

Dipper

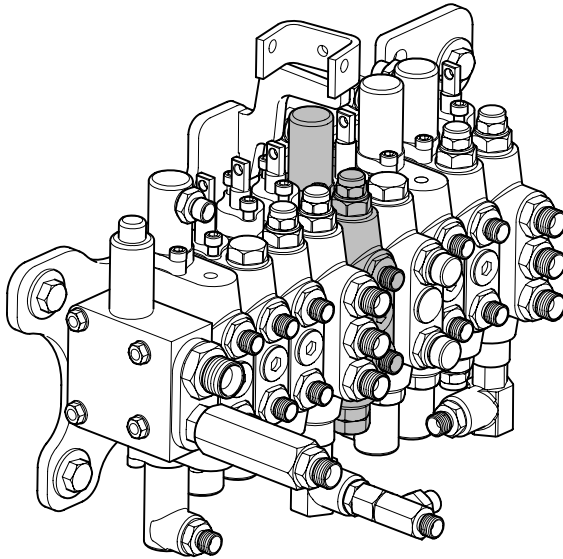


Fig 18.

Torque Settings and Key

1	Spring Adjuster	4.5 Nm	40 lbf in
2	Capscrew	2.5 Nm	22 lbf in
3	Cap	22 Nm	16 lbf ft
4	ARV/Anti-Cavitation Valve	50 Nm	37 lbf ft
5	Check Valve Plug	20 Nm	15 lbf in
6	ARV	50 Nm	37 lbf ft
7	Cap	22 Nm	16 lbf ft

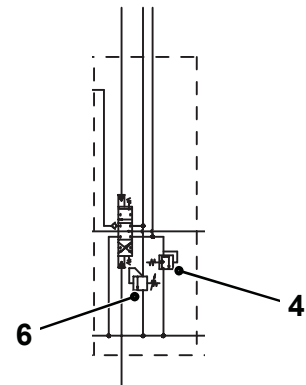
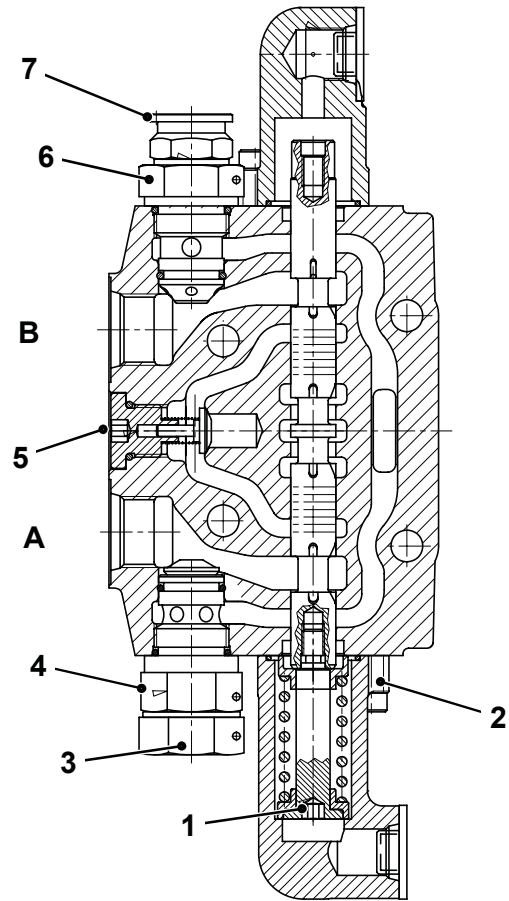


Fig 19.

Removal and Replacement

Removal

WARNING

Fluid Under Pressure

Fine jets of fluid at high pressure can penetrate the skin. Keep face and hands well clear of fluid under pressure and wear protective glasses. Hold a piece of cardboard close to suspected leaks and then inspect the cardboard for signs of fluid. If fluid penetrates your skin, get medical help immediately.

INT-3-1-10_2

- 1 Position the machine on firm level ground. Stop the engine and vent the hydraulics.
- 2 Raise the cab, see **Section B, Cab Tilting**.
- 3 Remove the controls assembly, see **Section D, Control Bar**.
- 4 Undo and plug the feed and return hoses to the hydraulic tank.
- 5 Disconnect the hydraulic hoses from the valve block, plug both the hoses and the valve block to prevent the ingress of dirt. Identify the hoses as they are removed, ready for replacement.
- 6 Remove the linkages to the valve spools.
- 7 Remove the three screws and washers **A** securing the valve block to the frame. Remove the valve block from the machine to a clean working area.

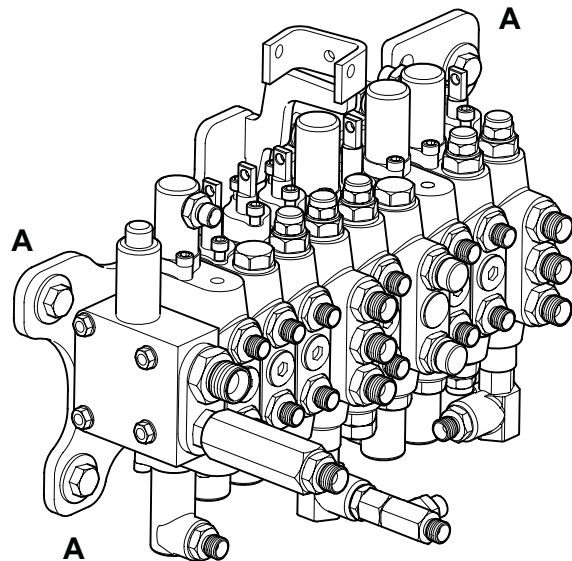


Fig 20.

Replacement

Replacement is a reversal of the removal procedure. On completion, check the linkage for freedom of operation, top up the hydraulic system and test the circuits for circuit operation, leakage etc.