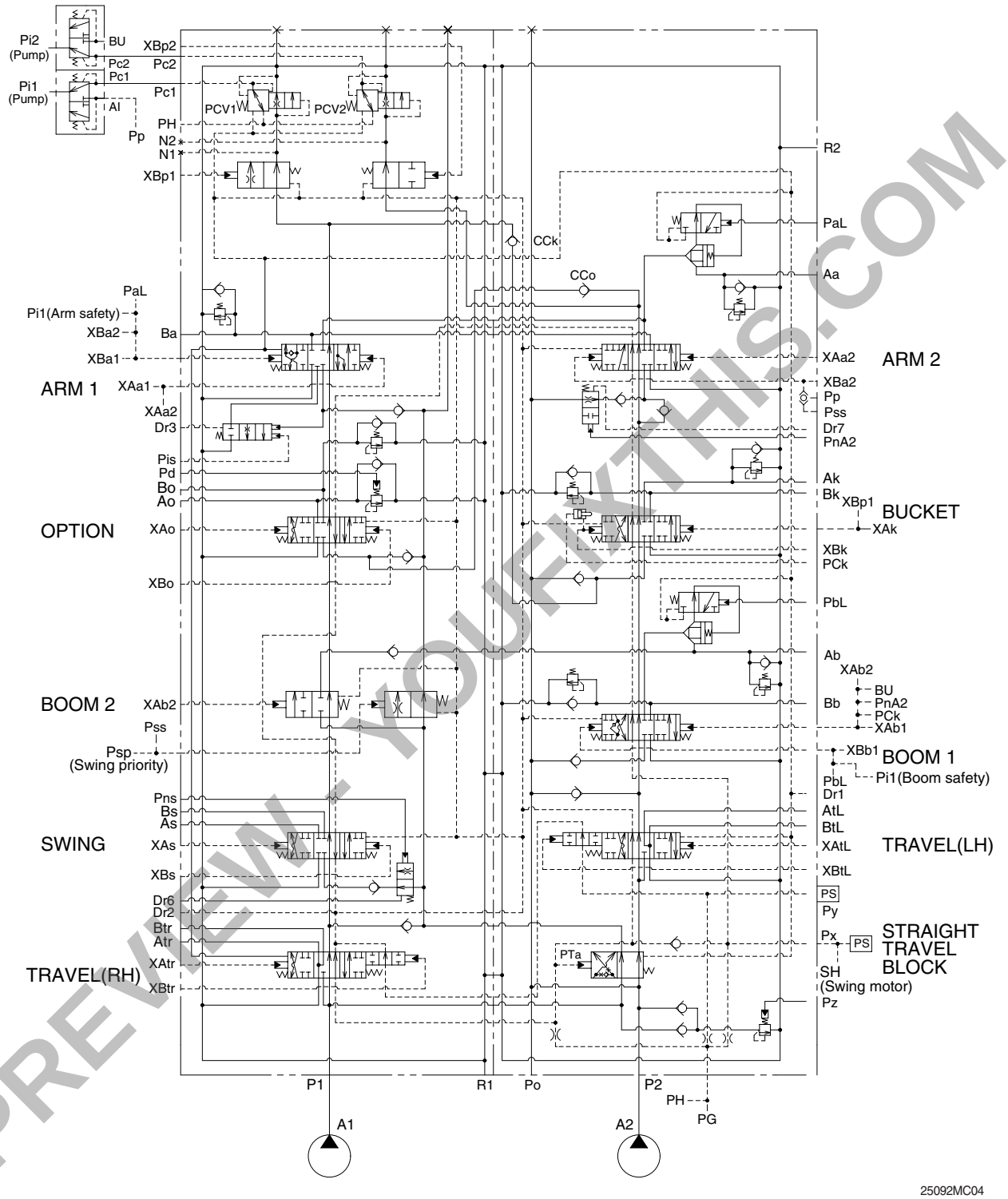
2. HYDRAULIC CIRCUIT



25092MC04

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3) DISASSEMBLY

(1) Select place suitable to disassembling.

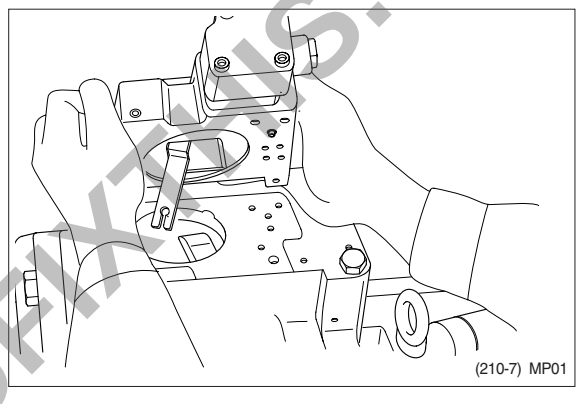
※ Select clean place.

※ 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.



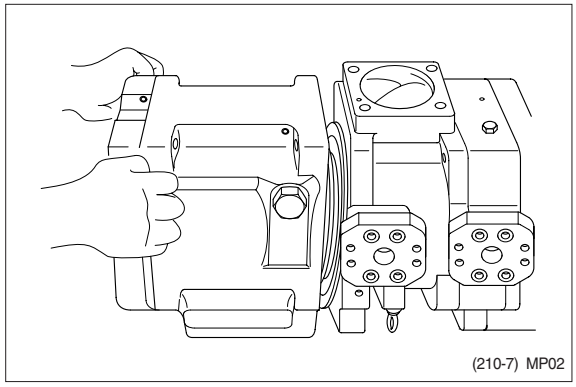
(210-7) MP01

(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.



(210-7) MP02

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GROUP 2 TIGHTENING TORQUE

1. MAJOR COMPONENTS

No.	Descriptions		Bolt size	Torque	
				kgf · m	lbf · ft
1	Engine	Engine mounting bolt (engine-bracket)	M12 × 1.75	10	72.3
2		Engine mounting bolt (bracket-frame, FR)	M20 × 2.5	55 ± 3.5	398 ± 25.3
3		Engine mounting bolt (bracket-frame, RR)	M24 × 3.0	97 ± 7.0	702 ± 50.6
4		Radiator mounting bolt	M16 × 2.0	29.7 ± 4.5	215 ± 32.5
5		Coupling mounting socket bolt	M18 × 2.5	32 ±1.0	231 ±7.2
6		Fuel tank mounting bolt	M20 × 2.5	46 ± 5.1	333 ± 36.9
7	Hydraulic system	Main pump housing mounting bolt	M10 × 1.5	4.8 ± 0.3	34.7 ± 2.2
8		Main pump mounting socket bolt	M20 × 2.5	42 ± 4.5	304 ± 32.5
9		Main control valve mounting nut	M12 × 1.75	12.3 ± 1.3	89.0 ± 9.4
10		Hydraulic oil tank mounting bolt	M20 × 2.5	46 ± 5.1	333 ± 36.9
11		Turning joint mounting bolt, nut	M12 × 1.75	12.3 ± 1.3	89.0 ± 9.4
12	Power train system	Swing motor mounting bolt	M24 × 3.0	97.8 ± 10	707 ± 72.3
13		Swing bearing upper part mounting bolt	M20 × 2.5	57.8 ± 6.4	418 ± 46.3
14		Swing bearing lower part mounting bolt	M20 × 2.5	57.8 ± 6.4	418 ± 46.3
15		Travel motor mounting bolt	M16 × 2.0	23 ± 2.5	166 ± 18.1
16		Sprocket mounting bolt	M16 × 2.0	26 ± 2.5	188 ± 18.1
17	Under carriage	Carrier roller mounting bolt, nut	M16 × 2.0	23 ± 2.5	166 ± 18.1
18		Track roller mounting bolt	M16 × 2.0	29.7 ± 4.5	215 ± 32.5
19		Track tension cylinder mounting bolt	M16 × 2.0	29.7 ± 4.5	215 ± 32.5
20		Track shoe mounting bolt, nut	M20 × 1.5	78 ± 8.0	564 ± 57.9
21		Track guard mounting bolt	M20 × 2.5	57.9 ± 8.7	419 ± 62.9
22	Others	Counterweight mounting bolt	M36 × 3.0	340 ± 10	2460 ± 72.3
23		Cab mounting bolt	M12 × 1.75	12.8 ± 3.0	92.6 ± 21.7
24		Operator's seat mounting bolt	M 8 × 1.25	4.05 ± 0.8	29.3 ± 5.8

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3. MACHINE ERROR CODES TABLE

