SPECIFICATIONS

PC20R-8

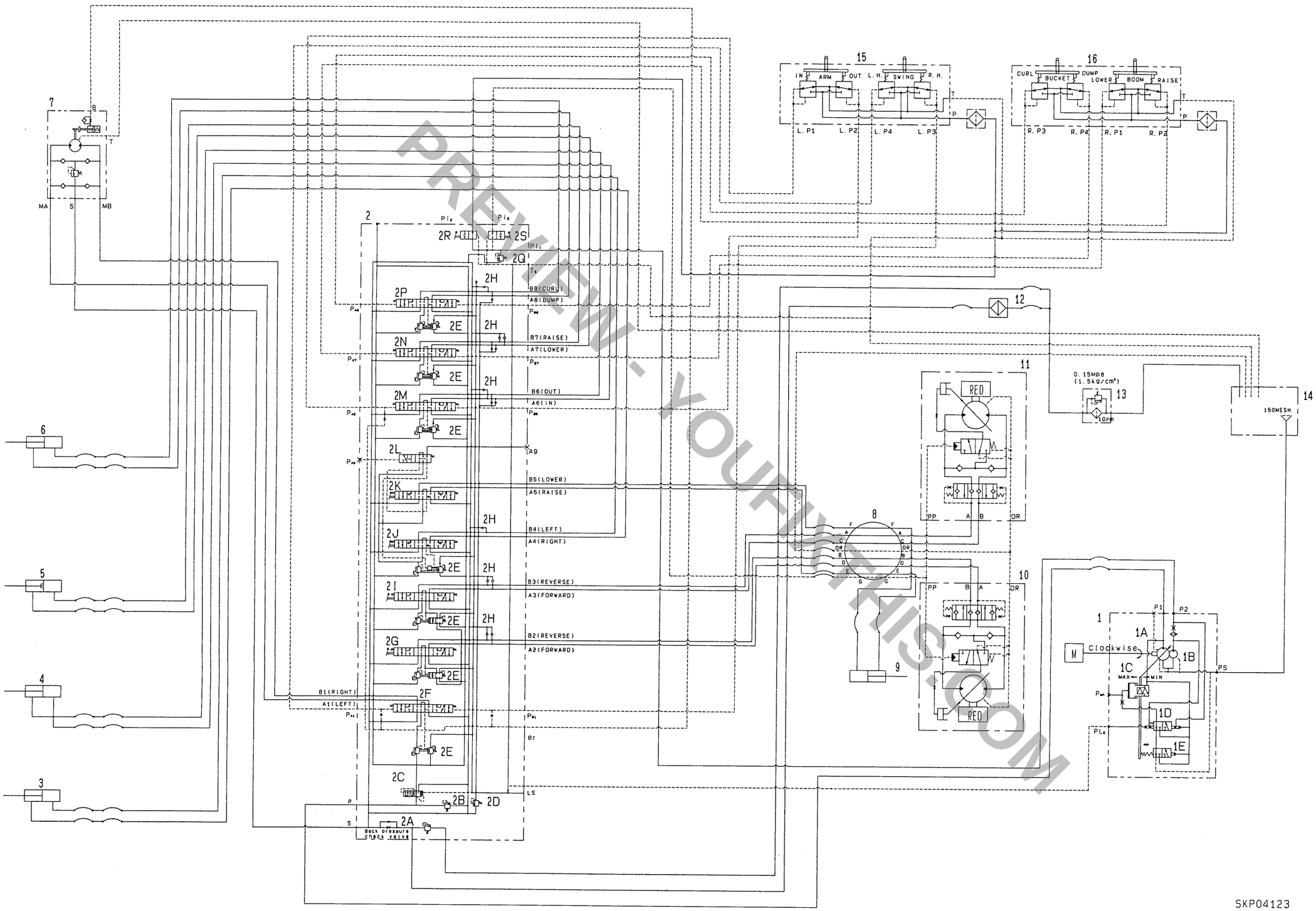
Machine model				PC20R-8	
				Canopy specification	Cab specification
Serial number				10001 and up	
		Bucket capacity	m^3	0.066	0.066
		Operating weight	kg	1,960 [2,060]	2,140 [2,240]
Performance	Working ranges	Max. digging depth	mm	2,350	2,350
		Max. vertical wall depth	mm	1,800	1,800
		Max. digging reach	mm	4,400	4,400
		Max. reach at ground level	mm	4,250	4,250
		Max. digging height	mm	4,250	4,030
		Max. dumping height	mm	3,000	2,765
		Bucket offset	mm	500 (L.H.)/720 (R.H.)	500 (L.H.)/720 (R.H.)
		Max. blade lifting amount	mm	250	250
		Max. blade lowering amount	mm	250	250
	Max. digging force		kN{kg}	18.8 {1,920}	18.8 {1,920}
	Swing speed		rpm	8.9	8.9
	Swing max. slope angle		deg.	24	24
	Travel speed (Hi/Lo)		km/h	4.8/2.4	4.8/2.4
	Gradeability		deg.	30	30
	Ground pressure (standard shoe width: 260 mm)		kPa{kg/cm^2}	23.5 {0.24}	26.5 {0.27}
Dimensions	Overall length (for transport)		mm	4,250	4,250
	Overall width		mm	1,420	1,420
	Overall height (for transport)		mm	2,380 [2,375]	2,475 [2,470]
	Ground clearance of counterweight		mm	540	540
	Min. ground clearance		mm	275	275
	Tail swing radius		mm	1,250	1,250
	Min. swing radius of work equipment (at boom swing)		mm	1,500 [1,150]	1,710 [1,325]
	Height of work equipment at min. swing radius		mm	3,260	3,260
	Length of track on ground		mm	1,385 [1,350]	1,385 [1,350]
	Track gauge		mm	1,120	1,120
	Blade width x height		mm	1,380 x 300	1,380 x 300

[ ] : Steel shoe specification

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HYDRAULIC CIRCUIT DIAGRAM

PC25R-8



SKP04123

1. Hydraulic pump assembly
   - 1A. Hydraulic pump
   - 1B. Control pump
   - 1C. Servo piston
   - 1D. LS valve
   - 1E. TCC valve
2. Control valve assembly
   - 2A. Cooler check valve
   - 2B. Main relief valve
   - 2C. Un-load valve
   - 2D. Safety valve
   - 2E. Pressure compensation valve
   - 2F. Swing spool
   - 2G. L.H. travel spool
   - 2H. Suction valve
   - 2I. R.H. travel spool
   - 2J. Swing spool
   - 2K. Blade spool
   - 2L. Breaker spool
   - 2M. Arm spool
   - 2N. Boom spool
   - 2P. Bucket spool
   - 2Q. Pilot relief valve
   - 2R. PPC pressure lock valve
   - 2S. Travel 2-speed selecter valve
3. Boom swing cylinder
4. Arm cylinder
5. Boom cylinder
6. Bucket cylinder
7. Swing motor
8. Swivel joint
9. Blade cylinder
10. Travel motor (L.H.)
11. Travel motor (R.H.)
12. Oil cooler
13. Oil filter
14. Hydraulic tank
15. PPC valve(L.H.)
16. PPC valve (R.H.)

