

# SHOP MANUAL

# **KOMATSU** **WA380-5**

MACHINE MODEL

SERIAL NUMBER

**WA380-5**

**60001 and up**

- This shop manual may contain attachments and optional equipment that are not available in your area. Please consult your local Komatsu distributor for those items you may require. Materials and specifications are subject to change without notice.
- WA380-5 mounts the SAA6D114E-2 engine. For details of the engine, see the 114 Series Engine Shop Manual.

# CONTENTS

	No. of page
01 GENERAL .....	01-1
10 STRUCTURE, FUNCTION AND MAINTENANCE STANDARD .....	10-1
20 TESTING AND ADJUSTING .....	20-1
30 DISASSEMBLY AND ASSEMBLY .....	30-1
90 OTHERS .....	90-1

The affected pages are indicated by the use of the following marks. It is requested that necessary actions must be taken to these pages according to the list below.

Mark	Indication	Action required
○	Page to be newly added	Add
●	Page to be replaced	Replace
( )	Page to be deleted	Discard

Pages having no marks are not revised at this time.

### LIST OF REVISED PAGES

Mark	Pages	Revision number	Mark	Pages	Revision number	Mark	Pages	Revision number	Mark	Pages	Revision number	Mark	Pages	Revision number
●	00- 1	(8)		10- 5			10-48			10-91			10-134	
	00- 2	(2)		10- 6			10-49			10-92		●	10-135	(8)
●	00- 2-1	(8)		10- 7			10-50			10-93			10-136	
●	00- 2-2	(8)		10- 8			10-51			10-94			10-137	
●	00- 2-3	(8)		10- 9			10-52			10-95			10-138	
●	00- 2-4	(8)		10-10			10-53			10-96	(1)		10-139	
●	00- 2-5	(8)		10-11	(4)		10-54			10-97	(1)		10-140	
	00- 3			10-12			10-55			10-98			10-141	
	00- 4			10-13			10-56			10-99			10-142	
	00- 5			10-14			10-57			10-100			10-143	
	00- 6			10-15	(4)		10-58			10-101			10-144	
	00- 7			10-16	(4)		10-59			10-102			10-145	
	00- 8			10-17			10-60			10-103			10-146	
	00- 9			10-18			10-61			10-104			10-147	
	00-10			10-19			10-62			10-105			10-148	
	00-11			10-20			10-63			10-106			10-149	
	00-12			10-21	(4)		10-64			10-107			10-150	
	00-13			10-22			10-65	(4)		10-108			10-151	
	00-14			10-23			10-66			10-109			10-152	
	00-15			10-24			10-67	(1)		10-110			10-153	
	00-16			10-25			10-68			10-111			10-154	
	00-17			10-26			10-69			10-112			10-155	
	00-18			10-27			10-70			10-113			10-156	
	00-19			10-28	(4)		10-71			10-114			10-157	
	00-20			10-29	(4)		10-72			10-115			10-158	
	00-21			10-30	(4)		10-73			10-116			10-159	
	00-22			10-31	(4)		10-74			10-117			10-159-1	(1)
				10-32	(4)		10-75			10-118			10-159-2	(1)
	01- 1		●	10-34	(8)		10-76			10-119			10-159-3	(1)
●	01- 2	(8)	○	10-34-1	(8)		10-77			10-120	(4)		10-159-4	(1)
●	01- 3	(8)		10-35			10-78		●	10-121	(8)		10-159-5	(1)
	01- 4	(4)	●	10-36	(8)		10-79		●	10-122	(8)		10-159-6	(1)
	01- 5		○	10-36-1	(8)		10-80			10-123			10-160	
●	01- 6	(8)		10-37			10-81			10-124		●	10-161	(8)
●	01- 7	(8)	●	10-38	(8)		10-82			10-125		●	10-162	(8)
	01- 8		●	10-39	(8)		10-83			10-126			10-163	
	01- 9	(4)	●	10-40	(8)		10-84			10-127			10-164	
	01-10	(4)	●	10-41	(8)		10-85			10-128			10-165	
				10-42			10-86			10-129		●	10-166	(8)
●	10- 1	(8)		10-43			10-87		●	10-130	(8)	●	10-167	(8)
	10- 2			10-44	(4)		10-88			10-131			10-168	
	10- 3			10-45	(4)		10-89			10-132			10-169	
	10- 4	(4)		10-46			10-90			10-133			10-170	

Mark	Pages	Revision number	Mark	Pages	Revision number	Mark	Pages	Revision number	Mark	Pages	Revision number	Mark	Pages	Revision number
	10-171			10-231			10-279-2	(1)		20- 8			20-201	(7)
	10-172		●	10-232	(8)		10-279-3	(1)		20- 9			20-202	
	10-173			10-233			10-279-4	(4)		20-101	(7)		20-203	
	10-174			10-234		●	10-280	(8)		20-101-2	(5)		20-204	
	10-175		●	10-235	(8)	●	10-281	(8)		20-102			20-205	
	10-176			10-236		●	10-282	(8)		20-103			20-206	
	10-177			10-236-1	(4)	●	10-283	(8)		20-104			20-207	(5)
	10-178			10-236-2	(4)		10-284	(1)		20-105			20-208	
	10-179		●	10-236-3	(8)	●	10-285	(8)		20-106			20-209	
	10-180			10-236-4	(4)		10-286			20-107	(5)		20-210	
	10-181		●	10-236-5	(8)		10-287			20-108	(5)		20-211	
	10-182			10-236-6	(4)		10-288			20-109			20-212	
	10-183		●	10-236-7	(8)		10-289			20-110			20-214	
	10-184			10-236-8	(4)		10-290			20-111			20-215	
	10-185			10-236-9	(4)		10-291			20-112			20-216	
●	10-186	(8)		10-237			10-292			20-113		●	20-217	(8)
●	10-187	(8)		10-238	(4)		10-293			20-114			20-218	
●	10-188	(8)		10-239			10-294			20-115			20-219	
●	10-189	(8)		10-240			10-295			20-117			20-220	
●	10-190	(8)	●	10-241	(8)	●	10-296	(8)		20-118			20-221	
●	10-191	(8)		10-242			10-297			20-119			20-222	
	10-192		●	10-243	(8)		10-298			20-120			20-223	(5)
	10-193	(4)	●	10-244	(8)	●	10-300	(8)		20-121			20-224	(5)
	10-194	(4)		10-245		●	10-301	(8)		20-122			20-225	(5)
	10-195	(4)		10-246			10-302			20-123			20-226	(5)
	10-196	(4)		10-247			10-303	(4)		20-124			20-227	
	10-197	(4)		10-248			10-304			20-125			20-228	
	10-198	(4)		10-249			10-305			20-126			20-229	
●	10-199	(8)		10-250			10-306			20-127			20-230	
	10-200			10-251			10-307			20-128			20-231	
	10-201	(4)		10-252			10-308			20-129			20-232	
●	10-202	(8)		10-253		●	10-309	(8)		20-130			20-233	
	10-203	(4)		10-254			10-310			20-131			20-234	
●	10-204	(8)		10-255	(1)	●	10-311	(8)		20-132			20-235	
	10-205	(4)		10-256		●	10-312	(8)		20-133			20-236	
	10-206	(4)		10-257		●	10-313	(8)		20-134			20-237	
	10-207		●	10-258	(8)	●	10-314	(8)		20-135		●	20-238	(8)
	10-208			10-259		●	10-315	(8)		20-136			20-239	(7)
●	10-209	(8)	●	10-260	(8)	●	10-316	(8)		20-137			20-240	
●	10-210	(8)		10-261		●	10-317	(8)		20-138	(5)		20-241	(1)
	10-211			10-262		●	10-318	(8)		20-139			20-242	(1)
●	10-212	(8)		10-263		●	10-319	(8)		20-140	(5)		20-244	
●	10-213	(8)		10-264		●	10-320	(8)		20-141			20-245	
	10-214			10-265		●	10-321	(8)		20-142	(5)	●	20-246	(8)
	10-215	(4)		10-266	(4)	●	10-322	(8)		20-143			20-247	
	10-216			10-267		●	10-323	(8)		20-144			20-248	
	10-217	(4)	●	10-268	(8)	●	10-324	(8)		20-145			20-249	(7)
	10-218			10-269		●	10-325	(8)		20-146			20-249-1	(5)
	10-219	(4)	●	10-270	(8)	●	10-326	(8)		20-147			20-249-2	(5)
	10-220	(4)		10-271		●	10-327	(8)		20-148			20-249-3	(5)
	10-221	(4)		10-272			(10-328)			20-149			20-249-4	(5)
	10-222	(4)	●	10-273	(8)					20-150	(6)		20-250	(5)
	10-224			10-274			20- 1			20-151	(7)		20-251	(5)
	10-225			10-275			20- 2	(7)		20-152	(7)		20-252	
	10-226			10-276			20- 3			20-153	(7)		20-254	(7)
●	10-227	(8)		10-277			20- 4			20-154	(5)		20-255	
●	10-228	(8)		10-278			20- 5			20-155	(5)		20-256	
●	10-229	(8)		10-279			20- 6			20-156	(7)		20-257	(7)
	10-230	(4)		10-279-1	(1)		20- 7	(7)		20-157	(7)		20-258	

