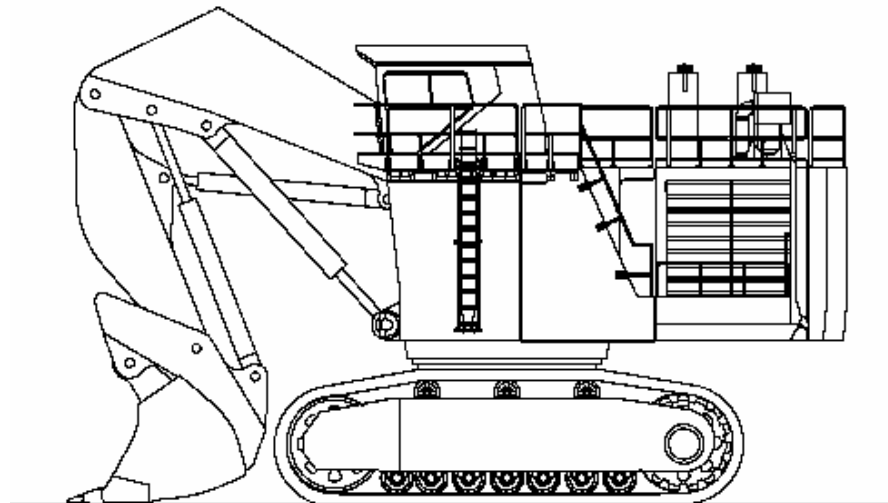
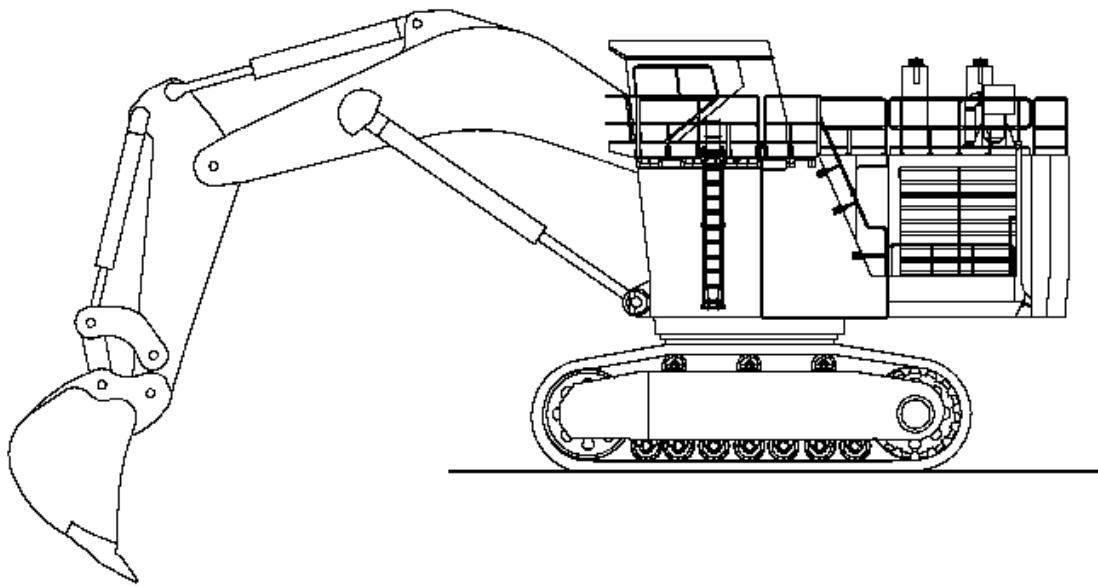


# General Assembly Procedure

## Hydraulic Mining Shovel PC4000

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- **Before assembling/disassembling, lifting or transporting this excavator contact your local Service Center for all the necessary instructions for safe and economic assembling/disassembling, lifting and transportation procedures of your excavator.**

The sequence of assembly as shown in this Manual. Disassembling is basically the reverse order of the assembling procedure.

### **2.3 Transportation and Lifting**

The transport dimensions and weights of the excavator's components are listed in this manual are for general information only. For the correct dimensions and weights please refer to the packing list of your machine.

