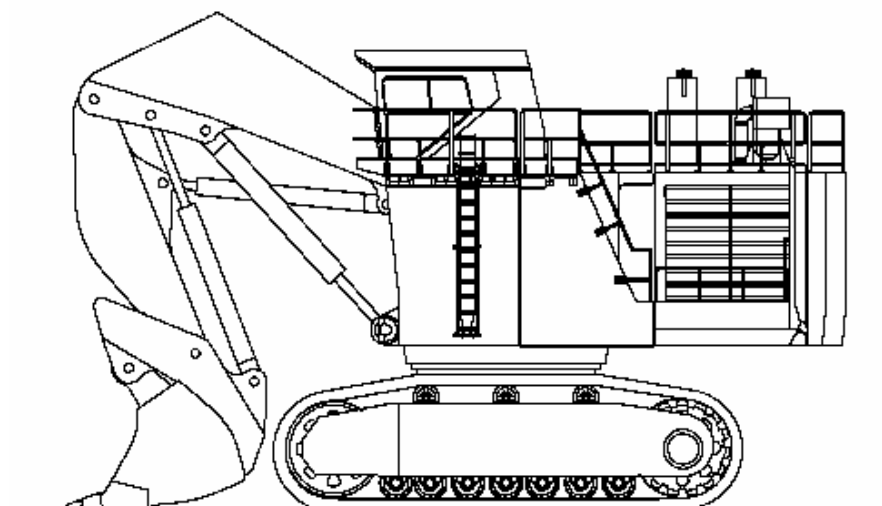
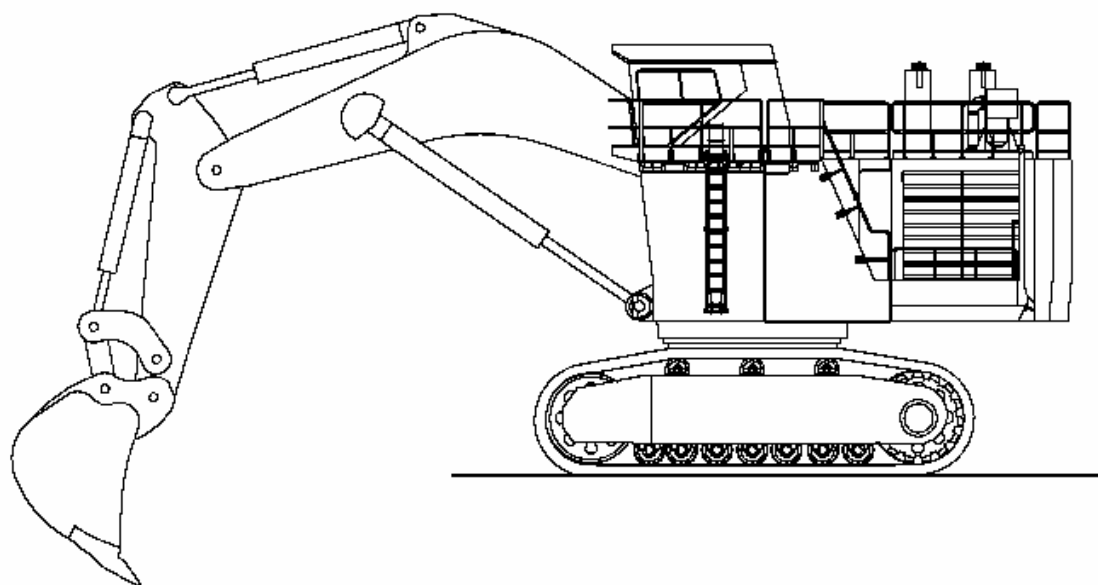