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STANDARD TIGHTENING TORQUE

STANDARD TIGHTENING TORQUE TABLE (WHEN USING TORQUE WRENCH)

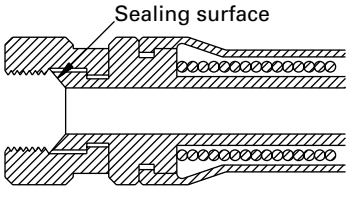
★ In the case of metric nuts and bolts for which there is no special instruction, tighten to the torque given in the table below.

Thread diameter of bolt	Width across flats	 CDL00372	
mm	mm	Nm	kgm
6	10	13.2 ± 1.4	1.35 ± 0.15
8	13	31 ± 3	3.2 ± 0.3
10	17	66 ± 7	6.7 ± 0.7
12	19	113 ± 10	11.5 ± 1
14	22	177 ± 19	18 ± 2
16	24	279 ± 30	28.5 ± 3
18	27	382 ± 39	39 ± 4
20	30	549 ± 59	56 ± 6
22	32	745 ± 83	76 ± 8.5
24	36	927 ± 103	94.5 ± 10.5
27	41	1320 ± 140	135 ± 15
30	46	1720 ± 190	175 ± 20
33	50	2210 ± 240	225 ± 25
36	55	2750 ± 290	280 ± 30
39	60	3290 ± 340	335 ± 35

Thread diameter of bolt	Width across flats	 CDL00373	
mm	mm	Nm	kgm
6	10	7.85 ± 1.95	0.8 ± 0.2
8	13	18.6 ± 4.9	1.9 ± 0.5
10	14	40.2 ± 5.9	4.1 ± 0.6
12	27	82.35 ± 7.85	8.4 ± 0.8

TABLE OF TIGHTENING TORQUES FOR FLARED NUTS

★ In the case of flared nuts for which there is no special instruction, tighten to the torque given in the table below.



SAD00483

Thread diameter	Width across flat	Tightening torque	
mm	mm	Nm	kgm
14	19	24.5 ± 4.9	2.5 ± 0.5
18	24	49 ± 19.6	5 ± 2
22	27	78.5 ± 19.6	8 ± 2
24	32	137.3 ± 29.4	14 ± 3
30	36	176.5 ± 29.4	18 ± 3
33	41	196.1 ± 49	20 ± 5
36	46	245.2 ± 49	25 ± 5
42	55	294.2 ± 49	30 ± 5

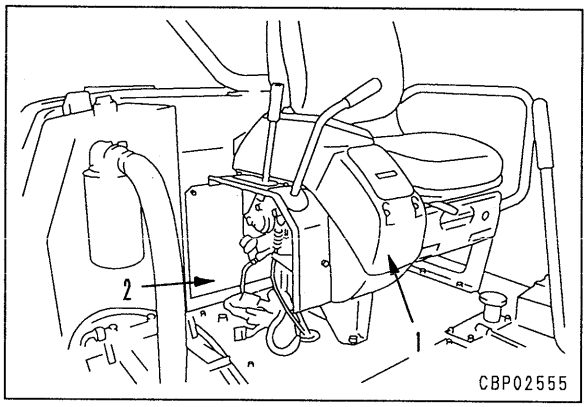
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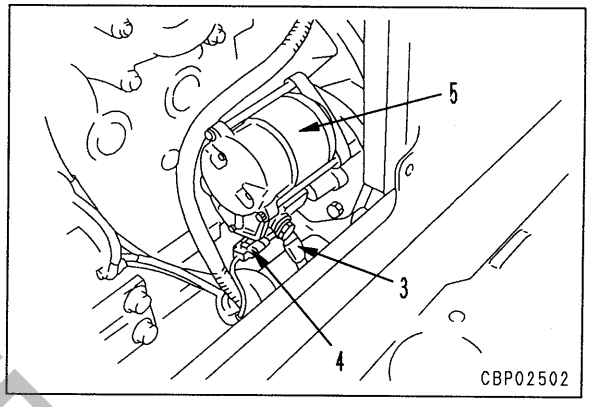
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REMOVAL OF STARTING MOTOR ASSEMBLY

⚠ Disconnect the cable from the negative (–) terminal of the battery.

1. Remove operator's cab assembly.
   For details, see REMOVAL OF OPERATOR'S CAB ASSEMBLY.
   ★ Operator's cab specification machine only.
2. Remove right side cover and partition at right side of operator's seat.
3. Move operator's seat (1) to front.
   ★ Do not disconnect the cable and harness connector.
4. Remove inspection cover (2) at rear of operator's seat.
5. Disconnect battery terminal E1 (3) and wiring connector **E2** (4).
6. Remove starting motor assembly (5).