Observe the operating permits of the low-bed trailers used for transportation. They contain the permissible load, loading width and height.



- **Observe the federal, state and local laws and regulations for transportation of heavy units. Know the safety rules and laws before you transport this Excavator.**
- **Make sure the flat-bed trailer and the components of the Excavator are equipped with the correct safety devices.**
- **Secure the Excavator and all components transported on the trailer against movement.**
- **Use exclusively approved handling equipment.**
- **When lifting components make sure that the handling elements do not cause damage to the component.**
- **Secure the components safely before removing the lifting straps, ropes or chains.**

## 2.8 Basic Measurements (Z23038)

## 2.9 Transport Dimensions and Weights (as example)

(For exact Dimensions and Weights refer to the packing list of your machine.)

Face Shovel			Backhoe		
<b>L.H. and R.H. Crawler side frame</b>			<b>L.H. and R.H. Crawler side frame</b>		
Track width	1200 mm		Track width	1200 mm	
Dimensions (mm)	8450 x 2700 x 2420		Dimensions (mm)	8450 x 2700 x 2420	
Weight	52,000 kg / 114,700 lb		Weight	52.000 kg / 114.700 lb	
<b>Carbody centre</b>			<b>Carbody centre</b>		
Dimensions (mm)	4420 x 4130 x 2350		Dimensions (mm)	4420 x 4130 x 2350	
Weight	29,000 kg / 64,000 lb		Weight	29.000 kg / 64.000 lb	
<b>Counterweight</b>			<b>Counterweight</b>		
Dimensions (mm)	6150 x 3420 x 700		Dimensions (mm)	6150 x 3420 x 700	
Weight	33,800 kg / 75,000 lb		Weight	33.800 kg / 75.000 lb	
<b>Upper-structure main frame</b>			<b>Upper-structure main frame</b>		
Dimensions (mm)	8420 x 4440 x 3700		Dimensions (mm)	8420 x 4440 x 3900	
Weight	57,500 kg / 126,800 lb		Weight	57.500 kg / 126.800 lb	
<b>Main machinery house</b>			<b>Main machinery house</b>		
Dimensions (mm)	6500 x 3000 x 3300		Dimensions (mm)	6500 x 3000 x 3300	
Weight	30,100 kg / 66,400 lb		Weight	30,100 kg / 66.400 lb	
<b>Fuel tank</b>			<b>Fuel tank</b>		
Dimensions (mm)	2400 x 2100 x 3230		Dimensions (mm)	2400 x 2100 x 3230	
Weight	3.600 kg / 8000 lb		Weight	4.800 kg / 10.600 lb	
<b>Hydraulic tank</b>			<b>Hydraulic tank</b>		
Dimensions (mm)	2400 x 1200 x 3300		Dimensions (mm)	2400 x 1200 x 3300	
Weight	3.200 kg / 7.100 lb		Weight	3.000 kg / 6.700 lb	
<b>Cab base</b>			<b>Cab base</b>		
Dimensions (mm)	2280 x 2100 x 3000		Dimensions (mm)	2280 x 2100 x 3000	
Weight	3.400 kg / 7.500 lb		Weight	2.500 kg / 5.600 lb	
<b>Boom 7.15 m with 4 cylinders</b>			<b>Boom 9,75 m with cylinders</b>		
Dimensions (mm)	7700 x 2500 x 3200		Dimensions (mm)	10500 x 2600 x 3700	
Weight	34.600 kg / 76.300 lb		Weight	32.300 kg / 71.200 lb	
<b>Stick 4.9 m without cylinder</b>			<b>Stick 4.50 m with 2 bucket cylinders, linkage and control arm</b>		
Dimensions (mm)	5300 x 2100 x 2000		Dimensions (mm)	6300 x 1250 x 2400	
Weight	14.350 kg / 31.700 lb		Weight	26.000 kg / 57.400 lb	
<b>21 m<sup>3</sup> shovel bullclam bucket bowl</b>			<b>22 m<sup>3</sup> SAE backhoe</b>		
Dimensions (mm)	4100 x 3500 x 3400		Dimensions (mm)	3800 x 4200 x 3100	
Weight	15.350 kg / 33.900 lb		Weight	23.300 kg / 49.300 lb	
<b>5 cases with accessories</b>			<b>1 case oil cooler / 4 cases accessories</b>		
Dimensions (mm)	Weight (kg)	Weight (lb)	Dimensions (mm)	Weight (kg)	Weight (lb)
5780 x 2490 x 1970	5.820	12.900	5770 x 2490 x 1980	5.500	12.200
4000 x 3300 x 3300	5.000	11.100	3970 x 3290 x 3280	4.950	11.000
5800 x 2490 x 1970	6.100	13.500	5770 x 2490 x 1980	3.450	7.700
4900 x 1200 x 1200	4.150	9.200	4870 x 1090 x 1280	6.400	14.200
1660 x 850 x 730	1.000	2.300	5870 x 1290 x 1380	9.300	20.500

