

SECTION 2 STRUCTURE AND FUNCTION

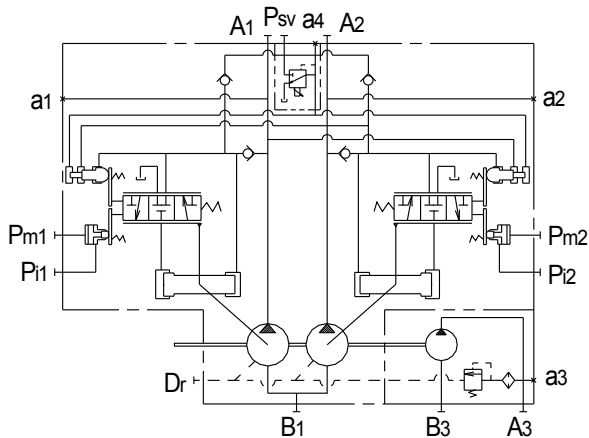
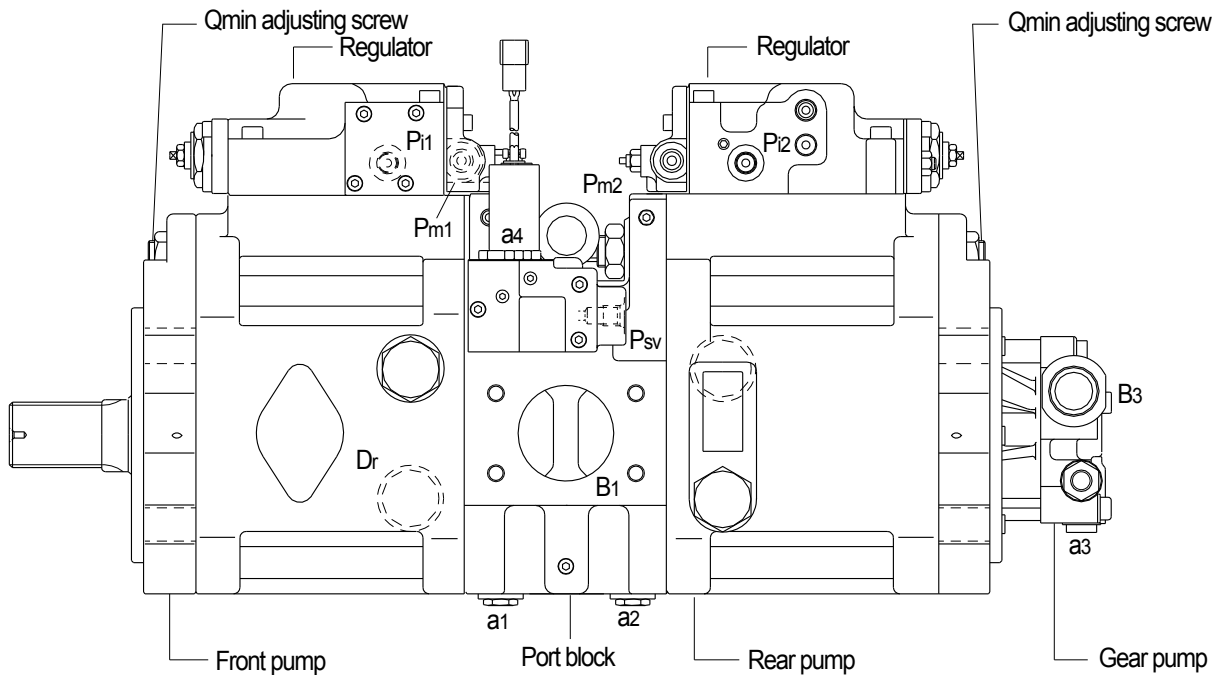
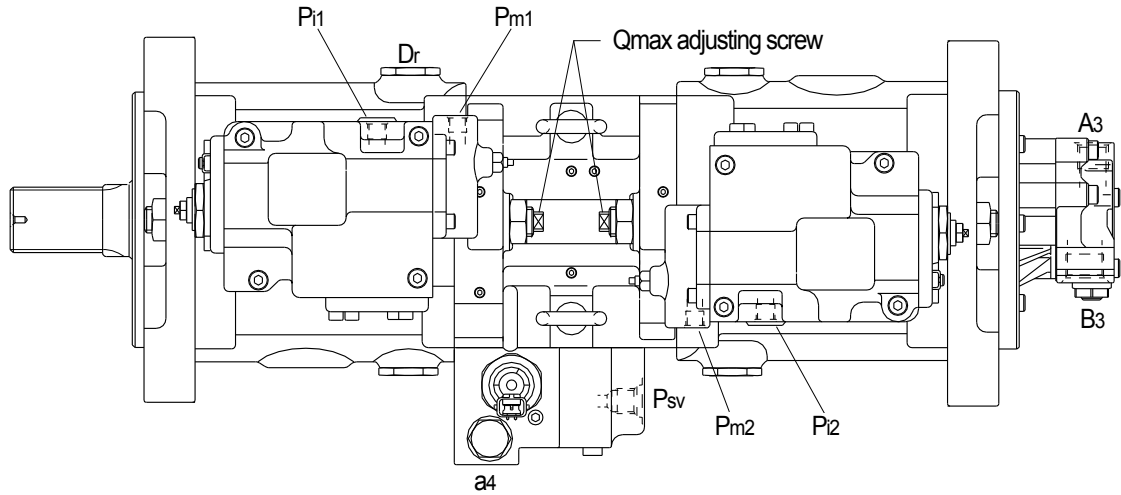
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SECTION 2 STRUCTURE AND FUNCTION

GROUP 1 PUMP DEVICE

1. STRUCTURE

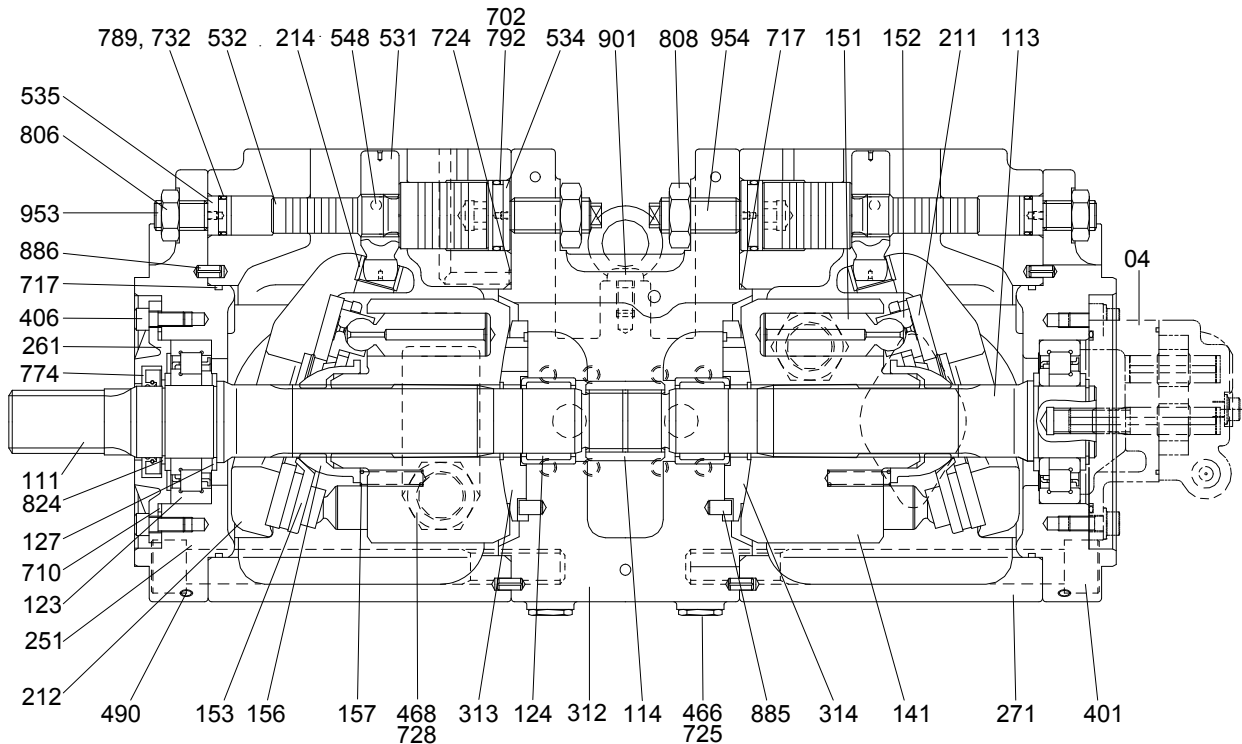
The pump device consists of main pump, regulator and gear pump.



Port	Port name	Port size
A1,2	Delivery port	SAE6000psi 3/4"
B1	Suction port	SAE2500psi 2 1/2"
Dr	Drain port	PF 3/4 - 20
P1,i,2	Pilot port	PF 1/4 - 15
Pm1,m2	Qmax cut port	PF 1/4 - 15
Psv	Servo assist port	PF 1/4 - 15
a1,2,4	Gauge port	PF 1/4 - 15
a3	Gauge port	PF 1/4-14
A3	Gear pump delivery port	PF 1/2 - 19
B3	Gear pump suction port	PF 3/4 - 20

1) MAIN PUMP(1/2)

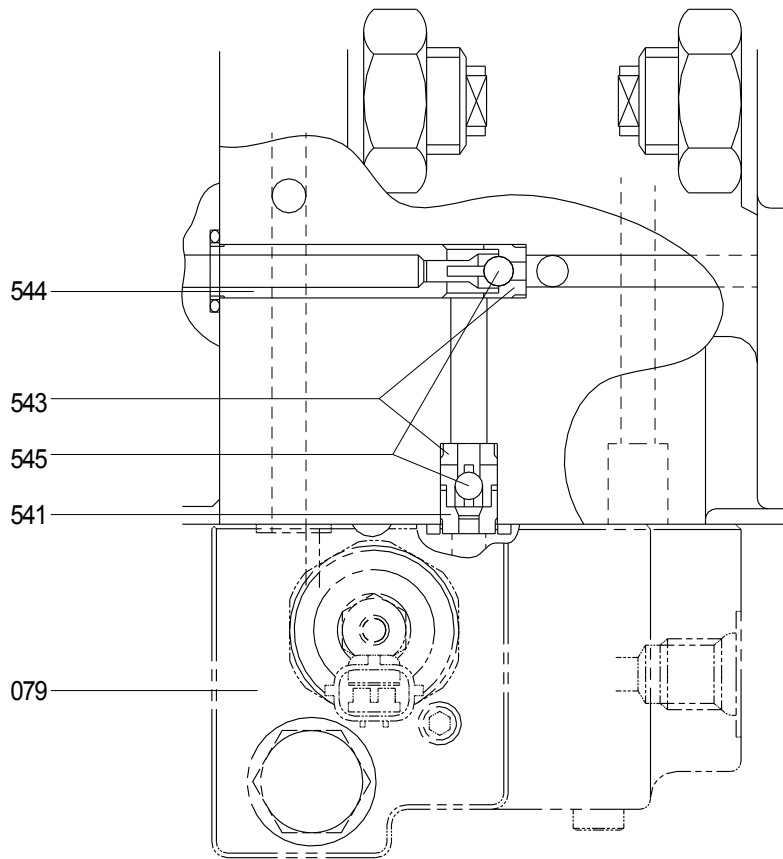
The main pump consists of two piston pumps(front & rear) and valve block.



RD21072SF02

04	Gear pump	261	Seal cover(F)	717	O-ring
111	Drive shaft(F)	271	Pump casing	724	O-ring
113	Drive shaft(R)	312	Valve block	725	O-ring
114	Spline coupling	313	Valve plate(R)	728	O-ring
123	Roller bearing	314	Valve plate(L)	732	O-ring
124	Needle bearing	401	Hexagon socket bolt	774	Oil seal
127	Bearing spacer	406	Hexagon socket bolt	789	Back up ring
141	Cylinder block	466	VP Plug	792	Back up ring
151	Piston	468	VP Plug	806	Hexagon head nut
152	Shoe	490	Plug	808	Hexagon head nut
153	Set plate	531	Tilting pin	824	Snap ring
156	Bushing	532	Servo piston	885	Pin
157	Cylinder spring	534	Stopper(L)	886	Spring pin
211	Shoe plate	535	Stopper(S)	901	Eye bolt
212	Swash plate	548	Pin	953	Set screw
214	Bushing	702	O-ring	954	Set screw
251	Support	710	O-ring		

MAIN PUMP(2/2)



VIEW A

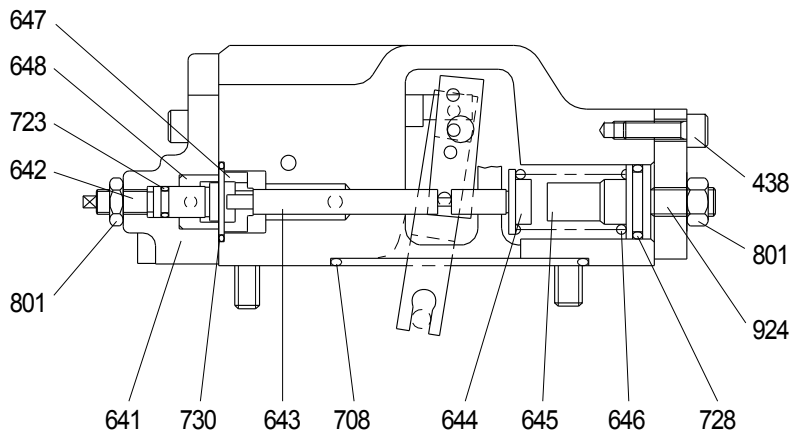
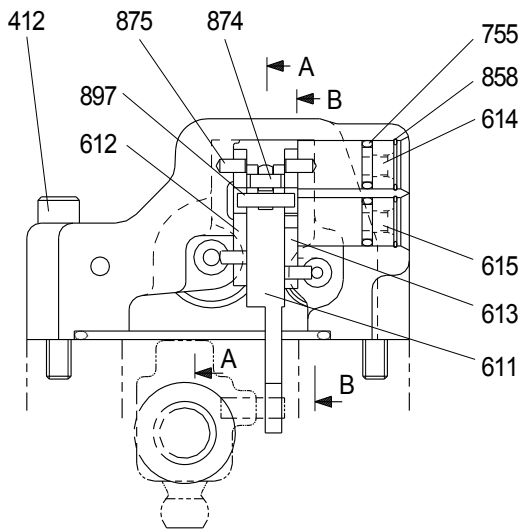
2-3

079 Proportional reducing valve
541 Seat

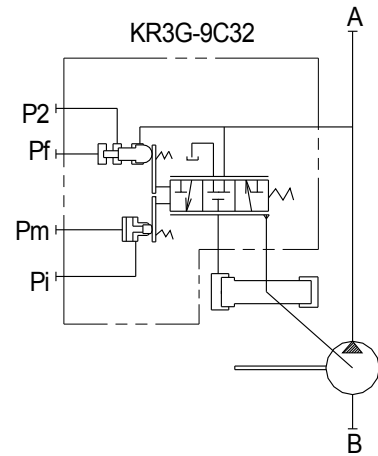
543 Stopper 1
544 Stopper 2

545 Steel ball

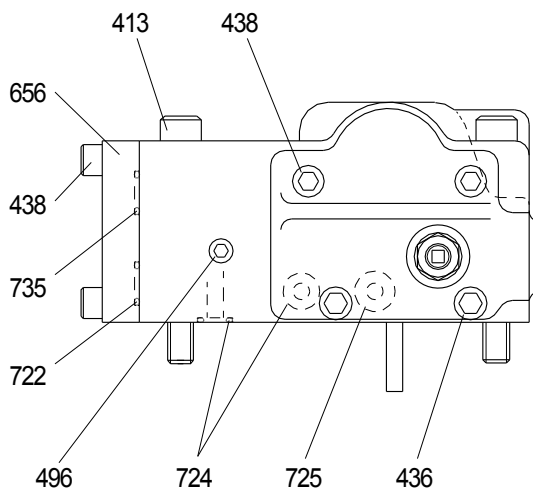
2) REGULATOR(1/2)



SECTION B-B



2-4

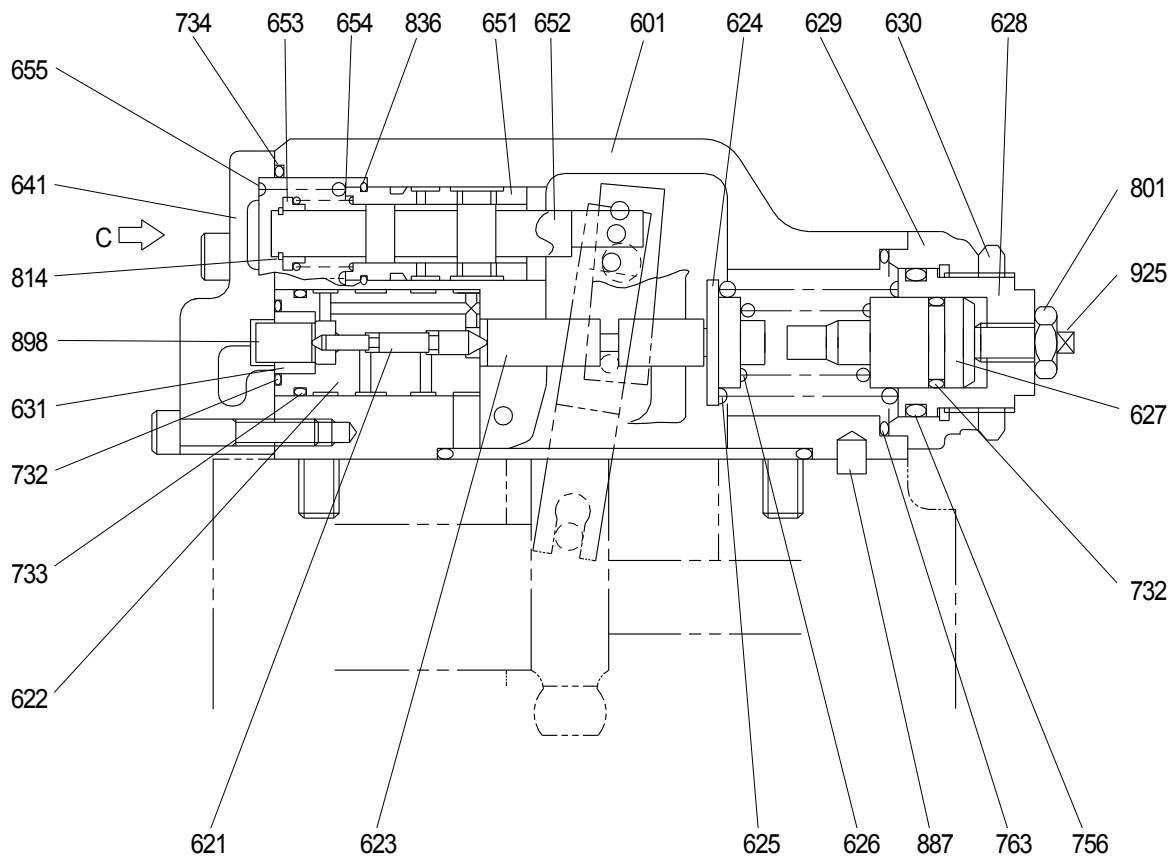


VIEW C

Port	Port name	port size
A	Delivery port	3/4"
B	Suction port	2 1/2"
Pi	Pilot port	PF 1/4-15
Pm	Qmax cut port	PF 1/4-15

2-4

REGULATOR(2/2)

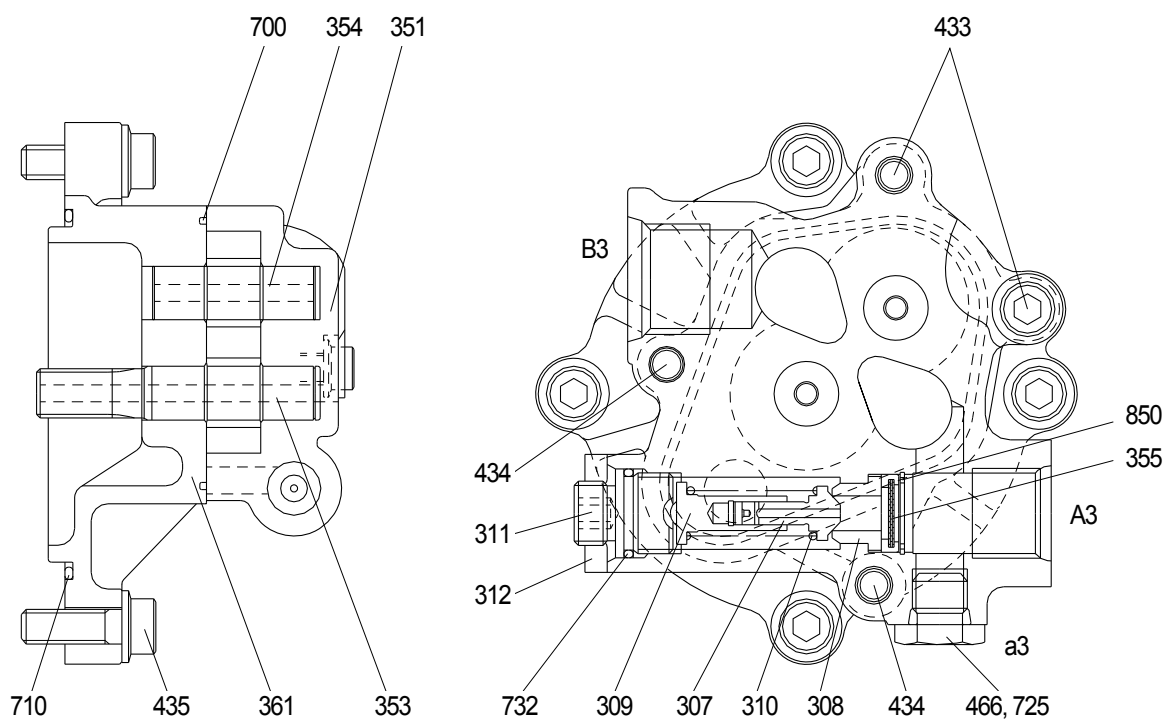


SECTION A-A

2-5

412 Hexagon socket screw	631 Sleeve, pf	730 O-ring
413 Hexagon socket screw	641 Pilot cover	732 O-ring
436 Hexagon socket screw	642 Pilot cover(QMC)	733 O-ring
438 Hexagon socket screw	643 Pilot piston	734 O-ring
496 Plug	644 Spring seat(Q)	735 O-ring
601 Casing	645 Adjust stem(Q)	755 O-ring
611 Feed back lever	646 Pilot spring	756 O-ring
612 Lever(1)	647 Stopper	763 O-ring
613 Lever(2)	648 Piston(QMC)	801 Nut
614 Fulcrum plug	651 Sleeve	814 Snap ring
615 Adjust plug	652 Spool	836 Snap ring
621 Compensator piston	653 Spring seat	858 Snap ring
622 Piston case	654 Return spring	874 Pin
623 Compensator rod	655 Set spring	875 Pin
624 Spring seat(C)	656 Block cover	887 Pin
625 Outer spring	708 O-ring	897 Pin
626 Inner spring	722 O-ring	898 Pin
627 Adjust stem(C)	723 O-ring	924 Set screw
628 Adjust screw(C)	724 O-ring	925 Adjust screw(QI)
629 Cover(C)	725 O-ring	
630 Lock nut	728 O-ring	

3) GEAR PUMP



2-6

307	Poppet	353	Drive gear	466	Plug
308	Seat	354	Driven gear	700	Ring
309	Spring seat	355	Filter	710	O-ring
310	Spring	361	Front case	725	O-ring
311	Screw	433	Flange socket	732	O-ring
312	Nut	434	Flange socket	850	Snap ring
351	Gear case	435	Flange socket		

2. FUNCTION

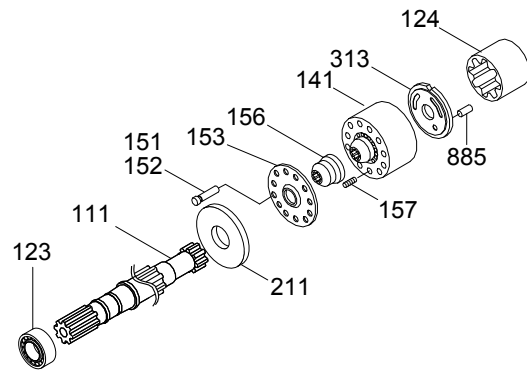
1) MAIN PUMP

The pumps may be classified roughly into the rotary group performing a rotary motion and working as the major part of the whole pump function: the swash plate group that varies the delivery rates: and the valve cover group that changes over oil suction and discharge.

(1) Rotary group

The rotary group consists of drive shaft (F)(111), cylinder block(141), piston shoes(151,152), set plate(153), spherical bush(156) and cylinder spring(157). The drive shaft is supported by bearing (123,124) at its both ends.

The shoe is caulked to the piston to form a spherical coupling. It has a pocket to relieve thrust force generated by loading pressure and to take hydraulic balance so that it slides lightly over the shoe plate(211). The sub group composed by a piston and a shoe is pressed against the shoe plate by the action of the cylinder spring via a retainer and a spherical bush. Similarly, the cylinder block is pressed against valve plate(313) by the action of the cylinder spring.



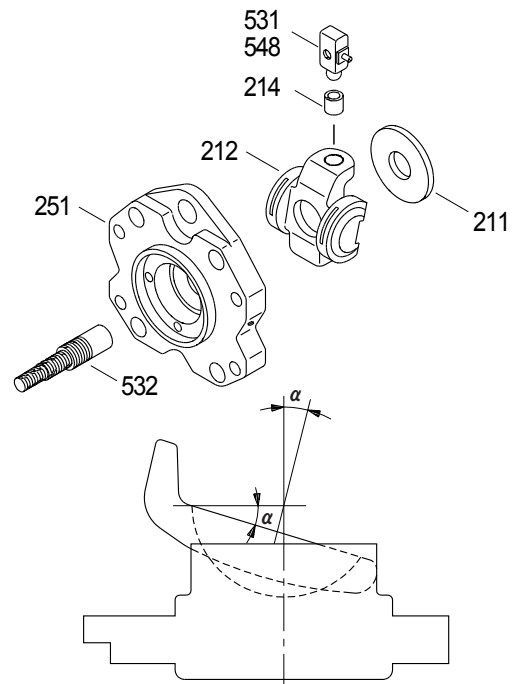
RD210722-71

(2) Swash plate group

The swash plate group consists of swash plate(212), shoe plate(211), swash plate support(251), tilting bush(214), tilting pin(531) and servo piston(532).

The swash plate is a cylindrical part formed on the opposite side of the sliding surface of the shoe and is supported by the swash support.

If the servo piston moves to the right and left as hydraulic force controlled by the regulator is admitted to hydraulic chamber located on both sides of the servo piston, the swash plate slides over the swash plate support via the spherical part of the tilting pin to change the tilting angle(α)



2-7

(3) Valve block group

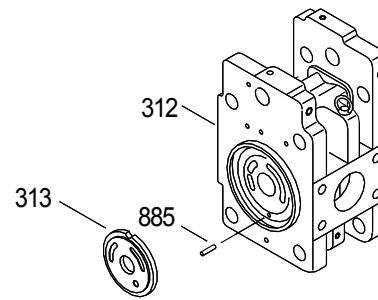
The valve block group consists of valve block(312), valve plate(313) and valve plate pin(885).

The valve plate having two melon-shaped ports is fixed to the valve block and feeds and collects oil to and from the cylinder block.

The oil changed over by the valve plate is connected to an external pipeline by way of the valve block.

Now, if the drive shaft is driven by a prime mover(electric motor, engine, etc), it rotates the cylinder block via a spline linkage at the same time. If the swash plate is tilted as in Fig(previous page) the pistons arranged in the cylinder block make a reciprocating motion with respect to the cylinder block, while they revolve with the cylinder block.

If you pay attention to a single piston, it performs a motion away from the valve plate(oil sucking process) within 180 degrees, and makes a motion towards the valve plate(or oil discharging process) in the rest of 180 degrees. When the swash plate has a tilting angle of zero, the piston makes no stroke and discharges no oil.



2) REGULATOR

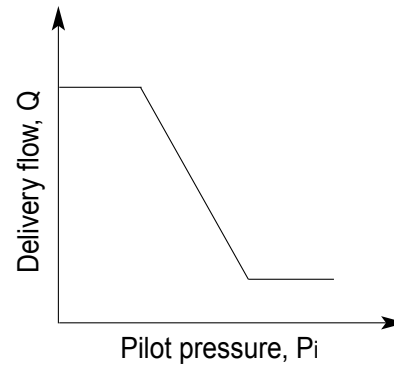
Regulator consists of the negative flow control, total horse power control and power shift control function.

(1) Negative flow control

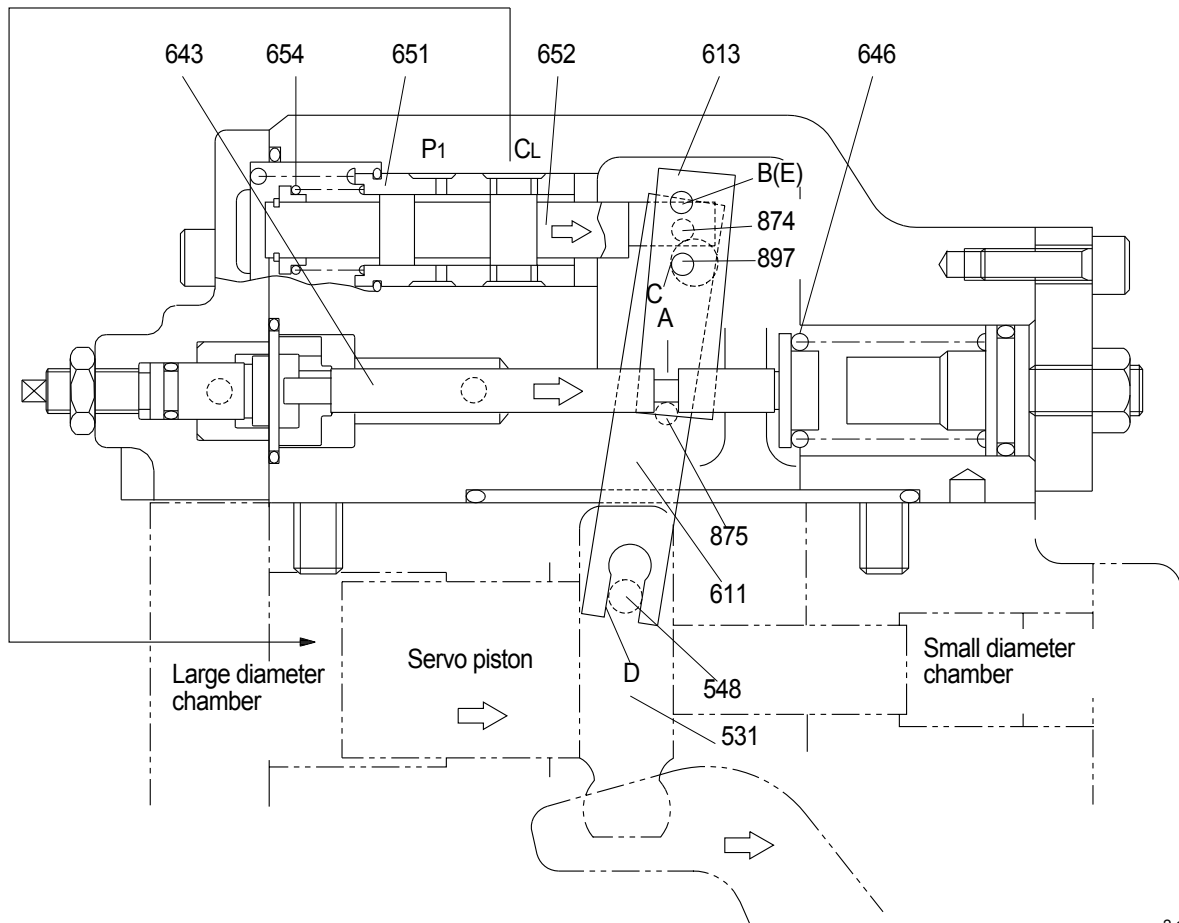
By changing the pilot pressure P_i , the pump tilting angle (delivery flow) is regulated arbitrarily, as shown in the figure.

This regulator is of the negative flow control in which the delivery flow Q decreases as the pilot pressure P_i rises.

With this mechanism, when the pilot pressure corresponding to the flow required for the work is commanded, the pump discharges the required flow only, and so it does not consume the power uselessly.



① Flow reducing function



2-10

As the pilot pressure P_i rises, the pilot piston(643) moves to the right to a position where the force of the pilot spring(646) balances with the hydraulic force.

The groove(A) in the pilot piston is fitted with the pin(875) that is fixed to lever 2(613). Therefore, when the pilot piston moves, lever 2 rotates around the fulcrum of point B [fixed by the fulcrum plug(614) and pin(875)]. Since the large hole section(C) of lever 2 contains a protruding pin(897) fixed to the feedback lever(611), the pin(897) moves to the right as lever 2 rotates. Since the opposing-flat section(D) of the feedback lever is fitted with the pin(548) fixed by the tilting pin(531) that swings the swash plate, the feedback lever rotates around the fulcrum of point D, as the pin(897) moves.