Error code		Description
HCESPN	FMI	
101	3	Hydraulic oil temperature sensor circuit - Voltage above normal, or shorted to high source.
	4	Hydraulic oil temperature circuit - Voltage below normal, or shorted to low source.
105	0	Working pressure sensor data above normal range.
	1	Working pressure sensor data below normal range.
	2	Working pressure sensor data error.
	4	Working pressure sensor circuit - Voltage below normal, or shorted to Low source.
108	0	Travel oil pressure sensor data above normal range.
	1	Travel oil pressure sensor data below normal range.
	2	Travel oil pressure sensor data error.
	4	Travel oil pressure sensor circuit - Voltage below normal, or shorted to low source.
120	0	Main pump 1 (P1) pressure sensor data above normal range.
	1	Main pump 1 (P1) pressure sensor data below normal range.
	2	Main pump 1 (P1) pressure sensor data error.
	4	Main pump 1 (P1) pressure sensor circuit - Voltage below normal, or shorted to low source.
121	0	Main pump 2 (P2) pressure sensor data above normal range.
	1	Main pump 2 (P2) pressure sensor data below normal range.
	2	Main pump 2 (P2) pressure sensor data error.
	4	Main pump 2 (P2) pressure sensor circuit - Voltage below normal, or shorted to low source.
122	0	Overhead pressure sensor data above normal range.
	1	Overhead pressure sensor data below normal range.
	2	Overhead pressure sensor data error.
	4	Overhead pressure sensor circuit - Voltage below normal, or shorted to low source.
123	0	Negative 1 pressure sensor data above normal range.
	1	Negative 1 pressure sensor data below normal range.
	2	Negative 1 pressure sensor data error.
	4	Negative 1 pressure sensor circuit - Voltage below normal, or shorted to low source.
124	0	Negative 2 Pressure sensor data above normal range.
	1	Negative 2 Pressure sensor data below normal range.
	2	Negative 2 Pressure sensor data error.
	4	Negative 2 Pressure sensor circuit - Voltage below normal, or shorted to low source.
125	0	Pilot pump (P3) pressure sensor data above normal range.
	1	Pilot pump (P3) pressure sensor data below normal range.
	2	Pilot pump (P3) pressure sensor data error.
	4	Pilot pump (P3) pressure sensor circuit - Voltage below normal, or shorted to low source.
127	0	Boom up pilot pressure sensor data above normal range.
	1	Boom up pilot pressure sensor data below normal range.
	2	Boom up pilot pressure sensor data error.
	4	Boom up pilot pressure sensor circuit - Voltage below normal, or shorted to low source.
133	0	Arm in/out & bucket in pilot pressure sensor data above normal range.
	1	Arm in/out & bucket in pilot pressure sensor data below normal range.
	2	Arm in/out & bucket in pilot pressure sensor data error.
	4	Arm in/out & bucket in pilot pressure sensor circuit - Voltage below normal, or shorted to low source.

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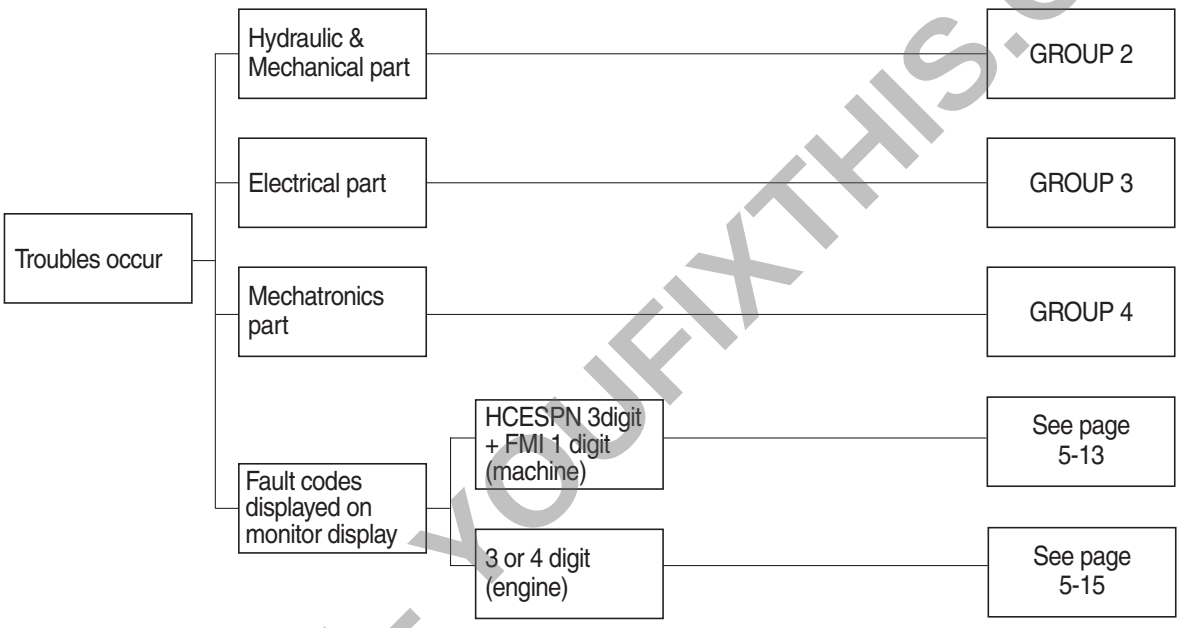
GROUP 1 BEFORE TROUBLESHOOTING

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.

※ **Before carring out troubleshooting procedure, check monitoring menu in the cluster.**



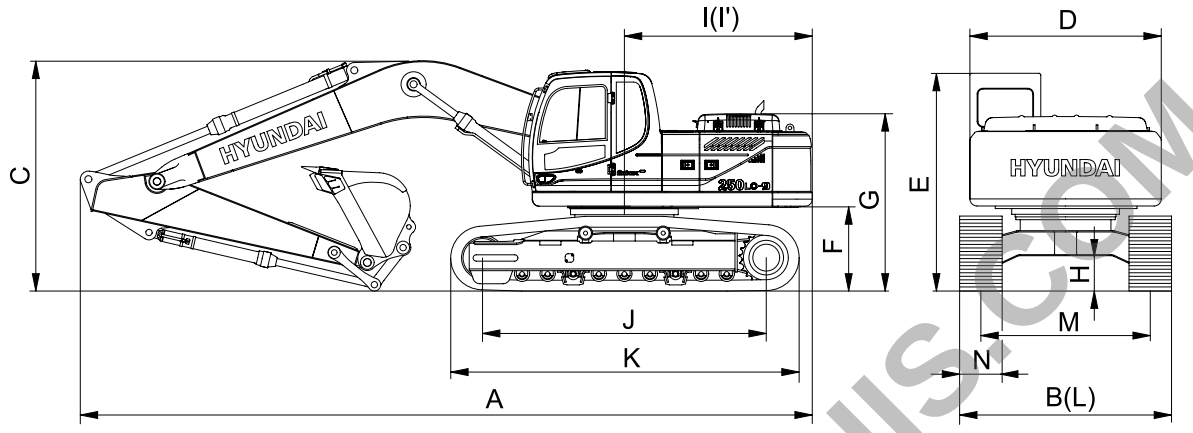
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2. SPECIFICATIONS

1) R250LC-9

· 5.85 m (19' 2") BOOM and 3.05 m (10' 0") ARM



25092SP02

Description		Unit	Specification
Operating weight		kg (lb)	25200 (55600)
Bucket capacity (SAE heaped), standard		m^3 (yd^3)	1.08 (1.41)
Overall length	A	mm (ft-in)	9920 (32' 7")
Overall width, with 600mm shoe	B		3180 (10' 5")
Overall height	C		3220 (10' 7")
Superstructure width	D		2840 (9' 4")
Overall height of cab	E		2990 (9' 10")
Ground clearance of counterweight	F		1115 (3' 8")
Engine cover height	G		2427 (7' 12")
Minimum ground clearance	H		480 (1' 7")
Rear-end distance	I		2870 (9' 5")
Rear-end swing radius	I'		2975 (9' 9")
Distance between tumblers	J		3830 (12' 7")
Undercarriage length	K		4640 (15' 3")
Undercarriage width	L		3180 (10' 5")
Track gauge	M		2580 (8' 6")
Track shoe width, standard	N		600 (24")
Travel speed (low/high)		km/hr (mph)	3.3/5.3 (2.1/3.3)
Swing speed		rpm	12
Gradeability		Degree (%)	35 (70)
Ground pressure (600 mm shoe)		kgf/cm^2 (psi)	0.51 (7.25)
Max traction force		kg (lb)	21600 (47600)

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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.

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(2) 5.85 m (19' 2") boom, 2.50 m (8' 2") arm equipped with 1.08 m³ (SAE heaped) bucket and 600 mm (24") triple grouser shoe and 4600 kg (10140 lb) counterweight.

