motor test bench, test the availability of each part.



220078SM14

3. REMOVAL AND INSTALL OF REDUCTION GEAR

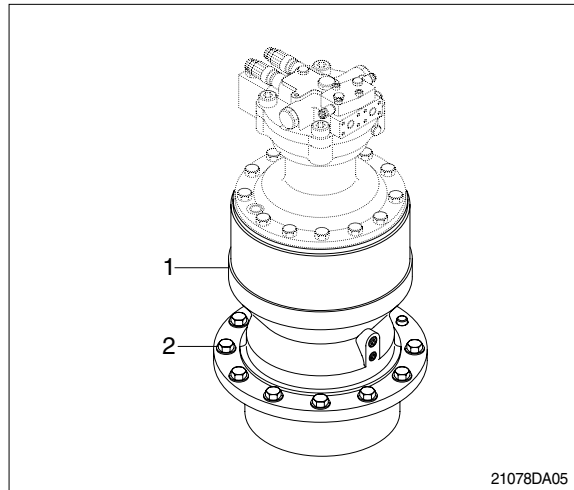
1) REMOVAL

- (1) Remove the swing motor assembly.
For details, see **removal of swing motor assembly**.
- (2) Sling reduction gear assembly(1) and remove mounting bolts(2).
- (3) Remove the reduction gear assembly.
 - Reduction gear device weight : 180kg
(396lb)



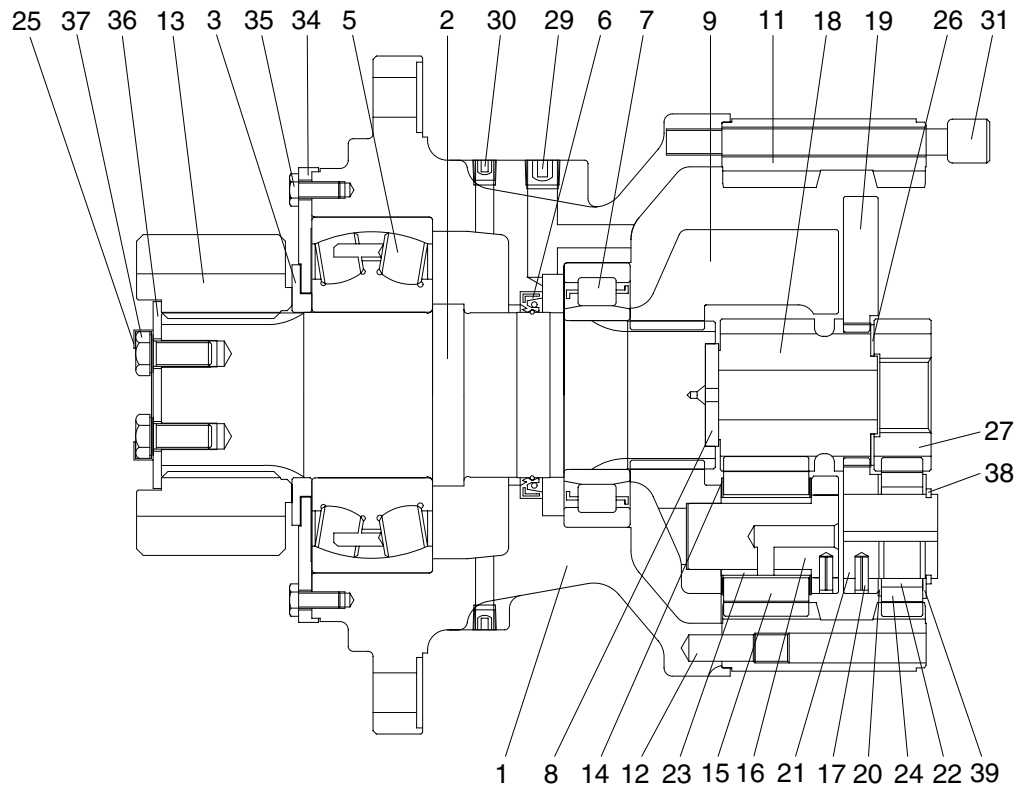
2) INSTALL

- (1) Carry out installation in the reverse order to removal.
 - Tightening torque : 49.2~66.6kgf · m
(356~481lbf · ft)



4. DISASSEMBLY AND ASSEMBLY OF REDUCTION GEAR

1) STRUCTURE



2107V2SM03

| | | | | | |
|----|----------------|----|---------------|----|--------------|
| 1 | Casing | 15 | Planet gear 2 | 26 | Side plate 3 |
| 2 | Drive shaft | 16 | Pin & bushing | 27 | Sun gear 1 |
| 3 | Spacer | 17 | Spring pin | 29 | Plug |
| 5 | Roller bearing | 18 | Sun gear 2 | 30 | Plug |
| 6 | Oil seal | 19 | Carrier 1 | 31 | Socket bolt |
| 7 | Roller bearing | 20 | Side plate 1 | 34 | Cover plate |
| 8 | Thrust plate | 21 | Pin 1 | 35 | Hexagon bolt |
| 9 | Carrier 2 | 22 | Needle cage | 36 | Lock plate |
| 11 | Ring gear | 23 | Bushing 2 | 37 | Hexagon bolt |
| 12 | Knock pin | 24 | Planet gear 1 | 38 | Stop ring |
| 13 | Pinion gear | 25 | Lock washer | 39 | Side plate 2 |
| 14 | Thrust washer | | | | |

2) DISASSEMBLY

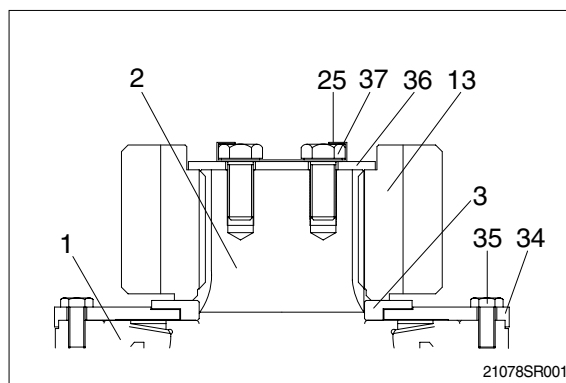
(1) Spread off the 4 corners of lock washer (25) with a tool.

※ Do not reuse lock washer(25).

Loosen the bolts(37) and then remove lock washer(25) and lock plate (36) from the pinion gear(13).

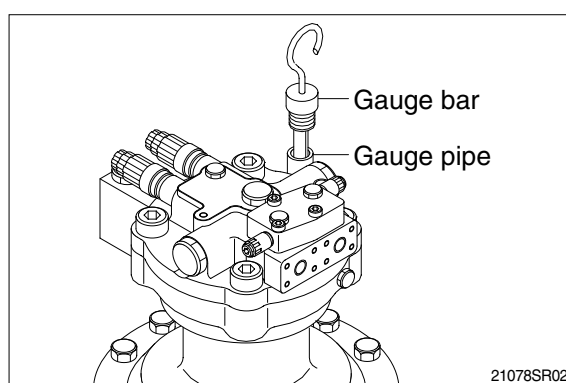
Remove pinion gear(13) and spacer(3) from the drive shaft(2).

Remove cover plate(34) from the casing (1) by loosening the hexagon bolts (35).

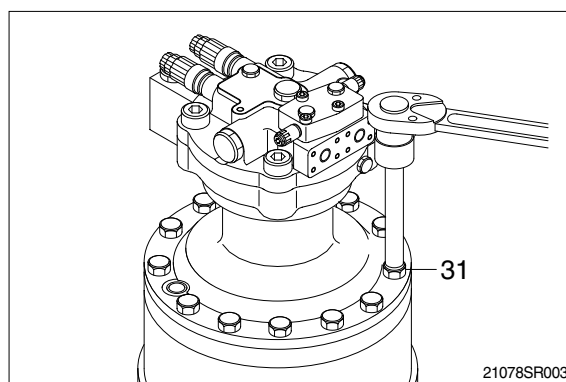


(2) Remove gauge bar and gauge pipe from the swing motor casing.

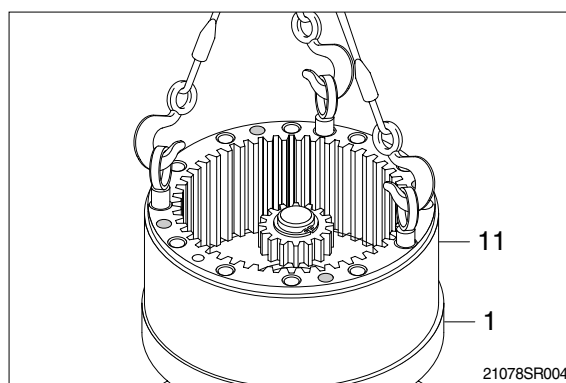
※ Pour the gear oil out of reduction gear into the clean bowl to check out the friction decrease.



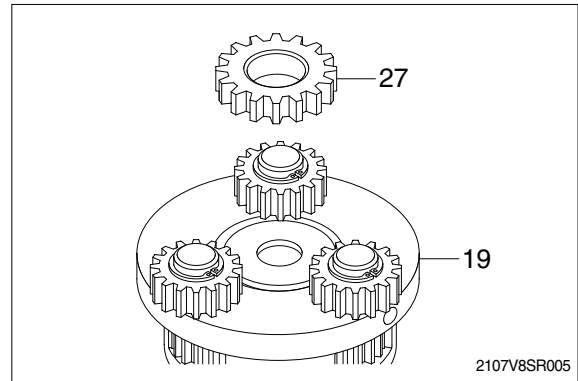
(3) Loosen the socket bolts(31) to separate swing motor from reduction gear.



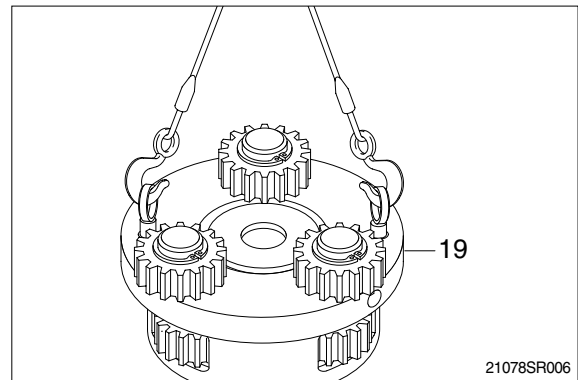
(4) Tighten 3 M16 eye bolts to the ring gear (11) and then lift the ring gear(11) out of the casing(1).



(5) Remove sun gear1 (27).

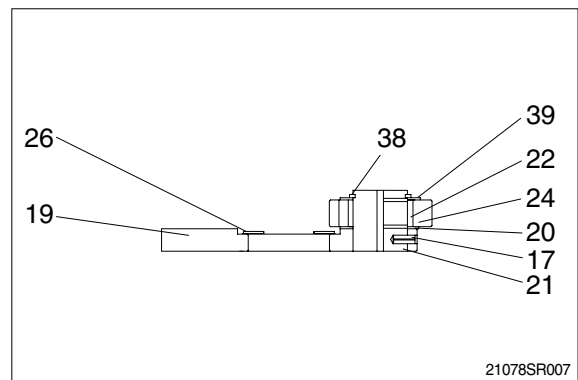


(6) Tighten two M10 eye bolts to carrier1(19) and lift up and remove carrier1(19) as subassembly.

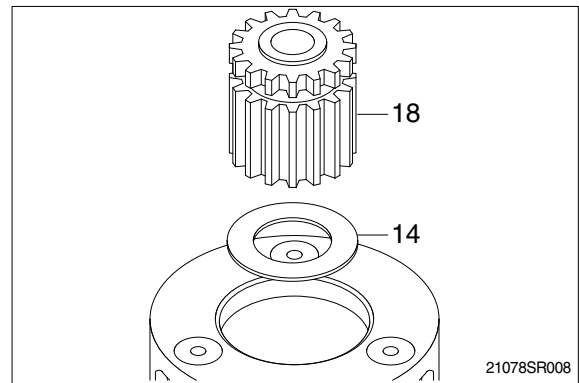


(7) Disassembling carrier1(19) assembly.

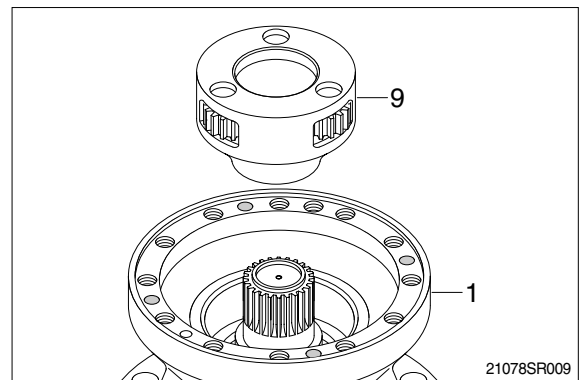
- ① Remove stop ring(38).
- ② Remove side plate2(39), planet gear1 (24), needle cage(22), side plate1(20) and side plate3(26) from the carrier.
- ③ Using M8 solid drill, crush spring pin(17) so that the pin1(21) can be removed by hammering.
- ④ Remove side plate3(26) from carrier1(19).
 - ※ Do not reuse spring pin(17).
 - ※ Do not remove pin1(21), carrier1(19) and spring pin(17) but in case of replacement.
 - ※ Put matching marks on the planet gear1 (24) and the pin1(21) for easy reassembly.



- (8) Remove sun gear2(18) and thrust washer (14).



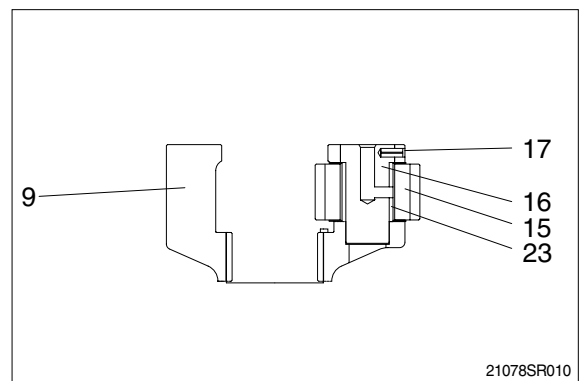
- (9) Remove carrier2(9) assembly from casing (1).



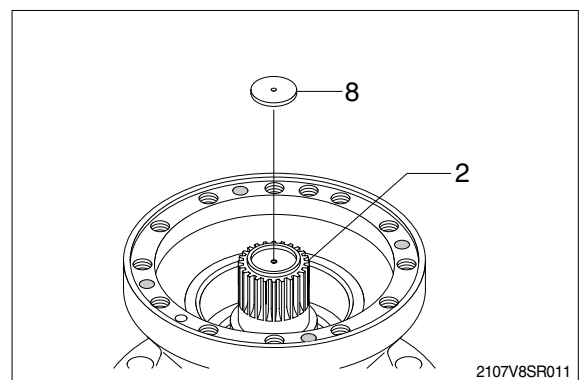
- (10) Disassembling carrier2(9) assembly

- ① Using M8 solid drill, crush spring pin(17) so that the pin & bushing(16) can be removed.
 - ② Do not reuse spring pin(17).
Remove pin & bushing(16), planet gear2(15) and bush2(23) from the carrier2(9).
- ※ Put matching marks on the planet gear2 (15) and the pin & bushing(16) for easy reassembly.

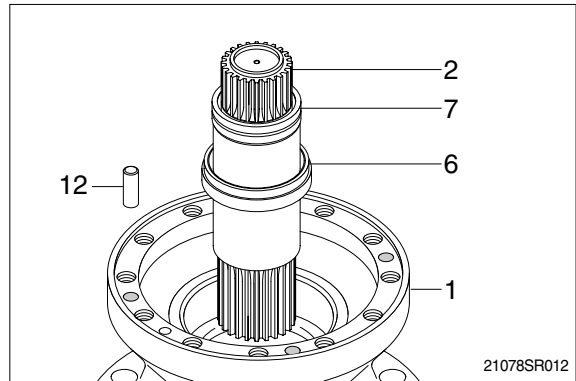
Do not disassemble pin & bushing(16), carrier2(9) and spring pin(17) but in case of replacement.



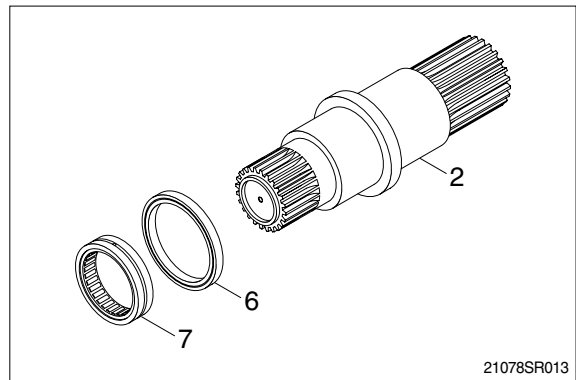
- (11) Remove thrust plate(8) from the drive shaft(2).



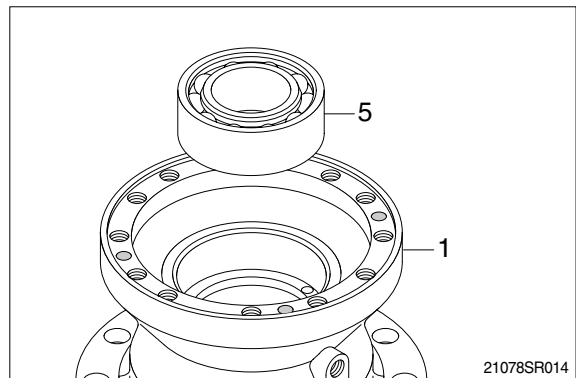
- (12) Remove drive shaft(2) with roller bearing(7) and oil seal(6) assembled.
Remove knock pin(12) from the casing(1).



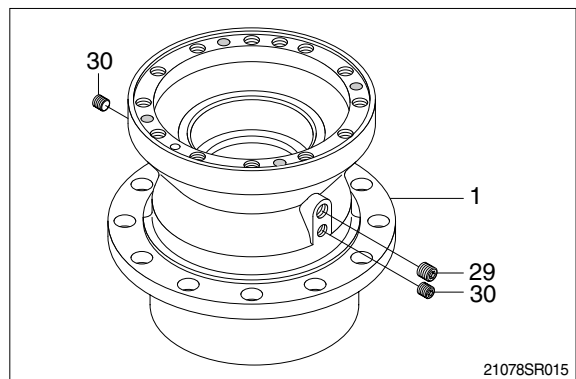
- (13) Remove roller bearing(7) and oil seal(6) from the drive shaft(2).
※ Do not reuse oil seal(6) once removed.



- (14) Using the bearing disassembly tool, remove roller bearing(5).

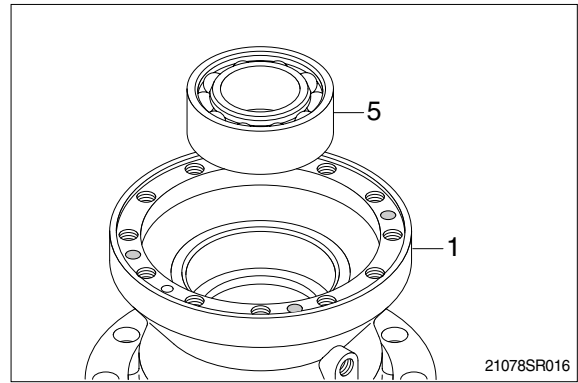


- (15) Remove plugs(29, 30) from the casing(1).

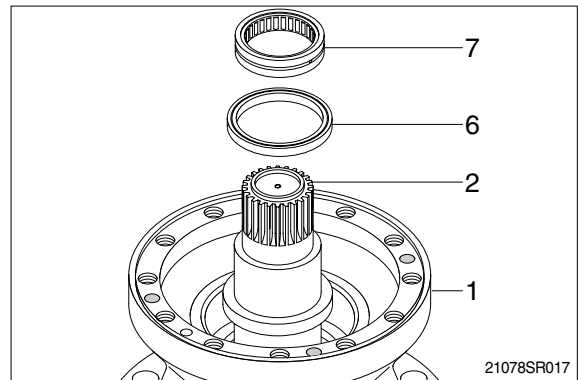


3) ASSEMBLY

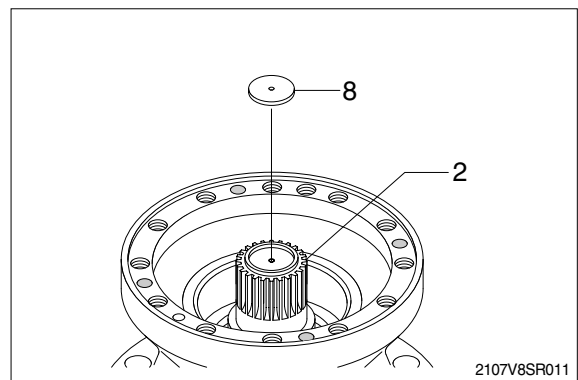
- (1) Assemble roller bearing(5) inside the casing(1).



- (2) Assemble the drive shaft(2) into the casing(1) and then install oil seal(6) and roller bearing(7).

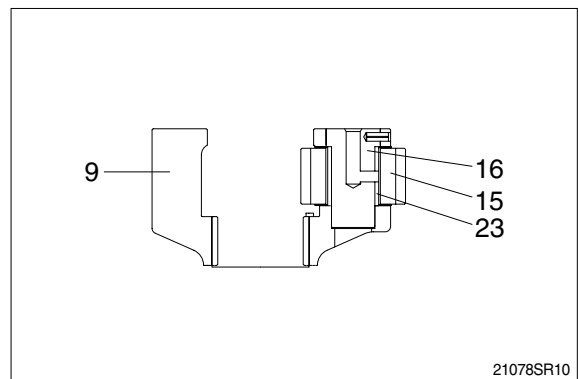


- (3) Install thrust plate(8) on top of drive shaft(2).

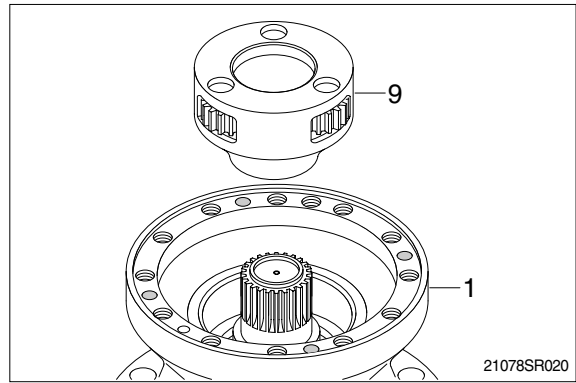


- (4) Assembling carrier2(9) assembly.

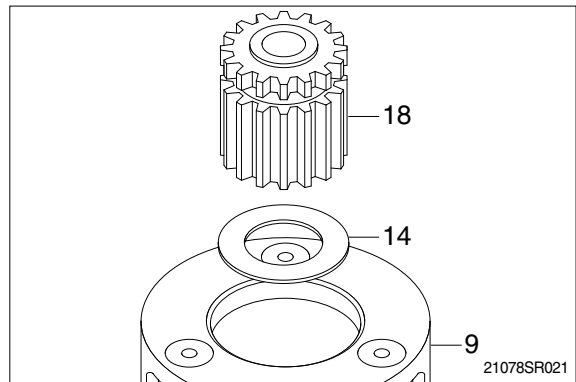
- ① Install thrust washer(14) inside the carrier2 (9).
 - ② Install bushing2(23) inside the planet gear2 (15) and then assemble them to the carrier2(9).
 - ③ Assemble the pin & bushing(16) to the carrier2(9) and then press the spring pin(17) by hammering.
 - ④ Punch 2 points of the spring pin(17) lip.
- ※ Take care not to mistake the matching marks of each part.



- (5) Assemble carrier2(9) assembly correctly to the drive shaft(2).



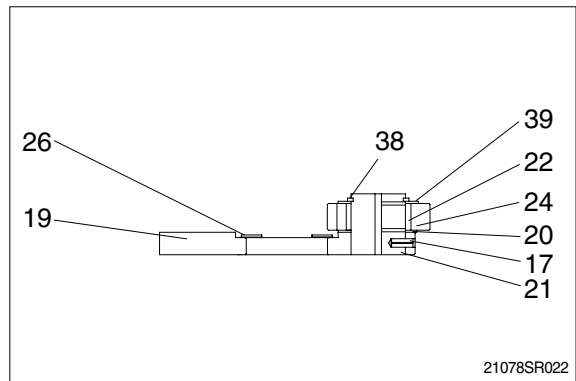
- (6) Assemble sun gear2(18) and thrust washer(14) to the center of the carrier2(9) assembly.



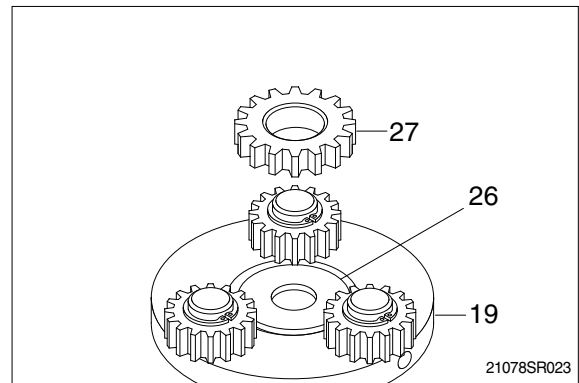
- (7) Assembling carrier1(19) assembly.

- ① Assemble the pin1(21) to the carrier1(19) and then press the spring pin(17) by hammering.
- ② Punch 2 points of the spring pin's(17) lip.
- ③ Install side plate3(26) onto the center of carrier1(19).
- ④ Install needle cage(22) into the planet gear1(24).
- ⑤ Assemble side plate(20), planet gear1 (24), side plate2(39) and then stop ring (38) to the pin1(21).

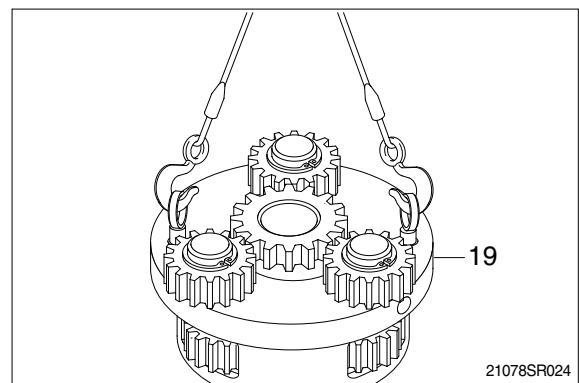
※ Take care not to mistake the matching marks of each part.



- (8) Install sun gear(27) onto the side plate3 (26).



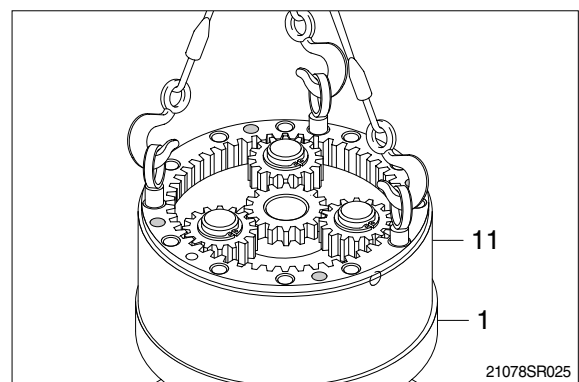
- (9) Assemble carrier1(19) assembly onto the carrier2 assembly.



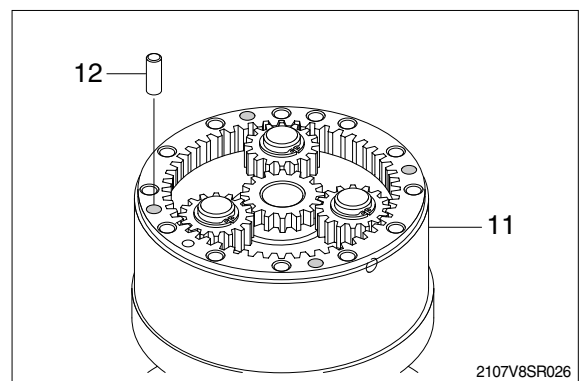
- (10) Apply loctite to the tapped holes of casing (1).

- (11) Tighten 3 M16 eye bolts to the ring gear(11) and lift up and then assemble it onto the casing(1).

※ Don't fail to coincide the knock pin(12) holes.



- (12) Hammer 4 knock pins(12) around the ring gear(11).

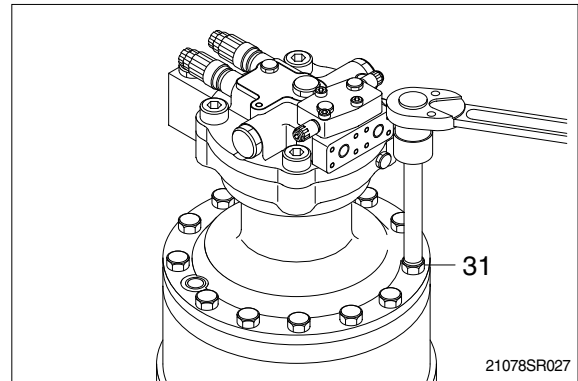


(13) Apply loctite to the tapped holes of the ring gear(11) and then mount swing motor onto the ring gear(11).

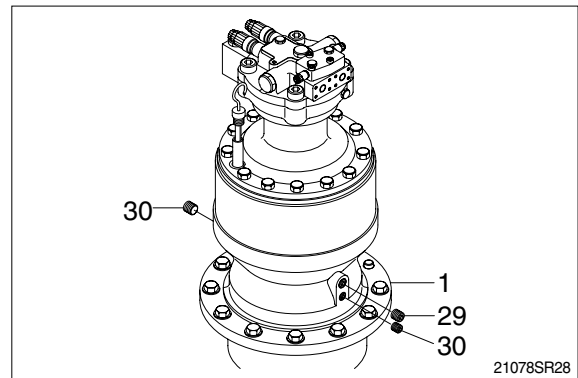
※ Don't fail to coincide the gauge bar(33) hole.

(14) Tighten socket bolts(31) around the swing motor assembly.

• Tightening torque : 24kgf · m(173lbf · ft)



(15) Assemble plugs(29, 30).



(16) Turn the swing motor assembly upside down and assemble cover plate(34) by tightening the hexagon bolts(35).

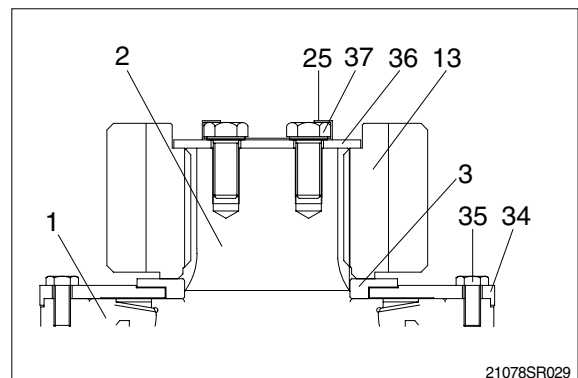
Install spacer(3) and pinion gear(13) to the drive shaft(2).

Assemble lock plate(36) on the pinion gear(13).

Assemble 2 lock washers(25) on the lock plate(36) with their 2 hole coincided individually to the tapped holes of drive shaft(2).

Tighten hexagon bolts(37) to the drive shaft(2) and then fold all the lock washer(25) corners over the hexagon bolts(37).

• Tightening torque : 24kgf · m(173lbf · ft)



(17) Inject oil into the reduction gear.

GROUP 5 SWING DEVICE (TYPE 2 & TYPE 3)

1. REMOVAL AND INSTALL OF MOTOR

1) REMOVAL

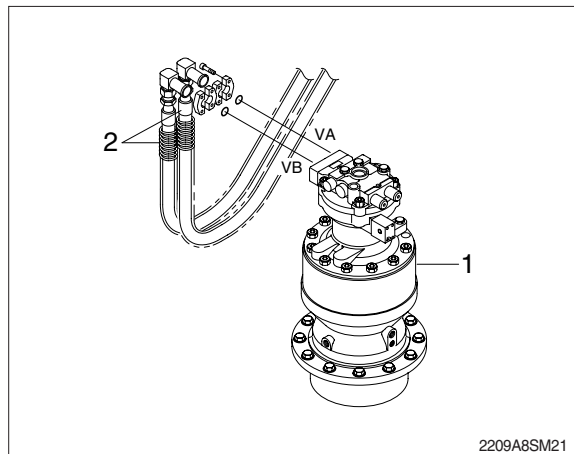
- (1) Lower the work equipment to the ground and stop the engine.
- (2) Operate the control levers and pedals several times to release the remaining pressure in the hydraulic piping.
- (3) Loosen the breather slowly to release the pressure inside the hydraulic tank.

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

※ When pipes and hoses are disconnected, the oil inside the piping will flow out, so catch it in oil pan.

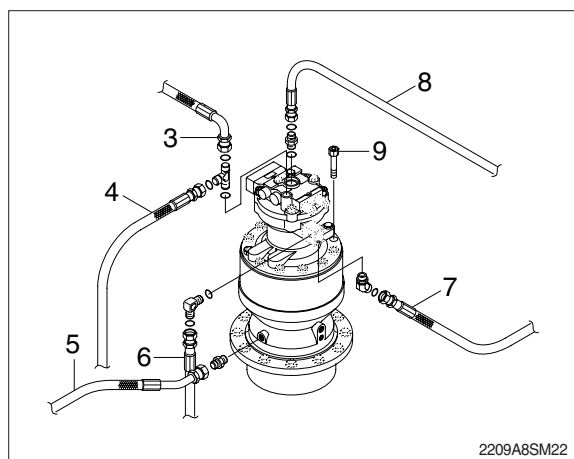
- (4) Disconnect hose assembly (2).
- (5) Disconnect pilot line hoses (3, 4, 5, 6, 7, 8).
- (6) Sling the swing motor assembly (1) and remove the swing motor mounting socket bolts (9).
 - Motor device weight : 61 kg (135 lb)

- (7) Remove the swing motor assembly.
 - ※ When removing the swing motor assembly, check that all the piping have been disconnected.



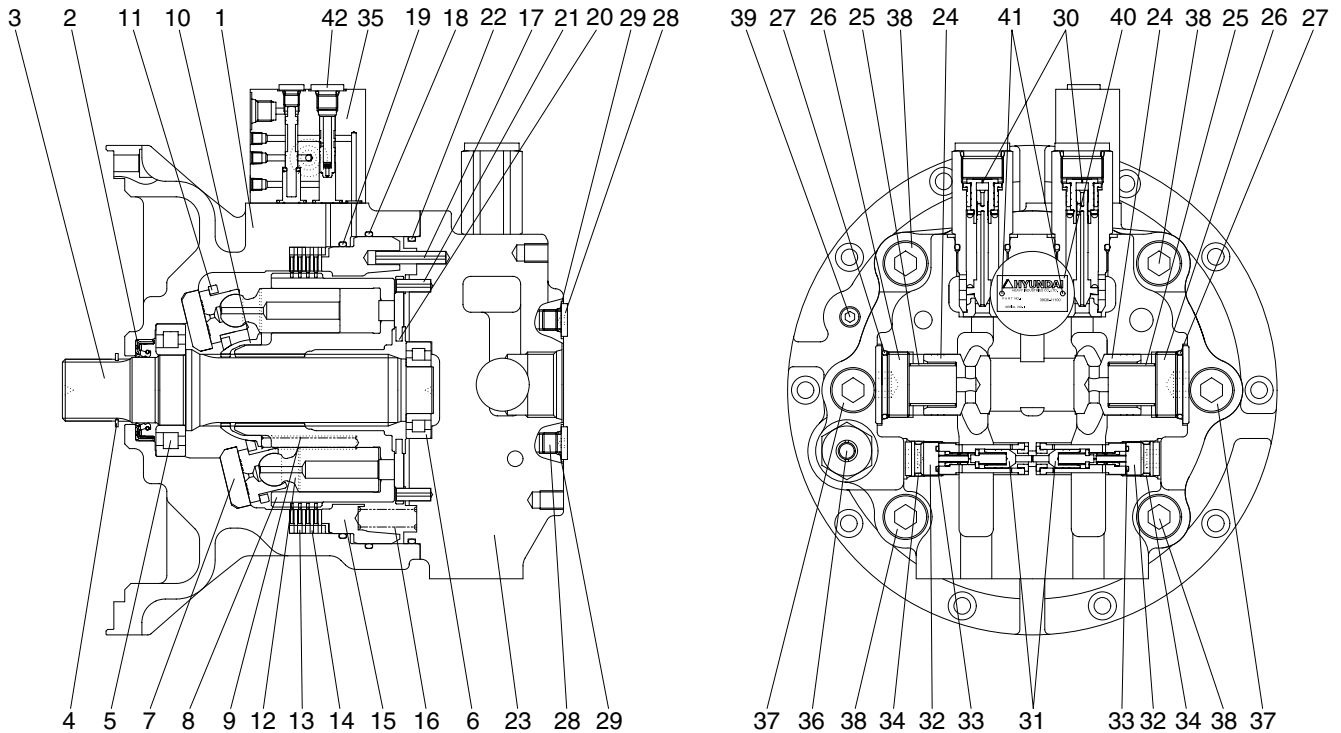
2) INSTALL

- (1) Carry out installation in the reverse order to removal.
- (2) Bleed the air from the swing motor.
 - ① Remove the air vent plug.
 - ② Pour in hydraulic oil until it overflows from the port.
 - ③ Tighten plug lightly.
 - ④ Start the engine, run at low idling and check oil come out from plug.
 - ⑤ Tighten plug fully.
- (3) Confirm the hydraulic oil level and check the hydraulic oil leak or not.



2. DISASSEMBLY AND ASSEMBLY OF SWING MOTOR

1) STRUCTURE



2209A8SM23

| | | | | | |
|----|----------------|----|----------------|----|-------------------------|
| 1 | Casing | 15 | Parking piston | 29 | O-ring |
| 2 | Oil seal | 16 | Spring | 30 | Relief valve assy |
| 3 | Shaft | 17 | Spring pin | 31 | Reactionless valve assy |
| 4 | Snap ring | 18 | O-ring | 32 | Plug |
| 5 | Roller bearing | 19 | O-ring | 33 | O-ring |
| 6 | Needle bearing | 20 | Valve plate | 34 | O-ring |
| 7 | Swash plate | 21 | Spring pin | 35 | Time delay valve assy |
| 8 | Cylinder block | 22 | O-ring | 36 | Level gauge |
| 9 | Spring | 23 | Valve casing | 37 | Socket bolt |
| 10 | Ball guide | 24 | Check valve | 38 | Socket bolt |
| 11 | Retainer plate | 25 | Spring | 39 | Plug |
| 12 | Piston assy | 26 | Plug | 40 | Name plate |
| 13 | Friction plate | 27 | O-ring | 41 | Rivet |
| 14 | Separate plate | 28 | Plug | 42 | Socket bolt |

2) DISASSEMBLY

(1) Disassemble drive shaft

- ① Unloosing socket bolt (time delay valve, 42) and disassemble time delay valve assy (35) from casing (1).



2209A8SM51

- ② Disassemble level gauge (36) from casing (1).



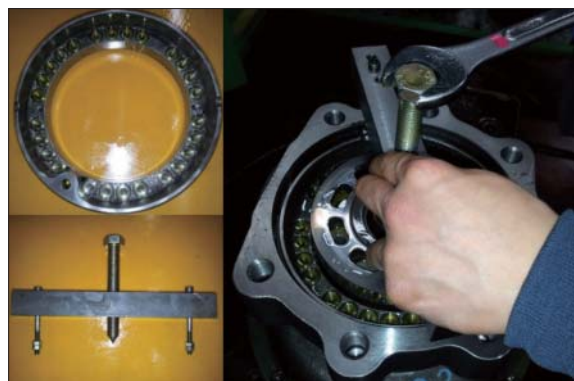
2209A8SM52

- ③ Hang valve casing (23) on hoist, unloose socket bolt (37, 38) and disassemble from casing (1).



2209A8SM53

- ④ Disassemble spring (16) and using a jig, disassemble parking piston (15) from casing (1).



2209A8SM54

- ⑤ Disassemble respectively cylinder block sub (8), friction plate (13), separate plate (14) from casing (1).



2209A8SM55

- ⑥ Disassemble swash plate (7) from casing (1).



2209A8SM56

- ⑦ Using a plier jig, disassemble snap ring (4) from casing (1).



2209A8SM57

- ⑧ Disassemble shaft assy (3), oil seal (2) and O-ring (18, 22) from casing (1).



2209A8SM58

(2) Disassemble cylinder block sub

- ① Disassemble piston assy (12) from cylinder block (8).



2209A8SM59

- ② Disassemble ball guide (10) and spring (cylinder block, 9) from cylinder block (8).
 - Ball guide × 1EA
 - Spring × 9EA



2209A8SM60

(3) Disassemble valve casing sub

- ① Disassemble spring pin (17, 21), valve plate (20), O-ring (22) from valve casing (23).



2209A8SM61

- ② Using a torque wrench, disassemble relief valve (30) from valve casing (23).



2209A8SM62

- ③ Using a torque wrench, disassemble plug (32) from valve casing (23) and disassemble O-ring (33, 34) and reaction-less valve assy (31).



2209A8SM63

- ④ Using a torque wrench, disassemble check valve (24) from valve casing (23).



2209A8SM64

- ⑤ Disassemble plug (28), O-ring (29) from valve casing (23).



2209A8SM65

3) ASSEMBLING

(1) Assemble shaft sub

- ① Put roller bearing (3) on preheater and provide heat to inner race.
(Temperature in conveyor : 120°C for 3~5 minutes)



2209A8SM66

- ② Using a robot machine, assemble and press preheated roller bearing (3) into shaft (5).



2209A8SM67

(2) Assemble cylinder block sub

- ① Assemble 9 springs (cylinder block, 9) into cylinder block (8).
 - Spring × 9EA



2209A8SM68

- ② Assemble ball guide (10) into cylinder block (8).
 - Ball guide × 1EA



2209A8SM69

③ Assemble 9 piston assy (12) into retainer plate (11).

