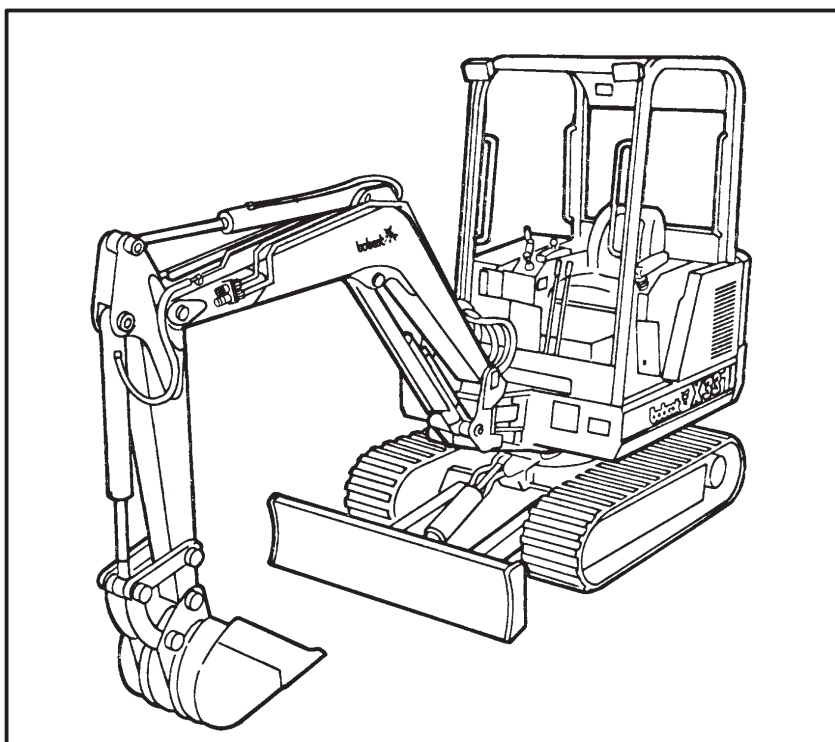


**X 331**  
**X 331E**  
**X 334**

# **Excavator**

## **Service Manual**

**331 (S/N 512913001 & Above)**  
**331E (S/N 517711001 & Above)**  
**334 (S/N 516711001 & Above)**



**MELROE**  
**INGERSOLL-RAND**

6900464 (2-98)



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Printed in U.S.A.

# MAINTENANCE SAFETY



## WARNING

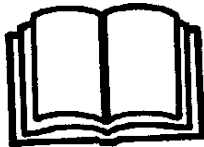
Instructions are necessary before operating or servicing machine. Read and understand the Operation & Maintenance Manual, Operator's Handbook and signs (decals) on machine. Follow warnings and instructions in the manuals when making repairs, adjustments or servicing. Check for correct function after adjustments, repairs or service. Untrained operators and failure to follow instructions can cause injury or death.

W-2003-0903



**Safety Alert Symbol:** This symbol with a warning statement, means: "Warning, be alert! Your safety is involved!" Carefully read the message that follows.

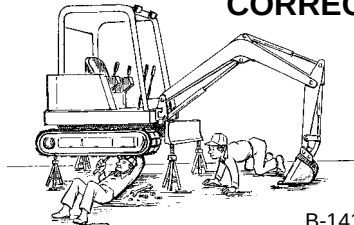
### CORRECT



B-10731a

- ⚠ Never service the Bobcat Hydraulic Excavator without instructions.

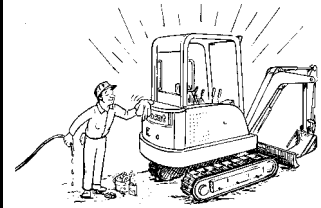
### CORRECT



B-14148

- ⚠ Use the correct procedure to lift and support the excavator.
- ⚠ Always lift the blade fully before installing jackstands.

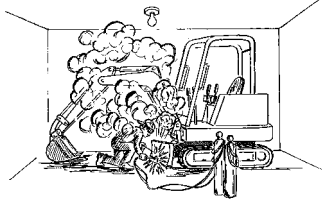
### CORRECT



B-14142

- ⚠ Cleaning and maintenance are required daily.