Load point height		Load radius										At max. reach		
		1.5 m (5 ft)		3.0 m (10 ft)		4.5 m (15 ft)		6.0 m (20ft)		7.5 m (25ft)		Capacity		Reach
														m (ft)
6.0 m (20 ft)	kg											4900	3000	8.67
	lb											10800	6610	(28.4)
4.5 m (15 ft)	kg							*6070	5670	*5630	3770	4280	2550	9.23
	lb							*13380	12500	*12410	8310	9440	5620	(30.3)
3.0 m (10 ft)	kg					*9550	8410	*7210	5280	5950	3590	3990	2340	9.48
	lb					*21050	18540	*15900	11640	13120	7910	8800	5160	(31.1)
1.5 m (5 ft)	kg					*11790	7650	8310	4910	5750	3410	3950	2290	9.45
	lb					*25990	16870	18320	10820	12680	7520	8170	5050	(31.0)
Ground Line	kg					*12990	7280	8030	4660	5600	3270	4150	2410	9.13
	lb					*28640	16050	17700	10270	12350	7210	9150	5310	(30.0)
-1.5 m (-5 ft)	kg			*15100	14960	13050	7190	7910	4560	5550	3220	4690	2750	8.49
	lb			*33290	32980	28770	15850	17440	10050	12240	7100	10340	6060	(27.9)
-3.0 m (-10 ft)	kg	*16360	*16360	*18120	15250	*12470	7300	7970	4610			5940	3550	7.41
	lb	*36070	*36070	*39950	33620	*27490	16090	17570	10160			13100	7830	(24.3)
-4.5 m (-15 ft)	kg			*14860	*14860	*10430	7620							
	lb			*32760	*32760	*22990	16800							

(3) 5.85 m (19' 2") boom, 3.05 m (10' 0") arm equipped with 1.08 m³ (SAE heaped) bucket and 600 mm (24") triple grouser shoe and 4600 kg (10140 lb) counterweight.

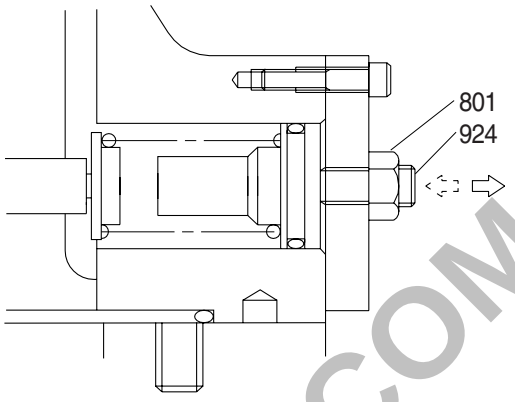
Load point height		Load radius										At max. reach		
		1.5 m (5 ft)		3.0 m (10 ft)		4.5 m (15 ft)		6.0 m (20ft)		7.5 m (25ft)		Capacity		Reach
														m (ft)
6.0 m (20 ft)	kg									*3700	*3700	4400	2660	9.22
	lb									*8160	*8160	9700	5860	(30.2)
4.5 m (15 ft)	kg							*5350	*5350	*5060	3830	3880	2280	9.74
	lb							*11790	*11790	*11160	8440	8550	5030	(32.0)
3.0 m (10 ft)	kg			*13640	*13640	*8400	*8400	*6540	5360	*5660	3620	3630	2090	9.98
	lb			*30070	*30070	*18520	*18520	*14420	11820	*12480	7980	8000	4610	(32.7)
1.5 m (5 ft)	kg			*9450	*9450	*10870	7800	*7820	4950	5750	3400	3580	2040	9.95
	lb			*20830	*20830	*23960	17200	*17240	10910	12680	7500	7890	4500	(32.6)
Ground Line	kg			*10570	*10570	*12490	7280	8010	4640	5560	3230	3730	2130	9.65
	lb			*23300	*23300	*27540	16050	17660	10230	12260	7120	8220	4700	(31.7)
-1.5 m (-5 ft)	kg	*9940	*9940	*13870	*13870	12930	7090	7830	4480	5460	3140	4150	2390	9.05
	lb	*21910	*21910	*30580	*30580	28510	15630	17260	9880	12040	6920	9150	5270	(29.7)
-3.0 m (-10 ft)	kg	*13540	*13540	*18430	14860	*12780	7110	7820	4470			5080	2980	8.06
	lb	*29850	*29850	*40630	32760	*28180	15670	17240	9850			11200	6570	(26.4)
-4.5 m (-15 ft)	kg	*17830	*17830	*16580	15340	*11360	7340	8020	4640			*5940	4480	6.48
	lb	*39310	*39310	*36550	33820	*25040	16180	17680	10230			*13100	9880	(21.3)

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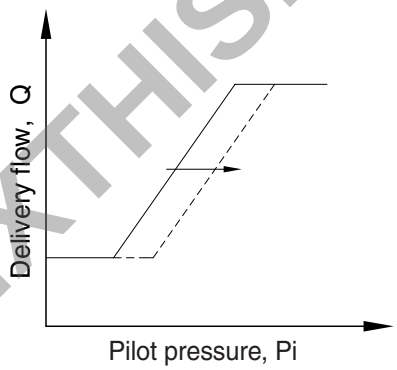
③ Adjustment of flow control characteristic

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 value**

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)
1900	+1/4	+1.0	+16.7



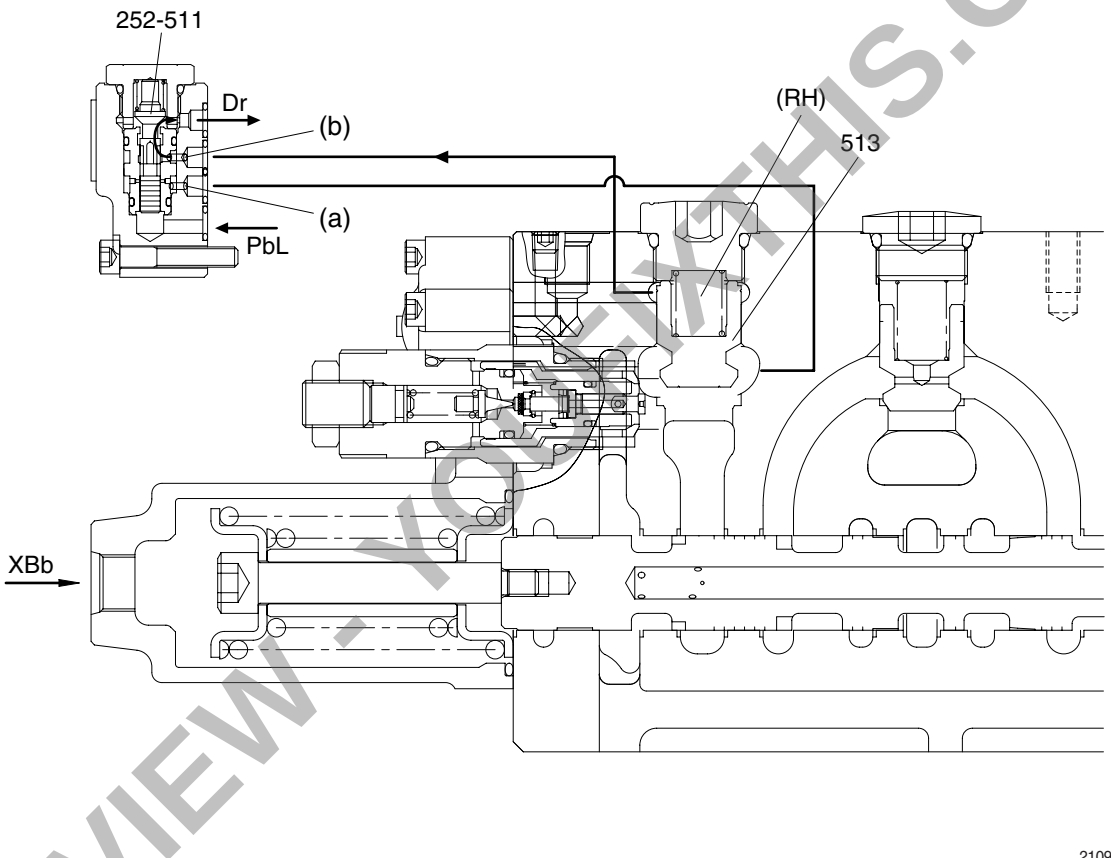
21092MP11

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(2) Boom down operation

During the boom down operation, the pilot pressure enters through Port PbL and XBb1. The pilot pressure transfers the spool (252-511) in the lock valve assy in the top direction. By the transfer of the spool (252-511), firstly the hole (a) is blocked and the pressurized oil from the boom cylinder head side does not enter to the spring chamber (RH). Secondly, the oil in the spring chamber (RH) enters through the hole (b) and flows to drain circuit. Therefore, the poppet (513) is lifted by the pressure of the boom cylinder head side and the function of the lock valve (252) is released.