Mark	Pages	Revision number	Mark	Pages	Revision number	Mark	Pages	Revision number	Mark	Pages	Revision number	Mark	Pages	Revision number
	20-256			20-339			20-396	(7)		20-509	(5)		20-570	
	20-257	(7)		20-340			20-397	(7)		20-510	(5)		20-571	
	20-258			20-341			20-398	(7)		20-512			20-572	
	20-259			20-342			20-399	(7)		20-513	(5)		20-573	
	20-260			20-344	(1)		20-400	(7)		20-514	(5)		20-574	
	20-261			20-345	(1)		20-401	(7)		20-515	(5)		20-575	
	20-262			20-346	(1)		20-402	(7)		20-516	(5)		20-576	
	20-263			20-347			20-403	(7)		20-517	(5)		20-577	
	20-264			20-348			20-404	(7)		20-518			20-578	
	20-265			20-349			20-405	(7)		20-519			20-579	
	20-266			20-349-1	(5)		20-406			20-520			20-580	
	20-267	(5)		20-349-2	(5)		20-407			20-521			20-581	
	20-268	(5)		20-350			20-408			20-522			20-582	(5)
	20-269	(5)		20-351			20-409			20-523	(5)		20-583	(5)
	20-270	(5)		20-352			20-410	(5)		20-524	(5)		20-584	(5)
	20-271	(5)		20-354	(1)		20-410-1	(5)		20-526			20-585	(5)
	20-272	(5)		20-355	(1)		20-410-2	(5)		20-527			20-586	(5)
	20-273	(7)		20-356	(1)		20-411	(5)		20-528			20-587	(5)
	20-274	(5)		20-356-1	(1)		20-412	(5)		20-529			20-588	(5)
	20-275	(5)		20-357			20-414	(5)		20-530			20-589	(5)
	20-276	(5)		20-358			20-415	(5)		20-531			20-590	(5)
	20-277	(7)		20-359			20-416	(5)		20-532			20-591	(5)
	20-301	(5)		20-360			20-417	(5)		20-533			20-592	(5)
	20-302	(5)		20-361			20-418	(5)		20-534			20-593	(5)
	20-302-1	(5)		20-362			20-419	(5)		20-535			20-594	(5)
	20-303	(5)		20-363			20-420	(5)		20-536			20-596	(5)
	20-304	(5)		20-364			20-421	(5)		20-537			20-597	(5)
	20-305	(5)		20-365			20-422	(5)		20-538			20-598	(5)
	20-306	(5)		20-366	(5)		20-423	(7)		20-539			20-599	(5)
	20-307	(5)		20-367	(5)		20-424	(5)		20-540			20-600	(5)
	20-308	(5)		20-368			20-426	(5)		20-541			20-601	(5)
	20-309	(5)		20-369			20-427	(5)		20-542			20-602	(5)
	20-310	(5)		20-370			20-428	(5)		20-543			20-603	(5)
	20-312			20-371	(1)		20-429	(5)		20-544			20-604	(5)
	20-313	(5)		20-371-1	(1)		20-430	(5)		20-545			20-605	(5)
	20-314	(5)		20-372	(1)		20-431	(5)		20-546			20-606	(5)
	20-315	(5)		20-373	(5)		20-432	(5)		20-547			20-607	(5)
	20-316	(5)		20-374			20-433	(5)		20-548			20-608	(5)
	20-317	(5)		20-375			20-434	(5)		20-549			20-609	(5)
	20-318	(5)		20-376			20-435	(5)		20-550			20-610	(5)
	20-319	(5)		20-377			20-436	(7)		20-551			20-611	(5)
	20-320			20-378			20-437	(7)		20-552	(5)		20-612	(5)
	20-321			20-379			20-438	(7)		20-553	(5)		20-613	(5)
	20-322			20-380			20-439	(7)		20-554			20-614	(5)
	20-323			20-381			20-440	(5)		20-555			20-615	(5)
	20-324			20-382			20-441	(7)		20-556			20-616	(5)
	20-325			20-383			20-442	(7)		20-557			20-617	(5)
	20-326			20-384			20-443	(7)		20-558			20-618	(5)
	20-327			20-385			20-444	(5)		20-559			20-619	(5)
	20-328			20-386			20-445	(5)		20-560			20-701	(5)
	20-329			20-387			20-501	(5)		20-561			20-702	(5)
	20-330			20-388			20-502	(5)		20-562			20-703	(5)
	20-331			20-389			20-502-1	(5)		20-563			20-704	(5)
	20-332			20-390			20-503	(5)		20-564			20-705	(5)
	20-333			20-391			20-504	(5)		20-565			20-706	(5)
	20-334			20-392	(7)		20-505	(5)		20-566			20-707	(5)
	20-335			20-393	(7)		20-506	(5)		20-567			20-708	(5)
	20-336			20-394	(7)		20-507	(5)		20-568			20-709	(5)
	20-338			20-395	(7)		20-508	(5)		20-569			20-710	(5)