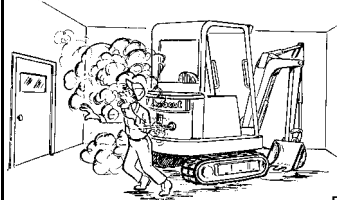
### WRONG



B-14147

- ⚠ Have good ventilation when welding or grinding painted parts.
- ⚠ Wear dust mask when grinding painted parts. Toxic dust and gas can be produced.

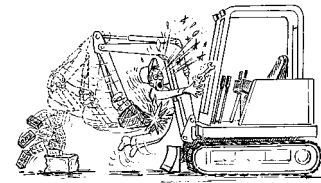
### WRONG



B-14141

- ⚠ Vent exhaust to outside when engine must be run for service.
- ⚠ Exhaust system must be tightly sealed. Exhaust Fumes can kill without warning.

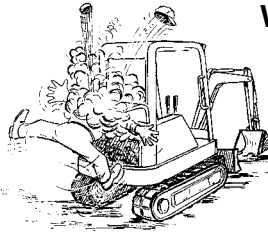
### WRONG



B-14145

- ⚠ Always lower the bucket and blade to the ground before doing any maintenance.
- ⚠ Never modify equipment or add attachments not approved by Bobcat Company.

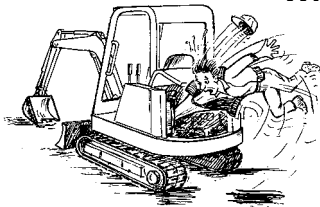
### WRONG



B-14146

- ⚠ Stop, cool and clean engine of flammable materials before checking fluids.
- ⚠ Never service or adjust machine with the engine running unless instructed to do so in the manual.
- ⚠ Avoid contact with leaking hydraulic fluid or diesel fuel under pressure. It can penetrate the skin or eyes.
- ⚠ Never fill fuel tank with engine running, while smoking or when near open flame.

### WRONG



B-14143

- ⚠ Keep body, jewelry and clothing away from moving parts, electrical contact, hot parts and exhaust.
- ⚠ Wear eye protection to guard from battery acid, compressed springs, fluids under pressure and flying debris when engines are running or tools are used. Use eye protection approved for type of welding.
- ⚠ Keep rear door closed except for service. Close and latch door before operating the excavator.

### WRONG



B-6589

- ⚠ Lead-acid batteries produce flammable and explosive gases.
- ⚠ Keep arcs, sparks, flames and lighted tobacco away from batteries.
- ⚠ Batteries contain acid which burns eyes or skin on contact. Wear protective clothing. If acid contacts body, flush well with water. For eye contact flush well and get immediate medical attention.

Maintenance procedures which are given in the Operation & Maintenance Manual can be performed by the owner/operator without any specific technical training. Maintenance procedures which are **not** in the Operation & Maintenance Manual must be performed **ONLY BY QUALIFIED BOBCAT SERVICE PERSONNEL**. Always use genuine Bobcat replacement parts. The Service Safety Training Course is available from your Bobcat dealer.

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### PREVENTIVE MAINTENANCE

### HYDRAULIC SYSTEM

### DRIVE SECTION

### UPPER WORKS & SWING SECTION

### MAIN FRAME & TRACKS

### ELECTRICAL SYSTEM

### ENGINE SERVICE

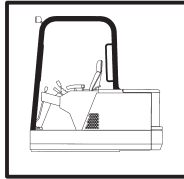
### SPECIFICATIONS

# FOREWORD

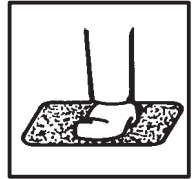
This manual is for the Bobcat hydraulic excavator mechanic. It provides necessary servicing and adjustment procedures for the hydraulic excavator and its component parts and systems. Refer to the Operation & Maintenance Manual for operating instructions, starting procedure, daily checks, etc.

A general inspection of the following items must be made after the hydraulic excavator has had service or repair:

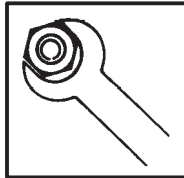
1. Check that the ROPS/TOPS/FOGS is in good condition and is not modified.