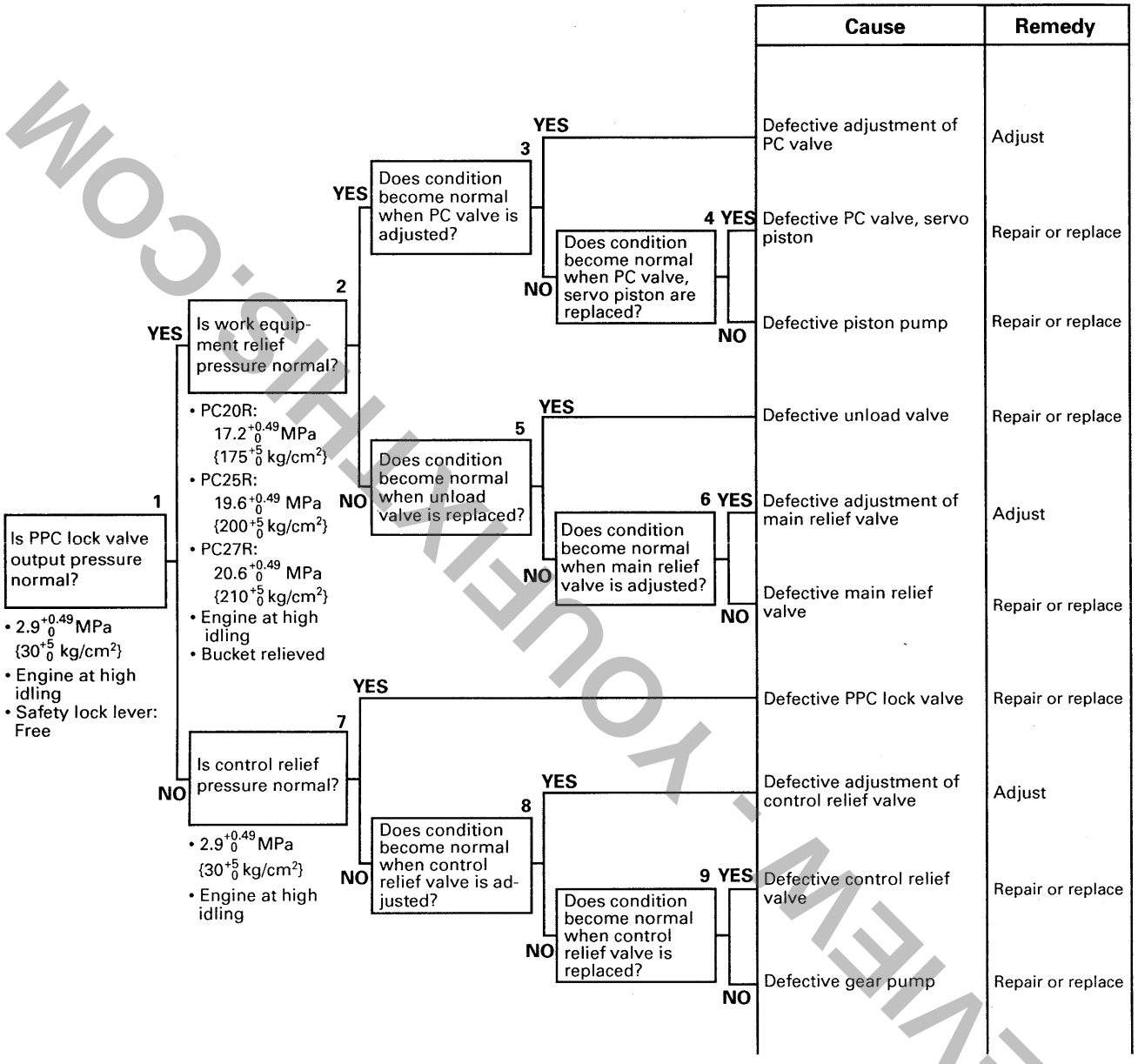
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INSTALLATION OF STARTING MOTOR ASSEMBLY

- Carry out installation in the reverse order to removal.

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H-1 Speeds of all work equipment, swing, travel are slow or lack power



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The affected pages are indicated by the use of the following marks. It is requested that necessary actions be taken to these pages according to the table below.

Mark	Indication	Action required
○	Page to be newly added	Add
●	Page to be replaced	Replace
( )	Page to be deleted	Discard

Pages having no marks are those previously revised or made aditions.

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SAFETY
SAFETY NOTICE

IMPORTANT SAFETY NOTICE

Proper service and repair is extremely important for safe machine operation. The service and repair techniques recommended by Komatsu and described in this manual are both effective and safe. Some of these techniques require the use of tools specially designed by Komatsu for the specific purpose.

To prevent injury to workers, the symbol ⚠ is used to mark safety precautions in this manual. The cautions accompanying these symbols should always be followed carefully. If any dangerous situation arises or may possibly arise, first consider safety, and take the necessary actions to deal with the situation.

GENERAL PRECAUTIONS

Mistakes in operation are extremely dangerous. Read the Operation and Maintenance Manual carefully BEFORE operating the machine.

1. Before carrying out any greasing or repairs, read all the precautions given on the decals which are fixed to the machine.
2. When carrying out any operation, always wear safety shoes and helmet. Do not wear loose work clothes, or clothes with buttons missing.
   - Always wear safety glasses when hitting parts with a hammer.
   - Always wear safety glasses when grinding parts with a grinder, etc.
3. If welding repairs are needed, always have a trained, experienced welder carry out the work. When carrying out welding work, always wear welding gloves, apron, hand shield, cap and other clothes suited for welding work.
4. When carrying out any operation with two or more workers, always agree on the operating procedure before starting. Always inform your fellow workers before starting any step of the operation. Before starting work, hang UNDER REPAIR signs on the controls in the operator's compartment.
5. Keep all tools in good condition and learn the correct way to use them.
6. Decide a place in the repair workshop to keep tools and removed parts. Always keep the tools and parts in their correct places. Always keep the work area clean and make sure that there is no dirt or oil on the floor. Smoke only in the areas provided for smoking. Never smoke while working.

PREPARATIONS FOR WORK

7. Before adding oil or making any repairs, park the machine on hard, level ground, and block the wheels or tracks to prevent the machine from moving.
8. Before starting work, lower blade, ripper, bucket or any other work equipment to the ground. If this is not possible, insert the safety pin or use blocks to prevent the work equipment from falling. In addition, be sure to lock all the control levers and hang warning signs on them.
9. When disassembling or assembling, support the machine with blocks, jacks or stands before starting work.
10. Remove all mud and oil from the steps or other places used to get on and off the machine. Always use the handrails, ladders or steps when getting on or off the machine. Never jump on or off the machine. If it is impossible to use the handrails, ladders or steps, use a stand to provide safe footing.

