CRAWLER EXCAVATOR

SERVICE MANUAL

R320LC-7

HYUNDAI

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10) BUCKET

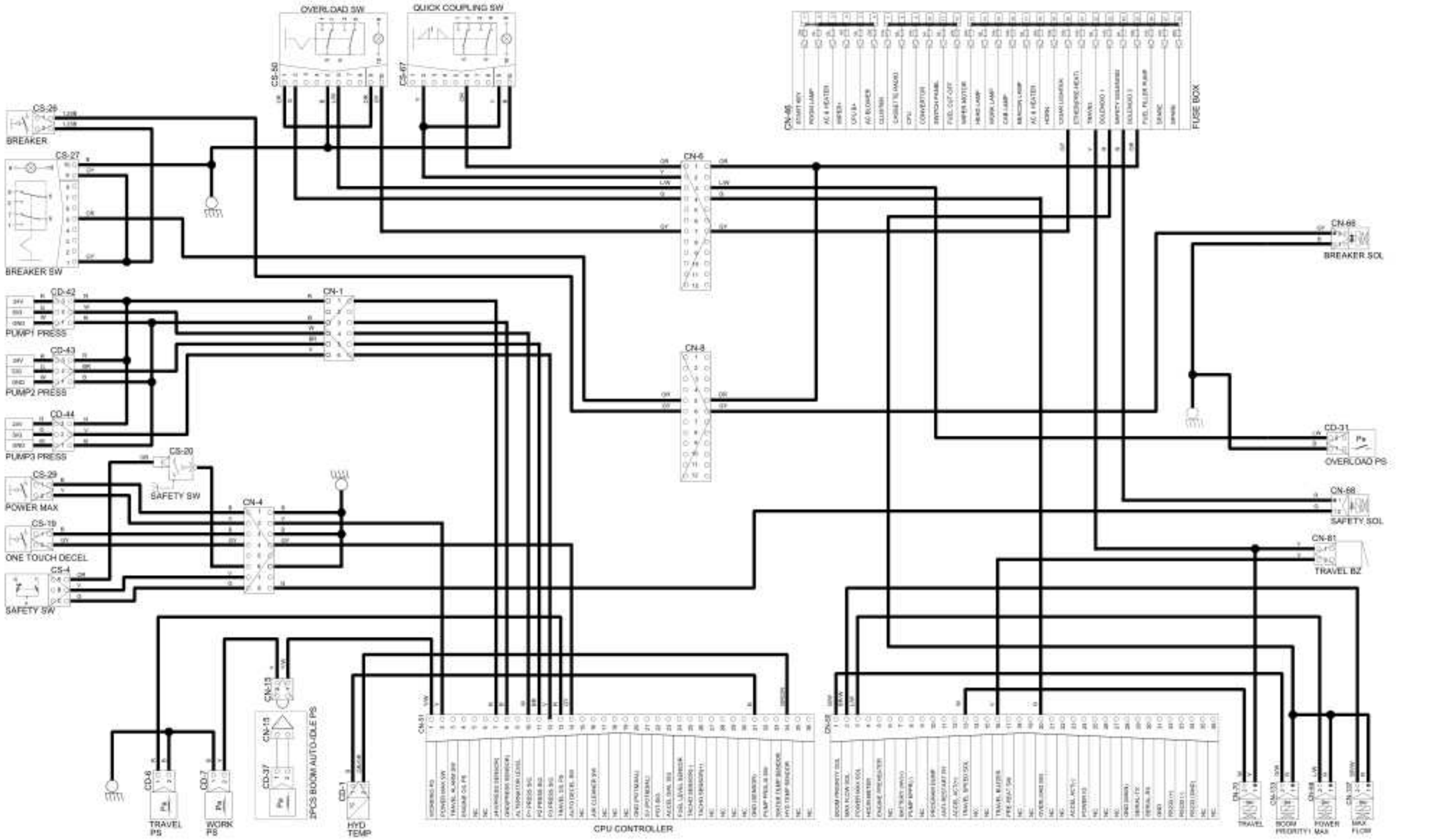
Item		Capacity		Tooth quantity	Width	
		PCSA heaped	CECE heaped		Without side cutter	With side cutter
R320LC-7	Standard	1.44m³(1.88yd³)	1.25m³(1.63yd³)	5	1380mm(54.3")	1500mm(59.1")
	Option	0.9m³(1.18yd³)	0.8m³(1.05yd³)	3	950mm(37.4")	1070mm(42.2")
		1.14m³(1.49yd³)	1.0m³(1.31yd³)	4	1140mm(44.9")	1260mm(49.6")
		1.74m³(2.28yd³)	1.5m³(1.96yd³)	5	1610mm(63.4")	1730mm(68.1")
		2.10m³(2.75yd³)	1.8m³(2.35yd³)	5	1900mm(74.8")	2020mm(79.5")
		* 1.44m³(1.88yd³)	1.25m³(1.63yd³)	5	1380mm(54.3")	-
		1.44m³(1.88yd³)	1.25m³(1.63yd³)	5	1380mm(54.3")	-