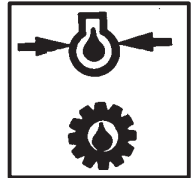
9. Safety treads must in good condition.



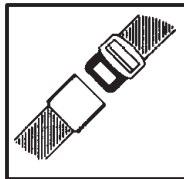
2. Check that ROPS/TOPS mounting hardware is tightened and is Melroe approved.



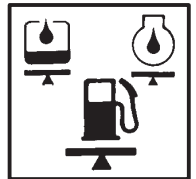
10. Check for correct function of indicator lamps (Optional on some models).



3. The seat belt must be correctly installed, functional and in good condition.



11. Check hydraulic fluid level, engine oil level and fuel supply.



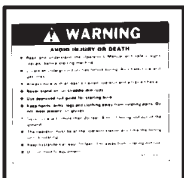
4. Inspect for loose or broken parts or connections.



12. Inspect for fuel, oil or hydraulic fluid leaks.



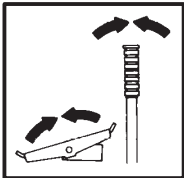
5. Machine signs must be legible and in the correct location.



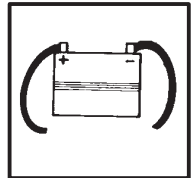
13. Lubricate the excavator.



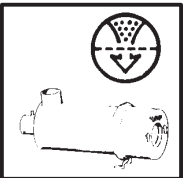
6. Steering levers, control levers and foot pedals must return to neutral. Check that foot pedals lock and control lever locks are in working condition.



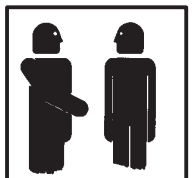
14. Check the condition of the battery and cables.



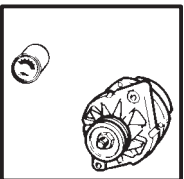
7. Inspect the air cleaner for damage or leaks. Check the condition of the element.



Recommend to the owner that all necessary corrections be made before the machine is returned to service.



8. Check the electrical charging system.

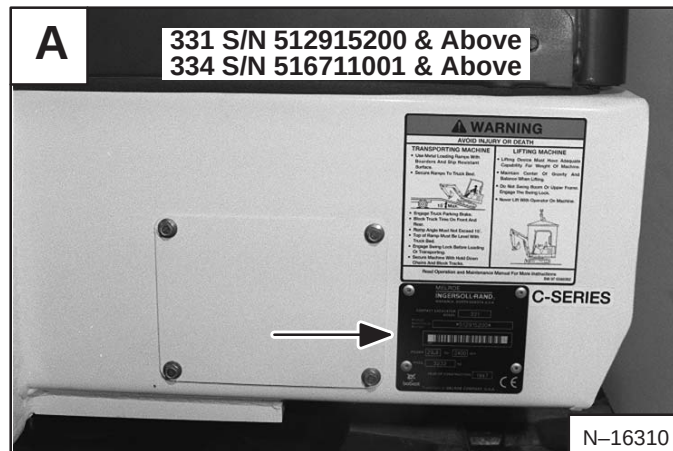


## SERIAL NUMBER LOCATIONS

Always use the complete serial number (including the first four digits) of the loader when requesting service information or when ordering parts. Early or later models (identification made by serial number) may use different parts, or it may be necessary to use a different procedure in doing a specific service operation.

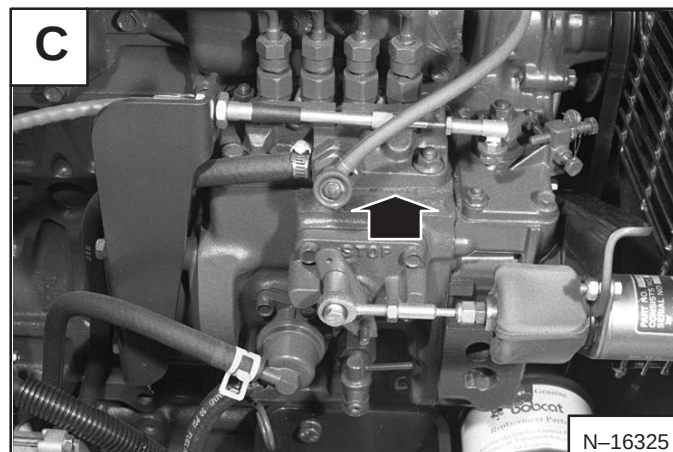
### HYDRAULIC EXCAVATOR SERIAL NUMBER

The excavator serial number is on the front of the machine frame, to the left of the boom [A] & [B].



