

ECR235C L Volvo			
ECR235D L Volvo			
ECR235E L Volvo			
ECR305C L Volvo			
ECR355E L Volvo			
ECR355E NL Volvo			
EW140E Volvo			
EW150E Volvo			
EW205D Volvo			
EW205E Volvo			
PL3005D Volvo			
PL3005E Volvo			
PL4608 Volvo			
PL4611 Volvo			
PL4809D Volvo			
PL4809E Volvo			

NOTE!

Read and understand the safety instructions in the Operator's Manual and Service Information for the machine.

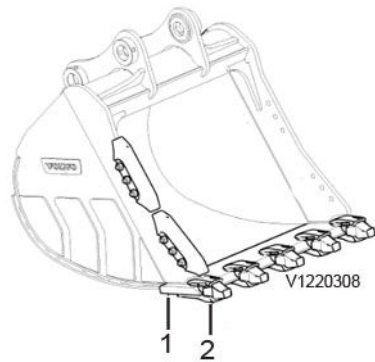


Figure 1

Bucket

1. Front cutting edge plate
2. Adapter

The worn-out adapters should be replaced even if there is no any crack on the front cutting edge plate. Unless those are replaced, cracks would be caused soon on the welding lines of adapters and then the cracks would be progressed to the front cutting edge plate.

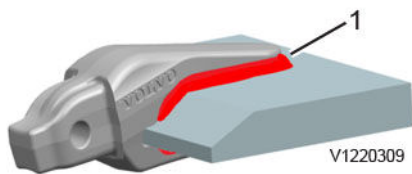


Figure 2

Adapter welding

1. Adapter welding line

Adapter wear measurement

1. Clean the adapter.
2. Measure the height as shown in Fig 3.

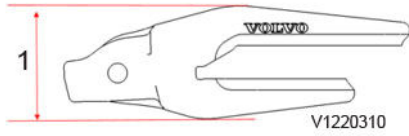


Figure 3

Adapter wear measurement

1. Height

Adapter worn-out dimension

EXC. Grade	Part name	Description	New Adapter height (mm)	Worn-out limit height (mm)
EC140	EA11BL30	30t Adapter	87	45
EC140/160/180	EA16TL30	30t Adapter	97	50
	14527865	30t Adapter	104	69
	14540724	30t Adapter	104	69
EC200/210 EC220/230	EA21TL40	40t Adapter	123	65
	14530543	40t Adapter	124	81
EC250	EA31TL40	40t Adapter	127	65
	14530543	40t Adapter	124	81
EC300	EA41TLW40	40t Adapter	141	75
	EA41TLW50	50t Adapter	146	85
	14530543	40t Adapter	124	81
	14540729	50t Adapter	145	94
EC350/380	EA56TLW50	50t Adapter	156	85
	14540729	50t Adapter	145	94
	14556464	50t Adapter	151	113
EC480	EA66TLW50	50t Adapter	174	90
	EA66TLW60	60t Adapter	173	100
	14556464	50t Adapter	151	113
	14556465	60t Adapter	163	125
EC750	EA81TLW80	80t Adapter	209	120
	14748562	80t Adapter	219	175
EC950	EA126TLW90	90t Adapter	232	120
	EA126TLW100	100t Adapter	236	140
	14746486	100t Adapter	268	213

Work instruction for adapter replacement. (Center side) Consumable

Unalloyed and low-alloyed consumable with tensile strength up to 500 MPa should be used. Such welding consumable reduce the residual stress level in the joint and thus the susceptibility to hydrogen cracking.