



Service Repair Manual

Models

385B and 385B L Excavator

Product: EXCAVATOR

Model: 385B EXCAVATOR CLS

Configuration: 385B & 385B L Excavators CLS00001-UP (MACHINE) POWERED BY 3456 Engine

Disassembly and Assembly 385B and 5090B Excavators Excavator Systems

Media Number -REN5407-06

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i01659183

Control Valve - Assemble - Attachment, Bucket, and Boom

SMCS - 5051-012

Assembly Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	1P-1862	Pliers	1

Note: Check the O-ring seals, the gaskets, and the seals for wear or for damage. Replace the components, if necessary.

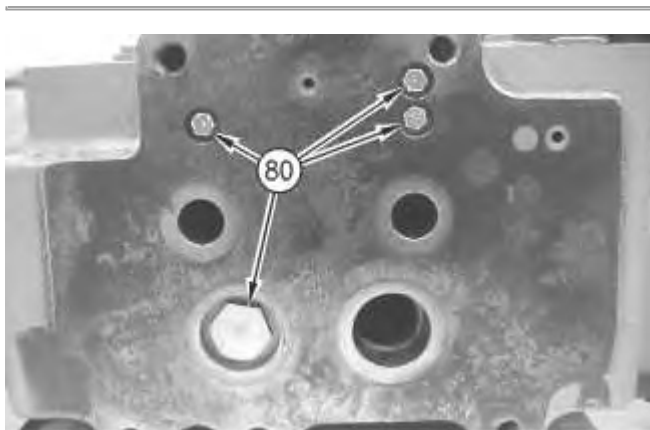


Illustration 1

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1. Install plugs and O-ring seals (80).

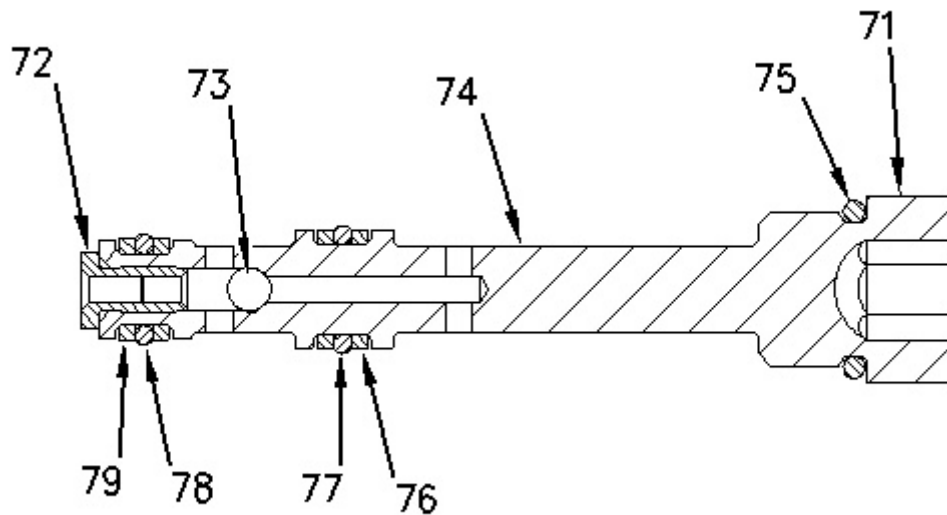


Illustration 2

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2. Assemble resolver (71). Install ball (73) in valve (74). Install seat (72). Install backup rings (76) and (79). Install O-ring seals (75), (77), and (78).

Note: Reduce the temperature of seat (72) before inserting the seat into the bore of valve (74).

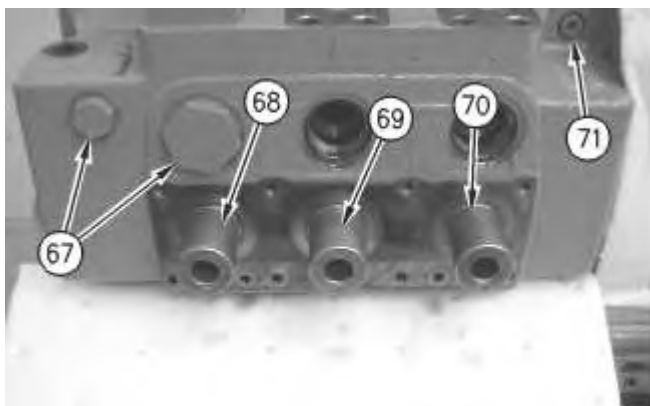


Illustration 3

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3. Install resolver (71). Tighten the resolver to a torque of 50 ± 10 N·m (37 ± 7 lb ft). Install stems (68), (69), and (70). Install plugs and O-ring seals (67).