21092MC36

(3) Boom up operation

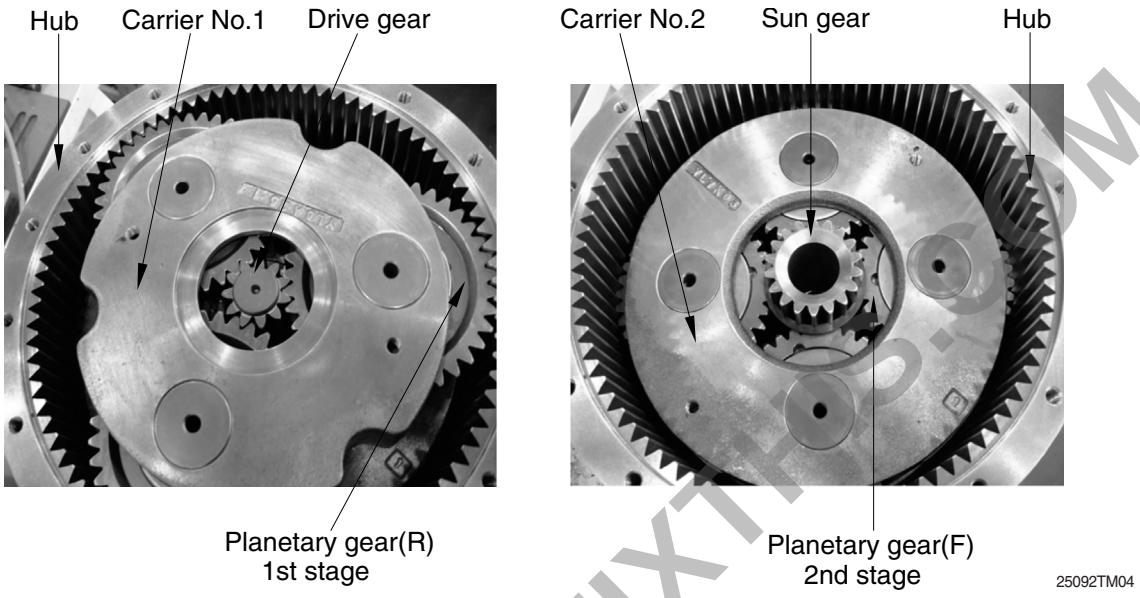
During the boom up operation, the pilot pressure enters through Port XAb1. The oil flowing from the boom 1 spool pushes open the poppet (513) and flows to Port Ab.

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3. REDUCTION GEAR

1) The reduction gear is composed of a two-stage planetary gear mechanism shown in the following figure.



2) The rotating motion of the hydraulic motor is transmitted to drive gear of 1st stage, and the drive gear rotate planetary gears (R). Then planetary gears (R) revolves inside fixed hub. This rotation becomes the output of 1st stage and is transmitted to carrier No.1 and sun gear. Similary the revolution of planetary gears (F) are transmitted to spindle. Then planetary gears (F) do not revolve, but rotate to hub. Therefore, the rotating case is driven by the overall driving torque of hub.

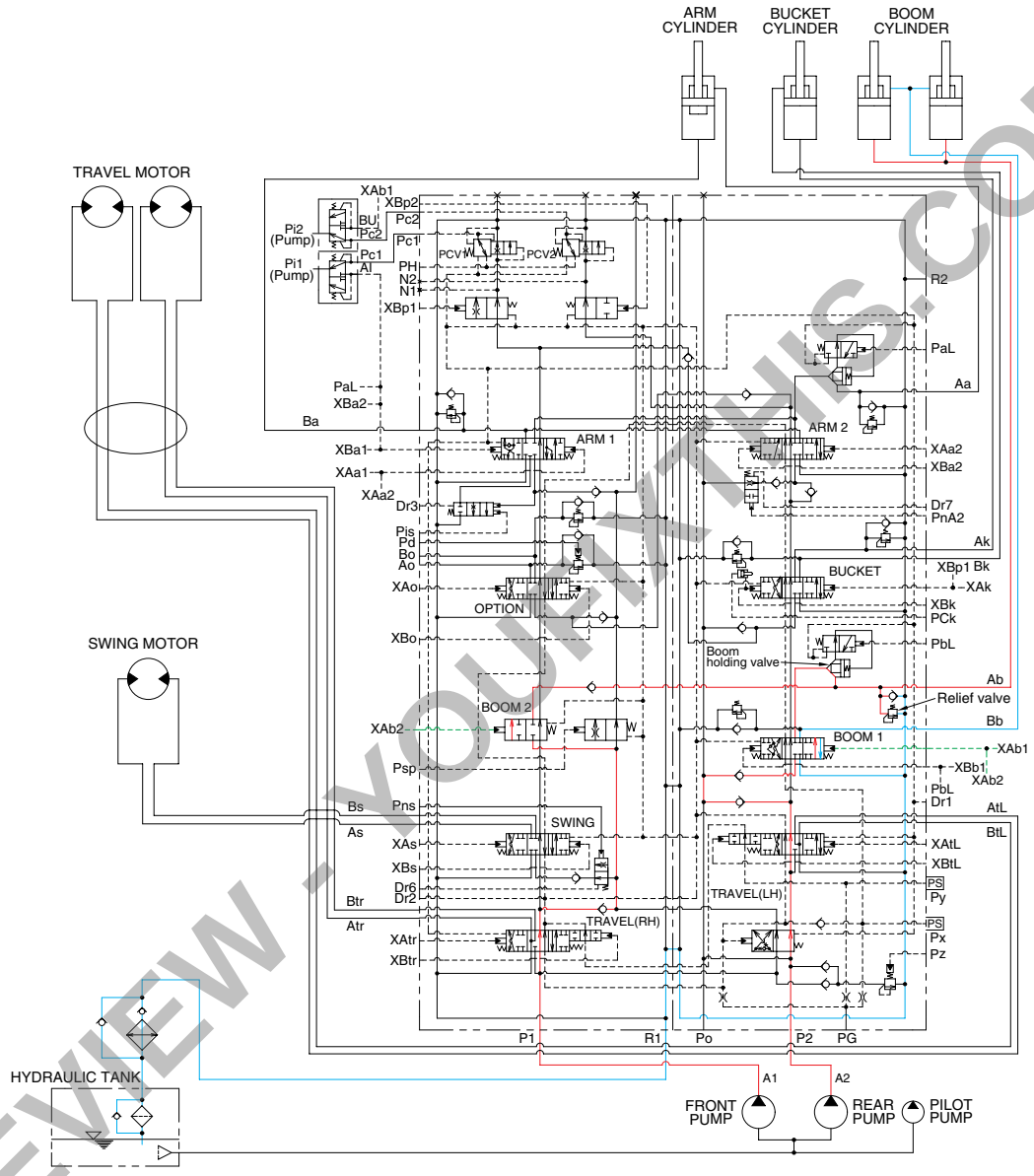
This reduction ratio is expressed as shown below :

Reduction ratio (I) = (Hub teeth / Drive gear teeth + 1) x (Hub teeth / Sun gear teeth + 1) - 1

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1. BOOM UP OPERATION



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 is prevented by relief valve.

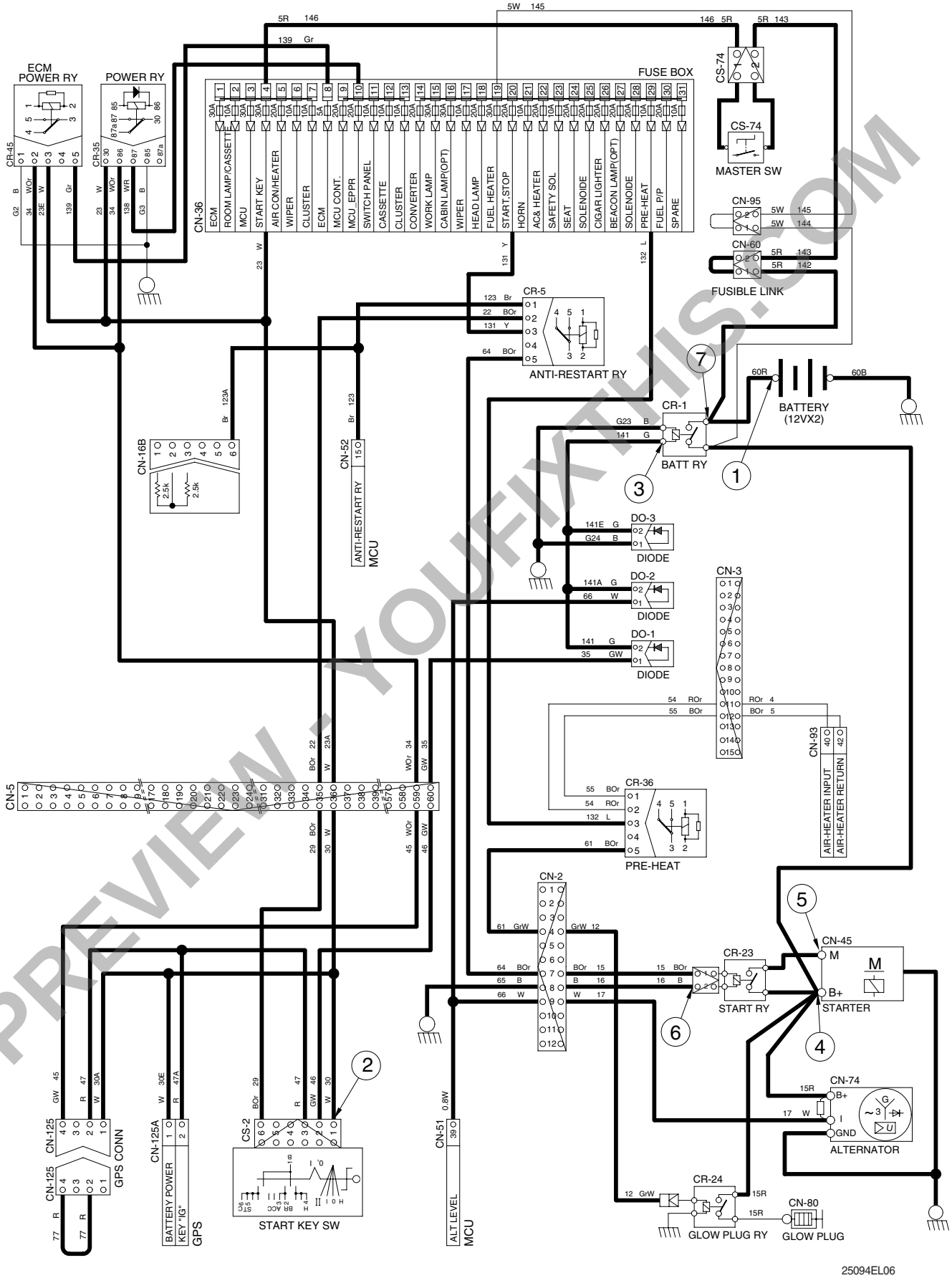
When the boom is up and the control lever is returned to neutral position, the circuit for the holding pressure at the bottom end of the boom cylinder is closed by the boom holding valve.