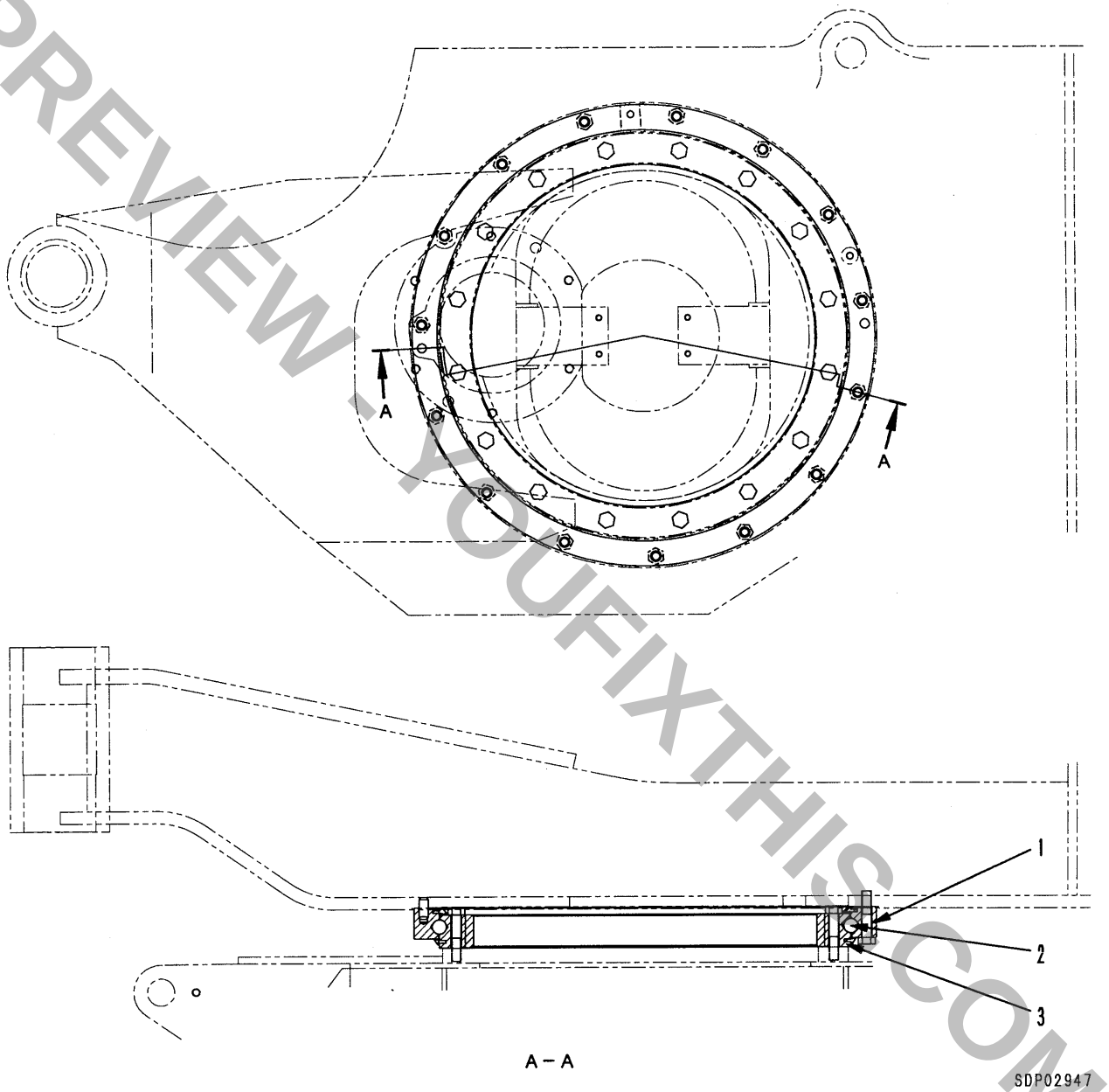
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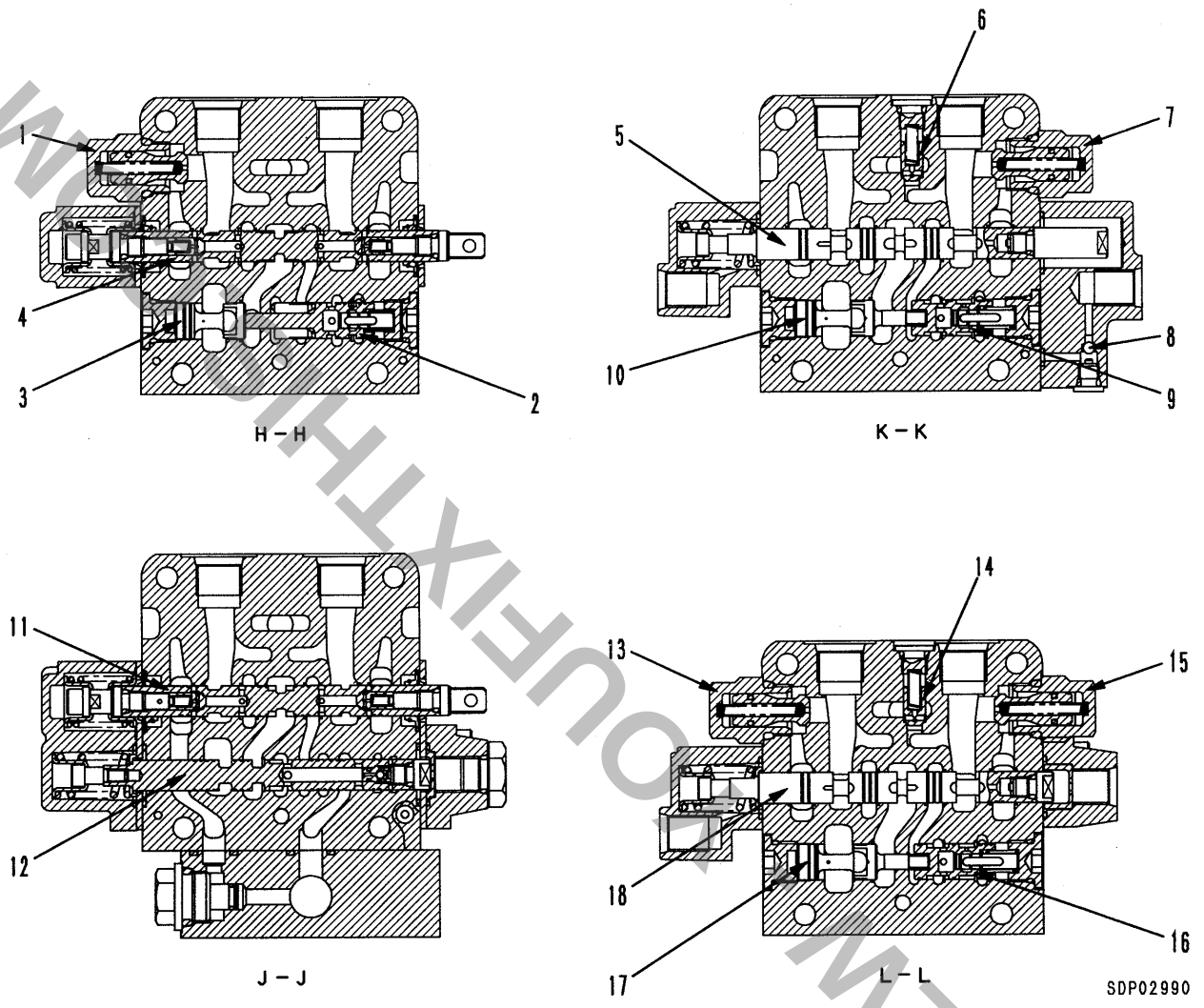
PC25R-8
PC27R-8



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1. Swing circle outer race
2. Ball bearing
3. Swing circle inner race

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1. Suction valve (boom swing)
2. Pressure compensation valve **R** (boom swing)
3. Pressure compensation valve **F** (boom swing)
4. Spool (boom swing)
5. Spool (arm)
6. Check valve
7. Suction valve (arm)
8. Pilot pressure valve
9. Pressure compensation valve **R** (arm)
10. Pressure compensation valve **F** (arm)
11. Spool (blade)
12. Spool (breaker)
13. Suction valve (boom)
14. Check valve
15. Suction valve (boom)
16. Pressure compensation valve **R** (boom)
17. Pressure compensation valve **F** (boom)
18. Spool (boom)