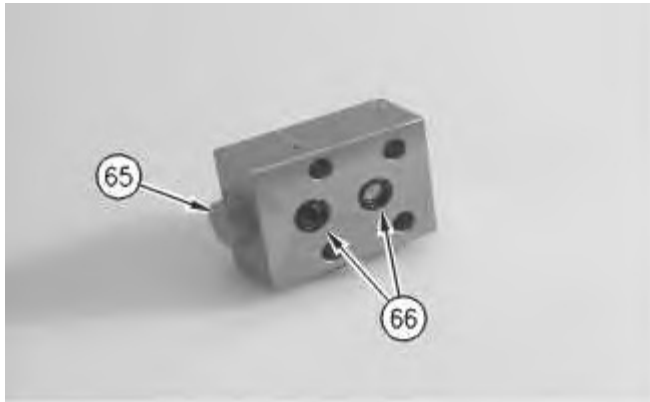


Illustration 4

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4. Install O-ring seals (66). Install plug (65) and the O-ring seal.

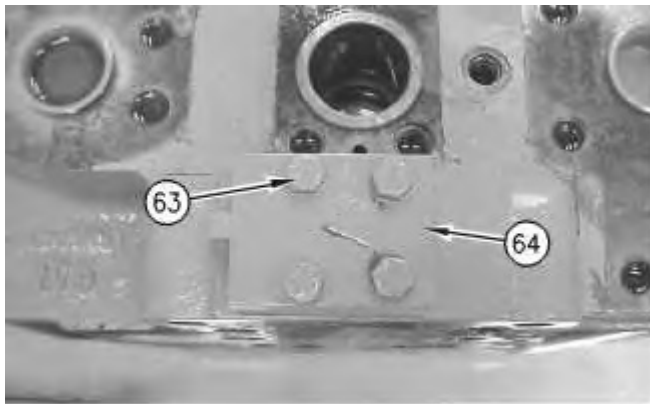


Illustration 5

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5. Position cover (64) and install bolts (63).

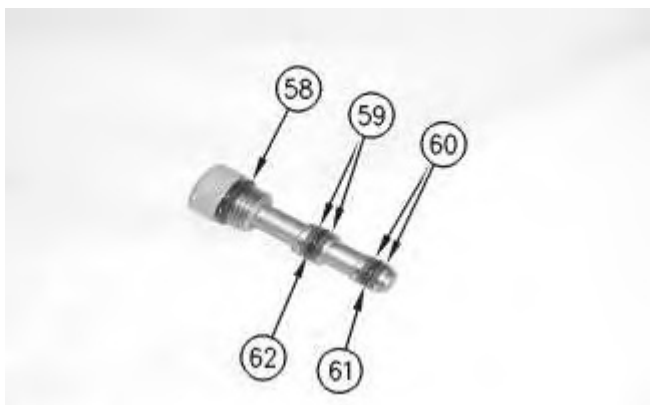


Illustration 6

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6. Assemble resolver valve (57). Install backup rings (59) and (60). Install O-ring seals (58), (61), and (62).

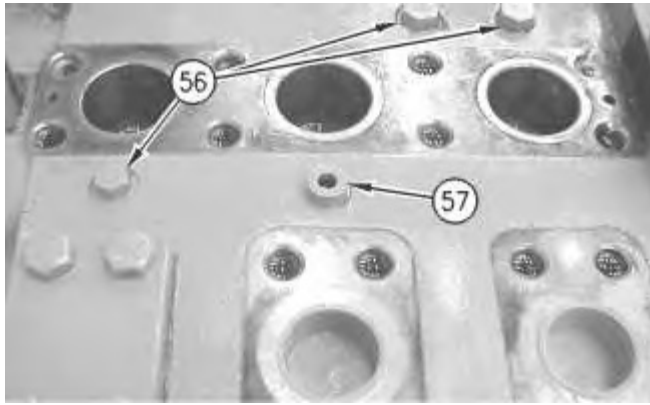


Illustration 7

g00854098

7. Install plugs and O-ring seals (56). Install resolver valve (57). Tighten the resolver valve to a torque of $50 \pm 10 \text{ N}\cdot\text{m}$ ($37 \pm 7 \text{ lb ft}$).

 **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.

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