- Piston assy × 9EA
- Retainer plate × 1EA



2209A8SM70

④ Assemble parts of procedure ② and ③.



2209A8SM71

(3) Assemble valve casing sub

① Assemble make up check valve sub

Assemble check valve (24), O-ring (27), plug (26) in that order and then screw it into torque wrench.

- Make up check valve × 2EA
- Spring × 2EA
- Plug × 2EA
- O-ring × 2EA



2209A8SM72

② Assemble reactionless valve assy

Assemble reactionless valve assy (31), plug (32), O-ring (33, 34) in that order and then screw it into torque wrench.

- Reactionless valve assy (31) × 2EA
- Plug (32) × 2EA
- O-ring (33, 34) × 2EA



2209A8SM73

- ③ Using a torque wrench, assemble relief valve (30) 2 sets into valve casing (23).
- Relief valve (30) × 2EA



- ④ Assemble plug (28) and O-ring (27) into valve casing (23).
- Plug (28) × 3EA
 - O-ring (27) × 3EA



- ⑤ Assemble needle bearing (6) into valve casing (23) and assemble spring pin (17, 21) into valve casing (23).
- Needle bearing (6) × 1EA
 - Spring pin (17, 21) × 1EA



- ⑥ Apply some grease valve plate (20) and assemble it into valve casing (23).



(4) Assemble drive shaft sub

- ① Using a jig, assemble oil sealing (2) into casing (1).



2209A8SM78

- ② Fit shaft sub (shaft+roller bearing) into casing (1).



2209A8SM79

- ③ Using a plier jig, assemble snap ring (4) to shaft (3).
• Snap ring × 1EA



2209A8SM80

- ④ Apply some grease swash plate (7) and assemble it into casing (1).
• Swash plate × 1EA



2209A8SM81

⑤ Insert O-ring (18, 19) into casing (1).

- O-ring (18) × 1EA
- O-ring (19) × 1EA



2209A8SM82

⑥ Assemble cylinder block (8) into casing (1).



2209A8SM83

⑦ Assemble separate plate (14) and friction plate (13) 4 sets into casing (1) and fit parking piston (15) into casing (1) by a jig or a press.

- Separate plate × 4EA
- Friction plate × 4EA
- Parking piston × 1EA



2209A8SM84

⑧ Assemble spring (parking piston, 16) into parking piston (15).

- Spring × 26EA



2209A8SM85

- ⑨ Lift up valve casing (23) on casing (1) by a crane and assemble it with socket bolts (37, 38).



- ⑩ Assemble level gauge (36) and plug (39) into casing (1).



- ⑪ Assemble time delay valve assy (35) into valve casing (23) with socket bolt (42).
- Time delay valve × 1EA
 - Socket bolt × 3EA



⑫ **Air pressing test**

Be sure of leakage, after press air into assembled motor and put it in water for 1 minute (pressure : 2 kgf/cm²).



⑬ **Leakage check**

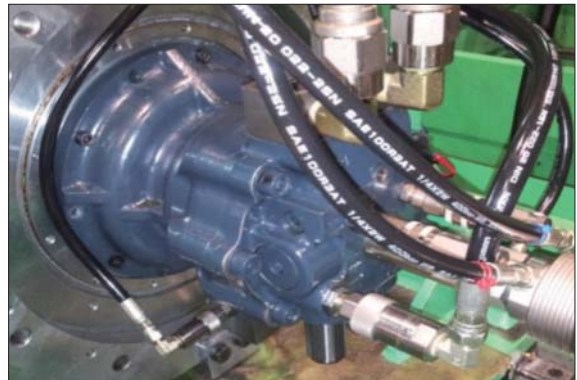
Place motor on a bench tester and after cleaning motor by color check No.1, paint No.3 and be sure of leakage.



2209A8SM90

⑭ **Mount test bench**

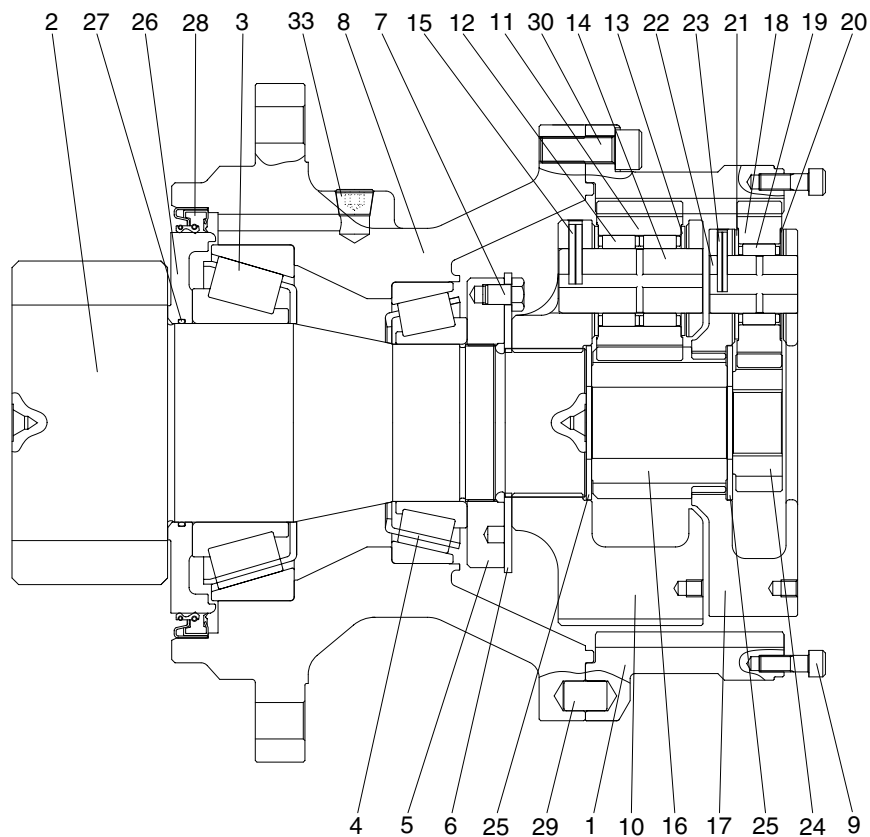
Mounting motor a test bench, test the availability of each part.



2209A8SM91

3. DISASSEMBLY AND ASSEMBLY OF REDUCTION GEAR

1) STRUCTURE



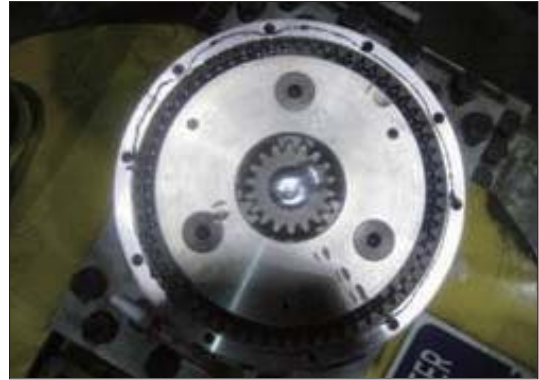
2209A2SM23

| | | | | | |
|----|--------------|----|------------------|----|-----------------|
| 1 | Ring gear | 11 | Planetary gear 2 | 21 | Thrust washer 1 |
| 2 | Drive shaft | 12 | Needle bearing 2 | 22 | Carrier pin 1 |
| 3 | Bearing | 13 | Thrust washer 2 | 23 | Spring pin |
| 4 | Bearing | 14 | Carrier pin 2 | 24 | Sun gear 1 |
| 5 | Ring nut | 15 | Spring pin | 25 | Thrust plate |
| 6 | Lock plate | 16 | Sun gear 2 | 26 | Sleeve |
| 7 | Hexagon bolt | 17 | Carrier 1 | 27 | O-ring |
| 8 | Casing | 18 | Planetary gear 1 | 29 | Parallel pin |
| 9 | Socket bolt | 19 | Needle bearing 1 | 30 | Socket bolt |
| 10 | Carrier 2 | 20 | Thrust washer 1 | 33 | Plug |

2) DISASSEMBLY

(1) Preparation

- ① The reduction gear removed from machine is usually covered with mud.
Wash out side of reduction gear and dry it.
 - ② Setting reduction gear on work stand for disassembling.
 - ③ Mark for mating
Put marks on each mating parts when disassembling so as to reassemble correctly as before.
- ▲ Take great care not to pinch your hand between parts while disassembling not let fall parts on your foot while lifting them.



2209A8SM01

(2) Disassembly

- ① Remove every "Socket bolt (M10)" that secure swing motor and reduction gear.
- ② Removing carrier sub assy & sun gear
 - a. Removing No.1 sun gear from No.1 carrier sub assy.
 - ※ Be sure maintaining it vertical with ground when disassembling No.1 sun gear.
 - b. Removing No.1 carrier sub assy screwing I-bolt to tab hole (M10) in No.1 carrier.
Lifting it gradually maintaining it vertical with ground.
 - ※ It's impossible to disassemble No.1 spring pin. If No.1 spring pin has problem, change whole No.1 carrier sub assy.



2209A8SM02



2209A8SM03

- c. Removing No.2 sun gear from No.2 carrier sub assy.
- ※ Be sure maintaining it vertical with ground when disassembling No.2 sun gear.



2209A8SM04

- d. Removing No.2 carrier sub assy screwing I-bolt to tab hole (M10) in No.2 carrier. Lifting it gradually maintaining it vertical with ground.
- ※ It's impossible to disassemble No.2 spring pin. If No.2 spring pin has problem, change whole No.2 carrier sub assy.



2209A8SM05

③ **Removing ring gear**

After unscrewing every socket bolt (M16), remove ring gear from casing.

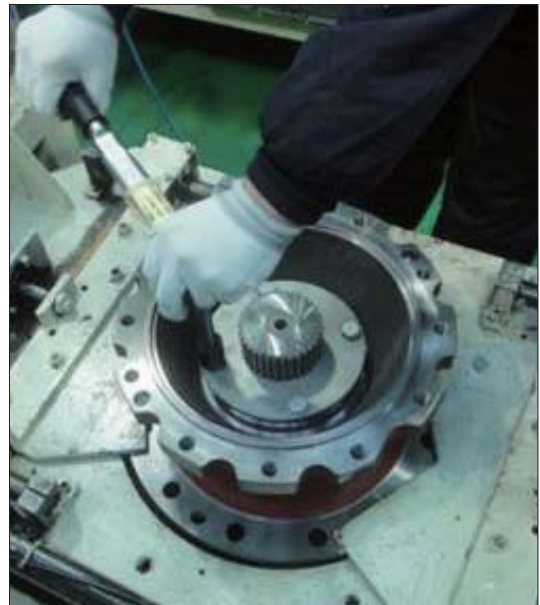
- ※ Because of liquid gaskets between ring gear and casing, put sharp punch between ring gear and casing and tapping it to remove them.



2209A8SM06

④ **Removing drive shaft sub assy**

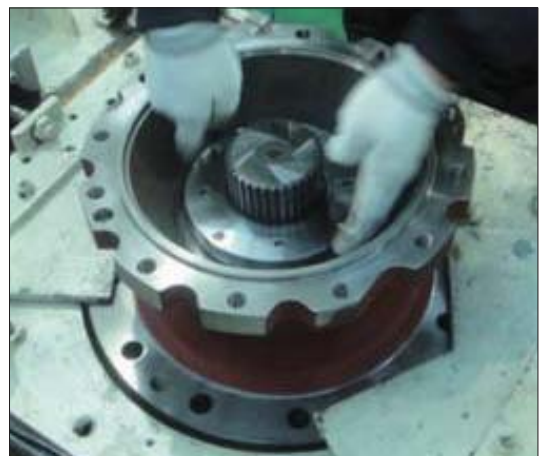
- a. Unscrew every hex head bolt (M12) to remove lock plate.



2209A8SM07

- b. Rolling ring nut for removing them from drive shaft sub assy.

- ※ Use special tool to roll ring nut to counter clockwise.



2209A8SM08

- c. Remove drive shaft sub assy from casing.
- ※ Set a rack for flange of casing, and remove drive shaft sub assy from casing by using press.



2209A8SM09

- d. Remove oil seal & taper bearing (small) from casing.
- ※ Do not re-use oil seal. It is impossible to disassemble drive shaft sub assy.



2209A8SM10



2209A8SM11

4. ASSEMBLY REDUCTION UNIT

1) GENERAL NOTES

- (1) Clean every part by kerosene and dry them in a cool and dry place.
- (2) Loctite on surface must be removed by solvent.
- (3) Check every part for any abnormal.
- (4) Each hexagon socket head bolt should be used with loctite #242 applied on its threads.
- (5) Apply gear oil slightly on each part before assembling.

▲ Take great care not to pinch your hand between parts or tools while assembling nor let fall parts on your foot while lifting them.

Inspection before assembling.

Thrust washer

- Check the seizure, abnormal wear or uneven wear.
- Check the unallowable wear.

Gear

- Check the pitting or seizure on tooth surface.
- Check the cracks on the root of tooth.

Bearing

- Rotate it by hands to check such noise or uneven rotation.

2) ASSEMBLING NO.1 CARRIER SUB ASSY

- (1) Put thrust plate firmly in No.1 carrier.
- (2) After assembling No.1 needle bearing to No.1 planetary gear, put a pair of No.1 thrust washer on both sides of bearing and install them to No.1 carrier.



2209A8SM12



2209A8SM13

- (3) Make of spring pin hole No.1 pin and No.1 carrier of spring pin hole in line, press No.1 spring pin into the holes.
Make No.1 spring pin hole head for No.1 planetary gear.



2209A8SM14

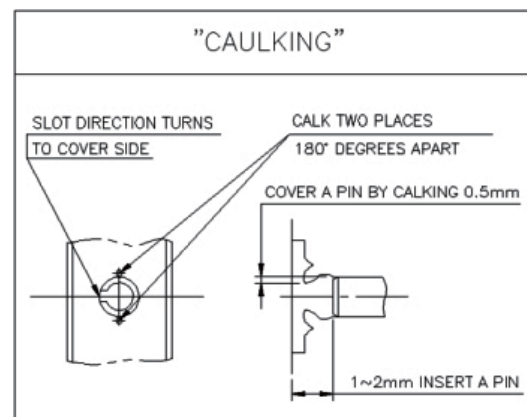
- (4) Caulk carrier holes to make No.1 spring pin settle down stably.



2209A8SM15

※ Refer to “Caulking details”

Use paint marker for marking after caulking.



2209A8SM16

2) ASSEMBLING NO.2 CARRIER SUB ASSY

(1) Put thrust plate in firmly No.2 carrier.



2209A8SM17

(2) After assembling No.2 needle bearing to No.2 planetary gear, put 2 pieces of No.2 thrust washer on both sides of bearing and install them to No.2 carrier.



2209A8SM18

(3) Align No.2 spring pin hole and No.2 carrier spring pin hole, put No.2 spring pin into the holes.
Make No.2 spring pin cutting line face to No.2 planetary gear.

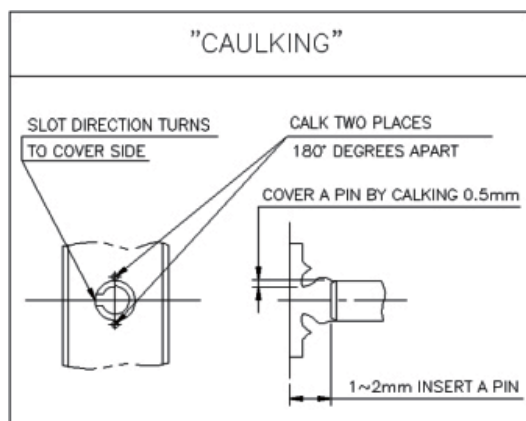


2209A8SM19

(4) Caulk carrier holes to make No.2 spring pin settle down stably.

※ Refer to "Caulking details"

Use paint marker for marking after caulking.



2209A8SM20

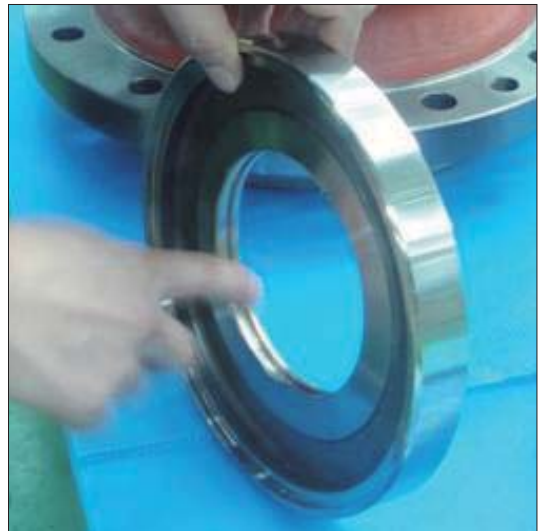
3) ASSEMBLING PINION GEAR SUB ASSY

- (1) Prepare drive shaft pinion gear vertical with ground.



2209A8SM21

- (2) Fully apply grease (albania EP02) to O-ring groove of sleeve.
※ Be sure to maintain it vertical with ground when assembling it.
- (3) Put O-ring into O-ring groove of sleeve.
Fully apply grease on O-ring.



2209A8SM22

- (4) Assemble taper bearing and sleeve into drive shaft using press jig.
Use special jig for pressing. Leave no space between sleeve and taper bearing.



2209A8SM23



2209A8SM24

4) ASSEMBLING BEARING CUP & OIL SEAL (PRESSING)

- (1) Put top, bottom bearing cup into casing.
Use special jig for pressing. Pay attention to foreign materials while assembling bearing cup.
- ※ Flip over casing to assemble oil seal.



2209A8SM25



2209A8SM26

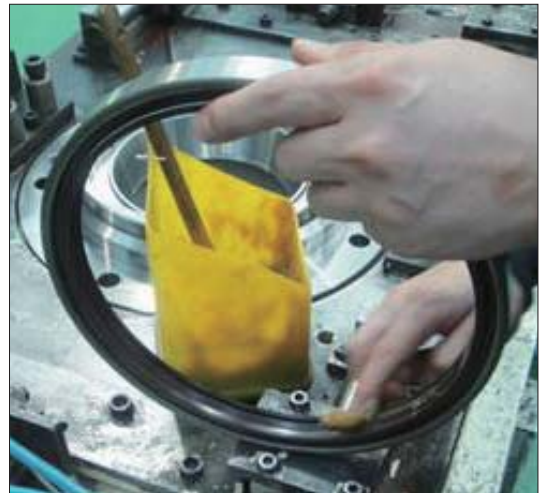
- (2) Assemble oil seal to casing.
Use special jig for pressing. Pay attention to direction of dust seal and dent.



2209A8SM27

※ WHILE ASSEMBLING OIL SEAL

1. Be sure to set dust seal to gear oil.
2. Before assembling, charge enough grease in oil seal.
3. Before assembling, apply enough grease inside and outside of oil seal.



2209A8SM28

5) ASSEMBLING SHAFT SUB ASSY & RING NUT

- (1) After assembling casing & drive shaft sub
assy, flip it over.



2209A8SM29

- (2) Put drive shaft sub assy into casing.
※ Be sure to maintain it vertical with ground when assembling it.



2209A8SM30

- (3) Put taper bearing into it.
Rotate bearing by hands for checking after assembly.



2209A8SM31

- (4) Put ring nut into drive shaft sub assy by using special jig.
The tightening torque (M95) = 3.5 ± 0.4 kgf·m
(25.3 ± 2.9 lbf·ft)



2209A8SM32

- ※ Apply enough loctite #242 before screwing bolts.



2209A8SM33

- (5) Align bolt screw of ring nut with lock plate's hole.

In case of misalign between bolt screw ring nut and lock plate's hole, put lock plate as near as possible to hole of bolt screw of ring nut and make it in line by increasing tightening torque.



2209A8SM34



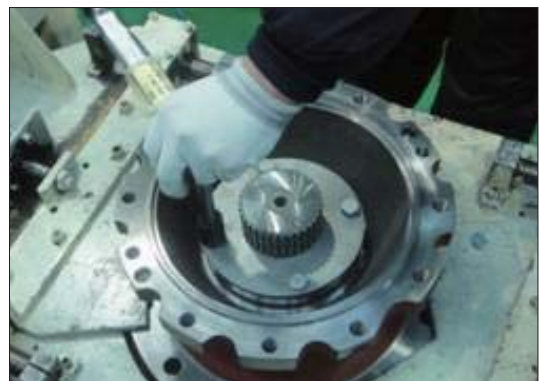
2209A8SM35

- (6) Screw 4 bolts (M12 × 16) to connect ring nut and lock plate by using torque wrench.

Bolt (M12, 4EA) = 10.9T

The tightening torque = 8.8 ± 0.9 kgf·m
(63.7 ± 6.5 lbf·ft)

- ※ Apply enough loctite #242 before screwing bolts.



2209A8SM36

- (7) Use paint marker for checking surplus parts after assembling.



2209A8SM37

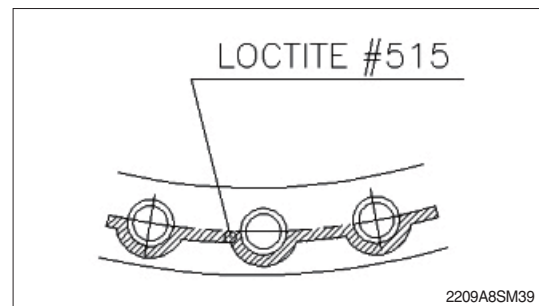
6) ASSEMBLING RING GEAR

- (1) Apply loctite #515 bottom of casing sub assy contacting with ring gear without disconnection.



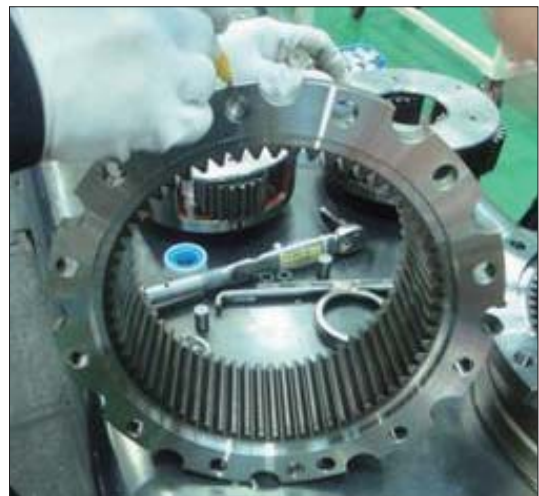
2209A8SM38

Refer to loctite detail.



2209A8SM39

- (2) Put parallel pin into hole of casing sub assy.
Mark parallel pin position using paint marker.



2209A8SM40

- (3) Align ring gear with parallel pin to put them into casing sub assy.
※ Be sure to maintain them vertical with ground while using press.



2209A8SM41

- (4) Screw 12 bolts (M16×45) to connect casing sub assy and ring gear (01) by using torque wrench.

Bolt (M16, 12EA) = 12.9T

The tightening torque = 27 ± 2.7 kgf·m
(195 ± 19.5 lbf·ft)

- ※ Apply enough loctite #242 before screwing bolts.



2209A8SM42

- (5) Use paint marker for checking surplus parts after assembling.



2209A8SM43



2209A8SM44

7) ASSEMBLING CARRIER SUB ASSY & SUN GEAR

- (1) Put No.2 carrier sub assy along spline of drive shaft spline.
- Screw M10 I-bolt to No.2 carrier sub assy.
 - Lifting up No.2 carrier sub assy and align planetary gear and tooth of ring gear by rotating planetary gear by hands.
 - Rotate No.2 carrier sub assy by hands to fit No.2 carrier sub assy into drive shaft spline.



2209A8SM45

- (2) Put No.2 sun gear into No.2 carrier sub assy.



2209A8SM46

(3) Put No.1 carrier sub assy into No.2 sun gear along spline.

- Screw M10 I-bolt to No.1 carrier sub assy.
- Lifting up No.1 carrier sub assy and align planetary gear and tooth of ring gear by rotating planetary gear by hands.
- Rotate No.1 carrier sub assy by hands to fit No.1 carrier into No.2 sun gear spline.



2209A8SM47

(4) Put No.1 sun gear into No.1 carrier sub assy.
Be sure to maintain it vertical with ground.
And align with No.1 planetary gear spline.

(5) Rotate No.1 carrier sub assy by hands to check noise.



2209A8SM48

8) MEASURING CLEARANCE & ASSEMBLING NAME PLATE

(1) Check the clearance between ring gear and No.1 sun gear using a tool with dial gauge.

Check the clearance

Dial gauge = -0.3 ~ +2.95



2209A8SM49

GROUP 6 TRAVEL DEVICE

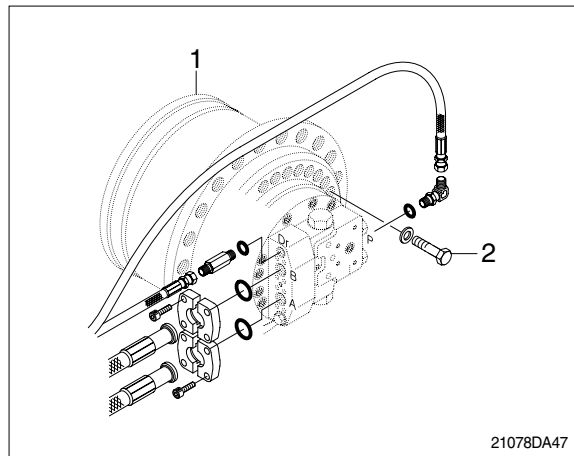
1. REMOVAL AND INSTALL

1) REMOVAL

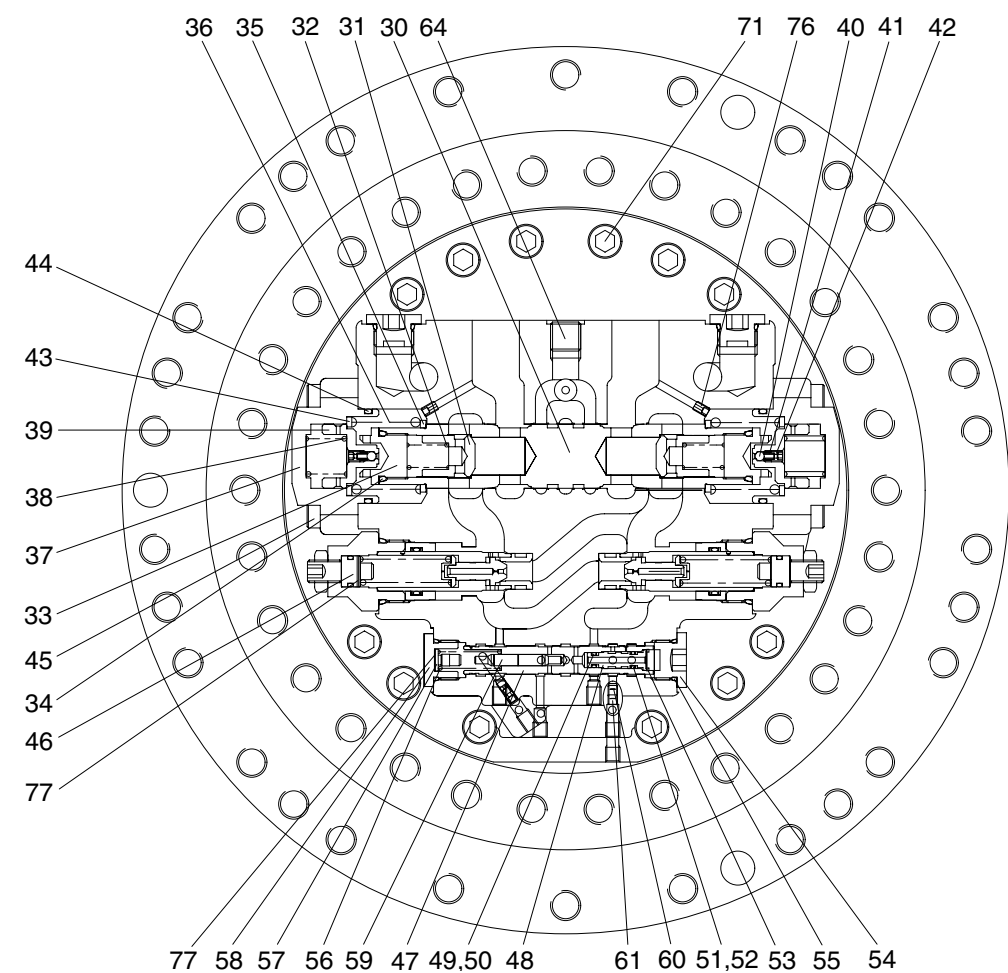
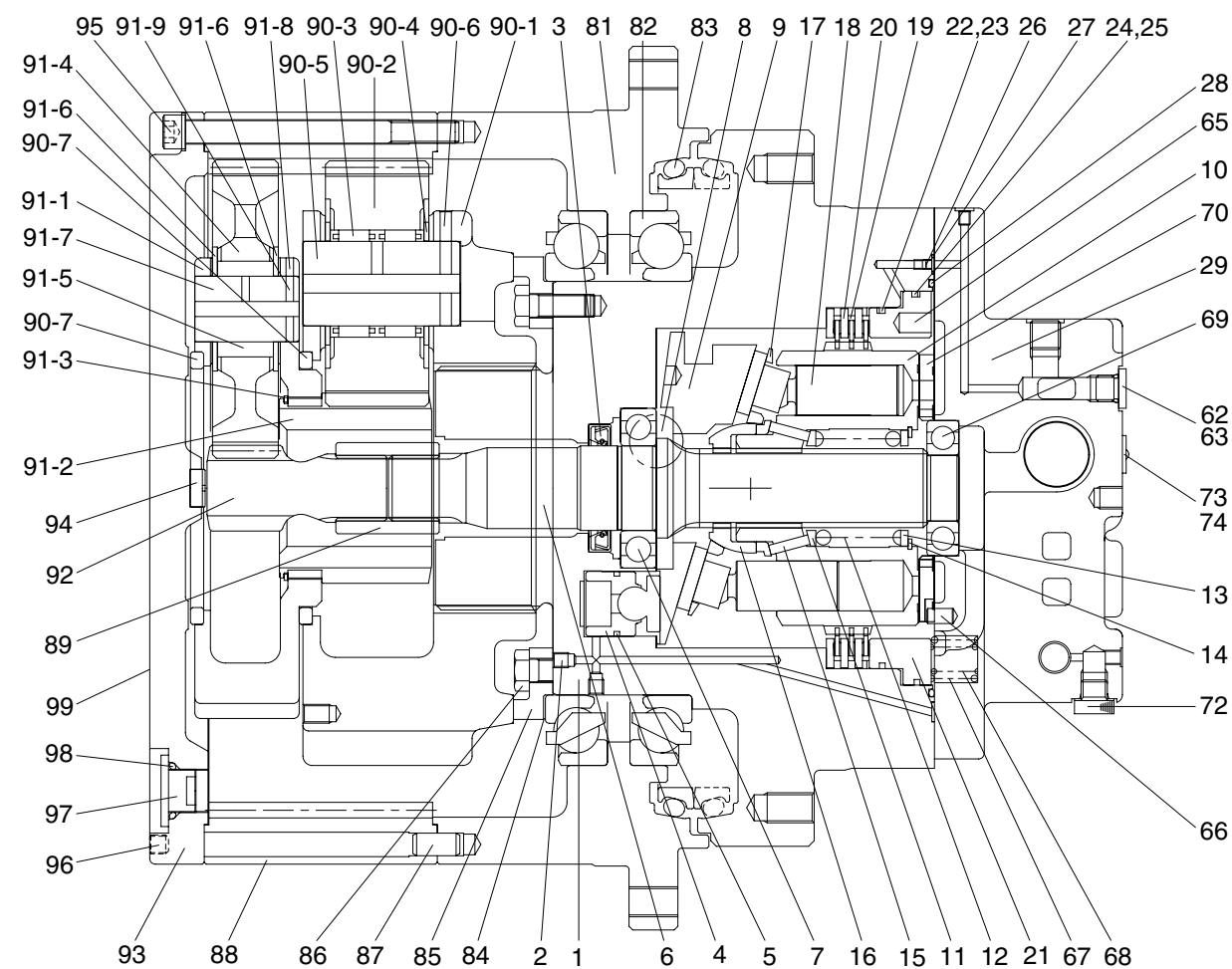
- (1) Swing the work equipment 90° and lower it completely to the ground.
- (2) Operate the control levers and pedals several times to release the remaining pressure in the hydraulic piping.
- (3) Loosen the breather slowly to release the pressure inside the hydraulic tank.
- ⚠ Escaping fluid under pressure can penetrate the skin causing serious injury.
- ※ When pipes and hoses are disconnected, the oil inside the piping will flow out, so catch it in oil pan.
- (4) Remove the track shoe assembly.
For details, see **removal of track shoe assembly**.
- (5) Remove the cover.
- (6) Remove the hose.
- ※ Fit blind plugs to the disconnected hoses.
- (7) Remove the bolts and the sprocket.
- (8) Sling travel device assembly(1).
- (9) Remove the mounting bolts(2), then remove the travel device assembly.
· Weight : 300kg(660lb)

2) INSTALL

- (1) Carry out installation in the reverse order to removal.
- (2) Bleed the air from the travel motor.
 - ① Remove the air vent plug.
 - ② Pour in hydraulic oil until it overflows from the port.
 - ③ Tighten plug lightly.
 - ④ Start the engine, run at low idling, and check oil come out from plug.
 - ⑤ Tighten plug fully.
- (3) Confirm the hydraulic oil level and check the hydraulic oil leak or not.



2. TRAVEL MOTOR
1) STRUCTURE

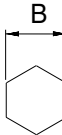


2107V2TM02

| | | | | | | | | | | | |
|----|----------------|----|----------------|----|-------------------|----|-------------|------|---------------------|------|----------------------|
| 1 | Shaft casing | 20 | Plate | 39 | Spool | 58 | Plug | 77 | Shim | 91-1 | Carrier No.1 |
| 2 | Plug | 21 | Packing piston | 40 | Steel ball | 59 | Spool | 81 | Housing | 91-2 | Sun-gear No.2 |
| 3 | Oil seal | 22 | O-ring | 41 | Spring | 60 | Orifice | 82 | Main bearing | 91-3 | Retaining ring |
| 4 | Swash piston | 23 | Back up ring | 42 | Plug | 61 | Orifice | 83 | Floating seal | 91-4 | Planetary gear No.1 |
| 5 | Piston ring | 24 | O-ring | 43 | Spring seat | 62 | Plug | 84 | Shim | 91-5 | Needle bearing No.1 |
| 6 | Shaft | 25 | Back up ring | 44 | O-ring | 63 | O-ring | 85 | Retainer | 91-6 | Thrust washer |
| 7 | Bearing | 26 | Orifice | 45 | Wrench bolt | 64 | Plug | 86 | Hex head bolt | 91-7 | Pin No.1 |
| 8 | Steel ball | 27 | O-ring | 46 | Relief valve assy | 65 | Pin | 87 | Parallel pin | 91-8 | Spring pin |
| 9 | Swash plate | 28 | O-ring | 47 | Spool | 66 | Pin | 88 | Ring gear | 91-9 | Spring pin |
| 10 | Cylinder block | 29 | Rear cover | 48 | Guide | 67 | Spring | 89 | Coupling | 92 | Sun gear No.1 |
| 11 | Spring seat | 30 | Spool | 49 | O-ring | 68 | Spring | 90 | Carrier assy No.2 | 93 | Cover |
| 12 | Spring | 31 | Check | 50 | Back up ring | 69 | Bearing | 90-1 | Carrier No.2 | 94 | Pad |
| 13 | End plate | 32 | Spring | 51 | O-ring | 70 | Valve plate | 90-2 | Planetary gear No.2 | 95 | Hex socket head bolt |
| 14 | Snap ring | 33 | Plug | 52 | Back up ring | 71 | Wrench bolt | 90-3 | Needle bearing No.2 | 96 | Hex socket Screw |
| 15 | Pin | 34 | O-ring | 53 | Snap ring | 72 | Plug | 90-4 | Thrust washer | 97 | Hydraulic plug |
| 16 | Ball guide | 35 | Spring seat | 54 | plug | 73 | Name plate | 90-5 | Pin No.2 | 98 | O-ring |
| 17 | Set plate | 36 | Spring | 55 | O-ring | 74 | Rivet | 90-6 | Spring pin | 99 | Name plate |
| 18 | Piston assy | 37 | Cover | 56 | Spring | 75 | Seal kit | 90-7 | Thrust ring | | |
| 19 | Friction plate | 38 | Spring | 57 | Spring seat | 76 | Orifice | 91 | Carrier assy No.1 | | |

2) TOOLS AND TIGHTENING TORQUE

(1) Tools

| Tool name | | Remark | |
|-----------------------------------|--------|--|---|
| Allen wrench | | 2.5, 4, 6, 10 |  |
| Socket for socket wrench, spanner | Socket | 8, 14, 24, 27 | |
| Torque wrench | | Capable of tightening with the specified torques | |
| Pliers | | - | |
| Plastic and iron hammer | | Wooden hammer allowed. Normal 1 or so | |
| Monkey wrench | | - | |
| Oil seal inserting jig | | - | |
| Bearing pliers | | - | |
| Seal tape | | - | |
| Eye bolt | | M10, M12, M14 | |
| Press(0.5 ton) | | - | |
| Oil stone | | - | |
| Bearing assembling jig | | - | |

(2) Tightening torque

| Part name | Item | Size | Torque | |
|----------------------|------|------------|-----------|-----------|
| | | | kgf · m | lbf · ft |
| Plug | 2 | NPTF 1/16 | 1 ± 0.1 | 7.2 ± 0.7 |
| Orifice | 26 | M5 | 0.7 ± 0.1 | 5 ± 0.7 |
| Wrench bolt | 45 | M12 × 40L | 10 ± 1.0 | 72 ± 7.0 |
| Relief valve | 46 | HEX 27 | 18 ± 1.0 | 130 ± 7.0 |
| Plug | 54 | PF 1/2 | 8.5 ± 1.0 | 61 ± 7.0 |
| Plug | 58 | HEX 24 | 5 ± 1.0 | 36 ± 7.0 |
| Plug | 62 | PF 1/4 | 5 ± 1.0 | 36 ± 7.0 |
| Wrench bolt | 71 | M10 × 35L | 10 ± 1.0 | 72 ± 7.0 |
| Hex head bolt | - | M12 × 25L | 11 ± 1.5 | 79 ± 10 |
| Hex socket head bolt | - | M12 × 155L | 11 ± 1.5 | 79 ± 10 |
| Hex socket head plug | - | PF 3/4 | 19 ± 1 | 137 ± 7.0 |

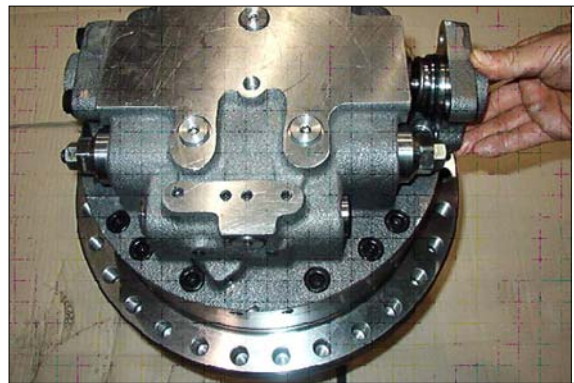
3. OUTLINE OF DISASSEMBLING

1) GENERAL SUGGESTIONS

- (1) Select a clean place for dismantling.
Spread a rubber plate on a working table in order to prohibit the damage of parts.
- (2) Clean a deceleration equipment and a motor part, washing out dirt and unnecessary substances.
- (3) Without any damage of O-ring, oil seal, the adhered surface of other seals, a gear, a pin, the adhered surface of other bearings, and the surface of moisturized copper, treat each parts.
- (4) Numbers written in the parenthesis, (), next to the name of a part represent the part numbers of a cross-sectional view annexed with a drawing.
- (5) The side of a pipe in a motor can be written as a rear side; the side of out-put as a front side.
- (6) Using and combining a liquid gasket, both sides must be dried completely before spraying a liquid gasket.
- (7) In case of bonding bolts, combine a standard torque by torque wrench after spraying locktight 262 on the tab parts. (It can be dealt as assembling NPTF screws and an acceleration equipment.)

3.1 DISASSEMBLING

- 1) Unloosing wrench bolt and disassemble cover(37).
※ Wrench bolt = M12×40L-8EA
(Purchasing goods)



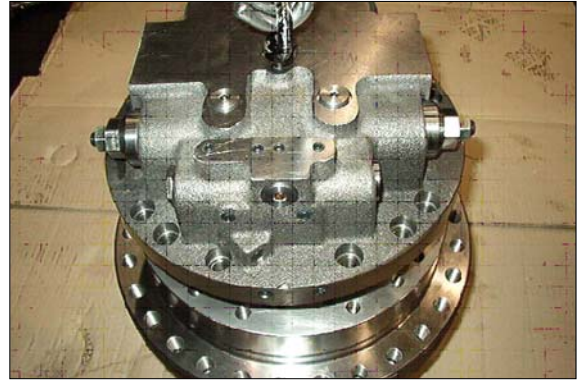
21078TM21

- 2) Disassemble parts related to C.B.V.

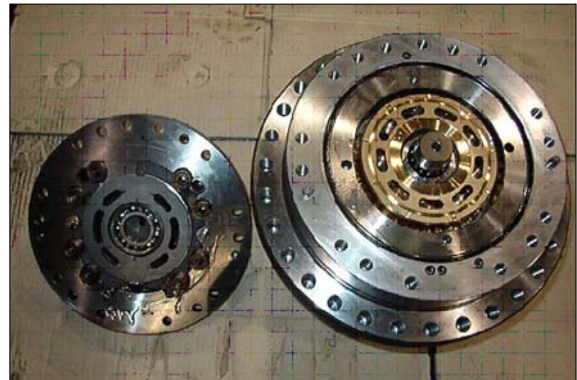


21078TM22

- 3) Unloosing wrench bolt(M12×35L, 16EA) and disassemble rear cover assembly from motor assembly.