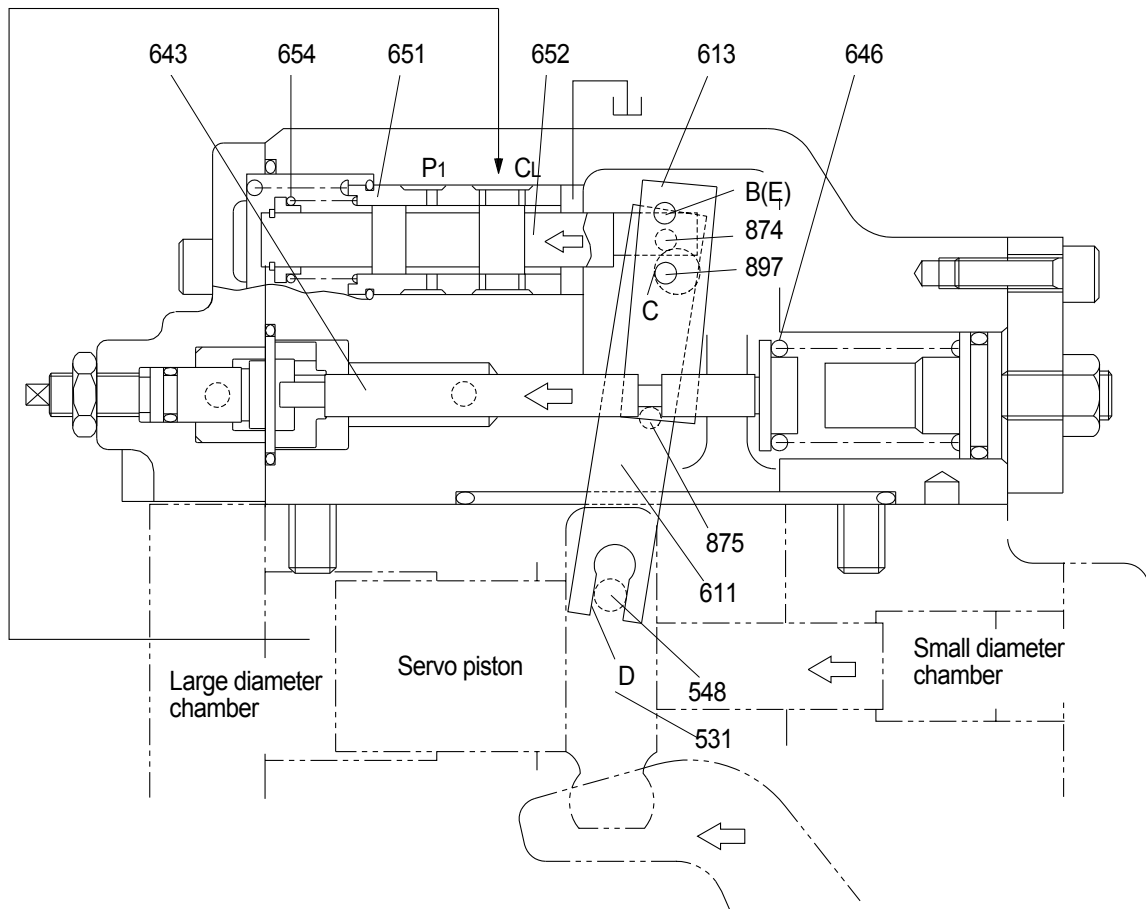
Since the feedback lever is connected with the spool(652) via the pin(874), the spool moves to the right.

The movement of the spool causes the delivery pressure P_1 to connect to port CL through the spool and to be admitted to the large diameter section of the servo piston. The delivery pressure P_1 that is constantly admitted to the small diameter section of the servo piston moves the servo piston to the right due to the area difference, resulting in decrease of the tilting angle.

When the servo piston moves to the right, point D also moves to the right. The spool is fitted with the return spring(654) and is tensioned to the left at all times, and so the pin(897) is pressed against the large hole section(C) of lever 2.

Therefore, as point D moves, the feedback lever rotates around the fulcrum of point C, and the spool is shifted to the left. This causes the opening between the sleeve(651) and spool(652) to close slowly, and the servo piston comes to a complete stop when it closes completely.

② Flow increasing function



2-11

As the pilot pressure P_i decreases, the pilot piston(643) moves to the left by the action of the pilot spring(646) and causes lever 2(613) to rotate around the fulcrum of point B. Since the pin(897) is pressed against the large hole section(C) of lever 2 by the action of the return spring(654) via the spool(652), pin(874), and feedback lever(611), the feedback lever rotates around the fulcrum of point D as lever 2 rotates, and shifts the spool to the left. Port CL opens a way to the tank port as the spool moves. This deprives the large diameter section of the servo piston of pressure, and shifts the servo piston to the left by the discharge pressure P1 in the small diameter section, resulting in an increase in the flow rate.

As the servo piston moves, point D also moves to the left, the feedback lever rotates around the fulcrum of point C, and the spool moves to the right till the opening between the spool and sleeve is closed.

③ Adjustment of flow control characteristic

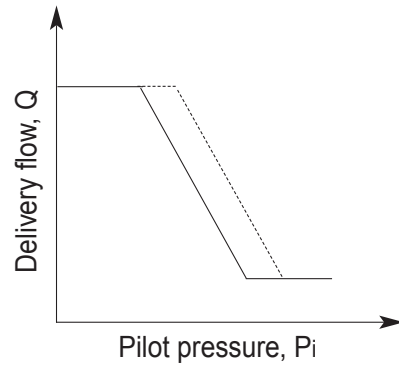
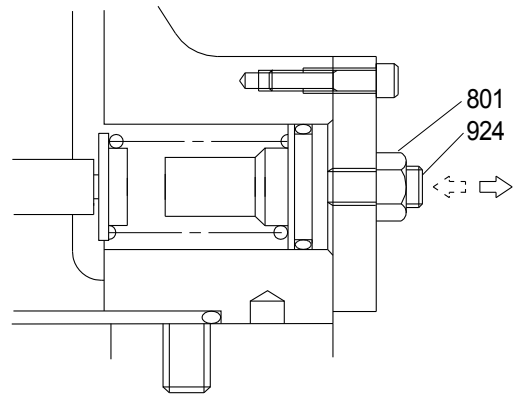
The flow control characteristic can be adjusted with the adjusting screw.

Adjust it by loosening the hexagon nut(801) and by tightening(or loosening) the hexagonal socket head screw(924).

Tightening the screw shifts the control chart to the right as shown in the figure.

※ Adjusting values are shown in table.

Speed	Adjustment of flow control characteristic		
	Tightening amount of adjusting screw(924)	Flow control starting pressure change amount	Flow change amount
(min ⁻¹)	(Turn)	(kgf/cm ²)	(l /min)
1950	+1/4	+1.5	+12.6



(2) Total horsepower control

The regulator decreases the pump tilting angle (delivery flow) automatically to limit the input torque within a certain value with a rise in the delivery pressure P_1 of the self pump and the delivery pressure P_2 of the companion pump.

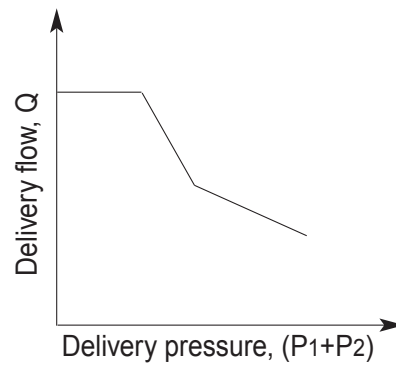
(The input horsepower is constant when the speed is constant.)

Since the regulator is of the simultaneous total horsepower type that operates by the sum of load pressures of the two pumps in the tandem double-pump system, the prime mover is automatically prevented from being overloaded, irrespective of the load condition of the two pumps, when horsepower control is under way.

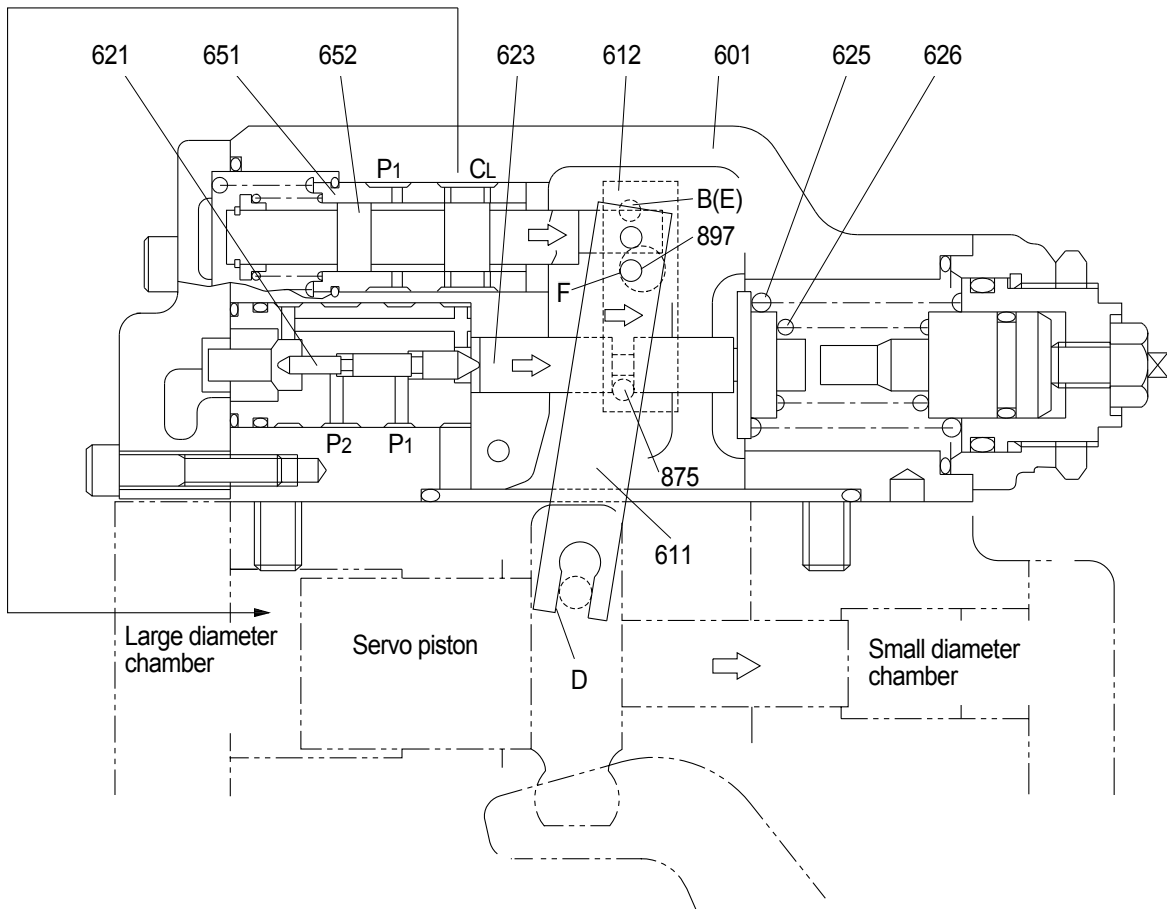
Since this regulator is of the simultaneous total horsepower type, it controls the tilting angles (displacement volumes) of the two pumps to the same value as represented by the following equation :

$$\begin{aligned} T_{in} &= P_1 \times q/2 \pi + P_2 \times q/2 \pi \\ &= (P_1 + P_2) \times q/2 \pi \end{aligned}$$

The horsepower control function is the same as the flow control function and is summarized in the following. (For detailed behaviors of respective parts, refer to the section of flow control).



① Overload preventive function



2-14

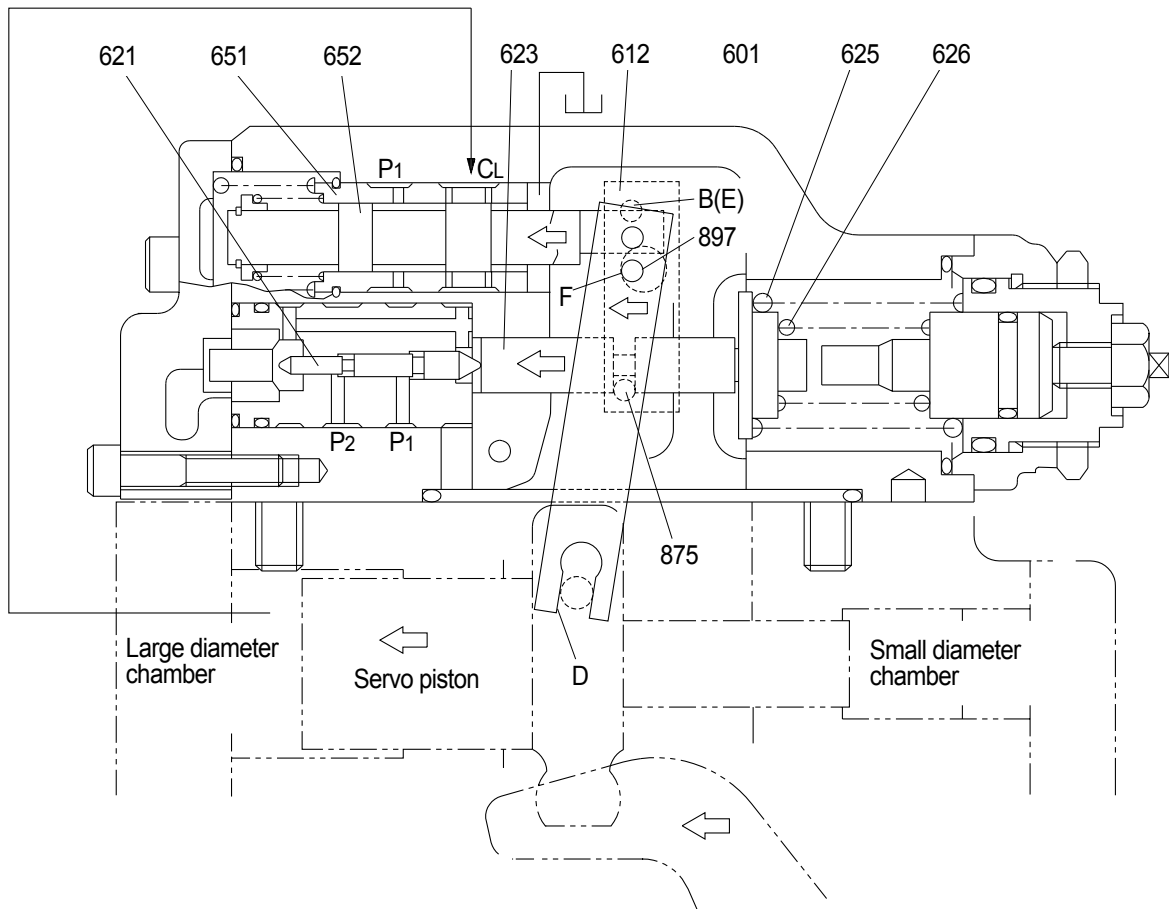
When the self pump delivery pressure P1 or the companion pump delivery pressure P2 rises, it acts on the stepped part of the compensating piston(621). It presses the compensating rod(623) to the right till the force of the outer spring(625) and inner spring(626) balances with the hydraulic force. The movement of the compensating rod is transmitted to lever 1(612) via pin(875).

Lever 1 rotates around the pin(875) (E) fixed to the casing(601).

Since the large hole section(F) of lever 1 contains a protruding pin(897) fixed to the feedback lever(611), the feedback lever rotates around the fulcrum of point D as lever 1 rotates, and then the spool(652) is shifted to the right. As the spool moves, the delivery pressure P1 is admitted to the large diameter section of the servo piston via port CL, causes the servo piston move to the right, reduces the pump delivery, flow rate, and prevents the prime mover from being overloaded.

The movement of the servo piston is transmitted to the feedback lever via point D. Then the feedback lever rotates around the fulcrum of point F and the spool is shifted to the left. The spool moves till the opening between the spool(652) and sleeve(651) is closed.

② Flow reset function



2-15

As the self pump delivery pressure P_1 or the companion pump delivery pressure P_2 decreases, the compensating rod (623) is pushed back by the action of the springs (625 & 626) to rotate lever 1 (612) around point E. Rotating of lever 1 causes the feedback lever (611) to rotate around the fulcrum of point D and then the spool (652) to move to the left. As a result, port CL opens a way to the tank port.

This causes the servo piston to move to the left and the pump's delivery rate to increase.

The movement of the servo piston is transmitted to the spool by the action of the feedback mechanism to move it till the opening between the spool and sleeve is closed.

③ **Low tilting angle(Low flow) command preferential function**

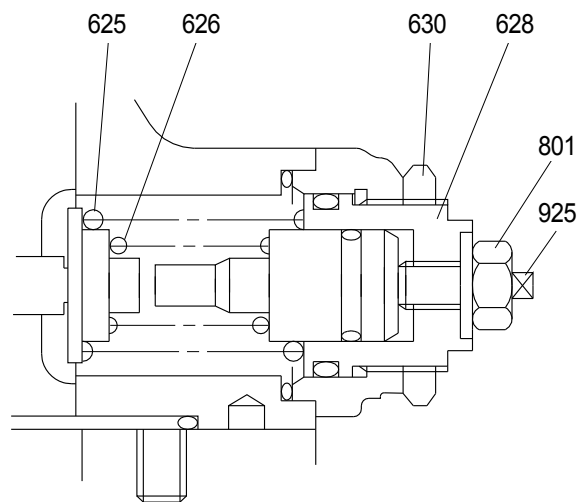
As mentioned above, flow control and horsepower control tilting angle commands are transmitted to the feedback lever and spool via the large-hole sections(C & F) of levers 1 and 2. However, since sections C and F have the pins($\varnothing 4$) protruding from the large hole($\varnothing 8$), only the lever lessening the tilting angle contacts the pin(897); the hole($\varnothing 8$) in the lever of a larger tilting angle command is freed without contacting the pin(897). Such a mechanical selection method permits preference of the lower tilting angle command of the flow control and horsepower control.

④ **Adjustment of input horsepower**

Since the regulator is of total cumulative horsepower type, adjust the adjusting screws of both the front and rear pumps, when changing the horsepower set values. The pressure change values by adjustment are based on two pumps pressurized at the same time, and the values will be doubled when only one pump is loaded.

a. **Adjustment of outer spring**

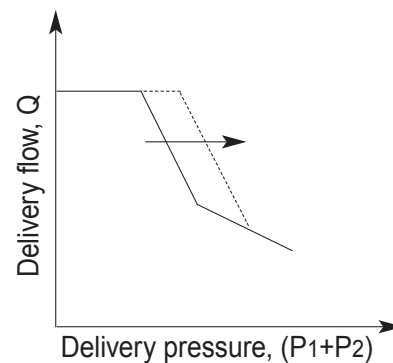
Adjust it by loosening the hexagon nut(630) and by tightening(or loosening) the adjusting screw C(628). Tightening the screw shifts the control chart to the right and increases the input horsepower as shown in the figure. Since turning the adjusting screw C by N turns changes the setting of the inner spring(626), return the adjusting screw QI(925) by $N \times A$ turns at first.($A=2.06$)



2-16

※ **Adjusting values are shown in table**

Speed	Adjustment of flow control characteristic		
	Tightening amount of adjusting screw(924)	Flow control starting pressure change amount	Flow change amount
(min ⁻¹)	(Turn)	(kgf/cm ²)	(l /min)
1950	+1/4	+15.9	+3.9



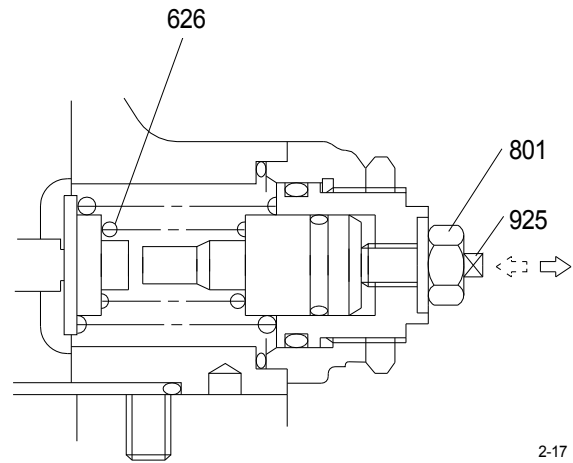
b. Adjustment of inner spring

Adjust it by loosening the hexagon nut (801) and by tightening(or loosening) the adjusting screw QI(925).

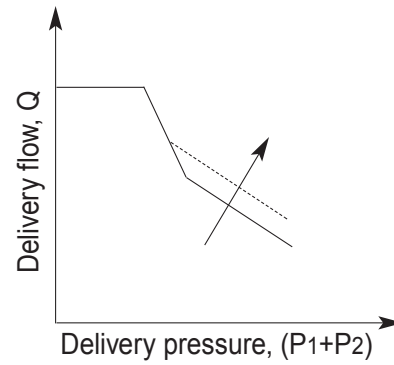
Tightening the screw increases the flow and then the input horsepower as shown in the figure.

※ Adjusting valves are shown in table

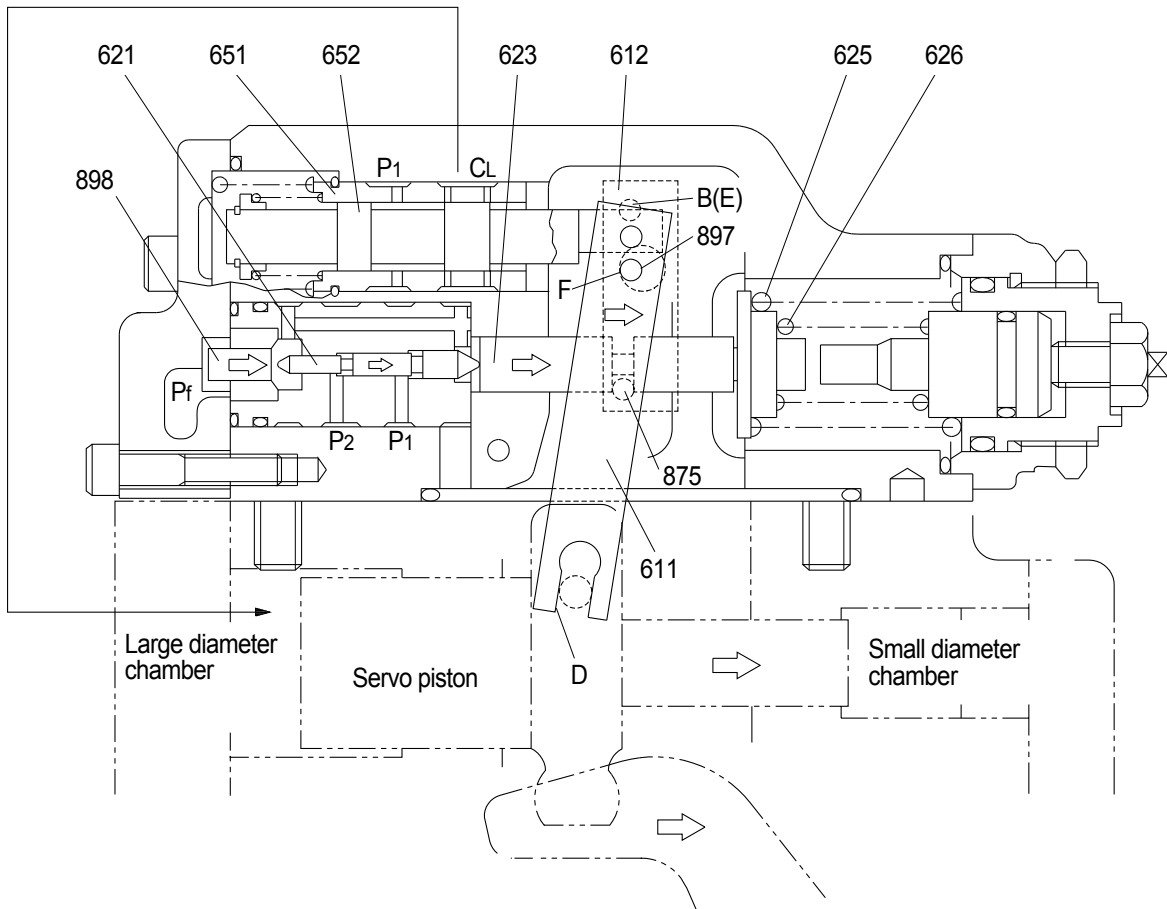
Speed	Adjustment of flow control characteristic		
	Tightening amount of adjusting screw(925)	Flow change amount	Input torque change amount
(min ⁻¹)	(Turn)	(l /min)	(kgf · m)
1950	+1/4	+8.4	+2.87



2-17



(3) Power shift control



2-18

The set horsepower valve is shifted by varying the command current level of the proportional pressure reducing valve attached to the pump.

Only one proportional pressure reducing valve is provided.

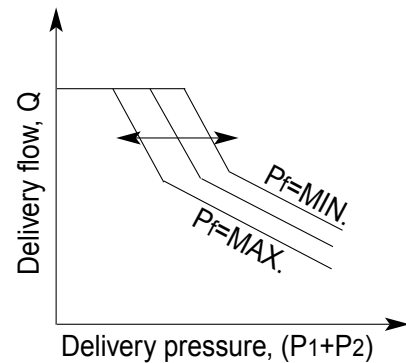
However, the secondary pressure P_f (power shift pressure) is admitted to the horsepower control section of each pump regulator through the pump's internal path to shift it to the same set horsepower level.

This function permits arbitrary setting of the pump output power, thereby providing the optimum power level according to the operating condition.

The power shift pressure P_f controls the set horsepower of the pump to a desired level, as shown in the figure.

As the power shift pressure P_f rises, the compensating rod (623) moves to the right via the pin (898) and compensating piston (621).

This decreases the pump tilting angle and then the set horsepower in the same way as explained in the overload preventive function of the horsepower control. On the contrary, the set horsepower rises as the power shift pressure P_f falls.

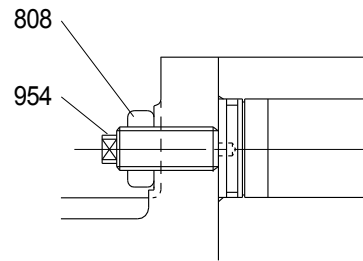


(4) Adjustment of maximum and minimum flows

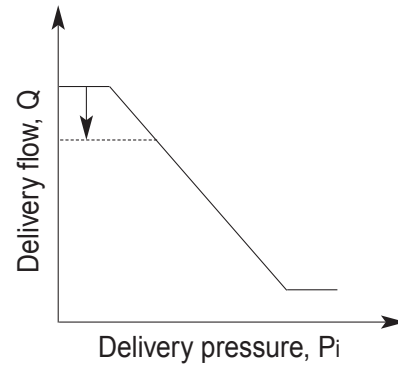
- ① Adjust it by loosening the hexagon nut(808) and by tightening(or loosening) the set screw(954).

The maximum flow only is adjusted without changing other control characteristics.

Speed	Adjustment of max flow	
	Tightening amount of adjusting screw (954)	Flow change amount
(min ⁻¹)	(Turn)	(l /min)
1950	+1/4	-5.6



2-19(1)

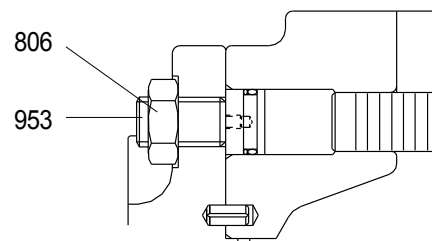


② Adjustment of minimum flow

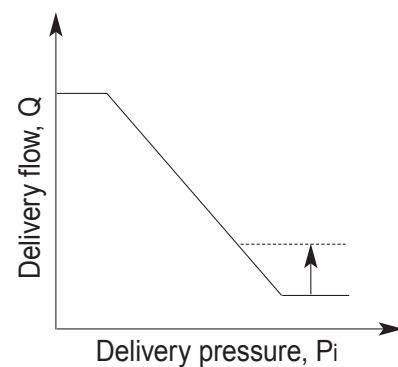
Adjust it by loosening the hexagon nut(808) and by tightening(or loosening) the hexagonal socket head set screw (953). Similarly to the adjustment of the maximum flow, other characteristics are not changed.

However, remember that, if tightened too much, the required horsepower during the maximum delivery pressure(or during relieving) may increase.

Speed	Adjustment of min flow	
	Tightening amount of adjusting screw (953)	Flow change amount
(min ⁻¹)	(Turn)	(l /min)
1950	+1/4	+4.5

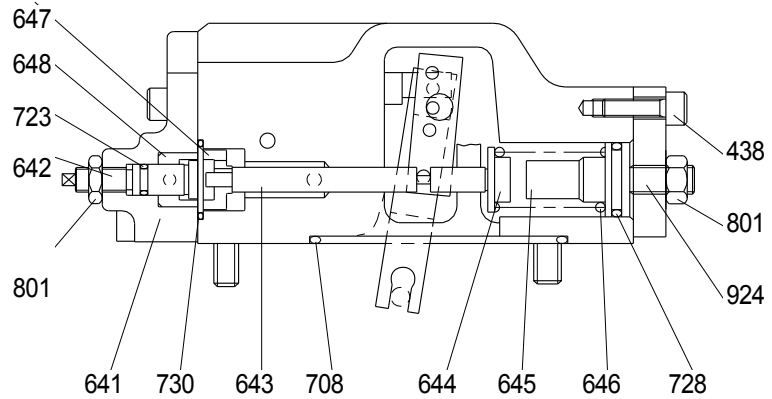


2-19(2)



(5) Qmax cut control

The regulator regulates the maximum delivery flow by inputting the pilot pressure P_m . Since this is a 2-position control method, the maximum delivery flow may be switched in two steps by turning on/off the pilot pressure P_m . (The maximum control flow cannot be controlled in intermediate level.)



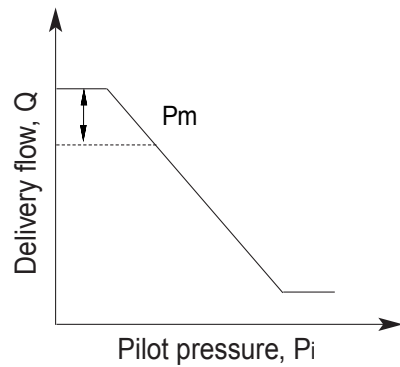
2-4

① Functional explanation

As shown in the figure, the pilot pressure P_m switches the maximum flow in two steps.

When the pilot pressure P_m is given, it is admitted to the lefthand side of the piston QMC(648). The piston QMC moves the stopper(647) and pilot piston(643) to the right, overcoming the force of the pilot spring(646), thereby reducing the delivery flow of the pump.

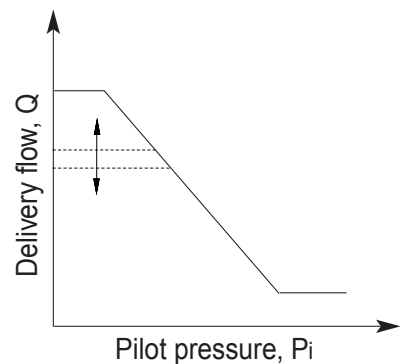
Since the adjusting screw QMC(642) is provided with a flange, the piston QMC stops upon contact with the flange, and the position of the pilot piston at this time determines the maximum flow of the pump.



② Adjustment of Qmax cut flow

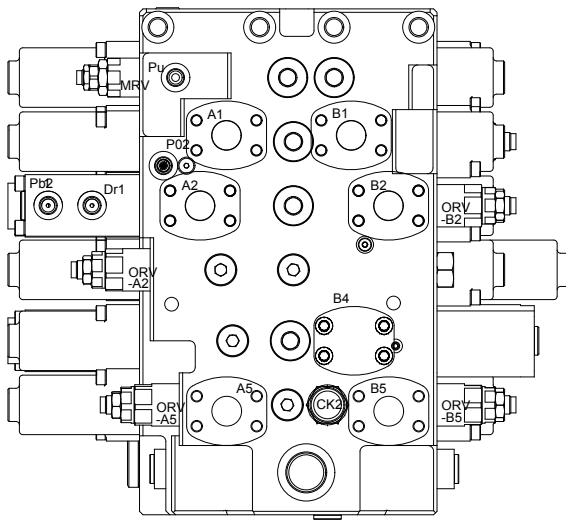
Adjust it by loosening the hexagon nut(801) and by tightening(or loosening) the adjusting screw QMC(642).

Tightening the screw decreases the Qmax cut flow as shown in the figure.