This prevents the hydraulic drift of boom cylinder.

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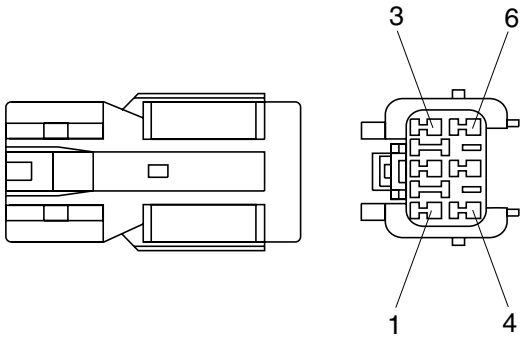
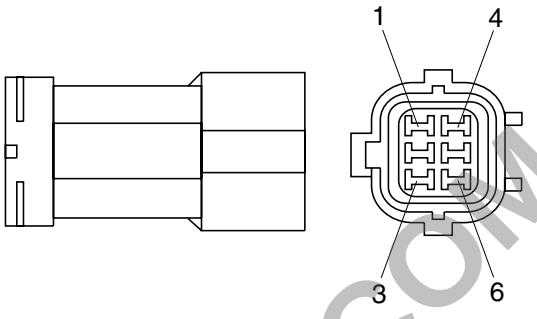
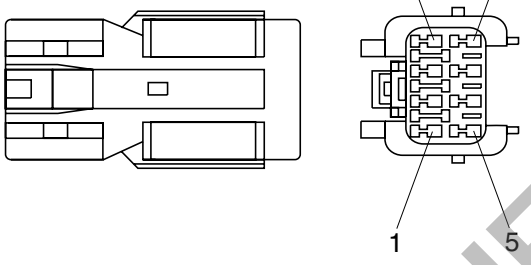
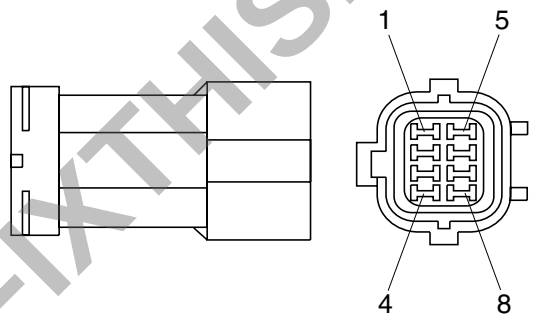
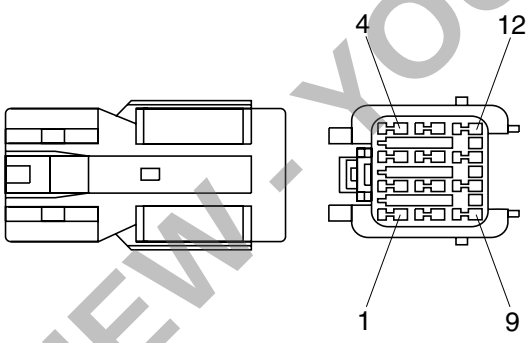
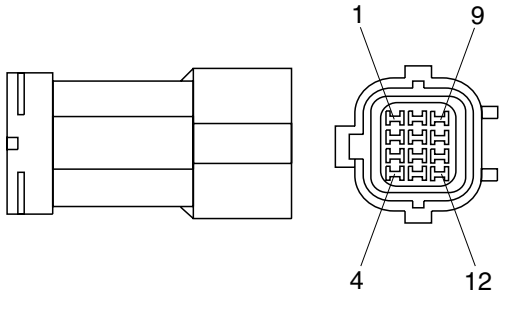
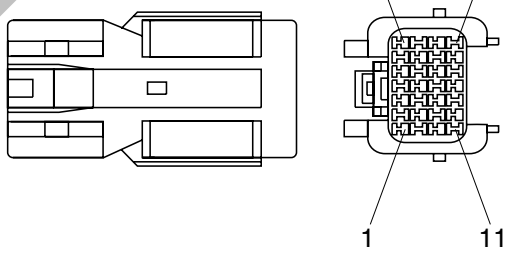
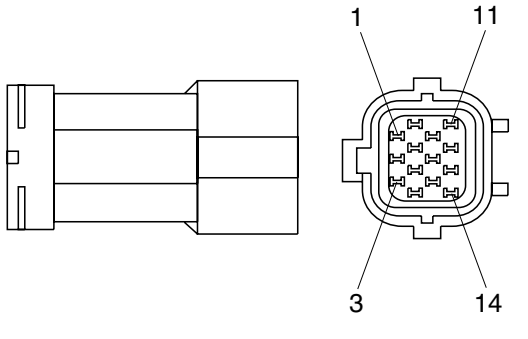
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STARTING CIRCUIT



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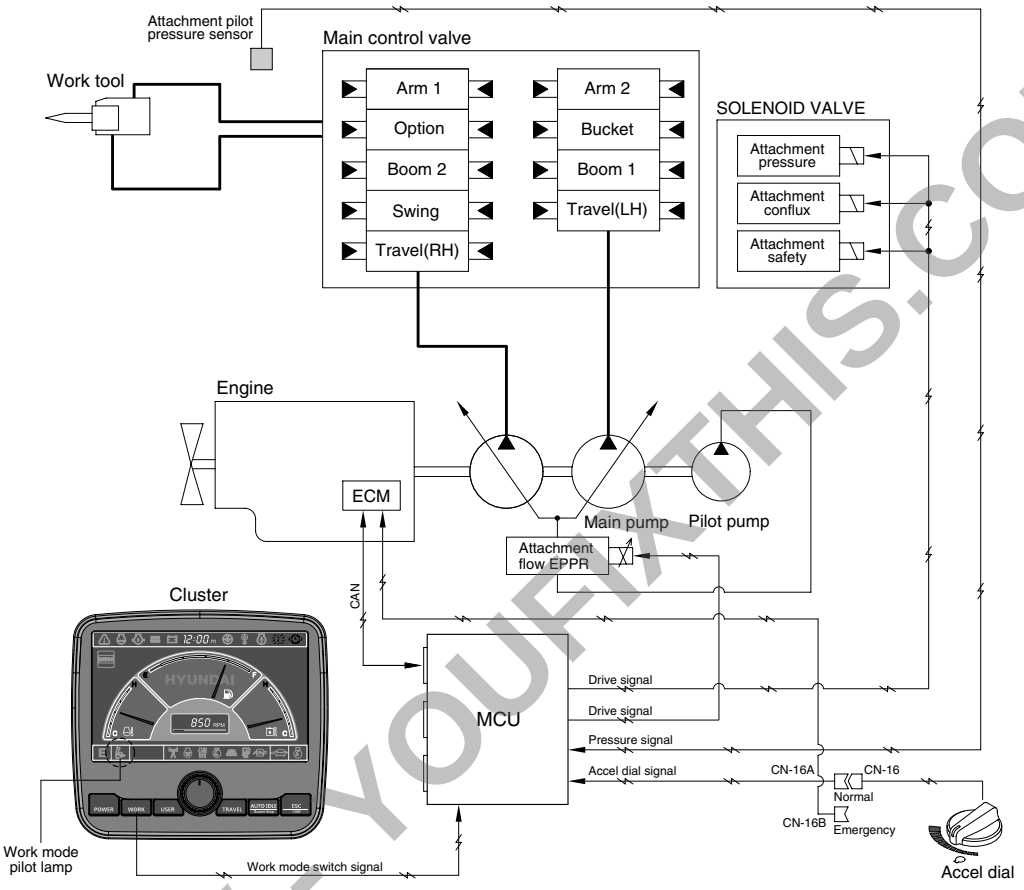
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No. of pin	Receptacle connector (female)	Plug connector (male)
6	 S814-006000	 S814-106000
8	 S814-008000	 S814-108000
12	 S814-012000	 S814-112000
14	 S814-014000	 S814-114000

