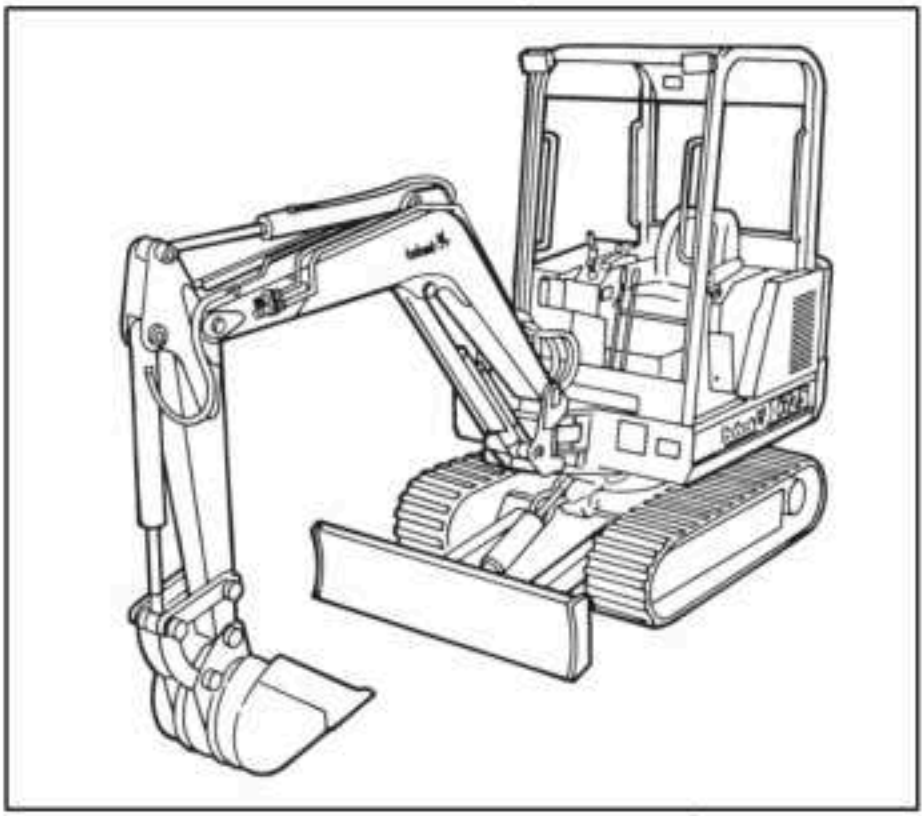
X 325

Excavator

Service Manual

(S/N 514011001 – 514012999)



MELROE
INGERSOLL-RAND

6724480 (11–95)

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Checking the Main Relief Valves (S/N 13001 & Above) (Cont'd)

Testing the Auxiliary and Bucket Circuit Relief Valve

Move the test gauge and coupler to pump section 2 **[A]**.

NOTE: Pump section 2 is the middle pump section.



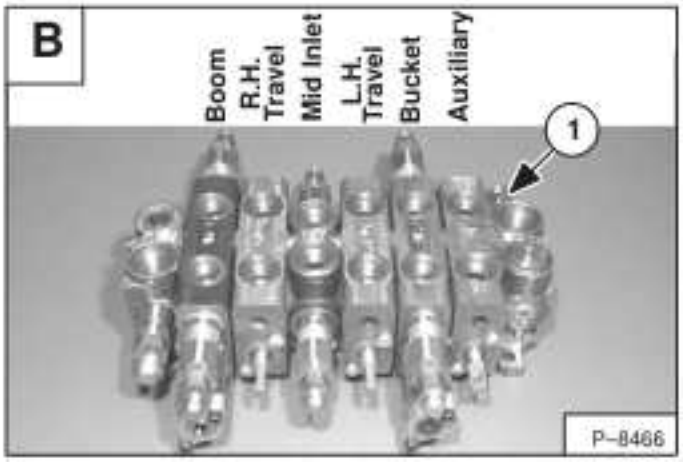
The main relief valve (Item 1) **[B]** & **[C]** protects the auxiliary and bucket circuits.