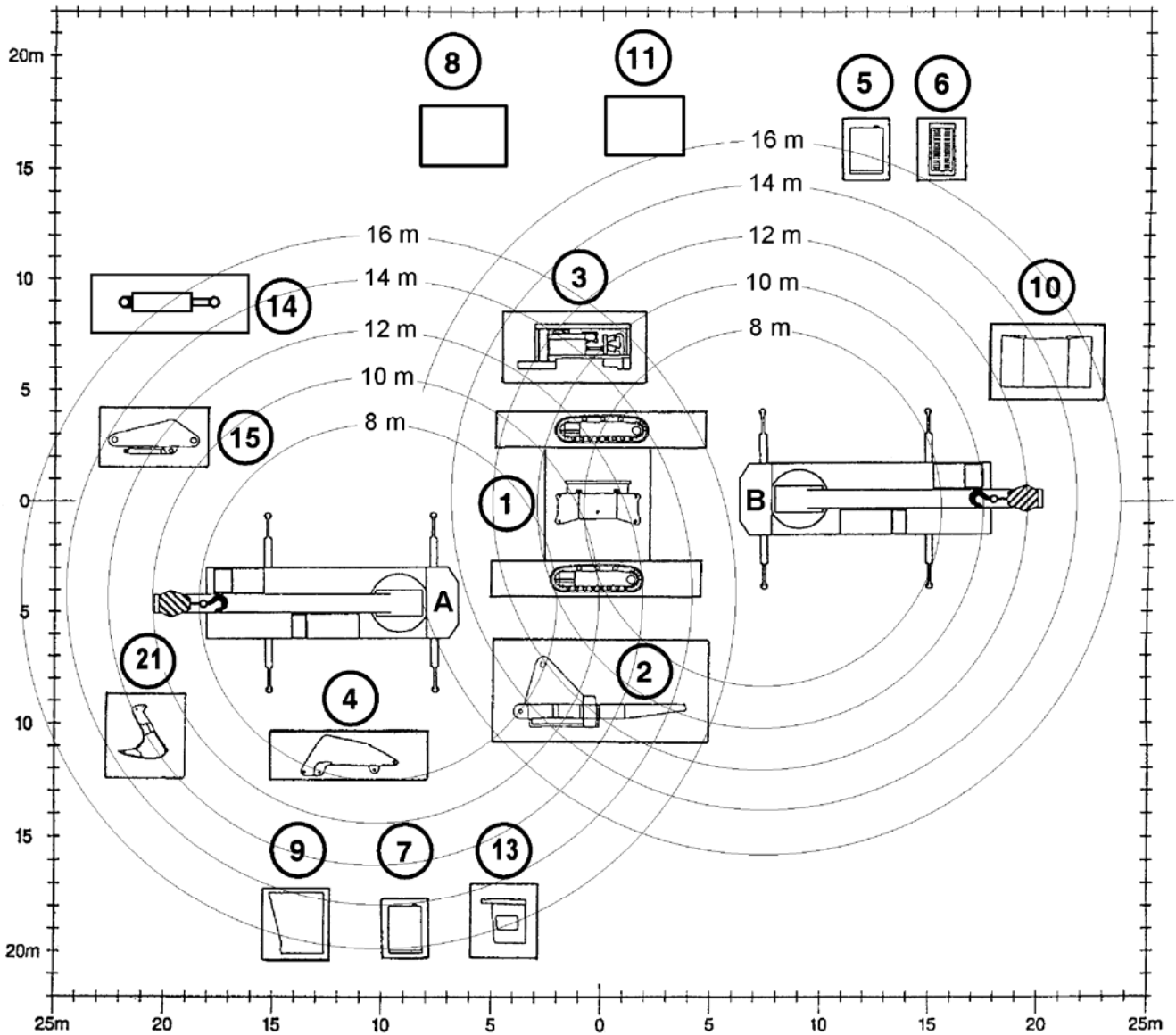


