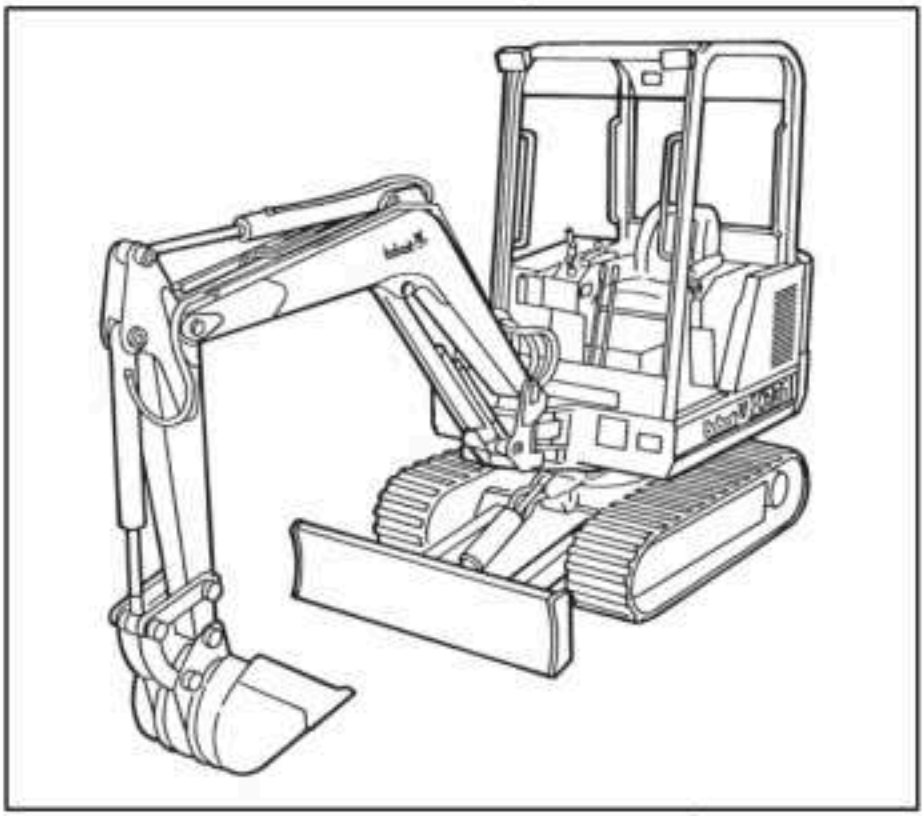
X 331

Excavator

Service Manual

(S/N 512911001 – 512912999)



MELROE
INGERSOLL-RAND

6724222 (2–96)

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ACCUMULATOR (S/N 12999 & Below)

Adjustment

The pressure build–up valve is set at 200 PSI (1379 kPa).

The pressure build–up valves function is to create 200 PSI (1379 kPa) back pressure in order to charge the accumulator.

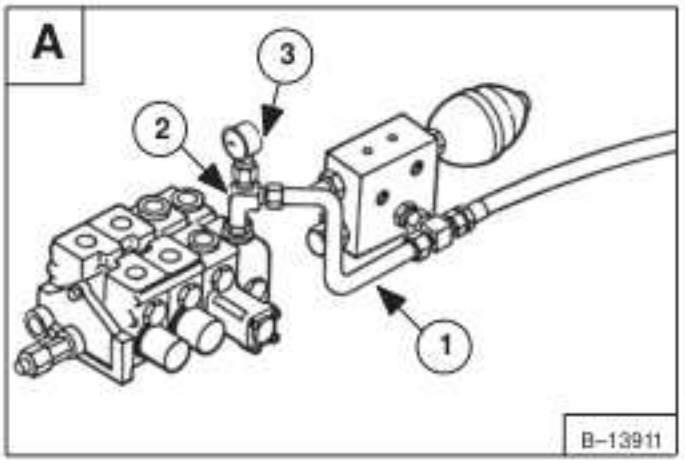
To test the pressure build–up valves pressure setting, disconnect the inlet tube (Item 1) **[A]** from the elbow on the 3–spool control valve. Remove the elbow from the valve. Install a tee (Item 2) **[A]** (21K–7) into the valve and reinstall the inlet tube (Item 1) **[A]** onto the tee.