### ENGINE SERIAL NUMBER

The engine serial number is located on the engine block, near the fuel injection pump [C].

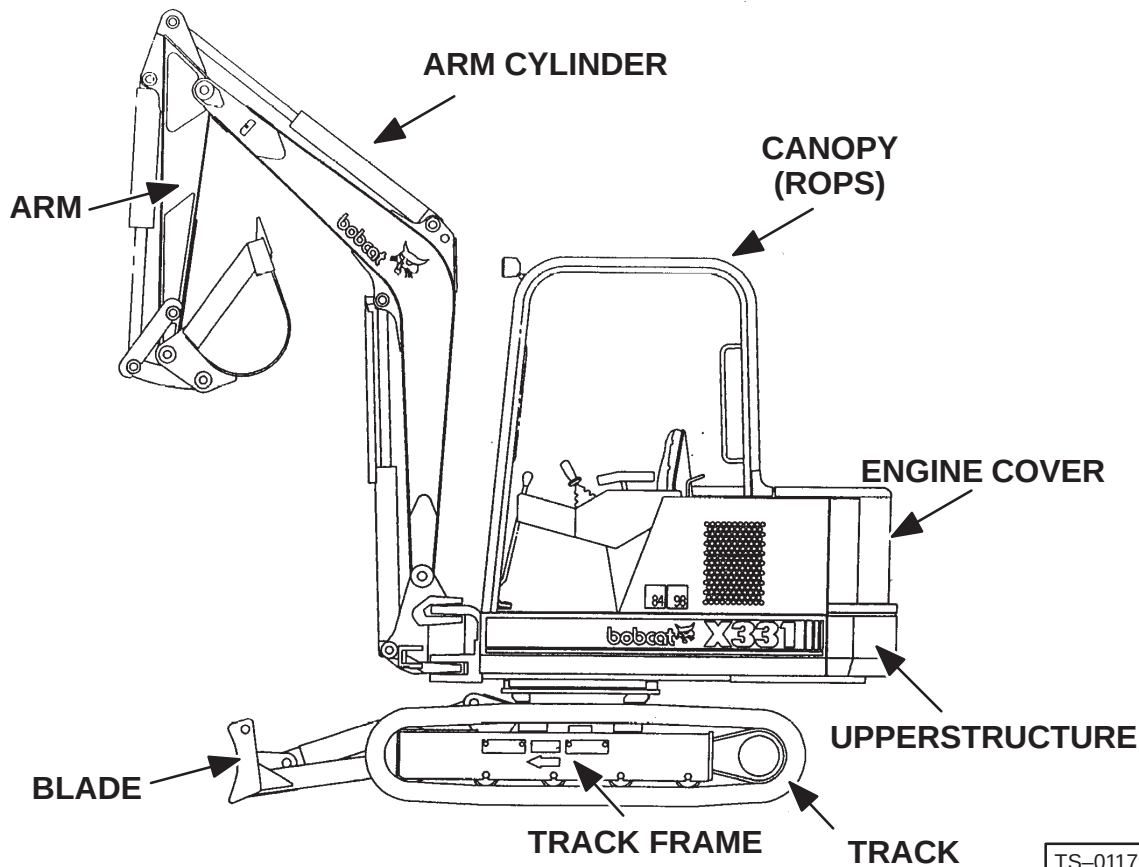
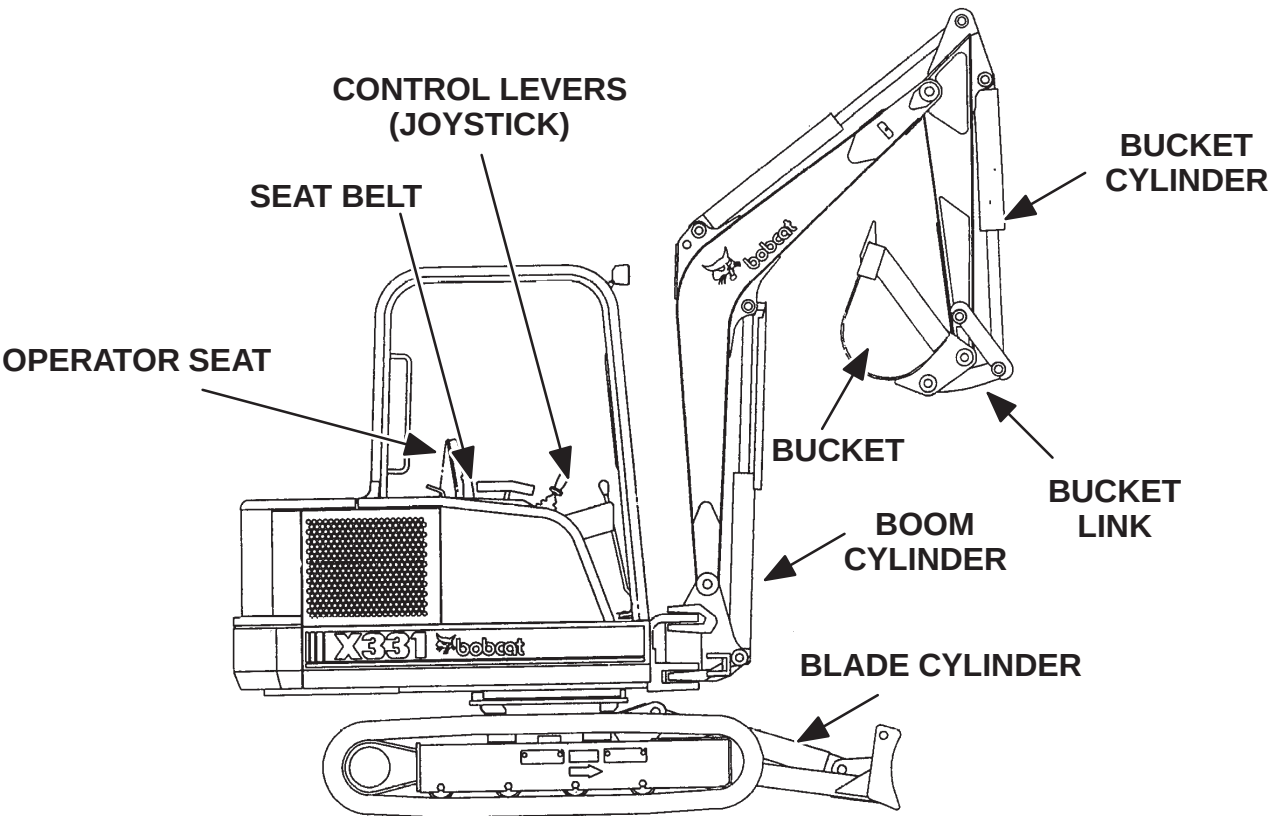