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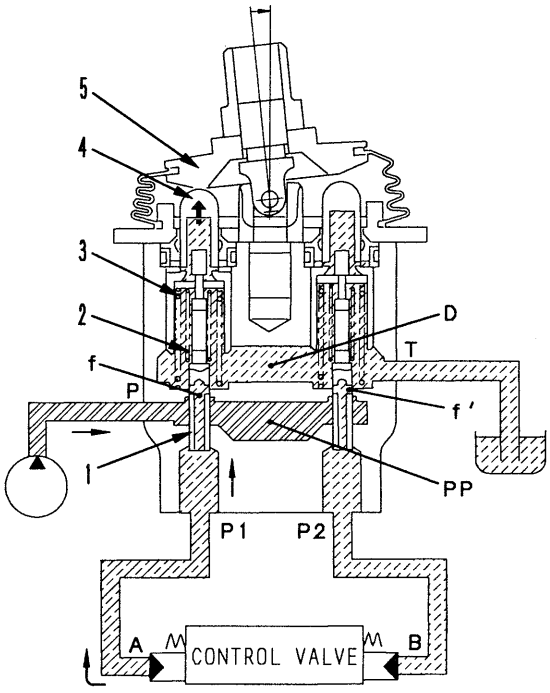
3) Duming fine control
(when control lever is returned)

When disc (5) starts to be returned, spool (1) is pushed up by the force of centering spring (3) and the pressure at port **P1**.

When this happens, fine control hole **f** is connected to drain chamber **D** and the pressure oil at port **P1** is released.

If the pressure at port **P1** drops too far, spool (1) is pushed down by metering spring (2), and fine control hole **f** is shut off from drain chamber **P1**. At almost the same time, it is connected to pump pressure chamber **PP**, and the pump pressure is supplied until the pressure at port **P1** recovers to a pressure that corresponds to the lever position.

When the spool of the control valve returns, oil in drain chamber **D** flows in from fine control hole **f'** in the valve on the side that is not working. The oil passes through port **P2** and enters chamber **B** to fill the chamber with oil. (Fig. 3)

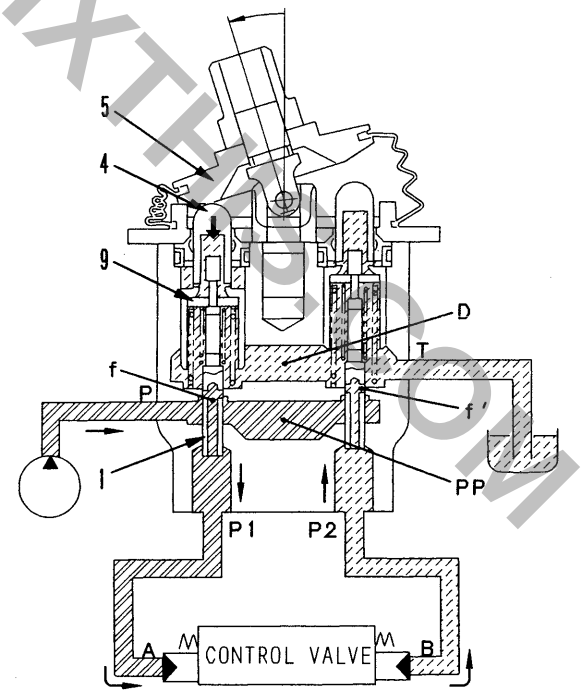


(Fig. 3) SBP01474

4) At full stroke

When disc (5) pushes down piston (4), and retainer (9) pushes down spool (1), fine control hole **f** is shut off from drain chamber **D**, and is connected with pump pressure chamber **PP**. Therefore, the pilot pressure from the control pump passes through fine control hole **f** and flows to chamber **A** from port **P1**, and pushes the control valve spool.

The oil returning from chamber **B** passes from port **P2** through fine control hole **f'** and flows to drain chamber **D**. (Fig. 4)



(Fig. 4) SBP01475

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Adjusting

★ The unload valve cannot be adjusted.

1. Adjusting main relief valve

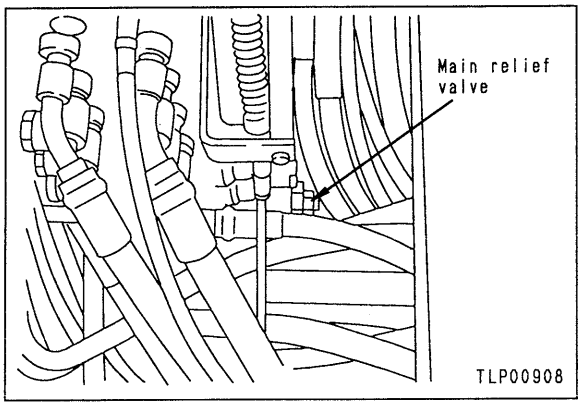
★ If the work equipment and travel relief pressure is not normal, adjust the main relief valve as follows.

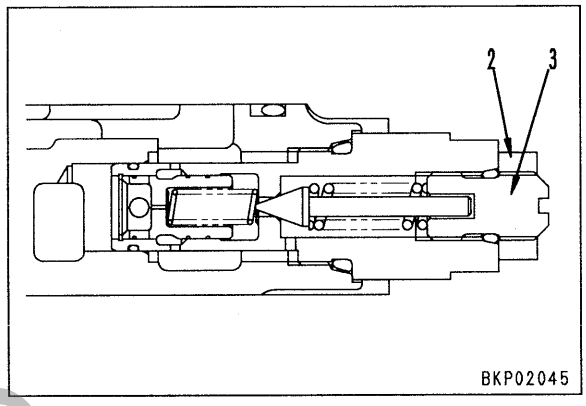
1) Loosen locknut (2) and turn adjustment screw (3) to adjust.
   ★ Turn the adjustment screw to adjust as follows.
   - To INCREASE pressure, turn CLOCKWISE
   - To DECREASE pressure, turn COUNTERCLOCKWISE

   ★ Amount of adjustment for one turn of adjustment screw: 12.6 MPa {128 kg/cm²}
2) After adjusting, tighten locknut (2).

   kgm Locknut: **59 ±10 Nm {6 ± 1 kgm}**

★ After completion of adjustment, use the measurement procedure above to check the oil pressure again.