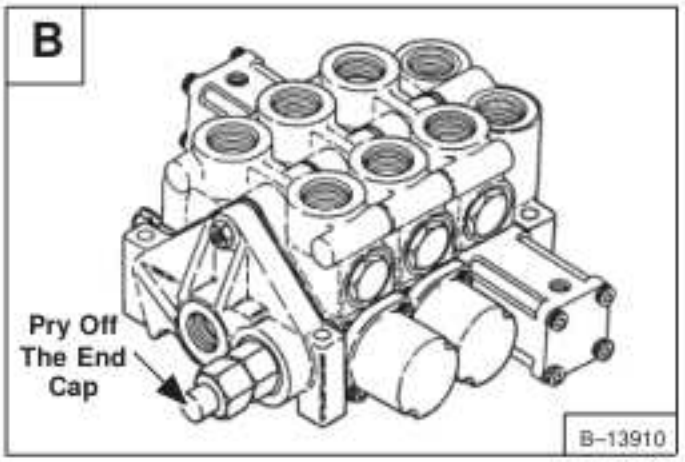
Install a *pressure gauge (Item 3) **[A]** onto the tee.

Start the excavator.

Warm the hydraulic fluid to 140°F. (60°C.).

Run the engine at high idle and record the pressure gauge reading. If the build–up valve needs to be reset, pry off the end cap from the build–up valve **[B]**.





Loosen the adjusting screw jam nut **[C]**.

Turn the adjusting screw clockwise to increase the pressure or counterclockwise to decrease the pressure **[C]**.

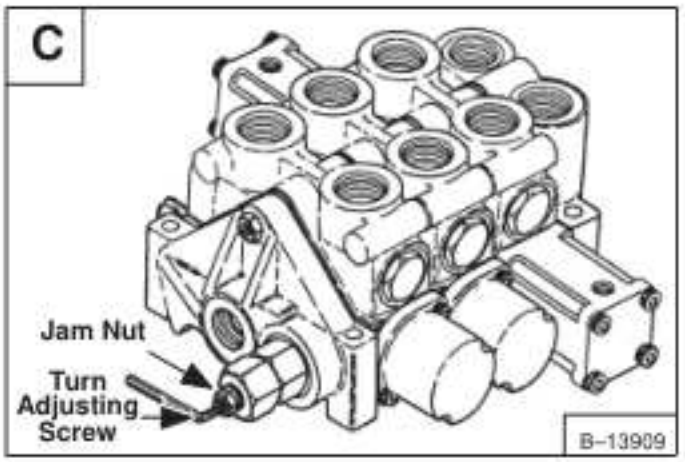
When the pressure gauge reading is correct, tighten the jam nut while holding the adjusting screw from turning.

Stop the engine.

Remove the pressure gauge and the tee.

Reinstall the elbow, previously removed, and install the tube on the elbow.

*5000 PSI (34475 kPa) Minimum.



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BUCKET

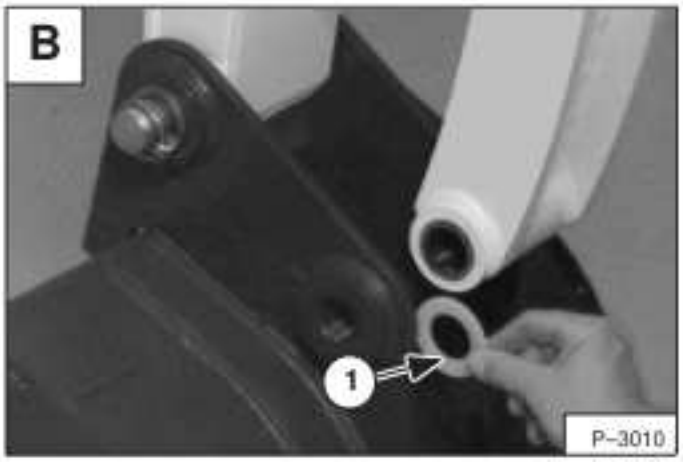
Removal and Installation

Remove the retainer clips from the bucket pins **[A]**.



Remove the bucket pins and plastic spacers (Item 1) **[B]**.