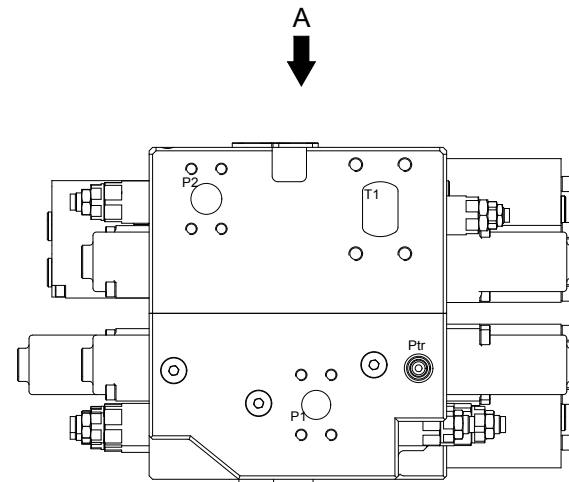


GROUP 2 MAIN CONTROL VALVE

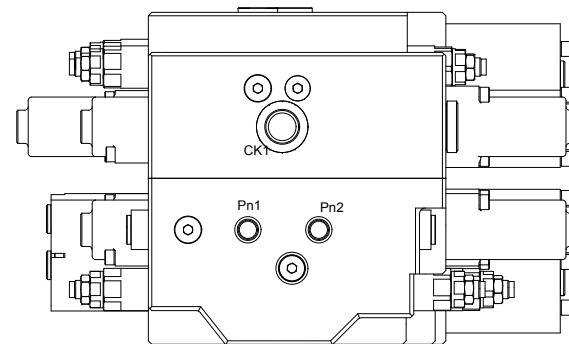
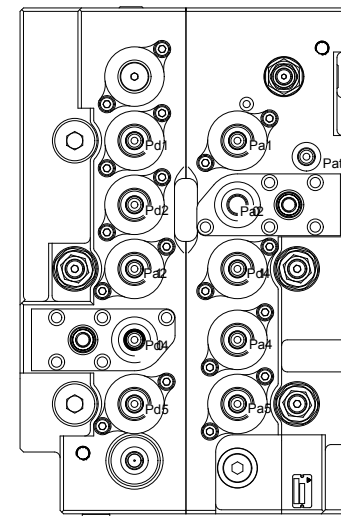
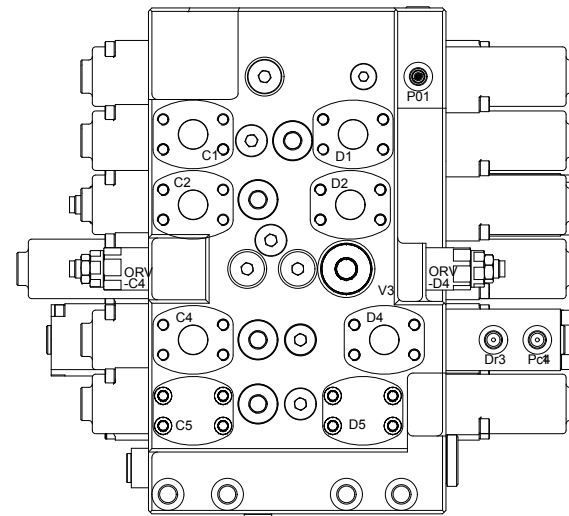
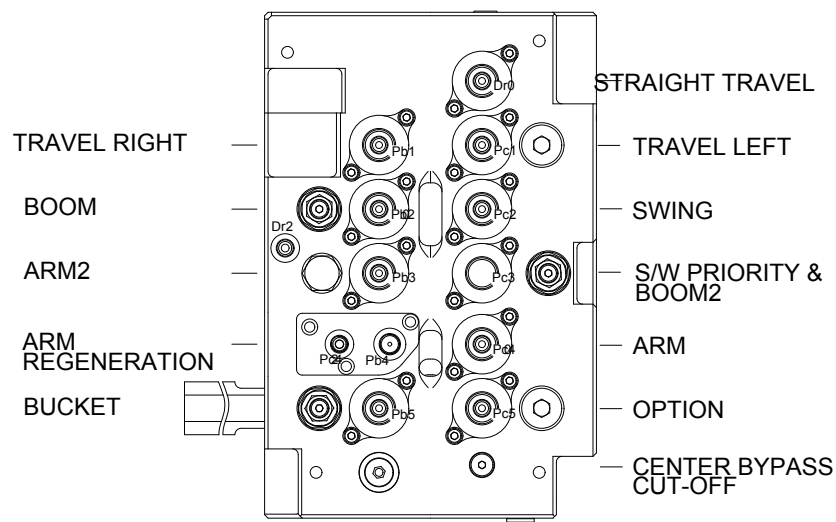
1. STRUCTURE



VIEW A

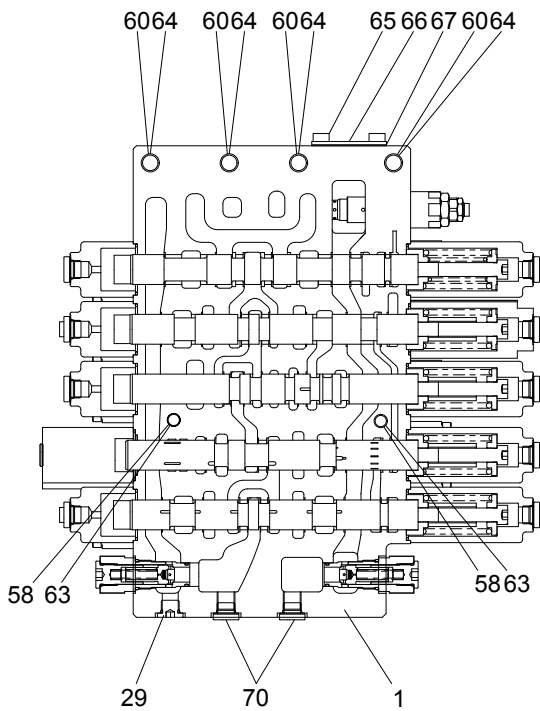


A

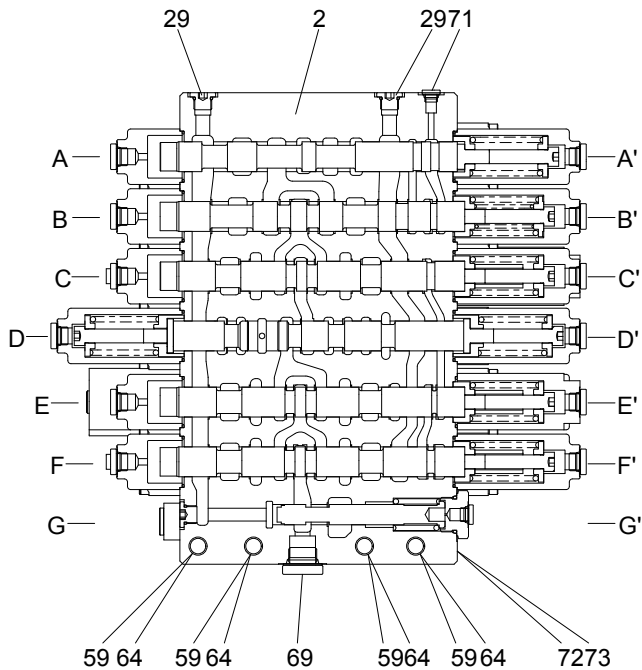


Mark	Port name	Port size	Tightening torque
Rs	Make up for swing motor	G1	20~25 kgf · m (145~180 lbf · ft)
Patt	Auto idle signal-attachment	G1/4	3.5~3.9 kgf · m (25.3~28.2 lbf · ft)
Pb21	Lock valve pilot port (boom)		
Pcb	Bucket in confluence pilot port		
P01	Pilot signal port		
P02	Pilot signal port		
Pc41	Unlock signal		
Pc42	Arm in regen-cut signal selector port		
Ptr	Auto idle signal-travel		
Pu	Power boost		
Dr1	Drain port		
Dr2	Drain port		
Ck1	Bucket confluence	G3/4	17~19 kgf · m (123~137.4 lbf · ft)
Ck2	Bucket confluence		
Pa1	Travel pilot port-RH (FW)	G3/8	7~8 kgf · m (50.6~57.8 lbf · ft)
Pb1	Travel pilot port-RH (BW)		
Pc1	Travel pilot port-LH (BW)		
Pd1	Travel pilot port-LH (FW)		
Pa20	Boom up pilot port		
Pa21	Boom up confluence pilot port		
Pb20	Boom down pilot port		
Pc2	Swing pilot port (LH)		
Pd2	Swing pilot port (RH)		
Pb3	Arm in confluence pilot port		
Pc3	Swing priority pilot port		
Pa4	Option A pilot port (breaker)		
Pb4	Arm in regeneration cut port		
Pc40	Arm in pilot port		
Pd40	Arm out pilot port		
Pd41	Arm out confluence pilot port		
Pa5	Bucket in pilot port		
Pb5	Bucket out pilot port		
Pc5	Option B pilot port		
Pd5	Option B pilot port		
Dr0	Drain port		
Pn1	Negative control signal port (A2 port side)		
Pn2	Negative control signal port (A1 port side)		
A1	Travel motor port-LH (FW)	SAE 5000 psi 1"	7.5~9.2 kgf · m (54.2~66.5 lbf · ft)
B1	Travel motor port-LH (BW)		
C1	Travel motor port-RH (BW)		
D1	Travel motor port-RH (FW)		
A2	Boom up port		
B2	Boom down port		
C2	Swing motor port (LH)		
D2	Swing motor port (RH)		
B4	Option A port (breaker)		
C4	Arm in port		
D4	Arm out port		
A5	Bucket in port	G1/8	1.5~1.9 kgf · m (10.8~13.7 lbf · ft)
B5	Bucket out port		
C5	Option B port	SAE 3000 psi 2" (M12)	6.4~8.6 kgf · m (46.2~62.2 lbf · ft)
D5	Option B port		
P1	Pump port (A2 side)	G1/8	1.5~1.9 kgf · m (10.8~13.7 lbf · ft)
P2	Pump port (A1 side)		
Dr5	Drain port	G1/8	1.5~1.9 kgf · m (10.8~13.7 lbf · ft)
T1	Return port	SAE 3000 psi 2" (M12)	6.4~8.6 kgf · m (46.2~62.2 lbf · ft)

D21072MC01

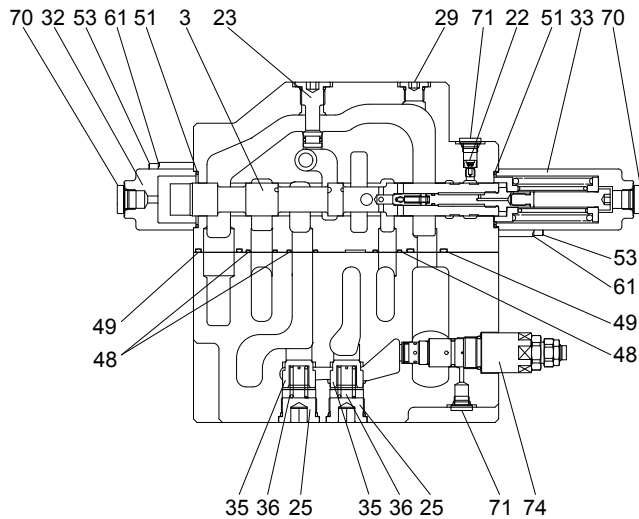


P1 BLOCK SPOOL SECTION

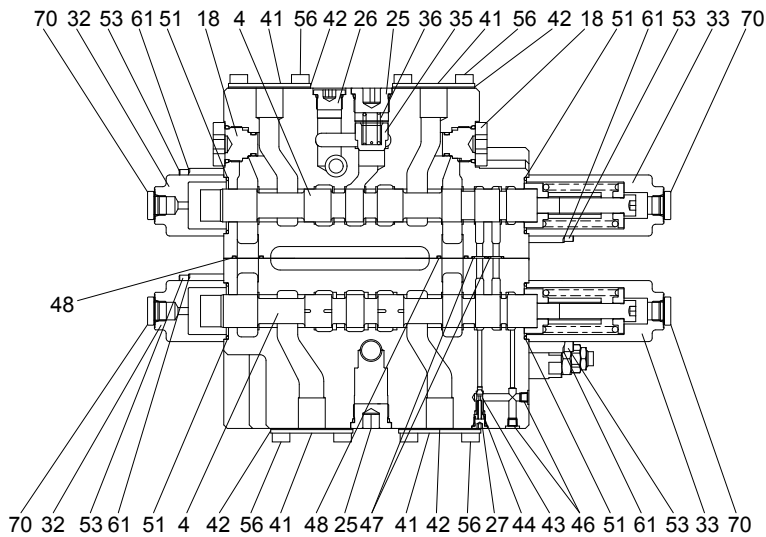


P2 BLOCK SPOOL SECTION

- 1 Housing P1
- 2 Housing P2
- 29 Plug kit
- 58 Socket bolt
- 59 Socket bolt
- 60 Socket bolt
- 63 Spring washer
- 64 Spring washer
- 65 Hexagon bolt
- 66 Cover 2
- 67 Gasket 2
- 69 Dust cap
- 70 Dust cap
- 71 Dust cap
- 72 Name plate
- 73 Rivet



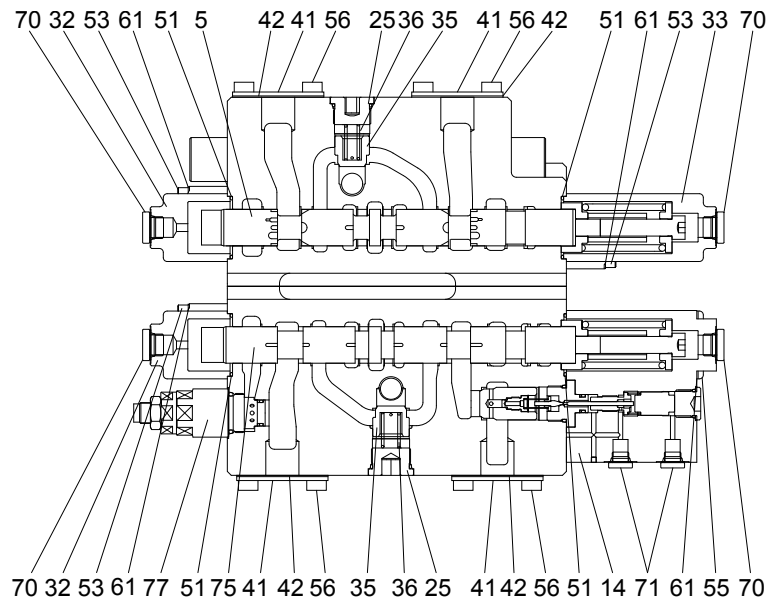
A-A ' (STRAIGHT-TRAVEL & SUPPLY)



B-B ' (TRAVEL RIGHT & LEFT)

- 3 Spool assy
- 4 Spool assy
- 18 Overload R/V plug assy
- 22 Signal orifice assy
- 23 Parallel block plug assy
- 25 Load check plug kit
- 27 Plug kit
- 29 Plug kit
- 32 Pilot cover A
- 33 Pilot cover B1
- 35 Load check poppet 1
- 36 Load check spring 1
- 41 Cover 1
- 42 Gasket 1
- 43 Poppet signal
- 44 Spring signal
- 46 Plug
- 47 O-ring
- 48 O-ring
- 49 O-ring
- 51 O-ring
- 53 Socket bolt
- 56 Hexagon bolt
- 61 Spring washer
- 70 Dust cap
- 71 Dust cap
- 74 Main relief valve assy

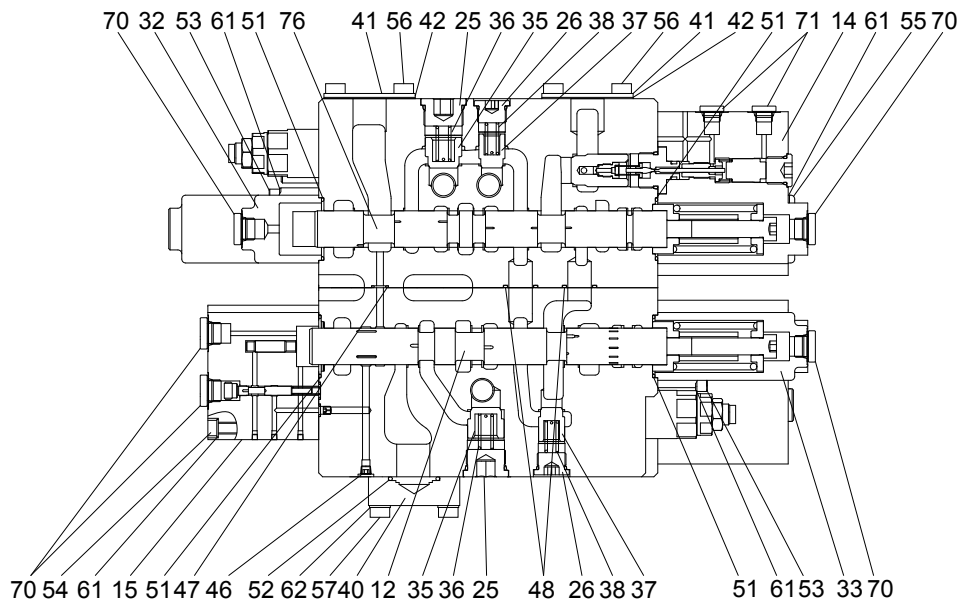
D21072MC41



C-C' (SWING & BOOM)

D21072MC42

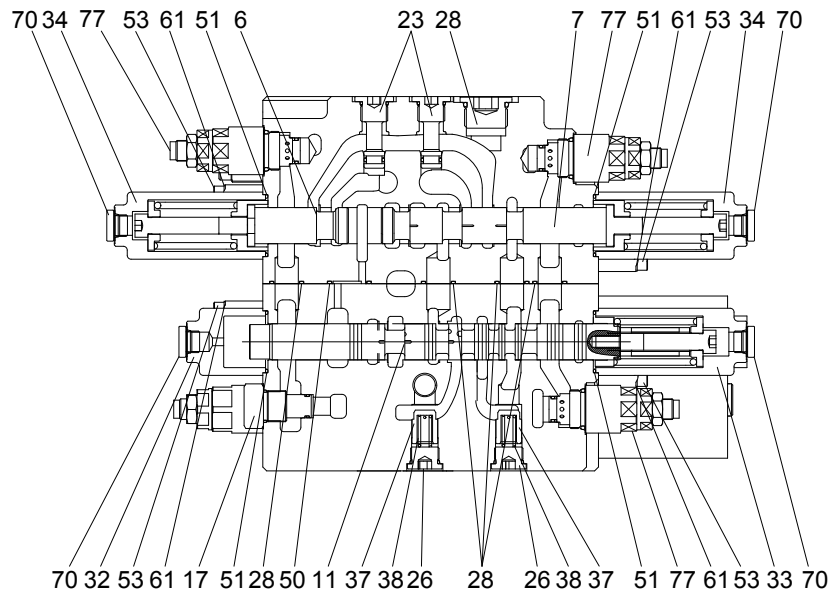
- | | | | | | |
|----|---------------------|----|---------------------|----|-------------------|
| 5 | Swing spool assy | 36 | Load check spring 1 | 56 | Haxagon bolt |
| 14 | Holding valve assy | 41 | Cover 1 | 61 | Spring washer |
| 25 | Load check plug kit | 42 | Gasket 1 | 70 | Dust cap |
| 32 | Pilot cover A | 51 | O-ring | 71 | Dust cap |
| 33 | Pilot cover B1 | 53 | Socket bolt | 75 | Boom 1 spool |
| 35 | Load check poppet 1 | 55 | Socket bolt | 77 | Overload R/V assy |



E-E ' (ARM & ARM REGENERATION)

D21072MC44

12	Arm regen spool assy	38	Load check spring 2	54	Socket bolt
14	Holding valve assy	40	Flange	55	Socket bolt
15	Regen valve assy	41	Cover 1	56	Haxagon bolt
25	Load check plug kit	42	Gasket 1	57	Socket bolt
26	Load check plug kit	46	Plug	61	Spring washer
32	Pilot cover A	47	O-ring	62	Spring washer
33	Pliot cover B1	48	O-ring	70	Dust cap
35	Load check poppet 1	51	O-ring	71	Dust cap
36	Load check spring 1	52	O-ring	76	Arm 1 spool assy
37	Load check poppet 1	53	Socket bolt		

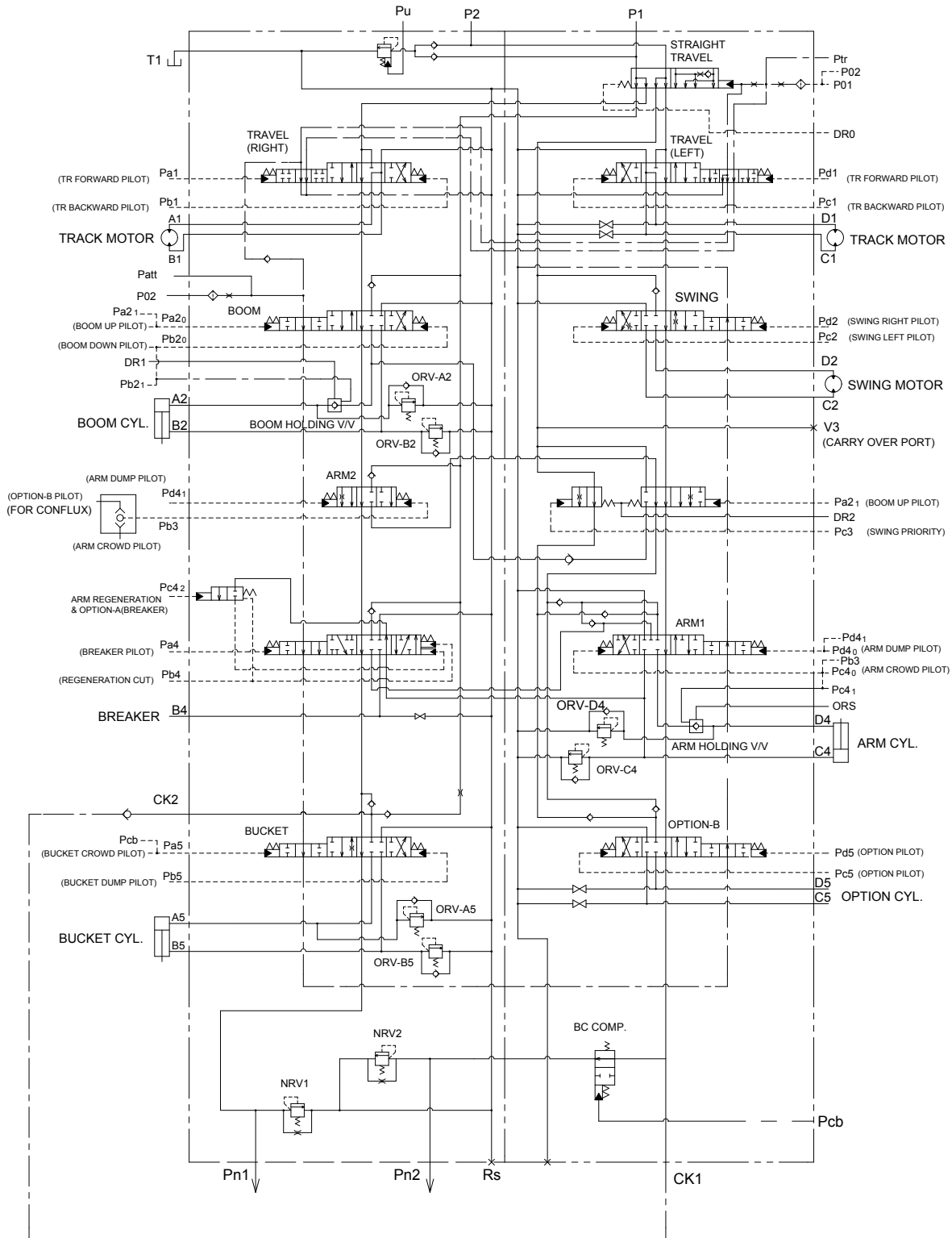


D-D ' (SWING PRIORITY & BOOM2 & ARM2)

D21072MC43

6	Swing PRI. spool assy	32	Pilot cover A	53	Socket bolt
7	Boom 2 spool assy	33	Pilot cover B1	61	Spring washer
11	Arm 2 spool assy	34	Pilot cover B2	70	Dust cap
17	Overload R/V plug assy	37	Load check poppet 2	75	Boom 1 spool assy
23	Parallel block plug assy	38	Load check spring 2	77	Overload R/V assy
26	Load check plug kit	50	O-ring		
28	Plug kit	51	O-ring		

2. HYDRAULIC CIRCUIT



D21072MC02

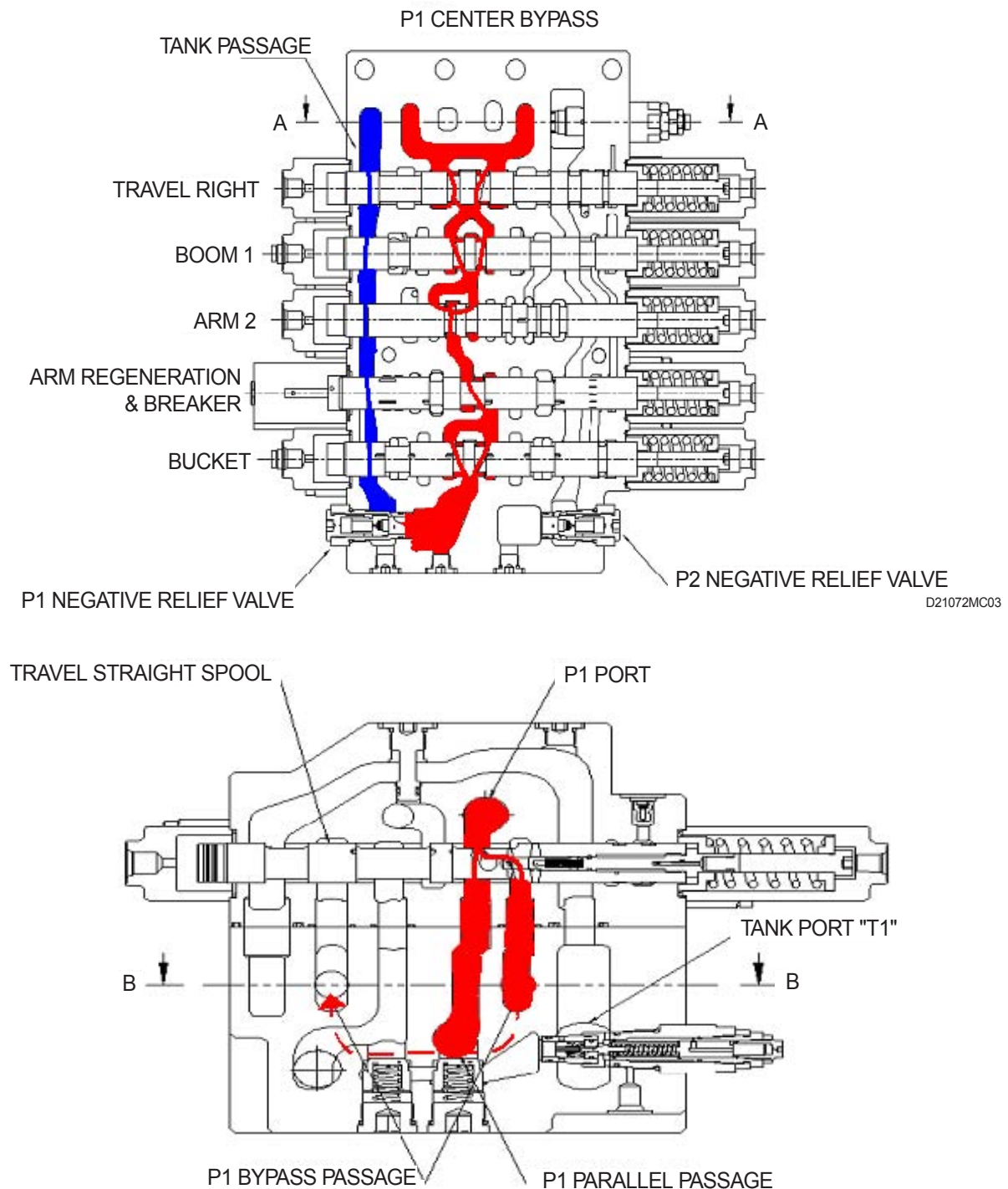
3. FUNCTION

1) CONTROL IN NEUTRAL

(1) P1 SIDE

The hydraulic fluid from pump flows into the main control valve through the inlet port "P1", pass the land of the travel straight spool, into the P1 bypass passage and P1 parallel passage.

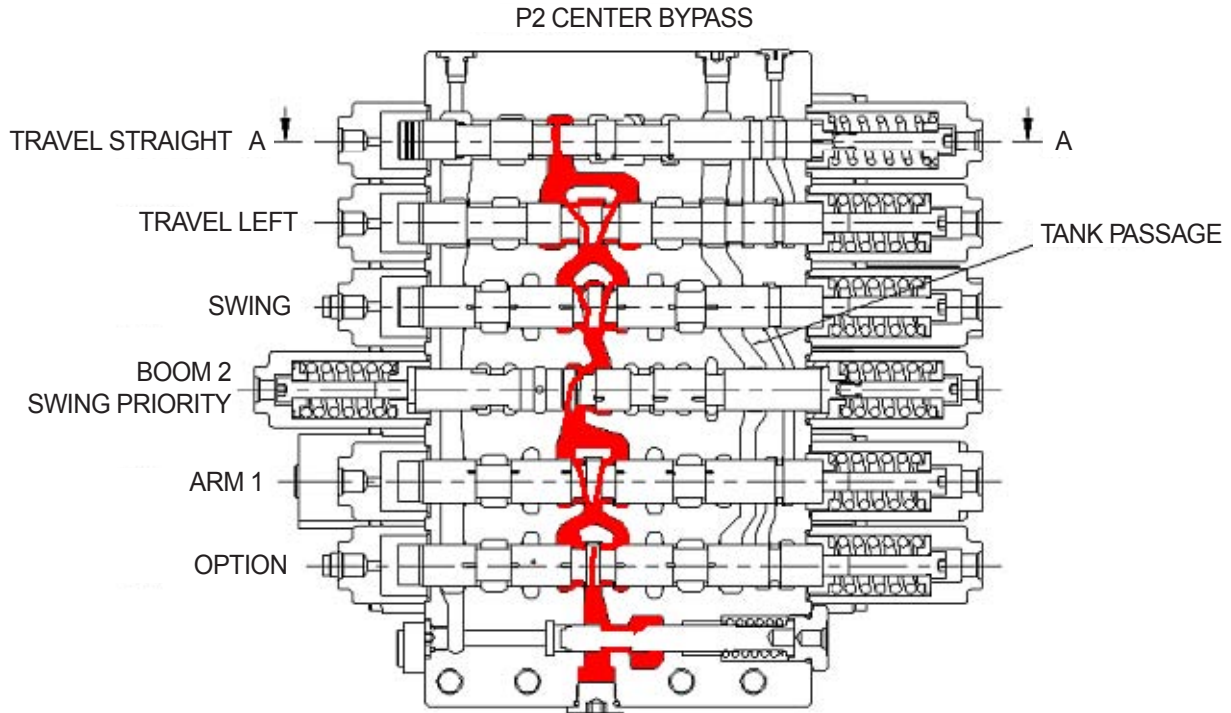
When the straight travel spool is in neutral position, the bypass passage is not shut off. Then the hydraulic fluid from the pump P1 is directed to the tank through the bypass passage of spools : travel right, boom 1, arm 2, arm regeneration & breaker and bucket, the negative relief valve of P1, tank passage, and the tank port "T1"



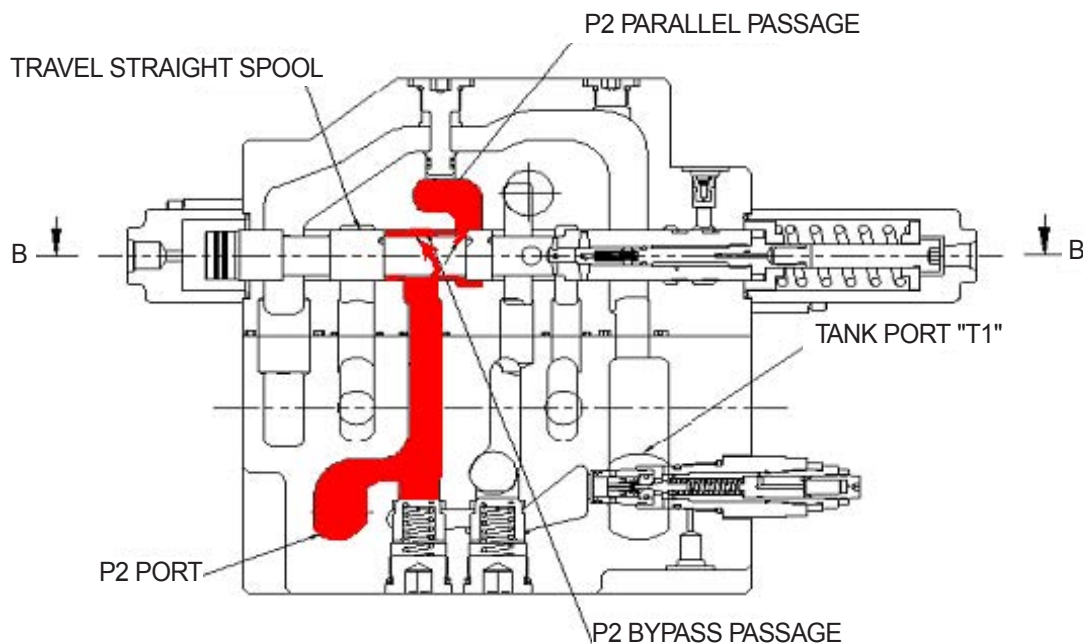
D21072MC03A

(2) P2 SIDE

The hydraulic fluid from pump flows into the main control valve through the inlet port "P2", pass the land of the straight travel spool, into the P2 bypass passage and P2 parallel passage. When the straight travel spool is in neutral position, the bypass passage is not shut off. Then the hydraulic fluid from the pump P2 is directed to the tank through the bypass passage of spools : travel left, swing, boom 2 & swing priority, arm 1, option "B" and bucket summation and the negative relief valve of P2, the tank passage and the tank port "T1".



D21072MC05



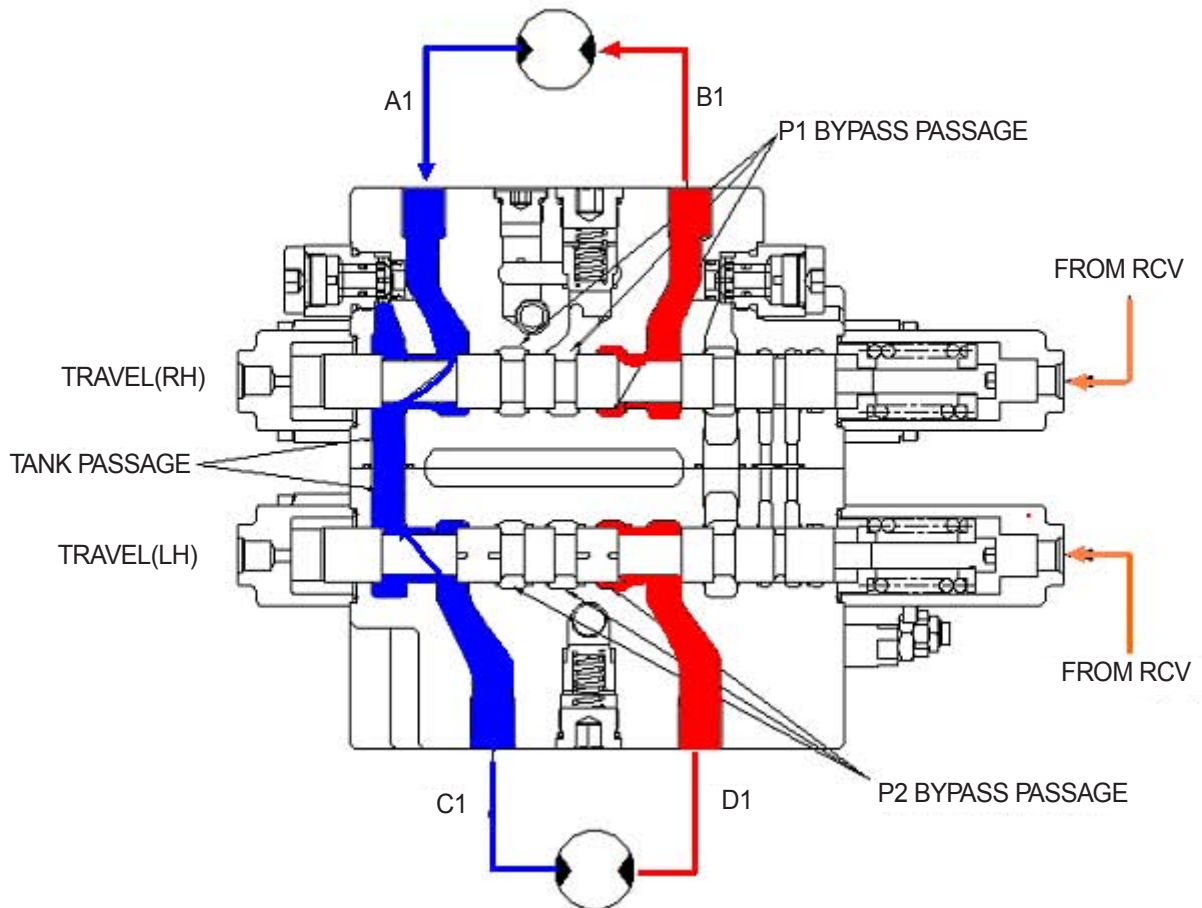
D21072MC04

2) TRAVEL OPERATION

(1) TRAVEL FORWARD OPERATION

During the travel forward operation, the pilot pressure of RCV is supplied to the port of the spring side, and it shifts travel right and left spools in the left direction against springs. Hydraulic fluid from the pump flows into the bypass passage of travel spool through the land of the straight travel spool.

