

Disassembly and Assembly

312D and 313D Excavators Machine Systems

Media Number -KENR6402-05

Publication Date -01/01/2012

Date Updated -17/01/2012

i01898035

Control Valve (Blade) - Assemble

SMCS - 5051-016-BG

Assembly Procedure

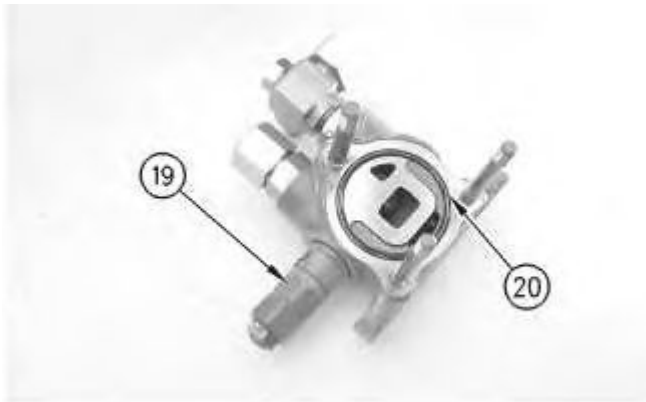


Illustration 1

g00987538

Note: Check the O-ring seal for wear or for damage. If necessary, replace the O-ring seal.

1. Install O-ring seal (20). Install relief valve (19). Tighten relief valve (19) to a torque of $74 \pm 5 \text{ N}\cdot\text{m}$ ($55 \pm 4 \text{ lb ft}$).



Illustration 2

g00987536

Note: Check the O-ring seal for wear or for damage. If necessary, replace the O-ring seal.

2. Install O-ring seal (18). Install relief valve (17). Tighten relief valve (17) to a torque of $74 \pm 5 \text{ N}\cdot\text{m}$ ($55 \pm 4 \text{ lb ft}$).



Illustration 3

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Note: Check the O-ring seal for wear or for damage. If necessary, replace the O-ring seal.

3. Install adapter (14). Install O-ring seal (15) and spring seat (16).



Illustration 4

g00987528

4. Install spring (13).

 **WARNING**

Improper assembly of parts that are spring loaded can cause bodily injury.

To prevent possible injury, follow the established assembly procedure and wear protective equipment.

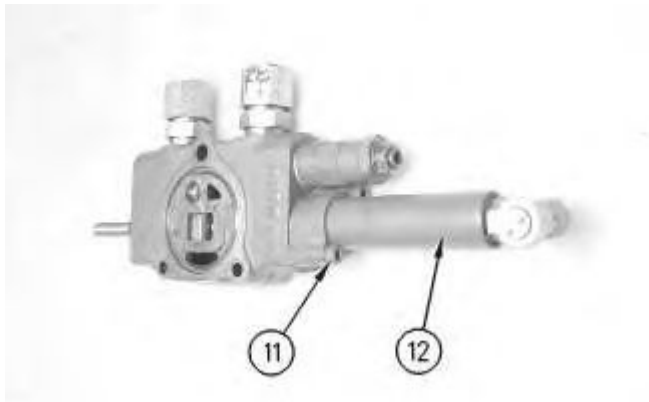


Illustration 5

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5. Position cap (12) and install bolts (11).

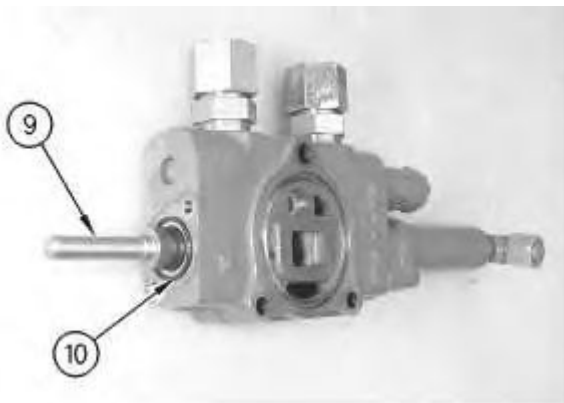


Illustration 6

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Note: Check the O-ring seal for wear or for damage. If necessary, replace the O-ring seal.

6. Install O-ring seal (10) and spring seat (9).

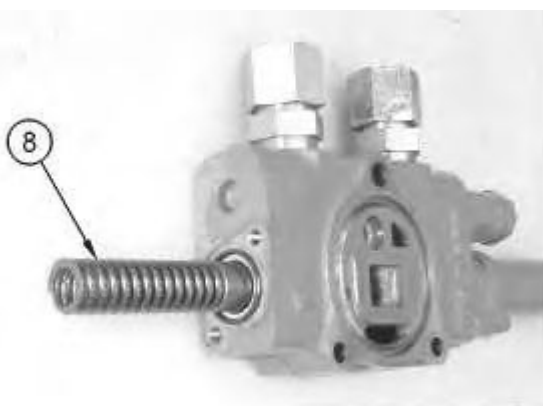


Illustration 7

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7. Install spring (8).

! WARNING

Improper assembly of parts that are spring loaded can cause bodily injury.

To prevent possible injury, follow the established assembly procedure and wear protective equipment.

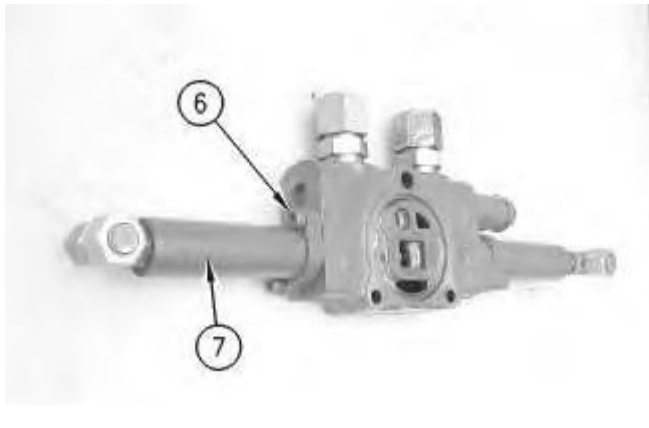


Illustration 8

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8. Position cap (7) and install bolts (6).

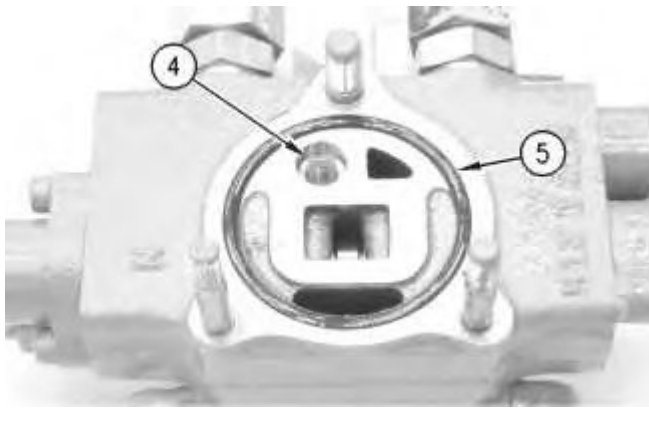


Illustration 9

g00987518

! WARNING

Improper assembly of parts that are spring loaded can cause bodily injury.

To prevent possible injury, follow the established assembly procedure and wear protective equipment.