General Assembly Procedure

Hydraulic Mining Shovel PC4000





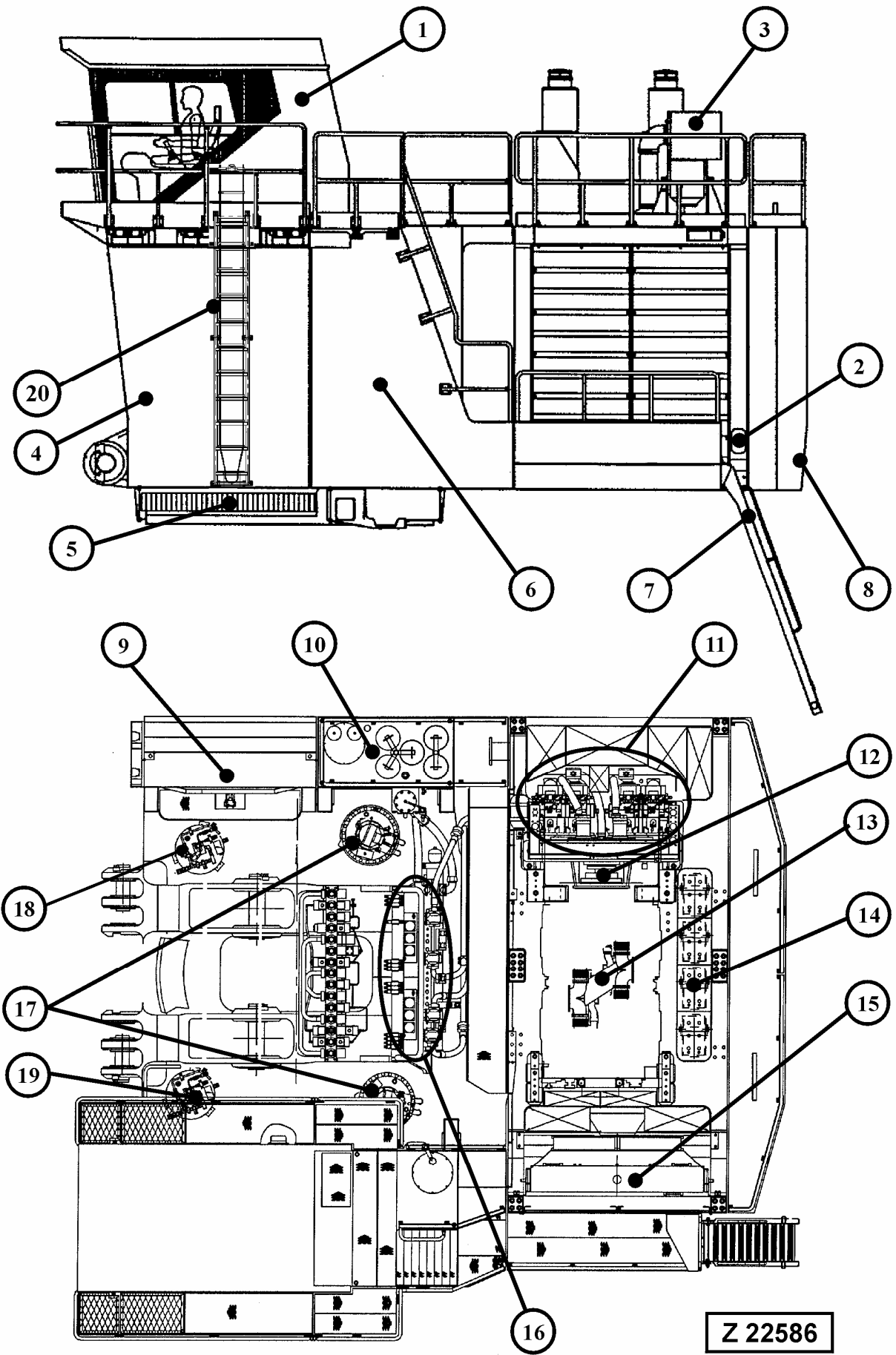
Z23038

All stated information corresponds to the present development and is subject to possible future changes without prior notice.