2. Swing motor safety valve

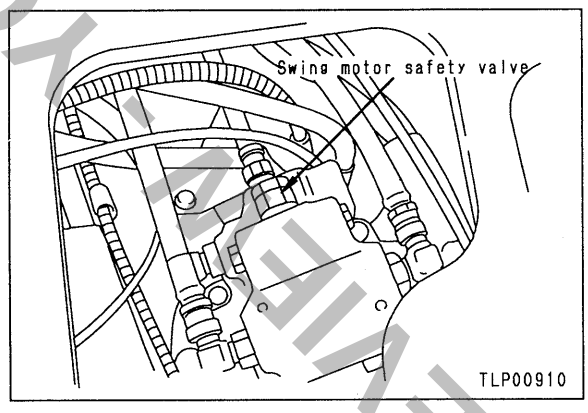
★ If the swing relief pressure is not normal, adjust the swing motor safety valve as follows.

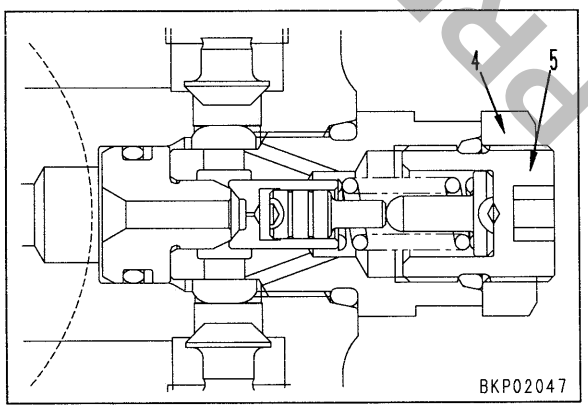
1) Loosen locknut (4) and turn adjustment screw (5) to adjust.
   ★ Turn the adjustment screw as follows.
   - To INCREASE pressure, turn CLOCKWISE
   - To DECREASE pressure, turn COUNTERCLOCKWISE

   ★ Amount of adjustment for one turn of adjustment screw: 17.54 MPa {179 kg/cm²}
2) After adjusting, tighten locknut (4).

   kgm Locknut:
   90.65 ± 12.25 Nm {9.25 ± 1.25 kgm}

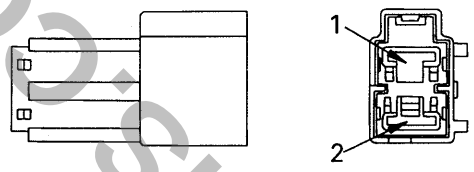
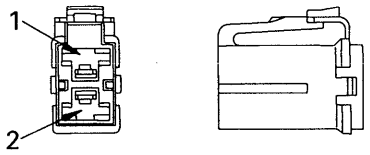
★ After completion of adjustment, use the measurement procedure above to check the oil pressure again.





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No. of pins	L type connector	
	Male (female housing)	Female (male housing)
2	 TEW00257	 TEW00258

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c) Fuel level does not match gauge display

	Cause	Remedy
1 YES — Is resistance between M9 (male) and M10 (female) as shown in the table? • Check sensor as individual part.	Defective monitor panel	Replace
	Defective fuel level sensor	Replace

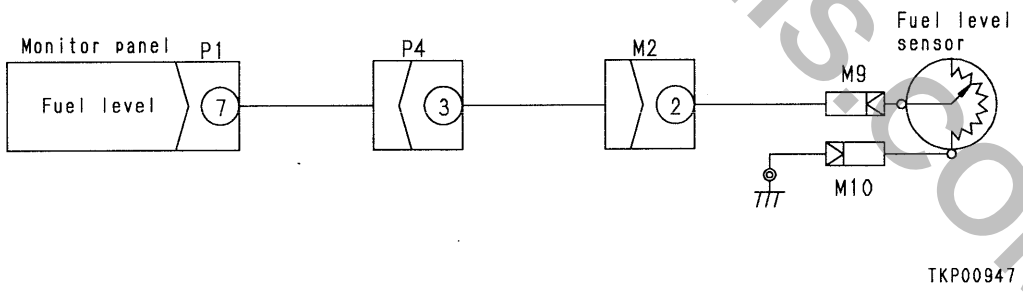
Table (Ω)

Float position	Resistance value
Upper end	$10^{+1.0}_{-0.5}$
Upper 1/4	(19)
1/2 (central)	32±3
Lower 1/4	49.5
Lower end	80^{+12}_{+2}

★ Figures in ( ) are reference values.

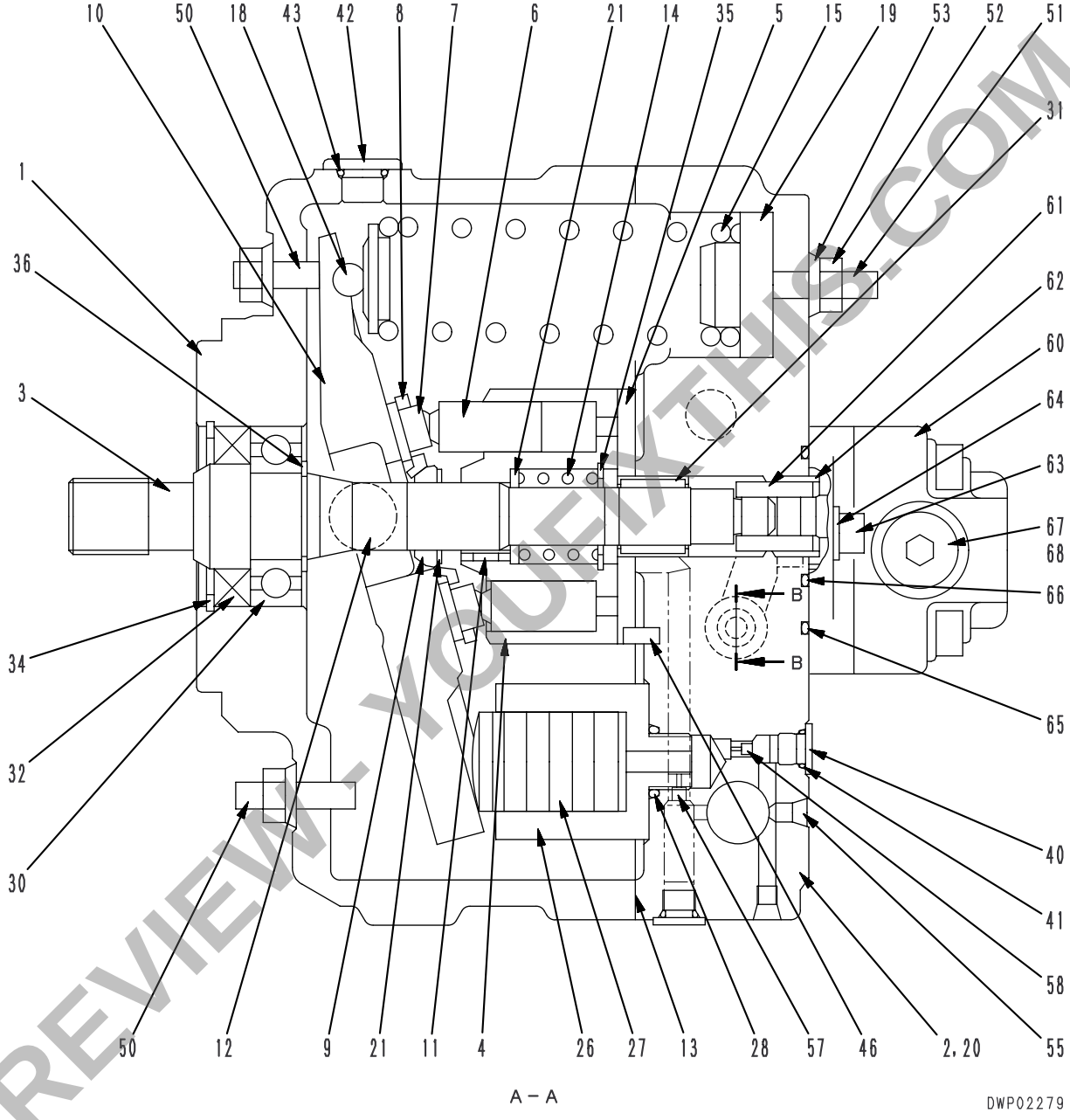
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M-11 Related electrical circuit diagram