Mark	Pages	Revision number	Mark	Pages	Revision number	Mark	Pages	Revision number	Mark	Pages	Revision number	Mark	Pages	Revision number
	20-712			20-773			20-907	(5)		20-1016	(7)		30- 49	(2)
	20-713	(5)		20-774	(7)		20-908	(5)		20-1017	(7)		30- 50	(2)
	20-714	(5)		20-775			20-909	(5)		20-1018	(7)		30- 51	(2)
	20-715	(5)		20-776	(5)		20-910	(5)		20-1019	(7)		30- 52	(2)
	20-716	(5)		20-777	(5)		20-912			20-1020	(7)		30- 53	(2)
	20-717	(5)		20-778	(5)		20-913	(5)		20-1021	(7)		30- 54	(2)
	20-718			20-779	(5)		20-914	(5)		20-1022	(7)		30- 55	(2)
	20-719			20-780	(5)		20-915	(5)		20-1023	(7)		30- 56	(2)
	20-720			20-781	(5)		20-916	(5)		30- 1	(7)		30- 57	(2)
	20-721			20-782	(5)		20-917	(5)		30- 2	(2)		30- 58	(2)
	20-722	(5)		20-783	(5)		20-918			30- 3	(5)		30- 59	(2)
	20-723	(5)		20-784	(5)		20-920	(5)		30- 4	(2)		30- 60	(2)
	20-724	(5)		20-785	(5)		20-921	(5)		30- 5	(2)		30- 61	(2)
	20-725	(5)		20-786	(5)		20-922	(5)		30- 5-2	(5)		30- 62	(2)
	20-726			20-787	(5)		20-923	(5)		30- 5-3	(5)		30- 63	(2)
	20-727			20-788	(5)		20-924	(5)		30- 5-4	(5)		30- 64	(2)
	20-728			20-789	(5)		20-925	(5)		30- 6	(2)		30- 65	(2)
	20-729			20-790	(5)		20-926	(5)		30- 7	(2)	●	30- 66	(8)
	20-730			20-791	(5)		20-927	(5)		30- 8	(2)		30- 67	(2)
	20-731			20-792	(5)		20-928	(7)		30- 9	(2)		30- 68	(2)
	20-732			20-793	(5)		20-929	(7)		30- 10	(2)	●	30- 69	(8)
	20-733			20-794	(5)		20-930	(5)		30- 11	(2)	●	30- 70	(8)
	20-734			20-795	(7)		20-931	(5)		30- 12	(2)		30- 71	(2)
	20-735			20-796	(7)		20-932	(5)		30- 13	(2)		30- 72	(2)
	20-736			20-797	(5)		20-933	(5)		30- 14	(2)		30- 73	(2)
	20-737		●	20-801	(8)		20-934	(5)		30- 15	(2)		30- 74	(2)
	20-738		●	20-802	(8)		20-935	(5)		30- 16	(2)		30- 75	(2)
	20-739		●	20-803	(8)		20-936	(5)		30- 17	(2)		30- 76	(2)
	20-740		●	20-804	(8)		20-937	(5)		30- 18	(2)		30- 77	(2)
	20-741		●	20-805	(8)		20-938	(5)		30- 19	(2)		30- 78	(2)
	20-742	(5)	●	20-806	(8)		20-939	(5)		30- 20	(2)		30- 79	(2)
	20-744	(7)	●	20-807	(8)		20-940	(5)		30- 21	(2)		30- 80	(2)
	20-745		●	20-808	(8)		20-941	(5)		30- 22	(2)		30- 81	(2)
	20-746		●	20-809	(8)		20-942	(5)		30- 23	(2)		30- 82	(2)
	20-747		●	20-810	(8)		20-943	(5)		30- 24	(2)		30- 83	(2)
	20-748		●	20-811	(8)		20-944	(5)		30- 25	(2)		30- 84	(2)
	20-749		●	20-812	(8)		20-945	(5)		30- 26	(2)		30- 85	(2)
	20-750		●	20-813	(8)		20-946	(5)		30- 27	(2)		30- 86	(2)
	20-751		●	20-814	(8)		20-947	(5)		30- 28	(2)		30- 87	(2)
	20-752		●	20-815	(8)		20-948	(5)		30- 29	(2)		30- 88	(2)
	20-753		●	20-816	(8)		20-949	(5)		30- 30	(2)		30- 89	(2)
	20-754		●	20-817	(8)		20-950	(5)		30- 31	(2)		30- 90	(2)
	20-755		●	20-818	(8)		20-951	(5)		30- 32	(2)		30- 91	(2)
	20-756	(5)	●	20-819	(8)		20-952	(5)		30- 33	(2)		30- 92	(2)
	20-757	(5)	●	20-820	(8)		20-1001	(7)		30- 34	(2)		30- 93	(2)
	20-758	(5)	●	20-821	(8)		20-1002	(7)		30- 35	(2)	●	30- 94	(8)
	20-759	(5)	●	20-822	(8)		20-1003	(7)		30- 36	(5)		30- 95	(2)
	20-760	(5)	●	20-823	(8)		20-1004	(7)		30- 37	(2)		30- 96	(2)
	20-761	(5)	●	20-824	(8)		20-1005	(7)		30- 38	(2)		30- 97	(2)
	20-762		●	20-825	(8)		20-1006	(7)		30- 39	(2)		30- 98	(2)
	20-763		●	20-826	(8)		20-1007	(7)		30- 40	(5)		30- 99	(2)
	20-764		●	20-827	(8)		20-1008	(7)		30- 41	(2)		30-100	(2)
	20-765			(20-828)			20-1009	(7)		30- 42	(5)		30-101	(2)
	20-766			(20-829)			20-1010	(7)		30- 43	(2)		30-102	(2)
	20-768	(7)		20-901	(5)		20-1011	(7)		30- 44	(2)		30-103	(2)
	20-769	(5)		20-903	(5)		20-1012	(7)		30- 45	(2)		30-104	(2)
	20-770	(7)		20-904	(5)		20-1013	(7)		30- 46	(2)		30-105	(2)
	20-771	(5)		20-905	(5)		20-1014	(7)		30- 47	(2)		30-106	(2)
	20-772	(5)		20-906	(5)		20-1015	(7)		30- 48	(2)		30-107	(2)

Mark	Pages	Revision number	Mark	Pages	Revision number	Mark	Pages	Revision number	Mark	Pages	Revision number	Mark	Pages	Revision number
	30-108	(2)	●	90- 19	(8)									
	30-109	(2)		90- 21	(4)									
	30-110	(2)		90- 23	(4)									
●	30- 111	(8)		90- 25	(4)									
	30-112	(2)	●	90- 27	(8)									
	30-113	(2)		90- 29	(4)									
	30-114	(2)		90- 31	(4)									
	30-115	(2)		90- 33	(4)									
	30-116	(2)		90- 35	(4)									
	30-117	(2)		90- 37	(4)									
	30-118	(2)		90- 39	(4)									
	30-119	(2)												
	30-120	(2)												
	30-121	(2)												
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	90- 5	(4)												
	90- 7													
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	90- 11													
	90- 13	(4)												
	90- 15	(4)												
	90- 17	(4)												






# SAFETY

## SAFETY NOTICE

### IMPORTANT SAFETY NOTICE

Proper service and repair is extremely important for safe machine operation. The service and repair techniques recommended by Komatsu and described in this manual are both effective and safe. Some of these techniques require the use of tools specially designed by Komatsu for the specific purpose.