Then the bypass passage is shut off by the movement of the spool, they are directed to the each travel motor through port B1 and D1. At the same time, the hydraulic fluid from the each travel motor through port A1 and C1 returns to the tank passage through the travel spools.

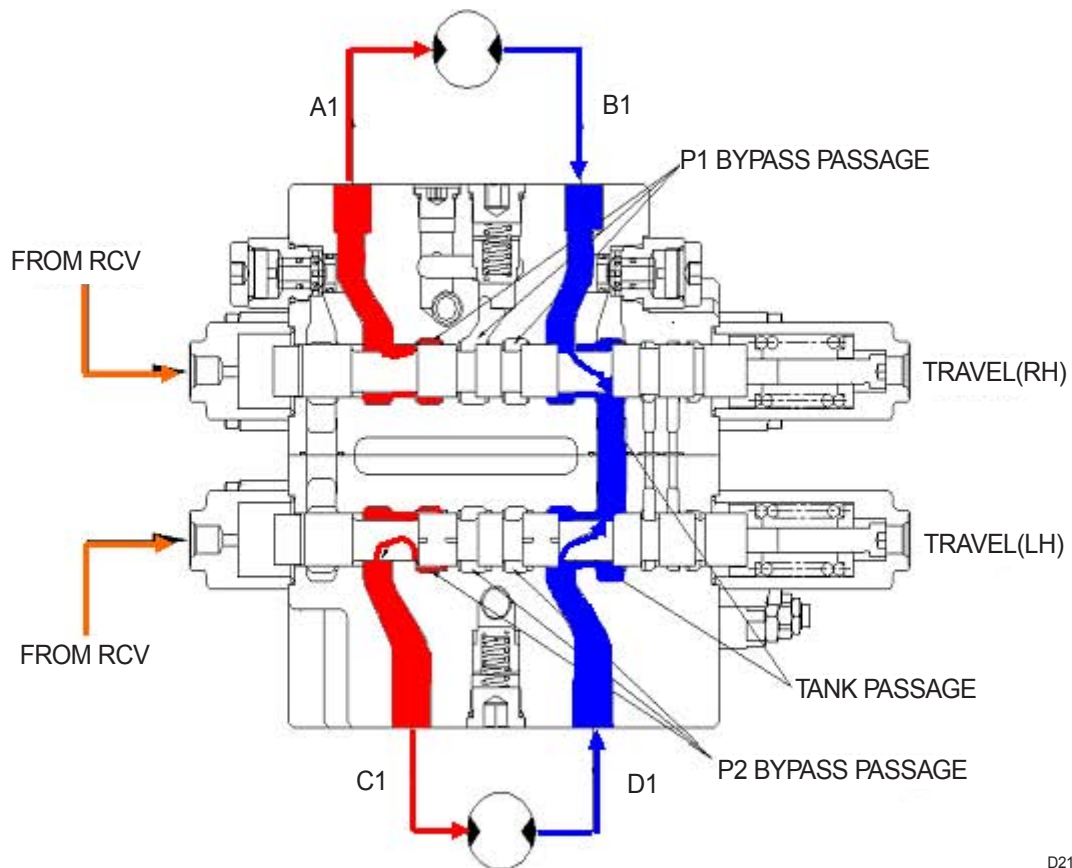


D21072MC06

(2) TRAVEL REVERSE OPERATION

During the travel reverse operation, the pilot pressure of RCV is supplied to the port of the spring opposite side, and it shifts travel right and left spools in the right direction against springs. Hydraulic fluid from the pump flows into the bypass passage of travel spool through the land of the straight travel spool.

Then the bypass passage is shut off by the movement of the spool, they are directed to the each travel motor through port A1 and C1. At the same time, the hydraulic fluid from the each travel motor through port B1 and D1 returns to the tank passage through the travel spools.



D21072MC07

(3) TRAVEL STRAIGHT FUNCTION

This function keeps straight travel in case of simultaneous operation of other actuators (boom, arm, bucket, swing) during a straight travel.

① During travel only :

The hydraulic fluid of the pump P1 is supplied to the RH travel motor and the pump P2 is supplied to the LH travel motor.

Thus, the machine keep travel straight.

② The other actuator operation during straight travel operation :

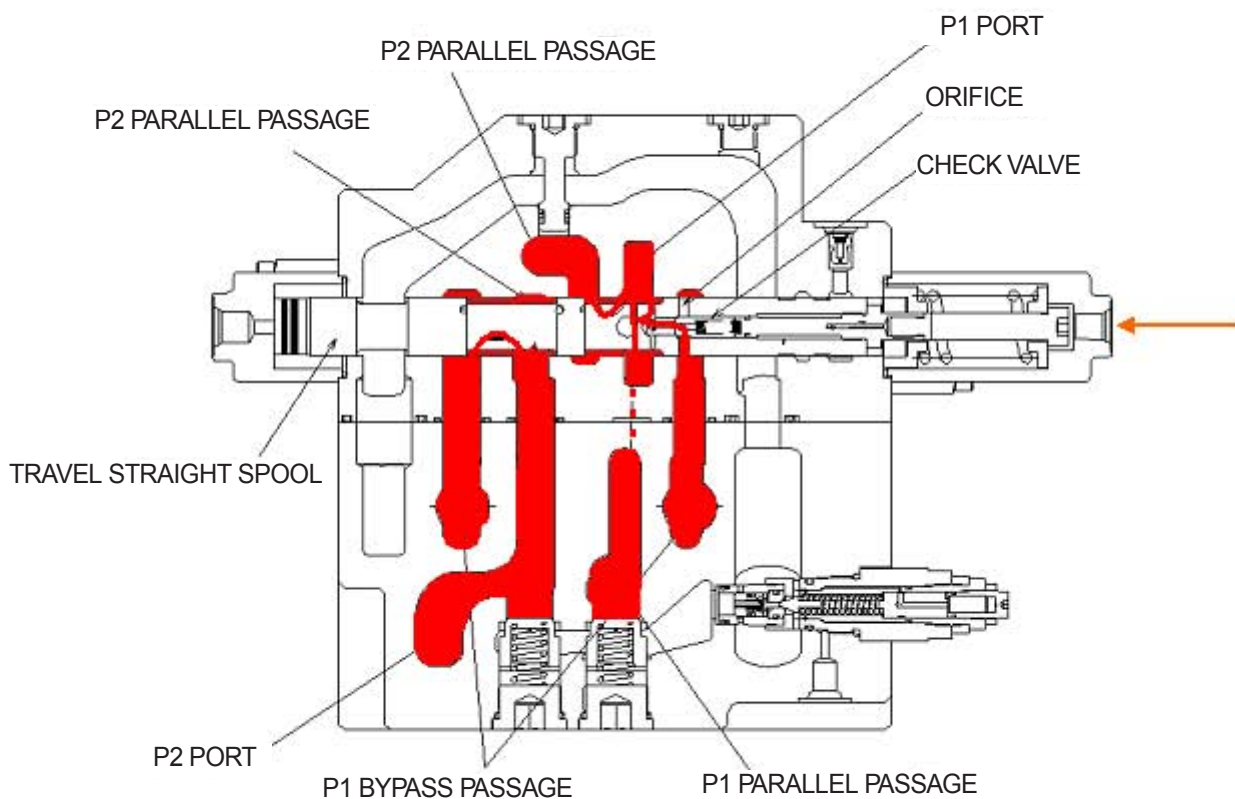
When the other actuator spool (S) is selected under straight travel operation, the straight travel spool is moved.

The hydraulic fluid from pump P1 is supplied actuator through P1 and P2 parallel pass and travel motors through orifice at side of straight travel spool.

The hydraulic oil fluid from pump P2 is supplied to travel motors (left/right).

Therefore, the other actuator operation with straight travel operation, hydraulic oil fluid from pump P1 is mainly supplied to actuator, and the hydraulic oil fluid form pump P2 is mainly supplied to travel motors (left/right).

Then the machine keeps straight travel.



D21072MC08

3) BOOM OPERATION

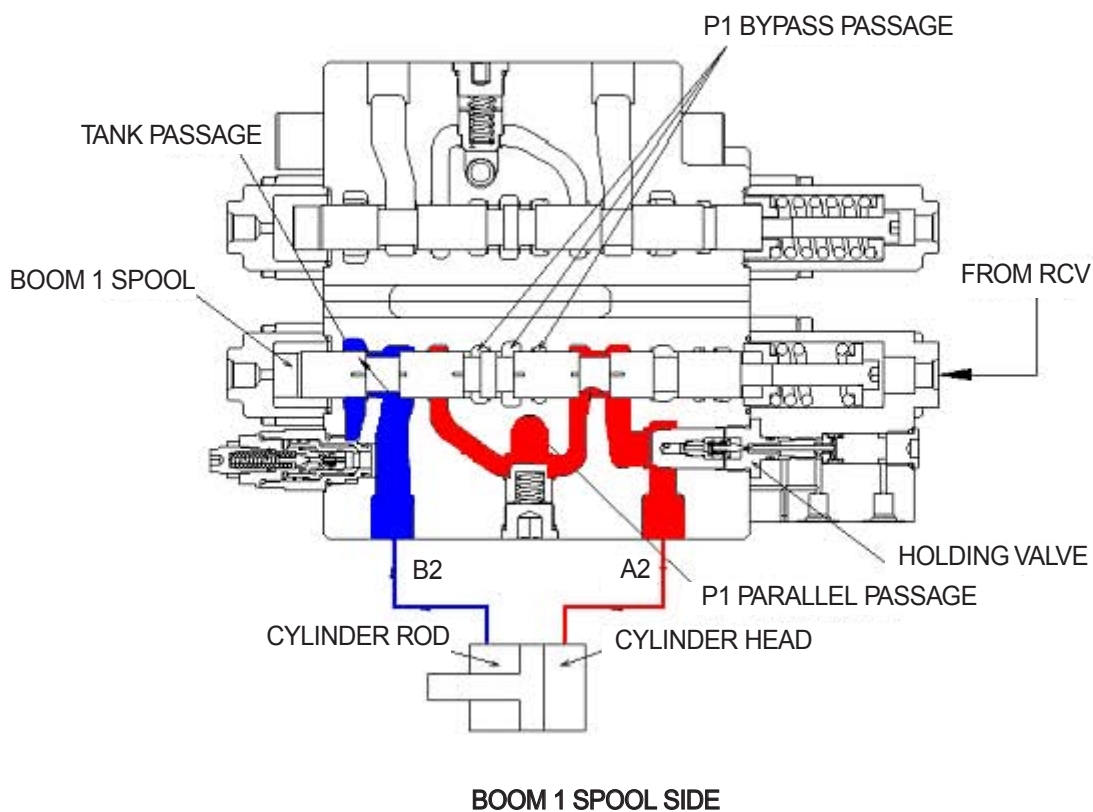
(1) BOOM UP OPERATION

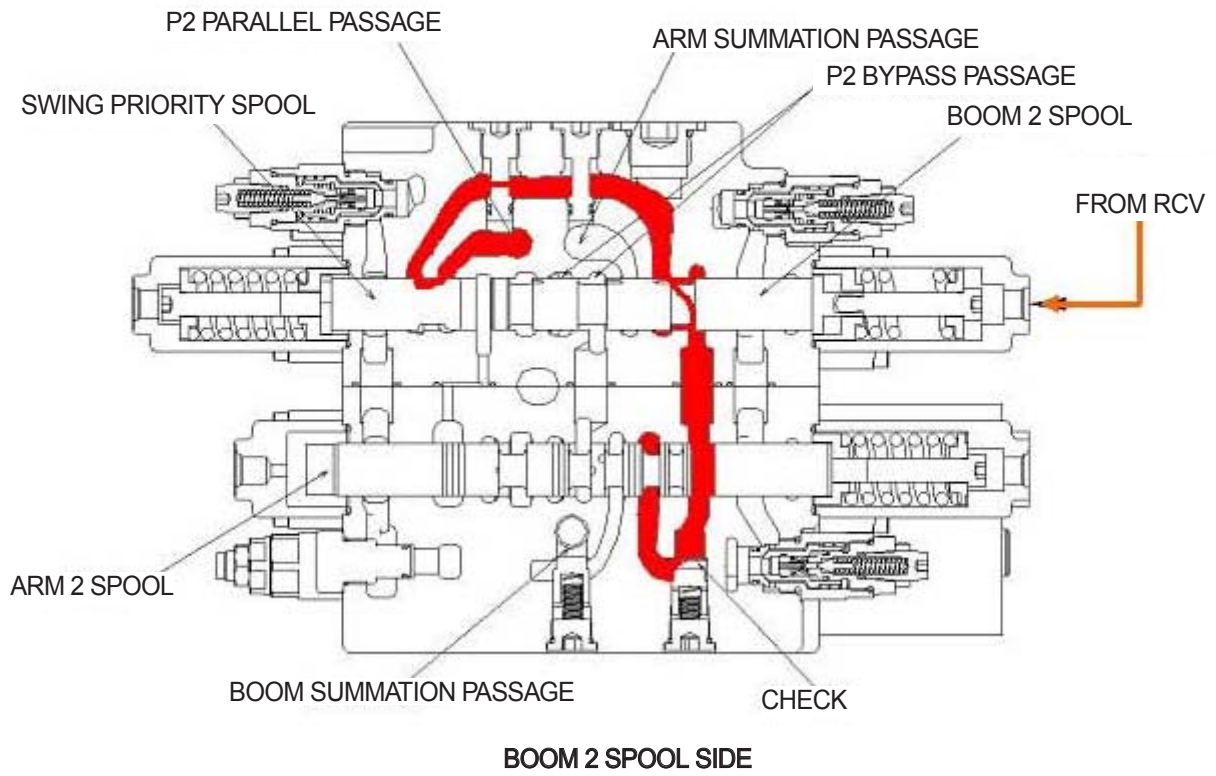
During boom up operation, the pilot secondary pressure from RCV is supplied to the port of the spring side and shifts the boom 1 spool in the left direction. The bypass passage is shut off by the movement of the spool and the hydraulic oil fluid from pump P1 is entered P1 parallel passage and then passes through the load check valve, bridge passage and boom holding valve then flows into the port A2.

Following this it flows into the head side of the boom cylinder.

(In this case, the boom holding valve is free flow condition)

At the same time, the pilot pressure from RCV is supplied to the port of the spring side of boom 2 and shifts the boom 2 spool. The bypass passage is shut off by the movement of the spool and the hydraulic oil fluid from pump P2 entered boom summation passage via the P2 parallel passage, the land of the swing priority spool, notch of the boom 2 spool, arm 2 spool and the check. The flows combine in passage and are directed to port A2 and head side of boom cylinder. At the same time, the flow from rod side of the boom cylinder return to the boom 1 spool through the port B2. There after it is directed to the hydraulic oil tank through the tank passage.





D21072MC10

(2) BOOM DOWN OPERATION

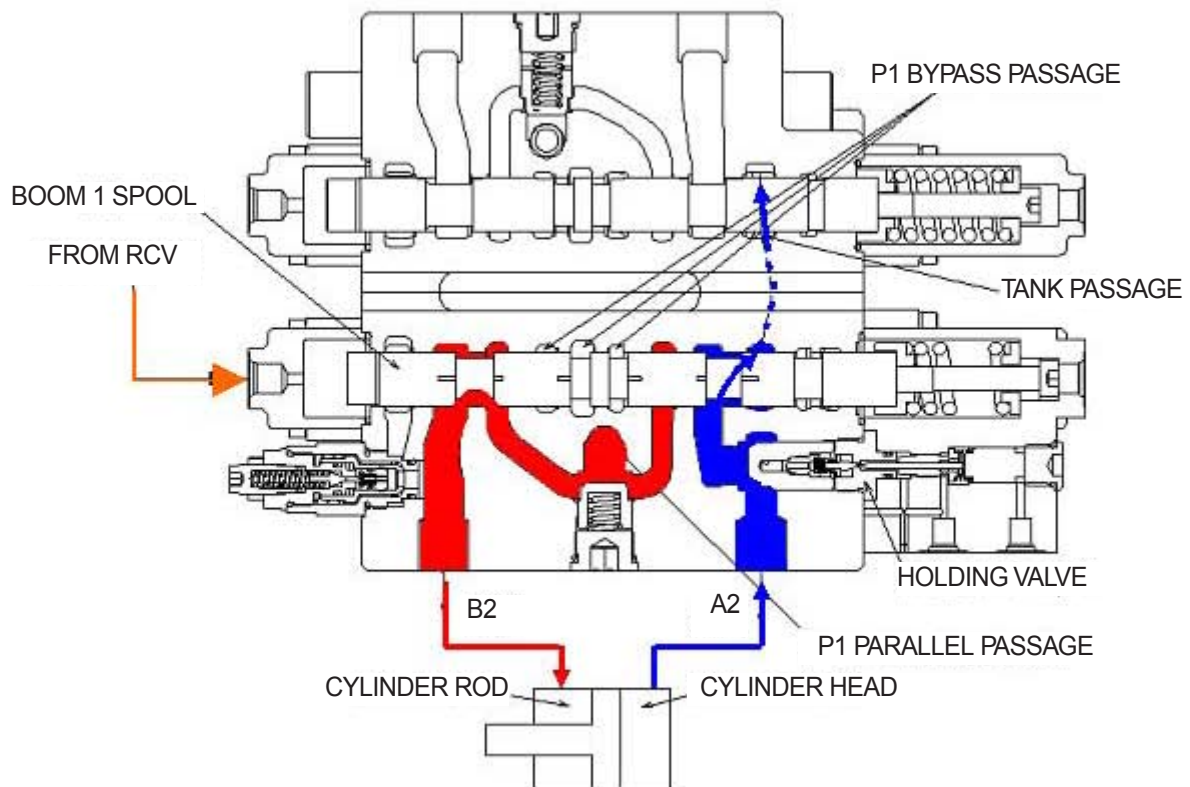
During the boom lowering operation, the pilot pressure from RCV is supplied to the port of the spring opposite side and shifts the boom 1 spool in the right direction.

The bypass passage is shut off by the movement of the spool and the hydraulic fluid from the pump P1 enters the parallel passage and is directed to the port B2 through the load check valve. Following this, it flows into the rod side of the boom cylinder.

At the same time, the return flow from the head side of the boom cylinder returns to the port A2 and boom holding valve. And it is directed to the hydraulic oil tank through opened tank passage by movement of the boom 1 spool.

In this case, the holding valve is open condition, for details of the boom holding valve, see page following page.

During the boom lowering operation, the fluid from P2 pump is not summation.



D21072MC11

4) HOLDING VALVE OPERATION

(1) HOLDING OPERATION

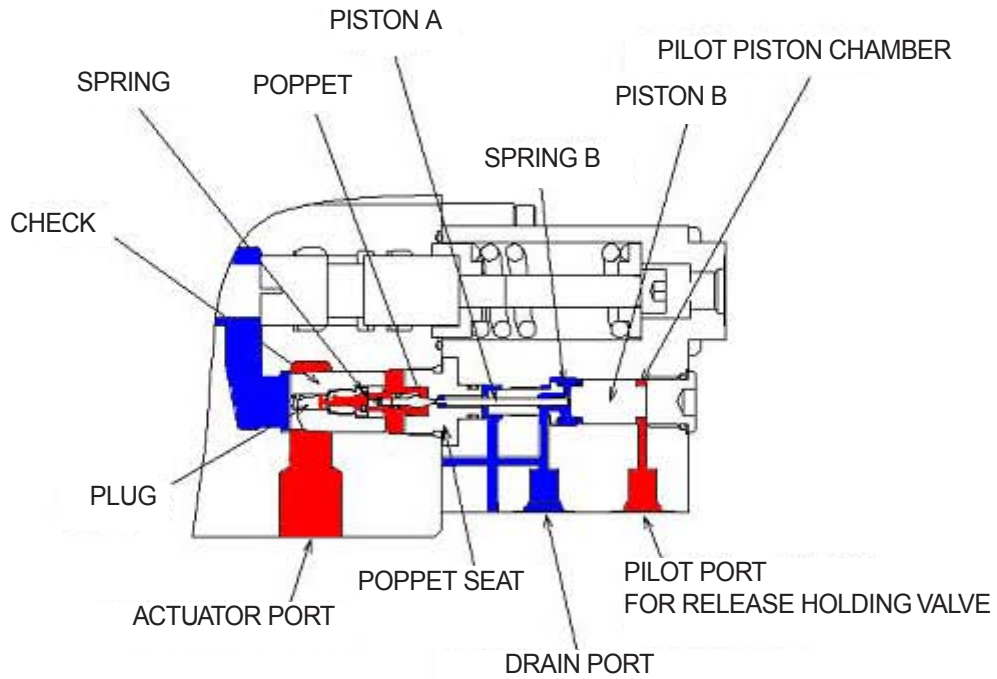
At neutral condition, the pilot piston chamber is connected to drain port through the pilot port.

And the piston "B" is supported with spring "B".

Also, the pressured fluid from actuator entered to inside of the holding valve through the periphery hole of check, crevice of the check and the plug and the periphery hole of plug.

Then, this pressured oil pushed the poppet to the poppet seat and the check to the seat of body.

So the hydraulic fluid from actuator is not escaped and the actuator is not moved.



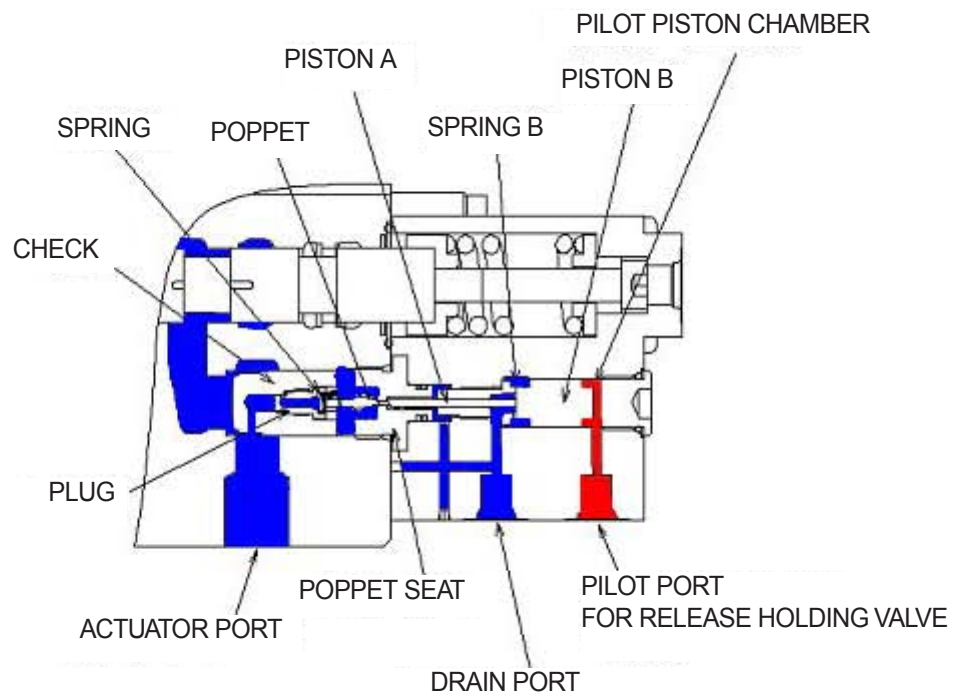
D21072MC12

(2) RELEASE HOLDING OPERATION

The pilot pressure is supplied to the pilot port for release holding valve and shifts the piston "B" in the left direction against the spring "B", and shifts the poppet in the left direction through piston "B" and piston "A" against spring "B" and shifts the spool in the left side.

At same time, the return fluid from actuator returns to the drain port through the periphery hole of check, crevice of the check and the plug, the periphery hole of the plug, in side of holding valve, crevice of the poppet and the poppet seat, the periphery hole of the poppet seat and internal passage of spool.

When the poppet is opened, pressure of inside of holding valve is decreased and the return fluid from actuator returns to the tank passage through the internal passage of spool.



D21072MC13

5) BUCKET OPERATION

(1) BUCKET IN OPERATION

① Bucket operation only

During the bucket in operation, the pilot secondary pressure from RCV is supplied to port of the spring side and shifts the bucket spool in the left direction.

The bypass passage is shut off by the movement of the spool and the hydraulic fluid from pump P1 entered P1 parallel passage and is directed to the port A5 through the check1.

At the same time, the hydraulic fluid from P1 bypass passage is directed to the port A5 through the check2.

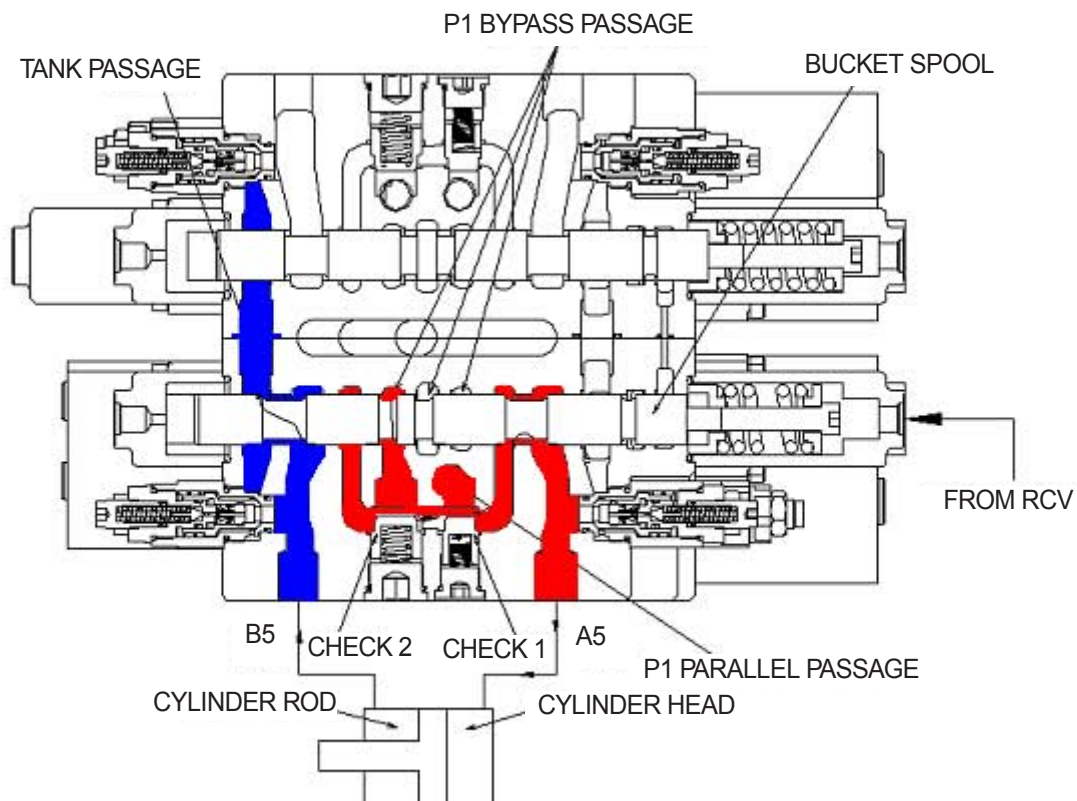
Following this it flows into the head side of the bucket cylinder.

The return flow from the rod side of the bucket cylinder returns to the bucket spool through the port B5. Thereafter it is directed to the hydraulic oil tank through the tank passage.

② Bucket operation with arm or boom operation

When combined operation, mostly same as above but the fluid from bypass passage is empty.

So only the fluid from parallel passage is supplied to the bucket cylinder. Also, parallel passage is installed the orifice for supplying the fluid from pump to the boom or the arm operation prior to the bucket operation.



D21072MC14

(2) BUCKET OUT OPERATION

① Bucket operation only

During the bucket out operation, the pilot secondary pressure from RCV is supplied to port of the spring opposite side and shifts the bucket spool in the left direction.

The bypass passage is shut off by the movement of the spool and the hydraulic fluid from pump P1 entered P1 parallel passage and is directed to the port B5 through the check1.

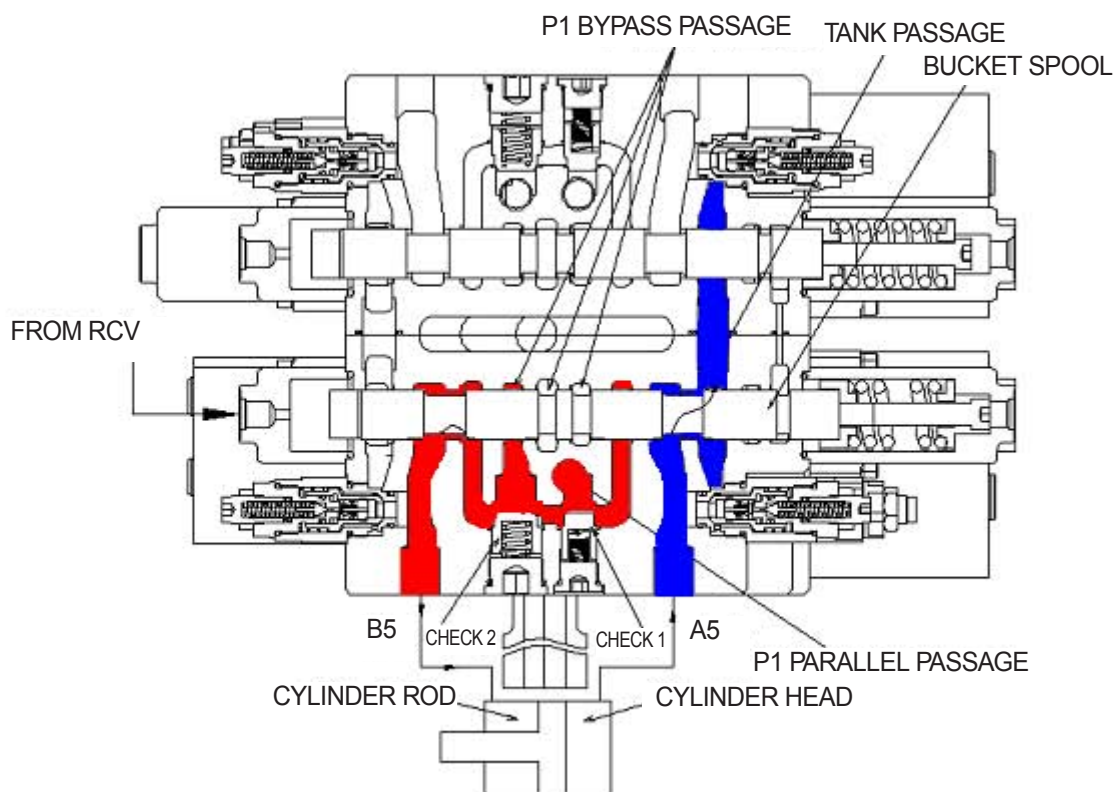
At the same time the hydraulic fluid from bypass passage is directed to the port B5 through the check 2.

The return flow from the rod side of the bucket cylinder returns to the hydraulic oil tank through the tank passage and the port A5.

② Bucket operation with arm or boom operation

When combined operation, mostly same as above but the fluid from bypass passage is empty.

So only the fluid from parallel passage is supplied to the bucket cylinder. Also, parallel passage is installed the orifice for supplying the fluid from pump to the boom or the arm operation prior to the bucket operation.



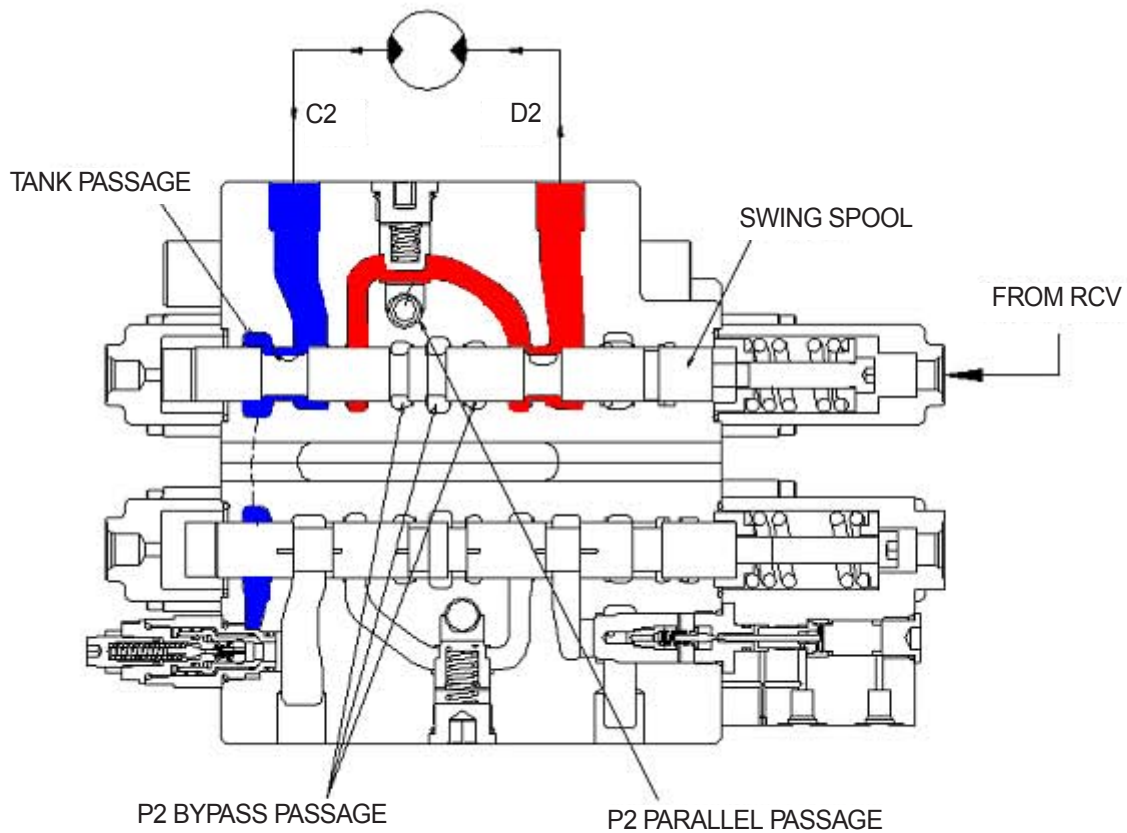
D21072MC15

6) SWING OPERATION

(1) SWING LEFT OPERATION

During the swing left operation, the pilot secondary pressure from the RCV is supplied to the port of the spring side and shift the swing spool in left direction. The bypass passage is shut off by the movement of the spool and the hydraulic fluid from pump P2 flows into swing spool through the parallel passage. Then it is directed to swing motor through the port D2.