21078TM23



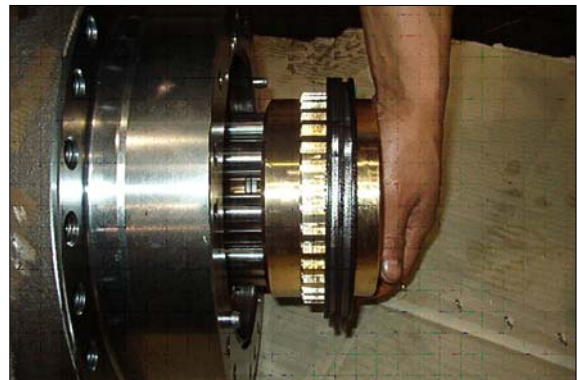
21078TM24

- 4) Dismantle packing piston(21) using compressed air.



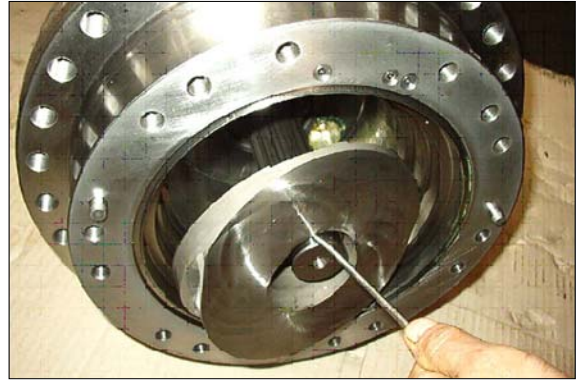
21078TM25

- 5) Disassembly rotary kit from motor assembly(Cylinder block assembly, piston assembly, ball guide, set plate, friction plate, steel plate...)



21078TM26

- 6) Using a jig, disassemble swash plate(9) from shaft casing.



21078TM27

- 7) Using compressed air, disassemble piston swash(4) piston ring(5), respectively.

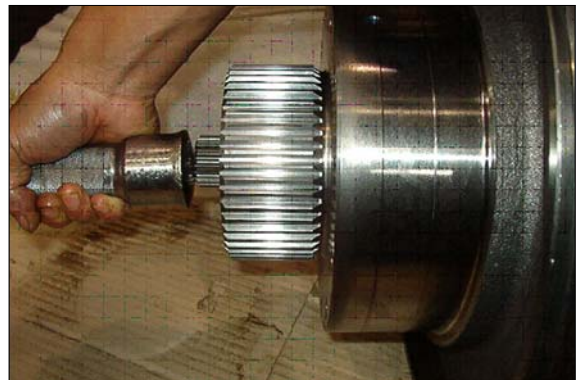


21078TM28



21078TM29

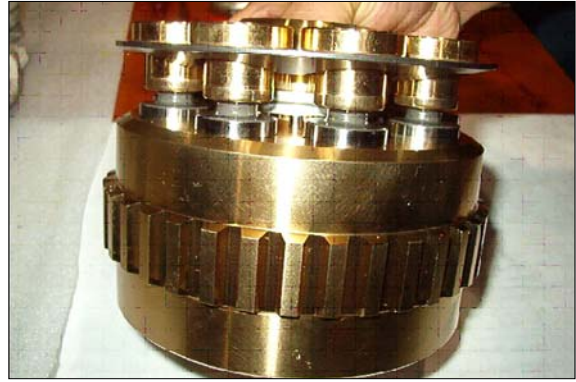
- 8) Using a hammer, disassemble shaft(6) from shaft casing(1).



21078TM30

■ **Disassemble cylinder sub.**

- 9) Disassemble cylinder block assembly, piston assembly(9) and seat plate(M).



21078TM31



21078TM32

- 10) Disassemble ball guide(16), ring and pin(15) from cylinder block, respectively.



21078TM33



21078TM34



21078TM35

- 11) Pushing spring(12) by an assembling jig, disassemble snap ring(14), spring seat(13), spring(12) and spring seat(11), respectively.



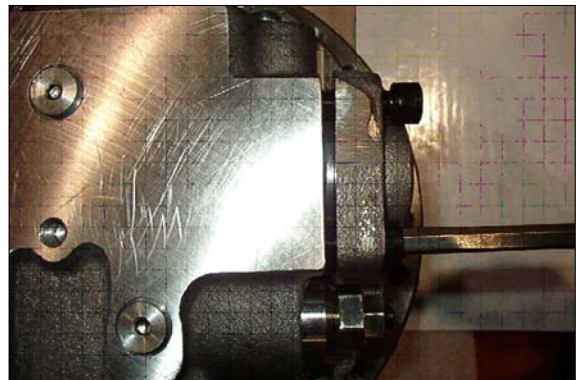
21078TM36



21078TM37

■ Disassemble valve casing sub.

- 12) Using an hexagon wrench, unloosing wrench bolt(45) and disassemble cover(37), spring(38), spool(39), spring seat(43), spring(36) and spring seat(35), respectively. (Same balance on both sides)

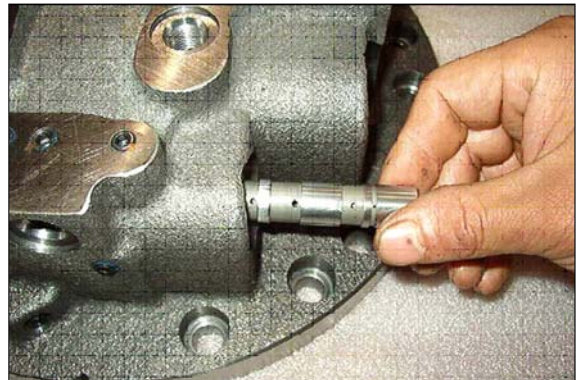


21078TM38



21078TM39

- 13) Disassemble spool(59), spool(47), O-ring (51), guide(48) and snap ring(53) on rear cover, respectively.

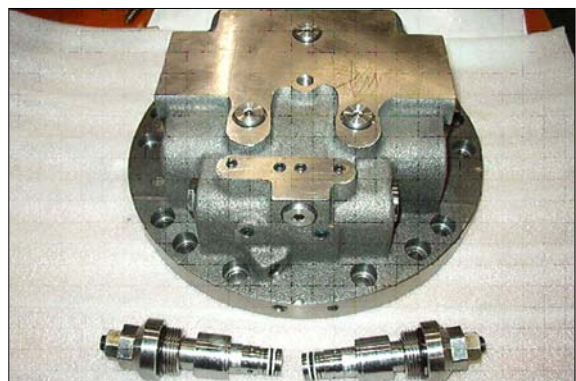


21078TM40



21078TM41

- 14) Using a torque wrench, disassemble relief assembly(46) on rear cover.



21078TM42

4. OUTLINE FOR ASSEMBLING

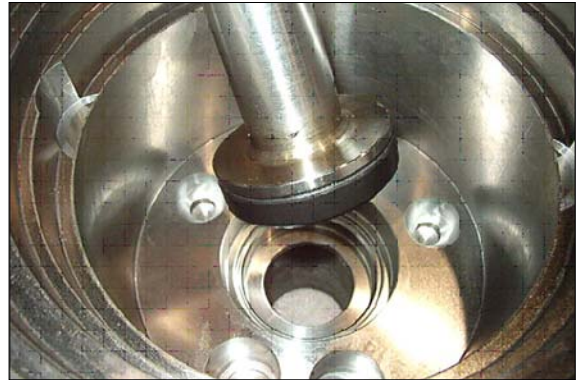
1) GENERAL SUGGESTIONS

- (1) After washing each parts cleanly, dry it with compressed air.
Provided that you do not wash friction plate with treated oil.
- (2) In bonding each part, fasten bond torque.
- (3) When using a hammer, do not forget to use a plastic hammer.

4.1 ASSEMBLING

- Assemble the sub of turning axis

- 1) Using a jig, assemble oil seal(3) into shaft casing(1)



- 2) Have a bearing(8) thermal reacted into shaft(6).





21078TM46

- 3) Using a jig, assemble shaft assembly into shaft casing(1).



21078TM47

- 4) After spreading grease on steel ball(8) assemble into shaft casing(1).



21078TM48

- 5) Assemble swash piston assembly(4, 5) into shaft casing(1).



21078TM49

- 6) Assemble swash plate(9) into shaft casing (1).



21078TM50

■ **Assemble cylinder block sub.**

- 7) Assemble spring seat(13), spring(12), spring seat(11) into cylinder block(10) respectively, pushing spring(12) using by a jig, assemble snap ring(14) with a snap ring(14).



21078TM51



21078TM52

- 8) Assemble ring, pin(15) on cylinder block(10) ball guide(16) respectively.



21078TM53



21078TM54

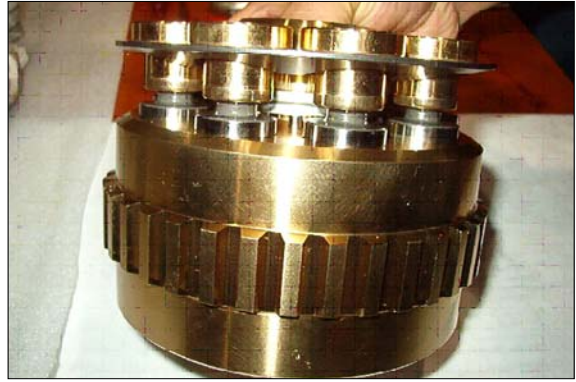


21078TM55

- 9) Assemble cylinder block assembly, piston assembly(9), seat plate(17).

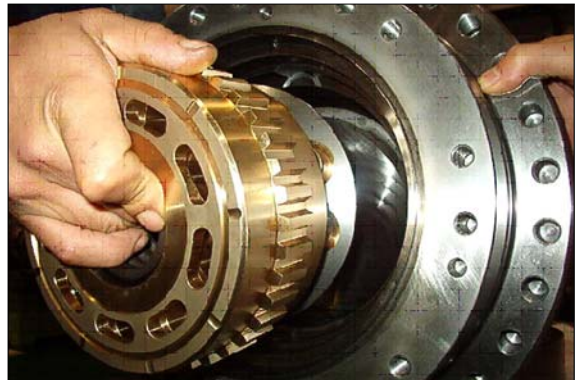


21078TM56



21078TM57

10) Assemble cylinder block assembly(9) into shaft casing(a).



21078TM58

11) Assemble friction plate(19) and plate(20) into shaft casing(1) respectively, prepare 6 set.



21078TM59

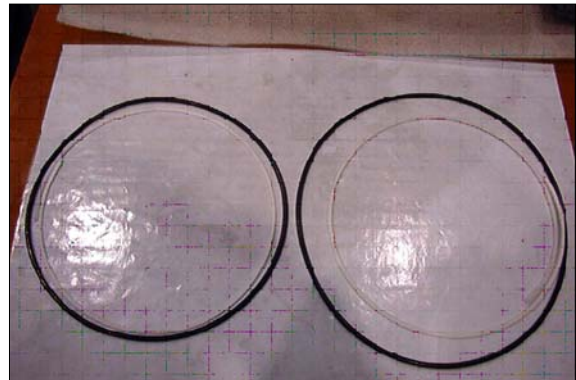


21078TM59-1

12) Assemble O-ring(22, 23) into packing piston (21).



21078TM60



21078TM60-1

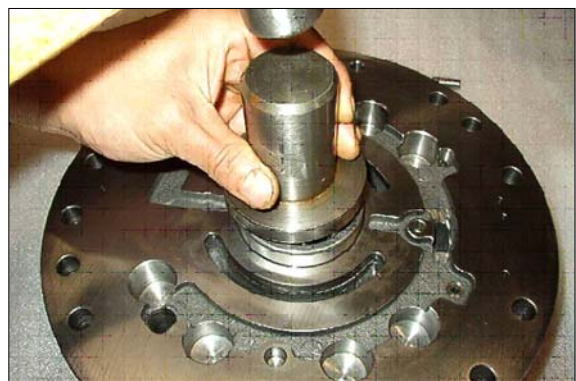
13) After spreading grease on packing piston(21) bond wrench bolt and assemble shaft casing(1).



21078TM61

■ Assemble rear cover sub.

14) Using a jig, assemble bearing(69) into rear cover(29).

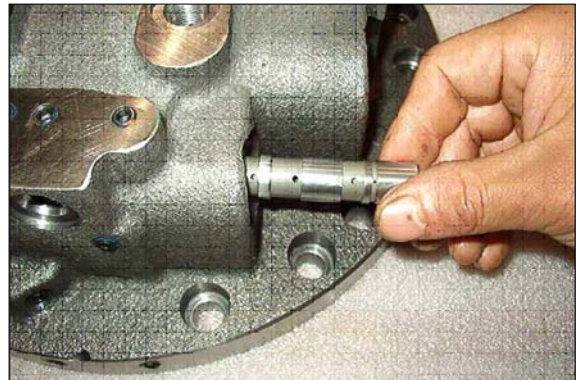


21078TM62

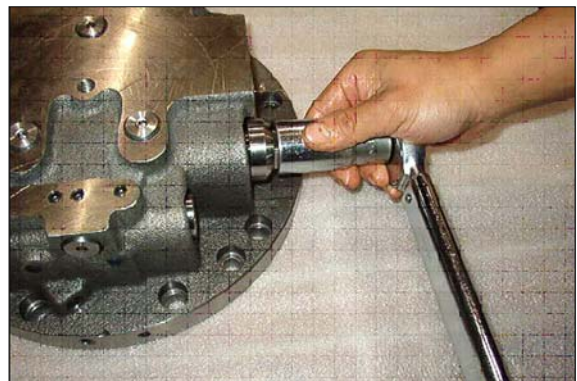
- 15) After assembling spool(59), spool(47), O-ring(51), guide(48) and snap ring(53) respectively into rear cover(29).
Using torque wrench, assemble it.



21078TM63

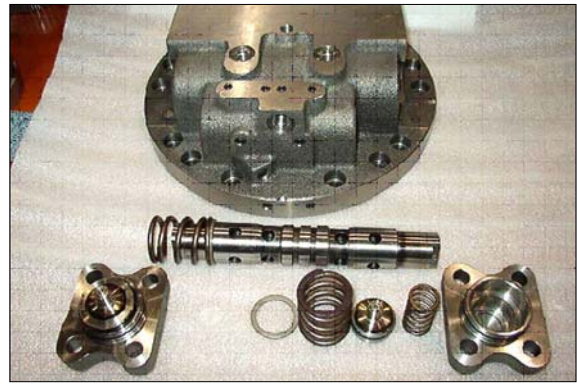


21078TM64

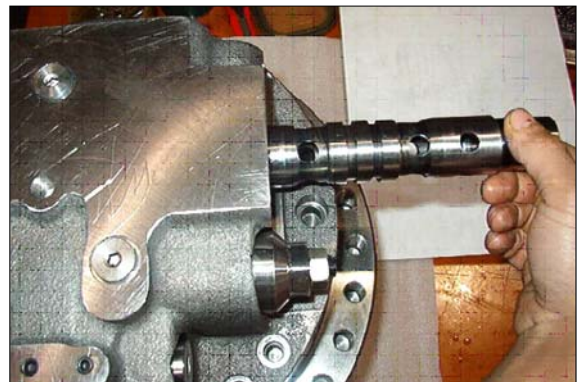


21078TM65

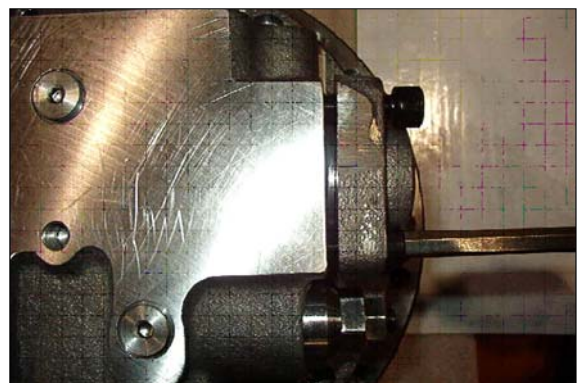
- 16) Assemble spring seat(35), spring(36), spring seat(43), spool(39), spring(38), cover(37) respectively and assemble wrench bolt(45).
(Same balance on both sides)



21078TM66



21078TM67



21078TM67-1

17) Assemble plug(2).

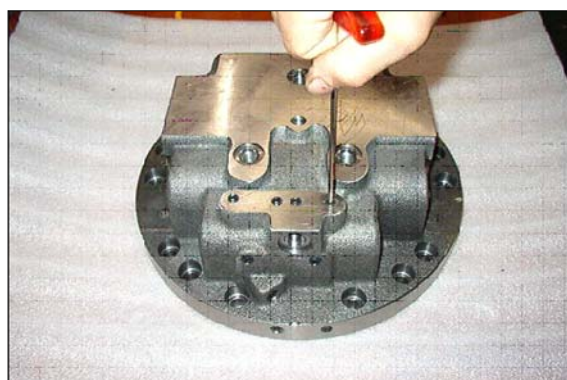
※ Plug(NPT1/16) - 11EA



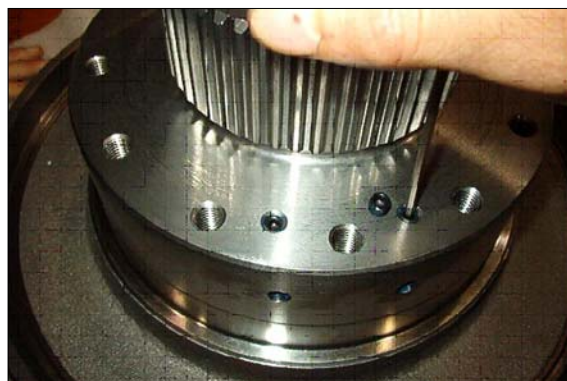
21078TM68



21078TM69

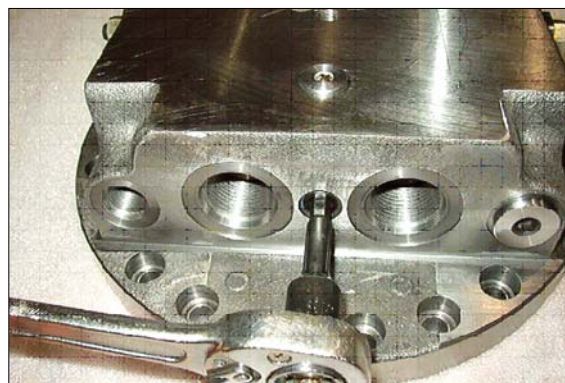


21078TM70



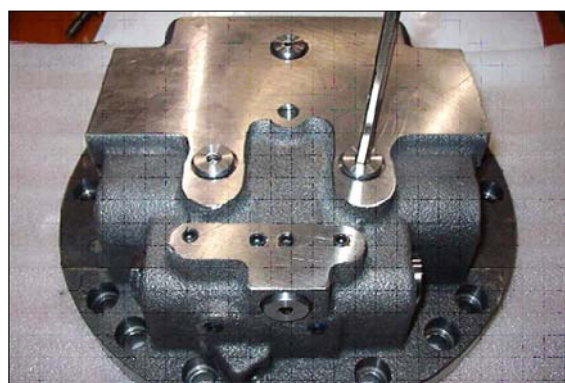
21078TM71

- 18) Assemble plug(64).
※ Plug(PT3/8) - 11EA

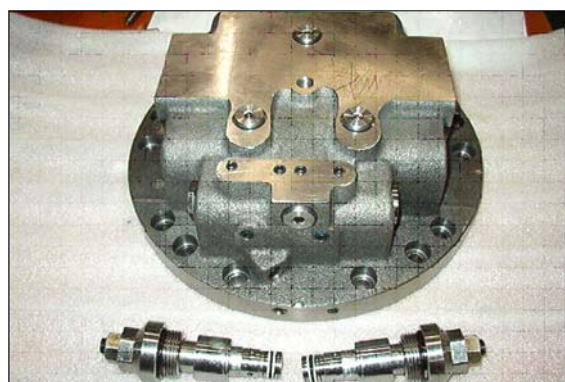


21078TM72

- 19) Assemble plug(62, 63) into rear cover(29)
and assemble relief valve assembly.



21078TM73



21078TM74

- 20) Put spring(67, 68) together into rear cover
(29), prepare 6 set.

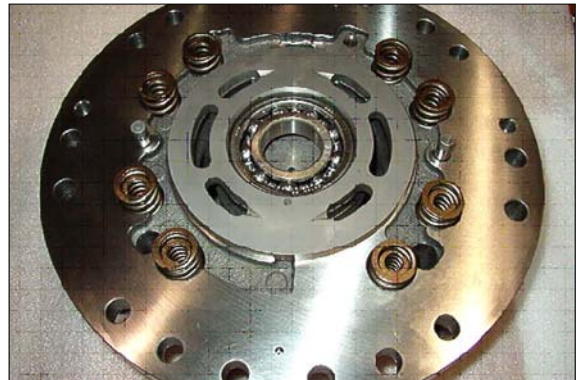


21078TM75



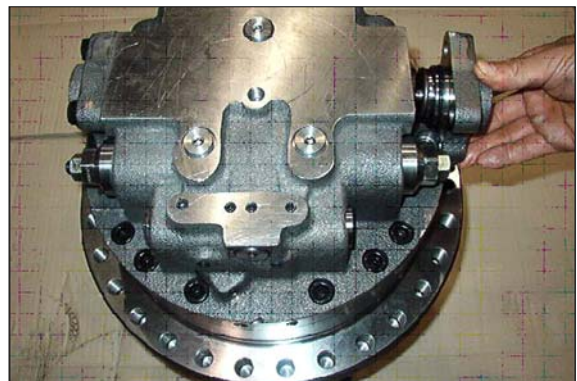
21078TM76

21) Assemble valve plate(70) into rear cover (29).



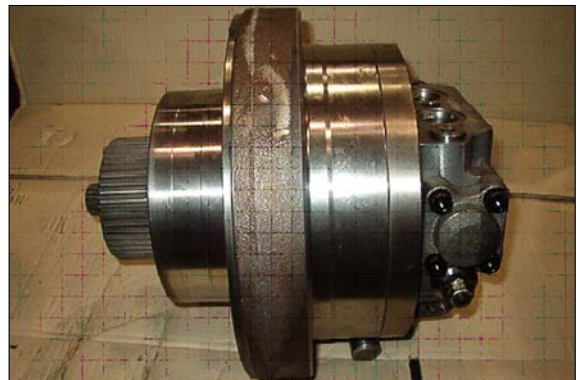
21078TM77

22) After assembling shaft casing(1) and rear cover(29).
Assemble spool assembly(30), spring(38), spool(39), cover(37) after then complete assembly with wrench bolt(45).



21078TM78

23) Finish assembly.



21078TM79

5.1 DISASSEMBLING REDUCTION UNIT

1) Preparation for disassembling

- (1) The reduction units removed from excavator are usually covered with mud. Wash outside of propelling unit and dry it.
- (2) Locate reducer in order for drain port to be at the lowest level loosen taper screw plug of drain port, and drain oil from reduction gear.
 - ※ While oil is still hot, inside of the unit may be pressurized.

▲ Take care of the hot oil gushing out of the unit when loosening the plug.

(3) Mark for mating

Put marks on each mating parts when disassembling so as to reassemble correctly as before.



21078TM80

2) Setting reduction unit(or whole propelling unit) on work stand for disassembling

- (1) Remove M12 hexagon socket head bolts(95) at 3 places from cover(93) almost equally apart each other, and then install M12 × 155L eye bolts.
Lift up the unit using them and place it on work stand with cover upward.

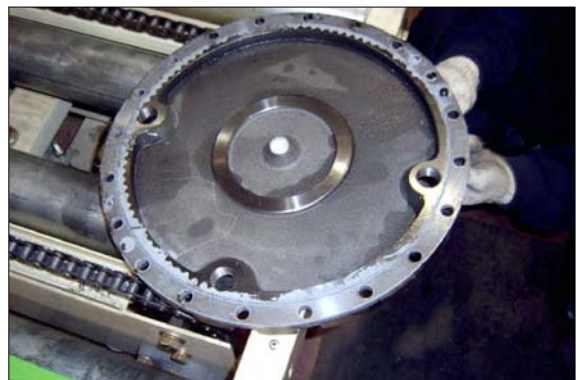
▲ Take great care not to pinch your hand between parts while disassembling nor let fall parts on your foot while lifting them.



21078TM81

3) Removing cover

- (1) Remove the rest of M12 hexagon socket head bolts(95) that securing gear and housing. Loosen all the socket bolts and then, disassemble cover.
- (2) As the cover(93) is adhered to ring gear (88), disassemble ring gear(88) and cover (93) by lightly hammering slantwise upward using sharpen punch inserted between the cover and ring gear.



21078TM82

4) Removing No.1 carrier sub assembly

- (1) Screw three M10 eye-bolt in No.1 carrier and lift up and remove No.1 carrier assy.



21078TM83

- (2) Remove No.1 sun gear

※ Be sure to maintain it vertical with the ground when disassembling No.1 sun gear.



21078TM84

5) Removing No.2 carrier sub assembly

- (1) Screw three M10 eye-bolt in No.2 carrier and lift up and remove No.2 carrier assy.



21078TM85

- (2) Remove No.2 sun gear

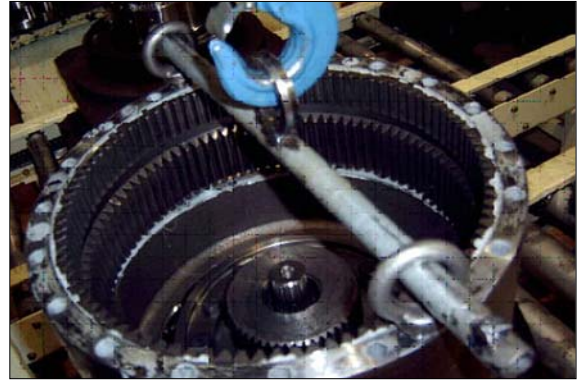
※ Be sure to maintain it vertical with the ground when disassembling No.2 sun gear.



21078TM86

6) Removing ring gear

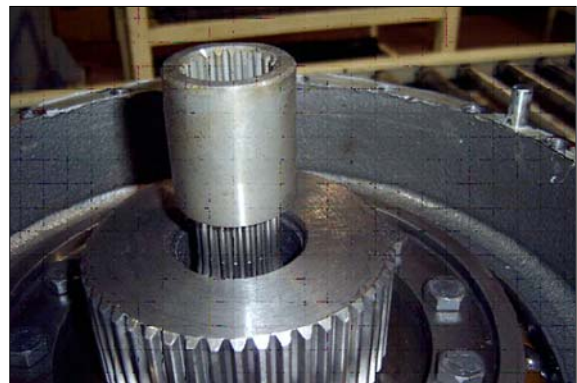
- (1) As the ring gear(88) is adhered to housing(81), disassemble ring gear(88) and housing(81) by lightly hammering slantwise upward using sharpen punch inserted between the ring gear and housing.
 - ※ Carefully disassembling ring gear not to make scratch on it.
- (2) Screw M14 eye-bolt in ring gear and lift up and remove it.



21078TM87

7) Removing coupling

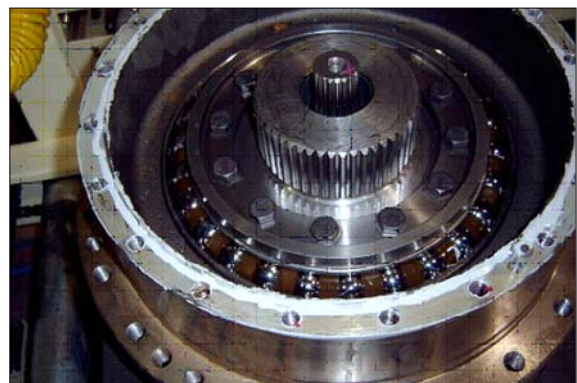
- (1) Remove coupling.



21078TM88

8) Removing retainer & shim

- (1) Remove M12 hexagon socket head bolts that secure retainer and motor.
- (2) Remove retainer & shim.



21078TM89

9) Removing housing sub assembly

- (1) Screw M12 eye bolt in housing and lift up housing assembly including angular bearing and floating seal.



21078TM90

10) Removing floating seal

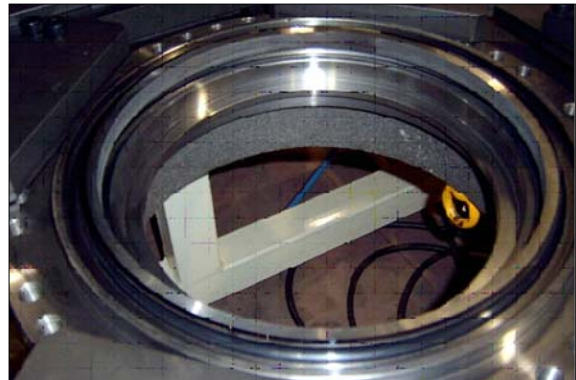
- (1) Lift up a piece of floating seal of motor side.



21078TM91

11) Disassembling housing assembly

- (1) After turning housing, lift up a piece of floating seal from housing and then remove it.
- ※ Don't disassemble angular bearing.



21078TM92

12) Disassembling No.1 carrier

- (1) Remove thrust ring(90-7) from carrier.
- (2) Knock spring pin(91-8) fully into No.1 pin (91-7).
- (3) Remove planetary, thrust washer, No.1 pin, bearing from carrier.



21078TM93



21078TM94



21078TM95

13) Disassembling No.2 carrier

- (1) Disassemble No.2 carriers, using the same method for No.1 carrier assembly.



21078TM96



21078TM97

6.1 ASSEMBLY REDUCTION GEAR

■ General notes

Clean every part by kerosene and dry them by air blow.

Surfaces to be applied by locktite must be decreased by solvent.

Check every part for any abnormalities.

Each hexagon socket head bolt should be used with locktite No. 262 applied on its threads.

Apply gear oil slightly on each part before assembling.

Take great care not to pinch your hand between parts or tools while assembling nor let fall parts on your foot while lifting them.

Inspection before reassembling

Thrust washer

- Check if there are seizure, abnormal wear or uneven wear.
- Check if wear is over the allowable limit.

Gears

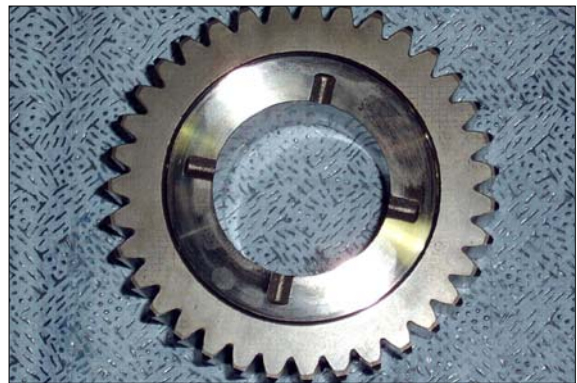
- Check if there are pitting or seizure on the tooth surface.
- Check if there are cracks on the root of tooth by die check.

Bearings

- Rotate by hand to see if there are something unusual such as noise or uneven rotation.

Floating seal

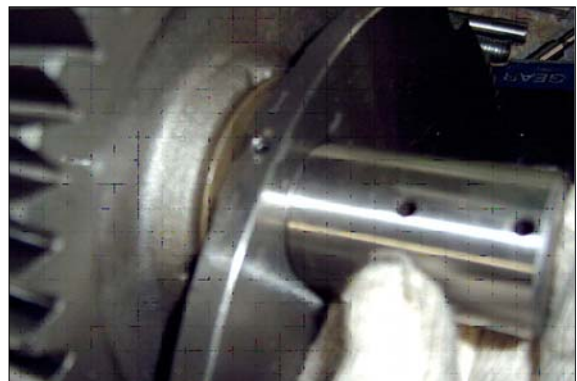
- Check flaw or score on sliding surfaces or O-ring.



21078TM98

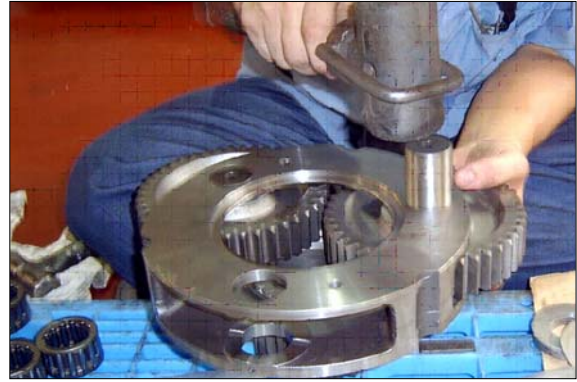
1) Assembling No.1 carrier

- (1) Put No.1 carrier(91-1) on a flat place.
- (2) Install No.1 needle bearing(91-5) into No.1 planetary gear(91-4), put 2EA of No.1 thrust washer(91-6) on both sides of bearing, and then, install it into carrier.



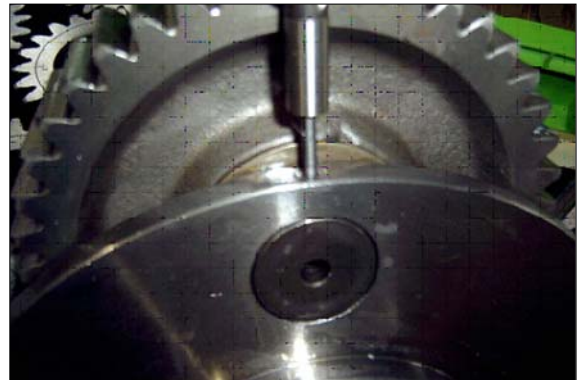
21078TM99

- (3) Install No.1 pin(91-5) into No.1 carrier where the holes for No.1 pin(91-5) are to be in line with those of No.1 carrier, and then, install spring pins into the holes.



21078TM100

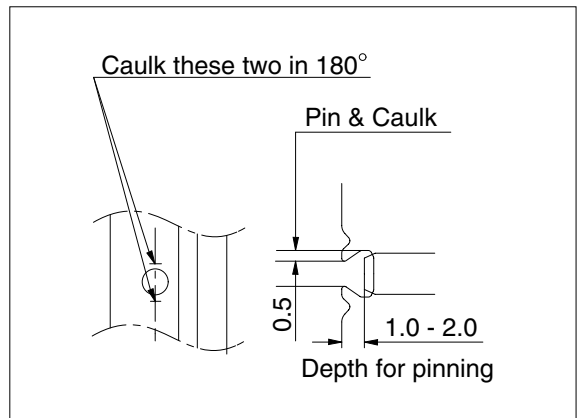
- (4) Caulk carrier holes as shown on the picture.
 (5) Assembly ring thrust(90-7) into carrier.



21078TM101

2) Assembling No.2 carrier

- (1) Put No.2 carrier(90-1) on a flat place.
 (2) Install No.2 needle bearing(90-3) into No.2 planetary gear(90-2), put 2EA of No.2 thrust washer(90-4) on both sides of bearing, and then, install it into carrier.



21078TM102

- (3) Install No.2 pin(90-5) into No.2 carrier where the holes for No.2 pin(90-5) are to be in line with those of No.2 carrier, and then, install spring pins into the holes.



21078TM103

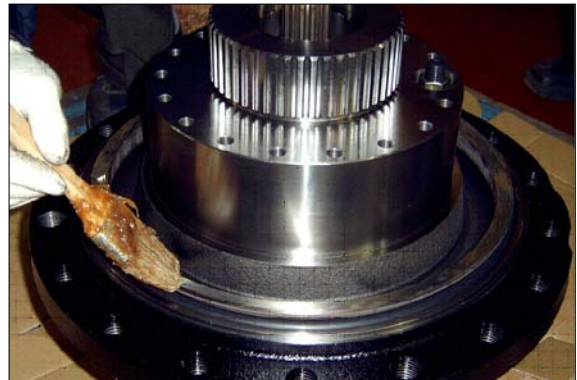
- (4) Caulk carrier holes as shown on the picture.
- (5) Assembly ring thrust(90-7) into carrier.



21078TM104

3) Assembling floating seal(83) and main bearing(82)

- (1) Assemble floating seal into motor by use of pressing jig. Grease the contact parts for floating seal which is assembled into motor.
- (2) Heat bearing at 60~70°C and then, put into the motor side.



21078TM105

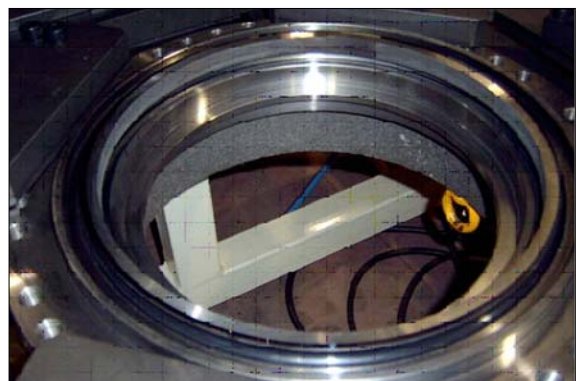
- ※ Be sure to maintain it vertical with the ground when assembling bearing and floating seal.



21078TM106

4) Assembling housing

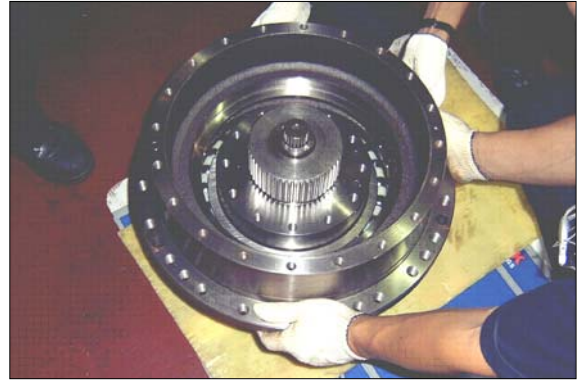
- (1) Heat housing at 60~70°C while clearing it out and then, assemble floating seal into housing by use of pressing jig.
- ※ Be sure to maintain it vertical with the ground when assembling floating seal.



21078TM705

5) Installing housing assembly

- (1) Install 2EA of M12 eye-bolt into housing assembly.
 - (2) Assemble housing into motor by use of hoist and eye-bolt.
- ※ Be sure to tighten eye-bolt deep enough.



21078TM108

6) Installing main bearing(82)

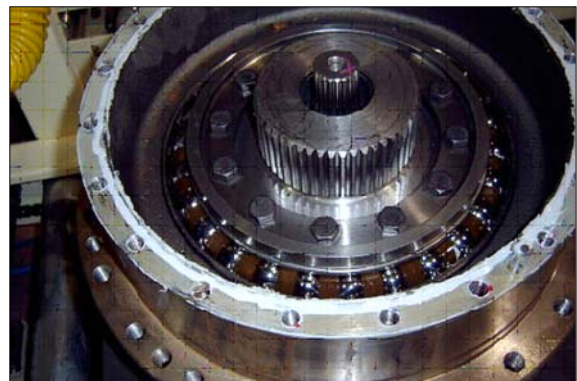
- (1) Heat main bearing at 60~70°C and then, install.
- ※ Be sure to maintain it vertical with the ground when assembling bearing.



21078TM109

7) Installing retainer(86) and shim(85)

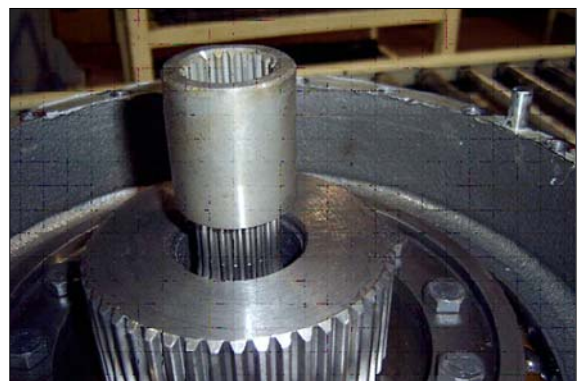
- (1) Measure clearance between main bearing and retainer by use of jig to decide the thickness of shim and select an appropriate shim, and then, assemble retainer.
- (2) Apply locktite(#262) on M12 hexagon head bolt, and then, bolt.



21078TM110

8) Installing coupling

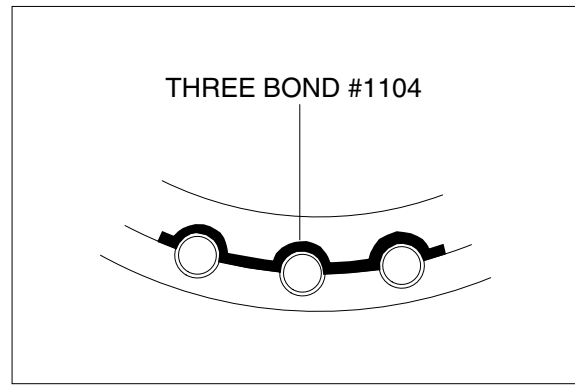
- (1) Install coupling on spline of the motor.



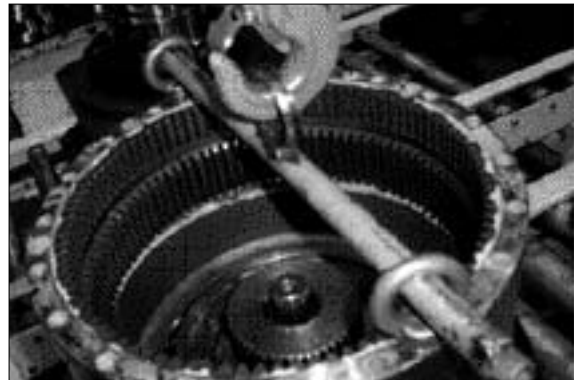
21078TM111

9) Installing ring gear

- (1) Apply three bone #1104(locktite #515) on housing for ring gear without gap.
- (2) Insert lock pin into housing hole.
- (3) Install M14 eye-bolt on the tap of ring gear.
- (4) Lift ring gear and then, assemble into housing in order for hole of ring gear and parallel pin of housing to be in line.
- (5) Temporarily secure 4EA of M12 hexagon socket bolt and shim with cover thickness having appropriate torque.