To prevent injury to workers, the symbol  is used to mark safety precautions in this manual. The cautions accompanying these symbols should always be followed carefully. If any dangerous situation arises or may possibly arise, first consider safety, and take the necessary actions to deal with the situation.

### GENERAL PRECAUTIONS

Mistakes in operation are extremely dangerous. Read the Operation and Maintenance Manual carefully BEFORE operating the machine.

1. Before carrying out any greasing or repairs, read all the precautions given on the decals which are fixed to the machine.
2. When carrying out any operation, always wear safety shoes and helmet. Do not wear loose work clothes, or clothes with buttons missing.
  - Always wear safety glasses when hitting parts with a hammer.
  - Always wear safety glasses when grinding parts with a grinder, etc.
3. If welding repairs are needed, always have a trained, experienced welder carry out the work. When carrying out welding work, always wear welding gloves, apron, hand shield, cap and other clothes suited for welding work.
4. When carrying out any operation with two or more workers, always agree on the operating procedure before starting. Always inform your fellow workers before starting any step of the operation. Before starting work, hang UNDER REPAIR signs on the controls in the operator's compartment.
5. Keep all tools in good condition and learn the correct way to use them.

6. Decide a place in the repair workshop to keep tools and removed parts. Always keep the tools and parts in their correct places. Always keep the work area clean and make sure that there is no dirt or oil on the floor. Smoke only in the areas provided for smoking. Never smoke while working.

### PREPARATIONS FOR WORK

7. Before adding oil or making any repairs, park the machine on hard, level ground, and block the wheels or tracks to prevent the machine from moving.
8. Before starting work, lower blade, ripper, bucket or any other work equipment to the ground. If this is not possible, insert the safety pin or use blocks to prevent the work equipment from falling. In addition, be sure to lock all the control levers and hang warning signs on them.
9. When disassembling or assembling, support the machine with blocks, jacks or stands before starting work.
10. Remove all mud and oil from the steps or other places used to get on and off the machine. Always use the handrails, ladders or steps when getting on or off the machine. Never jump on or off the machine. If it is impossible to use the handrails, ladders or steps, use a stand to provide safe footing.

**PRECAUTIONS DURING WORK**

11. When removing the oil filler cap, drain plug or hydraulic pressure measuring plugs, loosen them slowly to prevent the oil from spurting out. Before disconnecting or removing components of the oil, water or air circuits, first remove the pressure completely from the circuit.
12. The water and oil in the circuits are hot when the engine is stopped, so be careful not to get burned.  
Wait for the oil and water to cool before carrying out any work on the oil or water circuits.
13. Before starting work, remove the leads from the battery. Always remove the lead from the negative (-) terminal first.
14. When raising heavy components, use a hoist or crane.  
Check that the wire rope, chains and hooks are free from damage.  
Always use lifting equipment which has ample capacity.  
Install the lifting equipment at the correct places.  
Use a hoist or crane and operate slowly to prevent the component from hitting any other part.  
Do not work with any part still raised by the hoist or crane.
15. When removing covers which are under internal pressure or under pressure from a spring, always leave two bolts in position on opposite sides. Slowly release the pressure, then slowly loosen the bolts to remove.
16. When removing components, be careful not to break or damage the wiring. Damaged wiring may cause electrical fires.
17. When removing piping, stop the fuel or oil from spilling out. If any fuel or oil drips onto the floor, wipe it up immediately. Fuel or oil on the floor can cause you to slip, or can even start fires.
18. As a general rule, do not use gasoline to wash parts. In particular, use only the minimum of gasoline when washing electrical parts.
19. Be sure to assemble all parts again in their original places.  
Replace any damaged parts with new parts.
  - When installing hoses and wires, be sure that they will not be damaged by contact with other parts when the machine is being operated.
20. When installing high pressure hoses, make sure that they are not twisted. Damaged tubes are dangerous, so be extremely careful when installing tubes for high pressure circuits. Also, check that connecting parts are correctly installed.
21. When assembling or installing parts, always use the specified tightening torques. When installing protective parts such as guards, or parts which vibrate violently or rotate at high speed, be particularly careful to check that they are installed correctly.
22. When aligning two holes, never insert your fingers or hand. Be careful not to get your fingers caught in a hole.
23. When measuring hydraulic pressure, check that the measuring tool is correctly assembled before taking any measurements.
24. Take care when removing or installing the tracks of track-type machines.  
When removing the track, the track separates suddenly, so never let anyone stand at either end of the track.

# FOREWORD

## GENERAL

This shop manual has been prepared as an aid to improve the quality of repairs by giving the serviceman an accurate understanding of the product and by showing him the correct way to perform repairs and make judgments. Make sure you understand the contents of this manual and use it to full effect at every opportunity.

This shop manual mainly contains the necessary technical information for operations performed in a service workshop. For ease of understanding, the manual is divided into the following chapters; these chapters are further divided into the each main group of components.

### STRUCTURE AND FUNCTION

This section explains the structure and function of each component. It serves not only to give an understanding of the structure, but also serves as reference material for troubleshooting.

In addition, this section may contain hydraulic circuit diagrams, electric circuit diagrams, and maintenance standards.

### TESTING AND ADJUSTING

This section explains checks to be made before and after performing repairs, as well as adjustments to be made at completion of the checks and repairs.

Troubleshooting charts correlating "Problems" with "Causes" are also included in this section.

### DISASSEMBLY AND ASSEMBLY

This section explains the procedures for removing, installing, disassembling and assembling each component, as well as precautions for them.

### MAINTENANCE STANDARD

This section gives the judgment standards for inspection of disassembled parts.

The contents of this section may be described in STRUCTURE AND FUNCTION.

### OTHERS

This section mainly gives hydraulic circuit diagrams and electric circuit diagrams.

In addition, this section may give the specifications of attachments and options together.

### NOTICE

The specifications contained in this shop manual are subject to change at any time and without any advance notice. Use the specifications given in the book with the latest date.