As the result, swing motor turns and flow from the swing motor returns to the hydraulic oil tank through the port C2, swing spool and the tank passage.

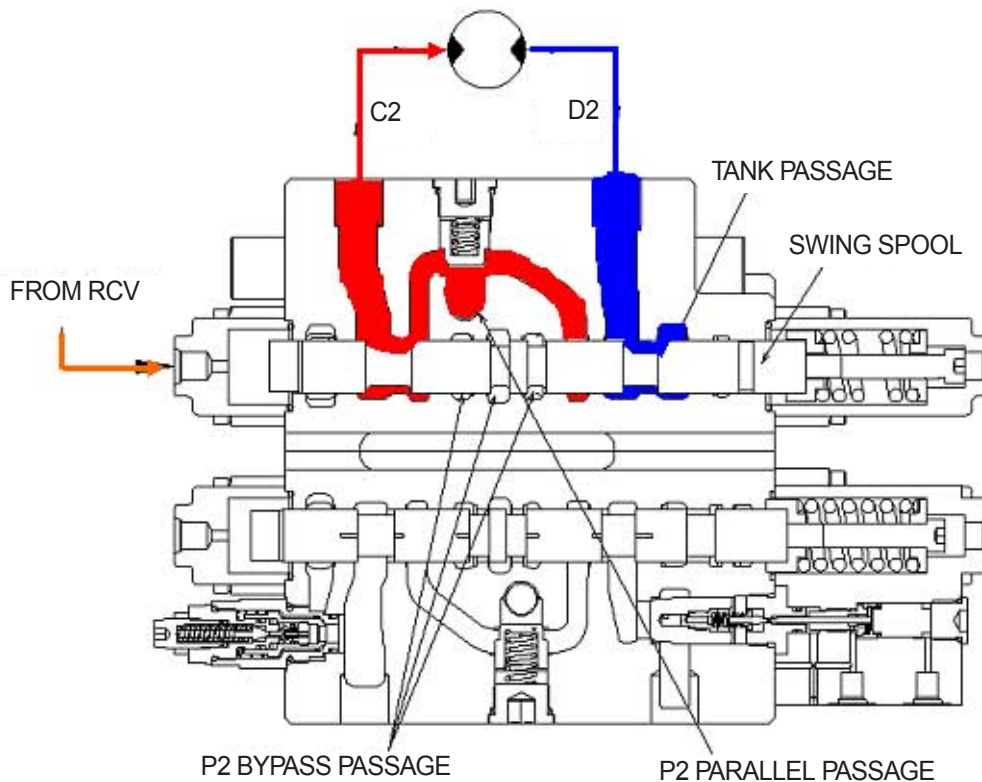


D21072MC16

(2) SWING RIGHT OPERATION

During the swing right operation, the pilot secondary pressure from the RCV is supplied to the port of the spring side and shift the swing spool in left direction. The bypass passage is shut off by the movement of the spool and the hydraulic fluid from pump P2 flows into swing spool through the parallel passage. Then it is directed to swing motor through the port C2.

As the result, swing motor turns and flow from the swing motor returns to the hydraulic oil tank through the port B2, swing spool and the tank passage.



D21072MC17

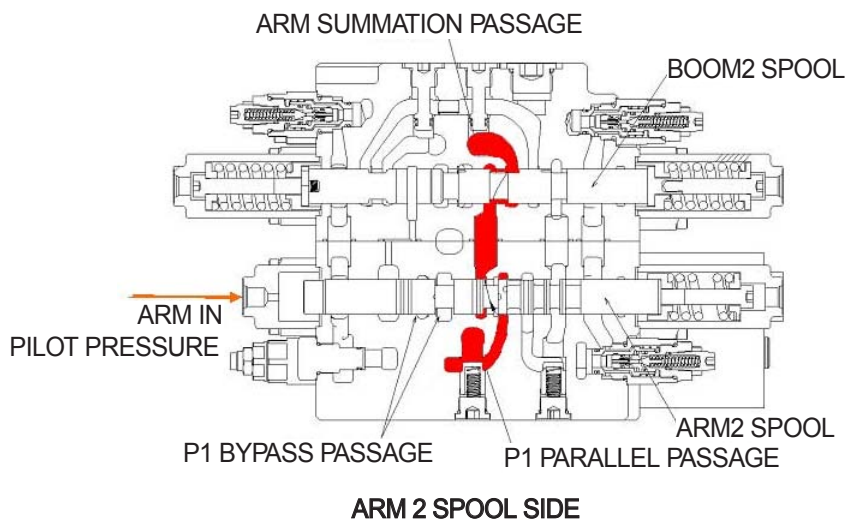
7) ARM OPERATION

(1) ARM IN OPERATION

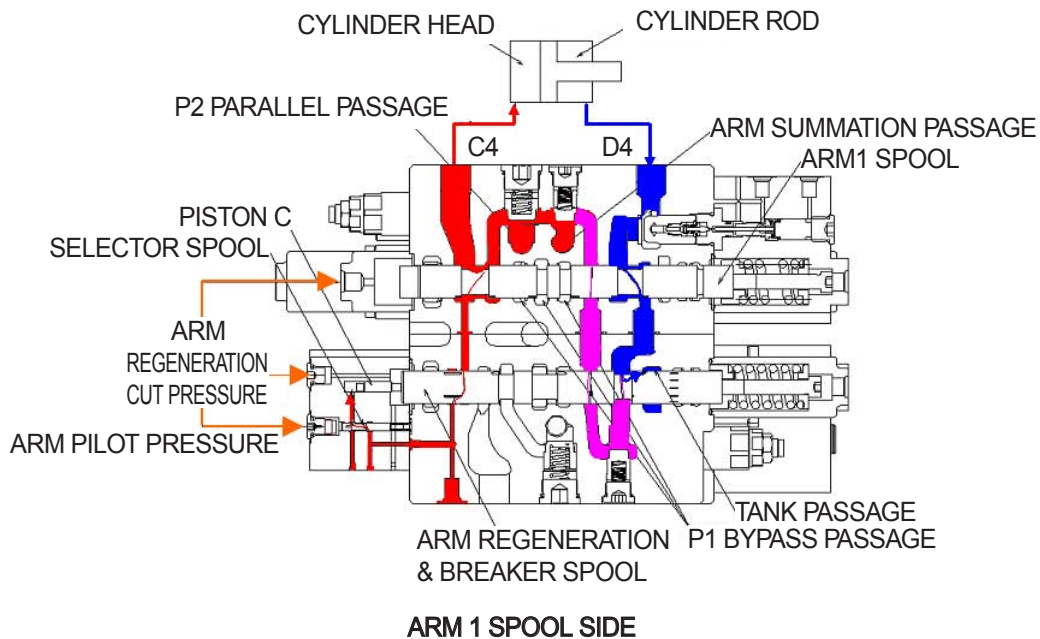
During arm in operation, the pilot secondary pressure from the RCV is supplied to the port of spring opposite side and shifts arm 1 spool in the right direction.

The bypass passage is shut off by the movement of the arm 1 spool and the hydraulic oil from the pump P2 flows into the arm cylinder head side through P2 parallel passage, the load check valve, bridge passage and the port C4.

At same time, the pilot secondary pressure from the RCV is supplied to the port of spring opposite side and shifts arm 2 spool in the right direction. The bypass passage is shut off by the movement of the spool and the hydraulic fluid from the pump P1 flows into the arm summation passage through parallel passage, the check valve, the arm 2 spool and the boom 2 spool. Then it entered the arm cylinder head side with hydraulic fluid from arm 1 spool.



D21072MC19



D21072MC18

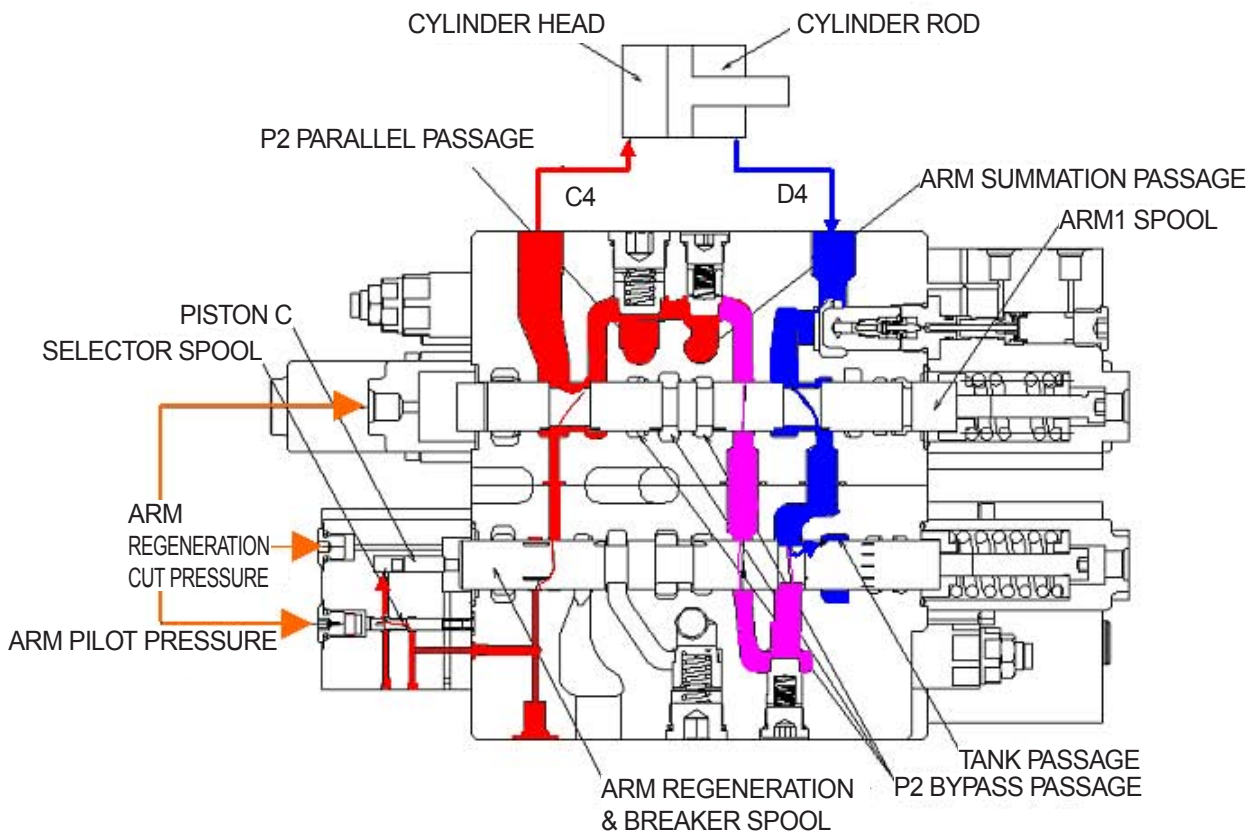
ARM REGENERATION

The return flow from the arm cylinder rod side is pressurized by self weight of arm and so, returns to port D4. The pressurized oil returning to port D4 enters the arm regeneration spool through the arm holding valve and the arm 1 spool. It is supplied the arm cylinder head through internal passage. This is called the arm regeneration function.

The amount of regeneration fluid is changed by movement of the arm regeneration spool. A few fluids after P2 parallel passage is push piston "C" through the notch of arm regeneration spool and selector spool. At this time, the selector spool is opened by pilot pressure from RCV.

Then, the arm regeneration spool shifts to right side and flow to tank pass increases and regeneration flow decreases. Therefore, pressure of arm cylinder head increases, then, arm regeneration flow decreases.

Furthermore, the arm regeneration cut pressure is supplied to the port of spring opposite side and arm regeneration spool is move into the right direction fully. The flow from the arm cylinder rod is returned to the hydraulic oil tank and regeneration function is not activated. (The return fluid is maximum condition)



D21072MC18

(2) ARM OUT OPERATION

During arm out operation, the pilot secondary pressure from RCV is supplied to the port of spring side and shifts arm 1 spool in the left direction.

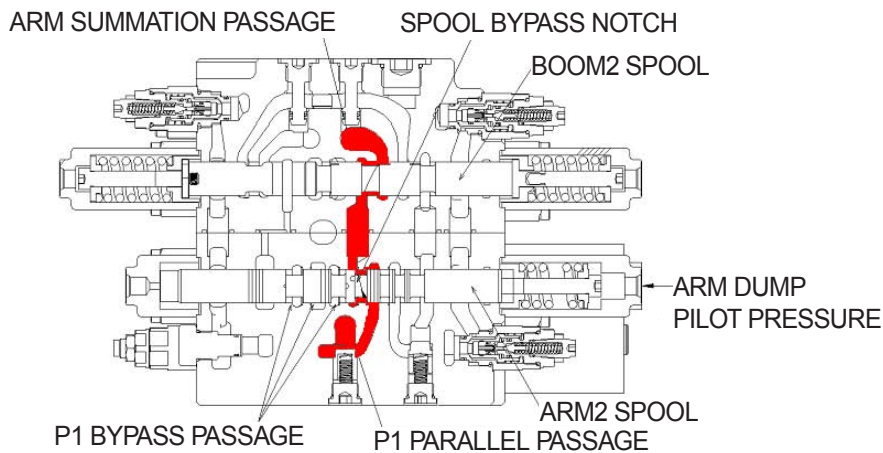
The bypass passage is shut off by the movement of the spool and the hydraulic fluid from pump P2 flows into arm 1 spool through the parallel passage. Then it enters into the arm cylinder rod side through the load check valve, bridge passage, arm holding valve and the port D4.

Also, the pilot secondary pressure from RCV is supplied to the port of spring side and shifts arm 2 spool in the left direction.

The bypass passage is shut off by the movement of the spool and some of the hydraulic fluid from pump P2 bypassed through bypass notch. The rest of hydraulic fluid from pump P2 flows into the arm summation passage through P1 parallel passage the check valve arm 2 spool and boom 2 spool.

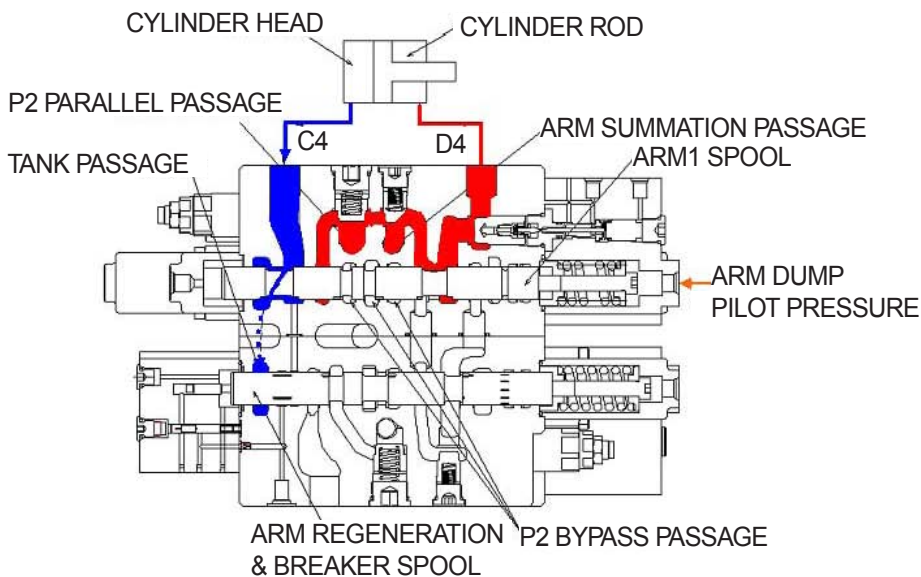
Then it enters into the arm cylinder rod side with the fluid from the arm 1 spool.

The return flow from the arm cylinder head side returns to the hydraulic tank through the port C4 the arm 1 spool and tank passage.



ARM 2 SPOOL SIDE

D21072MC21



ARM 1 SPOOL SIDE

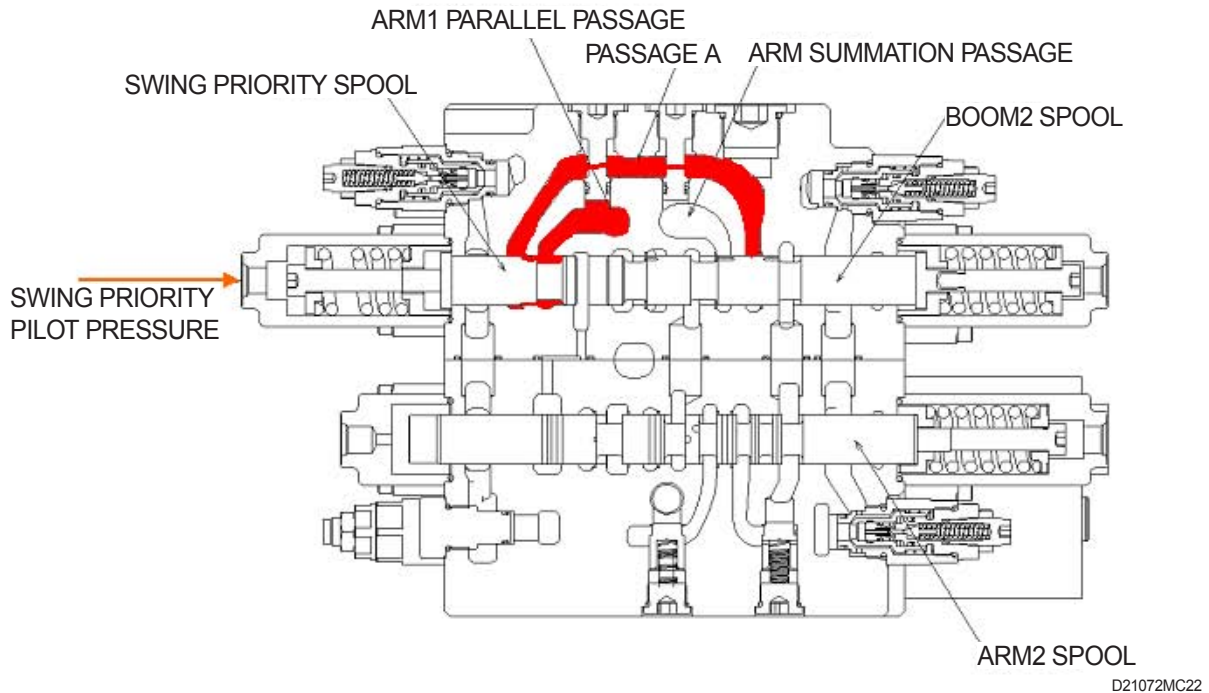
D21072MC20

8) SWING PRIORITY FUNCTION

During swing priority operation, the pilot secondary pressure is supplied to the port of the spring side of the swing priority spool and shift swing priority spool in the right direction.

The hydraulic fluid from P2 parallel passage flows into the parallel passage of arm 1 side through swing priority spool and the passage "A" and also flows into the boom 2 spool.

When the swing priority spool is neutral condition, the passage is same as normal condition. But due to shifting of the swing priority spool, the fluid from pump P2 flows to swing side more then the boom 2, arm 1, option B and bucket summation spools to make the swing operation most preferential.



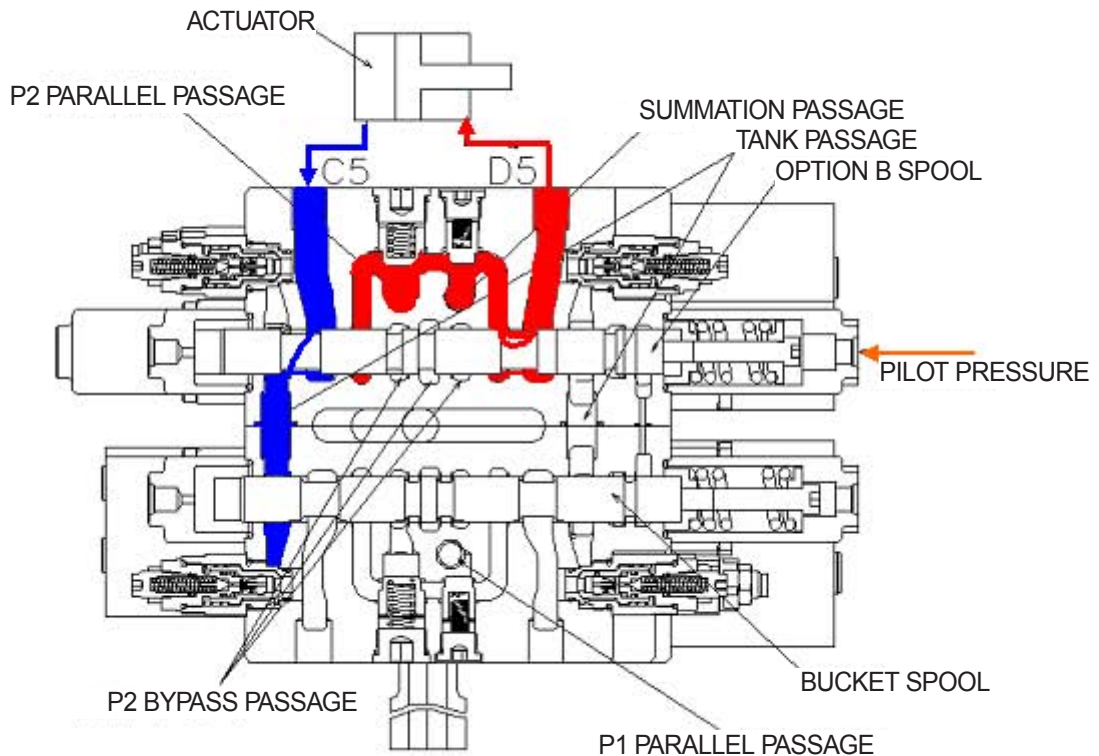
9) OPTION B OPERATION

The pilot secondary pressure from RCV is supplied to the port of spring side and shifts option spool as the figure.

The bypass passage is shut off by the movement of the spool and the hydraulic fluid from pump P2 flows into actuator through the load check valve, bridge passage and port D5.

At the same time, the fluid from actuator returns to the tank passage through port C5 and notch of the option spool.

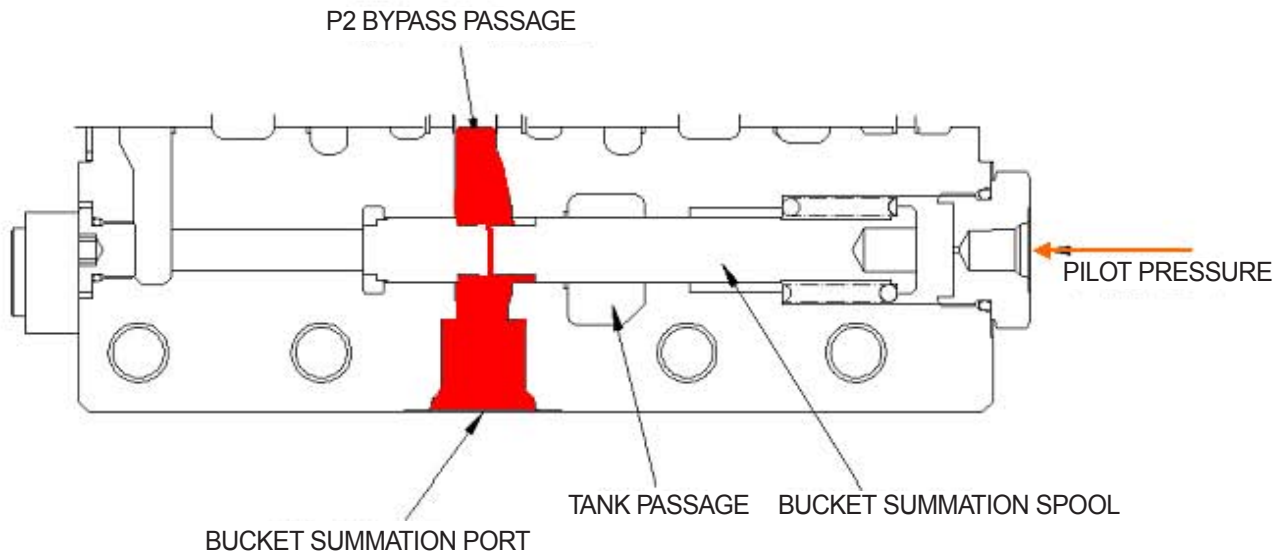
In case of reverse operation, the operating principle is same as above.



D21072MC24

10) BUCKET SUMMATION OPERATION

During bucket single operation, the bucket pilot pressure from RCV is supplied to the port of the spring side of the bucket summation spool and shift the spool in the left direction. As the spool moves, return line will be blocked and bypass pressure will open the check valve CK1 and join the parallel flow of the bucket from the P1 pump.



D21072MC25

11) NEGATIVE RELIEF VALVE OPERATION

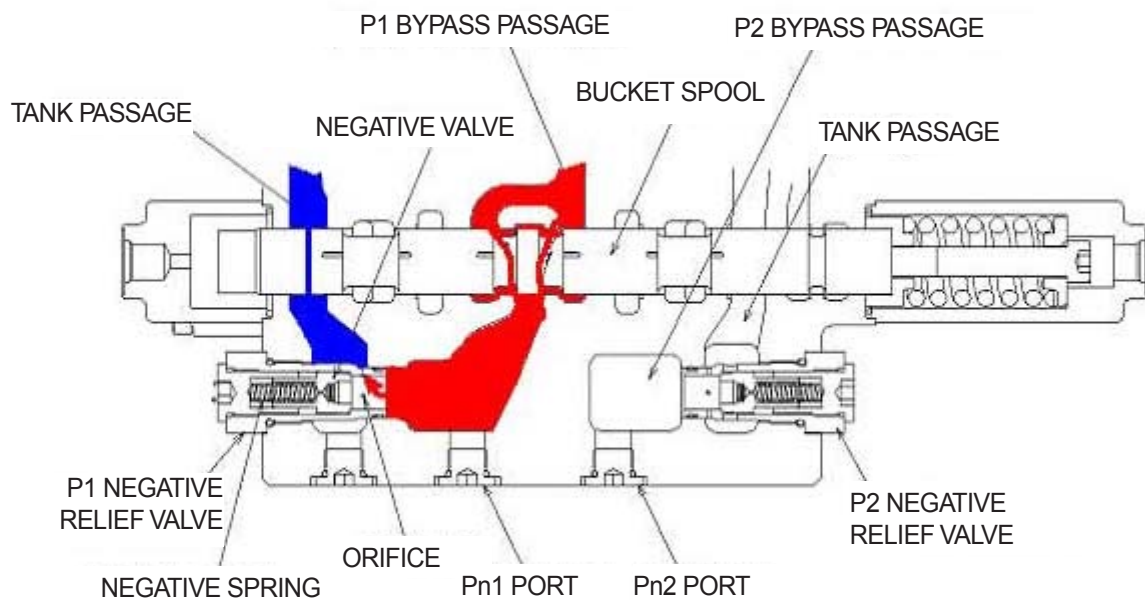
When no function is being actuated on P1 side, the hydraulic fluid from the pump P1, flows into the tank passage through the bypass passage and orifice. The restriction caused by this orifice thereby pressurizes. This pressure is transferred as the negative control signal pressure Pn1 to the pump P1 regulator.

It controls the pump regulator so as to minimize the discharge of the pump P1.

The bypass passage is shut off when the shifting of one or more spools and the flow through bypass passage became zero. The pressure of negative control signal becomes zero and the discharge of the pump P1 becomes maximum.

The negative control pressure reaches to the set level, the hydraulic fluid in the passage pushes open negative control valve and escapes into the return passage.

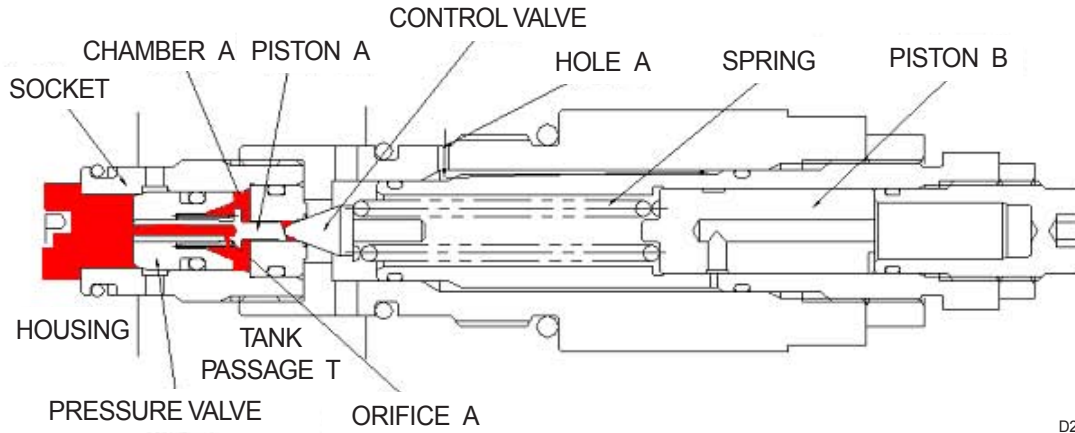
For the pump P2 the same negative control principle.



D21072MC26

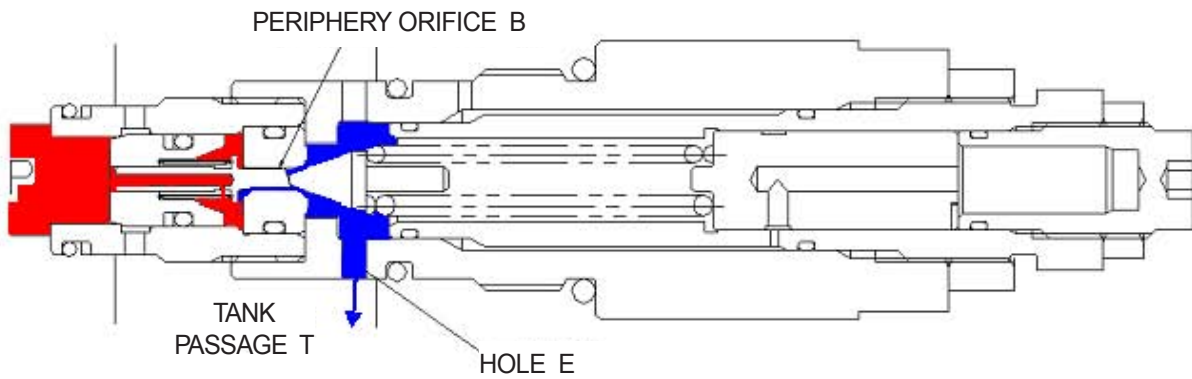
12) OPERATION OF MAIN RELIEF VALVE

- (1) The pressurized oil passes through the orifice (A) of the plunger is filled up in chamber A of the inside space, and seats the plunger against the housing securely.



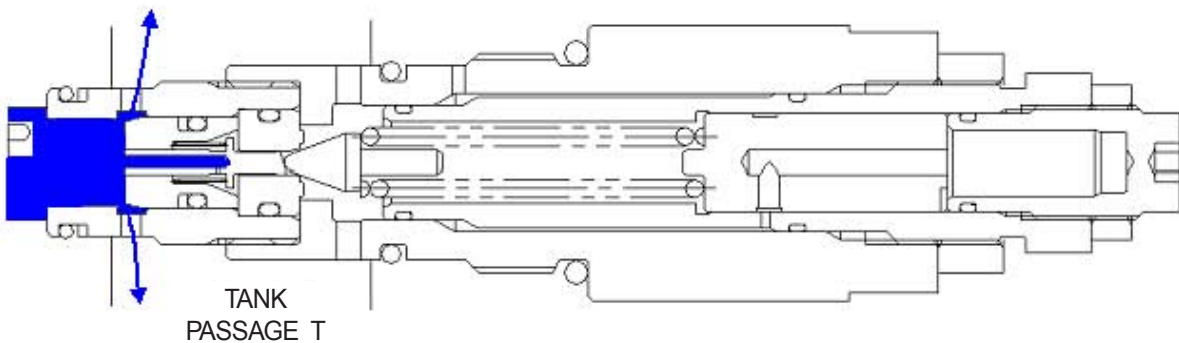
D21072MC27

- (2) When the pressure at (P) becomes equal to the set pressure of the spring the hydraulic oil passes through the piston (A) pushes open the poppet and flows to tank passage (T) through the plunger internal passage, periphery orifice A, chamber A, periphery orifice B and the hole (E).



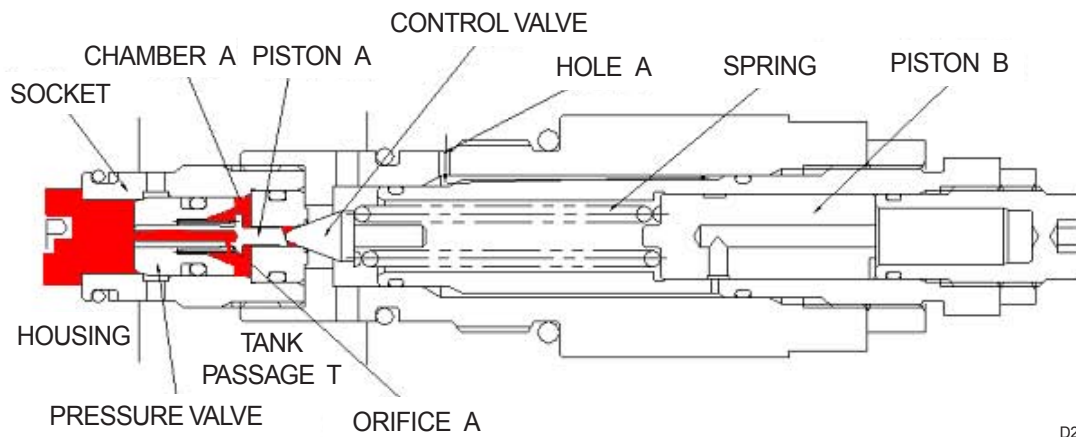
D21072MC28

- (3) Opening the poppet causes the pressure in chamber A to fall and the plunger to open. As the result the pressurized oil at port P runs into tank passage (T).