21078TM112A



21078TM113

10)Installing No.2 carrier sub assembly

- (1) Install M10 eye-bolt on No.2 carrier assembly.
- (2) Lift No.2 carrier assembly and then, slowly put it down on ring gear.
- (3) Rotate planetary gear by hands and install on ring gear.



21078TM114

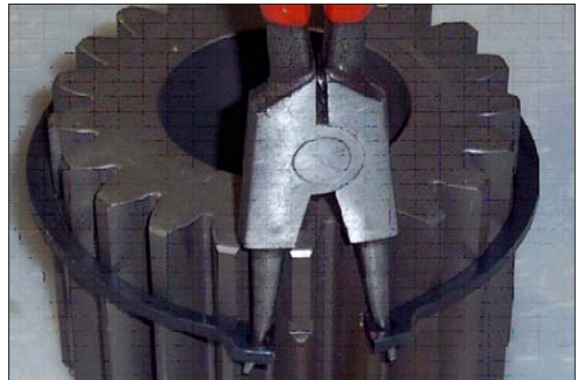
11)Installing No.2 sun gear(91-2)

- (1) Install No.2 sun gear on the spline of No.2 carrier and No.2 planetary gear, matching teeth of them.



21078TM115

- (2) Install No.2 sun gear on the spline of No.2 carrier and No.2 planetary gear, matching teeth of them.



21078TM116

12)Installing No.1 carrier sub assembly

- (1) Install M10 eye-bolt on No.2 carrier assembly.
- (2) Lift No.1 carrier assembly and then, slowly put it down on ring gear.
- (3) Rotate planetary gear by hands and install on ring gear.



21078TM117

13)Installing No.1 sun gear(92)

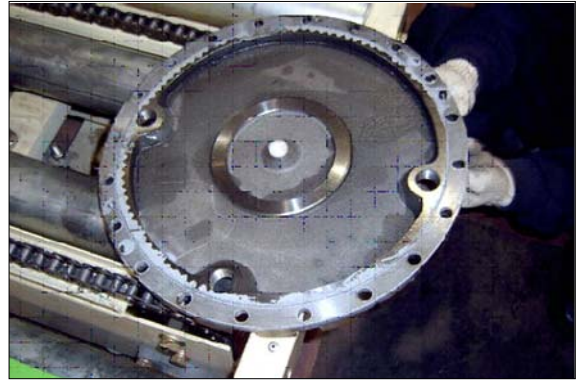
- (1) Put down No.1 sun gear on No.1 carrier, maintaining it vertical with spline of coupling.
- (2) Install No.1 sun gear on No.1 planetary gear, matching their teeth.



21078TM118

14)Installing cover(93)

- (1) Beat pad(94) with plastic hammer, and press it into the center of cover.
- (2) Apply three bond #1104(locktite#515) on the ring gear for cover without gap.
- (3) Put cover on ring gear, apply locktite (#262) on M12 hexagon socket head bolt, and then, bolt.



21078TM119

- (4) Fill gear oil(7.5liter) into drain port.
- (5) Apply gear oil on PF3/4 hydraulic plug(97) and then, bolt.



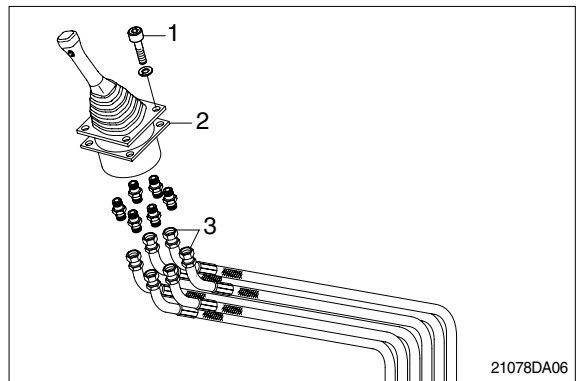
21078TM120

GROUP 7 RCV LEVER

1. REMOVAL AND INSTALL

1) REMOVAL

- (1) Lower the work equipment to the ground and stop the engine.
- (2) Operate the control levers and pedals several times to release the remaining pressure in the hydraulic piping.
- (3) Loosen the breather slowly to release the pressure inside the hydraulic tank.
- ▲ Escaping fluid under pressure can penetrate the skin causing serious injury.
- (4) Loosen the socket bolt(1).
- (5) Remove the cover of the console box.
- (6) Disconnect pilot line hoses(3).
- (7) Remove the pilot valve assembly(2).
- ※ When removing the pilot valve assembly, check that all the hoses have been disconnected.

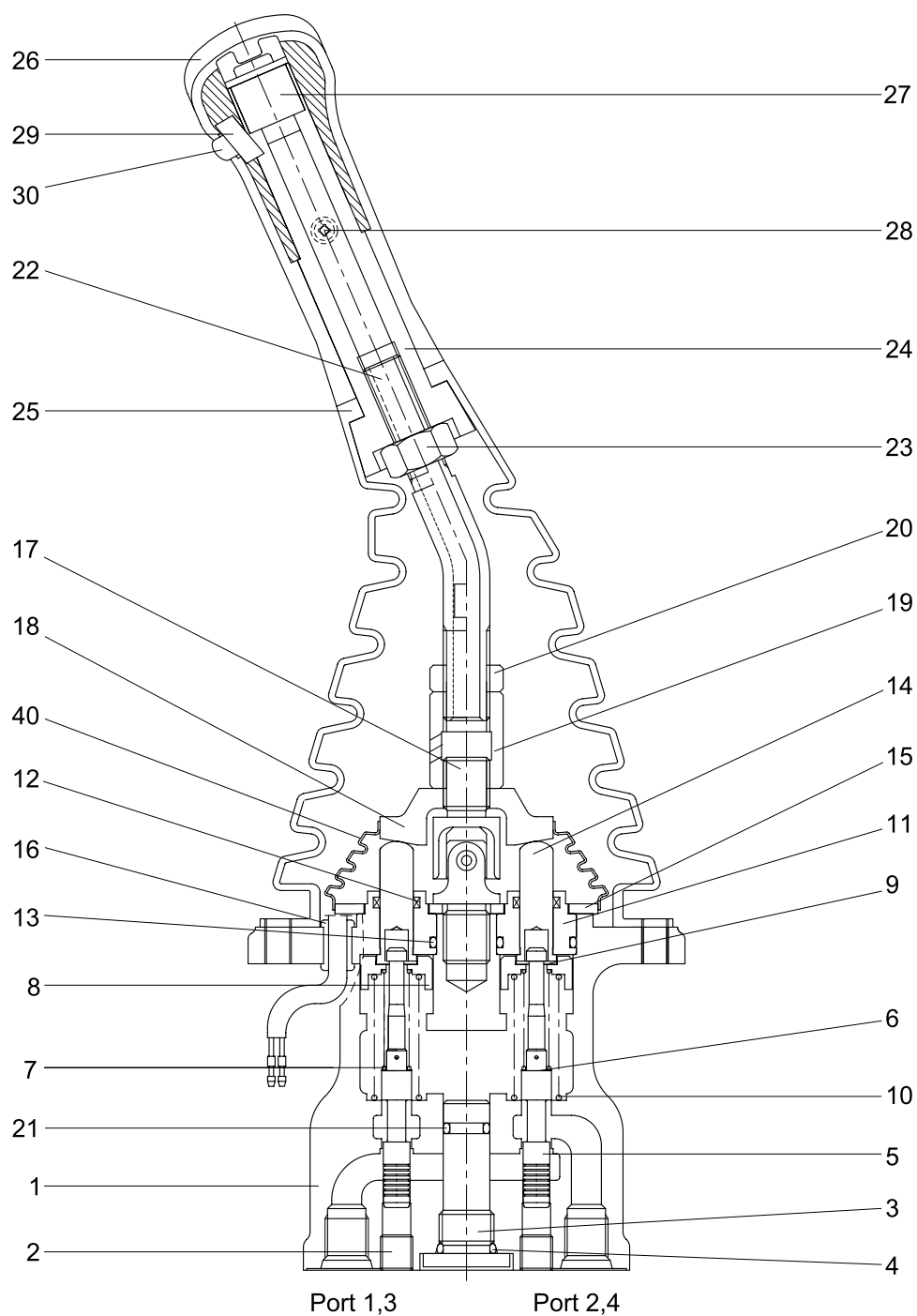


2) INSTALL

- (1) Carry out installation in the reverse order to removal.
- (2) Confirm the hydraulic oil level and check the hydraulic oil leak or not.

2. DISASSEMBLY AND ASSEMBLY

1) STRUCTURE

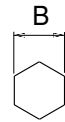


14072SF80

| | | | | | |
|----|-------------|----|----------------|----|------------------|
| 1 | Case | 11 | Plug | 21 | O-ring |
| 2 | Plug | 12 | Rod seal | 22 | Handle connector |
| 3 | Plug | 13 | O-ring | 23 | Nut |
| 4 | O-ring | 14 | Push rod | 24 | Insert |
| 5 | Spool | 15 | Plate | 25 | Boot |
| 6 | Shim | 16 | Bushing | 26 | Handle |
| 7 | Spring | 17 | Joint assembly | 27 | Switch assembly |
| 8 | Spring seat | 18 | Swash plate | 28 | Screw |
| 9 | Stopper | 19 | Adjusting nut | 29 | Switch assembly |
| 10 | Spring | 20 | Lock nut | 30 | Switch cover |
| | | | | 40 | Boot |

2) TOOLS AND TIGHTENING TORQUE

(1) Tools

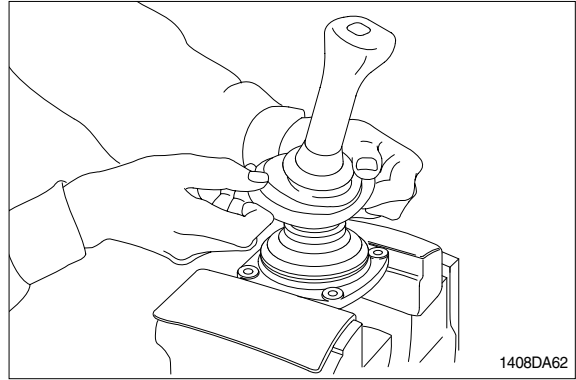
| Tool name | Remark | |
|---------------|--|---|
| Allen wrench | 6 |  |
| Spanner | 22 | |
| | 27 | |
| (+) Driver | Length 150 | |
| (-) Driver | Width 4~5 | |
| Torque wrench | Capable of tightening with the specified torques | |

(2) Tightening torque

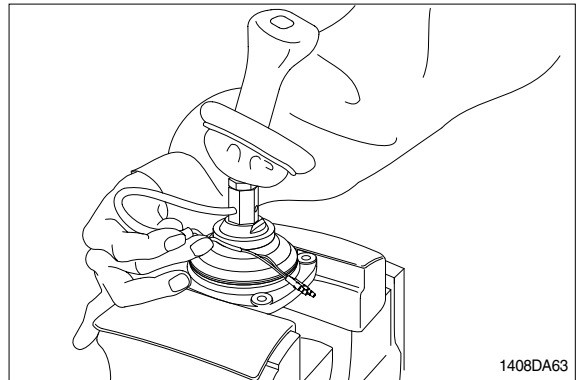
| Part name | Item | Size | Torque | |
|---------------|------|--------|----------|----------|
| | | | kgf · m | lbf · ft |
| Plug | 2 | PT 1/8 | 3.0 | 21.7 |
| Joint | 18 | M14 | 3.5 | 25.3 |
| Swash plate | 19 | M14 | 5.0±0.35 | 36.2±2.5 |
| Adjusting nut | 20 | M14 | 5.0±0.35 | 36.2±2.5 |
| Lock nut | 21 | M14 | 5.0±0.35 | 36.2±2.5 |
| Screw | 29 | M 3 | 0.05 | 0.36 |

3) DISASSEMBLY

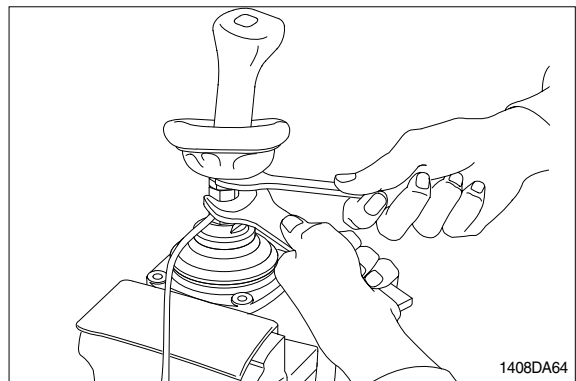
- (1) Clean pilot valve with kerosene.
 - ※ Put blind plugs into all ports
- (2) Fix pilot valve in a vise with copper(or lead) sheets.
- (3) Remove end of boot(25) from case(1) and take it out upwards.



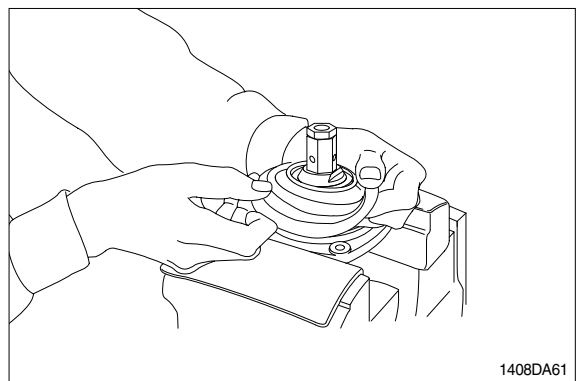
- ※ For valve with switch, remove cord also through hole of casing.



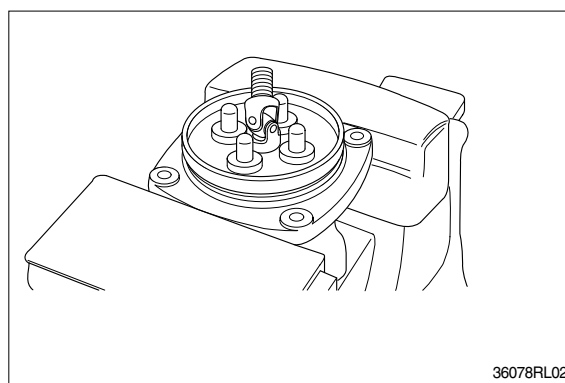
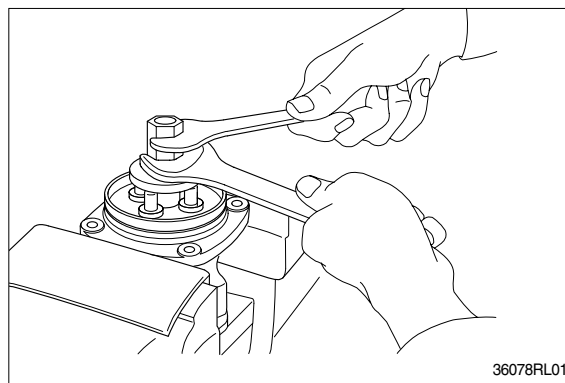
- (4) Loosen lock nut(20) and adjusting nut(19) with spanners on them respectively, and take out handle section as one body.



- (5) Remove the boot(40)

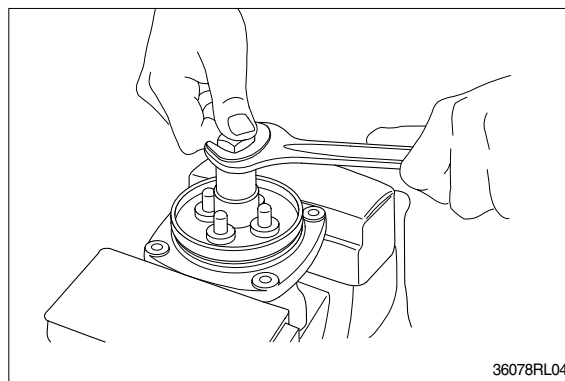
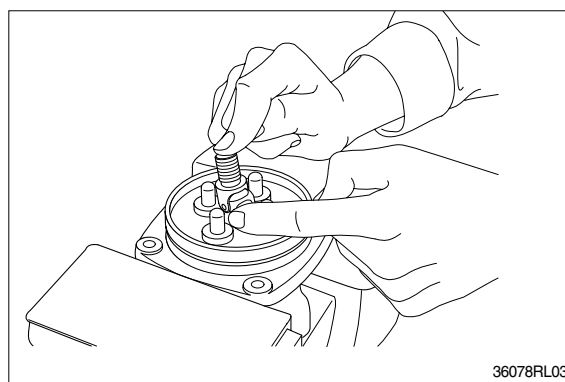


- (6) Loosen adjusting nut(19) and plate(18) with spanners on them respectively, and remove them.

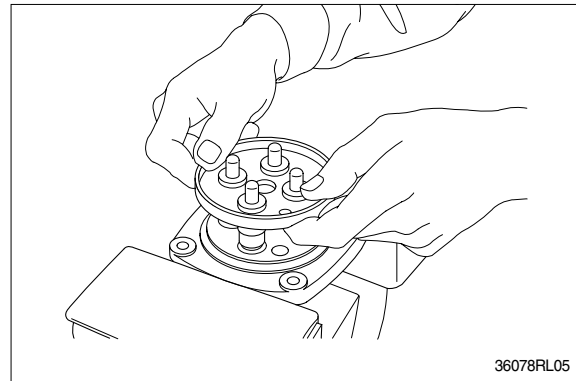


- (7) Turn joint anticlockwise to loosen it, utilizing jig(Special tool).

※ When return spring(10) is strong in force, plate(15), plug(11) and push rod(14) will come up on loosening joint. Pay attention to this.



(8) Remove plate(15).



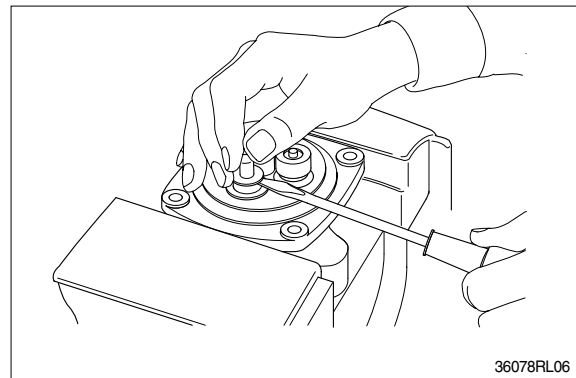
(9) When return spring(10) is weak in force, plug(11) stays in casing because of sliding resistance of O-ring.

※ Take it out with minus screwdriver.

Take it out, utilizing external periphery groove of plug and paying attention not to damage it by partial loading.

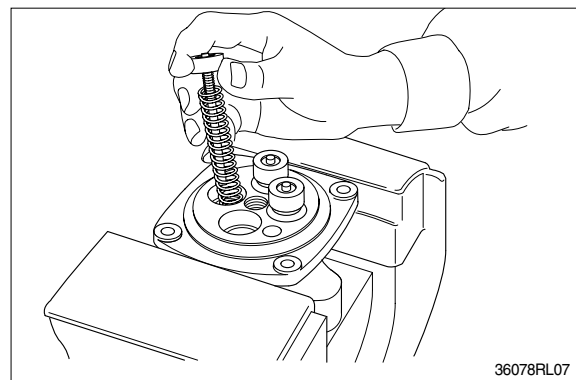
※ During taking out, plug may jump up due to return spring(10) force.

Pay attention to this.

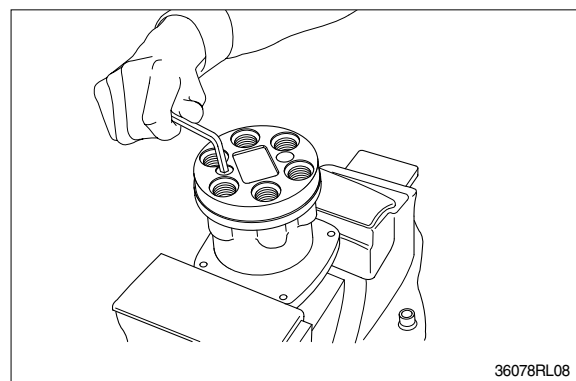


(10) Remove reducing valve subassembly and return spring(10) out of casing.

※ Record relative position of reducing valve subassembly and return springs.

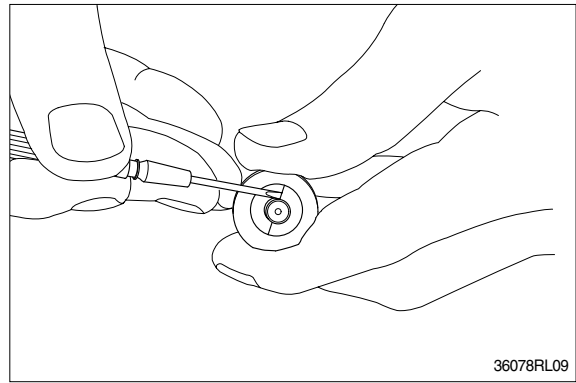


(11) Loosen hexagon socket head plug(2) with hexagon socket screw key.



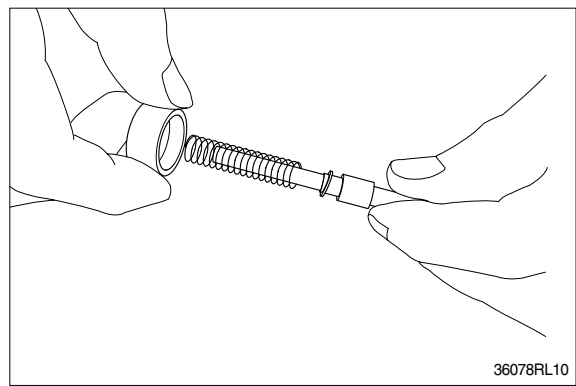
(12) For disassembling reducing valve section, stand it vertically with spool(5) bottom placed on flat workbench. Push down spring seat(8) and remove two pieces of semicircular stopper(9) with tip of small minus screwdriver.

- ※ Pay attention not to damage spool surface.
- ※ Record original position of spring seat(8, 31).
- ※ Do not push down spring seat more than 6mm.

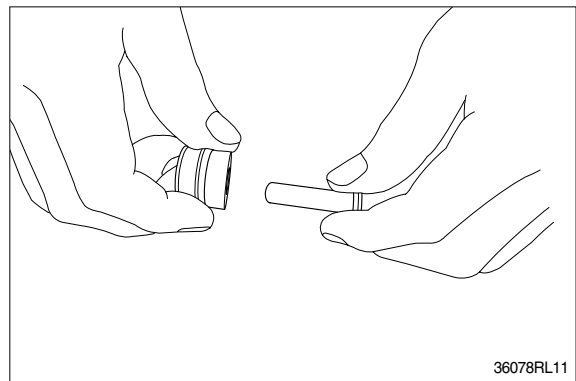


(13) Separate spool(5), spring seat(8), spring(7) and shim(6) individually.

- ※ Until being assembled, they should be handled as one subassembly group.

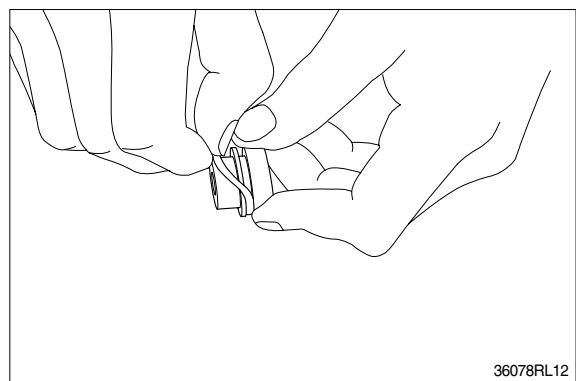


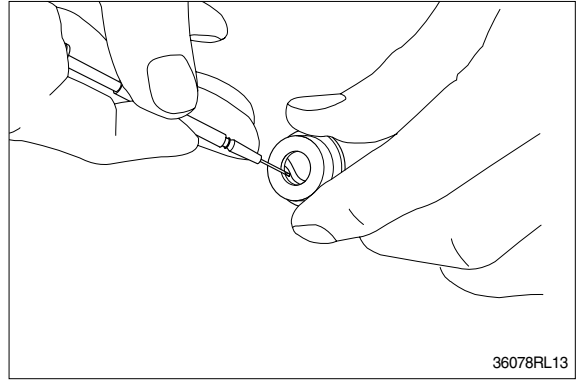
(14) Take push rod(14) out of plug(11).



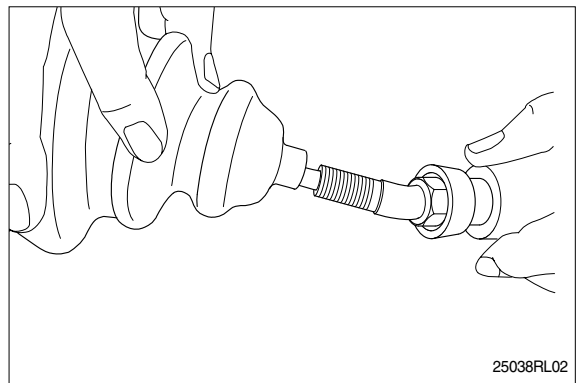
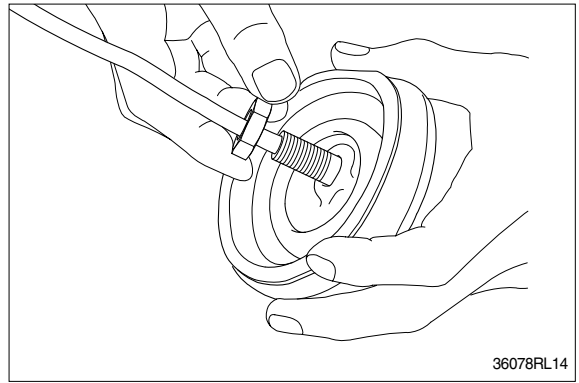
(15) Remove O-ring(13) and seal(12) from plug(11).

Use small minus screwdriver or so on to remove this seal.





(16) Remove lock nut(20) and then boot(25).



(17) Cleaning of parts

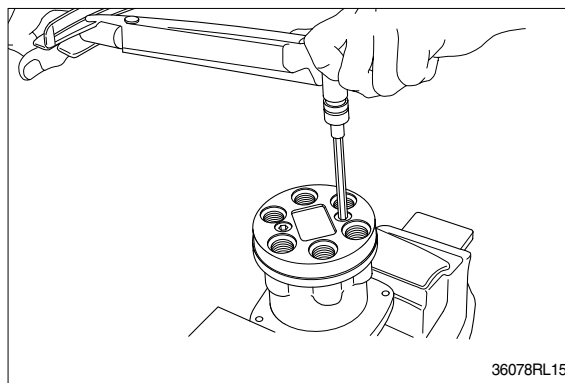
- ① Put all parts in rough cleaning vessel filled with kerosene and clean them (Rough cleaning).
 - ※ If dirty part is cleaned with kerosene just after putting it in vessel, it may be damaged. Leave it in kerosene for a while to loosen dust and dirty oil.
 - ※ If this kerosene is polluted, parts will be damaged and functions of reassembled valve will be degraded.
Therefore, control cleanliness of kerosene fully.
- ② Put parts in final cleaning vessel filled with kerosene, turning it slowly to clean them even to their insides (Finish cleaning).
 - ※ Do not dry parts with compressed air, since they will be damaged and/or rusted by dust and moisture in air.

(18) Rust prevention of parts.

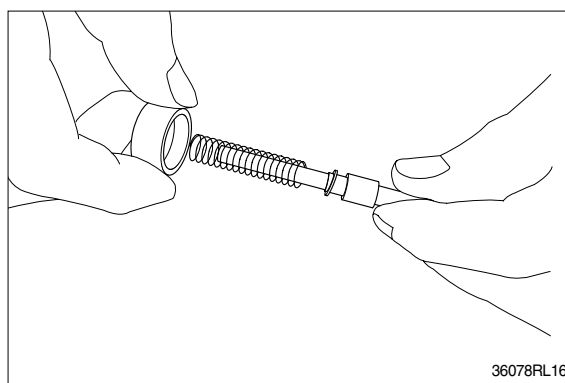
- Apply rust-preventives to all parts.
- ※ If left as they are after being cleaned, they will be rusted and will not display their functions fully after being reassembled.

4) ASSEMBLY

- (1) Tighten hexagon socket head plug(2) to the specified torque.
- ※ Tighten two bolts alternately and slowly.

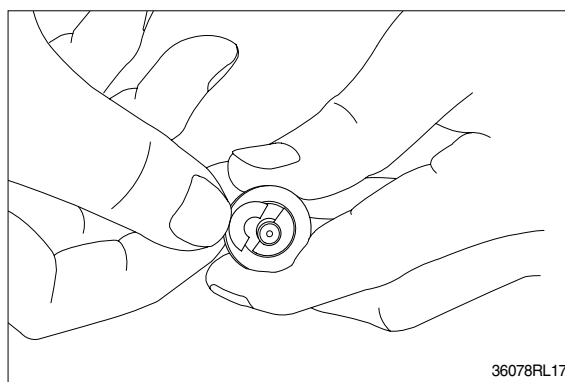


- (2) Put shim(6), springs(7) and spring seat(8) onto spool(5) in this order.

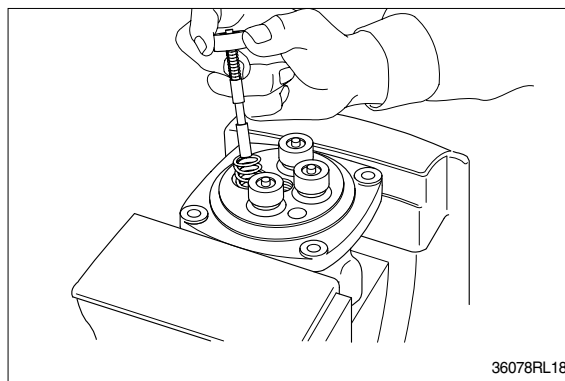


- (3) Stand spool vertically with its bottom placed on flat workbench, and with spring seat pushed down, put two pieces of semicircular stopper(9) on spring seat without piling them on.

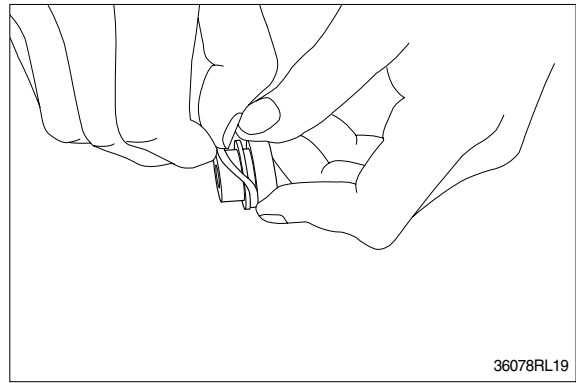
- ※ Assemble stopper(9) so that its sharp edge side will be caught by head of spool. Do not push down spring seat more than 6mm.



- (4) Assemble spring(10) into casing(1).
Assemble reducing valve subassembly into casing.
- ※ Assemble them to their original positions.

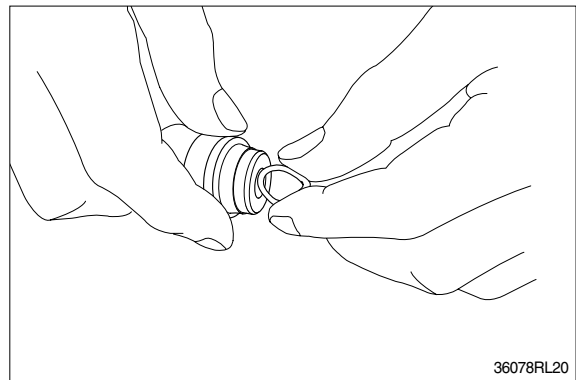


(5) Assemble O-ring(13) onto plug(11).



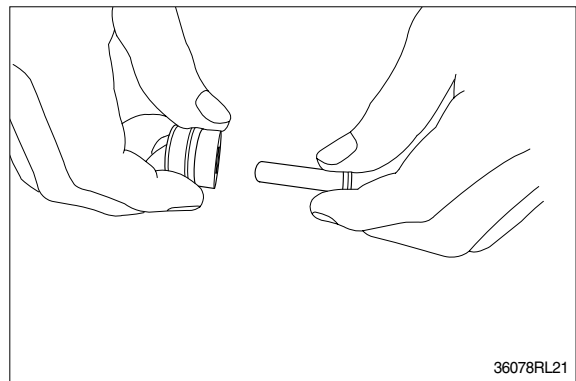
(6) Assemble seal(12) to plug(11).

※ Assemble seal in such lip direction as shown below.



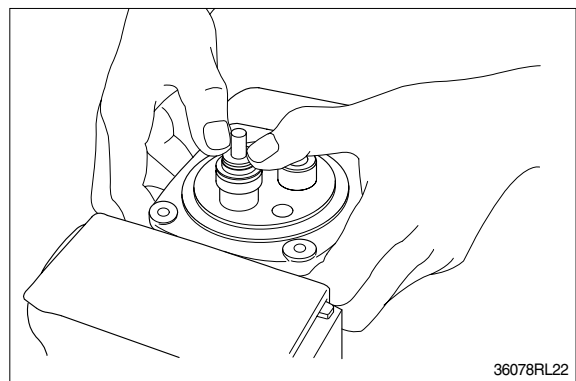
(7) Assemble push rod(14) to plug(11).

※ Apply working oil on push-rod surface.

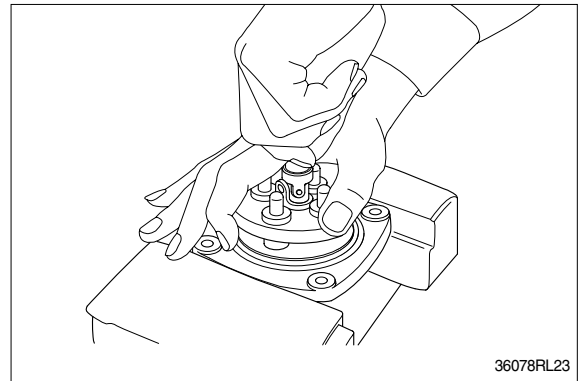


(8) Assemble plug subassembly to casing.

※ When return spring is weak in force, subassembly stops due to resistance of O-ring.

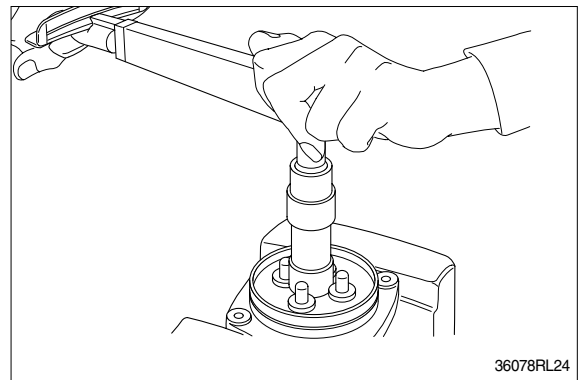


- (9) When return spring is strong in force, assemble 4 sets at the same time, utilizing plate(15), and tighten joint(17) temporarily.



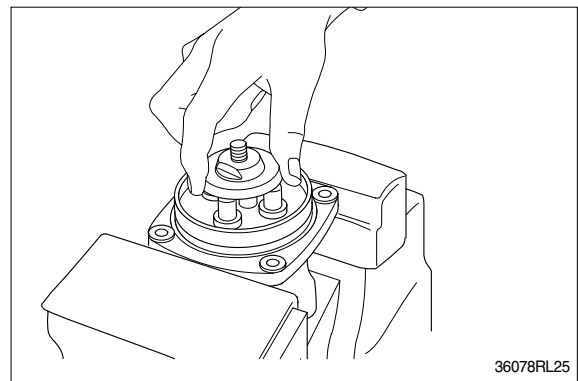
- (10) Fit plate(15).

- (11) Tighten joint(17) with the specified torque to casing, utilizing jig.



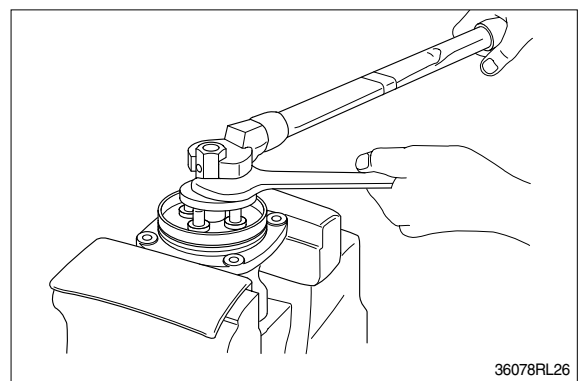
- (12) Assemble swash plate(18) to joint(17).

- ※ Screw it to position that it contacts with 4 push rods evenly.
- ※ Do not screw it over.

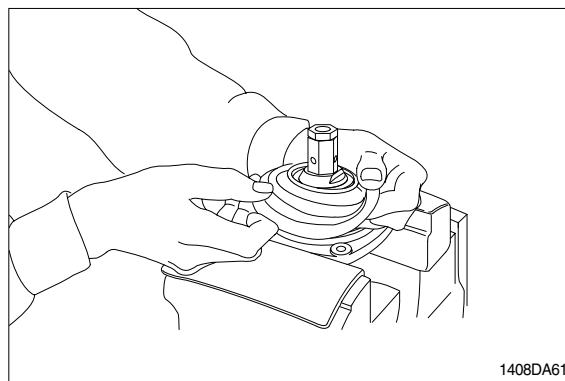


- (13) Assemble adjusting nut(19), apply spanner to width across flat of plate(18) to fix it, and tighten adjusting nut to the specified torque.

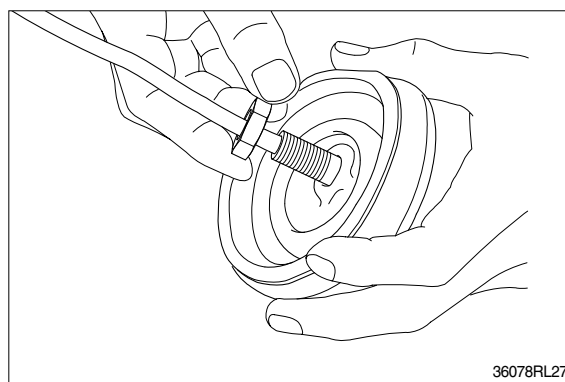
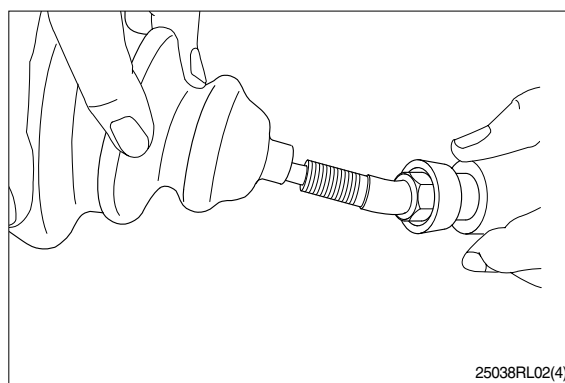
- ※ During tightening, do not change position of disk.



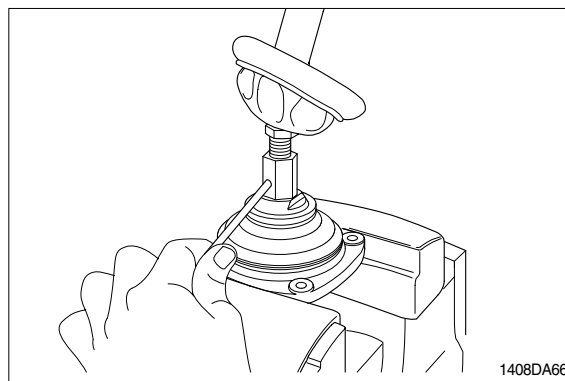
(14) Fit boot(40) to plate.



(15) Fit boot(25) and lock nut(20), and handle subassembly is assembled completely.

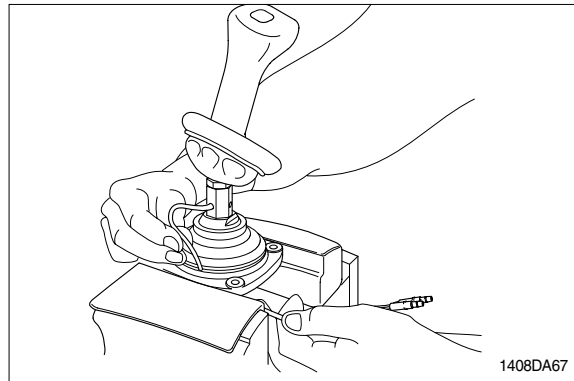


(16) Pull out cord and tube through adjusting nut hole provided in direction 60° to 120° from casing hole.

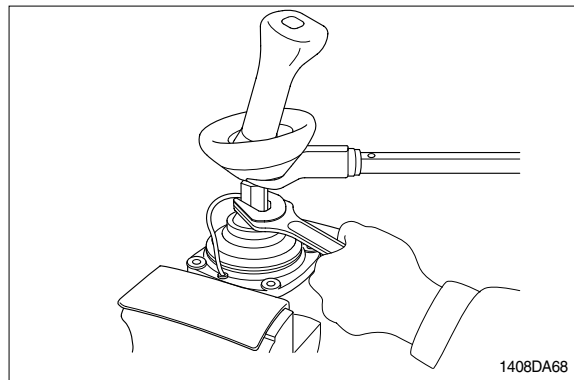


(17) Assemble bushing(16) to plate and pass cord and tube through it.

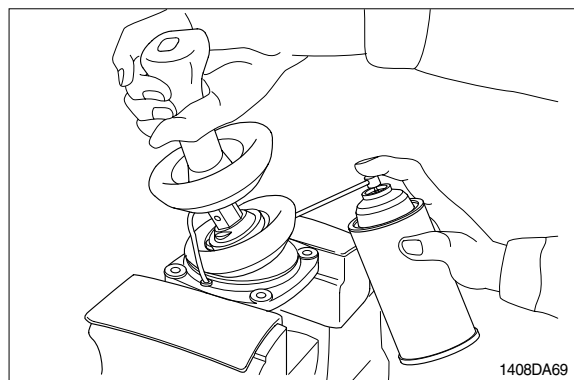
※ Provide margin necessary to operation.