### DELIVERY REPORT

The Delivery Report must be filled out by the dealer and signed by the owner or operator when the Bobcat excavator is delivered. The form contents must be explained to the owner. Make sure it is filled out completely [D].

Image D shows the Bobcat delivery report form. The form is titled 'DELIVERY REPORT' and contains sections for 'WARNING' and 'DELIVERY REPORT'. The form is divided into two columns, with the left column containing a 'WARNING' section and the right column containing the 'DELIVERY REPORT' section. The form is labeled 'D'.

HYDRAULIC EXCAVATOR IDENTIFICATION



TS-01179

## PREVENTIVE MAINTENANCE

## PREVENTIVE MAINTENANCE

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## PREVENTIVE MAINTENANCE (Cont'd)

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**SERVICE SCHEDULE (331 S/N 512913001–512915199)**

Maintenance work must be done at regular intervals. Failure to do so will result in excessive wear and early failures. The service schedule is a guide for correct maintenance of the Hydraulic Excavator.

**WARNING**

Instructions are necessary before operating or servicing machine. Read Operation & Maintenance Manual, Handbook and signs (decals) on machine. Follow warnings and instructions in the manuals when making repairs, adjustments or servicing. Check for correct function after adjustments, repairs or service. Failure to follow instructions can cause injury or death.

W-2003-0797

| SERVICE SCHEDULE                |                                                                                                                          | HOURS |    |     |     |     |      |
|---------------------------------|--------------------------------------------------------------------------------------------------------------------------|-------|----|-----|-----|-----|------|
| ITEM                            | SERVICE REQUIRED                                                                                                         | 8-10  | 50 | 100 | 250 | 500 | 1000 |
| Engine Air Cleaner              | Replace the filter element only when the red ring shows in the indicator window. Check for leaks and damaged components. |       |    |     |     |     |      |
| Engine Oil                      | Check the oil level and add oil as needed.                                                                               |       |    |     |     |     |      |
| Engine Coolant System           | Check coolant level in recovery tank.                                                                                    |       |    |     |     |     |      |
| Indicator Lights                | Check for correct operation.                                                                                             |       |    |     |     |     |      |
| Operator Cab                    | Check the fastening bolts, nuts, and condition of cab.                                                                   |       |    |     |     |     |      |
| Seat Belt                       | Check the condition and that fasteners are tight.                                                                        |       |    |     |     |     |      |
| Safety Signs (Decals)           | Check for damaged signs (decals) replace as needed.                                                                      |       |    |     |     |     |      |
| Tracks                          | Check and adjust tension.                                                                                                |       |    |     |     |     |      |
| All Machinery Pivot Points      | Lubricate 25 grease fittings.                                                                                            |       |    |     |     |     |      |
| Hyd. Fluid, Hoses and Tubelines | Check fluid level and add as needed. Check for damage and leaks. Repair and replace as needed.                           |       |    |     |     |     |      |
| Fuel Tank/Fuel Filter           | Drain water and sediment from fuel tank/fuel filter.                                                                     |       |    |     |     |     |      |
| Swing Circle                    | Lubricate two grease fittings.                                                                                           |       |    |     |     |     |      |
| Swing Pinion                    | Lubricate one grease fitting.                                                                                            |       |    |     |     |     |      |
| Spark Arrestor Muffler          | Clean spark chamber.                                                                                                     |       |    |     |     |     |      |
| Alternator Belt                 | Check and adjust tension.                                                                                                |       | *  |     |     |     |      |
| Engine Oil and Filter           | Replace oil and filter element.                                                                                          |       | *  |     |     |     |      |
| Travel Motor                    | Check fluid level and add oil as needed.                                                                                 |       |    |     |     |     |      |
| Hydraulic Filter                | Replace filter element.                                                                                                  |       |    | **  |     |     |      |
| Fuel Filter                     | Replace filter element.                                                                                                  |       |    |     |     |     |      |
| Battery                         | Check and clean cable ends and check electrolyte level.                                                                  |       |    |     |     |     |      |
| Air Cleaner                     | Replace the filter element.                                                                                              |       |    |     |     |     |      |
| Cooling System                  | Clean the radiator fins.                                                                                                 |       |    |     |     |     |      |
| Alternator and Starter          | Check the condition.                                                                                                     |       |    |     |     |     |      |
| Cooling System                  | Drain, flush and add new coolant to the cooling system.                                                                  |       |    |     |     |     |      |
| Hydraulic Tank                  | Change the fluid, clean fill neck strainer.                                                                              |       |    |     |     |     |      |
| Travel Motor                    | Change the oil.                                                                                                          |       |    | **  |     |     |      |

**\*After the first 50 hours of machine operation do the following:**

Replace the hydraulic fluid filter.

Check the condition of fan belt.

Replace the engine oil and filter.

**\*\*After the first 100 hours of machine operation do the following procedures:**

Change oil in the travel motor.

Replace hydraulic filter.

■ Or Every 12 Months.

**SERVICE SCHEDULE (331 S/N 512915200 & Above),  
(331E 517711001 & Above) & (334 S/N 516711001 & Above)**

Maintenance work must be done at regular intervals. Failure to do so will result in excessive wear and early failures. The service schedule is a guide for correct maintenance of the Hydraulic Excavator.