		PAGE
GENERAL CONTENT		
1.	Overviews	
1.1	Superstructure	5
1.2	Engine House	7
2.	General	
2.1	Delivery of the Excavator	9
2.2	Assembling of the Excavator	9
2.3	Transportation and Lifting	11
2.4	Manpower / Assembly Time	13
2.5	Assembly Site Requirements	15
2.6	Space and Placing Requirements	19
2.7	Preparation for Assembly	19
2.8	Basic Measurements and Weights	19
2.9	Transport Dimensions and Weights	21
3.	Assembly sequence	
3.1.	Assembly of Undercarriage	23
3.1.1	Mounting of travel gear breather filters	25
3.1.2	Track tensioning system	27
3.2	Assembly of Superstructure onto the Undercarriage	29
3.3	Assembly of engine house	31
3.4	Mounting of Boom	33
3.5	Mounting of Hydraulic Oil Tank	35
3.6	Mounting of Hydraulic Oil Cooler	37
3.7	Mounting of Fuel Tank	39
3.8	Mounting of Hydraulic access Ladder	41
3.9	Mounting of Cab Base	43
3.10	Mounting of Counterweight	45
<hr/>		
3.11	Mounting of Handrails, Steps and Gratings	47
3.12	Mounting of Cable transfer to the Operators Cab	49
3.13	Mounting of Cab	53
3.13.1	Mounting of cab air cleaner	55
3.14	Mounting of Bucket Cylinders	57
3.15	Mounting of Stick	59
3.15.1	Mounting of stick (backhoe)	61
3.16	Filling up hydraulic oil tank	63
3.17	Bleed air from all hydraulic tanks	65
3.18	Filling up fuel tank	67
3.19	Pre-checks prior Initial Start-up	69
3.20	Mounting of stick cylinders to the stick	73
3.21	Assembly of Bullclam Bucket to the Stick	75
3.22	Mounting of the pin seals	79
3.22.1	Mounting of pin seals (backhoe)	81
3.23	Connection of the cable harnesses to the terminal rails in the switch box "X2"	83
3.24	Putting the Central Lubrication System into operation	87
3.25	Standard Application Torque Chart	89