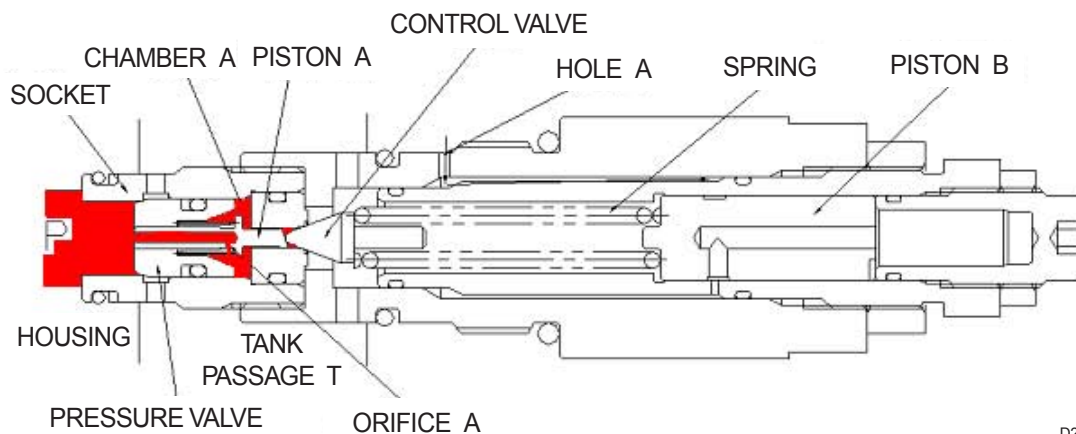
D21072MC29

- (4) The pressure at port P becomes lower than set pressure of the spring, the poppet is seated by spring force. Then the pressure at port P becomes equal to set pressure of the spring and the plunger is seated to the socket.



D21072MC27

- (5) When the power boost switch is ON, the pilot pressure enters through hole A. It pushes the piston (B) in the left direction to increase the force of the spring and change the relief set pressure to the high pressure.

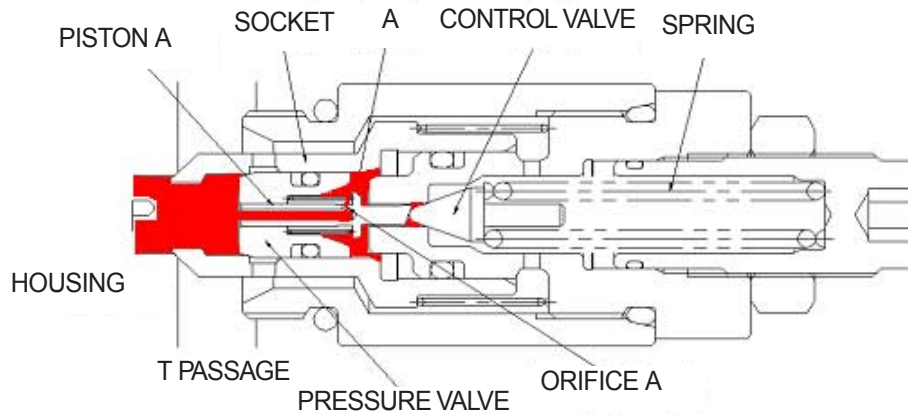


D21072MC27

13) OPERATION OF OVERLOAD RELIEF VALVE

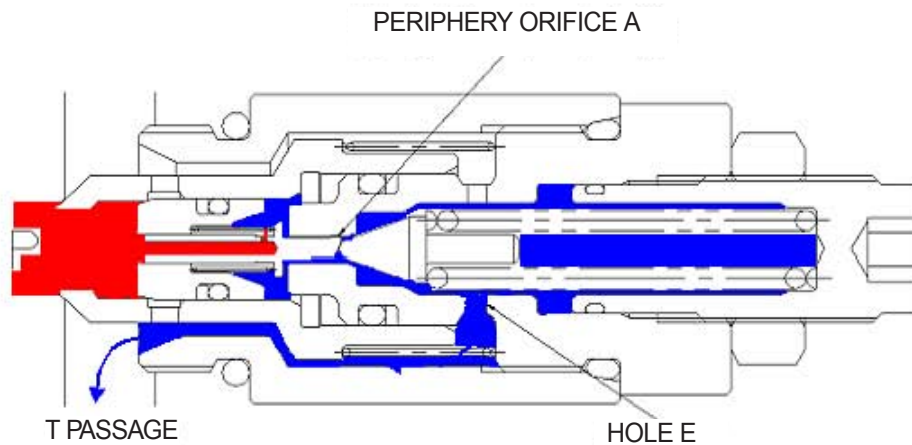
FUNCTION AS RELIEF VALVE

- (1) The pressurized oil passes through the piston and orifice A is filled up in chamber A of the inside space and seat the plunger against the socket and the socket against the housing securely.



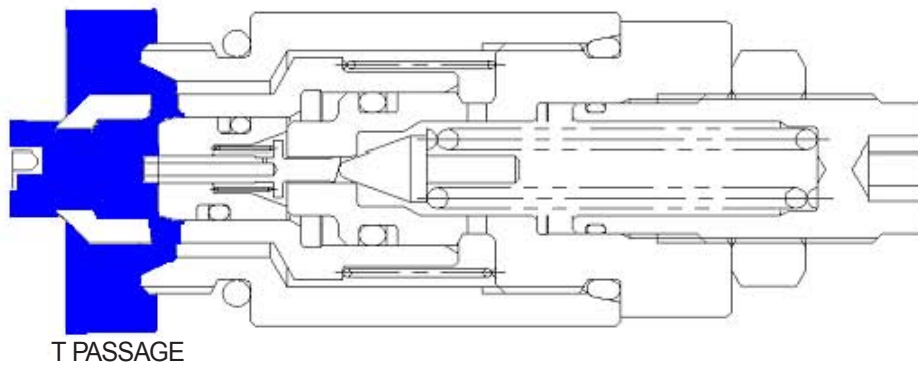
D21072MC30

- (2) When the pressure at port P becomes equal to the set pressure of the spring, the pressurized oil pushes open the poppet and flows to tank passage (T) through the plunger internal passage, orifice A, chamber A, periphery orifice B and hole E.



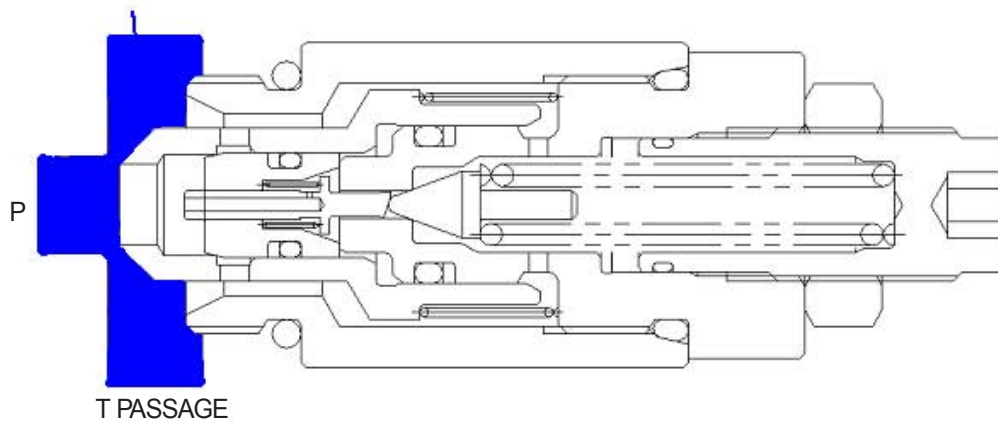
D21072MC31

- (3) Opening of the poppet causes the pressure in chamber A to fall and the plunger to open. As the result the pressurized oil at port P runs into tank passage (T).



D21072MC32

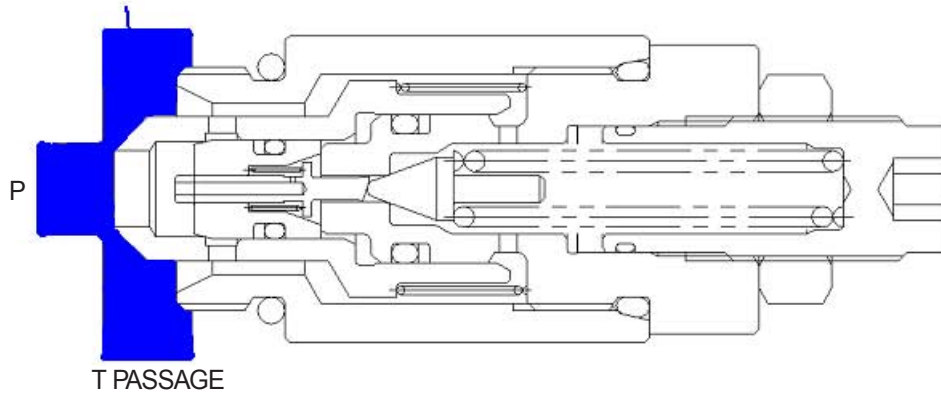
- (4) The pressure at port P becomes lower than set pressure of the spring, the poppet is seated by spring force. Then the pressure at port P becomes equal to set pressure of the spring and the plunger is seated to the socket.



D21072MC33

MAKE-UP FUNCTION

- (5) When negative pressure exists at port P, the oil is supplied through tank passage (T). When the pressure at tank passage (T) becomes higher than that of at port P, the socket moves in the right direction. Then, sufficient oil passes around the socket from tank passage (T) to port P and fills up the space.



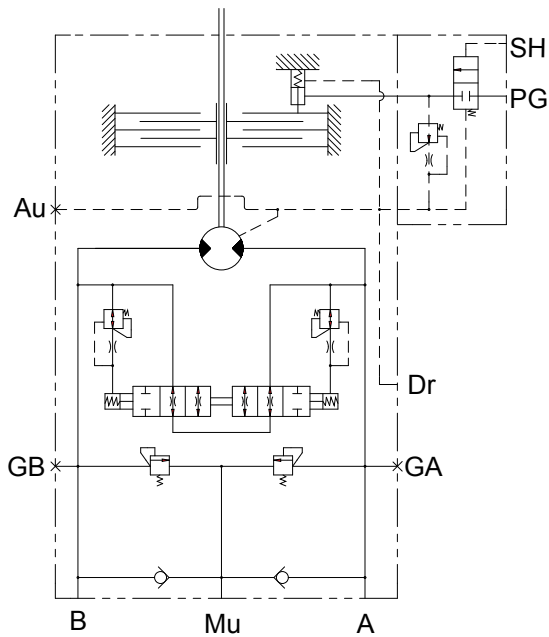
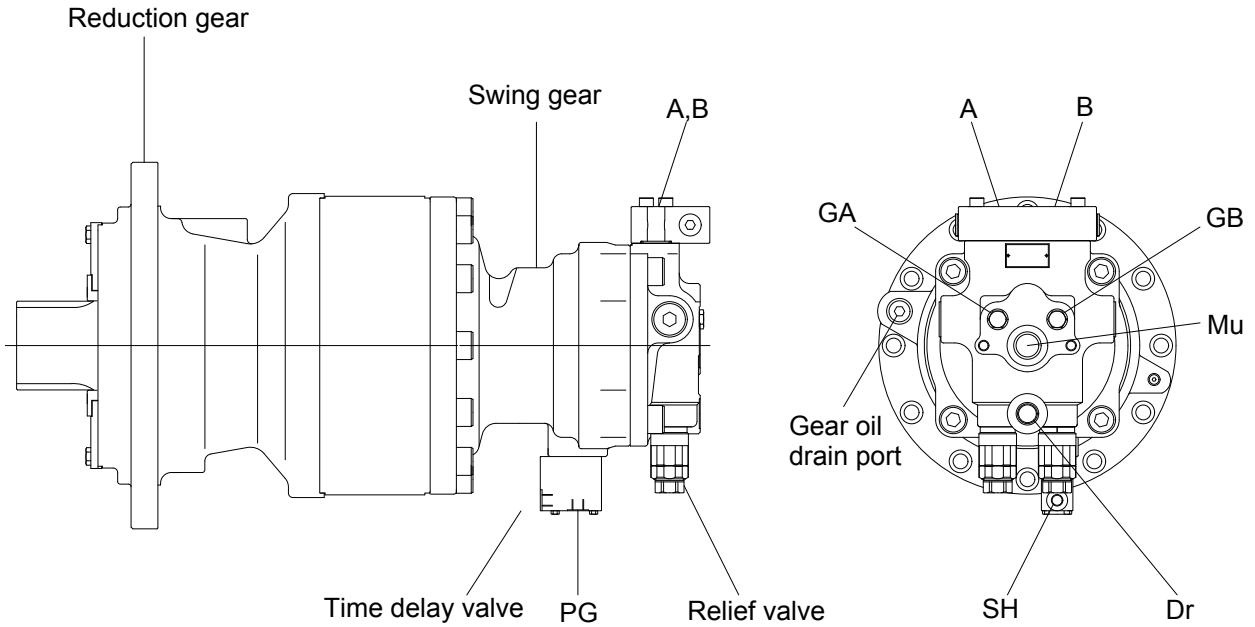
D21072MC33

GROUP 3 SWING DEVICE

1. STRUCTURE

Swing device consists swing motor, swing reduction gear.

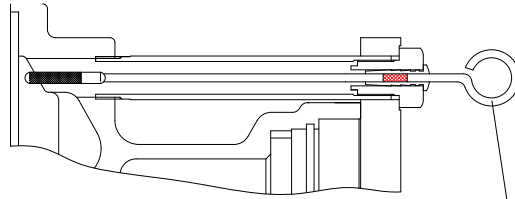
Swing motor include mechanical parking valve, relief valve, make up valve and time delay valve.



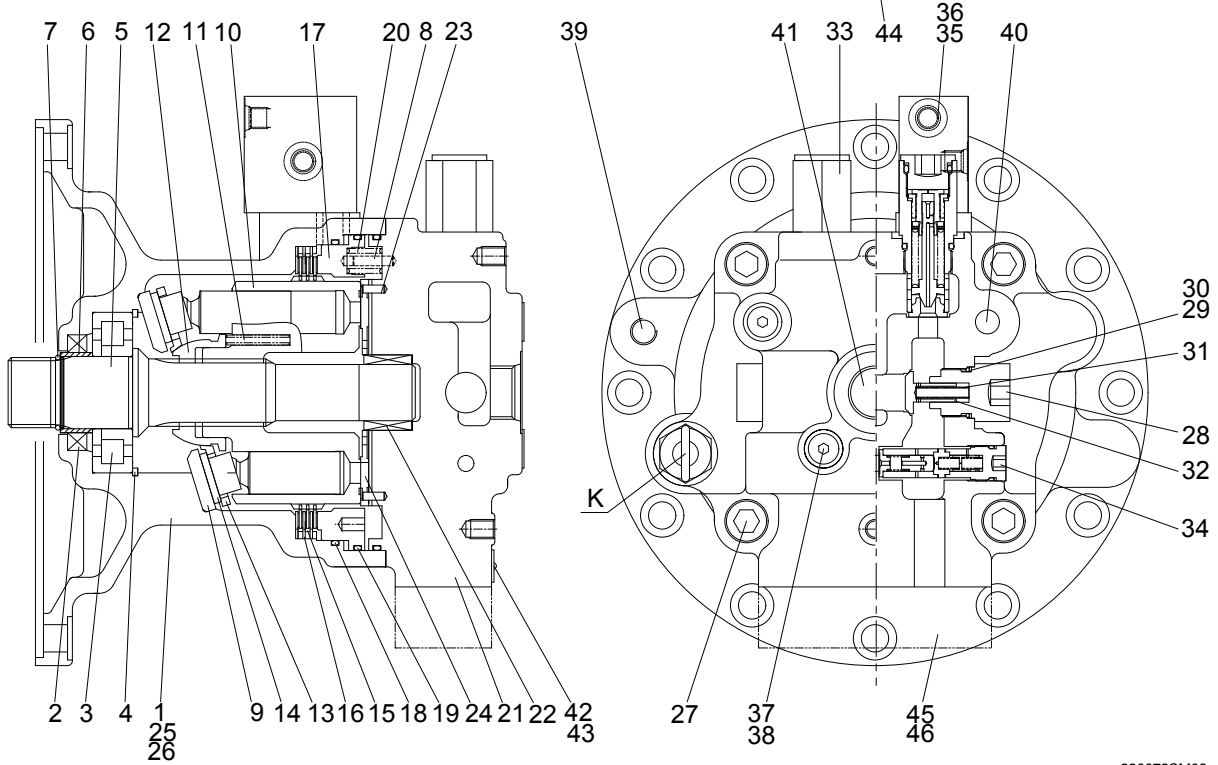
Port	Port name	Port size
A	Main port	ø 20
B	Main port	ø 20
Dr	Drain port	PF 1/2
Mu	Make up port	PF 1
PG	Brake release port	PF 1/4
SH	Stand by port	PF 1/4
GA, GB	Gage port	PF 1/4
Au	Air vent port	PF 1/4

22007SF03A(1)

1) SWING MOTOR



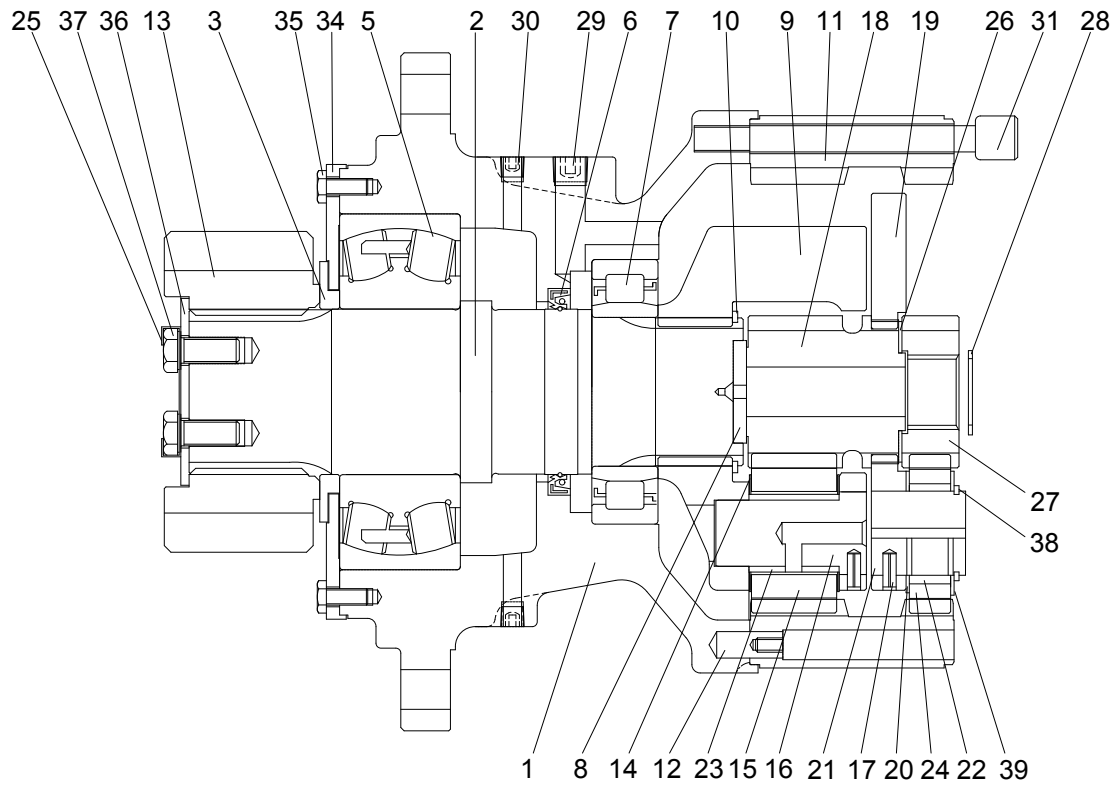
DETAIL : K



220072SM02

- | | | | | | |
|----|----------------|----|----------------------|----|------------------|
| 1 | Body | 18 | O-ring | 35 | Time delay valve |
| 2 | Oil seal | 19 | O-ring | 36 | Wrench bolt |
| 3 | Roller bearing | 20 | Spring | 37 | Plug |
| 4 | Snap ring | 21 | Rear cover | 38 | O-ring |
| 5 | Shaft | 22 | Needle bearing | 39 | Plug |
| 6 | Bushing | 23 | Pin | 40 | Plug |
| 7 | Stop ring | 24 | Valve plate | 41 | Plug |
| 8 | Pin | 25 | O-ring | 42 | Name plate |
| 9 | Shoe plate | 26 | O-ring | 43 | Rivet |
| 10 | Cylinder block | 27 | Wrench bolt | 44 | Level gauge |
| 11 | Spring | 28 | Plug | 45 | Flange |
| 12 | Ball guide | 29 | Back up ring | 46 | O-ring |
| 13 | Set plate | 30 | O-ring | 47 | Plug |
| 14 | Piston assy | 31 | Spring | 48 | O-ring |
| 15 | Friction plate | 32 | Check | 49 | O-ring |
| 16 | Plate | 33 | Relief valve | 50 | Back up ring |
| 17 | Brake piston | 34 | Anti-inversion valve | | |

2) REDUCTION GEAR



220072SF05A

1	Casing	14	Thrust washer	26	Side plate 3
2	Drive shaft	15	Planet gear 2	27	Sun gear 1
3	Spacer	16	Pin 2	28	Stop ring
5	Roller bearing	17	Spring pin	29	Plug
6	Oil seal	18	Sun gear 2	30	Plug
7	Roller bearing	19	Carrier 1	31	Socket bolt
8	Thrust plate	20	Side plate 1	34	Cover plate
9	Carrier 2	21	Pin 1	35	Hexagon bolt
10	Stop ring	22	Needle cage	36	Lock plate
11	Ring gear	23	Bush 2	37	Hexagon bolt
12	Knock pin	24	Planet gear 1	38	Stop ring
13	Pinion gear	25	Lock washer	39	Side plate 2

2. PRINCIPLE OF DRIVING

2.1 Generating the turning force

The high hydraulic supplied from a hydraulic pump flows into a cylinder(10) through valve casing of motor(21), and valve plate(24).

The high hydraulic is built as flowing on one side of Y-Y line connected by the upper and lower sides of piston(14).

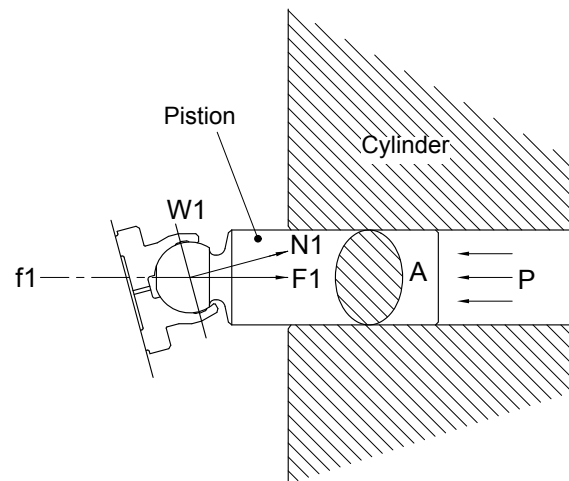
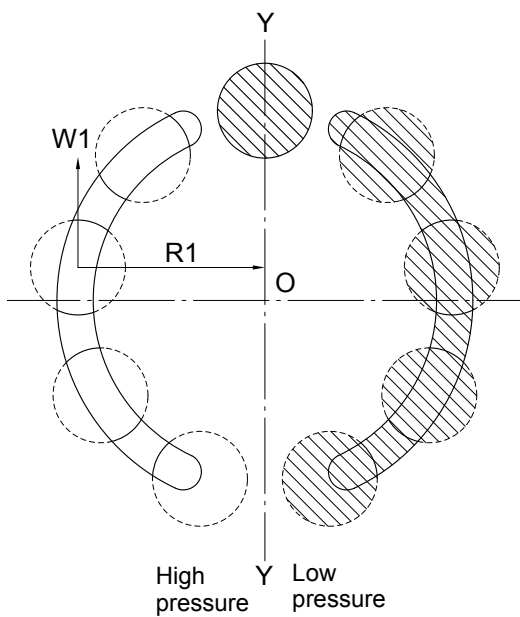
The high hydraulic can generate the force, $F1=P \times A$ (P : supplied pressure, A : water pressure area), like following pictures, working on a piston.

This force, $F1$, is divided as $N1$ thrust partial pressure and $W1$ radial partial pressure, in case of the plate of a tilt angle, α .

$W1$ generates torque, $T=W1 \times R1$, for Y-Y line connected by the upper and lower sides of the piston as following pictures.

The sum of torque ($\Sigma W1 \times R1$), generated from each piston(4~5 pieces) on the side of a high hydraulic, generates the turning force.

This torque transfers the turning force to a cylinder(10) through a piston; because a cylinder is combined with a turning axis and spline, a turning axis rotates and a turning force is sent.



21078TM05

2.2 Working of relief valve

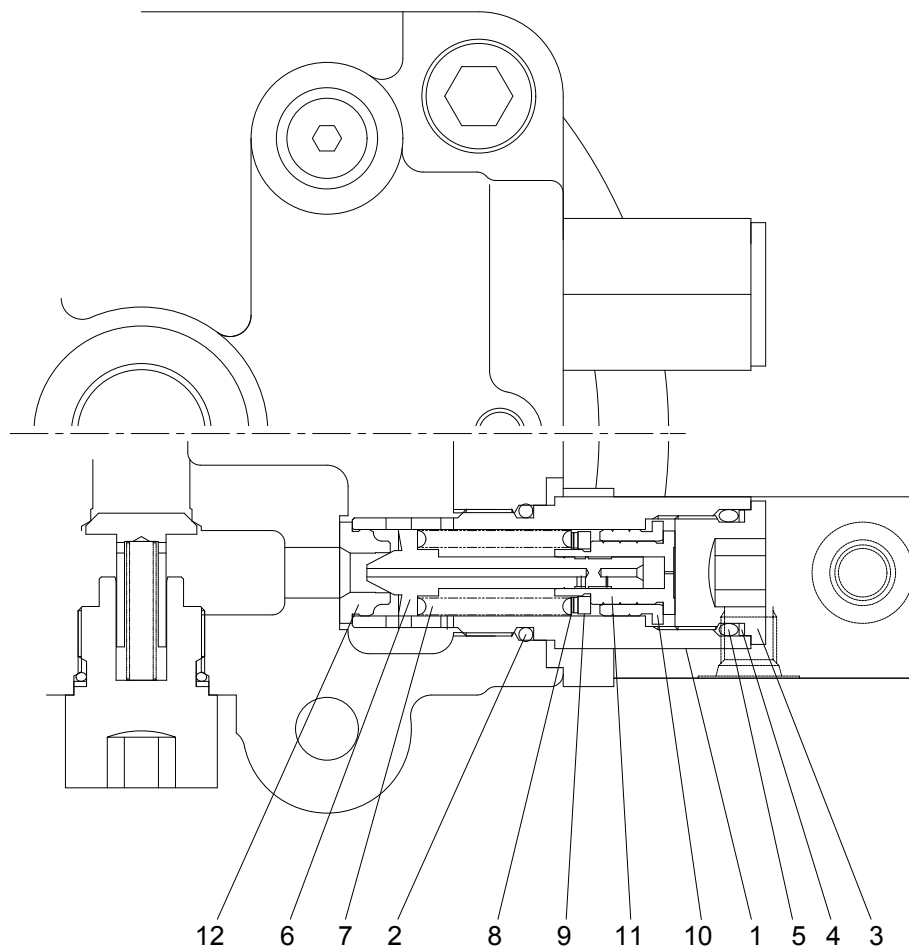
Relief valve carries on two functions of followings

- 1) It standardizes a pressure in case of driving a hydraulic motor; bypasses an extra oil in a motor inlet related to acceleration of an inertia to an outlet.
- 2) In case of an inertia stopped, it forces an equipment stopped, according to generating the pressure of a brake on the projected side.

Once high pressure oil supplied to P port, the inside pressure of shock less spool increases.

If the pressure is stronger than the power of the spring, it will be standardized.

In case of driving a hydraulic motor, it standardizes a pressure. And in the event of stopping an inertia, it forces an equipment stopped, according to generating the pressure of break on the projected side.



220072SM10

2.3 Working of parking brake

1) Parking brake OFF

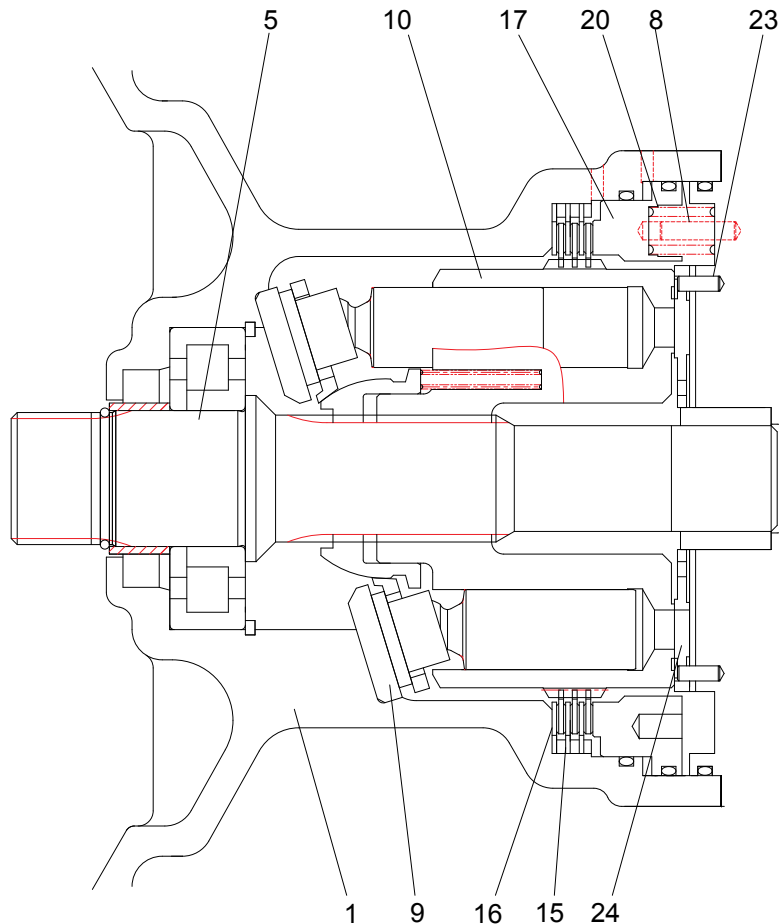
If swing control level sets the swing position, pilot oil will moves swing spool and also it will be supplied to SH port of time delay valve of swing motor through shuttle valve against the power of the spring. The pressure of the spring switches spool to left and moves awaiting PG port oil of delay valve to parking position. After then it moves up parking piston pressing frictional plate to release parking brake.

2) Parking brake ON

If swing control level sets neutrality, swing pilot supplied to SH port of time delay valve through shuttle valve will be stopped.

According to this process, spool is returned by the power of the spring and the pressure of PG port of time delay valve which is always standing by release valve is stopped to parking piston.

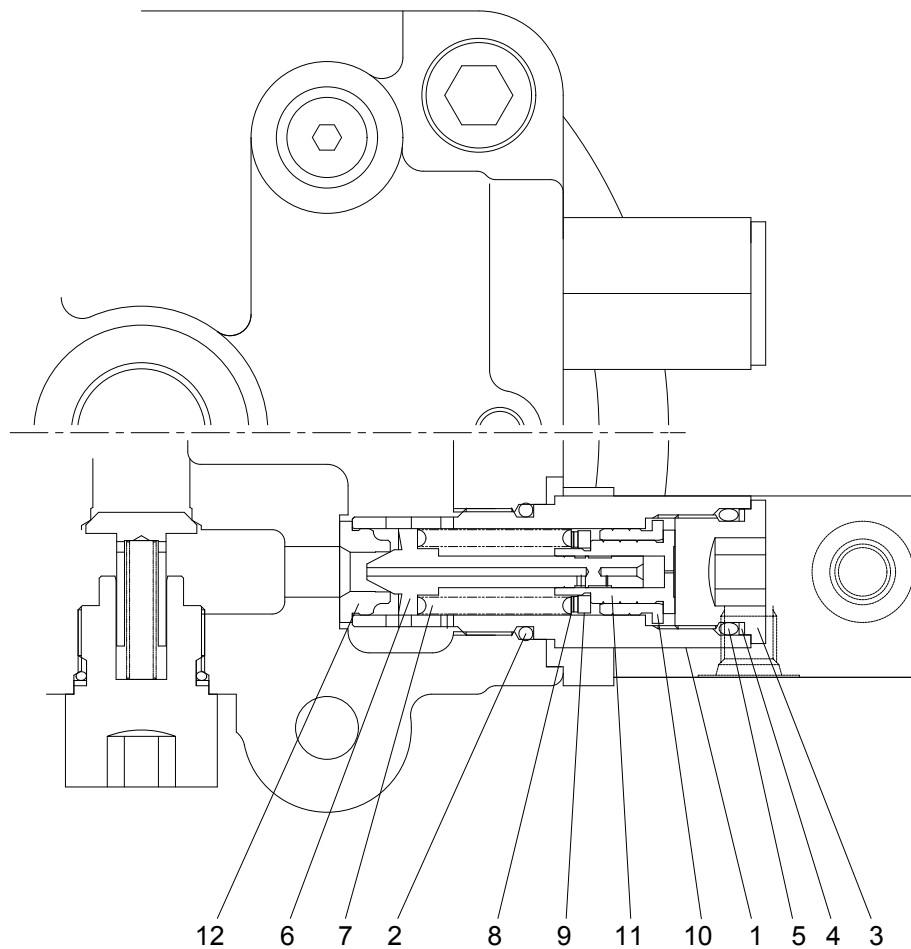
In that time, orifice in spool stops leaking out working oil to create 6 second time delay in order to prevent the impact which may be happened at the moment of sudden stop of swing brake.



2.4 Make up check valve

In case of rapid rotation which is faster than the amount of supplied oil to swing motor entrance, mounted make up check valve supplies working oil to prevent cavitation according to the shortage of supplying oil.

In the event of sudden stop of the operating excavator, supplying working oil to entrance of swing motor is stopped. However, by means of inertia of rotation, swing motor will be stopped after more rotation. In that time, make up check valve is opened and supplies working oil according to the pressure of hydraulic oil line to the entrance of the motor, which is lower than working oil awaiting in a make up check valve port.