(18) Determine handle direction, tighten lock nut(20) to specified torque to fix handle.

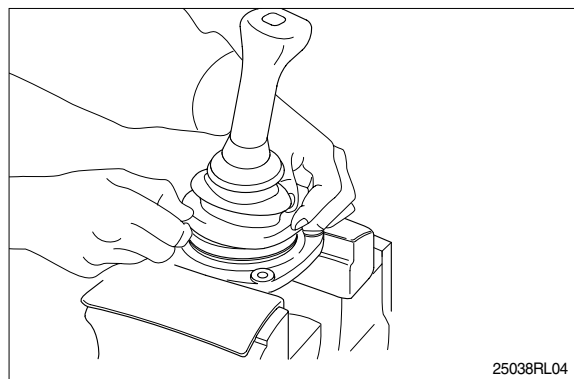


(19) Apply grease to rotating section of joint and contacting faces of disk and push rod.



(20) Assemble lower end of bellows to casing.

(21) Inject volatile rust-preventives through all ports and then put blind plugs in ports.

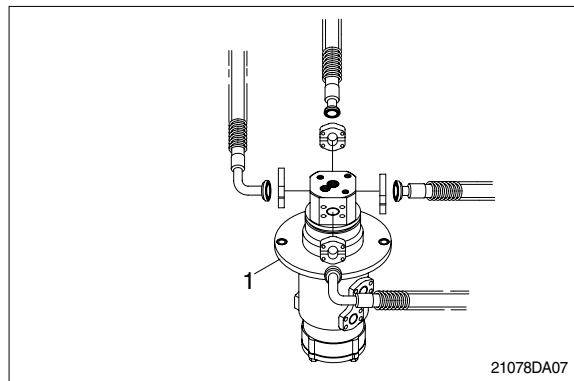


GROUP 8 TURNING JOINT

1. REMOVAL AND INSTALL

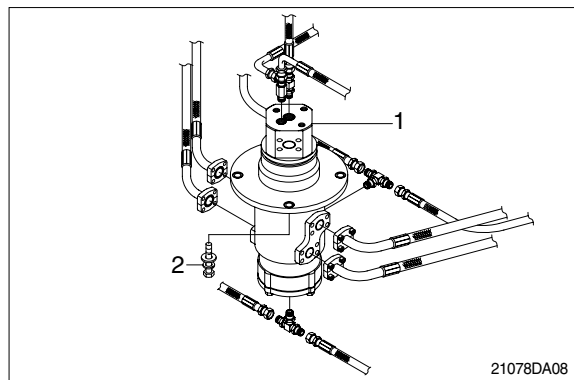
1) REMOVAL

- (1) Lower the work equipment to the ground and stop the engine.
- (2) Operate the control levers and pedals several times to release the remaining pressure in the hydraulic piping.
- (3) Loosen the breather slowly to release the pressure inside the hydraulic tank.
- ▲ Escaping fluid under pressure can penetrate the skin causing serious injury.
- ※ When pipes and hoses are disconnected, the oil inside the piping will flow out, so catch it in oil pan.
- (4) Disconnect all hoses.
- (5) Sling the turning joint assembly (1) and remove the mounting bolt(2).
- Weight : 54kg(119lb)
- Tightening torque : $12.3 \pm 1.3 \text{ kgf} \cdot \text{m}$
($88.9 \pm 9.4 \text{ lbf} \cdot \text{ft}$)
- (6) Remove the turning joint assembly.
- ※ When removing the turning joint, check that all the hoses have been disconnected.



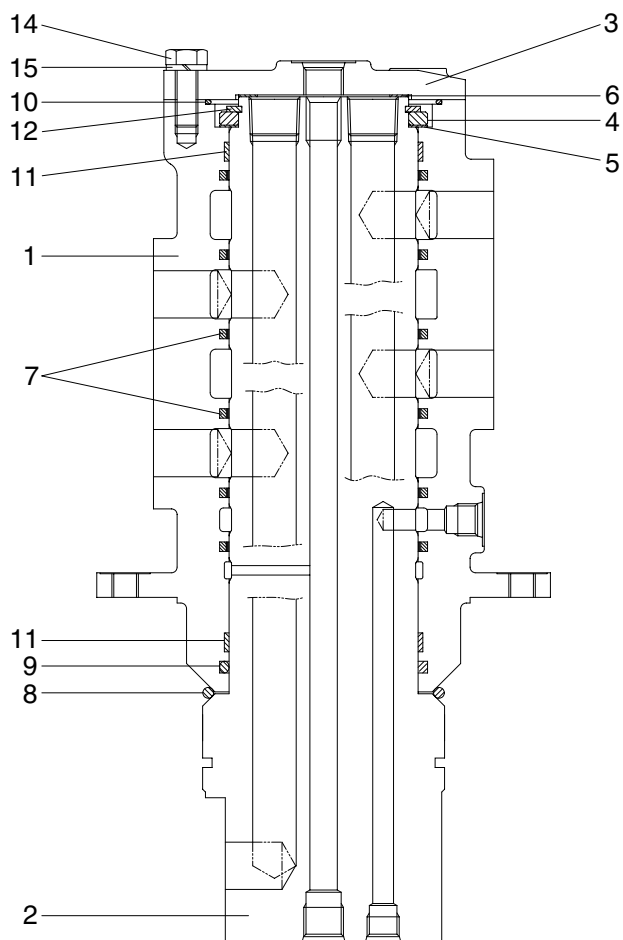
2) INSTALL

- (1) Carry out installation in the reverse order to removal.
- ※ Take care of turning joint direction.
- ※ Assemble hoses to their original positions.
- ※ Confirm the hydraulic oil level and check the hydraulic oil leak or not.



2. DISASSEMBLY AND ASSEMBLY

1) STRUCTURE



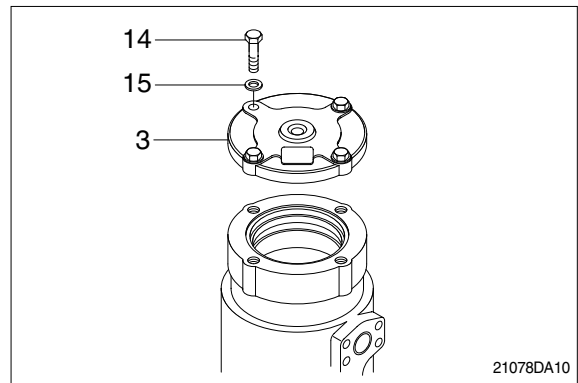
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- | | | | | | |
|---|--------|----|--------------|----|---------------|
| 1 | Hub | 6 | Shim | 11 | Wear ring |
| 2 | Shaft | 7 | Slipper seal | 12 | Retainer ring |
| 3 | Cover | 8 | O-ring | 13 | Plug |
| 4 | Spacer | 9 | O-ring | 14 | Hexagon bolt |
| 5 | Shim | 10 | O-ring | 15 | Spring washer |

2) DISASSEMBLY

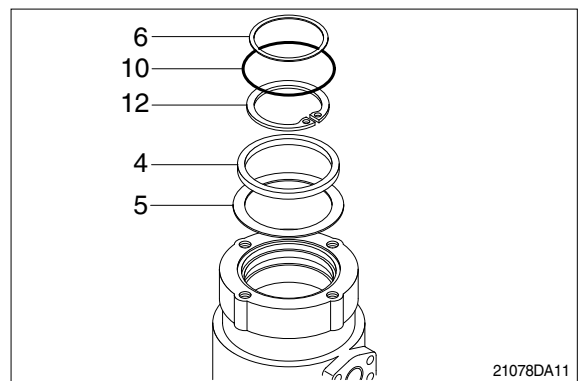
※ Before the disassembly, clean the turning joint.

- (1) Remove bolts(14), washer(15) and cover(3).



- (2) Remove shim(6) and O-ring(10).

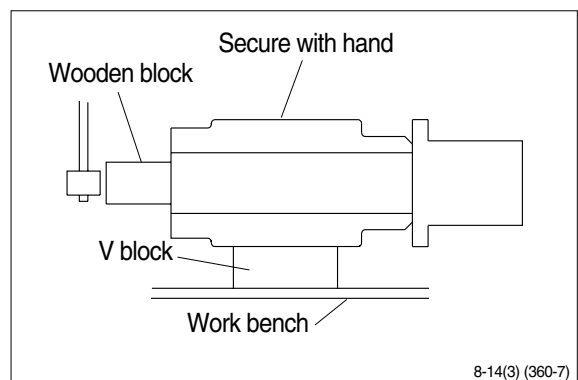
- (3) Remove retainer ring(12), spacer(4) and shim(5).



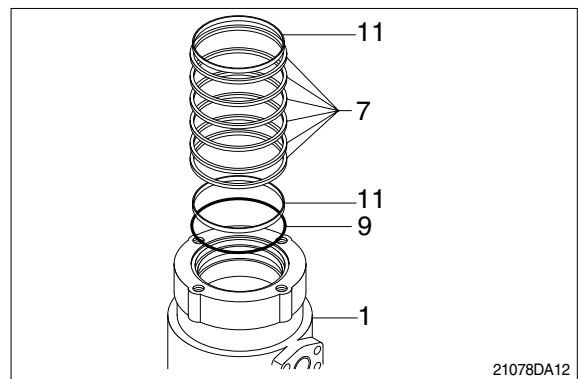
- (4) Place hub(1) on a V-block and by using a wood buffer at the shaft end, hit out shaft(2) to about 1/2 from the body with a hammer.

※ Take care not to damage the shaft(2) when remove hub(1) or rest it sideways.

※ Put a fitting mark on hub(1) and shaft(2).



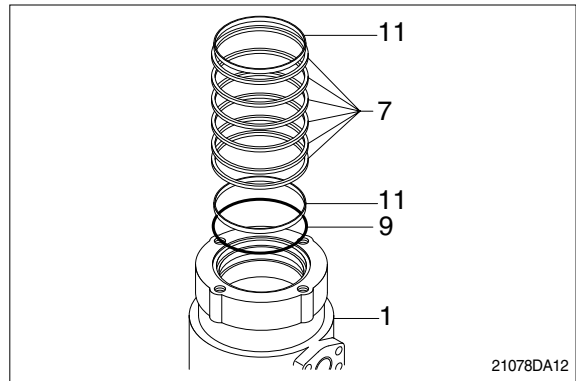
- (5) Remove six slipper seals(7) and O-ring(9), two ring wear(11) from hub(1).



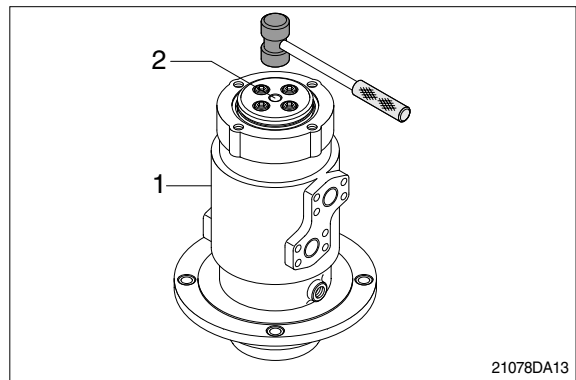
3) ASSEMBLY

- ※ Clean all parts.
- ※ As a general rule, replace oil seals and O-ring.
- ※ Coat the sliding surfaces of all parts with engine oil or grease before installing.

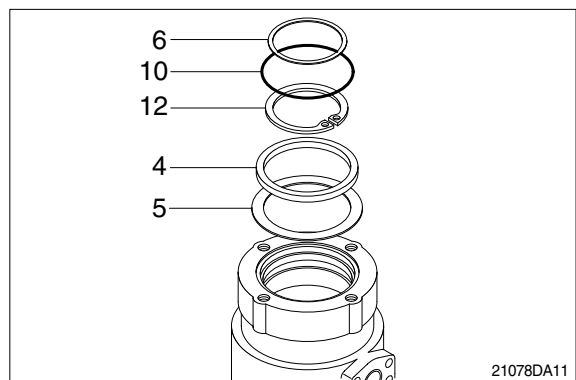
- (1) Fix seven slipper seal(7) and O-ring(9), two ring wear(11) to hub(1).
- (2) Fit O-ring(8) to shaft(2).



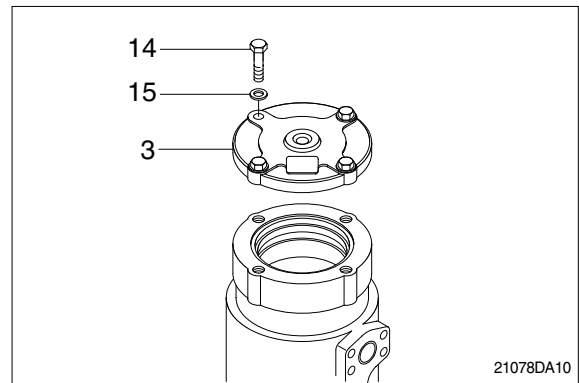
- (3) Set shaft(2) on block, tap hub(1) with a plastic hammer to install.



- (4) Fit shim(5), spacer(4) and retainer ring (12) to shaft(2).
- (5) Fit O-ring(10) to hub(1).
- (6) Fit shim(6) to shaft(2).



- (7) Install cover(3) to body(1) and tighten bolts(14).
- Torque : 10~12.5kgf · m(72.3~90.4lbf · ft)



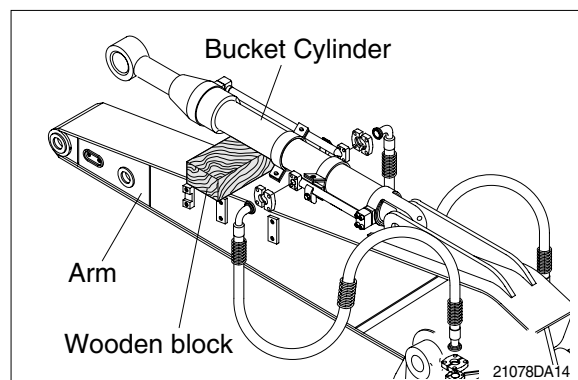
GROUP 9 BOOM, ARM AND BUCKET CYLINDER

1. REMOVAL AND INSTALL

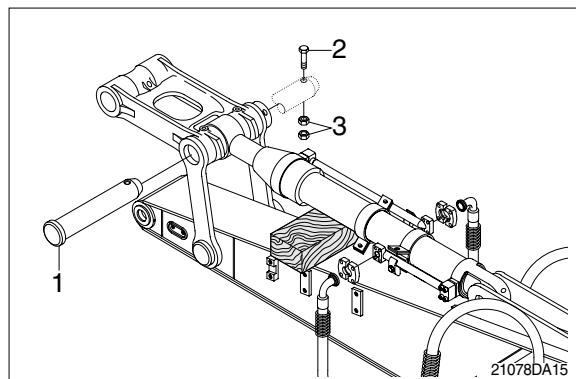
1) BUCKET CYLINDER

(1) Removal

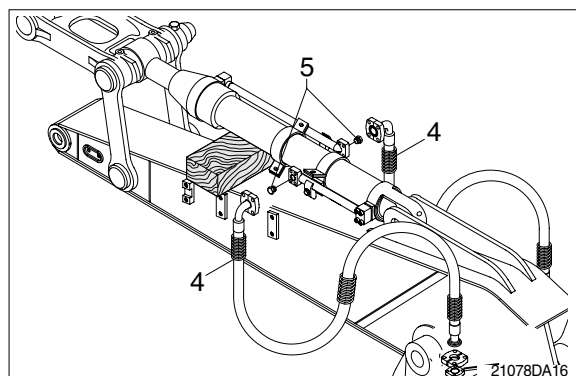
- ※ Expand the arm and bucket fully, lower the work equipment to the ground and stop the engine.
 - ※ Operate the control levers and pedals several times to release the remaining pressure in the hydraulic piping.
 - ▲ Loosen the breather slowly to release the pressure inside the hydraulic tank.
 - ※ Escaping fluid under pressure can penetrate the skin causing serious injury. Fit blind plugs in the hoses after disconnecting them, to prevent dirt or dust from entering.
- ① Set block between bucket cylinder and arm.



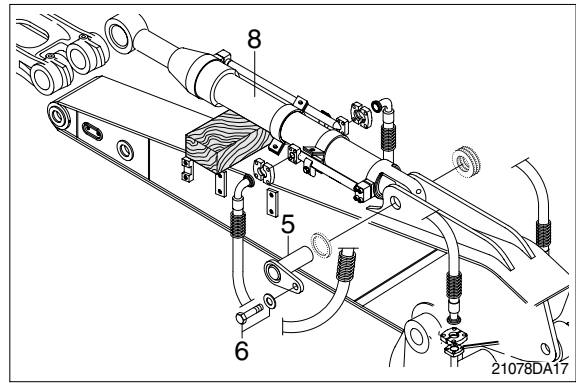
- ② Remove bolt(2), nut(3) and pull out pin (1).
- ※ Tie the rod with wire to prevent it from coming out.



- ③ Disconnect bucket cylinder hoses(4) and put plugs(5) on cylinder pipe.



- ④ Sling bucket cylinder assembly(8) and remove bolt(6) then pull out pin (5).
- ⑤ Remove bucket cylinder assembly(8).
 - Weight : 174kg(384lb)



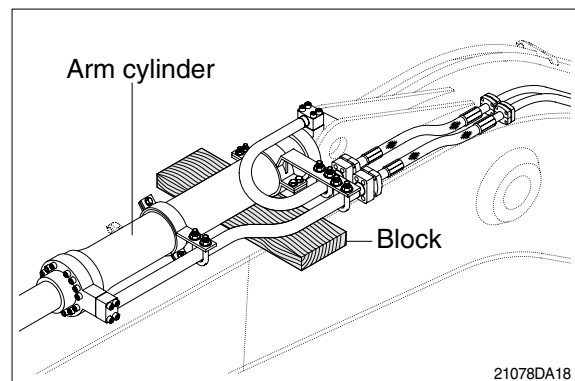
(2) Install

- ① Carry out installation in the reverse order to removal.
- ▲ When aligning the mounting position of the pin, do not insert your fingers in the pin hole.
- ※ Bleed the air from the bucket cylinder.
 - ※ Confirm the hydraulic oil level and check the hydraulic oil leak or not.

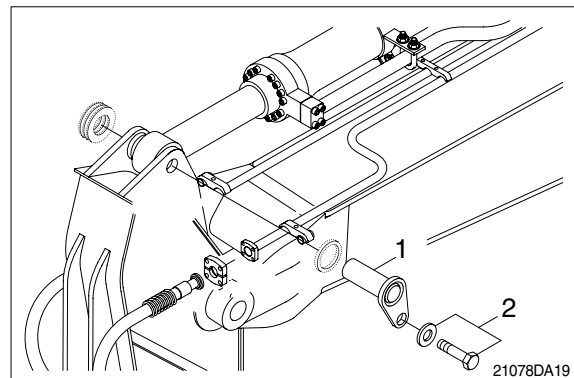
2) ARM CYLINDER

(1) Removal

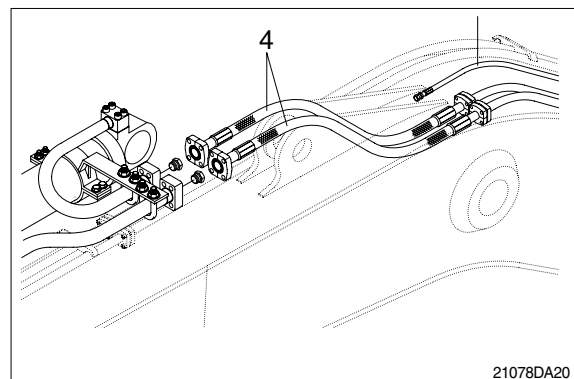
- ※ Expand the arm and bucket fully, lower the work equipment to the ground and stop the engine.
 - ※ Operate the control levers and pedals several times to release the remaining pressure in the hydraulic piping.
 - ⚠ Loosen the breather slowly to release the pressure inside the hydraulic tank.
 - ※ Escaping fluid under pressure can penetrate the skin causing serious injury. Fit blind plugs in the hoses after disconnecting them, to prevent dirt or dust from entering.
- ① Set block between arm cylinder and boom.



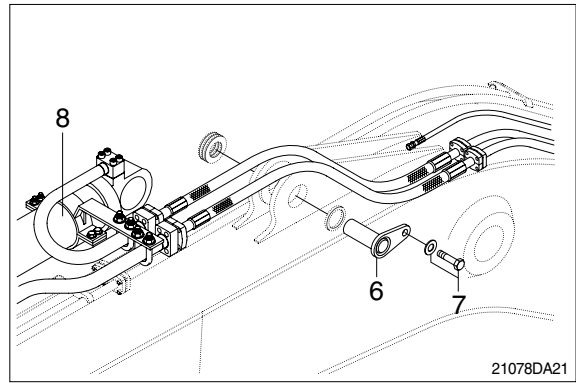
- ② Remove bolt(2) and pull out pin(1).
- ※ Tie the rod with wire to prevent it from coming out.



- ③ Disconnect arm cylinder hoses(4) and put plugs on cylinder pipe.
- ④ Disconnect greasing pipings(5).



- ⑤ Sling arm assembly(8) and remove bolt (7) then pull out pin(6).
- ⑥ Remove arm cylinder assembly(8).
 - Weight : 288kg(635lb)



(2) Install

- ① Carry out installation in the reverse order to removal.
- ▲ When aligning the mounting position of the pin, do not insert your fingers in the pin hole.
- ※ Bleed the air from the arm cylinder.
 - ※ Confirm the hydraulic oil level and check the hydraulic oil leak or not.

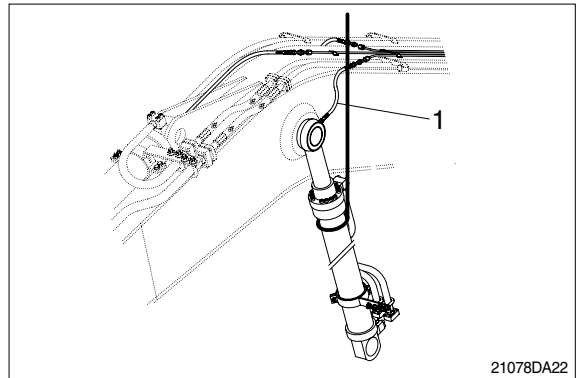
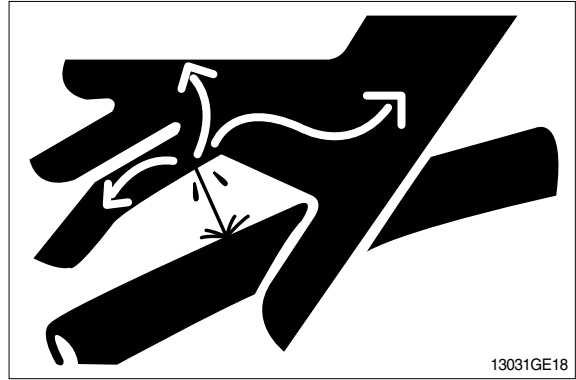
3) BOOM CYLINDER

(1) Removal

- ※ Expand the arm and bucket fully, lower the work equipment to the ground and stop the engine.
- ※ Operate the control levers and pedals several times to release the remaining pressure in the hydraulic piping.
- ▲ Loosen the breather slowly to release the pressure inside the hydraulic tank.
- ※ Escaping fluid under pressure can penetrate the skin causing serious injury. Fit blind plugs in the hoses after disconnecting them, to prevent dirt or dust from entering.

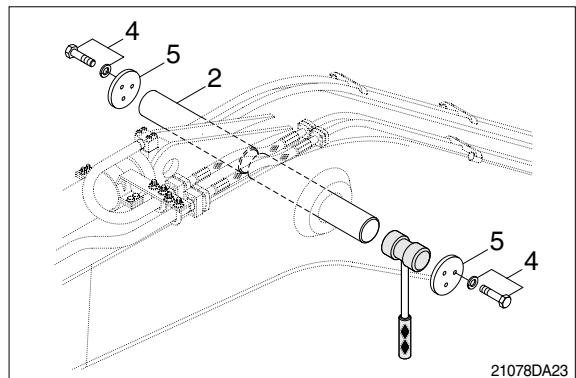
① Disconnect greasing hoses(1).

② Sling boom cylinder assembly.

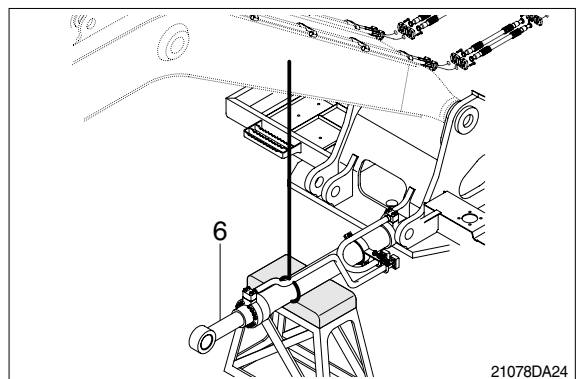


③ Remove bolt(4), stop plate(5) and pull out pin(2).

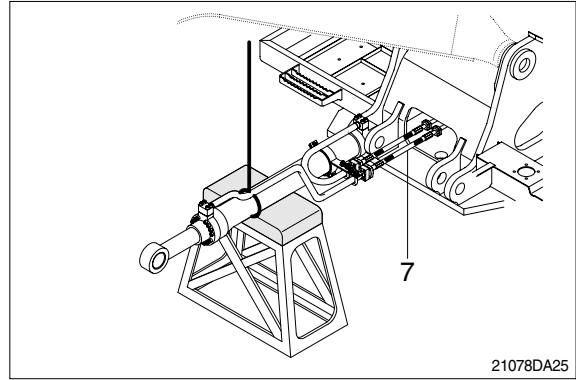
- ※ Tie the rod with wire to prevent it from coming out.



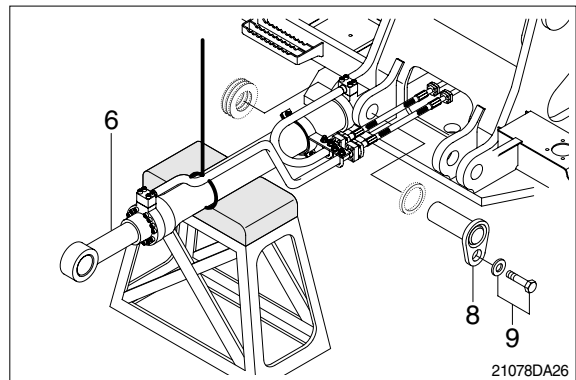
④ Lower the boom cylinder assembly(6) on a stand.



- ⑤ Disconnect boom cylinder hoses(7) and put plugs on cylinder pipe.



- ⑥ Remove bolt(9) and pull out pin(8).
⑦ Remove boom cylinder assembly(6).
· Weight : 182kg(386lb)



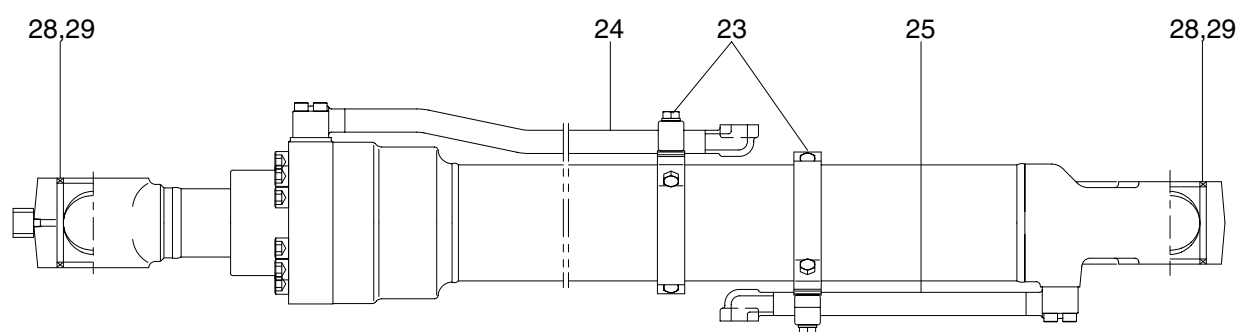
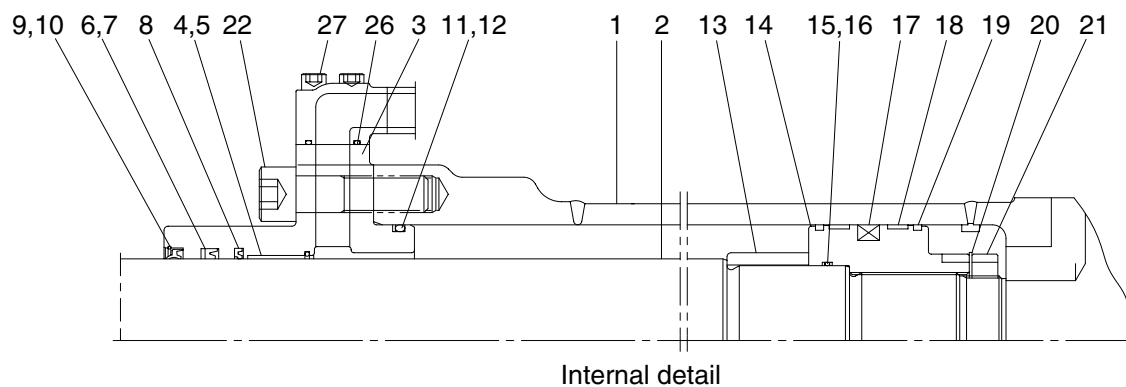
(2) Install

- ① Carry out installation in the reverse order to removal.
- ▲ When aligning the mounting position of the pin, do not insert your fingers in the pin hole.
- ※ Bleed the air from the boom cylinder.
 - ※ Confirmed the hydraulic oil level and check the hydraulic oil leak or not.

2. DISASSEMBLY AND ASSEMBLY

1) STRUCTURE

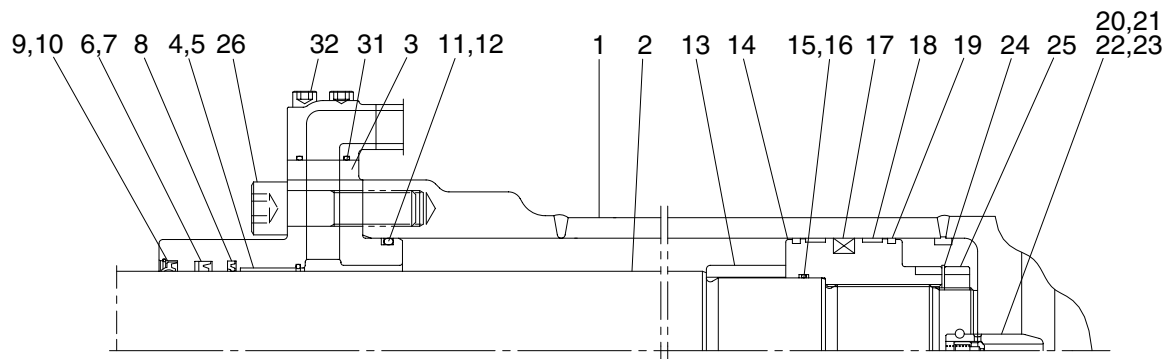
(1) Bucket cylinder



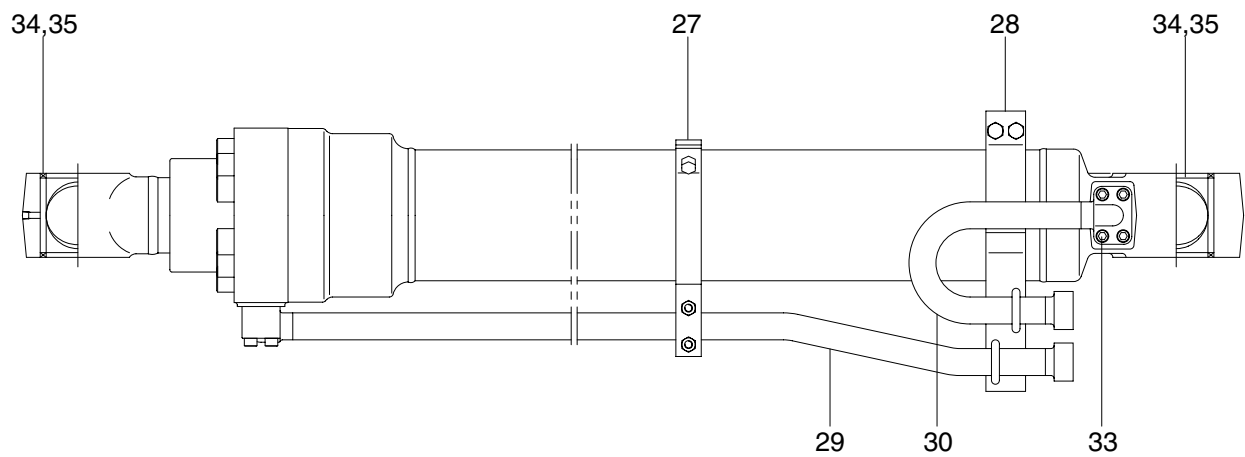
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| | | | | | |
|----|---------------|----|--------------|----|--------------------------|
| 1 | Tube assembly | 11 | O-ring | 21 | Lock nut |
| 2 | Rod assembly | 12 | Back up ring | 22 | Hexagon socket head bolt |
| 3 | Gland | 13 | Cushion ring | 23 | Band assembly |
| 4 | DD2 bushing | 14 | Piston | 24 | Pipe assembly(R) |
| 5 | Snap ring | 15 | O-ring | 25 | Pipe assembly(B) |
| 6 | Rod seal | 16 | Back up ring | 26 | O-ring |
| 7 | Back up ring | 17 | Piston seal | 27 | Hexagon socket head bolt |
| 8 | Buffer ring | 18 | Wear ring | 28 | Pin bushing |
| 9 | Dust wiper | 19 | Dust ring | 29 | Dust seal |
| 10 | Snap ring | 20 | Lock washer | | |

(2) Arm cylinder



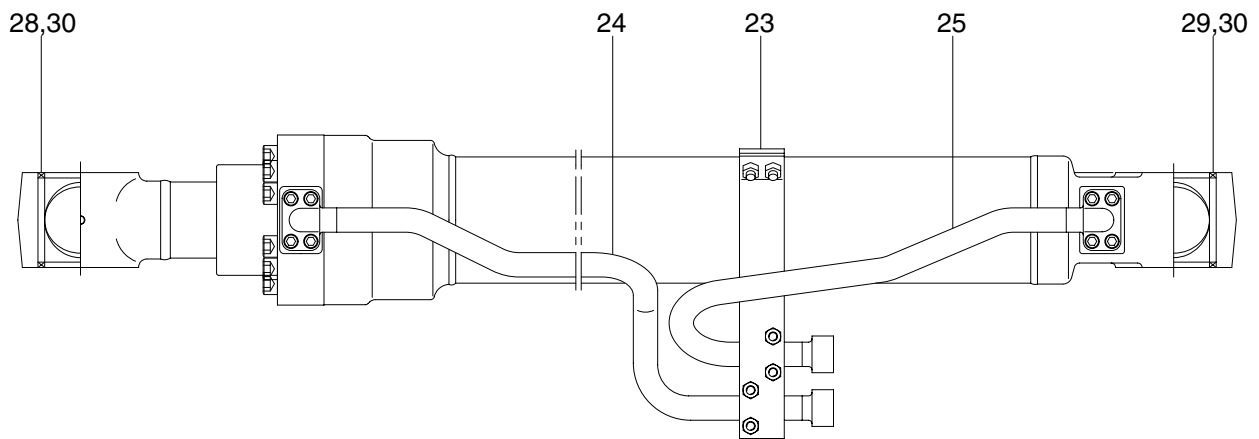
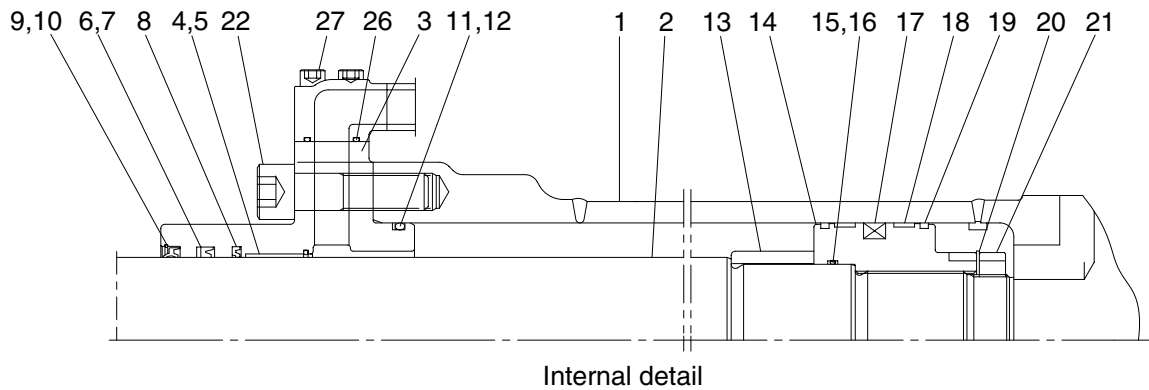
Internal detail



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- | | | |
|-----------------|------------------|-----------------------------|
| 1 Tube assembly | 13 Cushion ring | 25 Lock nut |
| 2 Rod assembly | 14 Piston | 26 Hexagon socket head bolt |
| 3 Gland | 15 O-ring | 27 Band assembly(R) |
| 4 DD2 bushing | 16 Back up ring | 28 Band assembly(B) |
| 5 O-ring | 17 Piston seal | 29 Pipe assembly(R) |
| 6 rod seal | 18 Wear ring | 30 Pipe assembly(B) |
| 7 Back up ring | 19 Dust ring | 31 O-ring |
| 8 Buffer ring | 20 Cushion spear | 32 Hexagon socket head bolt |
| 9 Dust wiper | 21 Check valve | 33 Hexagon socket head bolt |
| 10 Snap ring | 22 Coil spring | 34 Pin bushing |
| 11 O-ring | 23 Stop ring | 35 Dust seal |
| 12 Back up ring | 24 Lock washer | |

(3) Boom cylinder

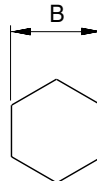


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| | | | | | |
|----|---------------|----|--------------|----|--------------------------|
| 1 | Tube assembly | 11 | O-ring | 21 | Lock nut |
| 2 | Rod assembly | 12 | Back up ring | 22 | Hexagon socket head bolt |
| 3 | Gland | 13 | Cushion ring | 23 | Band assembly |
| 4 | DD2 bushing | 14 | Piston | 24 | Pipe assembly(R) |
| 5 | Snap ring | 15 | O-ring | 25 | Pipe assembly(B) |
| 6 | Rod seal | 16 | Back up ring | 26 | O-ring |
| 7 | Back up ring | 17 | Piston seal | 27 | Hexagon socket head bolt |
| 8 | Buffer ring | 18 | Wear ring | 28 | Pin bushing |
| 9 | Dust wiper | 19 | Dust ring | 29 | Pin bushing |
| 10 | Snap ring | 20 | Lock washer | 30 | Dust seal |

2) TOOLS AND TIGHTENING TORQUE

(1) Tools

| Tool name | Remark | |
|---------------|--|---|
| Allen wrench | 6 |  |
| | 8 | |
| | 14 | |
| | 17 | |
| Spanner | 7 | |
| | 8 | |
| (-) Driver | Small and large sizes | |
| Torque wrench | Capable of tightening with the specified torques | |

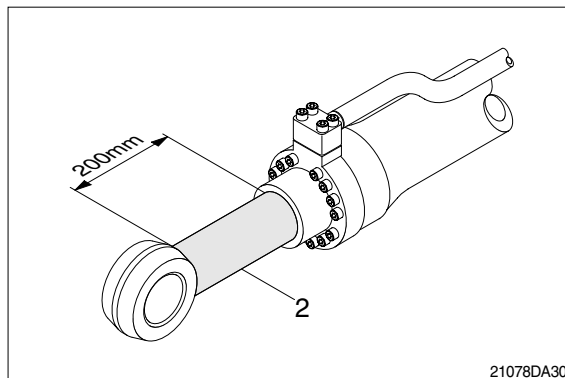
(2) Tightening torque

| Part name | | Item | Size | Torque | |
|------------------|-----------------|------|------|----------|-----------|
| | | | | kgf · m | lbf · ft |
| Socket head bolt | Bucket cylinder | 22 | M16 | 23.0±2.0 | 166± 14.5 |
| | Boom cylinder | 22 | M16 | 23.0±2.0 | 166± 14.5 |
| | Arm cylinder | 26 | M18 | 32.0±3.0 | 232± 21.7 |
| Socket head bolt | Bucket cylinder | 27 | M10 | 5.4±0.5 | 39.1± 3.6 |
| | Boom cylinder | 27 | M10 | 5.4±0.5 | 39.1± 3.6 |
| | Arm cylinder | 32 | M12 | 9.4±1.0 | 68.0± 7.2 |
| | | 33 | M10 | 5.4±0.5 | 39.1± 3.6 |
| Lock nut | Bucket cylinder | 21 | M60 | 100±10.0 | 723± 72.3 |
| | Boom cylinder | 21 | M60 | 100±10.0 | 723± 72.3 |
| | Arm cylinder | 25 | M70 | 100±10.0 | 723± 72.3 |
| Piston | Bucket cylinder | 14 | - | 150±15.0 | 1085± 109 |
| | Boom cylinder | 14 | - | 150±15.0 | 1085± 109 |
| | Arm cylinder | 14 | - | 150±15.0 | 1085± 109 |

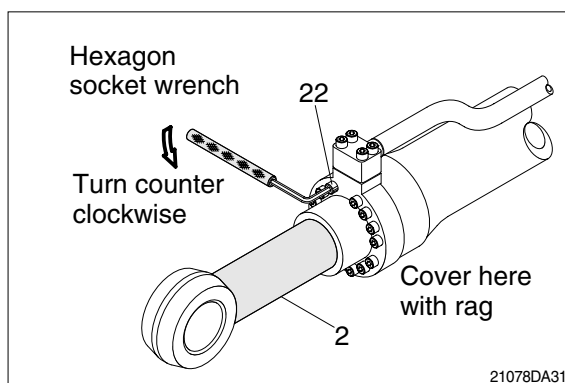
3) DISASSEMBLY

(1) Remove cylinder head and piston rod

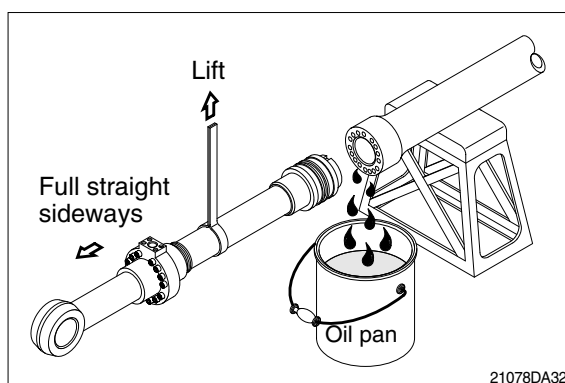
- ① Hold the clevis section of the tube in a vise.
 - ※ Use mouth pieces so as not to damage the machined surface of the cylinder tube. Do not make use of the outside piping as a locking means.
- ② Pull out rod assembly(2) about 200mm (7.1in). Because the rod assembly is rather heavy, finish extending it with air pressure after the oil draining operation.