## WARNING

Instructions are necessary before operating or servicing machine. Read Operation & Maintenance Manual, Handbook and signs (decals) on machine. Follow warnings and instructions in the manuals when making repairs, adjustments or servicing. Check for correct function after adjustments, repairs or service. Failure to follow instructions can cause injury or death.

W-2003-0797

| SERVICE SCHEDULE                |                                                                                                                          | HOURS |    |     |     |     |      |
|---------------------------------|--------------------------------------------------------------------------------------------------------------------------|-------|----|-----|-----|-----|------|
| ITEM                            | SERVICE REQUIRED                                                                                                         | 8-10  | 50 | 100 | 250 | 500 | 1000 |
| Engine Air Cleaner              | Replace the filter element only when the red ring shows in the indicator window. Check for leaks and damaged components. |       |    |     |     |     |      |
| Engine Oil                      | Check the oil level and add oil as needed.                                                                               |       |    |     |     |     |      |
| Engine Coolant System           | Check coolant level in recovery tank.                                                                                    |       |    |     |     |     |      |
| Indicator Lights                | Check for correct operation.                                                                                             |       |    |     |     |     |      |
| Operator Cab                    | Check the fastening bolts, nuts, and condition of cab/canopy.                                                            |       |    |     |     |     |      |
| Seat Belt                       | Check the condition and that fasteners are tight.                                                                        |       |    |     |     |     |      |
| Safety Signs (Decals)           | Check for damaged signs (decals) replace as needed.                                                                      |       |    |     |     |     |      |
| Tracks                          | Check and adjust tension.                                                                                                |       |    |     |     |     |      |
| All Machinery Pivot Points      | Lubricate 25 grease fittings.                                                                                            |       |    |     |     |     |      |
| Hyd. Fluid, Hoses and Tubelines | Check fluid level and add as needed. Check for damage and leaks. Repair and replace as needed.                           |       |    |     |     |     |      |
| Extendible Arm (If Equipped)    | Lubricate slide on extendible arm                                                                                        |       |    |     |     |     |      |
| Fuel Tank/Fuel Filter           | Drain water and sediment from fuel tank/fuel filter.                                                                     |       |    |     |     |     |      |
| Swing Circle                    | Lubricate two grease fittings.                                                                                           |       |    |     |     |     |      |
| Swing Pinion                    | Lubricate one grease fitting.                                                                                            |       |    |     |     |     |      |
| Battery                         | Check cables, connections and electrolyte level. Add distilled water as needed.                                          |       |    |     |     |     |      |
| Spark Arrestor Muffler          | Clean spark chamber.                                                                                                     |       |    |     |     |     |      |
| Alternator/Fan Belt             | Check and adjust tension.                                                                                                |       | *  |     |     |     |      |
| Engine Oil and Filter           | Replace oil and filter element.                                                                                          |       | *  |     |     |     |      |
| Travel Motor                    | Check fluid level and add oil as needed.                                                                                 |       |    |     |     |     |      |
| Fuel Filter                     | Replace filter element.                                                                                                  |       |    |     |     |     |      |
| Cooling System                  | Clean the radiator fins.                                                                                                 |       |    |     |     |     |      |
| Alternator and Starter          | Check the condition.                                                                                                     |       |    |     |     |     |      |
| Hydraulic Filter                | Replace filter element.                                                                                                  |       |    | **  |     |     |      |
| Drain Return Line Filter        | Clean filter with solvent, dry with air pressure.                                                                        |       |    | **  |     |     |      |
| Engine Valve Clearance          | Check and adjust as needed                                                                                               |       |    |     |     |     |      |
| Cooling System                  | Drain, flush and add new coolant to the cooling system.                                                                  |       |    |     |     |     |      |
| Hydraulic Tank                  | Change the fluid, clean fill neck strainer.                                                                              |       |    |     |     |     |      |
| Travel Motor                    | Change the oil.                                                                                                          |       |    | **  |     |     |      |
| Cab Heater Air Filter           | Clean the filter.                                                                                                        |       |    |     |     |     |      |

**\*After the first 50 hours of machine operation do the following:**

Replace the engine oil and filter.