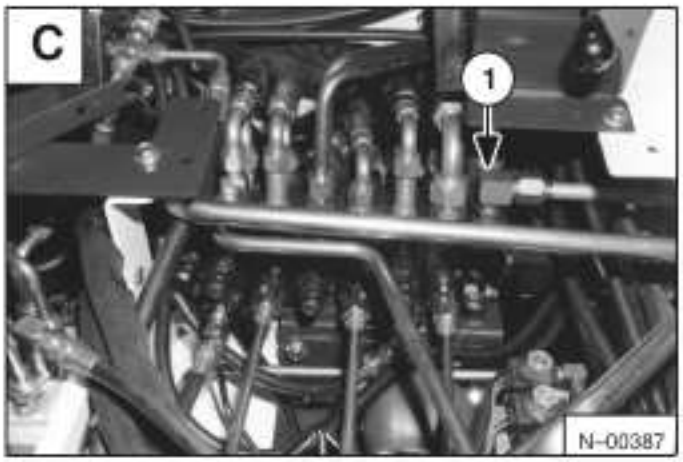
Start the engine and run at high idle.

Engage the blade lever until the blade is completely raised. Continue to engage the blade lever.

Engage the bucket circuit until the bucket is completely extended.

Continue engaging both the blade and bucket circuits at the same time will cause the main relief valve (Item 1) **[B]** & **[C]** to go over relief. The pressure reading at pump section 2 should be 2350 PSI (16235 KPA). If adjustment is needed, see Page 2–77 for adjustment procedure.





NOTE: Turn the upperstructure as shown in [D] to gain access to the main relief valve (Item 1) [B] & [C], from under the excavator.



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RADIATOR

Removal and Installation

Open the engine cover.

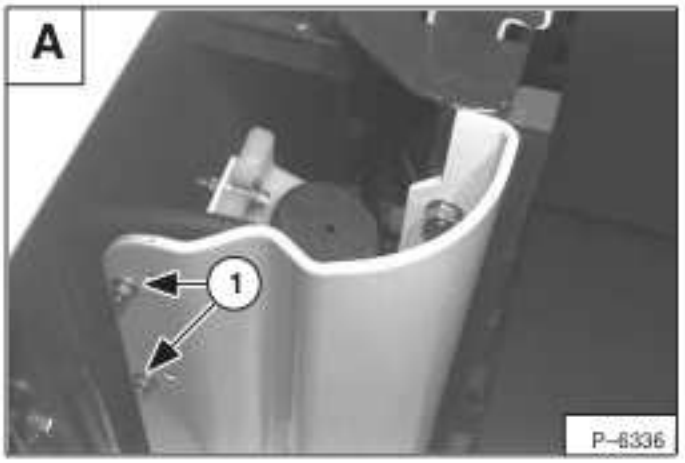
Remove the right rear side cover. (See Page 1–1.)

Remove the battery. (See Page 6–1.)

Remove the timer module. (See Page 7–6.)

Remove the fan guard. (See Page 7–14.)

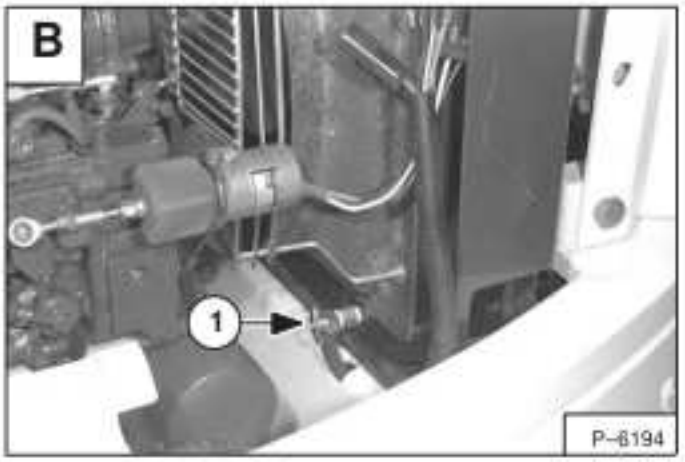
Remove the radiator overflow bottle by removing the two (2) bolts and nuts (Item 1) **[A]** holding the bottle to the right hand corner post.