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GROUP 9 ATTACHMENT FLOW CONTROL SYSTEM



21095MS11

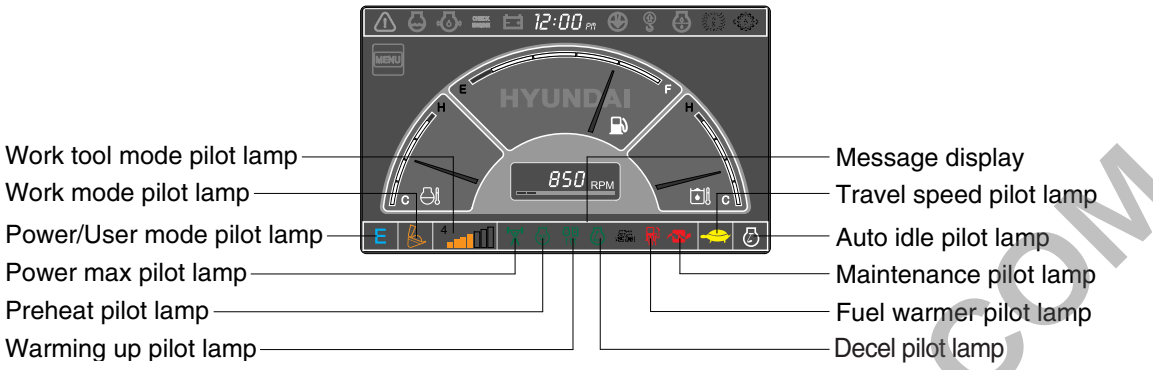
· The system is used to control the pump delivery flow according to set of the work tool on the cluster by the attachment flow EPPR valve.

Description	Work tool	
	Breaker	Crusher
Flow level	Max 7 step, reduced 10 lpm each step	Max 4 step, reduced 20 lpm each step
Attach safety solenoid	ON	ON
Attach pressure solenoid	OFF	ON
Attach conflux solenoid	OFF	ON/OFF

※ Refer to the page 5-45 for the attachment kinds and max flow.

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4) PILOT LAMPS



21093CD09

(1) Mode pilot lamps

No	Mode	Pilot lamp	Selected mode
1	Power mode	P	Heavy duty power work mode
		S	Standard power mode
		E	Economy power mode
2	User mode	U	User preferable power mode
3	Work mode		General operation mode
			Breaker operation mode
			Crusher operation mode
4	Travel mode		Low speed traveling
			High speed traveling
5	Auto idle mode		Auto idle
6	Work tool mode	4	Oil flow level of breaker or crusher mode
7	Message display	M	"Setting is completed" display after selection

(2) Power max pilot lamp



21093CD38

① The lamp will be ON when pushing power max switch on the LH RCV lever.

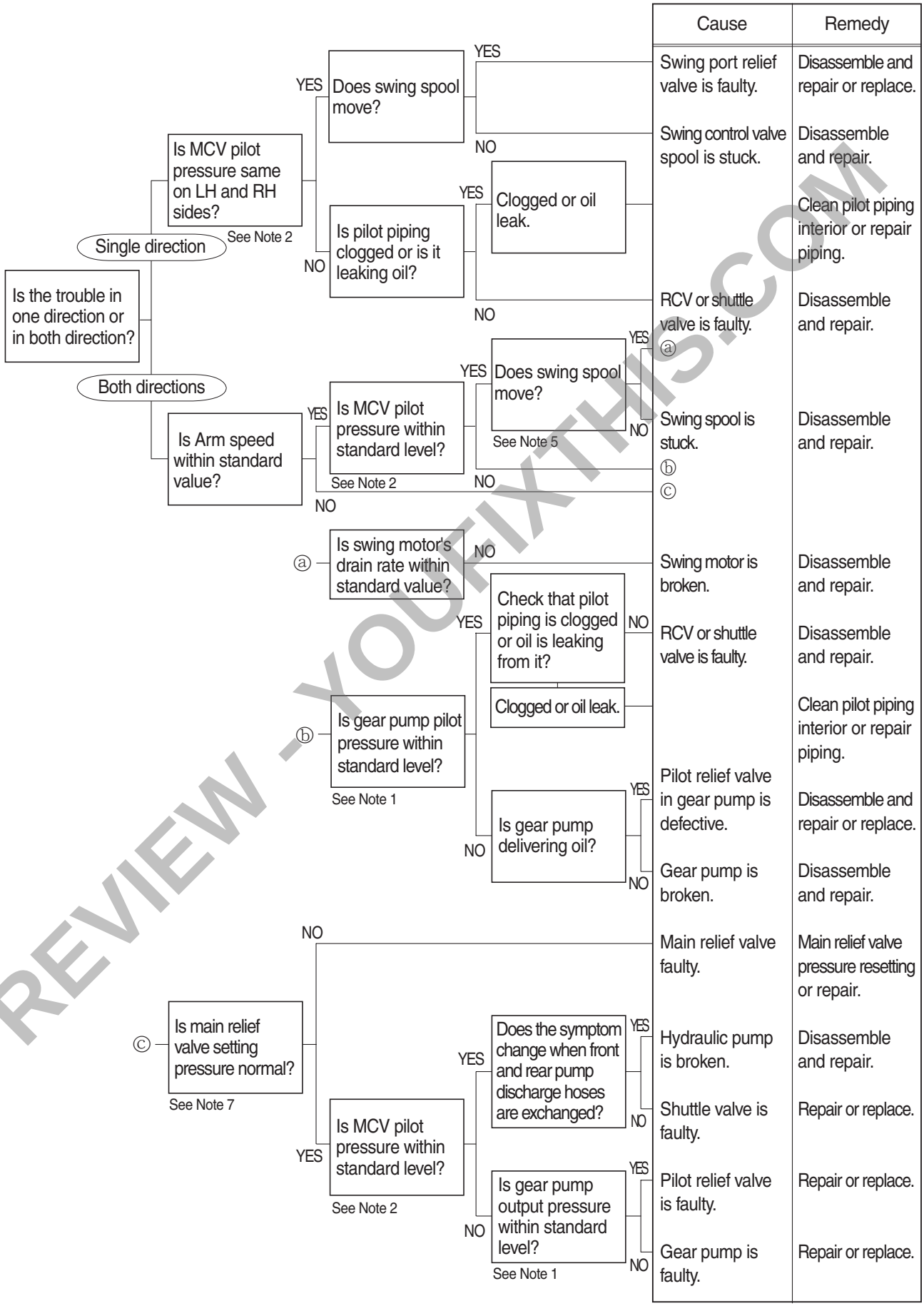
② The power max function is operated maximum 8 seconds.