**HOW TO READ THE SHOP MANUAL**

**VOLUMES**

Shop manuals are issued as a guide to carrying out repairs. They are divided as follows:

- Chassis volume:** Issued for every machine model
- Engine volume:** Issued for each engine series
- Electrical volume:** } Each issued as one
- Attachments volume:** } volume to cover all models

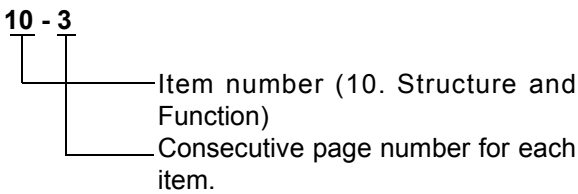
These various volumes are designed to avoid duplicating the same information. Therefore, to deal with all repairs for any model, it is necessary that chassis, engine, electrical and attachment volumes be available.

**DISTRIBUTION AND UPDATING**

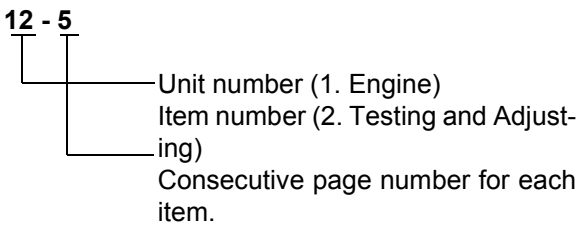
Any additions, amendments or other changes will be sent to KOMATSU distributors. Get the most up-to-date information before you start any work.

**FILING METHOD**

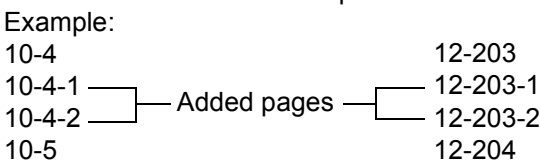
1. See the page number on the bottom of the page. File the pages in correct order.
2. Following examples show how to read the page number.  
Example 1 (Chassis volume):



Example 2 (Engine volume):



3. Additional pages: Additional pages are indicated by a hyphen (-) and number after the page number. File as in the example.



**REVISED EDITION MARK**

When a manual is revised, an edition mark (①②③....) is recorded on the bottom of the pages.

**REVISIONS**

Revised pages are shown in the LIST OF REVISED PAGES next to the CONTENTS page.


**SYMBOLS**

So that the shop manual can be of ample practical use, important safety and quality portions are marked with the following symbols.

Symbol	Item	Remarks
	Safety	Special safety precautions are necessary when performing the work.
	Caution	Special technical precautions or other precautions for preserving standards are necessary when performing the work.
	Weight	Weight of parts of systems. Caution necessary when selecting hoisting wire, or when working posture is important, etc.
	Tightening torque	Places that require special attention for the tightening torque during assembly.
	Coat	Places to be coated with adhesives and lubricants, etc.
	Oil, water	Places where oil, water or fuel must be added, and the capacity.
	Drain	Places where oil or water must be drained, and quantity to be drained.

HOISTING INSTRUCTIONS

HOISTING

**!** Heavy parts (25 kg or more) must be lifted with a hoist, etc. In the **DISASSEMBLY AND ASSEMBLY** section, every part weighing 25 kg or more is indicated clearly with the symbol 

- If a part cannot be smoothly removed from the machine by hoisting, the following checks should be made:
  - 1) Check for removal of all bolts fastening the part to the relative parts.
  - 2) Check for existence of another part causing interference with the part to be removed.

WIRE ROPES

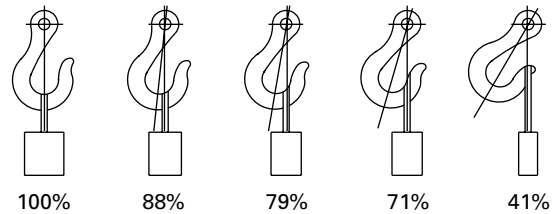
- 1) Use adequate ropes depending on the weight of parts to be hoisted, referring to the table below:

Wire ropes  
(Standard "Z" or "S" twist ropes  
without galvanizing)

Rope diameter	Allowable load	
	mm	kN
10	9.8	1.0
11.5	13.7	1.4
12.5	15.7	1.6
14	21.6	2.2
16	27.5	2.8
18	35.3	3.6
20	43.1	4.4
22.4	54.9	5.6
30	98.1	10.0
40	176.5	18.0
50	274.6	28.0
60	392.2	40.0

- ★ The allowable load value is estimated to be one-sixth or one-seventh of the breaking strength of the rope used.
- 2) Sling wire ropes from the middle portion of the hook.

Slinging near the edge of the hook may cause the rope to slip off the hook during hoisting, and a serious accident can result. Hooks have maximum strength at the middle portion.



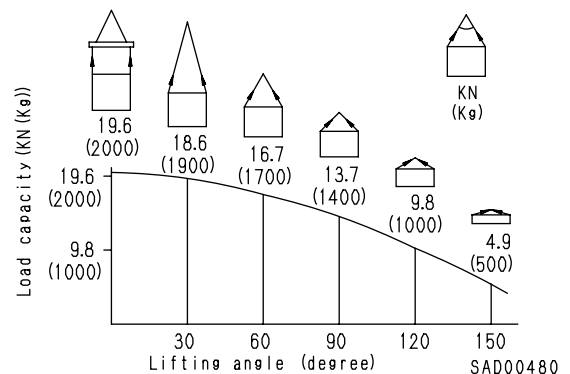
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- 3) Do not sling a heavy load with one rope alone, but sling with two or more ropes symmetrically wound onto the load.

**!** Slinging with one rope may cause turning of the load during hoisting, untwisting of the rope, or slipping of the rope from its original winding position on the load, which can result in a dangerous accident.

- 4) Do not sling a heavy load with ropes forming a wide hanging angle from the hook.

When hoisting a load with two or more ropes, the force subjected to each rope will increase with the hanging angles. The table below shows the variation of allowable load kN {kg} when hoisting is made with two ropes, each of which is allowed to sling up to 9.8 kN {1000 kg} vertically, at various hanging angles. When two ropes sling a load vertically, up to 19.6 kN {2000 kg} of total weight can be suspended. This weight becomes 9.8 kN {1000 kg} when two ropes make a 120° hanging angle. On the other hand, two ropes are subjected to an excessive force as large as 39.2 kN {4000 kg} if they sling a 19.6 kN {2000 kg} load at a lifting angle of 150°.



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## METHOD OF DISASSEMBLING, CONNECTING PUSH-PULL TYPE COUPLER

**!** Before carrying out the following work, release the residual pressure from the hydraulic tank. For details, see TESTING AND ADJUSTING, Releasing residual pressure from hydraulic tank.

**!** Even if the residual pressure is released from the hydraulic tank, some hydraulic oil flows out when the hose is disconnected. Accordingly, prepare an oil receiving container.