Remove the right hand corner post. (See Page 4–1.)

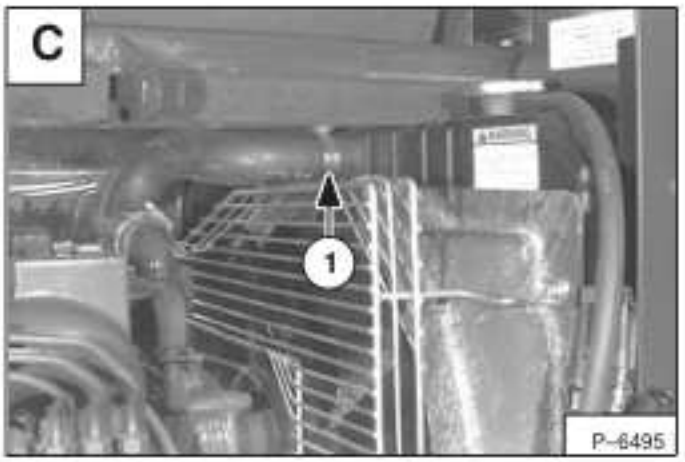
Remove the oil cooler. (See Page 2–1.)

Drain the cooling system by opening the radiator drain valve (Item 1) **[B]**.



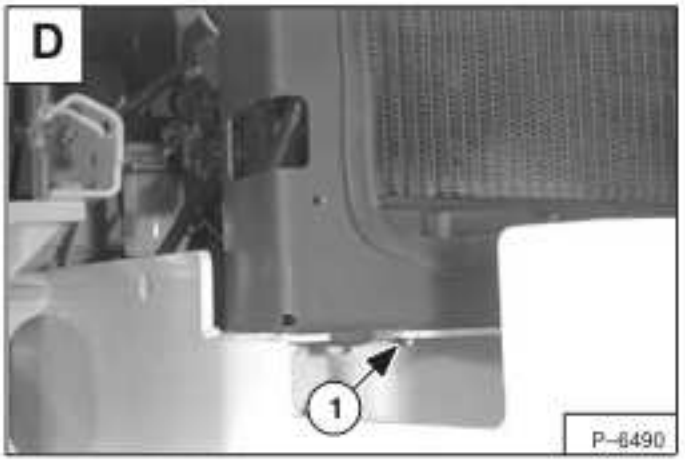
Loosen the top radiator hose clamps (Item 1) **[C]** and remove the top radiator hose.

Loosen the bottom radiator hose clamps and remove the lower radiator hose.



Remove the three (3) radiator mount bolts (Item 1) **[D]**.

Remove the one (1) radiator mount bolt from the front engine cover.



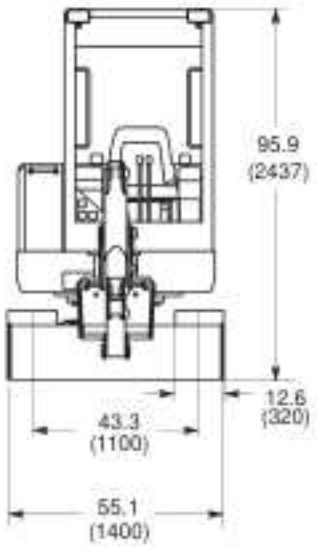
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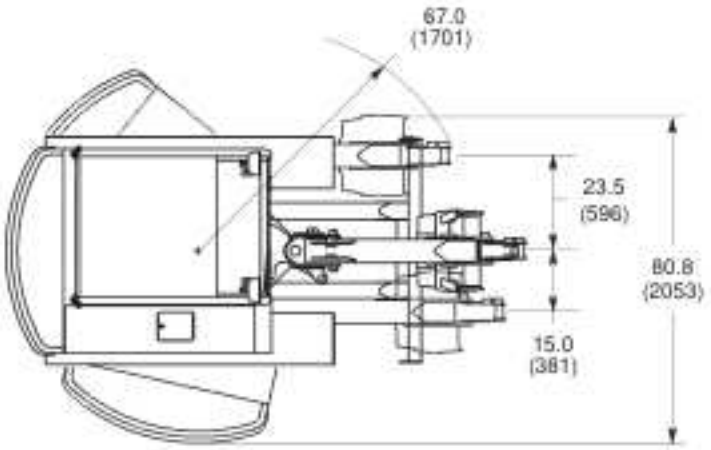
HYDRAULIC EXCAVATOR SPECIFICATIONS

- All dimensions are shown in inches. Respective metric dimensions are given in millimeters enclosed by parentheses.
- Where applicable, specifications conform to SAE or ISO standards. Specifications are subject to change without notice.