TKP00947

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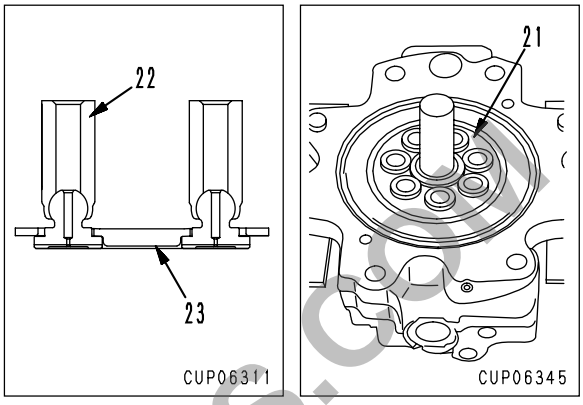


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9. Shoe retainer and piston assembly

1) Install piston (22) to shoe retainer (23).
2) Install shoe retainer and piston assembly (21) to the cylinder block.



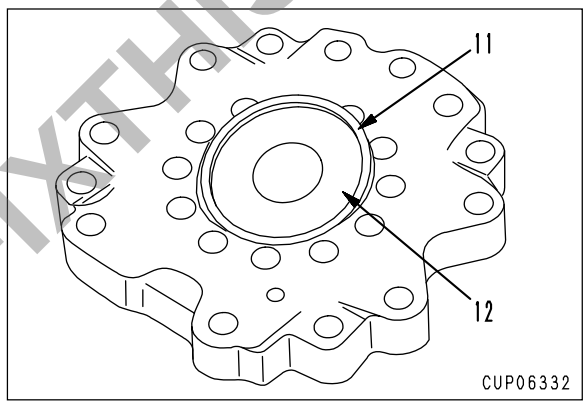
10. Spacer and thrust plate

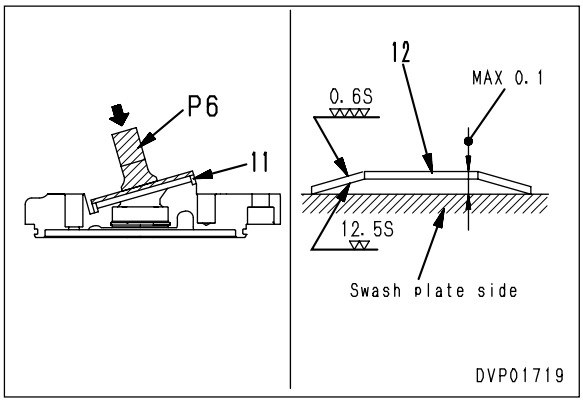
Install spacer (11) and thrust plate (12) to the swash plate.

★ The installation method of the spacer depends on its material.
Steel spacer: Press fit
Copper alloy spacer: Clearance fit
★ Press fit steel spacer with tool **P6** until it is fitted to the swash plate.
★ Press fitting load: Max. 980 N {100 kg}

Press fitting surface:
Engine oil (EO10-CD)

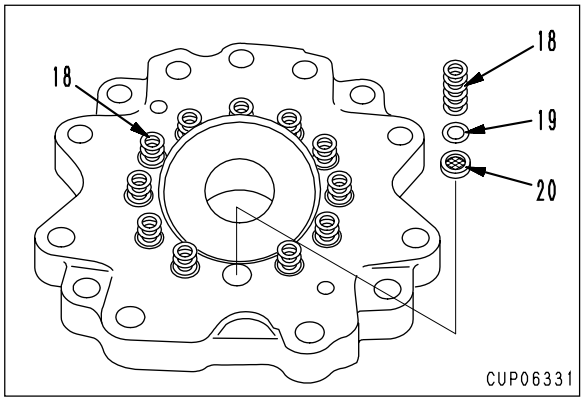
★ Judge the direction of the thrust plate by the difference of the surface machining accuracy and the sectional shape and install it as shown in the figure.





11. Filter and brake spring

1) Install filter (20) and washer (19) to the swash plate.
★ Turn over the swash plate and find out the through spring hole and install the filter to that hole.
2) Install 12 brake springs (18) to the swash plate.



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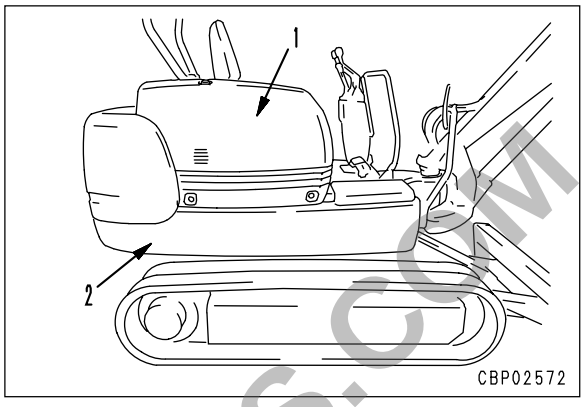
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REMOVAL OF CONTROL VALVE ASSEMBLY

⚠ Release the remaining pressure in the hydraulic circuit and hydraulic tank.
For details, see TESTING AND ADJUSTING, Releasing remaining pressure in hydraulic circuit and Releasing remaining pressure in hydraulic tank.