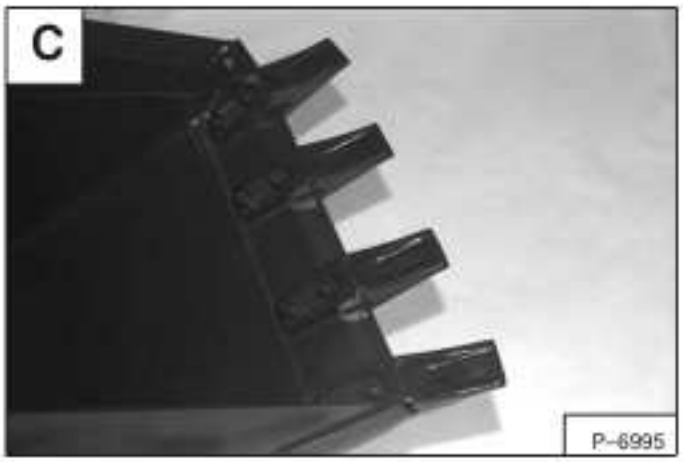
NOTE: Install the spacers in the same location during assembly.



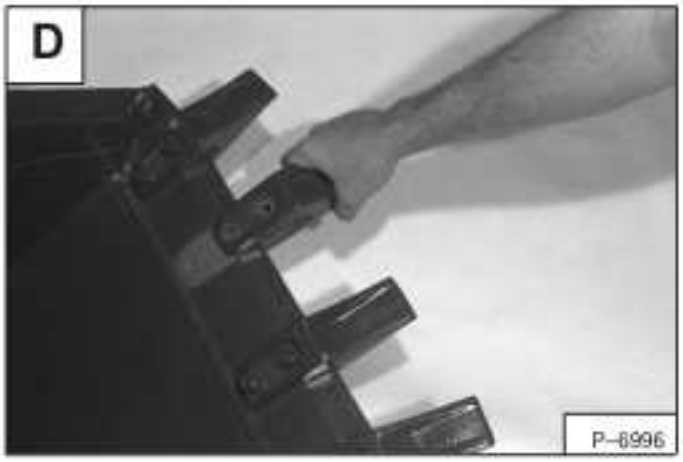
BUCKET TEETH

Removal and Installation

Remove the nuts and bolts from the bucket teeth **[C]**.



Remove the bucket teeth **[D]**.



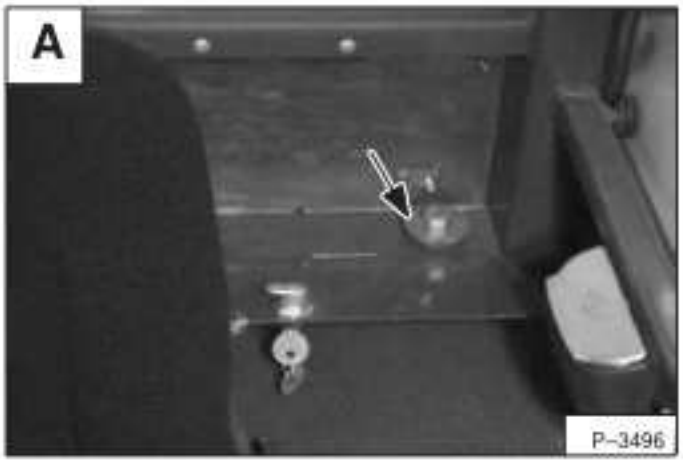
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Removal and Installation (Cont'd)

Remove the bolt and washer from the right rear cab mount **[A]**.

Installation: Tighten the bolt to 48–55 ft.–lbs. (65–75 Nm) torque.



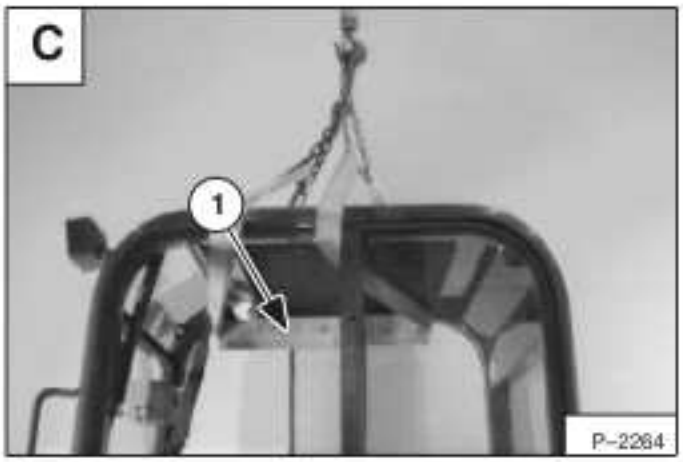
Disconnect the cab harness from the main harness **[B]**. The harness connectors are under the right hand upperstructure, near the boom swing cylinder.



TWO PIECE RIGHT SIDE WINDOW.