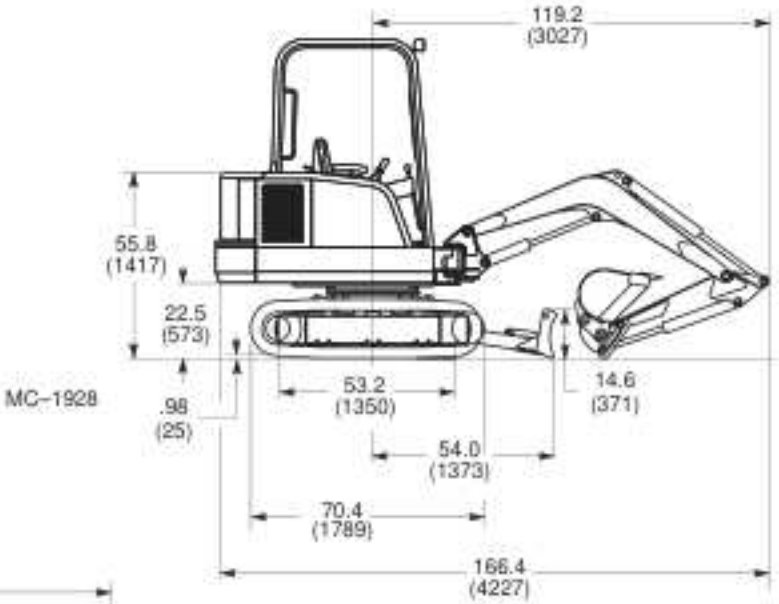
Machine Dimensions



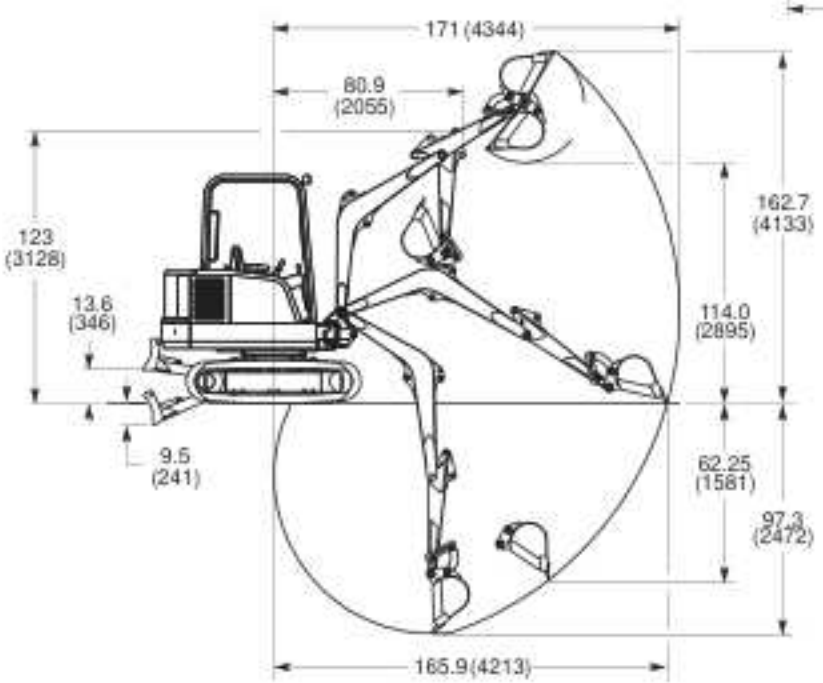
MC–1927



MC–1929



MC–1928



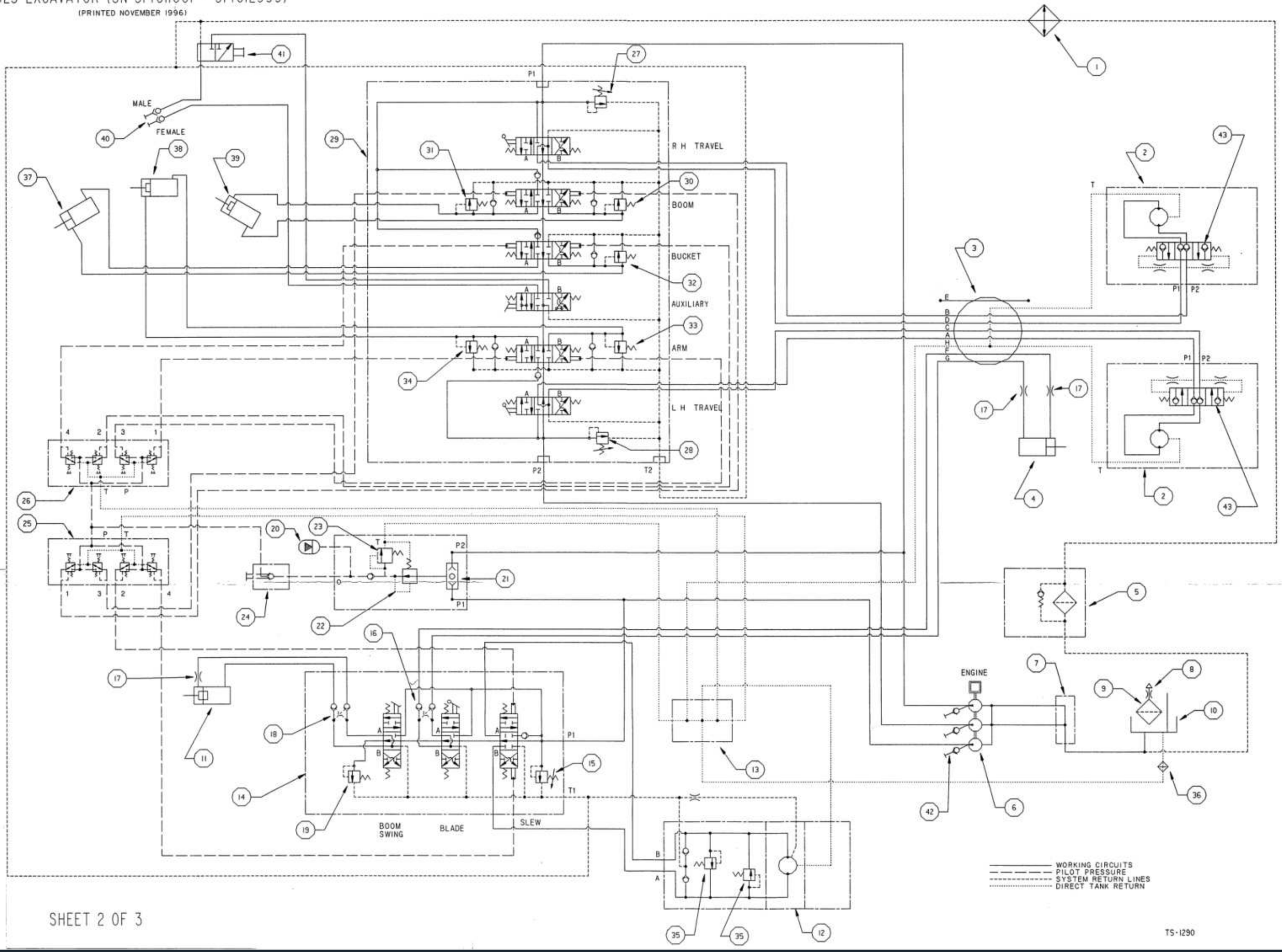
MC–1918

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HYDRAULIC SCHEMATIC (PN 6724485)
(STD CONTROLS)
325 EXCAVATOR (SN 514011001 - 514012999)

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SHEET 2 OF 3

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