



Service Repair Manual

Model

320C and 320C L 320CL Excavator

Product: EXCAVATOR

Model: 320C EXCAVATOR HKT

Configuration: 320C & 320C L Excavators HKT00001-UP (MACHINE) POWERED BY 3066 Engine

Disassembly and Assembly 320C Excavator Machine Systems

Media Number -REN3826-16

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i01525672

Control Valve (Auxiliary) - Install - F1 and F4 Auxiliary Control Valves

SMCS - 5051-012-AX

Installation Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
(A)	FT-2674	Vacuum Cap	1
(B)	138-7573	Link Bracket	1

NOTICE

Care must be taken to ensure that fluids are contained during performance of inspection, maintenance, testing, adjusting, and repair of the product. Be prepared to collect the fluid with suitable containers before opening any compartment or disassembling any component containing fluids.

Refer to Special Publication, NENG2500, "Dealer Service Tool Catalog" for tools and supplies suitable to collect and contain fluids on Cat® products.

Dispose of all fluids according to local regulations and mandates.

1. Install two hose assemblies on the bottom of the (F4) auxiliary control valve.
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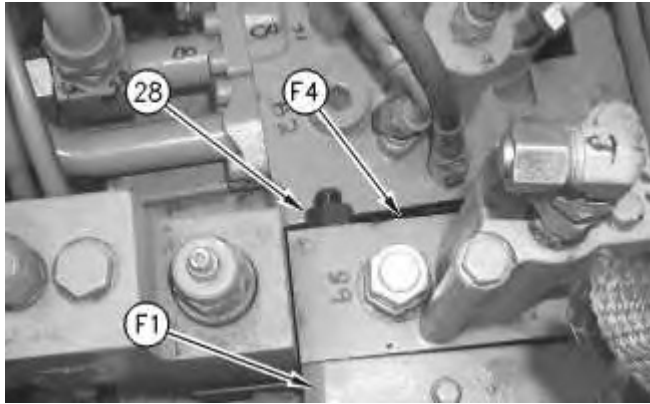


Illustration 1

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2. Fasten F1 and F4 auxiliary control valves together with the existing mount bolts. Fasten the control valves at the top with a washer and nut (28), as shown.
3. Install the F1 and F4 auxiliary control valves.
4. Lower the F1 and F4 auxiliary control valves in order to connect the hoses and electrical connections on the bottom of the auxiliary control valves.



Illustration 2

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5. Remove the cap to the hydraulic tank. Attach Tooling (A) to the hydraulic tank.

Note: Hook up the air to Tooling (A) in order to create a vacuum in the hydraulic system. This will minimize the leakage to the hose assemblies.

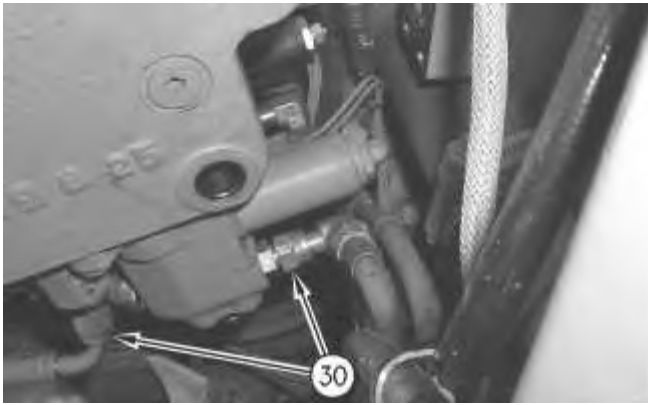


Illustration 3

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6. Connect two pilot lines (30) to the bottom of each control valve.

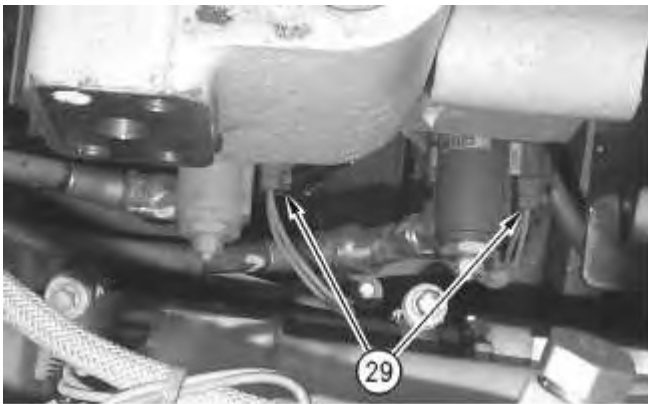


Illustration 4

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7. Connect one electrical connector (29) to each control valve.

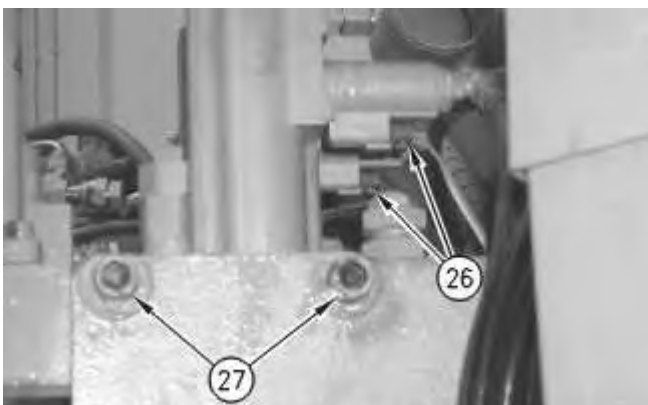


Illustration 5

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8. Align the auxiliary control valves with the main control valve. Install the bottom two mount bolts (27).

9. Remove nut (28) and the washer from the top two mount bolts that pass through control valves (F1) and (F4).
10. Install the top two mount bolts.
11. Tighten the four mount bolts (27) to a torque of 240 ± 40 N·m (177 ± 30 lb ft).
12. Connect one electrical connector (26) to each control valve.



Illustration 6

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13. Remove **7X-2547** Bolt (25).
14. Remove Tooling (B) and the hoist. Install the original bolt (25).

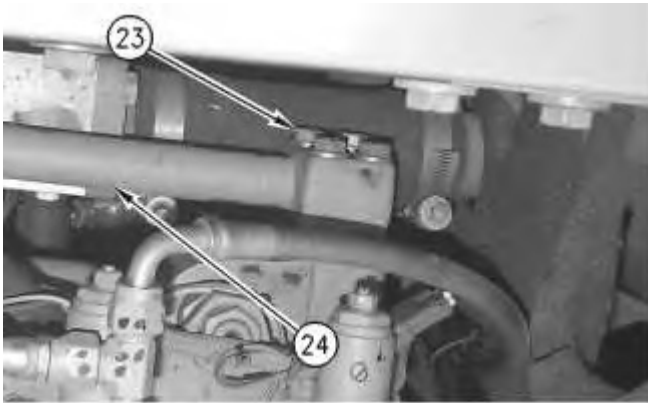


Illustration 7

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15. Install bolts (23) in order to connect tube (24) to the (F1) control valve.
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