- ③ Loosen and remove socket bolts(22) of the gland in sequence.
 - ※ Cover the extracted rod assembly(2) with rag to prevent it from being accidentally damaged during operation.

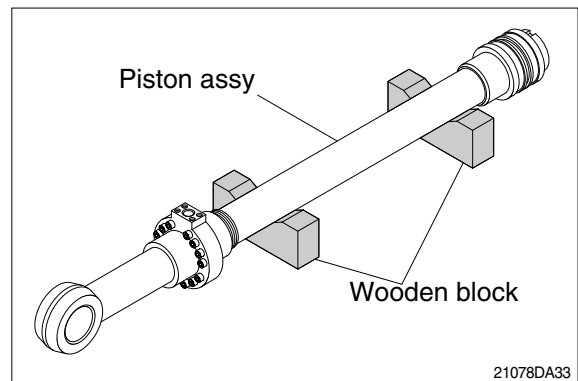


- ④ Draw out cylinder head and rod assembly together from tube assembly(1).
 - ※ Since the rod assembly is heavy in this case, lift the tip of the rod assembly(2) with a crane or some means and draw it out. However, when rod assembly(2) has been drawn out to approximately two thirds of its length, lift it in its center to draw it completely.



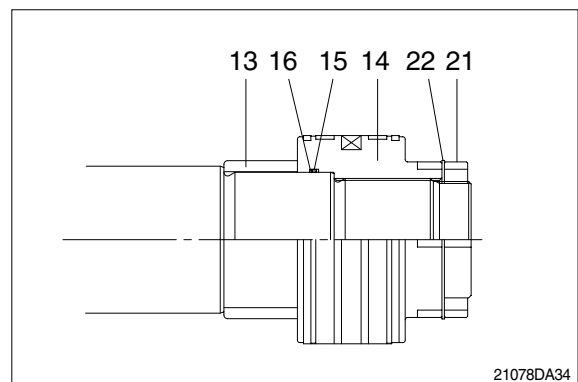
Note that the plated surface of rod assembly(2) is to be lifted. For this reason, do not use a wire sling and others that may damage it, but use a strong cloth belt or a rope.

- ⑤ Place the removed rod assembly on a wooden V-block that is set level.
- ※ Cover a V-block with soft rag.

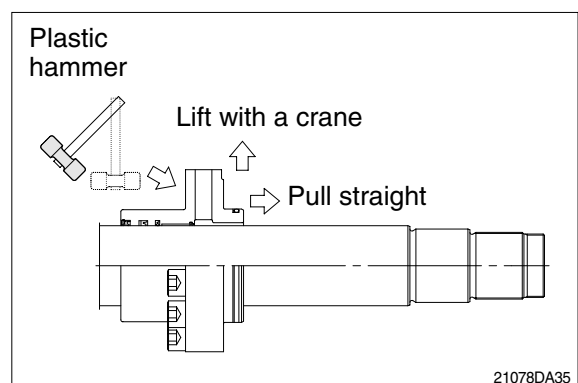


(2) Remove piston and cylinder head

- ① Remove lock nut(21).
- ※ Since lock nut(21) and lock washer(22) is tightened to a high torque, use a hydraulic and power wrench that utilizes a hydraulic cylinder, to remove the lock nut(21) and lock washer (22).
- ② Remove piston assembly(14), back up ring(16), and O-ring(15).

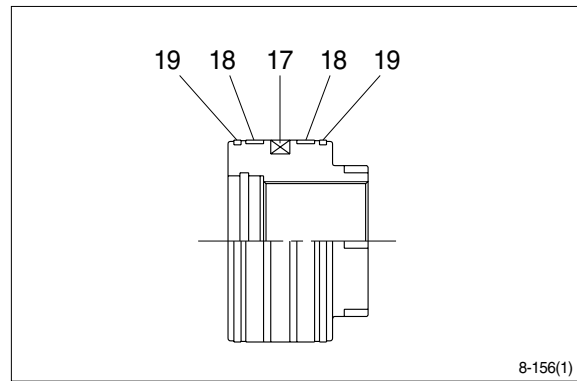


- ③ Remove the cylinder head assembly from rod assembly(2).
 - ※ If it is too heavy to move, move it by striking the flanged part of cylinder head with a plastic hammer.
 - ※ Pull it straight with cylinder head assembly lifted with a crane.
- Exercise care so as not to damage the lip of rod bushing(4) and packing (5,6,7,8,9,10) by the threads of rod assembly(2).



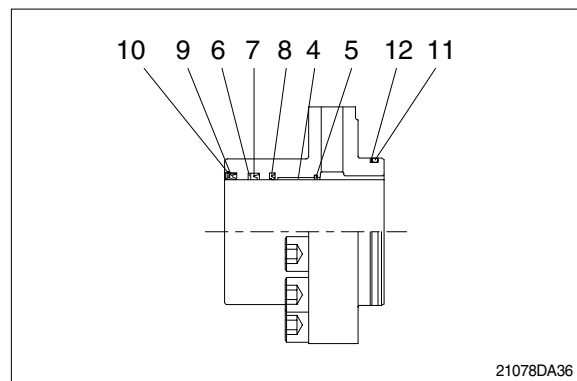
(3) Disassemble the piston assembly

- ① Remove wear ring(18).
 - ② Remove dust ring(19) and piston seal (17).
- ※ Exercise care in this operation not to damage the grooves.



(4) Disassemble cylinder head assembly

- ① Remove back up ring(12) and O-ring (11).
 - ② Remove snap ring(10), dust wiper(9).
 - ③ Remove back up ring(7), rod seal(6) and buffer ring(8).
- ※ Exercise care in this operation not to damage the grooves.
- ※ Do not remove seal and ring, if does not damaged.

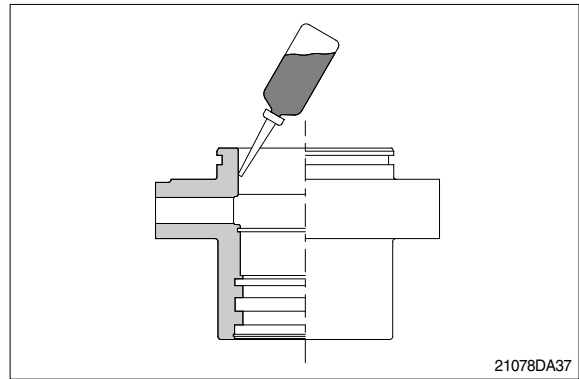


3) ASSEMBLY

(1) Assemble cylinder head assembly

- ※ Check for scratches or rough surfaces if found smooth with an oil stone.

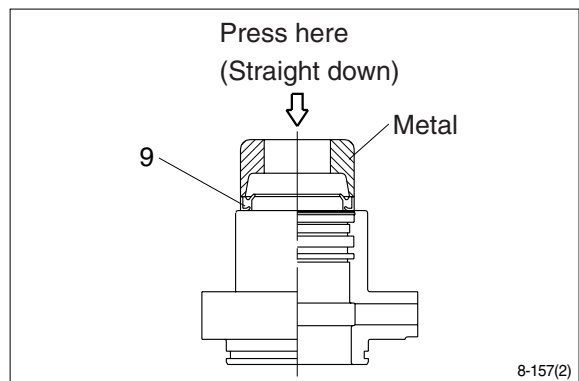
- ① Coat the inner face of gland(3) with hydraulic oil.



- ② Coat dust wiper(9) with grease and fit dust wiper(9) to the bottom of the hole of dust seal.

At this time, press a pad metal to the metal ring of dust seal.

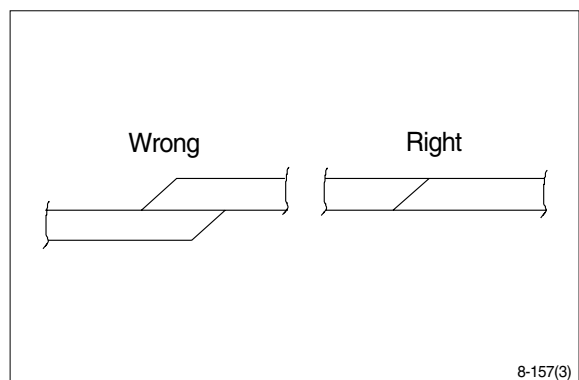
- ③ Fit snap ring(10) to the stop face.



- ④ Fit back up ring(7), rod seal(6) and buffer ring(8) to corresponding grooves, in that order.

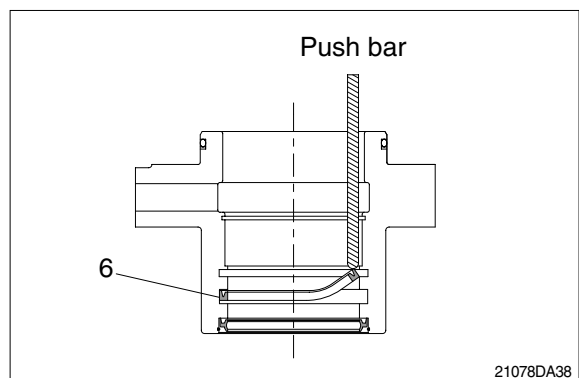
- ※ Coat each packing with hydraulic oil before fitting it.

- ※ Insert the backup ring until one side of it is inserted into groove.

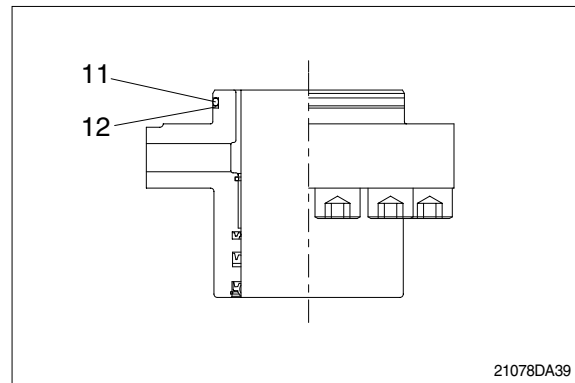


- ※ Rod seal(6) has its own fitting direction. Therefore, confirm it before fitting them.

- ※ Fitting rod seal(6) upside down may damage its lip. Therefore check the correct direction that is shown in fig.

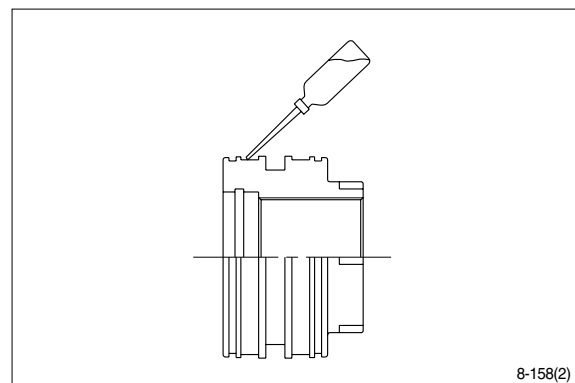


- ⑤ Fit back up ring(12) to gland(3).
- ※ Put the backup ring in the warm water of 30~50°C.
- ⑥ Fit O-ring(11) to gland(3).

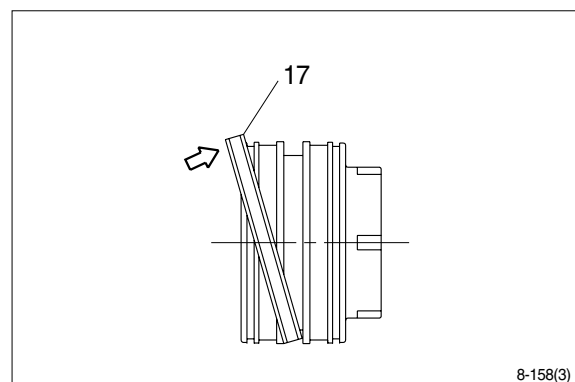


(2) Assemble piston assembly

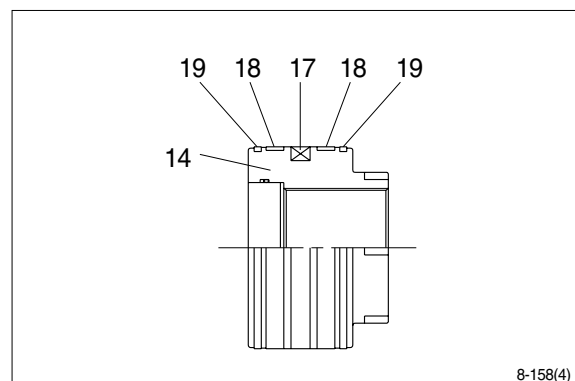
- ※ Check for scratches or rough surfaces.
If found smooth with an oil stone.
- ① Coat the outer face of piston(14) with hydraulic oil.



- ② Fit piston seal(17) to piston.
- ※ Put the piston seal in the warm water of 60~100°C for more than 5 minutes.
- ※ After assembling the piston seal, press its outer diameter to fit in.

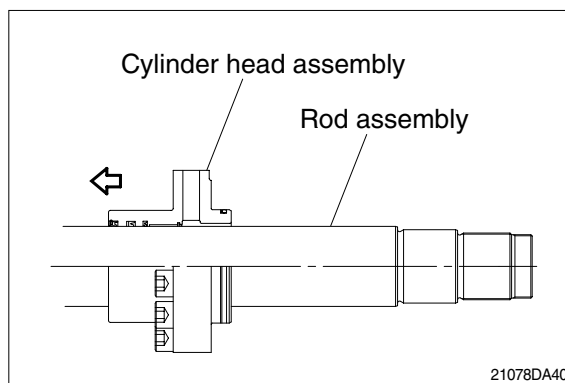


- ③ Fit wear ring(18) and dust ring(19) to piston(14).

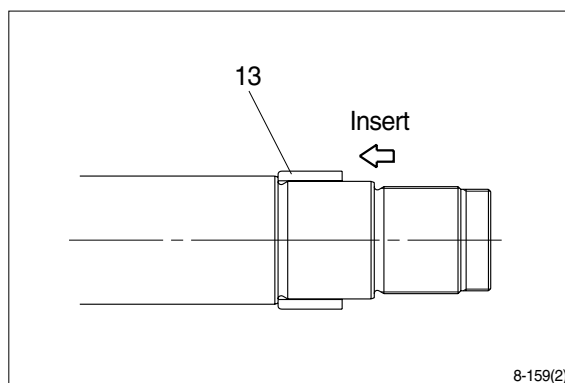


(3) Install piston and cylinder head

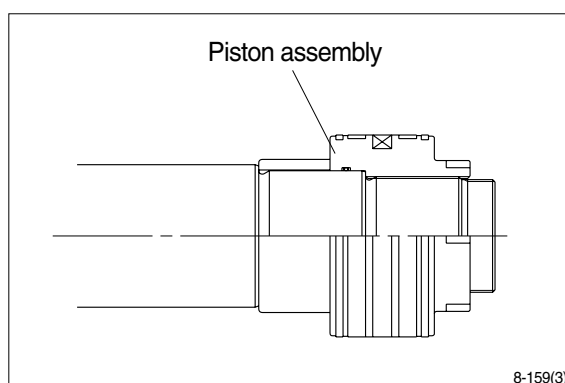
- ① Fix the rod assembly to the work bench.
- ② Apply hydraulic oil to the outer surface of rod assembly(2), the inner surface of piston and cylinder head.
- ③ Insert cylinder head assembly to rod assembly.



- ④ Insert cushion ring(13) to rod assembly.
- ※ Note that cushion ring(13) has a direction in which it should be fitted.

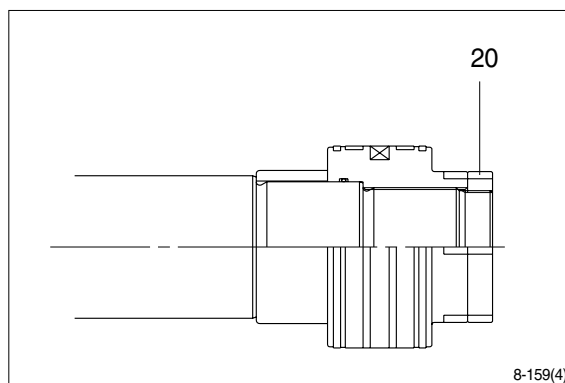


- ⑤ Fit piston assembly to rod assembly.
- Tightening torque : $100 \pm 10 \text{ kgf} \cdot \text{m}$
 $(723 \pm 72 \text{ lbf} \cdot \text{ft})$



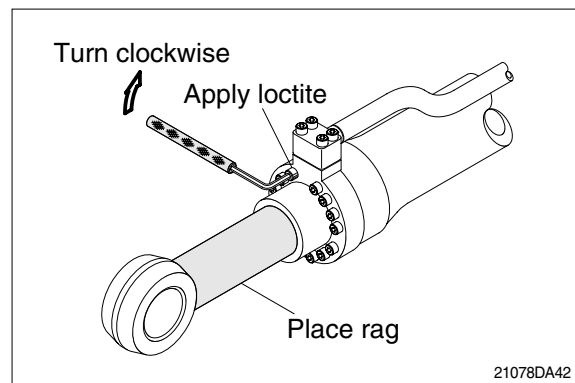
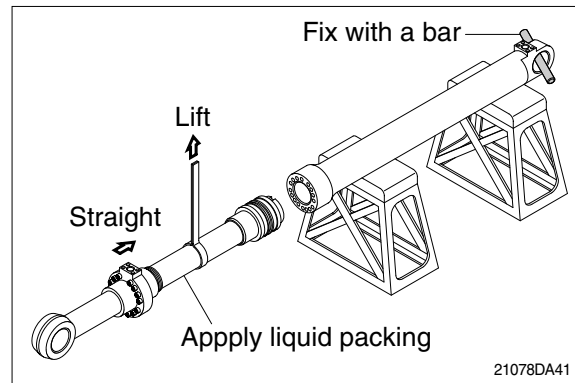
- ⑥ Fit lock nut(20) to piston.
- Tightening torque :

| Item | | kgf · m | lbf · ft |
|--------|----|--------------|------------------|
| Bucket | 21 | 100 ± 10 | 723.3 ± 72.3 |
| Boom | 21 | 100 ± 10 | 723.3 ± 72.3 |
| Arm | 25 | 100 ± 10 | 723.3 ± 72.3 |



(3) Overall assemble

- ① Place a V-block on a rigid work bench.
Mount the tube assembly(1) on it and fix the assembly by passing a bar through the clevis pin hole to lock the assembly.
- ② Insert the rod assembly in to the tube assembly, while lifting and moving the rod assembly with a crane.
 - ※ Be careful not to damage piston seal by thread of tube assembly.
- ③ Match the bolt holes in the cylinder head flange to the tapped holes in the tube assembly and tighten socket bolts to a specified torque.
 - ※ Refer to the table of tightening torque.

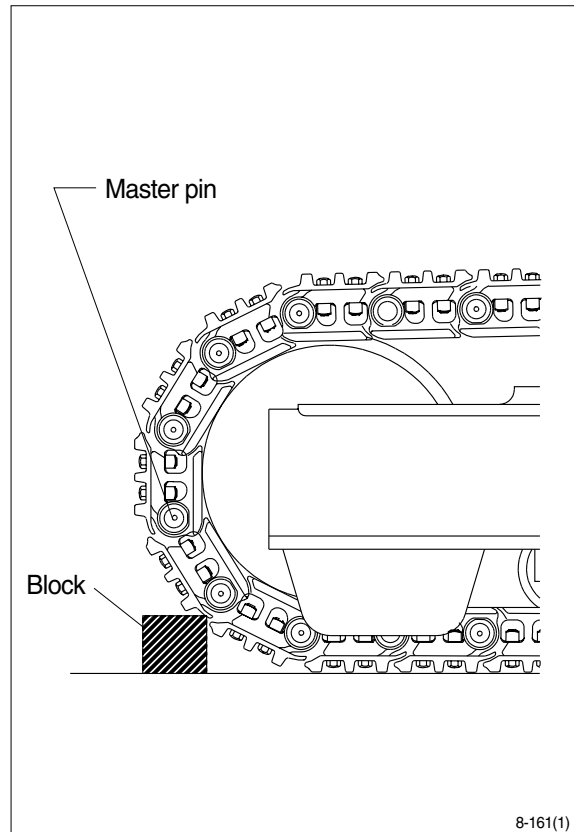


GROUP 10 UNDERCARRIAGE

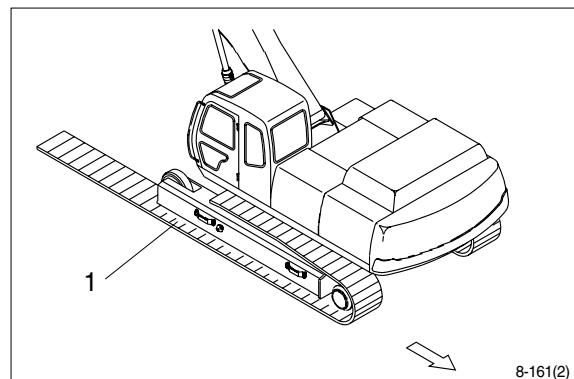
1. TRACK LINK

1) REMOVAL

- (1) Move track link until master pin is over front idler in the position put wooden block as shown.
- (2) Loosen tension of the track link.
 - ※ If track tension is not relieved when the grease valve is loosened, move the machine backwards and forwards.
- (3) Push out master pin by using a suitable tool.

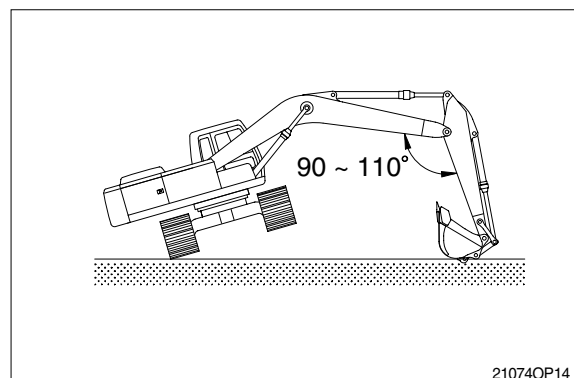


- (4) Move the machine slowly in reverse, and lay out track link assembly (1).
 - ※ Jack up the machine and put wooden block under the machine.
 - ※ Don't get close to the sprocket side as the track shoe plate may fall down on your feet.



2) INSTALL

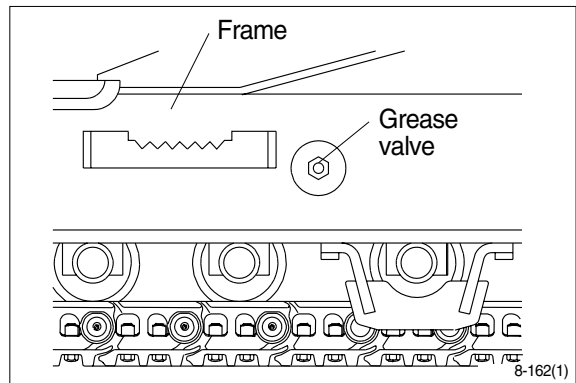
- (1) Carry out installation in the reverse order to removal.
 - ※ Adjust the tension of the track link.



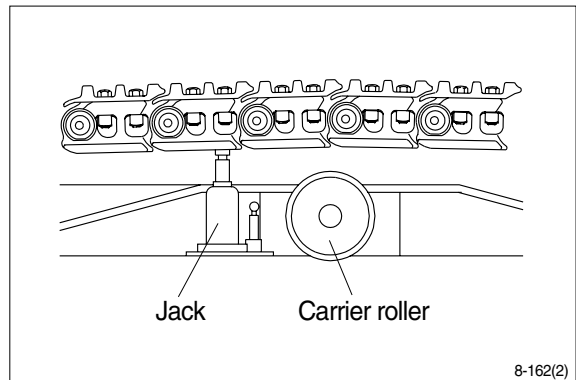
2. CARRIER ROLLER

1) REMOVAL

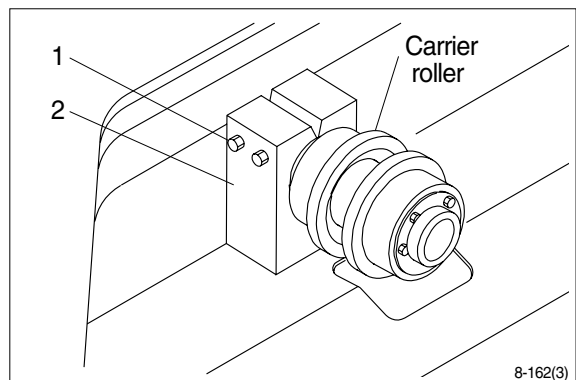
- (1) Loosen tension of the track link.



- (2) Jack up the track link height enough to permit carrier roller removal.



- (3) Loosen the lock nut (1).
- (4) Open bracket(2) with a screwdriver, push out from inside, and remove carrier roller assembly.
 - Weight : 21kg(46lb)



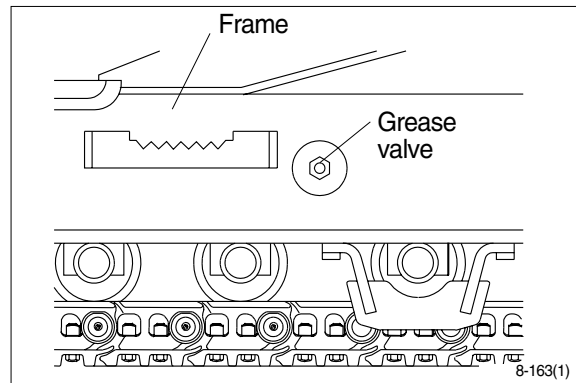
2) INSTALL

- (1) Carry out installation in the reverse order to removal.

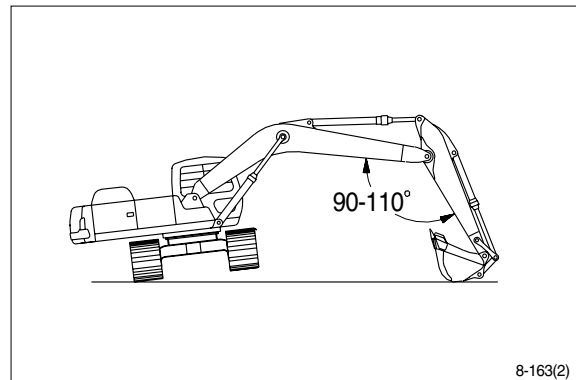
3. TRACK ROLLER

1) REMOVAL

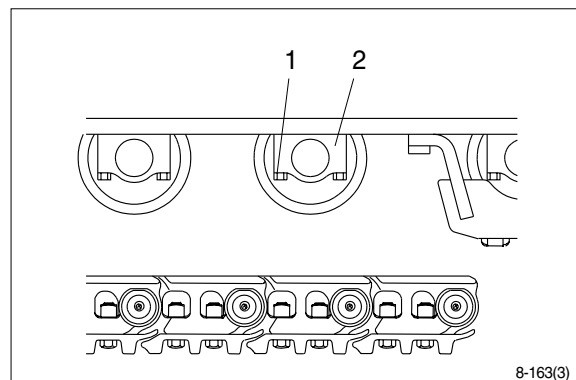
- (1) Loosen tension of the track link.



- (2) Using the work equipment, push up track frame on side which is to be removed.
※ After jack up the machine, set a block under the unit.



- (3) Remove the mounting bolt(1) and draw out the track roller(2).
· Weight : 38.3kg(84.4lb)



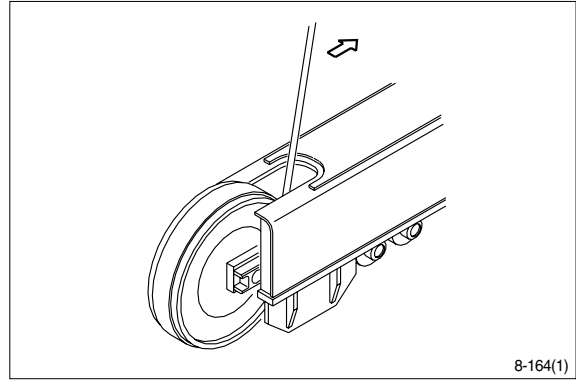
2) INSTALL

- (1) Carry out installation in the reverse order to removal.

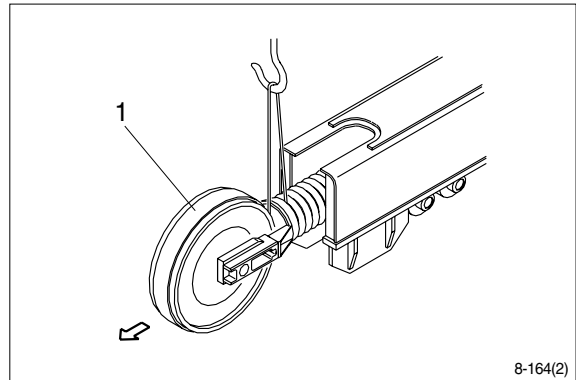
4. IDLER AND RECOIL SPRING

1) REMOVAL

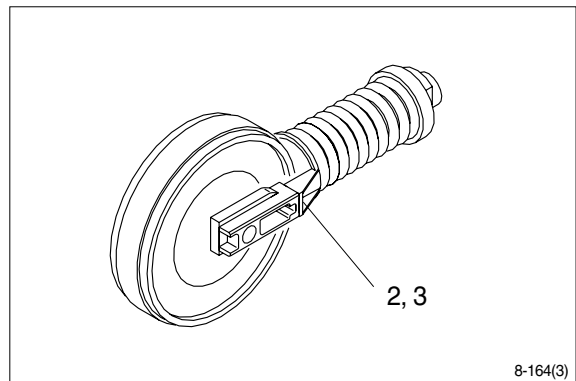
- (1) Remove the track link.
For detail, see **removal of track link**.



- (2) Sling the recoil spring(1) and pull out idler and recoil spring assembly from track frame, using a pry.
· Weight : 270kg(595lb)

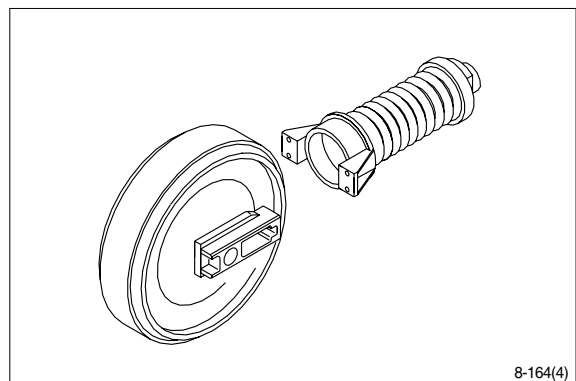


- (3) Remove the bolts(2), washers(3) and separate idler from recoil spring.



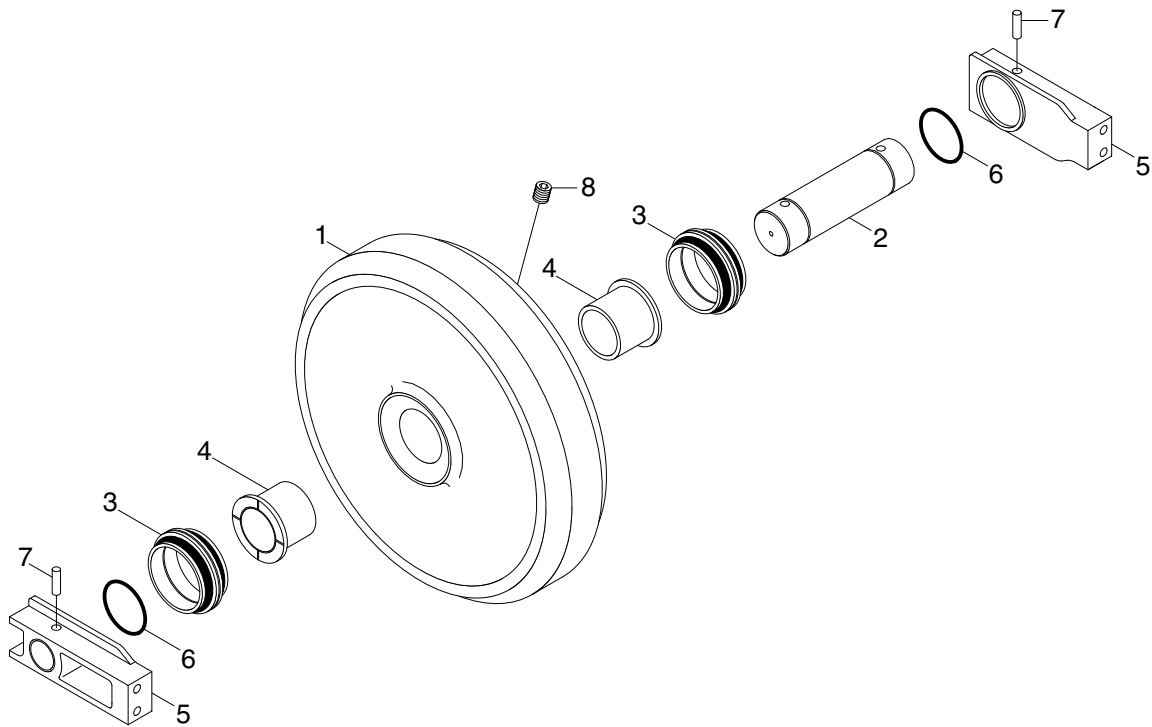
2) INSTALL

- (1) Carry out installation in the reverse order to removal.
※ Make sure that the boss on the end face of the recoil cylinder rod is in the hole of the track frame.



3) DISASSEMBLY AND ASSEMBLY OF IDLER

(1) Structure



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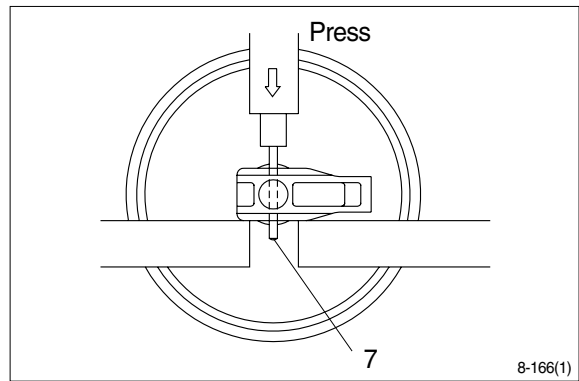
- 1 Shell
- 2 Shaft
- 3 Seal assembly

- 4 Bushing
- 5 Bracket
- 6 O-ring

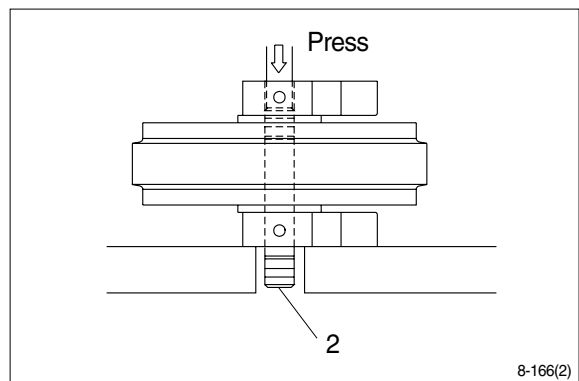
- 7 Spring pin
- 8 Plug

(2) Disassembly

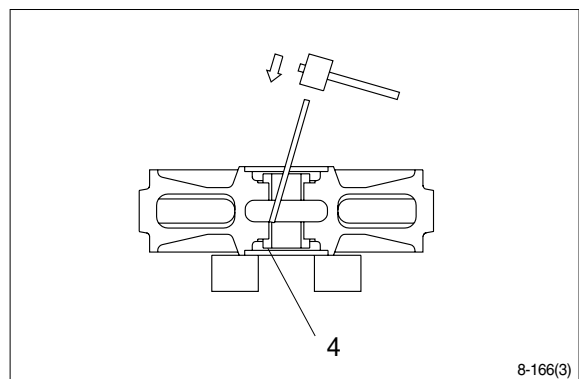
- ① Remove plug and drain oil.
- ② Draw out the spring pin(7), using a press.



- ③ Pull out the shaft(2) with a press.
- ④ Remove seal(3) from idler(1) and bracket (5).
- ⑤ Remove O-ring(6) from shaft.



- ⑥ Remove the bushing(4) from idler, using a special tool.
- ※ Only remove bushing if replacement is necessity.

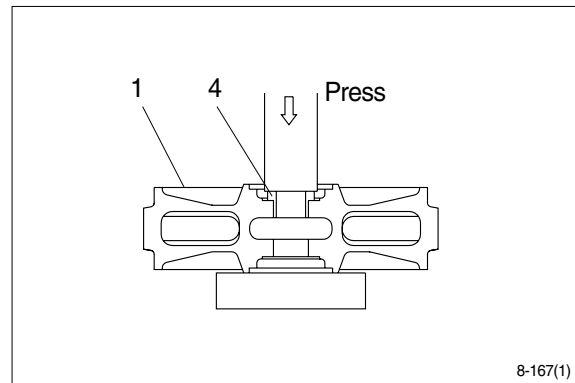


(3) Assembly

- ※ Before assembly, clean the parts.
- ※ Coat the sliding surfaces of all parts with oil.

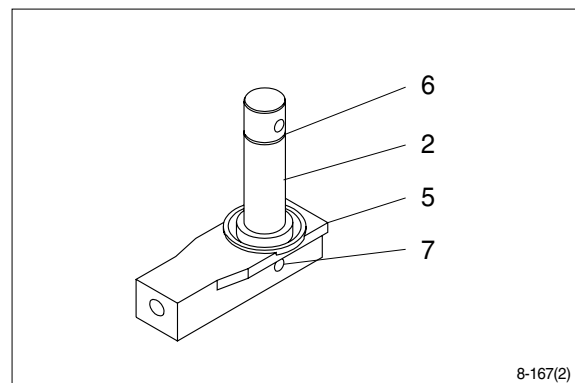
- ① Cool up bushing(4) fully by some dry ice and press it into shell(1).

Do not press it at the normal temperature, or not knock in with a hammer even after the cooling.

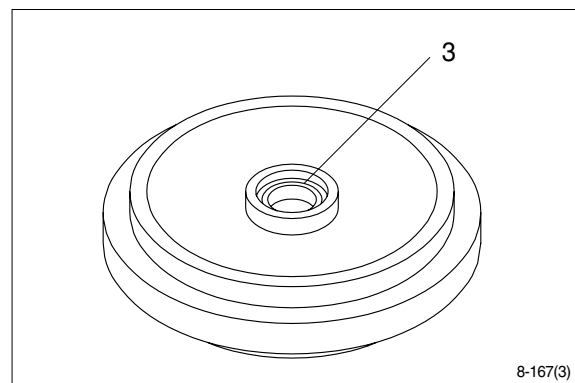


- ② Coat O-ring(6) with grease thinly, and install it to shaft(2).

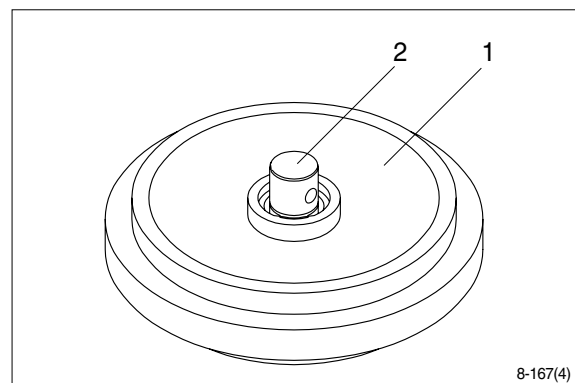
- ③ Insert shaft(2) into bracket(5) and drive in the spring pin(7).



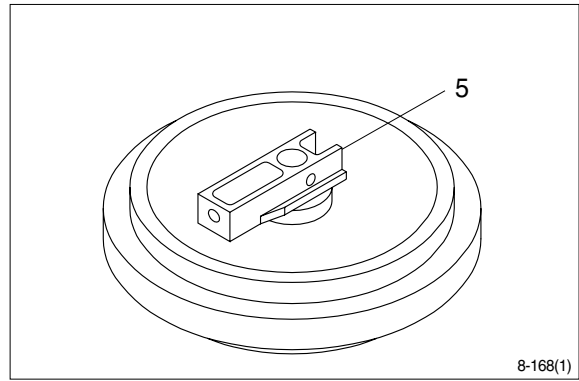
- ④ Install seal(3) to shell(1) and bracket(5).



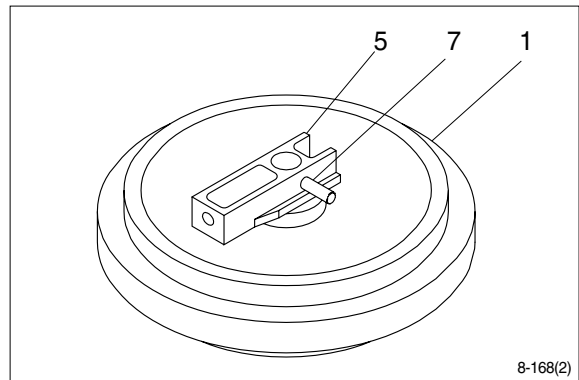
- ⑤ Install shaft(2) to shell(1).