※ **Refer to the operator's manual page 3-26 for power max function.**

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2) SWING SPEED IS LOW

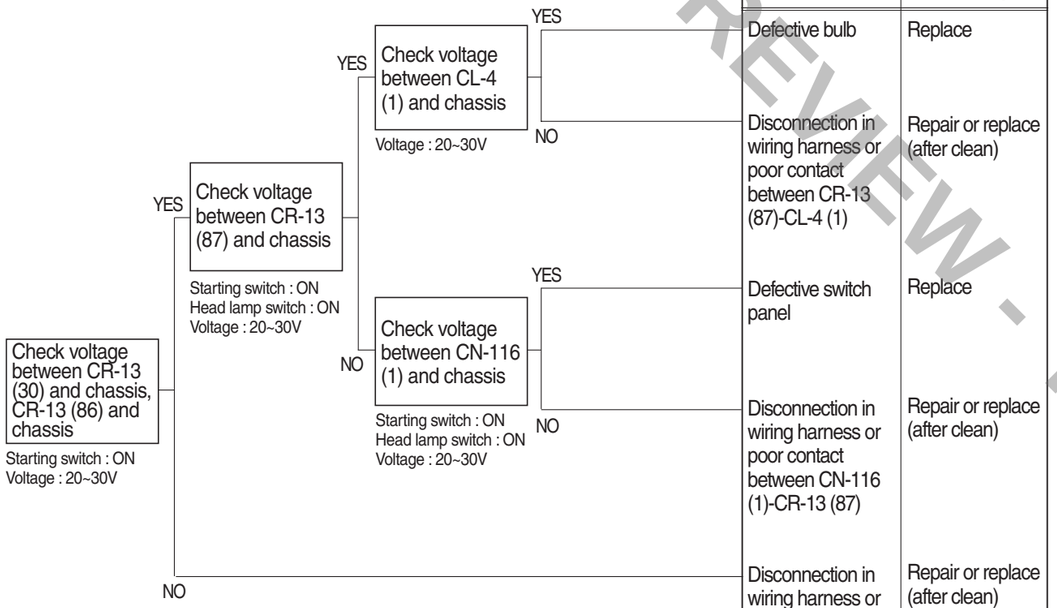


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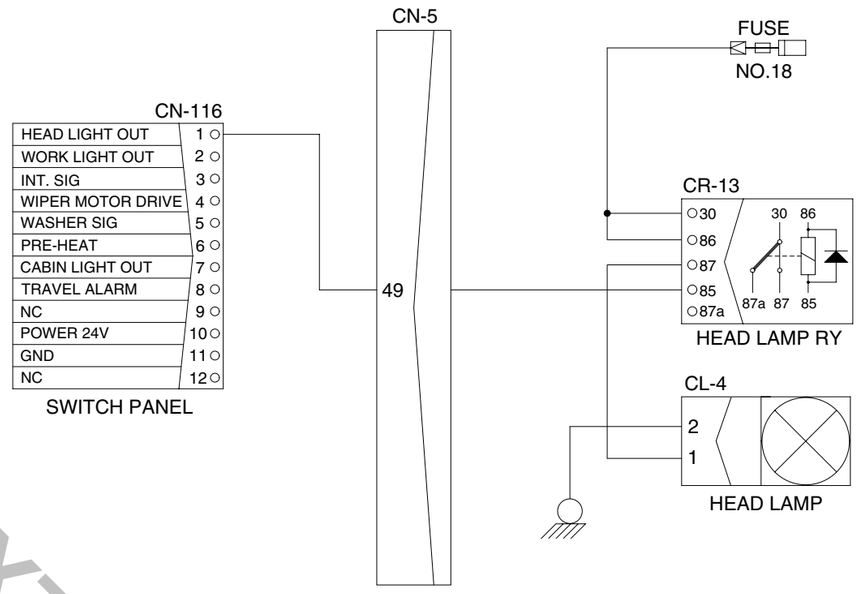
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15. WHEN STARTING SWITCH IS TURNED ON, HEAD LAMP DOES NOT LIGHTS UP

- 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.18.
- After checking, insert the disconnected connectors again immediately unless otherwise specified.



Cause	Remedy
Defective bulb	Replace
Disconnection in wiring harness or poor contact between CR-13 (87)-CL-4 (1)	Repair or replace (after clean)
Defective switch panel	Replace
Disconnection in wiring harness or poor contact between CN-116 (1)-CR-13 (87)	Repair or replace (after clean)
Disconnection in wiring harness or poor contact between CR-13 (30) and chassis or CR-13 (86) - chassis	Repair or replace (after clean)
Recheck fuse No. 18	Replace



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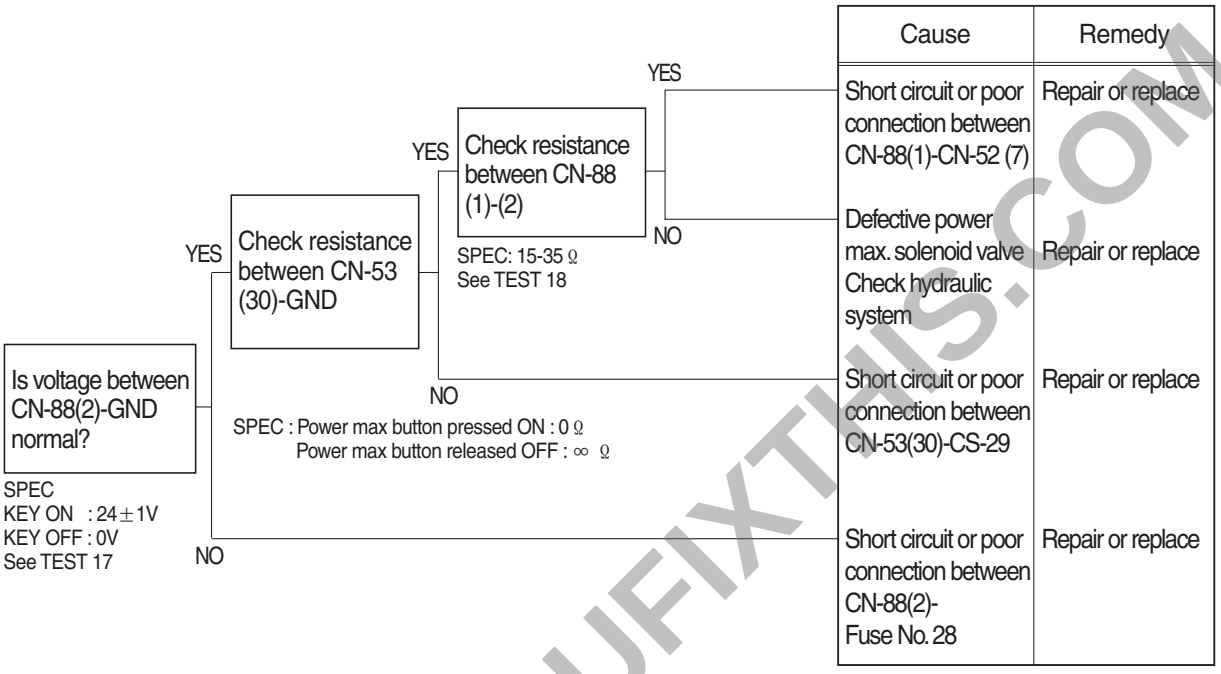
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14. MALFUNCTION OF POWER MAX

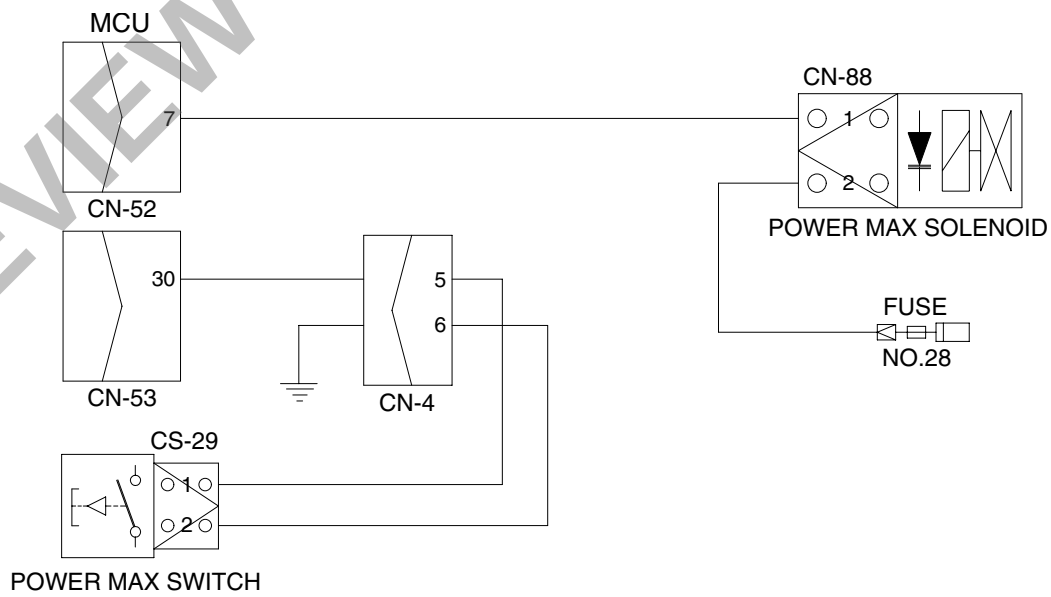
· Fault code : HCESPN 166, FMI 4 or 6

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

1) INSPECTION PROCEDURE



Wiring diagram

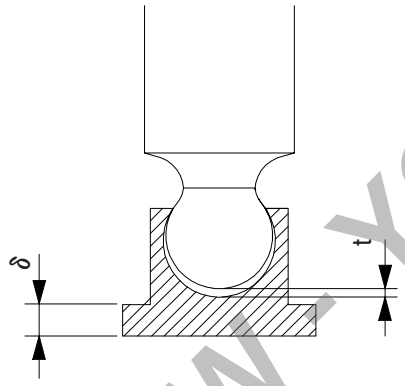
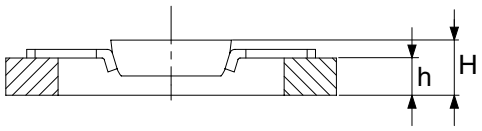


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3. SWING DEVICE

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 sperical bushing
Thickness of friction plate (h)	4.0	3.6	Replace
 2507A7MS04		 2507A7MS05	

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)	

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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.