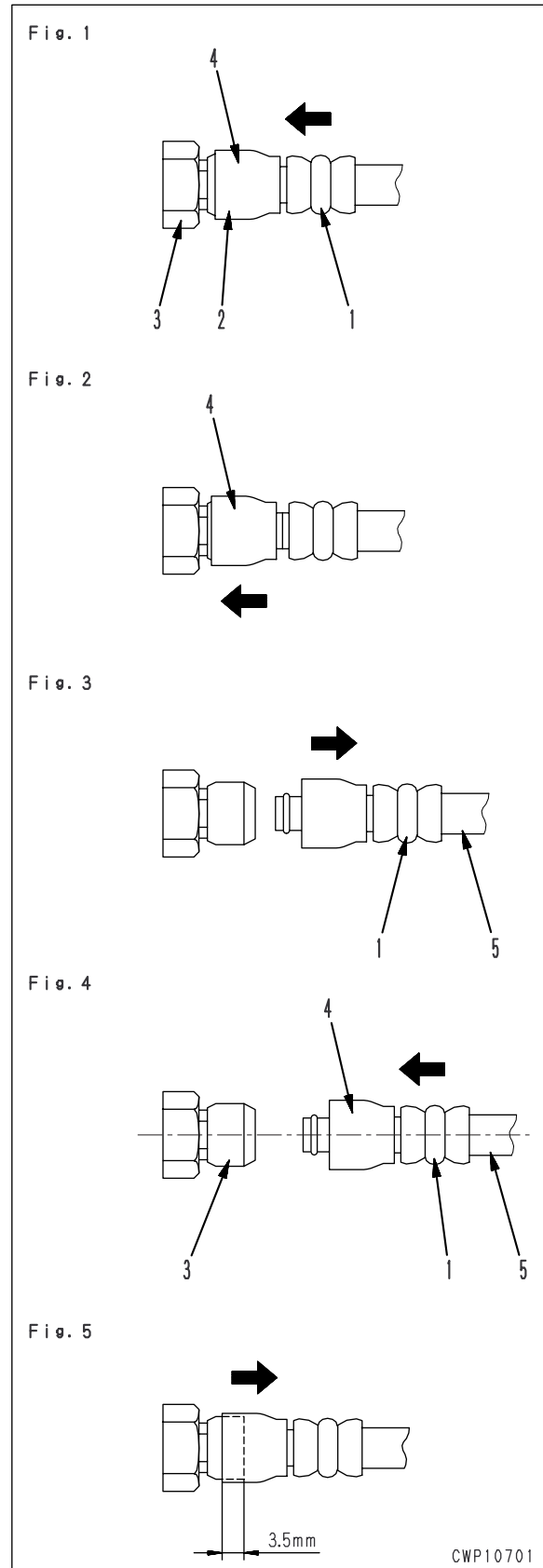
**Disconnection**

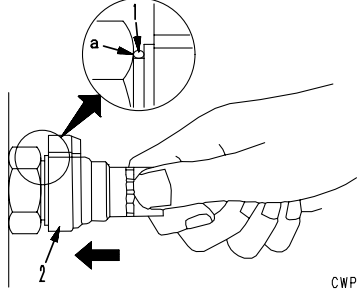
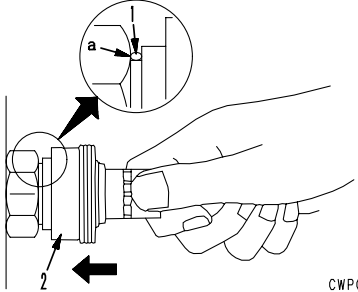
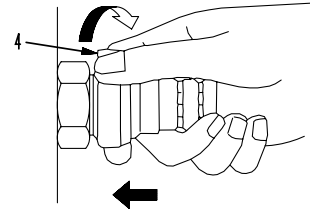
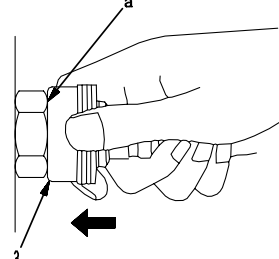
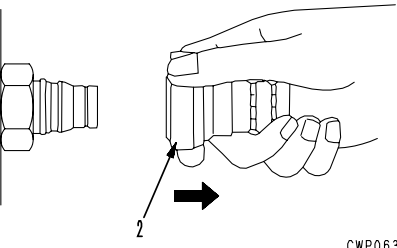
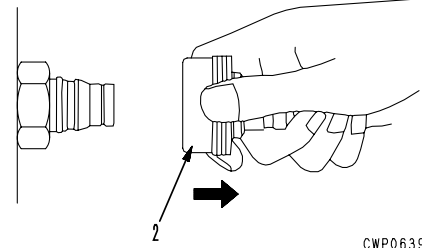
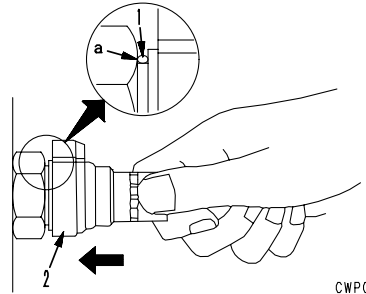
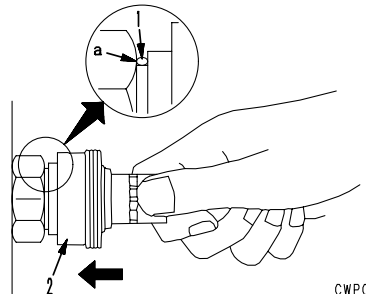
- 1) Release the residual pressure from the hydraulic tank. For details, see TESTING AND ADJUSTING, Releasing residual pressure from hydraulic tank.
- 2) Hold adapter (1) and push hose joint (2) into mating adapter (3). (See Fig. 1)
  - ★ The adapter can be pushed in about 3.5 mm.
  - ★ Do not hold rubber cap portion (4).
- 3) After hose joint (2) is pushed into adapter (3), press rubber cap portion (4) against (3) until it clicks. (See Fig. 2)
- 4) Hold hose adapter (1) or hose (5) and pull it out. (See Fig. 3)
  - ★ Since some hydraulic oil flows out, prepare an oil receiving container.

**Connection**

- 1) Hold hose adapter (1) or hose (5) and insert it in mating adapter (3), aligning them with each other. (See Fig. 4)
  - ★ Do not hold rubber cap portion (4).
- 2) After inserting the hose in the mating adapter perfectly, pull it back to check its connecting condition. (See Fig. 5)
  - ★ When the hose is pulled back, the rubber cap portion moves toward the hose about 3.5 mm. This does not indicate abnormality, however.