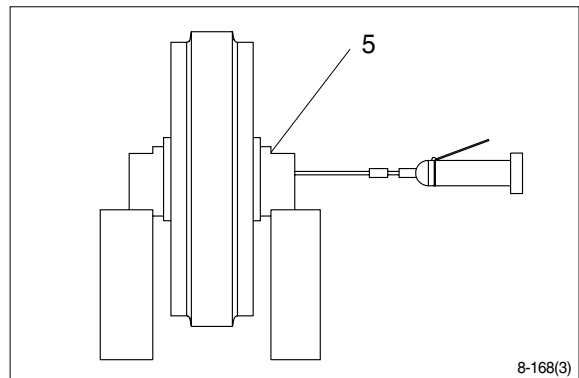
- ⑥ Install bracket(5) attached with seal(3).



- ⑦ Knock in the spring pin(7) with a hammer.

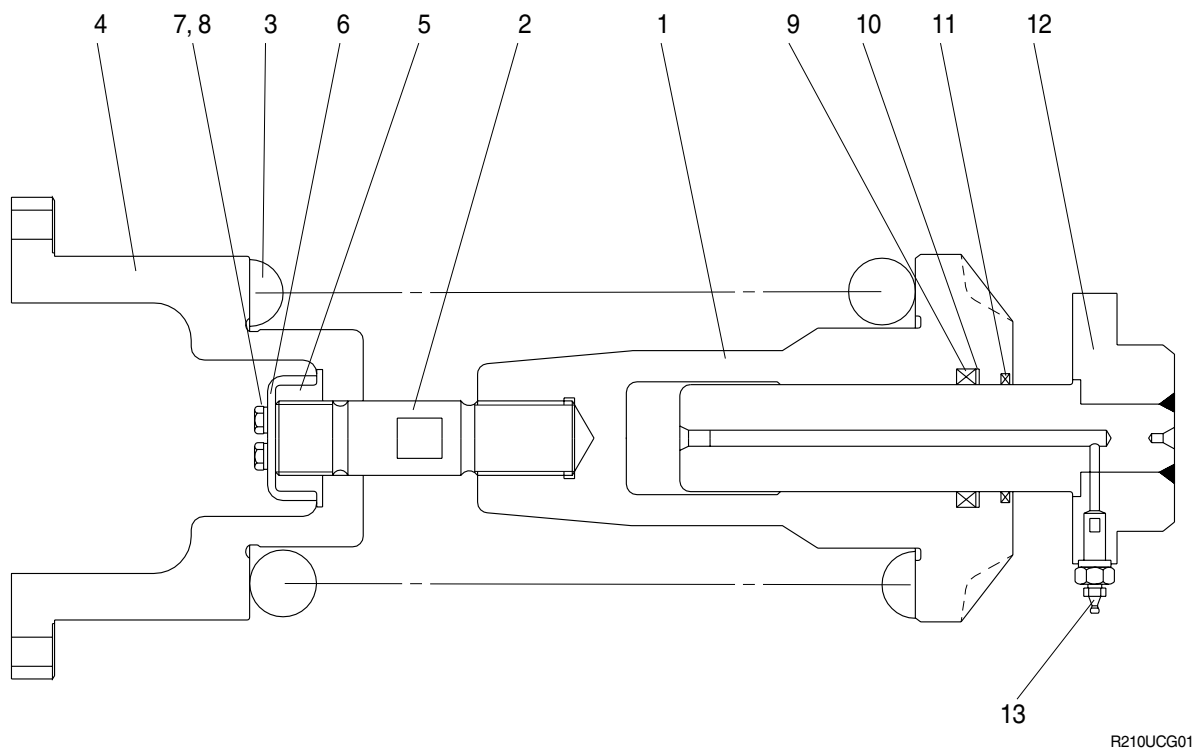


- ⑧ Lay bracket(5) on its side.
Supply engine oil to the specified level,
and tighten plug.



4) DISASSEMBLY AND ASSEMBLY OF RECOIL SPRING

(1) Structure



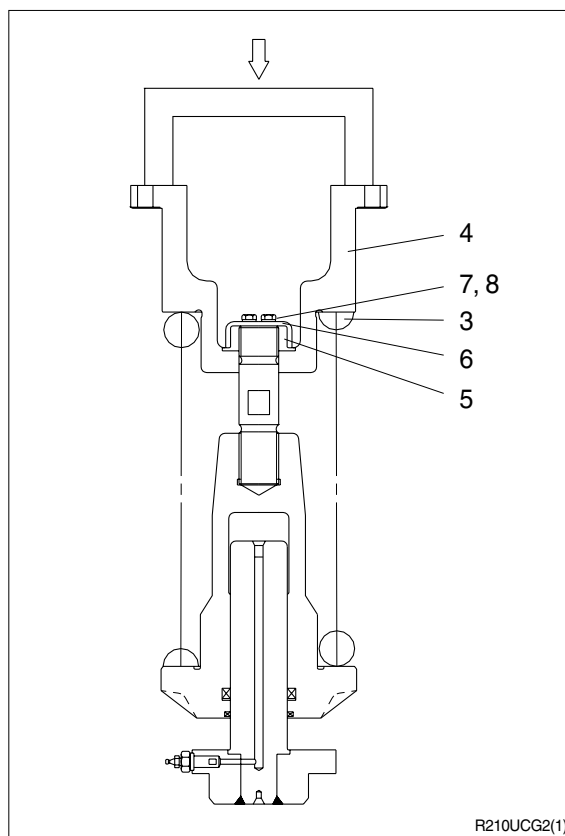
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- | | | | | | |
|---|----------|----|---------------|----|--------------|
| 1 | Body | 6 | Lock plate | 11 | Dust seal |
| 2 | Tie bar | 7 | Bolt | 12 | Rod assembly |
| 3 | Spring | 8 | Spring washer | 13 | Grease valve |
| 4 | Bracket | 9 | Rod seal | | |
| 5 | Lock nut | 10 | Back up ring | | |

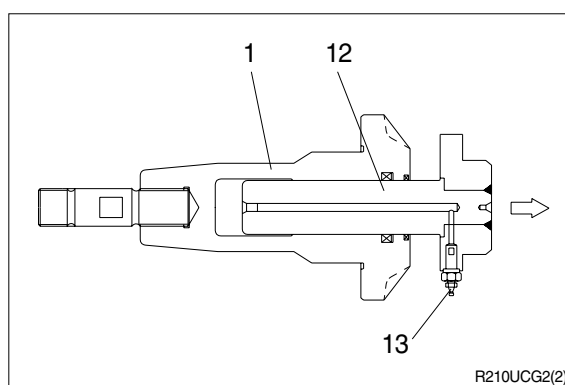
(2) Disassembly

- ① Apply pressure on spring(3) with a press.
 - ※ The spring is under a large installed load. This is dangerous, so be sure to set properly.
 - ・ Spring set load : 13716kg(30238lb)
- ② Remove bolt(7), spring washer(8) and lock plate(6).
- ③ Remove lock nut(5).

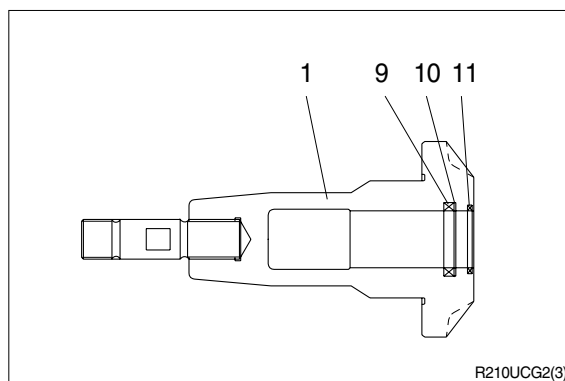
Take enough notice so that the press which pushes down the spring, should not be slipped out in its operation.
- ④ Lighten the press load slowly and remove bracket(4) and spring(3).



- ⑤ Remove rod(12) from body(1).
- ⑥ Remove grease valve(13) from rod(12).



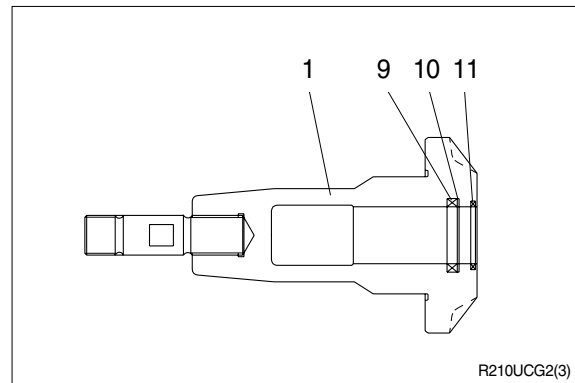
- ⑦ Remove rod seal(9), back up ring(10) and dust seal(11).



(3) Assembly

- ① Install dust seal(11), back up ring(10) and rod seal(9) to body(1).

※ When installing dust seal(11) and rod seal(9), take full care so as not to damage the lip.



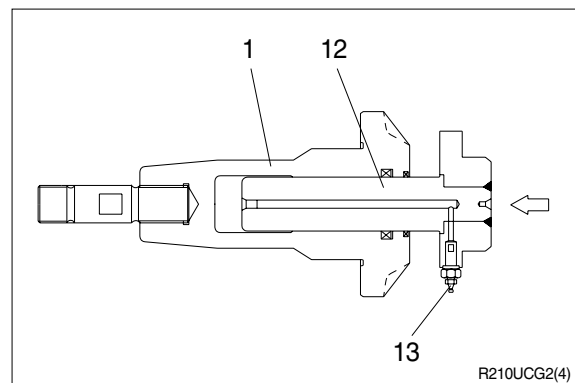
- ② Pour grease into body(1), then push in rod(12) by hand.

After take grease out of grease valve mounting hole, let air out.

※ If air letting is not sufficient, it may be difficult to adjust the tension of crawler.

- ③ Fit grease valve(13) to rod(12).

• Tightening torque : $10 \pm 0.5 \text{ kg} \cdot \text{m}$
($72.3 \pm 3.6 \text{ lb} \cdot \text{ft}$)

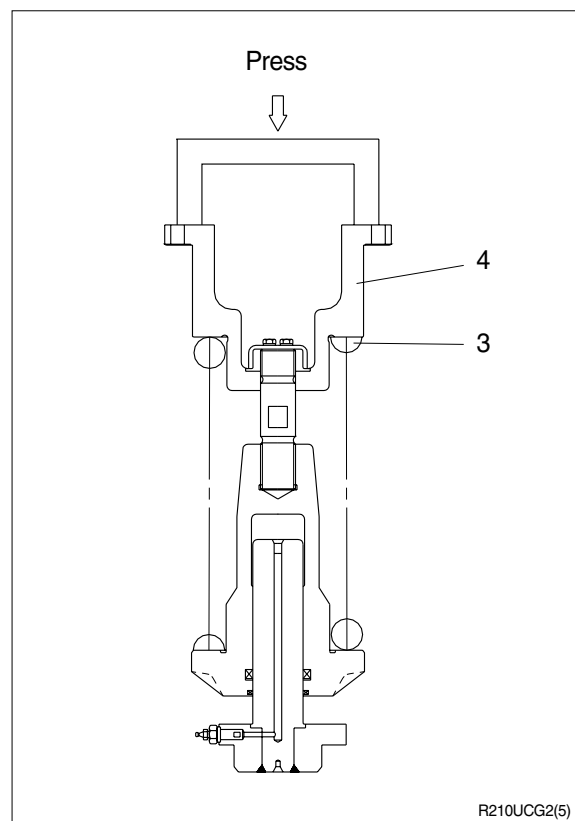


- ④ Install spring(3) and bracket(4) to body (1).

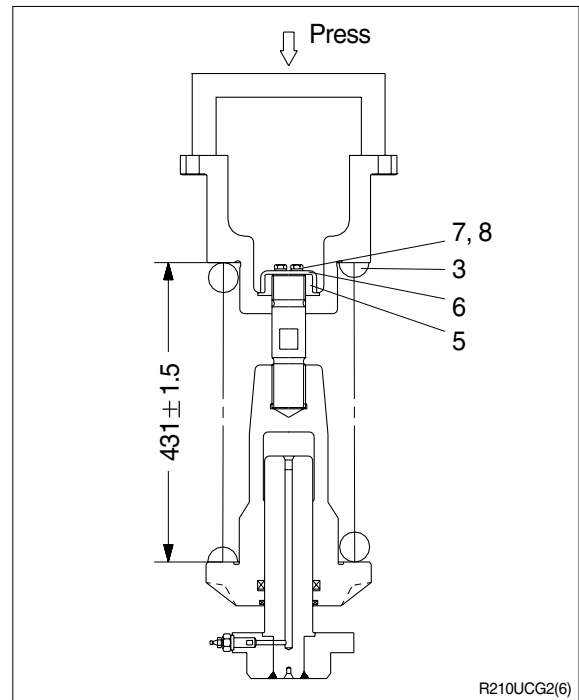
- ⑤ Apply pressure to spring(3) with a press and tighten lock nut(5).

※ Apply sealant before assembling.

※ During the operation, pay attention specially to prevent the press from slipping out.

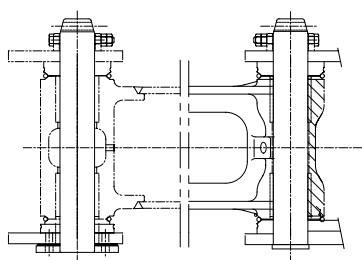
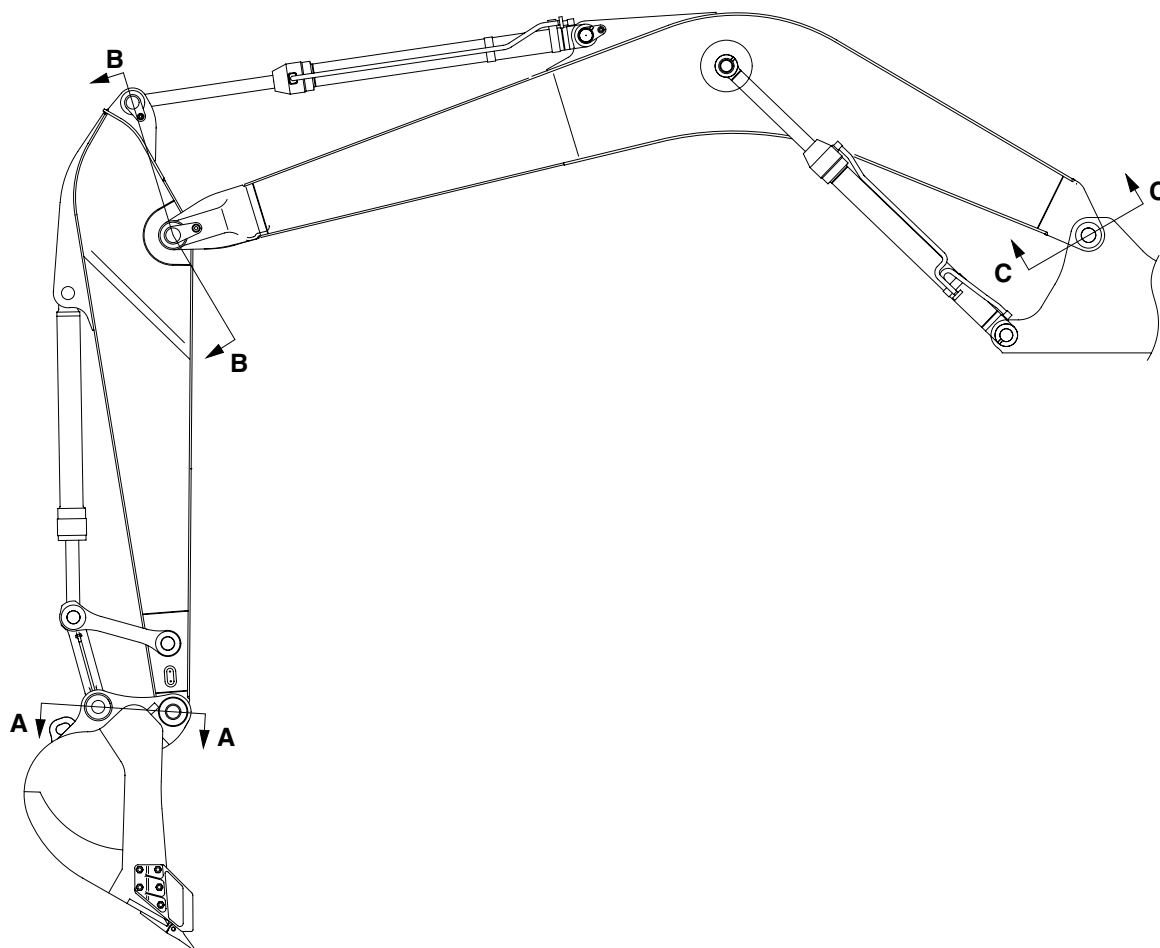


- ⑥ Lighten the press load and confirm the set length of spring(3).
- ⑦ After the setting of spring(3), install lock plate(6), spring washer(8) and bolt(7).

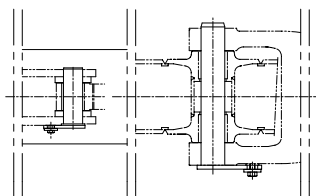


GROUP 11 WORK EQUIPMENT

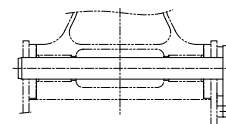
1. STRUCTURE



SECTION A



SECTION B



SECTION C

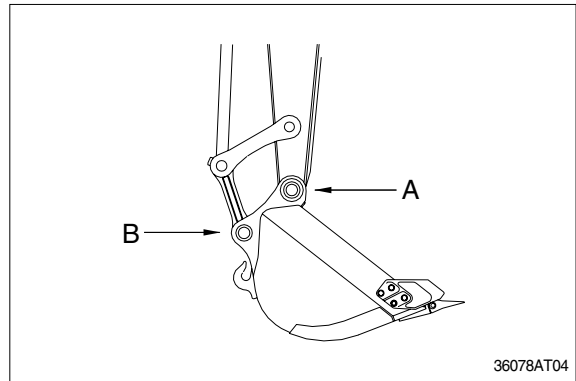
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2. REMOVAL AND INSTALL

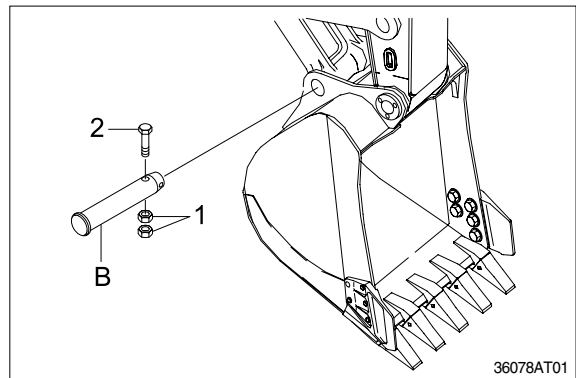
1) BUCKET ASSEMBLY

(1) Removal

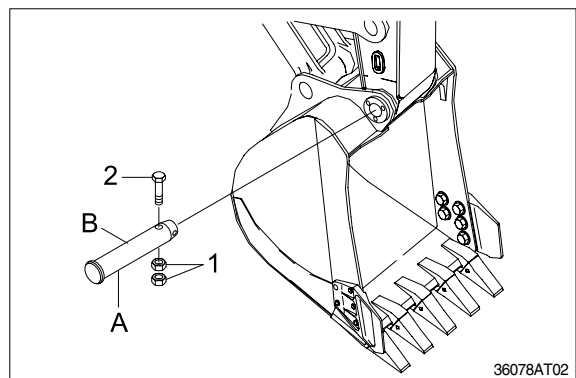
- ① Lower the work equipment completely to ground with back of bucket facing down.



- ② Remove nut(1), bolt(2) and draw out the pin(A).

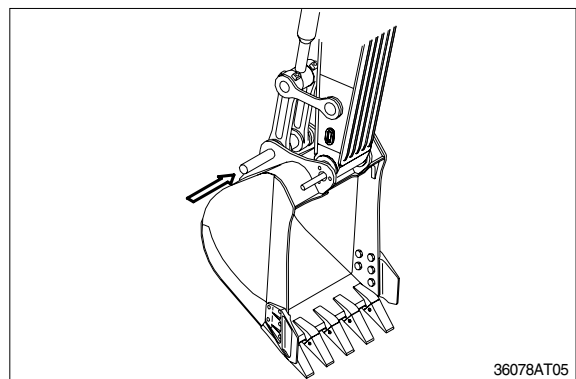


- ③ Remove nut(3), bolt(4) and draw out the pin(B).



(2) Install

- ① Carry out installation in the reverse order to removal.
- ▲ When aligning the mounting position of the pin, do not insert your fingers in the pin hole.
- ※ Adjust the bucket clearance.
For detail, see **operation manual**.



2) ARM ASSEMBLY

(1) Removal

※ Loosen the breather slowly to release the pressure inside the hydraulic tank.

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

① Remove bucket assembly.

For details, see **removal of bucket assembly**.

② Disconnect bucket cylinder hose(1).

▲ Fit blind plugs(5) in the piping at the chassis end securely to prevent oil from spurting out when the engine is started.

③ Sling arm cylinder assembly, remove spring, pin stopper and pull out pin.

※ Tie the rod with wire to prevent it from coming out.

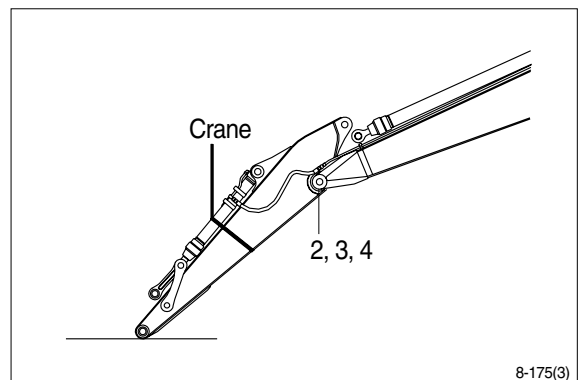
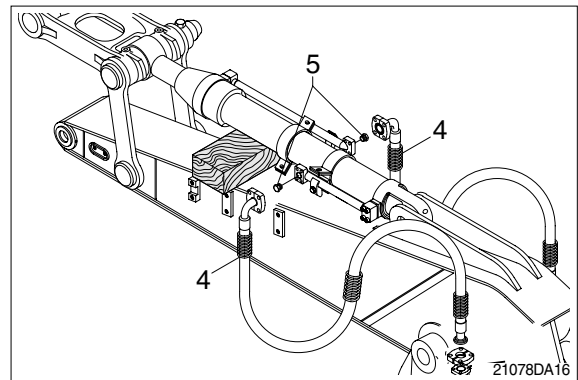
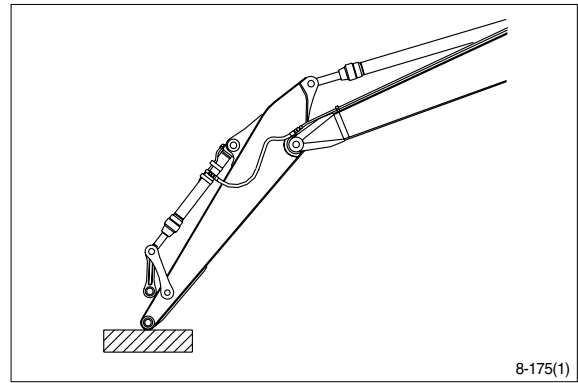
④ For details, see **removal of arm cylinder assembly**.

Place a wooden block under the cylinder and bring the cylinder down to it.

⑤ Remove bolt(2), plate(3) and pull out the pin(4) then remove the arm assembly.

· Weight : 1050kg(2310lb)

※ When lifting the arm assembly, always lift the center of gravity.



(2) Install

① Carry out installation in the reverse order to removal.

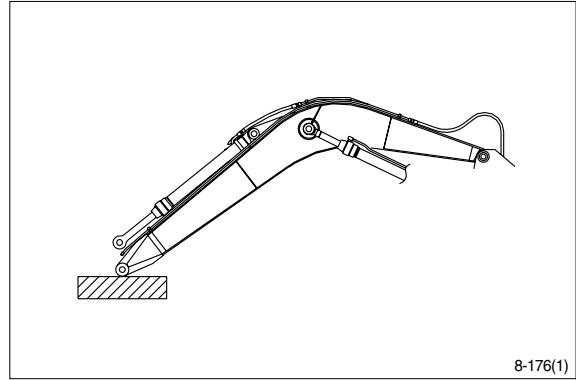
▲ When lifting the arm assembly, always lift the center of gravity.

※ Bleed the air from the cylinder.

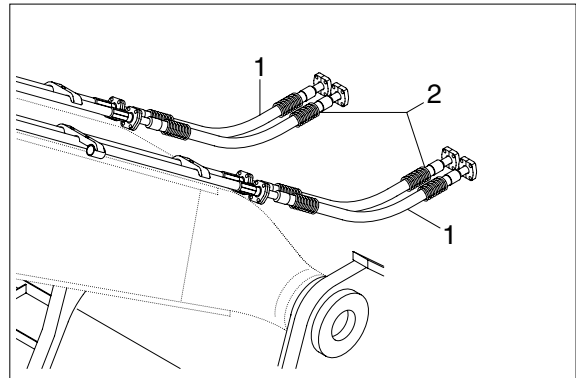
3) BOOM CYLINDER

(1) Removal

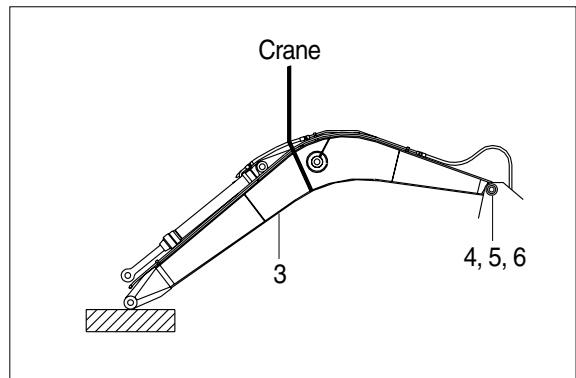
- ① Remove arm and bucket assembly.
For details, see **removal of arm and bucket assembly**.
- ② Remove boom cylinder assembly from boom.
For details, see **removal of arm cylinder assembly**.



- ③ Disconnect head lamp wiring.
- ④ Disconnect bucket cylinder hose(2) and arm cylinder hose(1).
- ※ When the hose are disconnected, oil may spurt out.
- ⑤ Sling boom assembly(3).

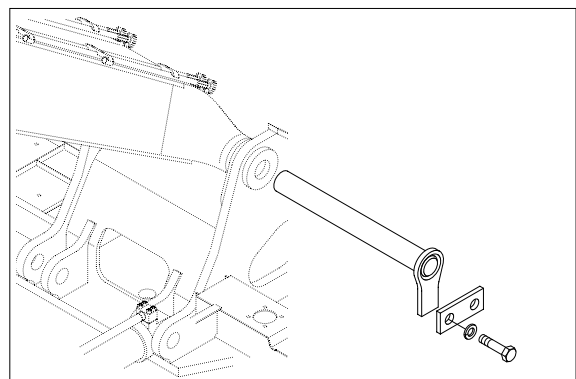


- ⑥ Remove bolt(4), plate(5) and pull out the pin(6) then remove boom assembly.
· Weight :1950kg(4300lb)
- ※ When lifting the boom assembly always lift the center of gravity.



(2) Install

- ① Carry out installation in the reverse order to removal.
- ▲ When lifting the arm assembly, always lift the center of gravity.
- ※ Bleed the air from the cylinder.



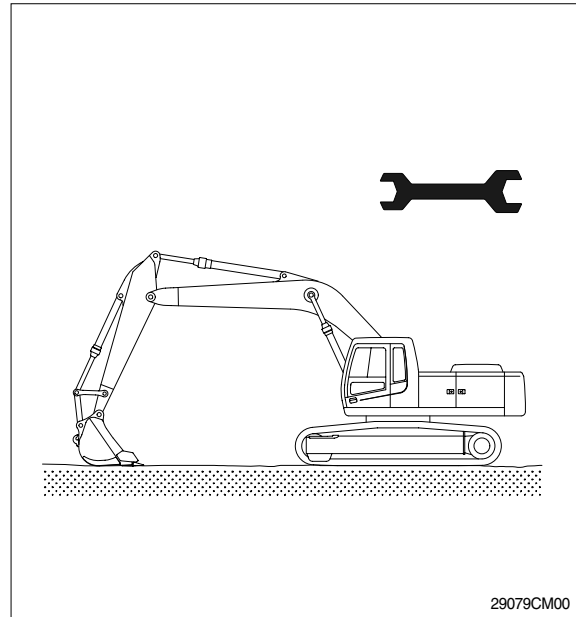
SECTION 9 COMPONENT MOUNTING TORQUE

| | | |
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| Group 1 | Introduction guide | 9-1 |
| Group 2 | Engine system | 9-2 |
| Group 3 | Electric system | 9-4 |
| Group 4 | Hydraulic system | 9-6 |
| Group 5 | Undercarriage | 9-9 |
| Group 6 | Structure | 9-10 |
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SECTION 9 COMPONENT MOUNTING TORQUE

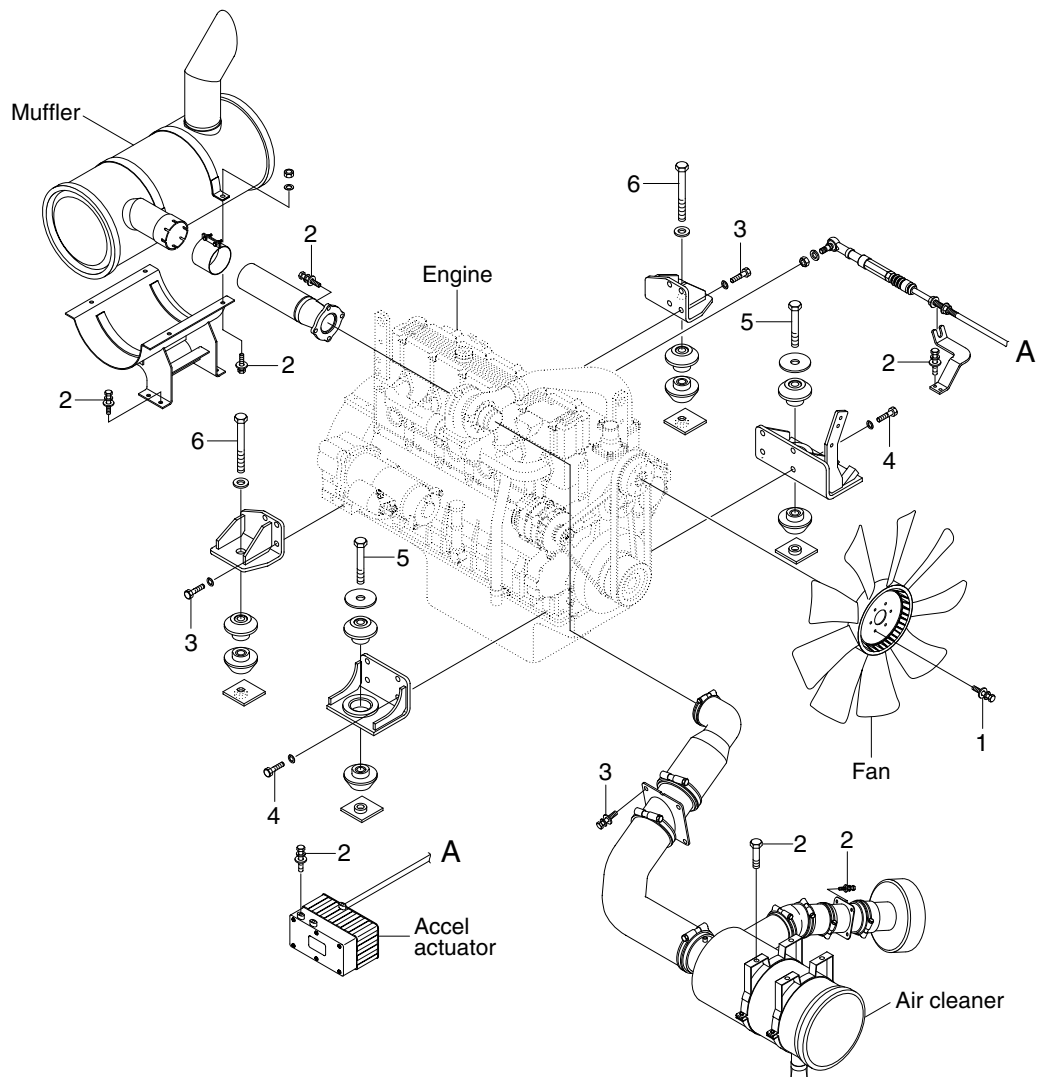
GROUP 1 INTRODUCTION GUIDE

1. This section shows bolt specifications and standard torque values needed when mounting components to the machine.
 2. Use genuine Hyundai spare parts.
We expressly point out that Hyundai will not accept any responsibility for defects resulted from non-genuine parts.
In such cases Hyundai cannot assume liability for any damage.
- ※ **Only metric fasteners can be used and incorrect fasteners may result in machine damage or malfunction.**
 - ※ **Before installation, clean all the components with a non-corrosive cleaner. Bolts and threads must not be worn or damaged.**



GROUP 2 ENGINE SYSTEM

ENGINE AND ACCESSORIES MOUNTING



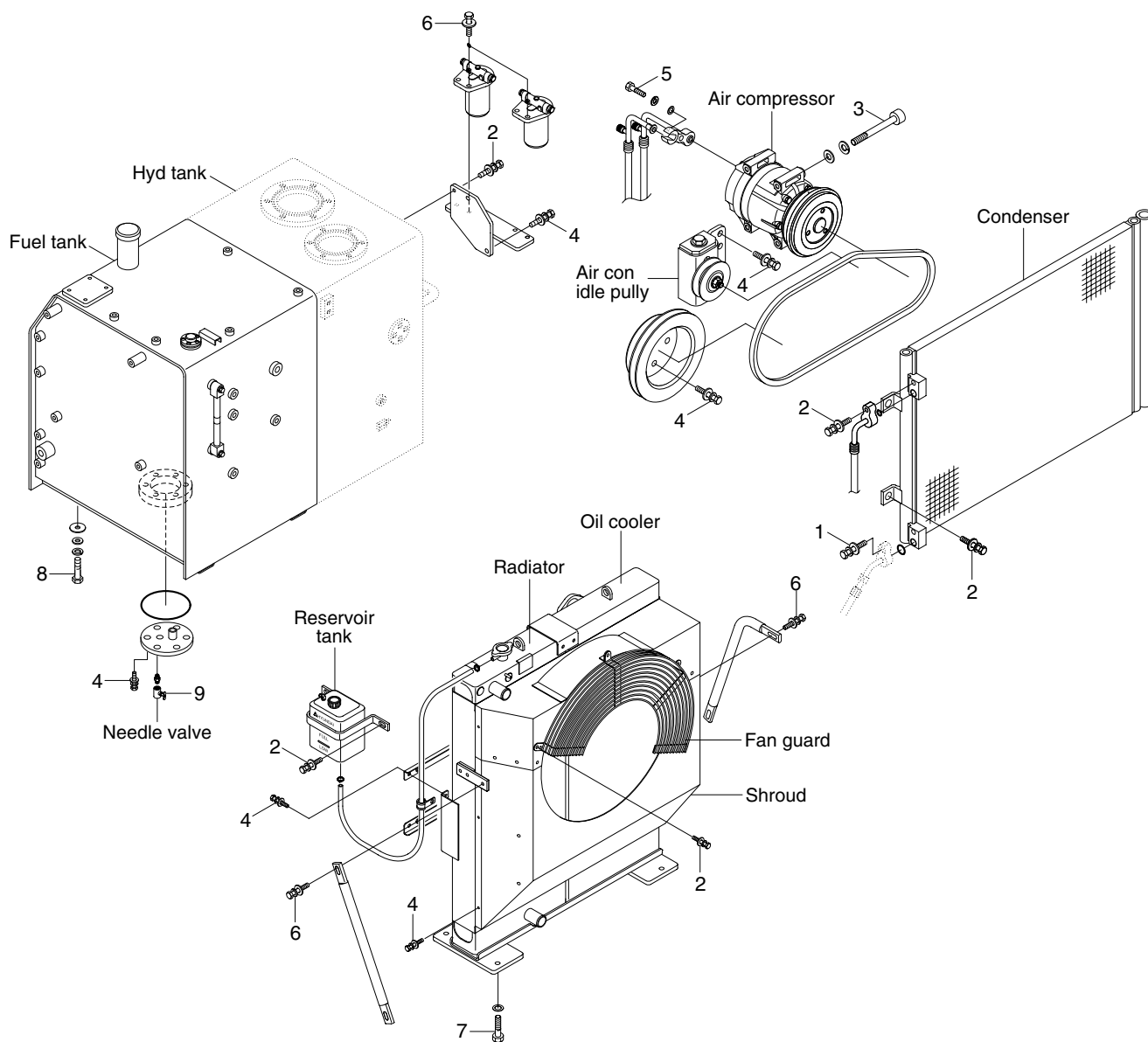
R2107V9CM01

• Tightening torque

| Item | Size | kgf · m | lbf · ft |
|------|----------|----------|-----------|
| 1 | M 8×1.25 | 2.5±0.5 | 18.1±3.6 |
| 2 | M10×1.5 | 6.9±1.4 | 49.9±10.1 |
| 3 | M12×1.75 | 12.8±3.0 | 92.6±21.7 |

| Item | Size | kgf · m | lbf · ft |
|------|---------|----------|----------|
| 4 | M14×2.0 | 19.6±2.9 | 142±21.0 |
| 5 | M20×2.5 | 55±3.5 | 398±25.3 |
| 6 | M24×3.0 | 97±7.0 | 702±51 |

COOLING SYSTEM AND FUEL TANK MOUNTING



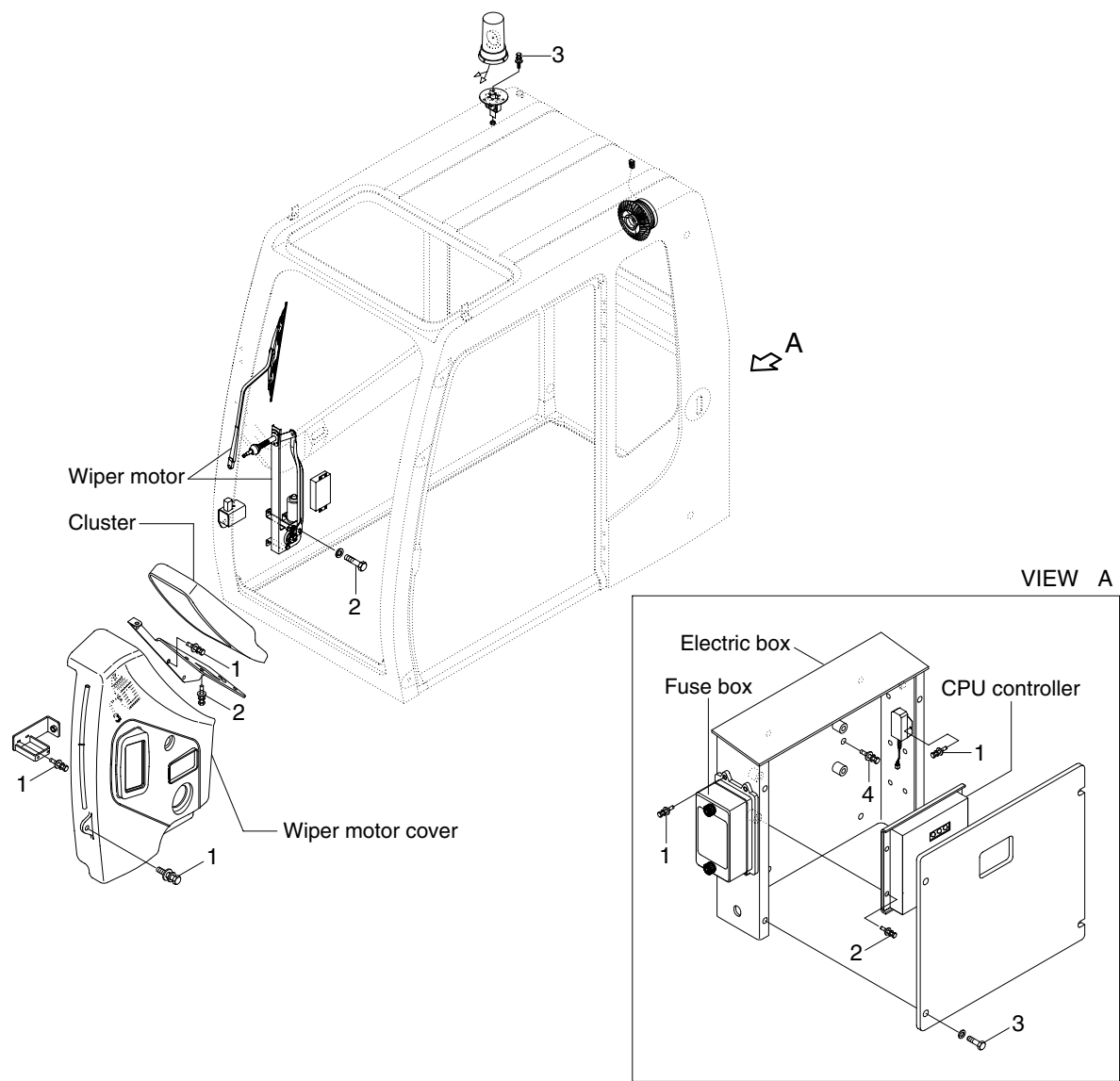
R2107V9CM02

· Tightening torque

| Item | Size | kgf · m | lbf · ft |
|------|----------|----------|-----------|
| 1 | M 6×1.0 | 1.05±0.2 | 7.6±1.45 |
| 2 | M 8×1.25 | 2.5±0.5 | 18.1±3.6 |
| 3 | M 8×1.25 | 4.05±0.8 | 29.3±5.8 |
| 4 | M10×1.5 | 6.9±1.4 | 49.9±10.1 |
| 5 | M10×1.25 | 7.4±1.5 | 53.5±10.8 |

| Item | Size | kgf · m | lbf · ft |
|------|----------|----------|-----------|
| 6 | M12×1.75 | 12.8±3.0 | 92.6±21.7 |
| 7 | M16×2.0 | 29.7±4.5 | 215±32.5 |
| 8 | M20×2.5 | 45±5.1 | 325±36.9 |
| 9 | - | 2.3±0.6 | 16.6±4.3 |
| - | - | - | - |