Open the right hand windows so that one lifting strap can be installed to the front of the window opening and a second lifting strap can be installed to the rear of the window opening **[C]**.

Install a 2 inch x 8 inch board (Item 1) **[C]** of sufficient length to spread the lifting straps so that they do not contact the right window.



Install a lifting device of sufficient capacity to the sling and lift the cab up a few inches **[D]**.

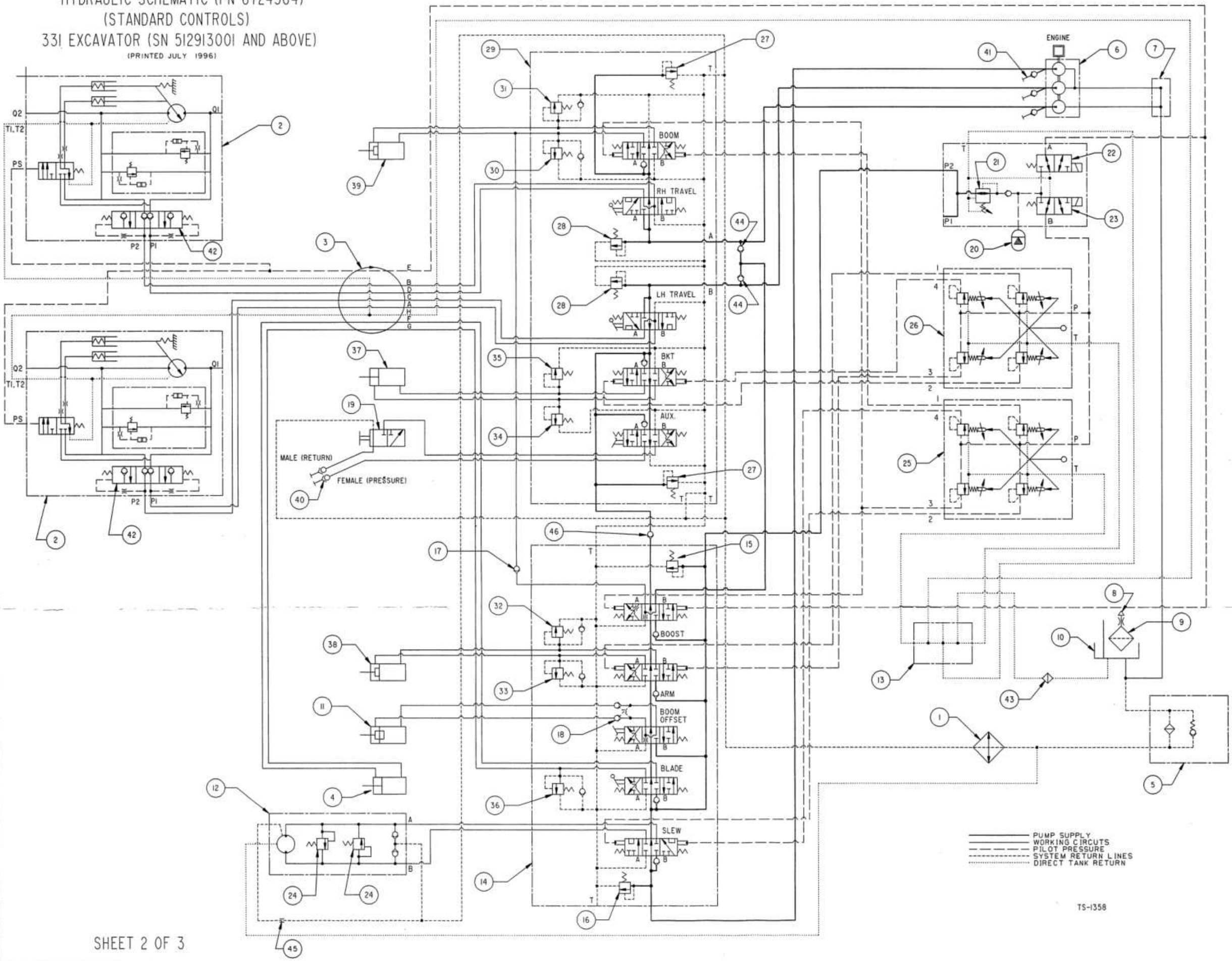


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HYDRAULIC SCHEMATIC (PN 6724564)
(STANDARD CONTROLS)
331 EXCAVATOR (SN 512913001 AND ABOVE)

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SHEET 2 OF 3

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