

# PARTS & SERVICE NEWS

REF NO.	AA03141
DATE	Oct. 8, 2003

**SUBJECT:** MAIN CONTROL VALVE - NEW ELBOW UNION

**PURPOSE:** Exchange of an elbow union at the main control valve to avoid leakage

**APPLICATION:** WA450-5H Wheel Loaders, S/N H50050 thru H50090, H50092 thru H50375, H50377 and H50378, H50380 thru H50382, H50384 thru H50387, H50395  
WA450-5L Wheel Loaders, S/N A36001 thru A36114  
WA480-5H Wheel Loaders, S/N H50050 and H50052, H50054 thru H50059, H50061 thru H50120, H50122 thru H50162 and H50165  
WA480-5L Wheel Loaders, S/N A37001 thru A37025

**FAILURE CODE:** P30037

## DESCRIPTION:

During some applications the long elbow union at the main control valve can crack and leak. Therefore a new shorter elbow union will be installed. This **Parts & Service News** explains the instructions for the change of the elbow union.

## Spare Parts:

Position	Name	P/N Current	P/N New	Qty.
1	Elbow Union	421-62-33790	02783-10422	1
2	O-ring	07002-12034	07002-12034	1

## Preparation

- Park the machine on flat ground and apply the parking brake.
- Raise the boom and block it, to avoid unintentional lowering.
- Stop the engine and work the control lever several times to release the hydraulic pressure.
- Open the hydraulic tank slowly, to release the pressure.

**Change of the elbow union:**

1. Remove the cover from the front frame.
2. Set a container under the main control valve.
3. Remove the hydraulic hose from the elbow union.
4. Remove the long elbow (1) from the main control valve.
5. Renew the O-ring (2)
6. Screw in the elbow (1) into the main control valve and tighten it. Tightening torque = 75Nm.
7. Screw on the hose at the new elbow union (1) and tighten it. Tightening torque = 83Nm
8. Be sure that the hose does not contact any other parts.
9. Bleed the hydraulic circuit, refill hydraulic oil if necessary and close the hydraulic tank.
10. Check the new mounted elbow union and hose for tightness.
11. Replace the cover on the front frame.