ELECTRIC COMPONENTS MOUNTING 2



R2107V9CM04

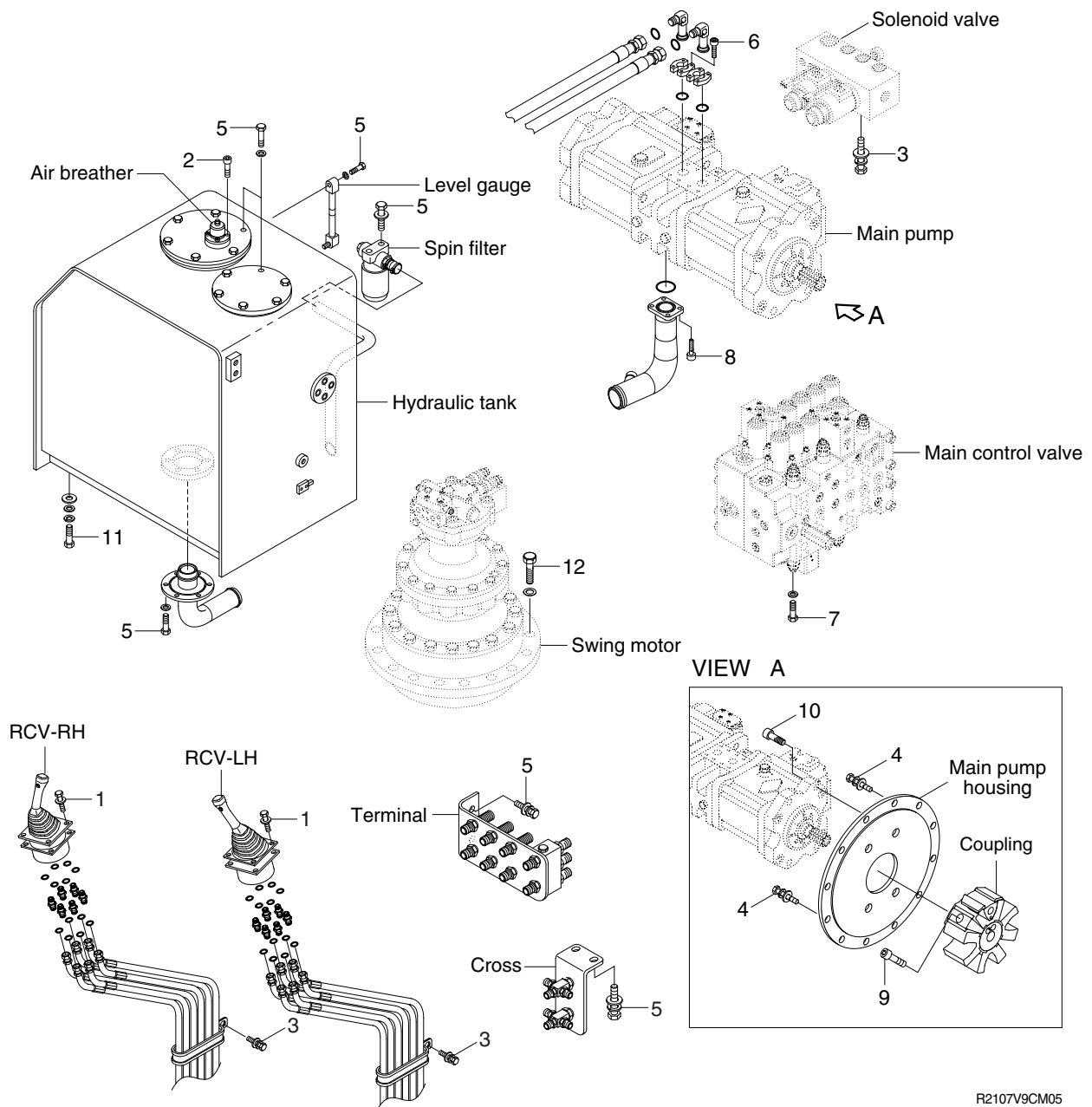
• Tightening torque

| Item | Size | kgf · m | lbf · ft |
|------|----------|----------|----------|
| 1 | M 6×1.0 | 1.05±0.2 | 7.6±1.45 |
| 2 | M 8×1.25 | 2.5±0.5 | 18.1±3.6 |

| Item | Size | kgf · m | lbf · ft |
|------|---------|---------|-----------|
| 3 | M10×1.5 | 6.9±1.4 | 49.9±10.1 |
| - | - | - | - |

GROUP 4 HYDRAULIC SYSTEM

HYDRAULIC COMPONENTS MOUNTING 1



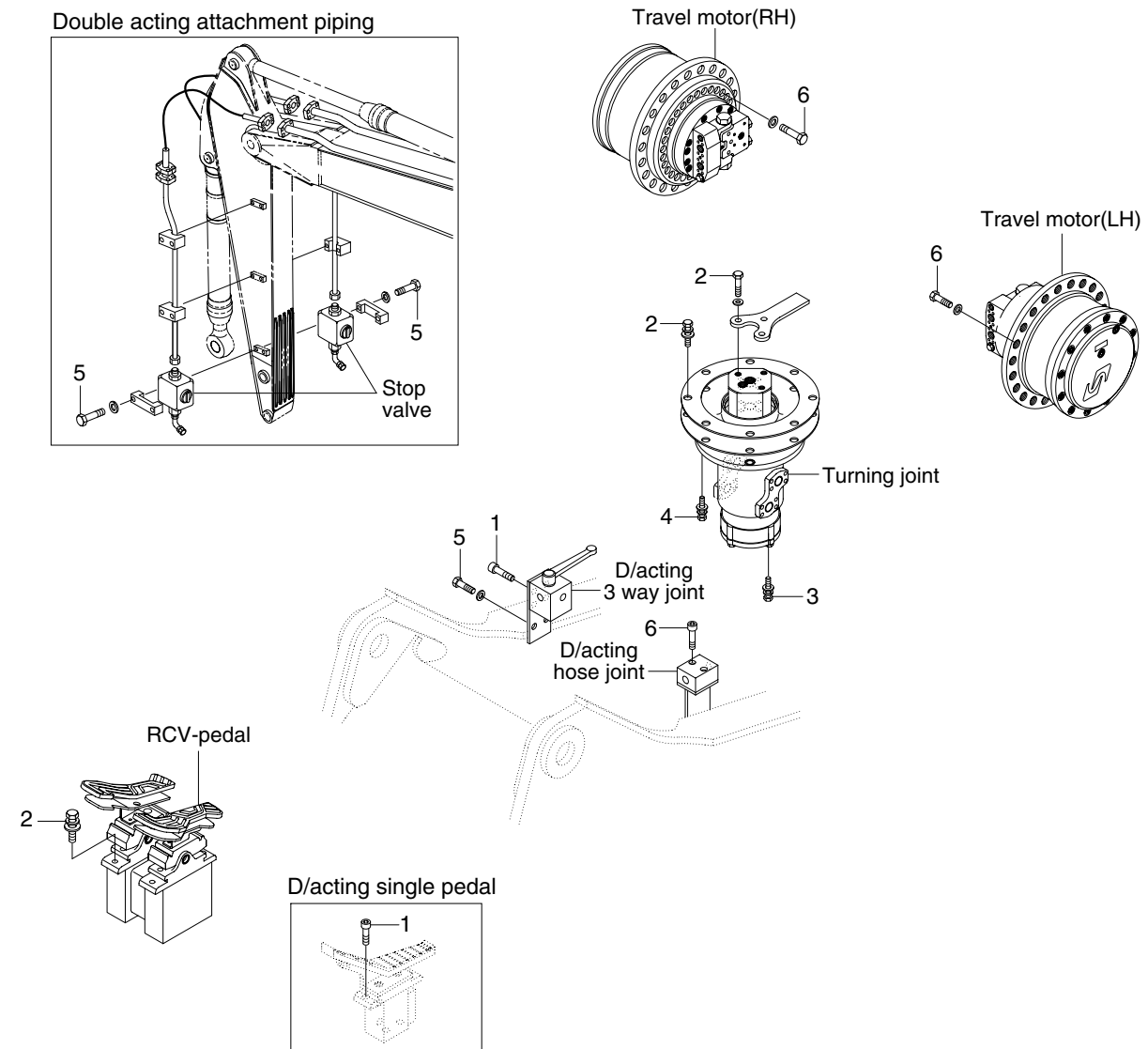
R2107V9CM05

· Tightening torque

| Item | Size | kgf · m | lbf · ft |
|------|----------|----------|-----------|
| 1 | M 6×1.0 | 1.05±0.2 | 7.6±1.45 |
| 2 | M 6×1.0 | 1.44±0.3 | 10.4±2.2 |
| 3 | M 8×1.25 | 2.5±0.5 | 18.1±3.6 |
| 4 | M10×1.5 | 4.8±0.3 | 34.7±2.2 |
| 5 | M10×1.5 | 6.9±1.4 | 49.9±10.1 |
| 6 | M10×1.5 | 8.27±1.7 | 59.8±12.3 |

| Item | Size | kgf · m | lbf · ft |
|------|----------|----------|----------|
| 7 | M12×1.75 | 12.2±1.3 | 88.2±9.4 |
| 8 | M12×1.75 | 14.7±2.2 | 106±15.9 |
| 9 | M18×2.5 | 32±1.0 | 231±7.2 |
| 10 | M20×2.5 | 42±4.5 | 304±32.5 |
| 11 | M20×2.5 | 45±5.1 | 325±36.9 |
| 12 | M20×2.5 | 57.9±8.7 | 419±62.9 |

HYDRAULIC COMPONENTS MOUNTING 2



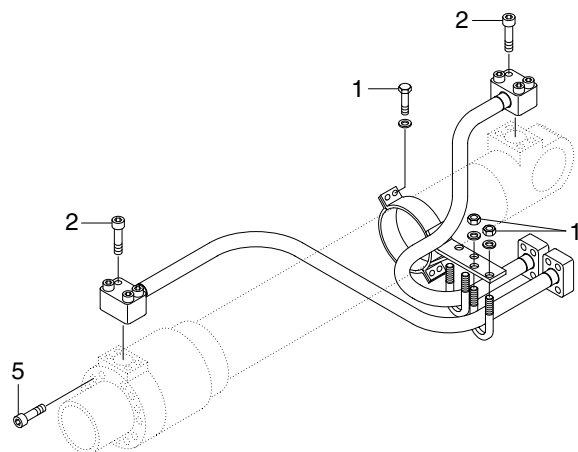
2107V9CM06

• Tightening torque

| Item | Size | kgf · m | lbf · ft |
|------|----------|------------|-----------|
| 1 | M 8×1.25 | 4.05±0.8 | 29.3±5.8 |
| 2 | M10×1.5 | 6.9±1.4 | 49.9±10.1 |
| 3 | M12×1.75 | 11.25±1.25 | 81.4±9.0 |

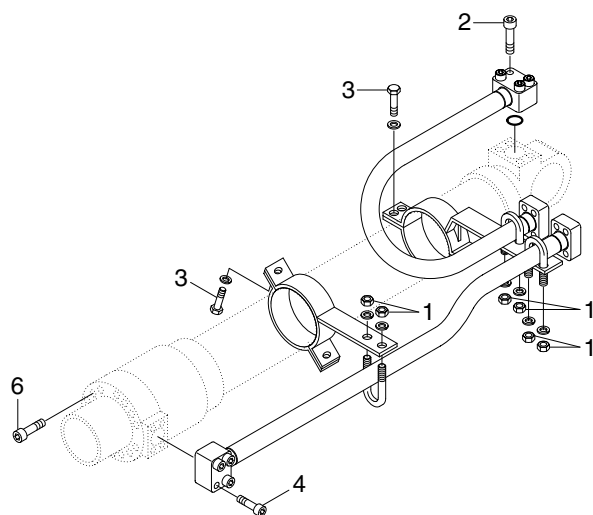
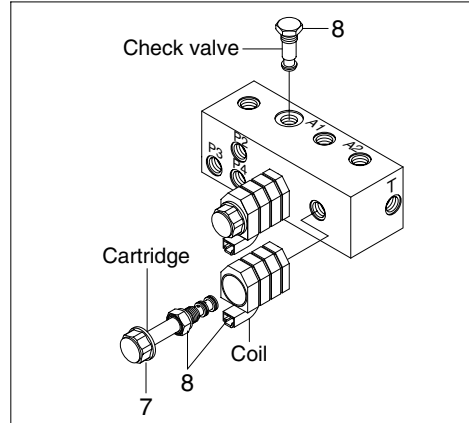
| Item | Size | kgf · m | lbf · ft |
|------|----------|----------|-----------|
| 4 | M12×1.75 | 12.3±1.3 | 88.9±9.4 |
| 5 | M12×1.75 | 12.8±3.0 | 92.6±21.7 |
| 6 | M16×2.0 | 23.0±2.5 | 166±18.1 |

HYDRAULIC COMPONENTS MOUNTING 3

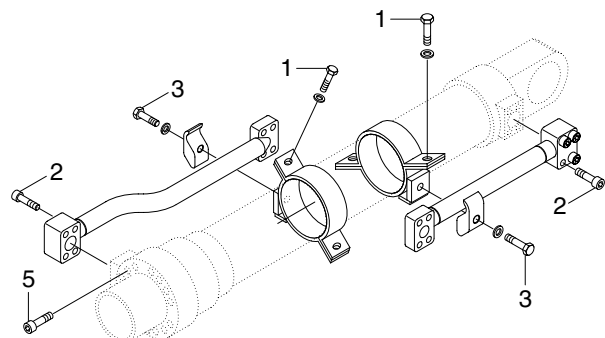


BOOM CYLINDER

Solenoid valve



ARM CYLINDER



BUCKET CYLINDER

2107V9CM07

· Tightening torque

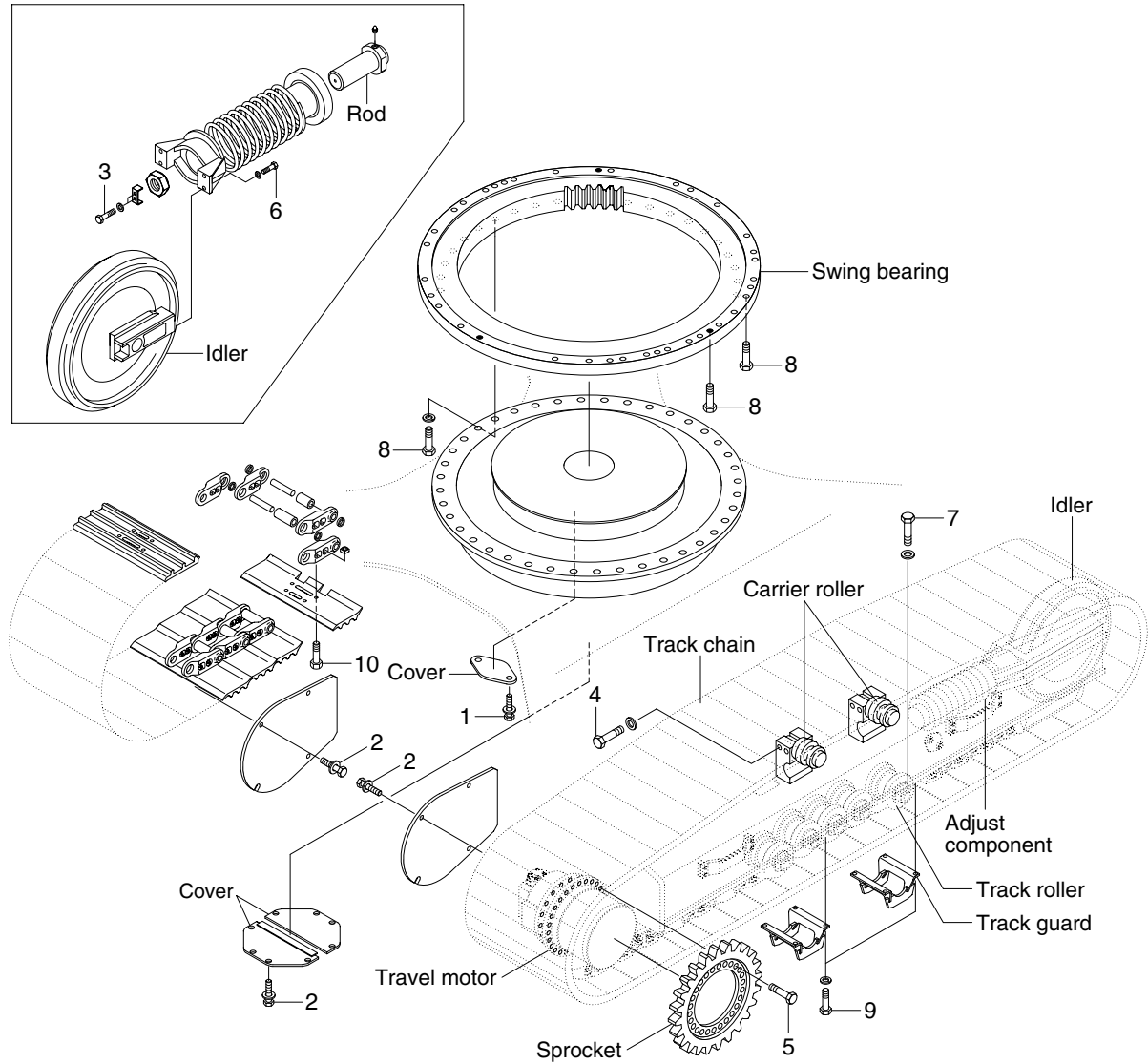
| Item | Size | kgf · m | lbf · ft |
|------|----------|---------|----------|
| 1 | M10×1.5 | 3.2±0.3 | 23.1±2.2 |
| 2 | M10×1.5 | 5.4±0.5 | 39.1±3.6 |
| 3 | M12×1.75 | 5.5±0.6 | 39.8±4.3 |
| 4 | M12×1.75 | 9.4±1.0 | 68.0±7.2 |

| Item | Size | kgf · m | lbf · ft |
|------|---------|---------|----------|
| 5 | M16×2.0 | 23±2.0 | 166±14.5 |
| 6 | M18×2.5 | 32±3.0 | 232±21.7 |
| 7 | - | 0.5±0.1 | 3.6±0.7 |
| 8 | - | 2.8±0.2 | 20.3±1.4 |

GROUP 5 UNDERCARRIAGE

UNDERCARRIAGE MOUNTING

ADJUST COMPONENT



2107V9CM08

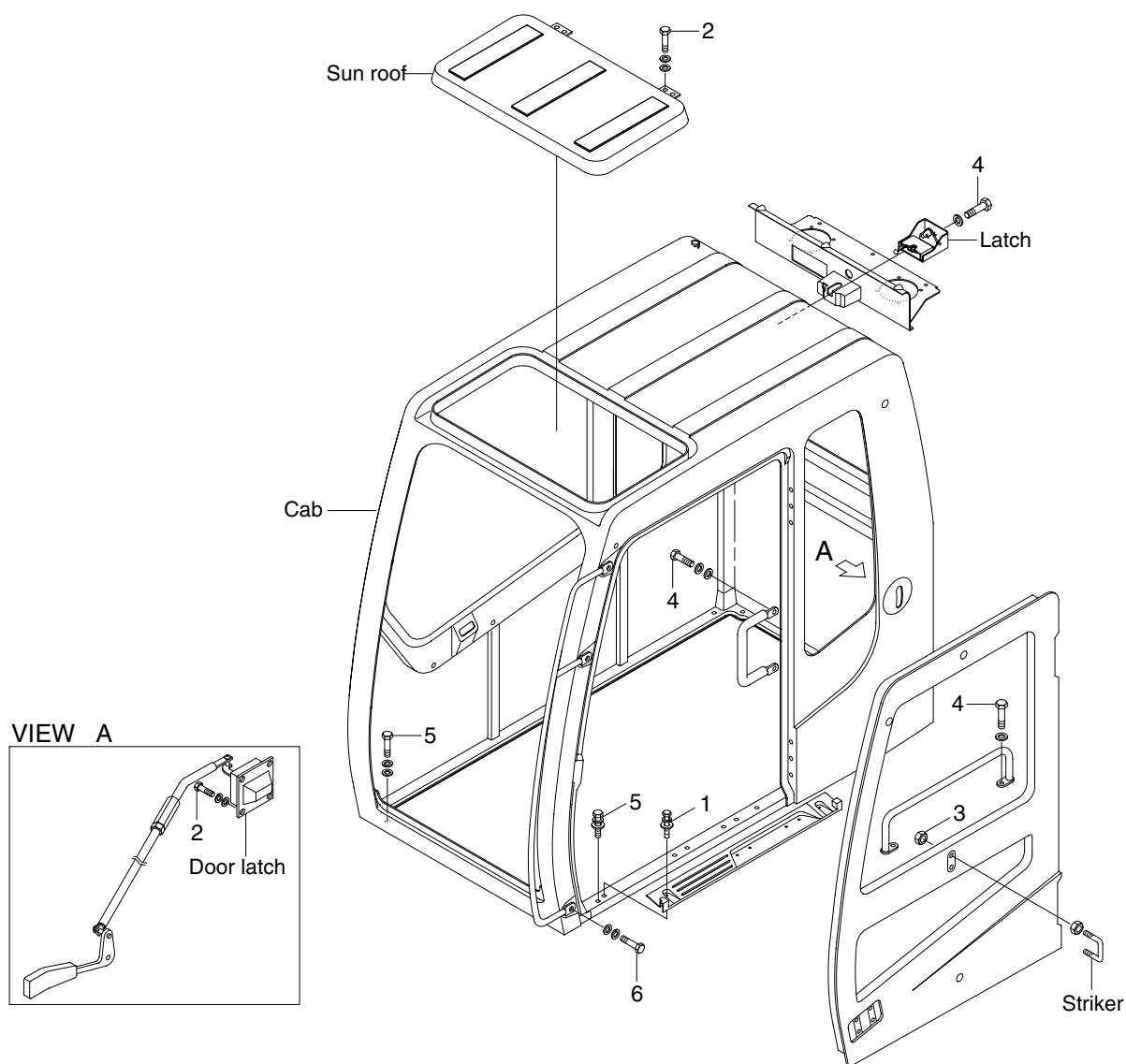
• Tightening torque

| Item | Size | kgf · m | lbf · ft |
|------|----------|----------|-----------|
| 1 | M10×1.5 | 6.9±1.4 | 49.9±10.1 |
| 2 | M12×1.75 | 12.8±3.0 | 92.6±21.7 |
| 3 | M12×1.75 | 15±0.5 | 108±3.6 |
| 4 | M16×2.0 | 23±2.5 | 166±18.1 |
| 5 | M16×2.0 | 26±2.5 | 188±18.1 |

| Item | Size | kgf · m | lbf · ft |
|------|---------|----------|----------|
| 6 | M16×2.0 | 29.7±4.5 | 215±32.5 |
| 7 | M20×2.5 | 54.7±5.0 | 396±36.2 |
| 8 | M20×2.5 | 57.8±6.4 | 418±46.3 |
| 9 | M20×2.5 | 57.9±8.7 | 419±62.9 |
| 10 | M20×2.5 | 78±8.0 | 564±57.9 |

GROUP 6 STRUCTURE

CAB AND ACCESSORIES MOUNTING



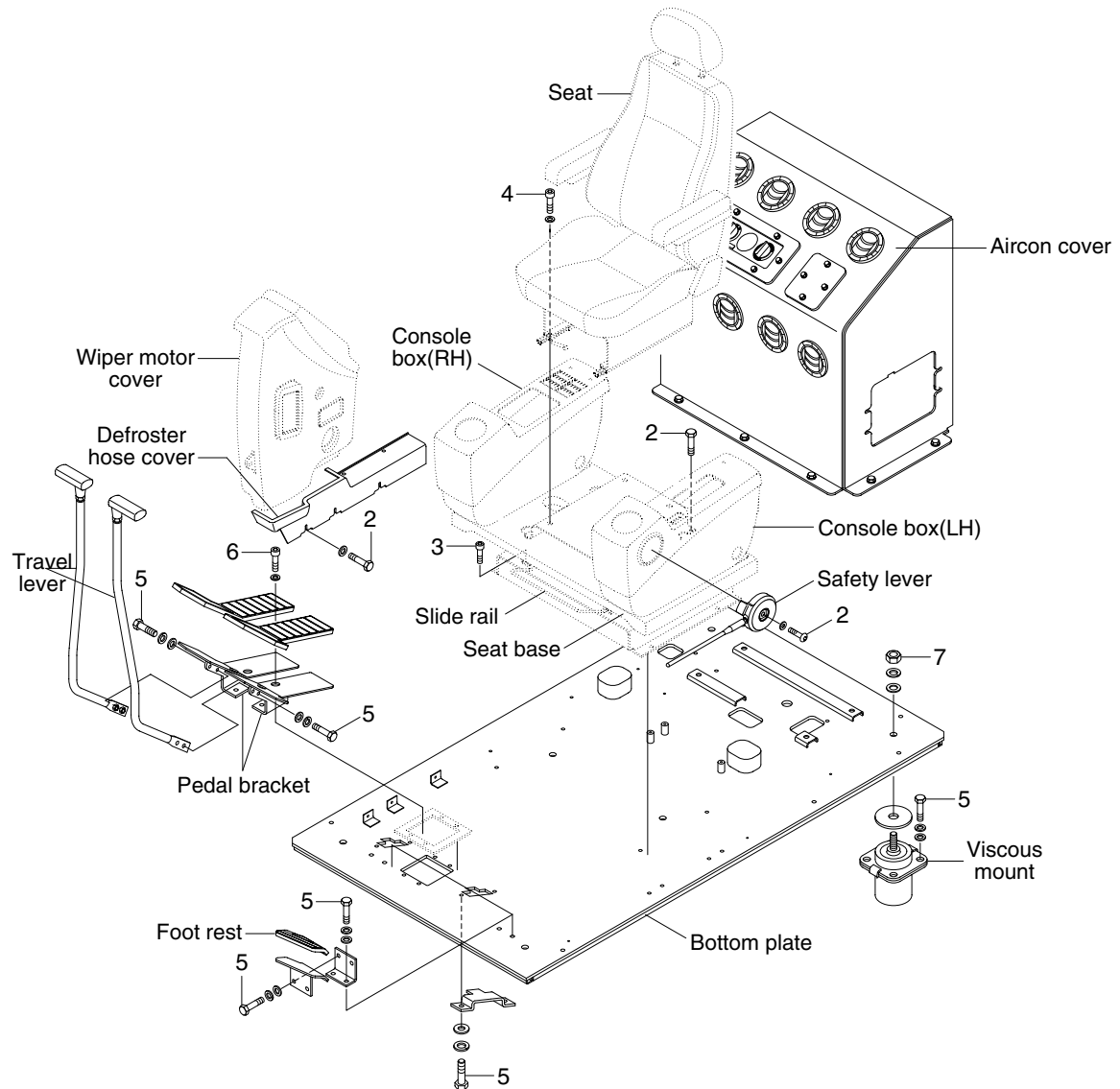
2107V9CM09

• Tightening torque

| Item | Size | kgf · m | lbf · ft |
|------|----------|----------|----------|
| 1 | M 6×1.0 | 0.49±0.1 | 3.5±0.7 |
| 2 | M 8×1.25 | 2.5±0.5 | 18.1±3.6 |
| 3 | M10×1.5 | 4.7±0.9 | 34±6.5 |

| Item | Size | kgf · m | lbf · ft |
|------|----------|----------|-----------|
| 4 | M10×1.5 | 6.9±1.4 | 49.9±10.1 |
| 5 | M12×1.75 | 12.8±3.0 | 92.6±21.7 |
| 6 | M16×2.0 | 29.7±4.5 | 215±32.5 |

CAB INTERIOR MOUNTING



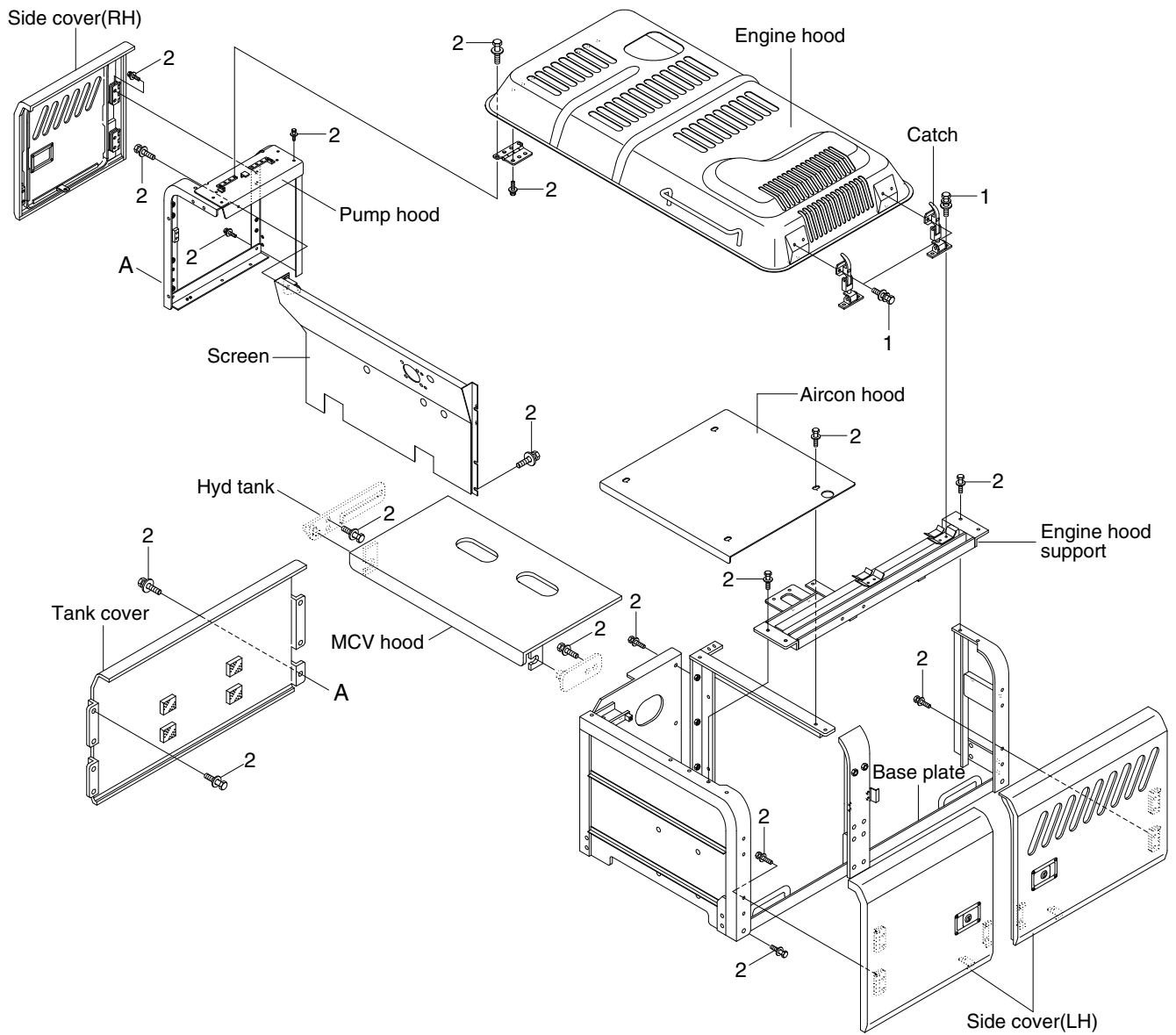
R2107V9CM10

• Tightening torque

| Item | Size | kgf · m | lbf · ft |
|------|----------|----------|----------|
| 1 | M 6×1.0 | 0.49±0.1 | 3.5±0.7 |
| 2 | M 6×1.0 | 1.05±0.2 | 7.6±1.4 |
| 3 | M 8×1.25 | 3.43±0.7 | 24.8±5.1 |
| 4 | M 8×1.25 | 4.05±0.8 | 29.3±5.8 |

| Item | Size | kgf · m | lbf · ft |
|------|---------|----------|-----------|
| 5 | M10×1.5 | 6.9±1.4 | 49.9±10.1 |
| 6 | M10×1.5 | 8.27±1.7 | 59.8±12.3 |
| 7 | M16×2.0 | 29.7±4.5 | 215±32.5 |
| - | - | - | - |

COWLING MOUNTING

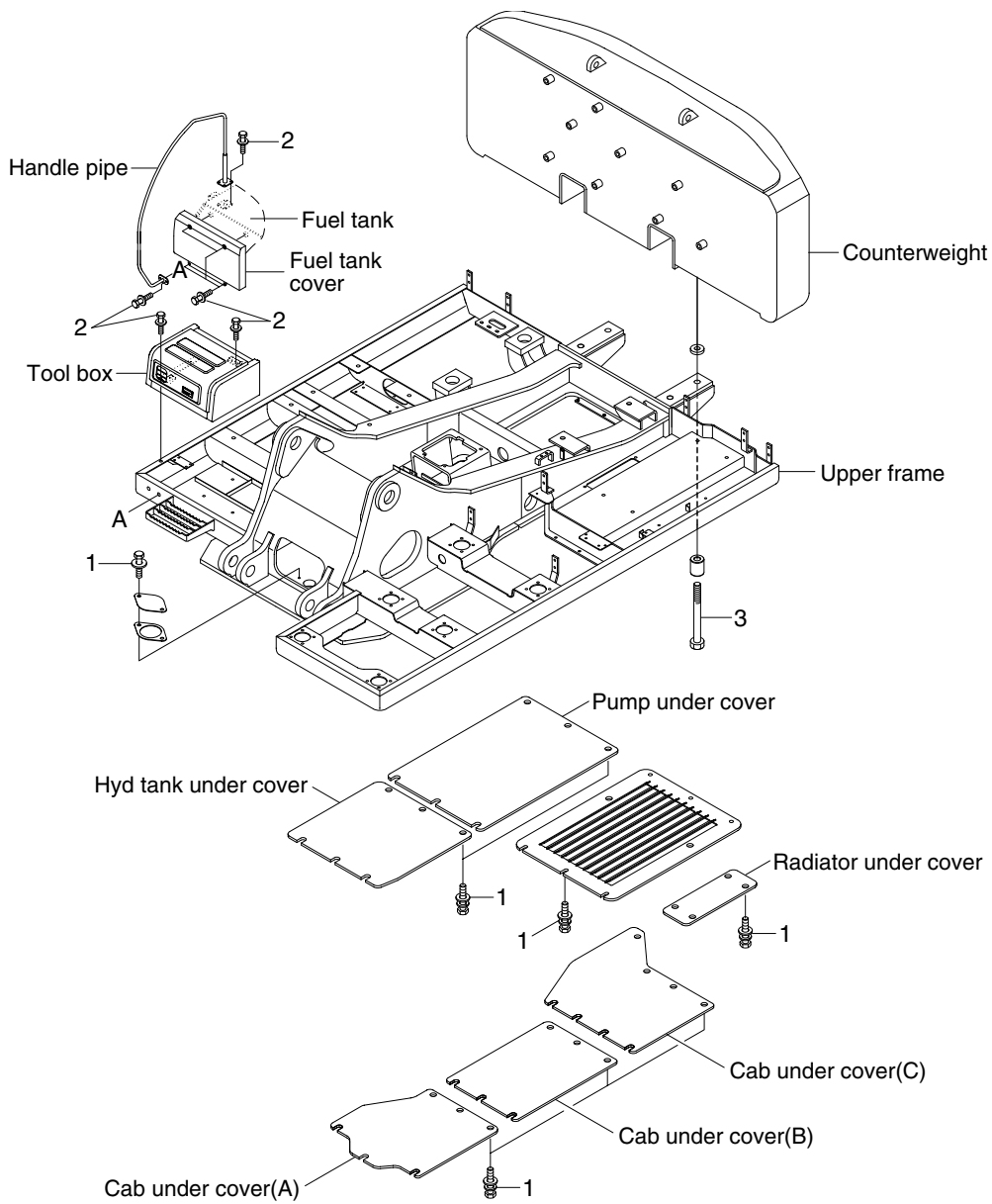


R2107V9CM11

· Tightening torque

| Item | Size | kgf · m | lbf · ft |
|------|----------|----------|-----------|
| 1 | M 8×1.25 | 2.5±0.5 | 18.1±3.6 |
| 2 | M12×1.75 | 12.8±3.0 | 92.6±21.7 |

COUNTERWEIGHT AND COVERS MOUNTING



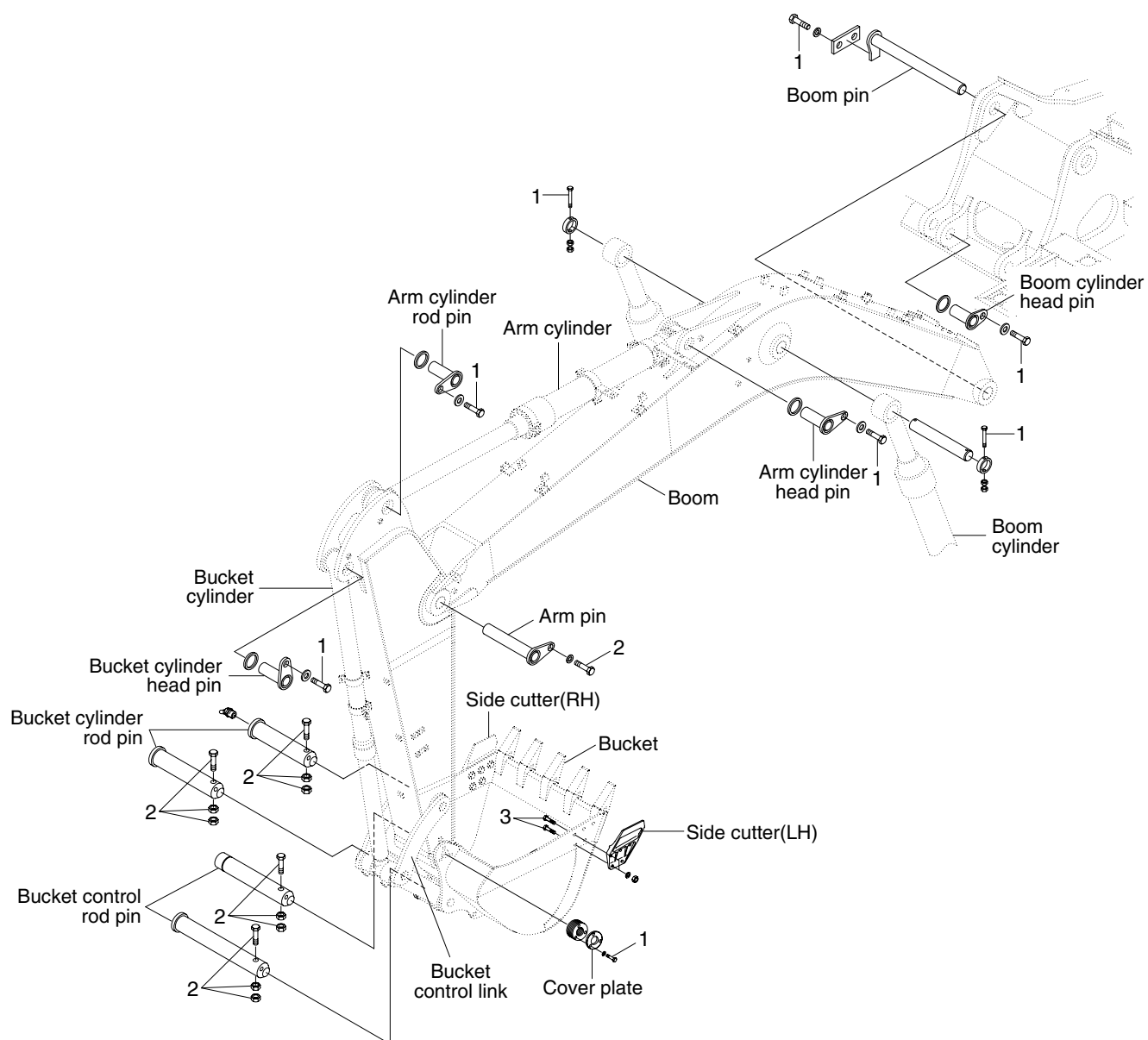
R2107V9CM12

· Tightening torque

| Item | Size | kgf · m | lbf · ft |
|------|----------|----------|-----------|
| 1 | M10×1.5 | 6.9±1.4 | 49.9±10.1 |
| 2 | M12×1.75 | 12.8±3.0 | 92.6±21.7 |

| Item | Size | kgf · m | lbf · ft |
|------|---------|---------|----------|
| 3 | M36×3.0 | 308±46 | 2228±333 |
| - | - | - | - |

GROUP 7 WORK EQUIPMENT



2107V9CM13

· Tightening torque

| Item | Size | kgf · m | lbf · ft |
|------|---------|----------|----------|
| 1 | M16×2.0 | 29.7±4.5 | 215±32.5 |
| 2 | M20×2.5 | 57.9±8.7 | 419±62.9 |

| Item | Size | kgf · m | lbf · ft |
|------|---------|----------|----------|
| 3 | M22×2.5 | 55.8±7.5 | 404±54.2 |
| - | - | - | - |