220072SM10

2.5 Working description of plowing switch

The capacity of driving motor is changeable depending on the change of plowing angle of the plate. That is operated by a plowing valve.

1) The pressure of external pilot : when $P_i = 0$ (large plowing)

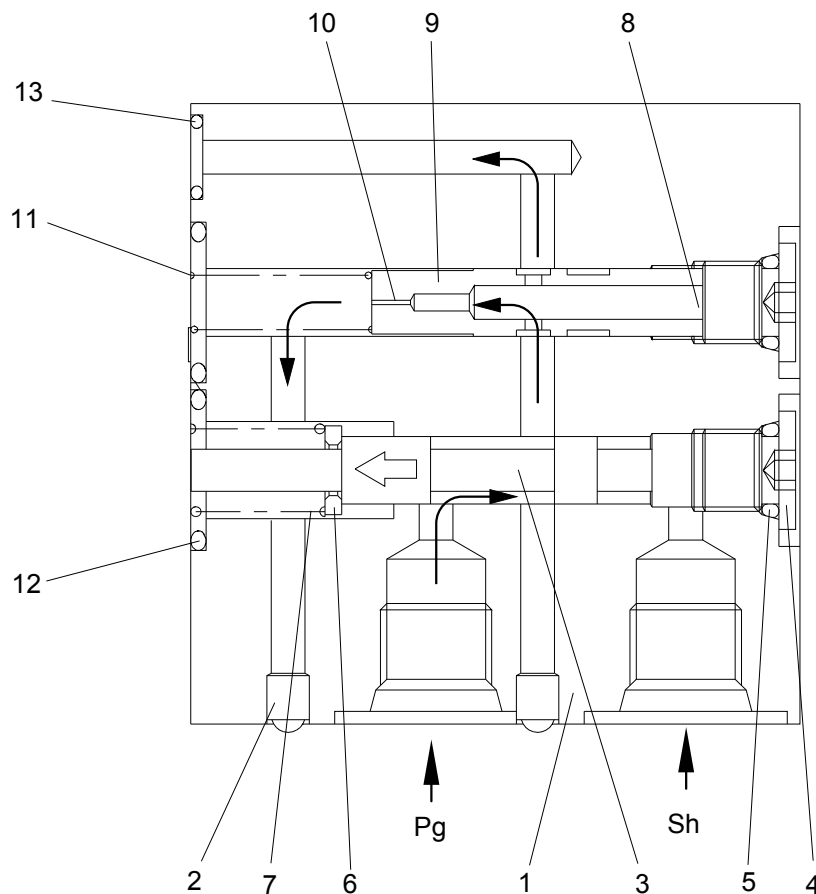
A high pressure oil operated at a motor works on port P of a switching valve, by the high pressure selecting function installed in valve casing.

Spool assembled at the switching part of plowing is adhered to plug by spring.

So the high pressure oil of port P flows to port Sb.

The pressure of this oil can be operated from port Sb to room A, through valve casing and the path A' of shaft casing. An oil in room B flows into a drain line through the path of $B \rightarrow S_a$.

Plowing piston moves to the right side because of the high pressure oil; the plate moves to the place adhered to stopper, based on the shaft "0"; it is fixed.



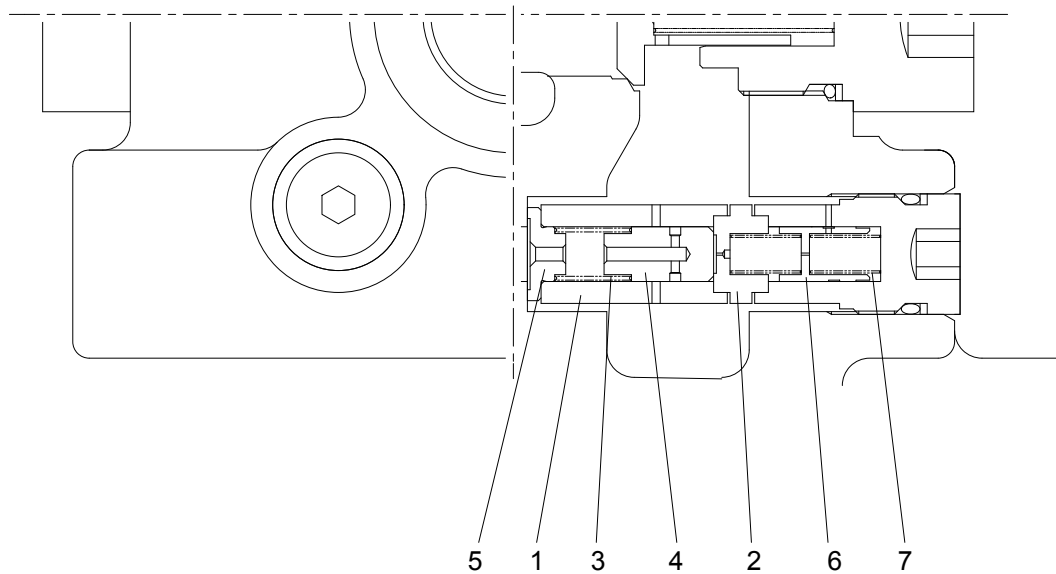
220072SM12

2.6 Working of anti-inversion valve

In the event of swing motor operates switch part to drive and stop the swing part. By the action of pump on motor, there is break on both-side of port because of the block on both sides.

Swing part is stopped by pressure of brake(in order words, 4-5 times of inversion)

Under the operating condition, the side of anti-inversion blocks off both ports but bypassing compressed oil which is blocked in processing of anti-inversion fixed time and amount to inverse port, prevent increasing pressure of motor and decrease inversing action.



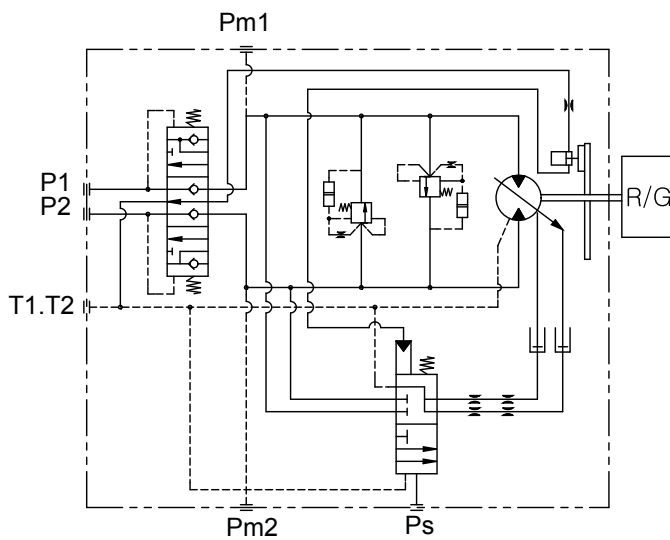
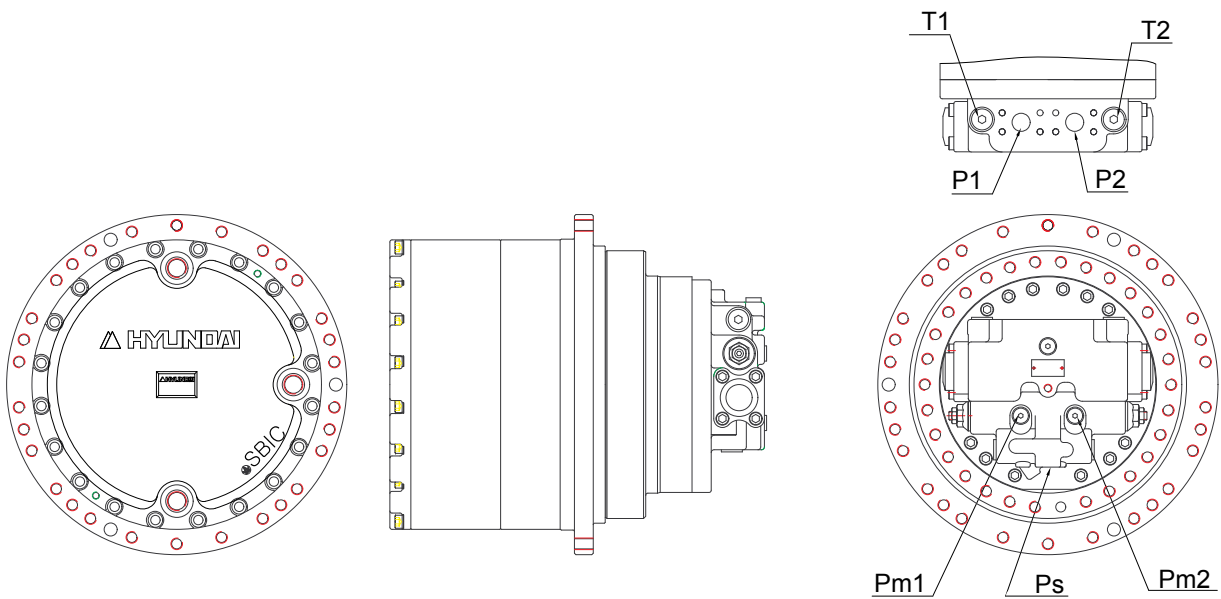
220072SM13

GROUP 4 TRAVEL DEVICE

1. STRUCTURE

A hydraulic motor includes followings.

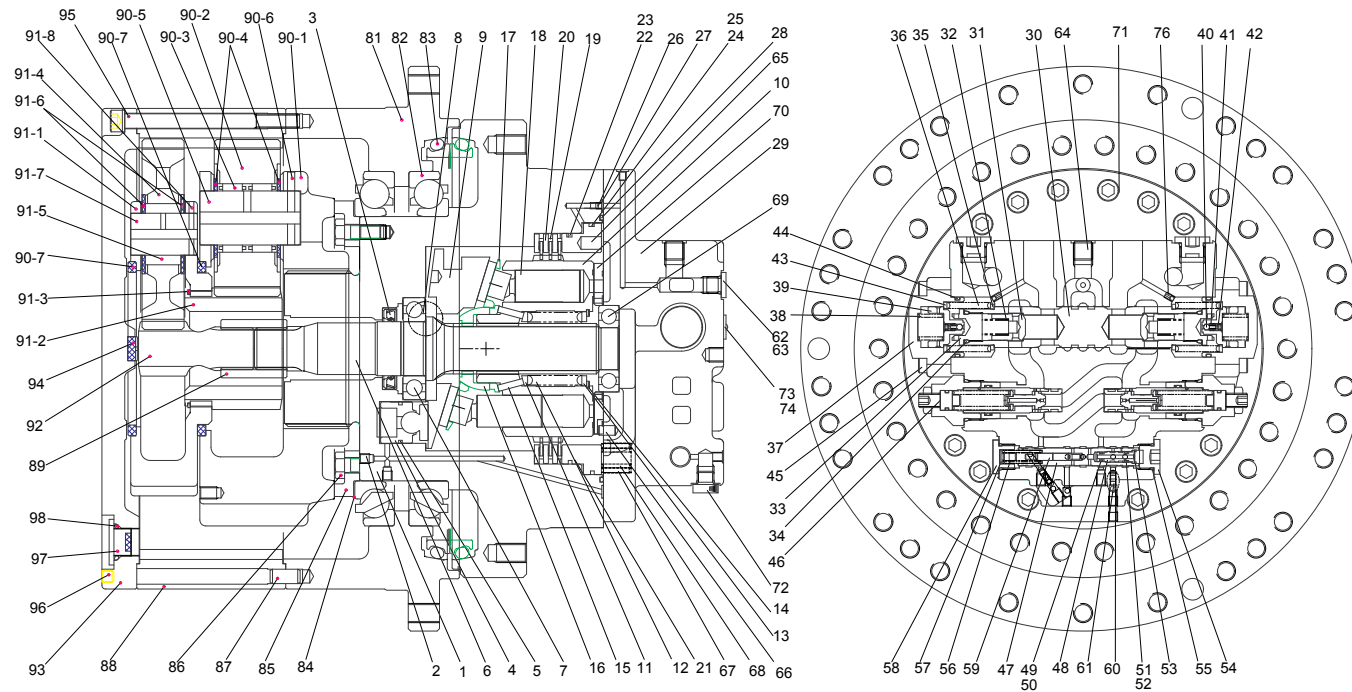
- Part of rotary generating turning force
- Part of a valve of relief
- Part of Brake
- Part of a valve of counterbalance
- Part of flowing changeover
- Part of auto changeover



Port	Port name	Port size
P1, P2	Main port	SAE 1"
Pm1, Pm2	Gauge port	PF 1/4
T1, T2	Drain port	PF 1/2
Ps	2 speed control port	PF 1/4

RD21072TM12

2) STRUCTURE



21078TM02

1 Shaft casing	20 Plate	39 Spool	57 Spring seat	75 Seal kit	90-7 Thrust ring
2 Plug	21 Packing piston	40 Steel ball	58 Plug	76 Orifice	91 Carrier Assy No.1
3 Oil seal	22 O-ring	41 Spring	59 Spool	81 Housing	91-1 Carrier No.1
4 Swash piston	23 Back up ring	42 Plug	60 Orifice	82 Main bearing	91-2 Sun-gear No.2
5 Piston ring	24 O-ring	43 Spring seat	61 Orifice	83 Floating seal	91-3 Retaining ring
6 Shaft	25 Back up ring	44 O-ring	62 Plug	84 Shim	91-4 Planetary gear No.1
7 Bearing	26 Orifice	45 Wrench bolt	63 O-ring	85 Retainer	91-5 Needle bearing No.1
8 Steel ball	27 O-ring	46 Relief valve Assy	64 Plug	86 Hex head bolt	91-6 Needle bearing No.2
9 Swash plate	28 O-ring	47 Spool	65 Pin	87 Parallel pin	91-7 Thrust washer
10 Cylinder block	29 Rear cover	48 Guide	66 Pin	88 Ring gear	91-8 Pin No.1
11 Spring seat	30 Spool	49 O-ring	67 Spring	89 Coupling	92 Sun gear No.1
12 Spring	31 Check	50 Back up ring	68 Spring	90 Carrier Assy No.2	93 Cover
13 End plate	32 Spring	51 O-ring	69 Bearing	90-1 Carrier No.2	94 Pad
14 Snap ring	33 Plug	52 Back up ring	70 Valve plate	90-2 Planetary gear No.2	95 Hex socket head bolt
15 Pin	34 O-ring	53 Snap ring	71 Wrench bolt	90-3 Needle bearing No.2	96 Hex socket Screw
16 Ball guide	35 Spring seat	54 Plug	72 Plug	90-4 Thrust washer	97 Hydraulic plug
17 Set plate	36 Spring	55 O-ring	73 Name plate	90-5 Pin No.2	98 O-ring
18 Piston Assy	37 Cover	56 Spring	74 Rivet	90-6 Spring pin	99 Name plate
19 Friction plate	38 Spring				

2. PRINCIPLE OF DRIVING

2.1 Generating the turning force

The high hydraulic supplied from a hydraulic pump flows into a cylinder(10) through valve casing of motor(29), and valve plate(77).

The high hydraulic is built as flowing on one side of Y-Y line connected by the upper and lower sides of piston(18).

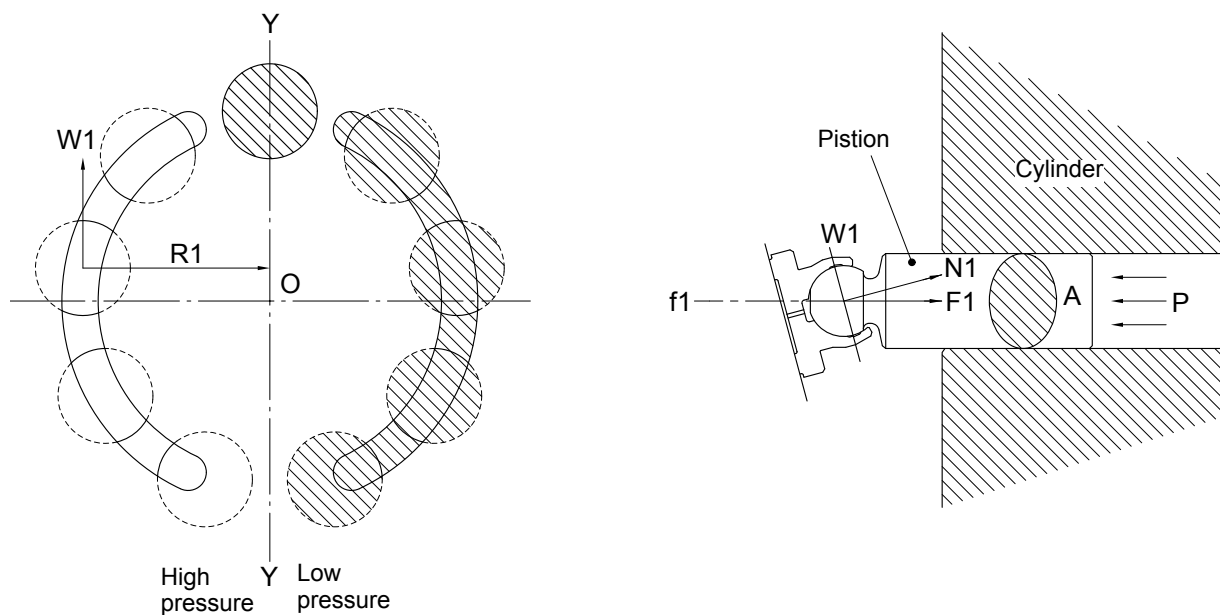
The high hydraulic can generate the force, $F1 = P \times A$ (P : Supplied pressure, A : water pressure area), like following pictures, working on a piston.

This force, F1, is divided as N1 thrust partial pressure and W1 radial partial pressure, in case of the plate(09) of a tilt angle, α .

W1 generates torque, $T = W1 \times R1$, for Y-Y line connected by the upper and lower sides of piston as following pictures.

The sum of torque ($\sum W1 \times R1$), generated from each piston(4~5pieces) on the side of a high hydraulic, generates the turning force.

This torque transfers the turning force to a cylinder(10) through a piston; because a cylinder is combined with a turning axis and spline, a turning axis rotates and a turning force is sent.



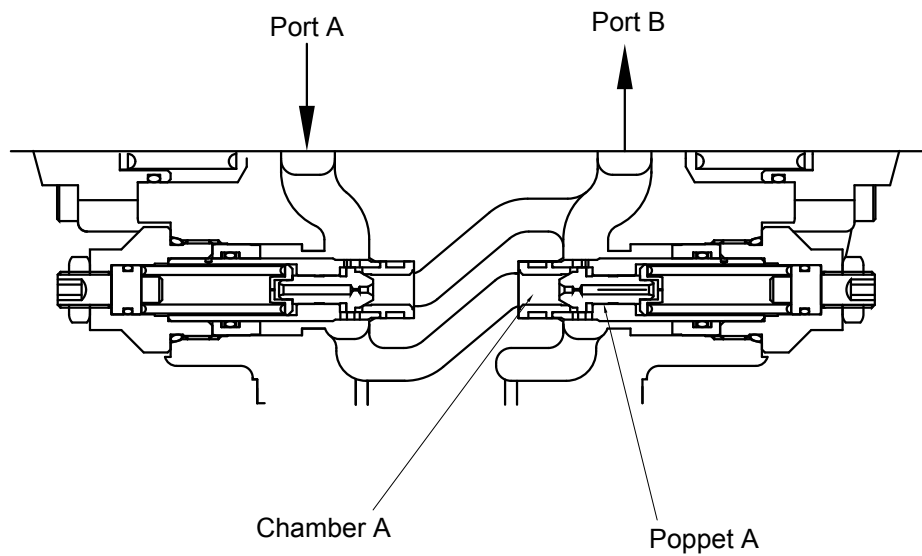
21078TM05

2.2 Working of relief valve

Relief valve carries on two functions of followings.

- 1) It standardizes a pressure in case of driving a hydraulic motor ; bypasses and extra oil in a motor inlet related to acceleration of an inertia to an outlet.
- 2) In case of an inertia stopped, it forces an equipment stopped, according to generating the pressure of a brake on the projected side.

Room A is always connected with port A of a motor. If the pressure of port is increased, press poppet A. And if it is higher than the setting pressure of a spring, the oil of an hydraulic flows from room A to port B, because poppet A is detached from the contact surface of seat A.



21078TM06

2.3 Working of negative brake

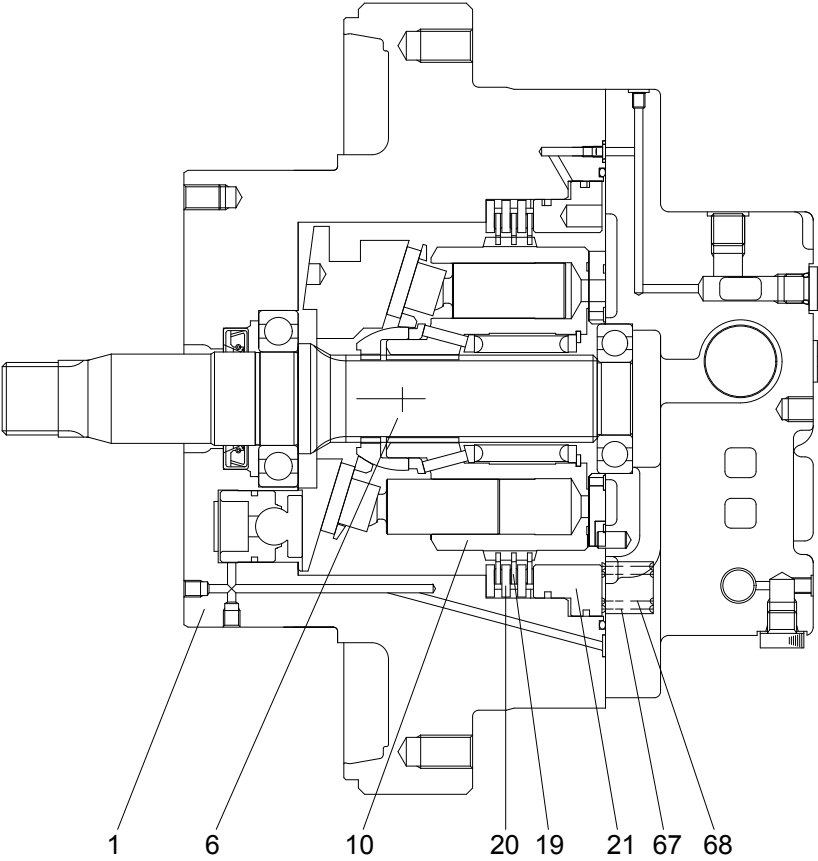
When the operating pressure is supplied to the brake piston (21) through the spool (simultaneous peripheral operation online) built in the valve casing (29), the negative brake is released.

When the pressure does not work, the brake always runs.

The force of a brake is generated by the frictional force among a separate plate (20) fixed by shaft casing, parking piston (21) and a frictional plate (19) connected through spline outside a cylinder block (10).

When a pressure does not work on the part of piston, brake spring presses brake piston; oil in a brake room flows into the drain of a motor through an orifice; in that time, brake piston compresses a frictional plate and a detached plate in the middle of shaft casing and brake piston according to the force that presses 10 pieces of brake springs (68, 67); finally, it makes a frictional force.

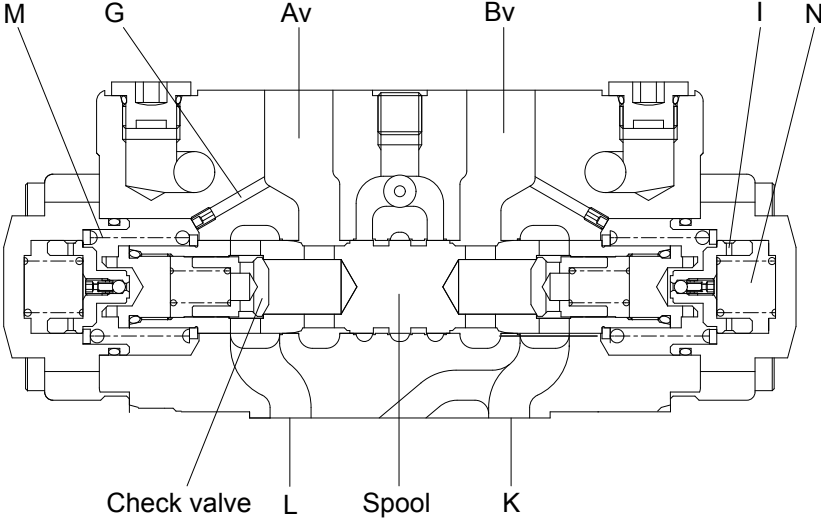
This frictional force helps the brake fixing a turning shaft (6) connected by a cylinder and spline operated.



2.4 Counterbalance valve

Av port is connected to a hydraulic pump; Bv port is connected to a tank.

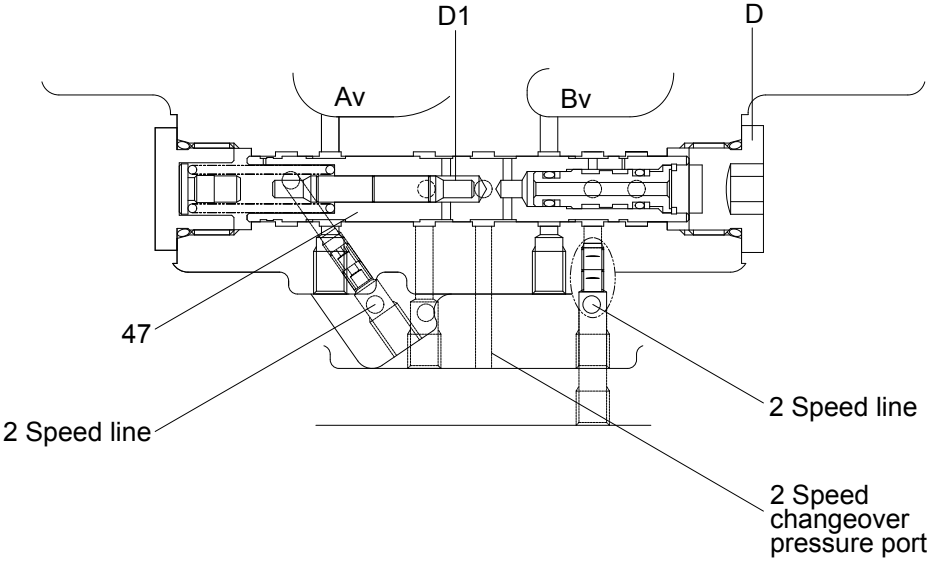
An oil supplied from a hydraulic pump presses check valve and flows into L port. It makes a hydraulic motor circulated. The oil pressure out of a pump is increased and transferred to spring room M through the path G because negative brake is working on. When the pressure of room M exceeds the force of spring that keeps spool at its neutral position, the spool begins to move the right side. An oil in room N is sent to room M by orifice I and discharged from G line to a tank. Then the spool moves to the right and the oil flows from K to Bv.



21078TM08

2.5 Working description of automatic switch(at normal speed)

Due to no pressure on pilot now, spool(47) is not working.

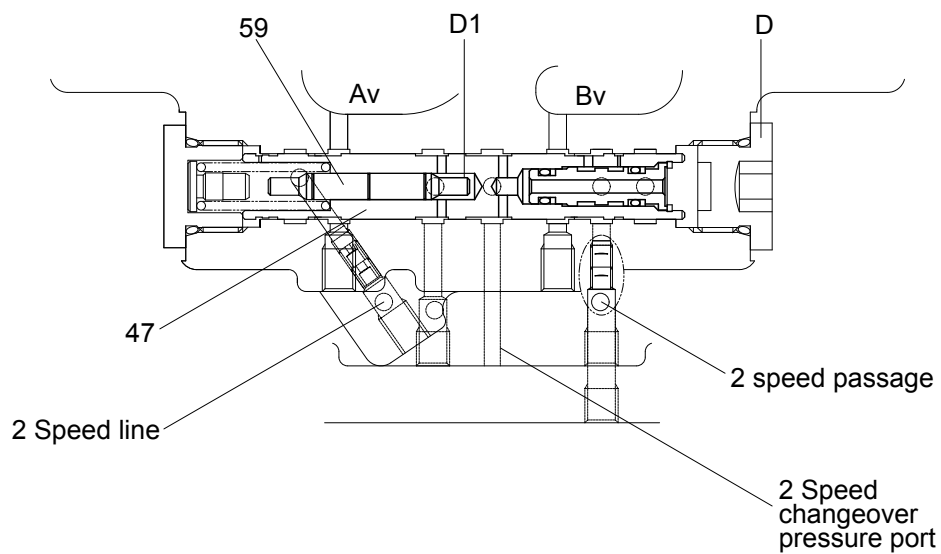


(Normal Speed)

2.6 Working description of automatic switch(at high speed)

At normal speed, once the hydraulic oil which is through the inner path of spool(47) flows into high speed switching pressure port(The pressure of external pilot : $P_i = 35\text{kgf/cm}^2$) spool(47) moves from right to left.

At high speed, turning pressure of motor(D1) is over 250kgf/cm^2 , when the power forcing to spool(59) (Pressure, P1) is stronger than spool(47) and spool(59) is pushed out, after then spool(47) moves from left to right. So it is switched.



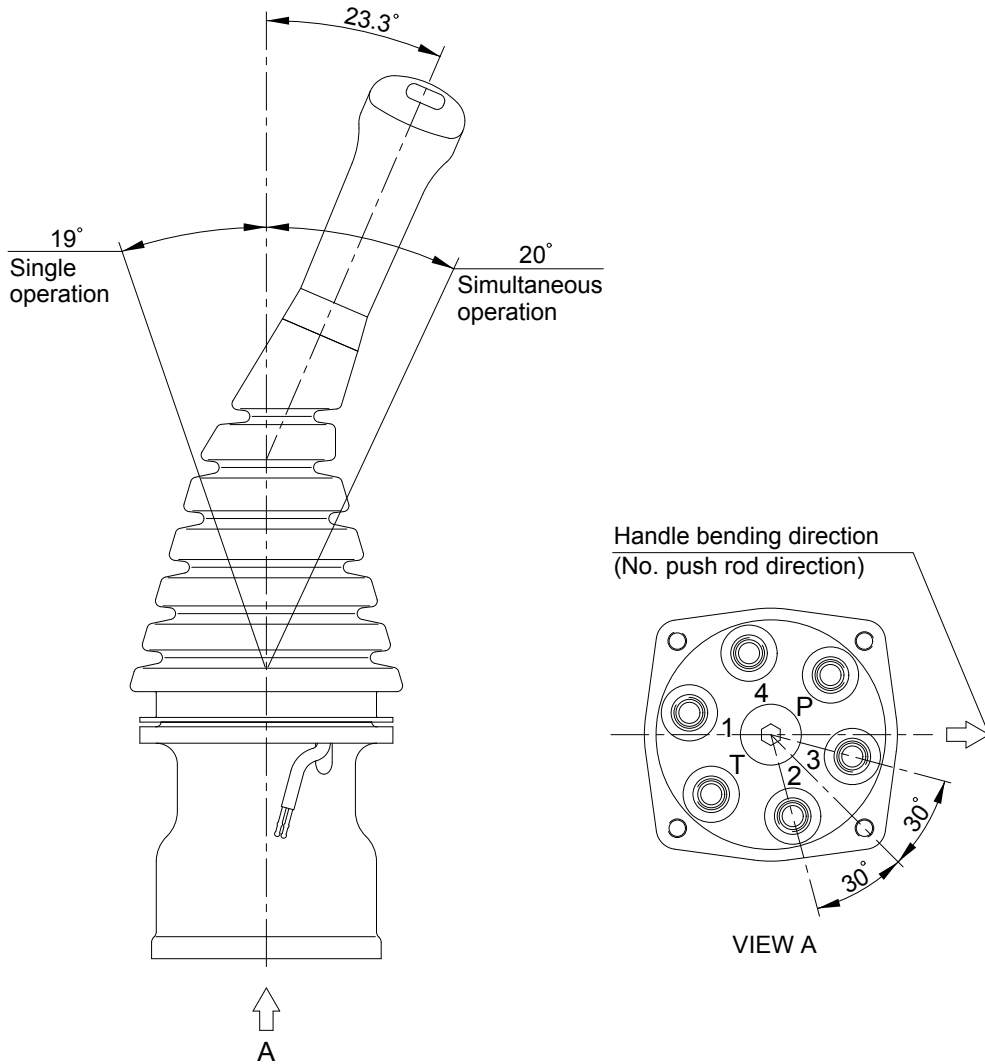
(High Speed)

21078TM10

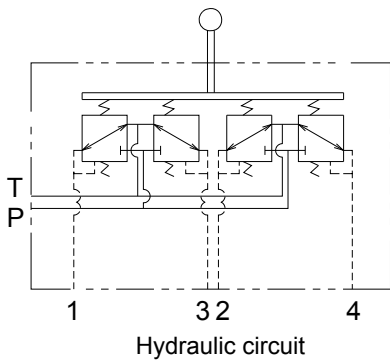
GROUP 5 RCV LEVER

1. STRUCTURE

The casing has the oil inlet port P(Primary pressure) and the oil outlet port T(Tank). In addition the secondary pressure is taken out through ports 1,2,3 and 4 provided at the bottom face.



