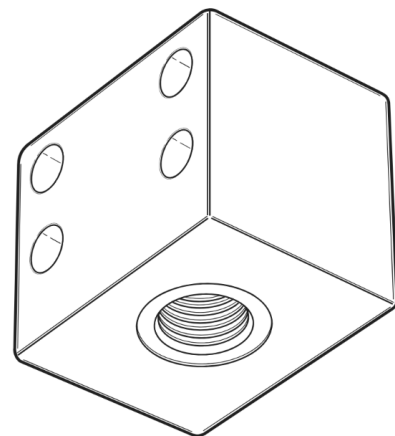
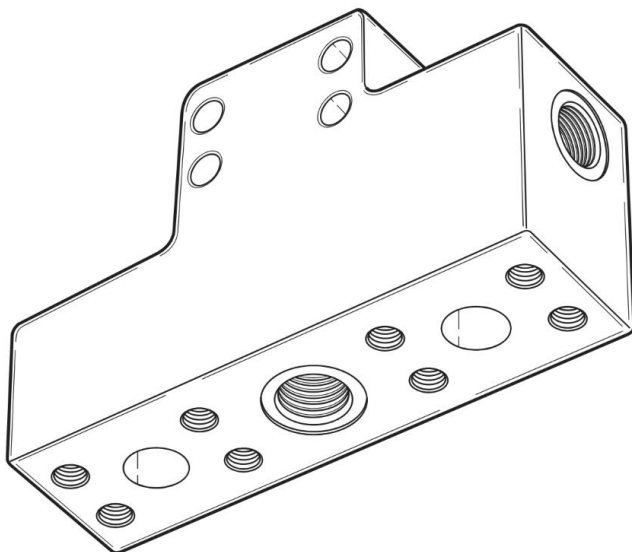




| D.B.R
MECHANICAL

LH517i Lift Cylinder Transfer Block Installation

Please follow all site standard safety requirements, including tagging & isolation procedures & always use the correct equipment/tooling for the task

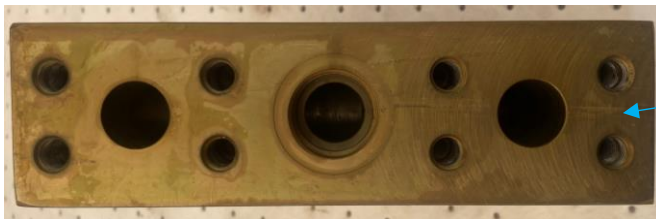


1. Set up the loader on flat level ground, ensure bucket is empty & thoroughly washed out. Raise boom and install boom locks & center articulation lock, rest the weight of the load frame on boom locks, and tilt bucket all the way forwards.
2. Remove OEM lift cylinder steel transfer pipe & lift hoses, as per OEM procedure.



Picture 1

3. Remove, thoroughly clean and inspect lift hoses from the OEM transfer pipe (only reuse lift hoses if found to be in good condition).
4. Thoroughly clean off soft seal/anti-corrosion compound from all mating surfaces on both blocks. See picture 2



Picture 2

Thoroughly clean mating surfaces, free of anti-corrosion compound (solvents can be used)

5. Install $\frac{3}{4}$ BSPP male x 1 $\frac{1}{6}$ JIC male fittings supplied in kit to DBR-01081632-01 Top Block & DBR-01081632-02 (Lower Block) as shown in picture 3



Picture 3

6. Blow lift hoses out with workshop air and install to DBR-01081632-01 Top Block using SF-12 3/4 Code 61/62 O-ring supplied in kit (lightly coat O-ring in rubber grease prior to install), as seen in picture 4. Torque lift hose M10 bolts to 65nm.

Install the 0.98m cut length -12 (3/4) JIC hose supplied in kit to DBR-01081632-01 Top Block, as seen in picture 5. Cover the other ends of hoses to prevent debris from entering before & on install, as in picture 5.



Picture 4



Picture 5

7. Apply rubber grease & install SF-12 3/4 Code 61/62 O-ring supplied in kit to DBR-01081632-02 (Lower Block), as seen in picture 6.
Clean sealing surface on the dead end of the lift cylinder & install DBR-01081632-02 (Lower Block) to the dead end of the lift cylinder using M10 x 70mm bolts supplied in kit, as seen in picture 7.
Torque M10 bolts in a star pattern up to 65nm (leave plastic cap on JIC fitting to prevent debris entering, as seen in picture 7).