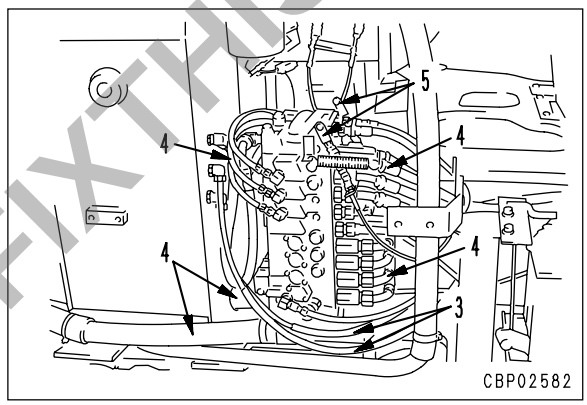
1. Remove right cover (1).

2. Remove right floor cover (2).



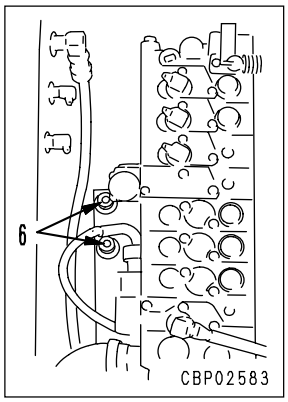
3. Disconnect 2 drain hoses (3) of right side of control valve at hydraulic tank end. ※1
   ★ After disconnecting the hoses, fit tags to distinguish them.

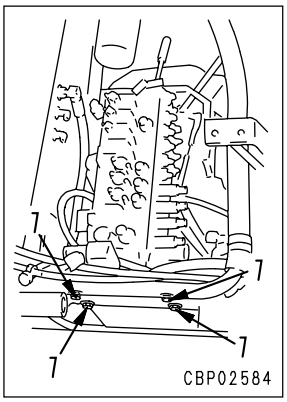
4. Disconnect all hoses (4) at control valve end. ※2
   ★ The hoses under the left side are difficult to disconnect, so disconnect them when removing the control valve.
   ★ After disconnecting the hoses, fit tags to distinguish them.



5. Disconnect control cable yokes (5) (2 places) and control linkage yokes (2 places) (under left side). ※3

6. Remove bracket mounting bolts (6) of left side of control valve and bracket mounting bolts (7) under control valve.

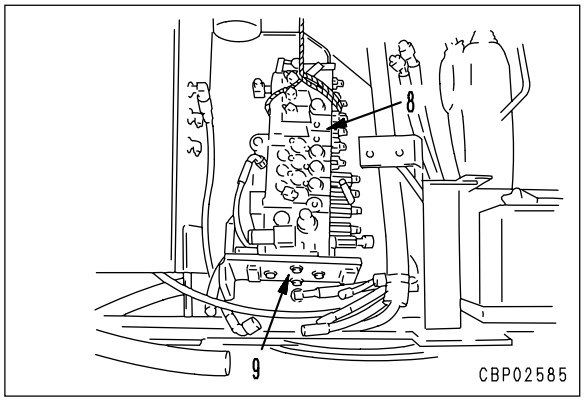




7. Raise control valve assembly (8) and disconnect bracket (9) under control valve.

8. Lift off control valve assembly (8).

   kg Control valve assembly : **40 kg**



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INSTALLATION OF BOOM SWING BRACKET ASSEMBLY

- Carry out installation in the reverse order to removal.

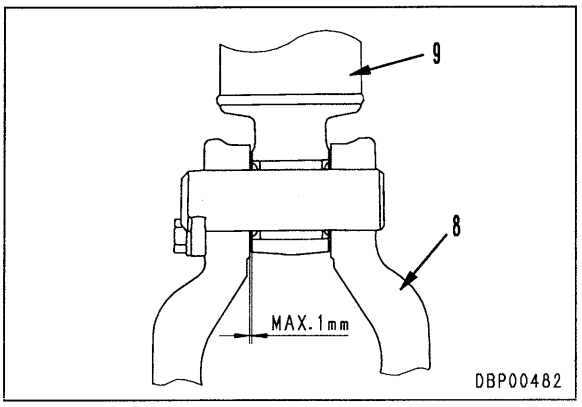
※ 1

⚠ When aligning the position of the pin hole, never insert your fingers in the pin hole.

Pin, sliding surface when assembling : **Molybdenum disulphide grease (LM-P)**

Greasing after assembling pin : **Molybdenum disulphide grease (LM-G)**

★ Adjust the shim thickness so that the clearance between the bottom of boom cylinder (9) and boom swing bracket (8) is below 1 mm.
- Shim thickness : 1 mm



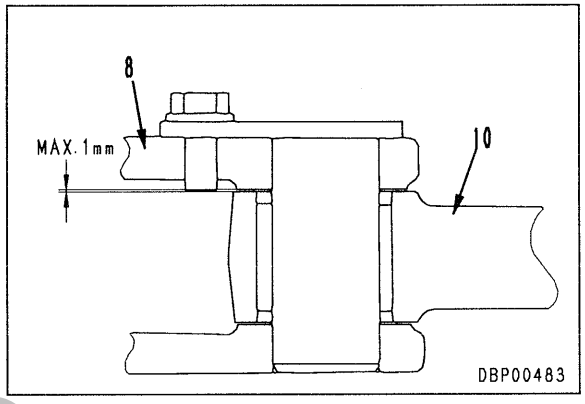
※ 2

⚠ When aligning the position of the pin hole, never insert your fingers in the pin hole.

Pin, sliding surface when assembling : **Molybdenum disulphide grease (LM-P)**

Greasing after assembling pin : **Molybdenum disulphide grease (LM-G)**

★ Adjust the shim thickness so that the clearance between the head of boom swing cylinder (10) and boom swing bracket (8) is below 1 mm.
- Shim thickness : 1 mm



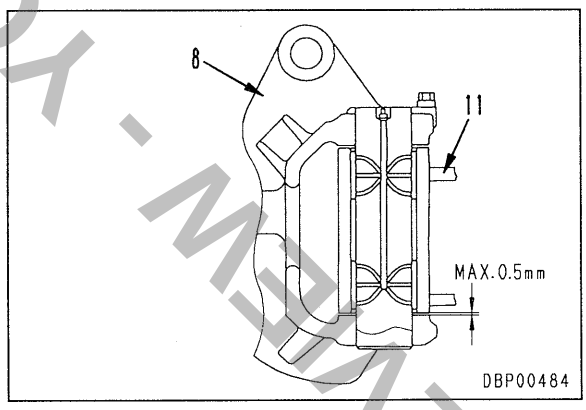
※ 3

⚠ When aligning the position of the pin hole, never insert your fingers in the pin hole.

Pin, sliding surface when assembling : **Molybdenum disulphide grease (LM-P)**

Greasing after assembling pin : **Molybdenum disulphide grease (LM-G)**

★ Adjust the shim thickness so that the clearance between the boom swing bracket (8) and revolving frame (11) is below 0.5 mm.
- Shim thickness : 0.5 mm



- **Bleeding air**
  Bleed the air from the boom cylinder.
  For details, see TESTING AND ADJUSTING, Bleeding air.

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