↓
2 cranes
↓

↓
1 crane
↓

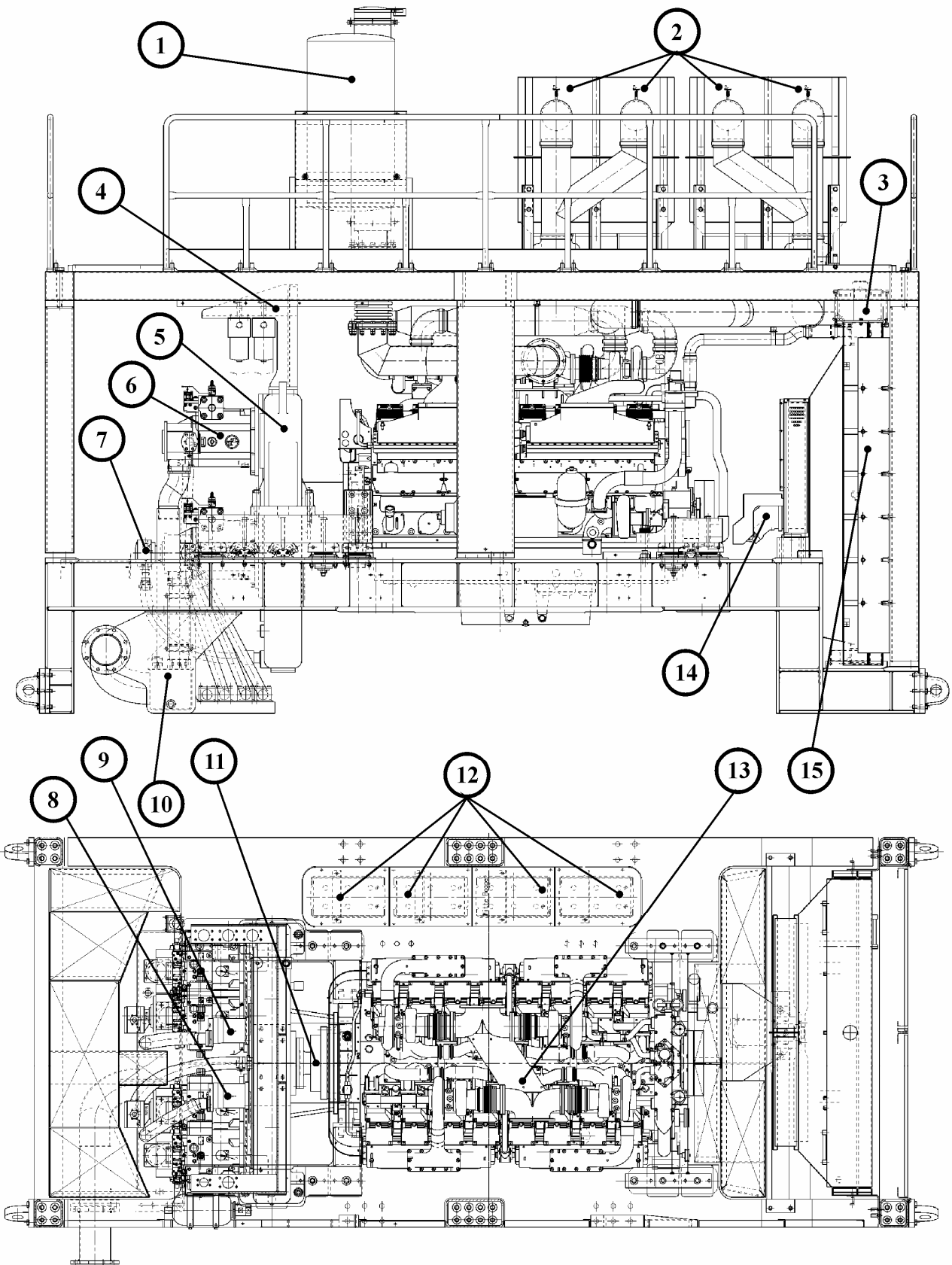


Z 22586

Z22586

1.1 Overview Superstructure (Z22586)

- (1) Operator's cab with Falling Object Protective Structure (FOPS)
- (2) Battery main switches
- (3) Air cleaner for engine
- (4) Cab support, contains the electric control system
- (5) Swing circle
- (6) Fuel tank
- (7) Hydraulically operated access ladder
- (8) Counter weight
- (9) Hydraulic oil cooler
- (10) Hydraulic oil reservoir
- (11) Power take off (PTO) with hydraulic pumps
- (12) Flexible coupling, oil filled
- (13) Diesel engine
- (14) Batteries
- (15) Radiator
- (16) Control valves with high pressure in-line filters
- (17) Swing machinery
- (18) Central lubrication system (CLS)
- (19) Swing circle pinion lubrication system (SLS)
- (20) Emergency escape ladder



Z21446

1.2 Overview Engine House (Z21446)

- (1) Exhaust mufflers
- (2) Engine air cleaner
- (3) Expansion tank for radiator
- (4) Central control and filter carrier
- (5) Power take off (PTO)
- (6) Main hydraulic pumps
- (7) Auxiliary piggyback hydraulic pumps
- (8) Hydraulic pump for radiator fan drive
- (9) Hydraulic pump for the hydraulic oil cooler fan drive
- (10) Suction oil reservoir
- (11) Flex coupling, oil filled
- (12) Batteries
- (13) Diesel engine
- (14) Hydraulic motor for radiator fan drive
- (15) Coolant radiator with fuel cooler section

2. General

2.1 Delivery of the Excavator

The excavator is being delivered disassembled into its main components. For the correct dimensions and weights please refer to the packing list of your machine.

For assembling the excavator follow the instructions in this manual.

2.2 Assembling of the Excavator



- **Personnel entrusted with work on the machine must have read the Assembly Manual, the Operation,- Lubrication- and Maintenance Manual and in particular the section on safety before beginning work. Reading the instructions after work has commenced is too late**

If there are any questions concerning the assembling procedure, contact your local Service Center.

Prior to first operation, inspect the excavator thoroughly with the Service Engineer responsible for the erection of the machine. Check all fluid levels according to the Lubrication and Maintenance Schedule.

Damages and defects caused by incorrect operation and maintenance are not covered by the manufacturers guarantee.



- **If the excavator is equipped with a fire suppression system, make sure that the system is ready for operation.**