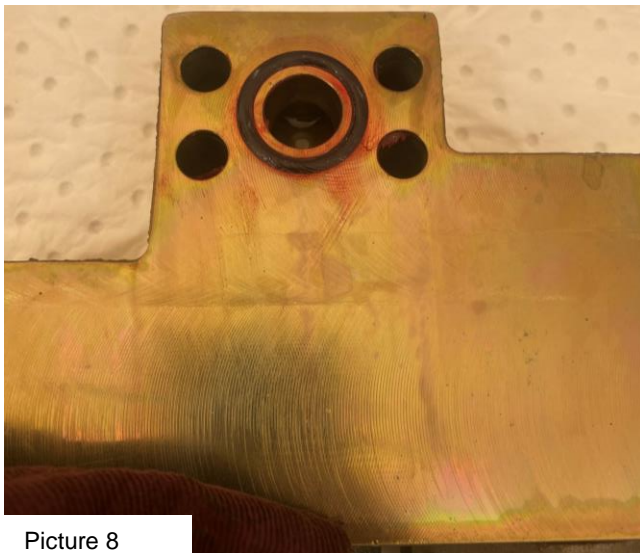


Picture 6



Picture 7

8. Apply rubber grease & install SF-12 3/4 Code 61/62 O-ring supplied in kit to DBR-01081632-01 Top Block, as seen in picture 8.
Clean sealing surface on the top end of the cylinder barrel, guide the 3 hoses down the back of the lift cylinder & secure DBR-01081632-01 Top Block using M10 x 70mm bolts supplied in kit, as seen in picture 9. Torque M10 bolts in a star pattern up to 65nm.
Note – the top transfer block & hoses needs to be installed via entering the rear of the lift cylinder coming over the front frame as per the OEM pipe. Securing the transfer block can be done in the same position or through the side frame access (fitters preference).



Picture 8



Picture 9

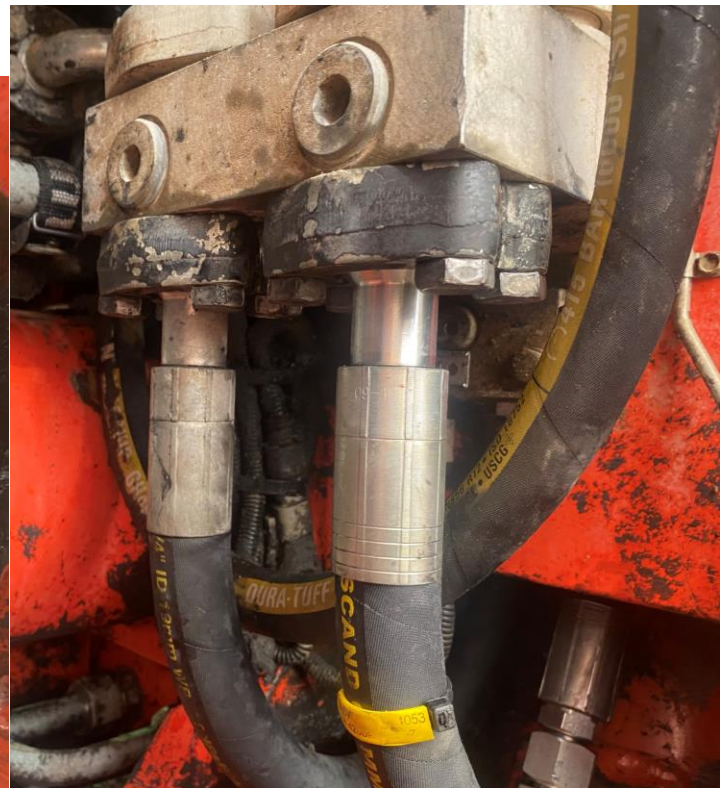
9. Entering the center hitch, remove sample bag from the 3 hoses & plastic cap from JIC fitting on DBR-01081632-02 (Lower Block). Connect -12 ($\frac{3}{4}$) JIC hose to lower block, as seen in picture 10.
10. Clean lift hose fittings, apply rubber grease & install SF-16 61/62 O-rings supplied in kit to lift hose fittings. Clean surface areas on implement block & reinstall lift hoses, as seen in picture 11.

Torque the M12 bolts up to 90nm.

Note – Lift hose arrangement remains the same, left to left & right to right.



Picture 10



Picture 11

Install completed

Prior to the loader being returned to service, it should be ran up in a safe manner & inspected for leaks.

Replacing a blown transfer hose

In the event of a blown transfer hose, please follow this guide to safely replace the hose.

1. Raise boom & empty bucket, tilting forwards whilst raising the boom and reversing loader.
2. Install boom locks, center articulation lock & lower load frame onto boom stops as per OEM procedure.
3. Complete site specific tagging and isolation procedures.
4. Ensure load frame is sitting on the boom locks, and machine is isolated & locked out. With a 32mm or 1 ¼" spanner, remove both ends of blown -12 (¾) hose.
5. Replace -12 (¾) hose with a cut length of 0.98m.
6. From the top block, slide the replacement hose down the middle of the 2 lift hoses, to ensure it does not slide around the front of the cylinder. Tighten both ends to JIC fittings in top & lower blocks.

Note – A -12 JIC nipple joiner connecting the old hose to the new hose can be used as good assistance for pulling the hose through to the center hitch after tightening the top fitting to the top block.