

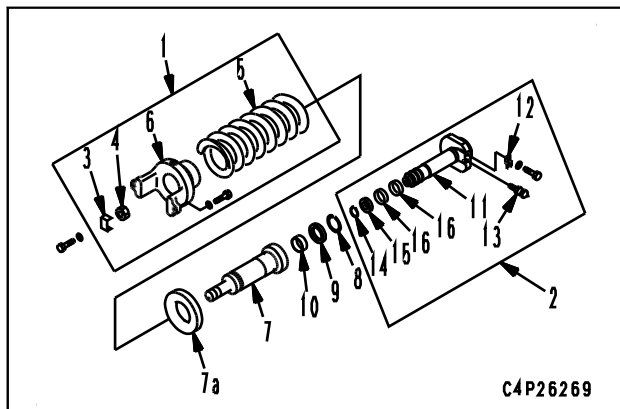
Disassembly and assembly of idler cushion (PC200_10-DTBP-926-K-00-A)

★ Special tools

Symbol	Part No.	Part Name	Necessity	Q'ty
M	791-600-2001 or 791-685-8006	Compressor (A) Compressor (B)	■	1
	790-201-2780	Spacer		1
	791-635-3160	Extension	■	1
	790-101-1600	Cylinder (686 kN {70 ton})	■	1
	790-101-1102	Pump	■	1
	790-640-2180	Guide-bolt	■	1
	790-101-5201	Push tool kit (B)	●	1
	790-101-5241	• Plate		1
	790-101-5221	• Grip		1
	01010-51225	• Bolt		2
2	790-201-1500	Push tool KIT	●	1
	790-101-1620	• Plate		1
	790-101-5021	• Grip		1
	01010-50816	• Bolt		2

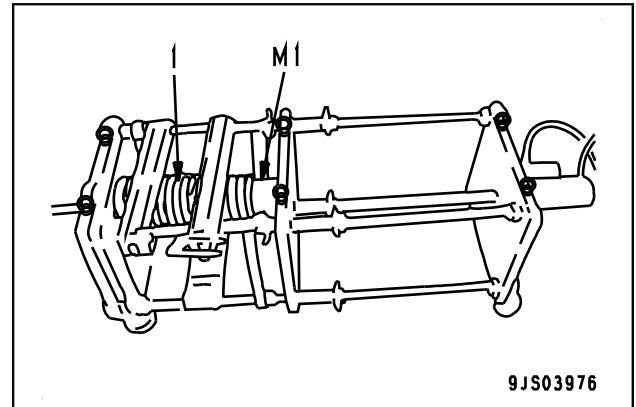
⚠ Since the load at installed length of the spring is large and dangerous, set the spring securely to the tool.

★ Figure of structure



Disassembly (PC200_10-DTBP-530-K-00-A)

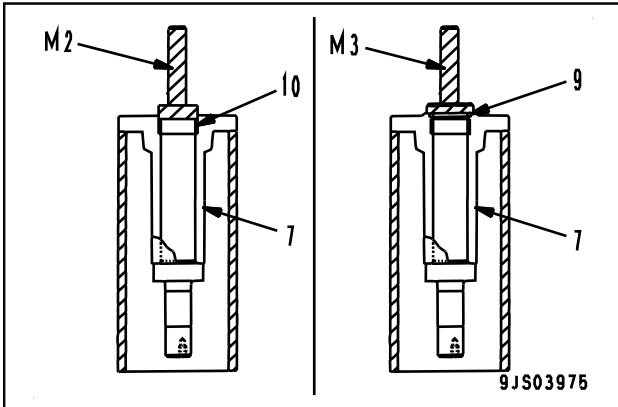
1. Remove piston assembly (2) from idler cushion assembly (1).
2. Disassembling idler cushion assembly
 - 1) Set idler cushion assembly (1) to tool M1.
 - ★ Load at installed length of spring: 137.3 kN {14,010 kg}



- 2) Apply hydraulic pressure gradually to compress the spring and remove lock plate (3) and nut (4).
 - ★ Compress the spring until the nut becomes loose.
 - ★ Release the hydraulic pressure slowly to release the compression of the spring.
 - ★ Free length of spring: 556 mm
- 3) Remove yoke (6), plate (7a) and cylinder (7) from spring (5).
- 4) Remove snap ring (8), dust seal (9) and bushing (10), in turn from cylinder (7).
3. Further disassembly of piston assembly (2)
 - 1) Remove lock plate (12) from piston (11), and then remove valve (13).
 - 2) Remove snap ring (14), then remove U-packing (15) and ring (16).

Assembly (PC200_10-DTBP-710-K-00-A)

1. Assembly of piston (2)
 - 1) Install ring (16) and U-packing (15) to piston (11), and secure them with snap ring (14).
 - 2) Tighten valve (13) lightly, and secure it with lock plate (12).
2. Assembly of idler cushion
 - 1) Using tool M2, press fit bushing (10) into cylinder (7).
 - 2) Using tool M3, install dust seal (9) to cylinder (7).
 - 3) Secure them by using snap ring (8).

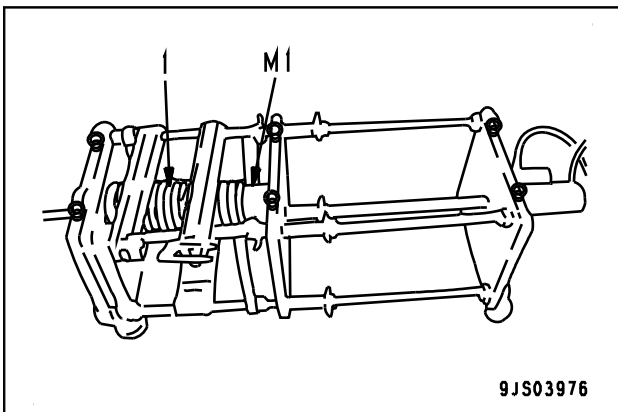


- 4) Install cylinder (7) and yoke (6), plate (7a) to spring (5). Install the assembly to tool M1.



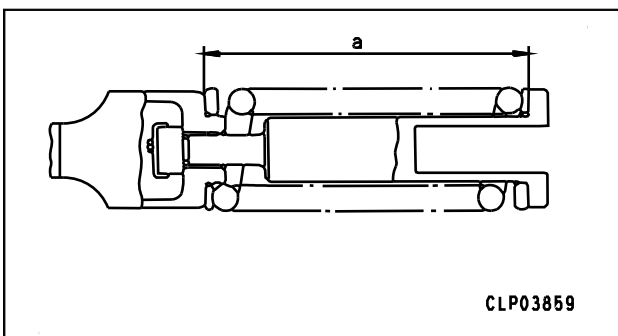
Sliding surface of cylinder:

Grease (G2-LI)



- 5) Apply hydraulic pressure slowly to compress the spring, and then tighten nut (4) so that the installed length of the spring is dimension (a) and secure it with lock plate (3)

★ Installed length (a) of spring: 433 mm



- 6) Remove idler cushion assembly (1) from tool M1.
3. Install piston assembly (2) to idler cushion assembly (1).



Sliding surface of cylinder: :

Grease (G2-LI)



Wear ring:

Grease (G2-LI)

- ★ Install the piston assembly with the valve installed position facing outward.
- ★ Pump 300 cc of grease (G2-LI) into the cylinder and bleed air. Check that grease comes out of the grease hole.