Type 1



	Type 2	Type 3
Disassembly	<p>1) Hold the mouthpiece of the tightening portion and push body (2) in straight until sliding prevention ring (1) contacts contact surface a of the hexagonal portion at the male end.</p>  <p style="text-align: right;">CWP06392</p>	<p>1) Hold the mouthpiece of the tightening portion and push body (2) in straight until sliding prevention ring (1) contacts contact surface a of the hexagonal portion at the male end.</p>  <p style="text-align: right;">CWP06391</p>
	<p>2) Hold in the condition in Step 1), and turn lever (4) to the right (clockwise).</p>  <p style="text-align: right;">CWP06394</p>	<p>2) Hold in the condition in Step 1), and push until cover (3) contacts contact surface a of the hexagonal portion at the male end.</p>  <p style="text-align: right;">CWP06393</p>
	<p>3) Hold in the condition in Steps 1) and 2), and pull out whole body (2) to disconnect it.</p>  <p style="text-align: right;">CWP06396</p>	<p>3) Hold in the condition in Steps 1) and 2), and pull out whole body (2) to disconnect it.</p>  <p style="text-align: right;">CWP06395</p>
Connection	<ul style="list-style-type: none"> <li>Hold the mouthpiece of the tightening portion and push body (2) in straight until sliding prevention ring (1) contacts contact surface a of the hexagonal portion at the male end to connect it.</li> </ul>  <p style="text-align: right;">CWP06392</p>	<ul style="list-style-type: none"> <li>Hold the mouthpiece of the tightening portion and push body (2) in straight until sliding prevention ring (1) contacts contact surface a of the hexagonal portion at the male end to connect it.</li> </ul>  <p style="text-align: right;">CWP06391</p>

## COATING MATERIALS

- ★ The recommended coating materials such as adhesives, gasket sealants and greases used for disassembly and assembly are listed below.
- ★ For coating materials not listed below, use the equivalent of products shown in this list.

Category	Komatsu code	Part No.	Q'ty	Container	Main applications, features
Adhesives	LT-1A	790-129-9030	150 g	Tube	<ul style="list-style-type: none"> <li>• Used to prevent rubber gaskets, rubber cushions, and cock plug from coming out.</li> </ul>
	LT-1B	790-129-9050	20 g (2 pcs.)	Polyethylene container	<ul style="list-style-type: none"> <li>• Used in places requiring an immediately effective, strong adhesive. Used for plastics (except polyethylene, polypropylene, tetrafluoroethylene and vinyl chloride), rubber, metal and non-metal.</li> </ul>
	LT-2	09940-00030	50 g	Polyethylene container	<ul style="list-style-type: none"> <li>• Features: Resistance to heat and chemicals</li> <li>• Used for anti-loosening and sealant purpose for bolts and plugs.</li> </ul>
	LT-3	790-129-9060 (Set of adhesive and hardening agent)	Adhesive: 1 kg Hardenin g agent: 500 g	Can	<ul style="list-style-type: none"> <li>• Used as adhesive or sealant for metal, glass and plastic.</li> </ul>
	LT-4	790-129-9040	250 g	Polyethylene container	<ul style="list-style-type: none"> <li>• Used as sealant for machined holes.</li> </ul>
	Holtz MH 705	790-126-9120	75 g	Tube	<ul style="list-style-type: none"> <li>• Used as heat-resisting sealant for repairing engine.</li> </ul>
	Three bond 1735	790-129-9140	50 g	Polyethylene container	<ul style="list-style-type: none"> <li>• Quick hardening type adhesive</li> <li>• Cure time: within 5 sec. to 3 min.</li> <li>• Used mainly for adhesion of metals, rubbers, plastics and woods.</li> </ul>
	Aron-alpha 201	790-129-9130	2 g	Polyethylene container	<ul style="list-style-type: none"> <li>• Quick hardening type adhesive</li> <li>• Quick cure type (max. strength after 30 minutes)</li> <li>• Used mainly for adhesion of rubbers, plastics and metals.</li> </ul>
	Loctite 648-50	79A-129-9110	50 cc	Polyethylene container	<ul style="list-style-type: none"> <li>• Resistance to heat, chemicals</li> <li>• Used at joint portions subject to high temperatures.</li> </ul>
Gasket sealant	LG-1	790-129-9010	200 g	Tube	<ul style="list-style-type: none"> <li>• Used as adhesive or sealant for gaskets and packing of power train case, etc.</li> </ul>
	LG-5	790-129-9070	1 kg	Can	<ul style="list-style-type: none"> <li>• Used as sealant for various threads, pipe joints, flanges.</li> <li>• Used as sealant for tapered plugs, elbows, nipples of hydraulic piping.</li> </ul>
	LG-6	790-129-9020	200 g	Tube	<ul style="list-style-type: none"> <li>• Features: Silicon based, resistance to heat, cold</li> <li>• Used as sealant for flange surface, tread.</li> <li>• Used as sealant for oil pan, final drive case, etc.</li> </ul>









Category	Komatsu code	Part No.	Q'ty	Container	Main applications, features
Adhesives	LG-7	790-129-9070	1 g	Tube	<ul style="list-style-type: none"> <li>• Features: Silicon based, quick hardening type</li> <li>• Used as sealant for flywheel housing, intake manifold, oil an, thermostat housing, etc.</li> </ul>
	Three bond 1211	790-129-9090	100 g	Tube	<ul style="list-style-type: none"> <li>• Used as heat-resisting sealant for repairing engine.</li> </ul>
Molybdenum disulphide lubricant	LM-G	09940-00051	60 g	Can	<ul style="list-style-type: none"> <li>• Used as lubricant for sliding portion (to prevent from squeaking).</li> </ul>
	LM-P	09940-00040	200 g	Tube	<ul style="list-style-type: none"> <li>• Used to prevent seizure or scuffing of the thread when press fitting or shrink fitting.</li> <li>• Used as lubricant for linkage, bearings, etc.</li> </ul>
Grease	G2-LI	SYG2-400LI SYG2-350LI SYG2-400LI-A SYG2-160LI SYGA-160CNLI	Various	Various	<ul style="list-style-type: none"> <li>• General purpose type</li> </ul>
	G2-CA	SYG2-400CA SYG2-350CA SYG2-400CA-A SYG2-160CA SYGA-160CNCA	Various	Various	<ul style="list-style-type: none"> <li>• Used for normal temperature, light load bearing at places in contact with water or steam.</li> </ul>
	Molybdenum disulphide lubricant	SYG2-400M	400 g (10 per case)	Belows type	<ul style="list-style-type: none"> <li>• Used for places with heavy load</li> </ul>

## STANDARD TIGHTENING TORQUE

### STANDARD TIGHTENING TORQUE TABLE (WHEN USING TORQUE WRENCH)

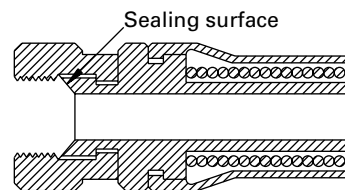
★ In the case of metric nuts and bolts for which there is no special instruction, tighten to the torque given in the table below.