* : Heavy duty bucket

: Rock bucket(Esco type)

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ELECTRIC CIRCUIT FOR HYDRAULIC

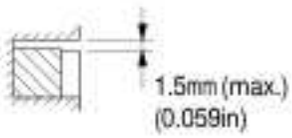
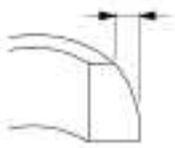


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8. TURNING JOINT

Part name		Maintenance standards	Remedy
Body, Stem	Sliding surface with sealing sections.	Plating worn or peeled due to seizure or contamination.	Replace
	Sliding surface between body and stem other than sealing section.	· Worn abnormality or damaged more than 0.1mm (0.0039in) in depth due to seizure contamination.	Replace
		· Damaged more than 0.1mm(0.0039in) in depth.	Smooth with oilstone.
	Sliding surface with thrust plate.	· Worn more than 0.5mm(0.02in) or abnormality.	Replace
		· Worn less than 0.5mm(0.02in).	Smooth
		· Damage due to seizure or contamination remediable within wear limit (0.5mm)(0.02in).	Smooth
Cover	Sliding surface with thrust plate.	· Worn more than 0.5mm(0.02in) or abnormality.	Replace
		· Worn less than 0.5mm(0.02in).	Smooth
		· Damage due to seizure or contamination remediable within wear limit (0.5mm)(0.02in).	Replace
Seal set	-	· Extruded excessively from seal groove square ring. 	Replace
	-	· Slipper ring 1.5mm(0.059in) narrower than seal groove, or narrower than back ring. 	Replace
	-	· Worn more than 0.5mm(0.02in) ~ 1.5mm(MAX.) (0.059in) 	Replace

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(28)Assemble piston ring(30), piston ring 252(30) and 278(31) into brake piston(29).



(29)Assemble brake piston into shaft casing.

※ Be careful of the direction of assembling brake piston.



(30)Assemble brake spring(32).

※ Quantity : Spring-10pieces, Holes-11pieces

※ Do not assemble on the top of brake piston.



(31)Insert O-ring(69), after fastening orifice screw(4) with standard torque.

- Quantity and size : (4)2 pieces-ø 1.0
  (56)1pieces-ø 1.5
- Tightening torque : 7kgf · m (50.63lbf · ft)



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(8) Negative control relief valve

① Remove plug(551).

- Hexagon wrench : 12mm



21078MC15

② Remove poppet(611), spring(621) and damping rod(631).



21078MC16

(9) Swing logic valve and check valve

① Loosen hexagon socket head bolts(251) and remove logic valve(251) and take check valve(254).

② Remove plug(551) or (552) and take out poppet(511) or (515, 516) and spring (521) or (523).