### 3.3 Assembly of engine house (Z21863)

1. Attach the unit to the crane (use only the attached lifting points (A).
2. Lower the unit as required so that two bolts with washers (02 + 03) for guiding can be inserted.
3. Lower the unit fully and insert all bolts with washers. Tighten the bolts with the resp. torque. (This must be done directly because later-on it may be difficult to reach the bolts).



- **There are two kinds of bolts:**

**(4):        8 bolts    M30 x 420 long**

**and:       18 bolts    M30 x 440 long**

### **3.8 Mounting of hydraulic access ladder (Z21871)**

Mount hinged ladder(01);

Connect ladder lifting cylinder (03);

Assemble ladder bearing (17);

Tighten the self locking nuts (06) according to the values listed below.

#### **Tightening Torque of Self Locking Nuts (06):**

- New nut: 440 Nm
- Used nut: 350 Nm

Check clamping torque of the free turning nuts (06) before tightening the bolt connection. If clamping torque is less than the minimum value of 12 Nm, use new nut.

Lubricate both eyes of hydraulic cylinder (03). Make sure both pivot pins (12 and 13) are properly secured with cotter pins (15).



- **Before lowering the cab onto the cab base mount the air hose to cab bottom.  
Refer to Illust. 22940 pos. (8) page 54.**

### 3.15.1 Mounting of Stick (Backhoe attachment) (Z23034)

#### Legend

A Location of Pins with a fine thread end

1. Pin
2. Cap for mounting
3. Final cap
4. Nut for mounting the final cap
5. Nut for mounting whirl
6. Safety bolt
7. Hole for the cotter pin
8. Cotter pin

#### Installing of this kind of pins:

1. Secure the thread with the mounting cap.
2. Install the pin.
3. Remove the mounting cap.
4. Install a whirl (M20) in the nut (5).
5. Lift the Final cap (3) with a crane, tilt it and turn it on the pin(1) by using the nut (4) (M30).
6. Secure the cap as shown with the bolt (6).
7. Secure the bolt (6) with the cotter pin (8).



- **There is only one mounting cap for all pins.**

- (13) Connect main battery switch and activate electrical system by using the key switch S1.
- (14) Check messages from display.
- (15) Check function of electrical system.
- (16) Activate swing parking brake by using switch S29 on dash board.
- (17) Start engine. Let it run in low idle about 5 min.
- (18) Bleed proportional valves of the pilot control. To do this turn the screw a few turn out until oil comes out. Retighten screw.
- (19) Bleed proportional valve of pump regulation system. To do this turn screw a few turn out until oil comes out. Retighten screw.
- (20) Let engine run in high idle.
- (21) Check function of engine water cooling fan by disconnecting plug to solenoid Y136.
- (22) Check function of hydraulic oil cooling fan by disconnecting plug to solenoid Y6a and Y6b.



- **Be carefully, make sure that nobody stand by the fan during function check.**

- (23) Bleed track extending system. To do this open both plugs near by the idler of each side frames. Connect inside a test hose to the test stud from each track extending cylinder. Drain the out flowing oil into a suitable container. Let engine run until bubble free oil flowing out.

\*(For more information refer to Maintenance Manual.)

### 3.22.1 Mounting of the Pin Seals (Backhoe) (Z23035)

#### Legend illustr. Z 23035:

- (1) Upper ring half
- (2) Lower ring half
- (3) Seal ring

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