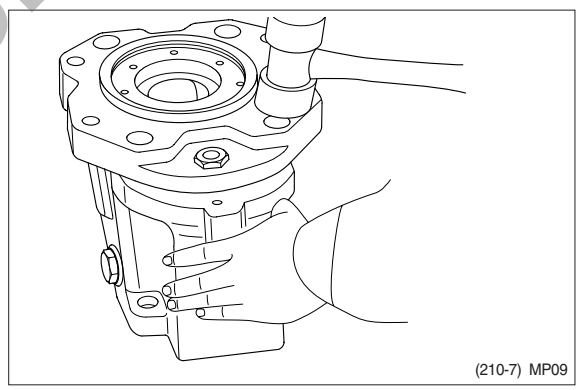
⑤ For fitting bolts, plug, etc., prepare a torque wrench or so on, and tighten them with torques shown in page 8-11, 12.

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.

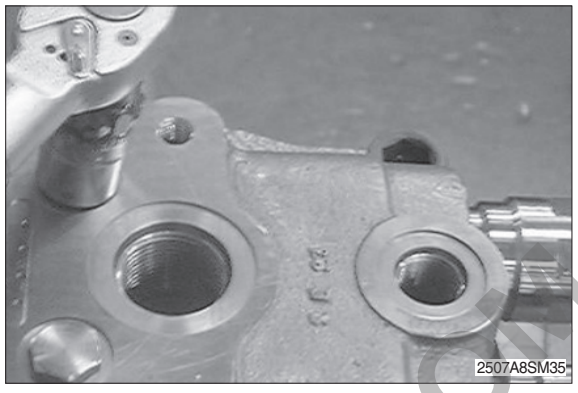


(210-7) MP09

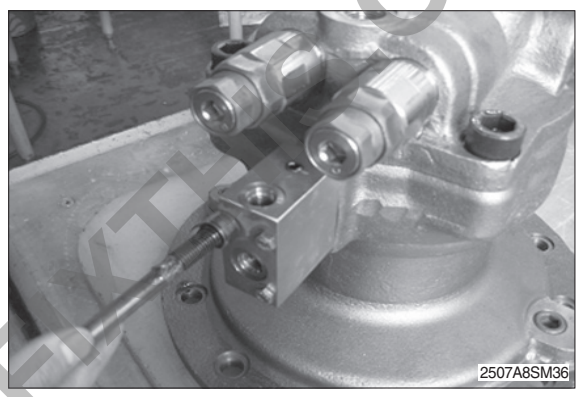
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(21) Tighten plug (468) with O-ring (487) to valve casing (303).
Tighten plug (464) with O-ring (485) to casing (301)



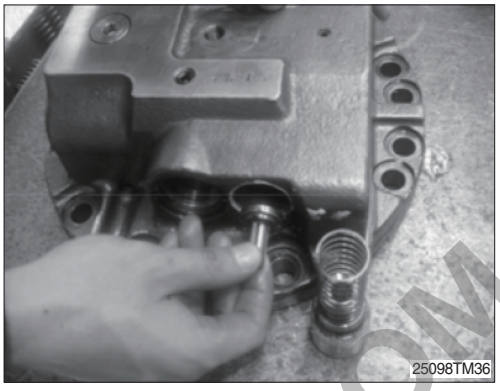
(22) Assemble time delay valve (761) to casing (301) and tightening the hex socket bolts to specified torque.



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② Remove the spring (32, 2EA), valve (30, 2EA) from rear flange (1).



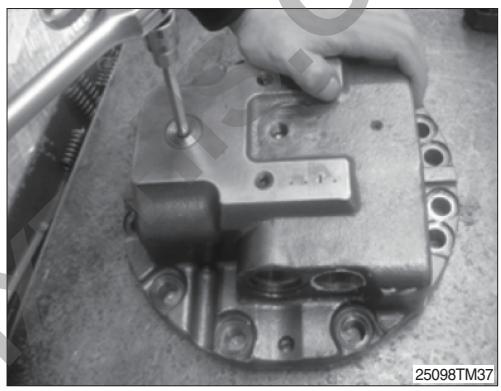
Disassembling the two speed valve

① Remove the plug (63) from the rear flange (1).

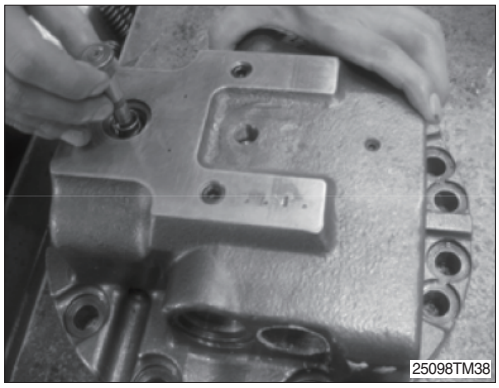
※ User can work easily if sub-disassembly was done on the reversal table.

※ Tools

· Hexagon wrench 10



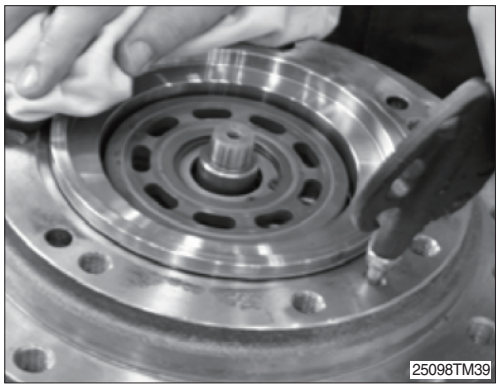
② Remove the spool (65) and spring (66) from rear flange (1).



(8) Disassembling the parking brake

① Remove the piston (212) by injecting compressed air from the parking brake access hole in the spindle (101).

※ Use the protection cover on the upper part of spindle (101) when users put the pressed air into suddenly. Otherwise part damage and accident might go on because the piston (212) is rushed out of the spindle (101).



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(16) 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.

(17) Rust prevention of parts

Apply rust-preventives to all parts.

※ If left as they after being cleaned, they will be rusted and will not display their functions fully after being reassembled.

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1. TRACK LINK

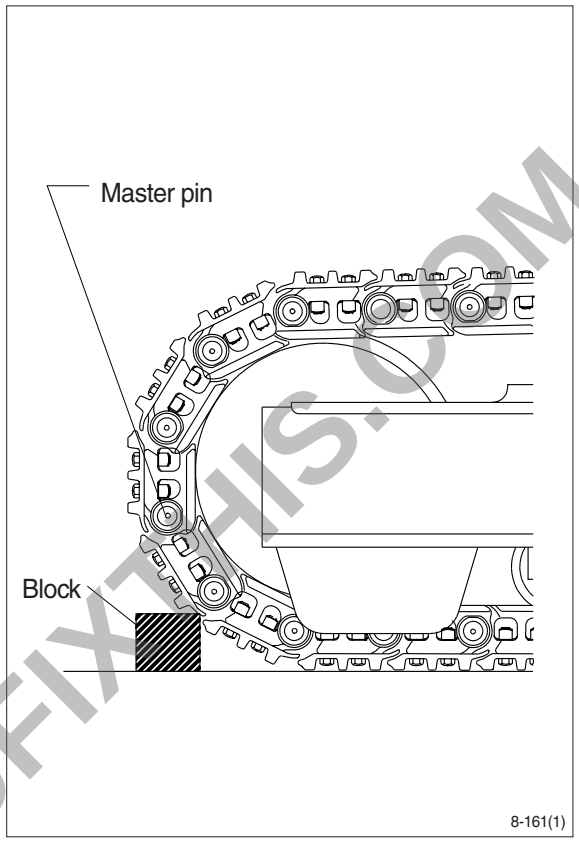
1) REMOVAL

(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.

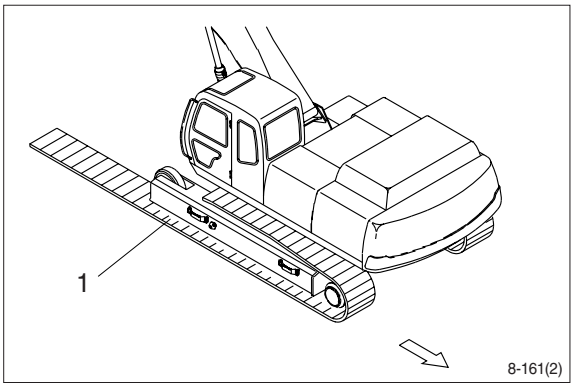


8-161(1)

(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.

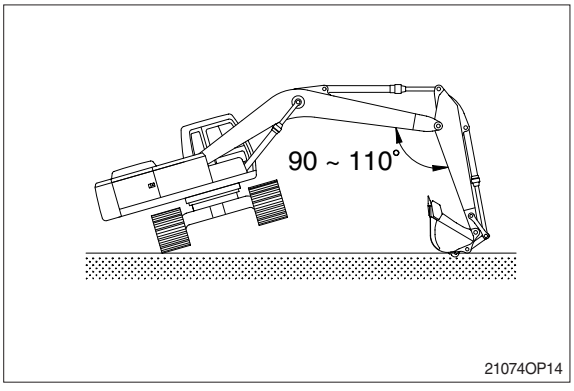


8-161(2)

2) INSTALL

(1) Carry out installation in the reverse order to removal.

※ Adjust the tension of the track link.



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