- Hexagon wrench : 6, 12mm



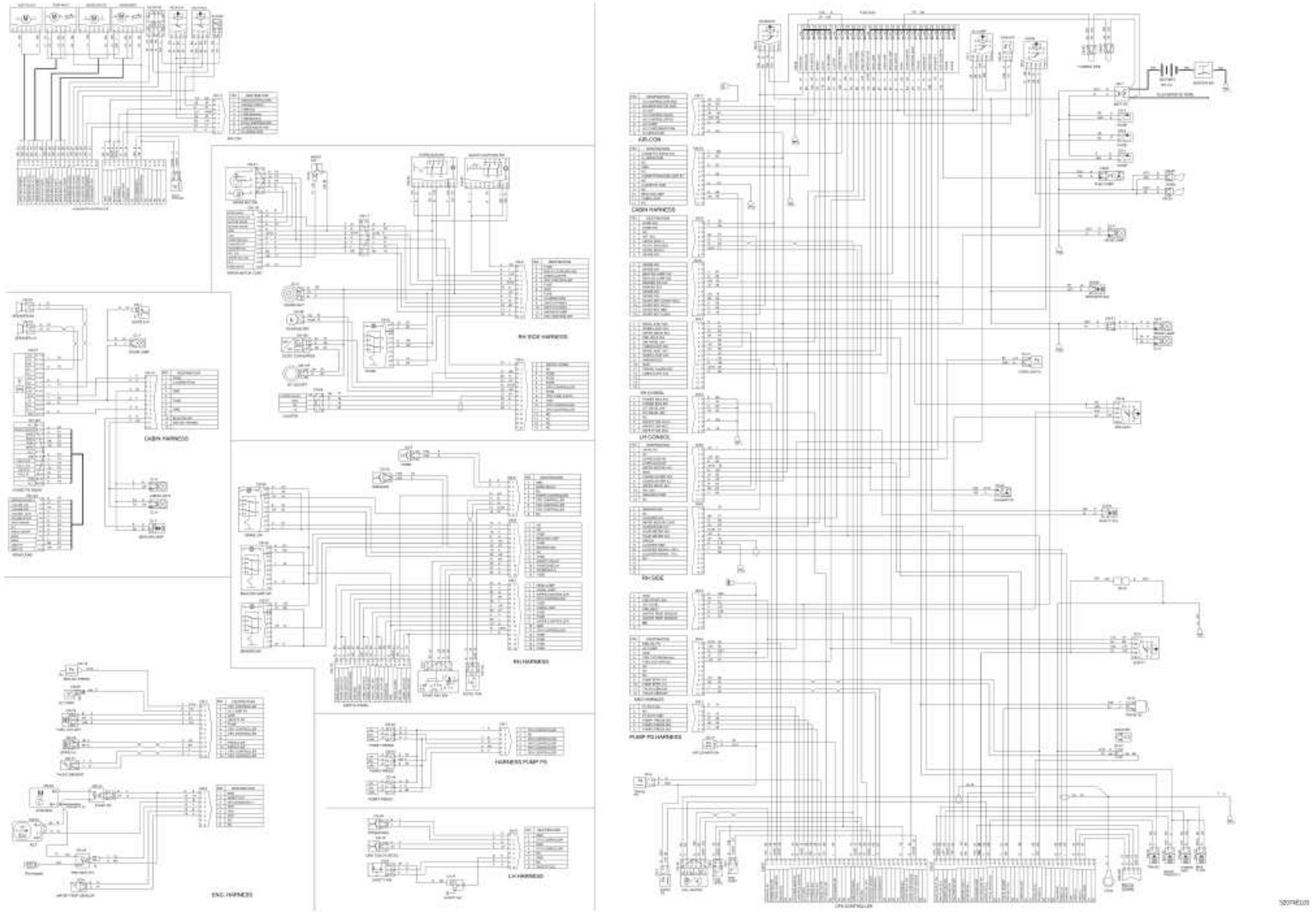
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(10) Boom priority valve

Loosen hexagon socket head bolts(104) and remove boom priority valve(104).

- Hexagon wrench : 10mm

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