25032RL01



Port	LH	RH	Port size
P	Pilot oil inlet port	Pilot oil inlet port	PF 1/4
T	Pilot oil return port	Pilot oil return port	
1	Left swing port	Bucket out port	
2	Arm in port	Boom down port	
3	Right swing port	Bucket in port	
4	Arm out port	Boom up port	

CROSS SECTION

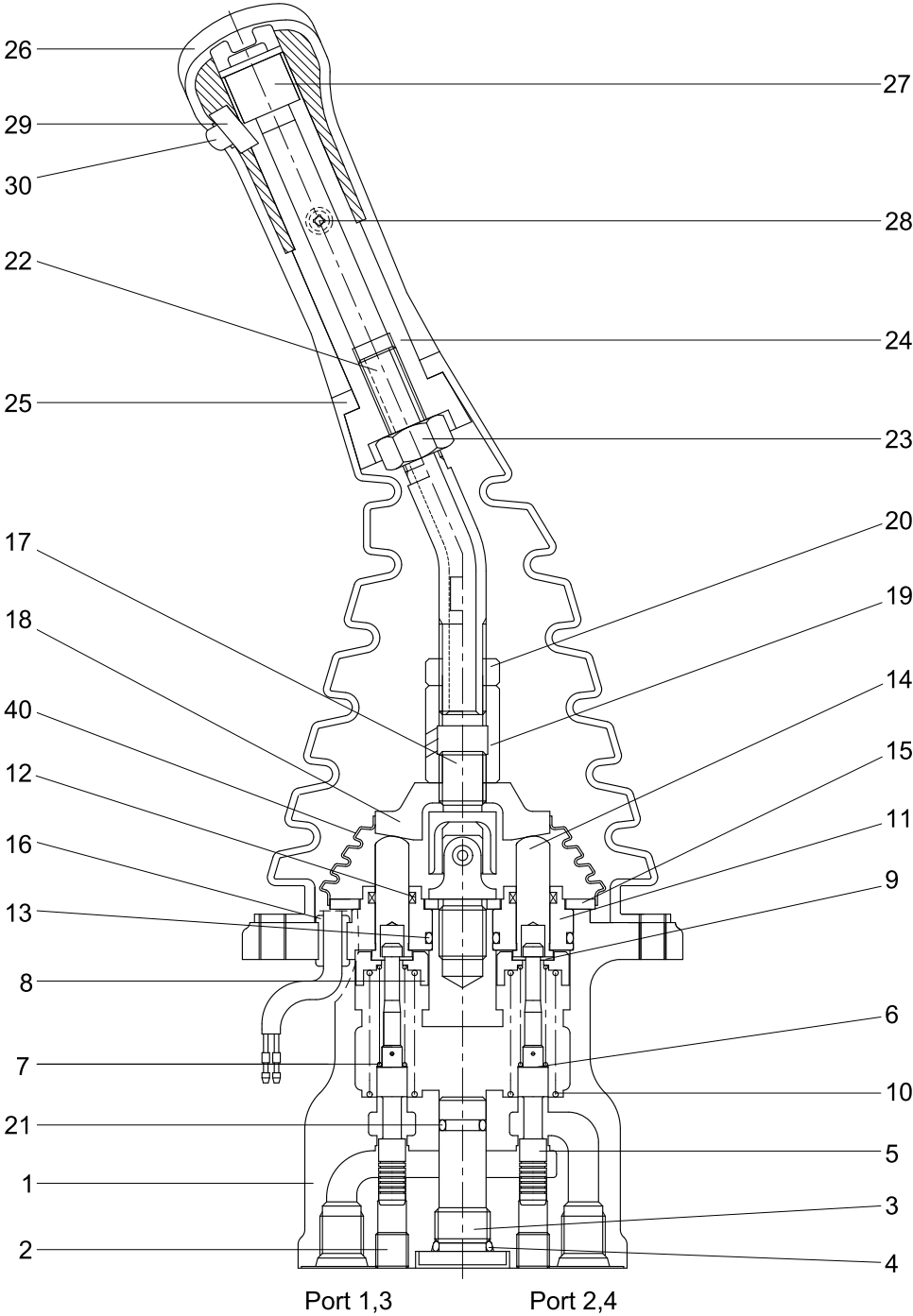
The construction of the pilot valve is shown in the attached cross section drawing. The casing has vertical holes in which reducing valves are assembled.

The pressure reducing section is composed of the spool(5), spring(7) for setting secondary pressure, return spring(10), stopper(9), spring seat(8) and shim(6). The spring for setting the secondary pressure has been generally so preset that the secondary pressure is 5 to 20.5kgf/cm²(Depending on the type). The spool is pushed against the push rod(14) by the return spring.

When the push rod is pushed down by tilting the handle, the spring seat comes down simultaneously and changes setting of the secondary pressure spring.

1	Case	12	Rod seal	23	Nut
2	Plug	13	O-ring	24	Insert
3	Plug	14	Push rod	25	Boot
4	O-ring	15	Plate	26	Handle
5	Spool	16	Bushing	27	Switch assembly
6	Shim	17	Joint assembly	28	Screw
7	Spring	18	Swash plate	29	Switch assembly
8	Spring seat	19	Adjusting nut	30	Switch cover
9	Stopper	20	Lock nut	40	Boot
10	Spring	21	O-ring		
11	Plug	22	Handle connector		

CROSS SECTION



14072SF80

2. FUNCTIONS

1) FUNDAMENTAL FUNCTIONS

The pilot valve is a valve that controls the spool stroke, direction, etc of a main control valve. This function is carried out by providing the spring at one end of the main control valve spool and applying the output pressure(Secondary pressure) of the pilot valve to the other end.

For this function to be carried out satisfactorily, the pilot valve is composed of the following elements.

- (1) Inlet port(P) where oil is supplied from hydraulic pump.
- (2) Output ports(1,2,3 & 4) to apply pressure supplied from inlet port to ends of control valve spools.
- (3) Tank port(T) necessary to control the above output pressure.
- (4) Spool to connect output port to inlet port or tank port.
- (5) Mechanical means to control output pressure, including springs that work on the above spools.

2) FUNCTIONS OF MAJOR SECTIONS

The functions of the spool(5) are to receive the supply oil pressure from the hydraulic pump at its port P, and to change over oil paths to determine whether the pressure oil of port P is led to output ports 1,2,3 & 4 or the output port pressure oil to tank port T.

The spring(7) works on this spool to determine the output pressure.

The change the deflection of this spring, the push rod(14) is inserted and can slide in the plug(11).

For the purpose of changing the displacement of the push rod through the switch plate(19) and adjusting nut(20) are provided the handle(27) that can be tilted in any direction around the fulcrum of the universal joint(18) center.

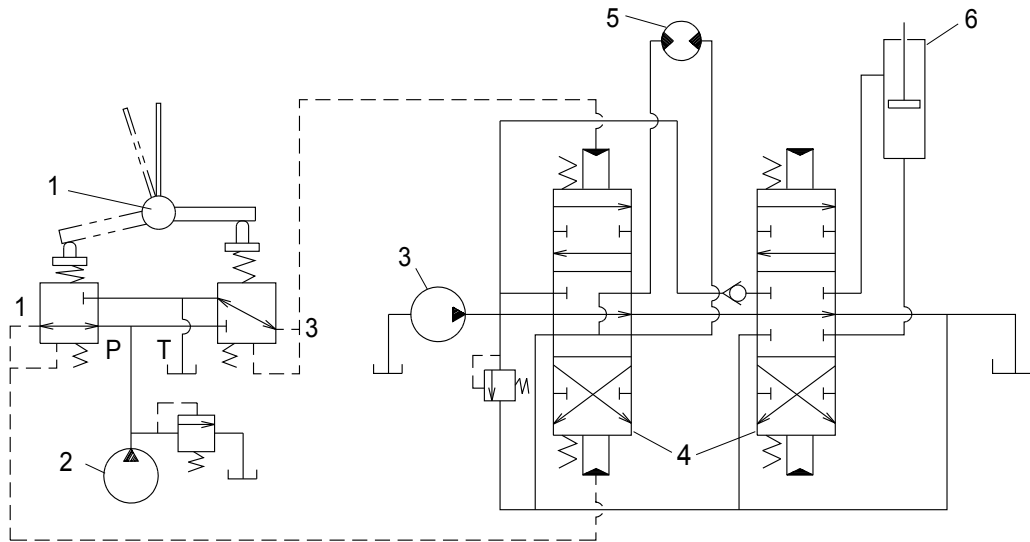
The spring(10) works on the case(1) and spring seat(8) and tries to return the push rod(14) to the zero-displacement position irrespective of the output pressure, securing its resetting to the center position.

This also has the effect of a reaction spring to give appropriate control feeling to the operator.

3) OPERATION

The operation of the pilot valve will be described on the basis of the hydraulic circuit diagram shown below and the attached operation explanation drawing.

The diagram shown below is the typical application example of the pilot valve.



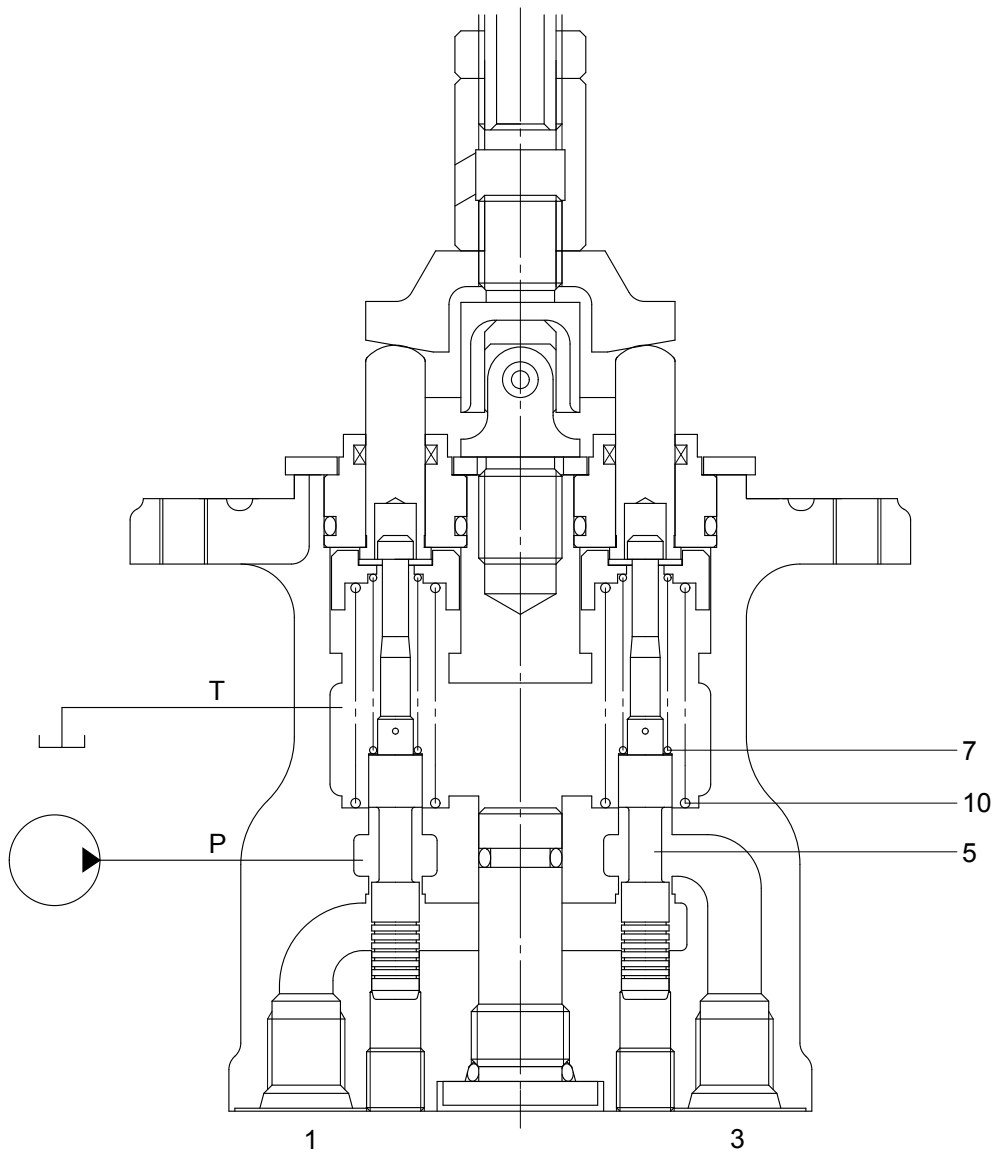
2-70

- 1 Pilot valve
- 2 Pilot pump

- 3 Main pump
- 4 Main control valve

- 5 Hydraulic motor
- 6 Hydraulic cylinder

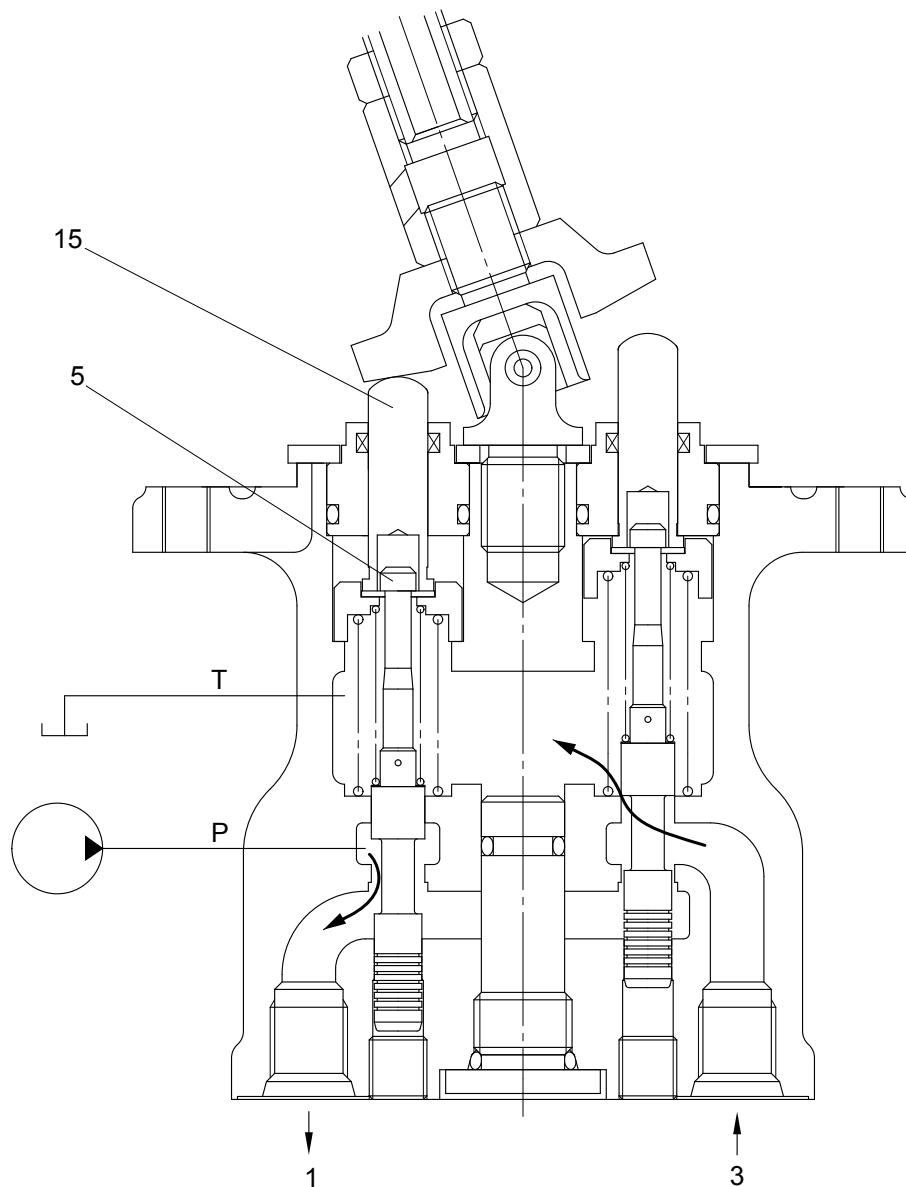
(1) Case where handle is in neutral position



25032RL03

The force of the spring(7) that determines the output pressure of the pilot valve is not applied to the spool(5). Therefore, the spool is pushed up by the spring(10) to the position of port(1, 3) in the operation explanation drawing. Then, since the output port is connected to tank port T only, the output port pressure becomes equal to tank pressure.

(2) Case where handle is tilted



25032RL04

When the push rod(14) is stroked, the spool(5) moves downwards.

Then port P is connected with port(1) and the oil supplied from the pilot pump flows through port(1) to generate the pressure.

When the pressure at port(1) increases to the value corresponding to the spring force set by tilting the handle, the hydraulic pressure force balances with the spring force. If the pressure at port(1) increases higher than the set pressure, port P is disconnected from port(1) and port T is connected with port(1). If it decreases lower than the set pressure, port P is connected with port(1) and port T is disconnected from port 1.

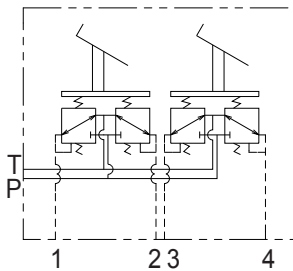
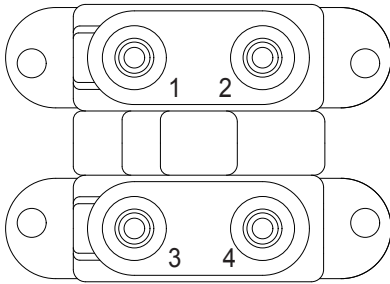
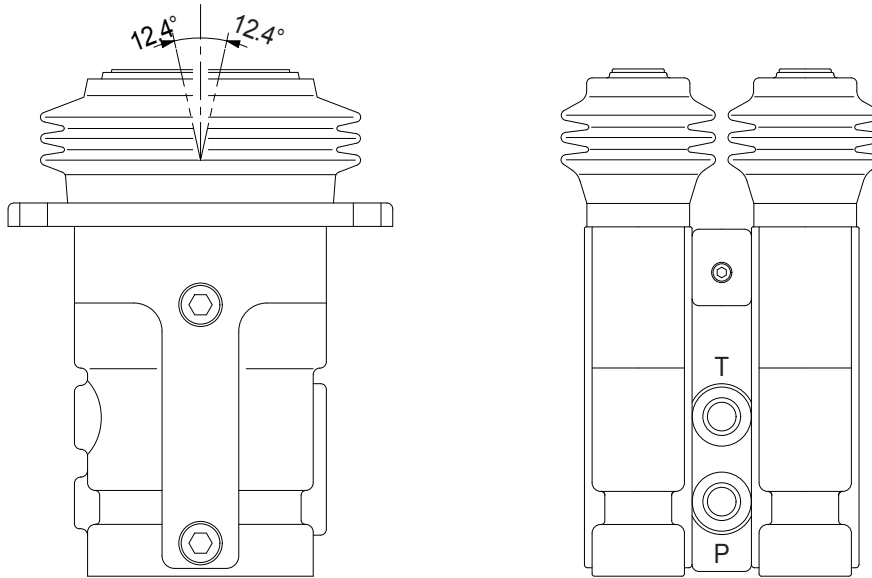
In this manner the secondary pressure is kept at the constant value.

Besides, in some type, when the handle is tilted more than a certain angle, the upper end of the spool contacts with the inside bottom of the push rod and the output pressure is left to be connected with port P.

GROUP 6 RCV PEDAL

1. STRUCTURE

The casing(Spacer) has the oil inlet port P(Primary pressure), and the oil outlet port T(Tank). In addition the secondary pressure is taken out through ports 1, 2, 3 and 4 provided at the bottom face.



Hydraulic circuit

Port	Port	Port size
P	Pilot oil inlet port	PF 1/4
T	Pilot oil return port	
1	Travel(LH, Forward)	
2	Travel(LH, Backward)	
3	Travel(RH, Forward)	
4	Travel(RH, Backward)	

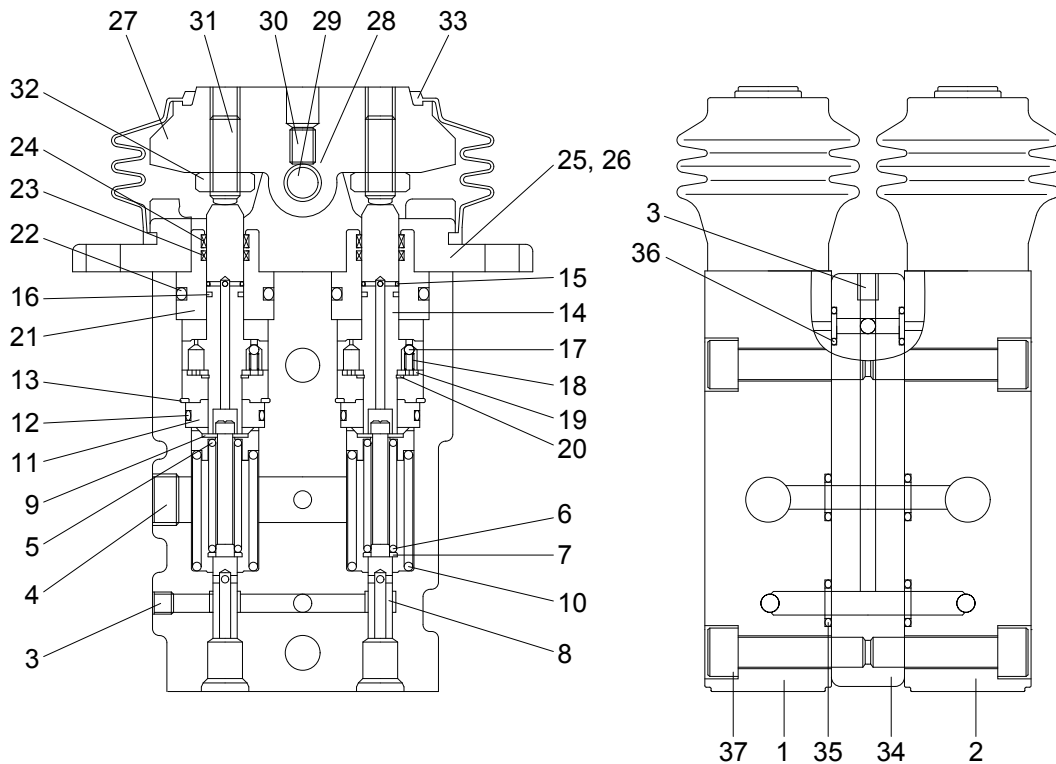
14072SF73

CROSS SECTION

The construction of the RCV pedal is shown in the below drawing. The casing has vertical holes in which reducing valves are assembled.

The pressure reducing section is composed of the spool(8), spring(6) for setting secondary pressure, return spring(10), stopper(9), and spring seat(7). The spring for setting the secondary pressure has been generally so preset that the secondary pressure is 5 to 19kgf/cm² (depending on the type). The spool is pushed against the push rod(14) by the return spring.

When the push rod is pushed down by tilting pedal, the spring seat comes down simultaneously and changes setting of the secondary pressure spring.



14072SF70

1	Body(1)	13	Snap ring	25	Cover
2	Body(2)	14	Push rod	26	Socket bolt
3	Plug	15	Spring pin	27	Cam
4	Plug	16	Seal	28	Bushing
5	Spring seat	17	Steel ball	29	Cam shaft
6	Spring	18	Spring	30	Set screw
7	Spring seat	19	Plate	31	Set screw
8	Spool	20	Snap ring	32	Nut
9	Stopper	21	Plug	33	Bellows
10	Spring	22	O-ring	34	Space
11	Rod guide	23	Rod seal	35	O-ring
12	O-ring	24	Dust seal	36	O-ring
				37	Socket bolt

2. FUNCTION

1) FUNDAMENTAL FUNCTIONS

The pilot valve is a valve controls the spool stroke, direction, etc of a main control valve. This function is carried out by providing the spring at one end of the main control valve spool and applying the output pressure(Secondary pressure) of the pilot valve to the other end.

For this function to be carried out satisfactorily, the pilot valve is composed of the following elements.

- (1) Inlet port(P) where oil is supplied from hydraulic pump.
- (2) Output port(1, 2, 3 & 4) to apply pressure supplied from inlet port to ends of control valve spools.
- (3) Tank port(T) necessary to control the above output pressure.
- (4) Spool to connect output port to inlet port tank port.
- (5) Mechanical means to control output pressure, including springs that work on the above spools.

2) FUNCTIONS OF MAJOR SECTIONS

The functions of the spool(8) are to receive the supply oil pressure from the hydraulic pump at its port P, and to change over oil paths to determine whether the pressure oil of port P is led to output ports 1, 2, 3 & 4 or the output spool to determine the output pressure.

The spring(6) works on this spool to determine the output pressure.

The change the deflection of this spring, the push rod(14) is inserted and can slide in the plug(21).

For the purpose of changing th displacement of the push rod through the cam(27) and adjusting nut(32) are provided the pedal that can be tilted in any direction around the fulcrum of the cam(27) center.

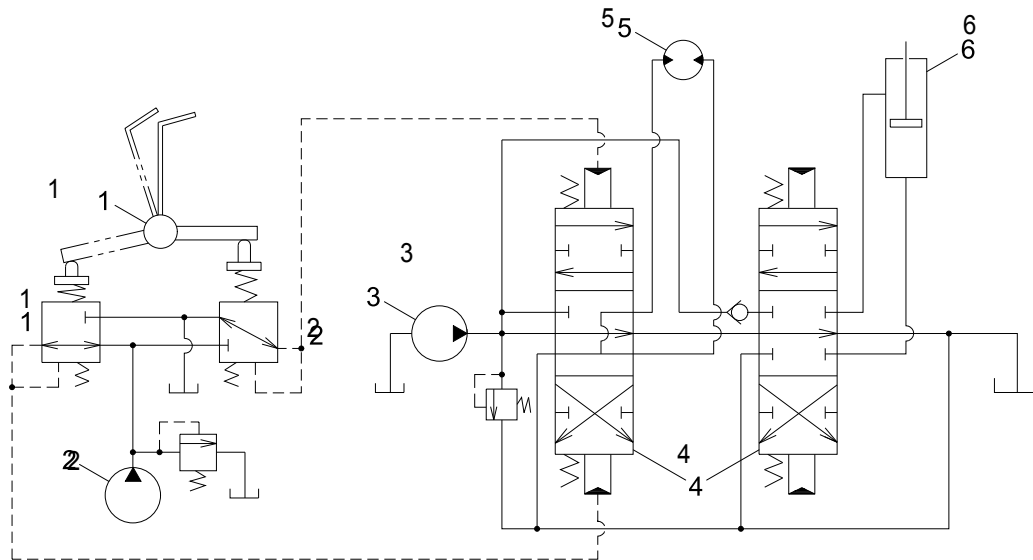
The spring(10) works on the casing(1) and spring seat(7) and tries to return the push rod(14) to the zero-displacement position irrespective of the output pressure, securing its resetting to the center position.

This also has the effect of a reaction spring to give appropriate control feeling to the operator.

3) OPERATION

The operation of the pilot valve will be described on the basis of the hydraulic circuit diagram shown below and the attached operation explanation drawing.

The diagram shown below is the typical application example of the pilot valve.



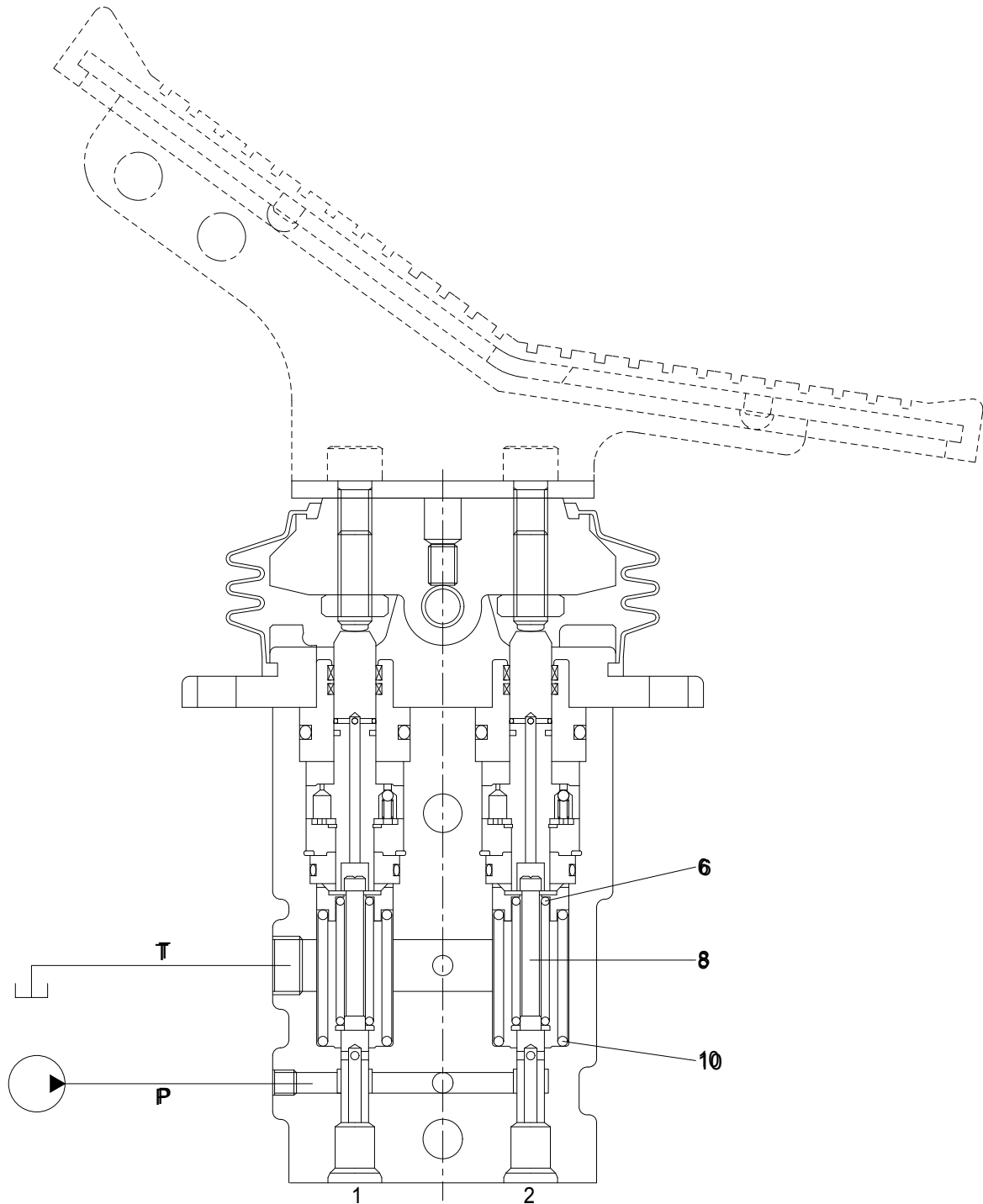
36072SF01

- 1 Pilot valve
- 2 Pilot pump

- 3 Main pump
- 4 Main control valve

- 5 Hydraulic motor
- 6 Hydraulic cylinder

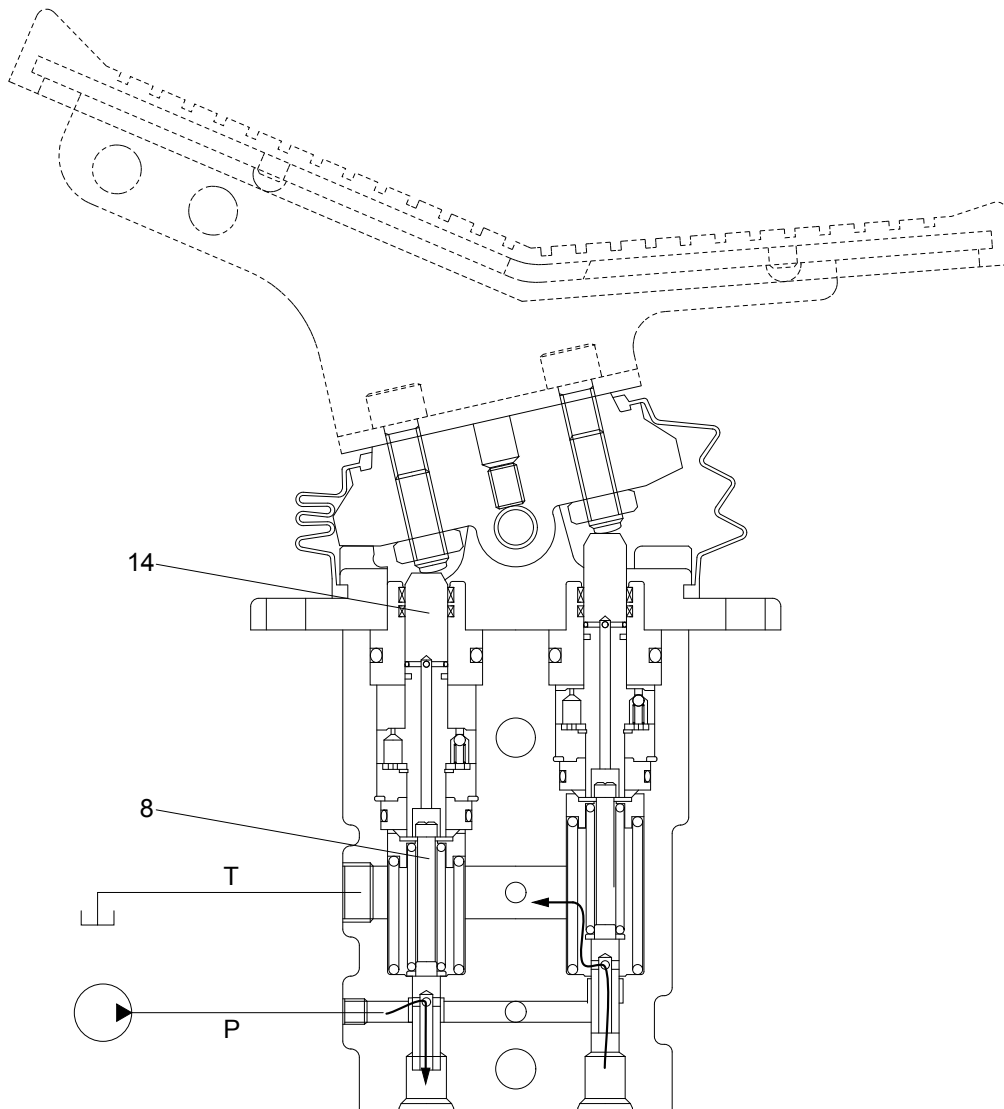
(1) Case where pedal is in neutral position



14072SF74

The force of the spring(6) that determines the output pressure of the pilot valve is not applied to the spool(8). Therefore, the spool is pushed up by the spring(10) to the position of port 2 in the operation explanation drawing. Then, since the output port is connected to tank port T only, the output port pressure becomes equal to tank pressure.

(2) Case where pedal is tilted



14072SF75

When the push rod(14) is stroked, the spool(8) moves downwards.

Then port P is connected with port 1, and the oil supplied from the pilot pump flows through port 1 to generate the pressure.

When the pressure at port 1 increases to the value corresponding to the spring force set by tilting the handle, the hydraulic pressure force balances with the spring force. If the pressure at port 1 increases higher than the set pressure, port P is disconnected from port 1 and port T is connected with port 1. If it decreases lower than the set pressure, port P is connected with port 1 and port T is disconnected from port 1.

In this manner the secondary pressure is kept at the constant value.

Besides, in some type, when the handle is tilted more than a certain angle, the upper end of the spool contacts with inside bottom of the push rod and the output pressure is left to be connected with port P.