Thread diameter of bolt	Width across flats						CDL00372
mm	mm	Nm		kgm			
6	10	13.2 ± 1.4		1.35 ± 0.15			
8	13	31 ± 3		3.2 ± 0.3			
10	17	66 ± 7		6.7 ± 0.7			
12	19	113 ± 10		11.5 ± 1			
14	22	177 ± 19		18 ± 2			
16	24	279 ± 30		28.5 ± 3			
18	27	382 ± 39		39 ± 4			
20	30	549 ± 59		56 ± 6			
22	32	745 ± 83		76 ± 8.5			
24	36	927 ± 103		94.5 ± 10.5			
27	41	1320 ± 140		135 ± 15			
30	46	1720 ± 190		175 ± 20			
33	50	2210 ± 240		225 ± 25			
36	55	2750 ± 290		280 ± 30			
39	60	3290 ± 340		335 ± 35			

Thread diameter of bolt	Width across flats		CDL00373	
mm	mm	Nm		kgm
6	10	7.85 ± 1.95		0.8 ± 0.2
8	13	18.6 ± 4.9		1.9 ± 0.5
10	14	40.2 ± 5.9		4.1 ± 0.6
12	27	82.35 ± 7.85		8.4 ± 0.8

### TABLE OF TIGHTENING TORQUES FOR FLARED NUTS

★ In the case of flared nuts for which there is no special instruction, tighten to the torque given in the table below.



SAD00483

Thread diameter	Width across flat	Tightening torque	
mm	mm	Nm	kgm
14	19	24.5 ± 4.9	2.5 ± 0.5
18	24	49 ± 19.6	5 ± 2
22	27	78.5 ± 19.6	8 ± 2
24	32	137.3 ± 29.4	14 ± 3
30	36	176.5 ± 29.4	18 ± 3
33	41	196.1 ± 49	20 ± 5
36	46	245.2 ± 49	25 ± 5
42	55	294.2 ± 49	30 ± 5

**TABLE OF TIGHTENING TORQUES FOR SPLIT FLANGE BOLTS**

★ In the case of split flange bolts for which there is no special instruction, tighten to the torque given in the table below.

Thread diameter	Width across flat	Tightening torque	
		Nm	kgm
mm	mm		
10	14	$65.7 \pm 6.8$	$6.7 \pm 0.7$
12	17	$112 \pm 9.8$	$11.5 \pm 1$
16	22	$279 \pm 29$	$28.5 \pm 3$

**TABLE OF TIGHTENING TORQUES FOR O-RING BOSS PIPING JOINTS**

★ Unless there are special instructions, tighten the O-ring boss piping joints to the torque below.

Nominal No.	Thread diameter	Width across flat	Tightening torque	
	mm	mm	Nm	kgm
02	14	Varies depending on type of connector.	$34.3 \pm 4.9$	$3.5 \pm 0.5$
03, 04	20		$93.1 \pm 9.8$	$9.5 \pm 1$
05, 06	24		$142.1 \pm 19.6$	$14.5 \pm 2$
10, 12	33		$421.4 \pm 58.8$	$43 \pm 6$
14	42		$877.1 \pm 132.3$	$89.5 \pm 13.5$

**TABLE OF TIGHTENING TORQUES FOR O-RING BOSS PLUGS**

★ Unless there are special instructions, tighten the O-ring boss plugs to the torque below.

Nominal No.	Thread diameter	Width across flat	Tightening torque	
	mm	mm	Nm	kgm
08	08	14	$7.35 \pm 1.47$	$0.75 \pm 0.15$
10	10	17	$11.27 \pm 1.47$	$1.15 \pm 0.15$
12	12	19	$17.64 \pm 1.96$	$1.8 \pm 0.2$
14	14	22	$22.54 \pm 1.96$	$2.3 \pm 0.2$
16	16	24	$29.4 \pm 4.9$	$3 \pm 0.5$
18	18	27	$39.2 \pm 4.9$	$4 \pm 0.5$
20	20	30	$49 \pm 4.9$	$5 \pm 0.5$
24	24	32	$68.6 \pm 9.8$	$7 \pm 1$
30	30	32	$107.8 \pm 14.7$	$11 \pm 1.5$
33	33	n	$127.4 \pm 19.6$	$13 \pm 2$
36	36	36	$151.9 \pm 24.5$	$15.5 \pm 2.5$
42	42	n	$210.7 \pm 29.4$	$21.5 \pm 3$
52	52	n	$323.4 \pm 44.1$	$33 \pm 4.5$

**TIGHTENING TORQUE FOR 102 ENGINE SERIES**

## 1) BOLT AND NUTS

Use these torques for bolts and nuts (unit: mm) of Cummins Engine.

Thread diameter	Tightening torque	
	Nm	kgm
6	10 ± 2	1.02 ± 0.20
8	24 ± 4	2.45 ± 0.41
10	43 ± 6	4.38 ± 0.61
12	77 ± 12	7.85 ± 1.22

## 2) EYE JOINTS

Use these torques for eye joints (unit: mm) of Cummins Engine.

Thread diameter	Tightening torque	
	Nm	kgm
6	8 ± 2	0.81 ± 0.20
8	10 ± 2	1.02 ± 0.20
10	12 ± 2	1.22 ± 0.20
12	24 ± 4	2.45 ± 0.41
14	36 ± 5	3.67 ± 0.51

## 3) TAPERED SCREWS

Use these torques for tapered screws (unit: inch) of Cummins Engine.

Thread diameter	Tightening torque	
	Nm	kgm
1 / 16	3 ± 1	0.31 ± 0.10
1 / 8	8 ± 2	0.81 ± 0.20
1 / 4	12 ± 2	1.22 ± 0.20
3 / 8	15 ± 2	1.53 ± 0.41
1 / 2	24 ± 4	2.45 ± 0.41
3 / 4	36 ± 5	3.67 ± 0.51
1	60 ± 9	6.12 ± 0.92

**TIGHTENING TORQUE TABLE FOR HOSES (TAPER SEAL TYPE AND FACE SEAL TYPE)**

★ Tighten the hoses (taper seal type and face seal type) to the following torque, unless otherwise specified.

★ Apply the following torque when the threads are coated (wet) with engine oil.

Nominal size of hose	Width across flats	Tightening torque (Nm {kgm})		Taper seal type Thread size (mm)	Face seal type	
		Range	Target		Nominal thread size - Threads per inch, Thread series	Root diameter (mm) (Reference)
02	19	35 - 63 {3.5 - 6.5}	44 {4.5}	14	$\frac{9}{16}$ - 18UNF	14.3
03	22	54 - 93 {5.5 - 9.5}	74 {4.5}	-	$\frac{11}{16}$ - 16UN	17.5
	24	59 - 98 {6.0 - 10.0}	78 {8.0}	18	-	-
04	27	84 - 132 {8.5 - 13.5}	103 {10.5}	22	$\frac{13}{16}$ - 16UN	20.7
05	32	128 - 186 {13.0 - 19.0}	157 {16.0}	24	1 - 14UNS	25.4
06	36	177 - 245 {18.0 - 25.0}	216 {22.0}	30	$1\frac{3}{16}$ - 12UNF	30.3
(10)	41	177 - 245 {18.0 - 25.0}	216 {22.0}	33	-	-
(12)	46	197 - 294 {20.0 - 30.0}	245 {25.0}	36	-	-
(14)	55	246 - 343 {25.0 - 35.0}	294 {30.0}	42	-	-