Check the condition of the alternator/fan belt.

**\*\*After the first 100 hours of machine operation do the following procedures:**

Change oil in the travel motor.

Clean drain return line filter.

Replace hydraulic filter.

■ Or Every 12 Months.

## LIFTING AND BLOCKING THE EXCAVATOR

### Procedure

Always park the machine on a level surface.



## WARNING

Instructions are necessary before operating or servicing machine. Read Operation & Maintenance Manual, Handbook and signs (decals) on machine. Follow warnings and instructions in the manuals when making repairs, adjustments or servicing. Check for correct function after adjustments, repairs or service. Failure to follow instructions can cause injury or death.

W-2003-0797

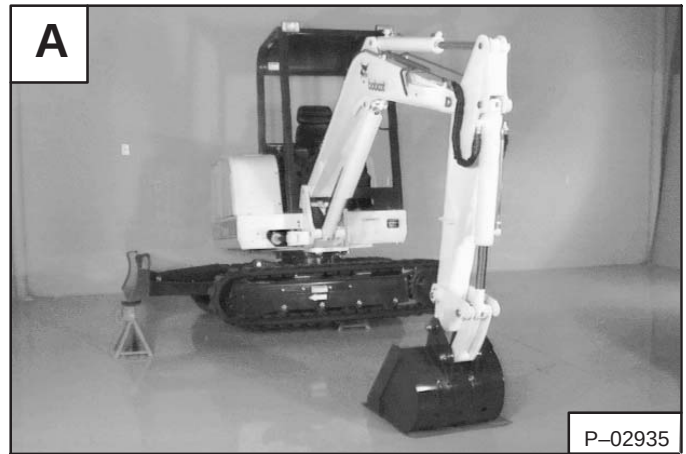


## WARNING

Put jackstands under the blade and track frame before running the engine for service. Failure to use jackstands can allow the machine to fall or move and cause injury or death.

W-2017-0286

**A**



**B**



Raise the machine using the boom and arm **[A]**.

Fully raise the blade and install jackstands under the blade **[A]** and track frame **[B]**.

Lower the boom until all the machine weight is on the jackstands.

Repeat the procedure for the other side.

Stop the engine.

## TRANSPORTING THE EXCAVATOR

### Procedure

Make sure the parking brakes on the transport vehicle are engaged and wheels are blocked.

Align the ramps with the center of the transport vehicle. Secure the ramps to the truck bed and be sure ramp angle does not exceed 15 degrees.

Use metal loading ramps and slip resistant surface.

Make sure the ramps are the correct length and width, and can support the weight of the machine.

The rear of the trailer must be blocked or supported when loading or unloading the excavator.

Determine the direction of the track movement before moving the machine (blade forward). Engage the swing lock pin to lock the upperstructure.

Move the machine forward onto the transport vehicle [A].

Do not change direction of the machine while it is on the ramps.

After loading the machine, position the arm and bucket as shown [B].

Lower the boom.

Stop the engine and remove the key.

Use the following procedure to fasten the Excavator to the transport vehicle:

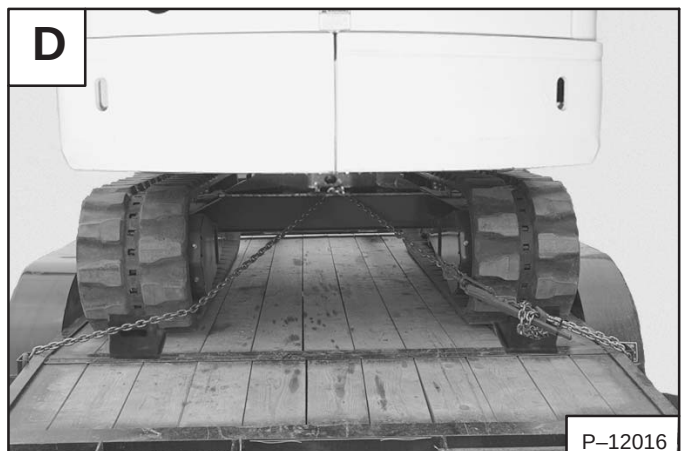
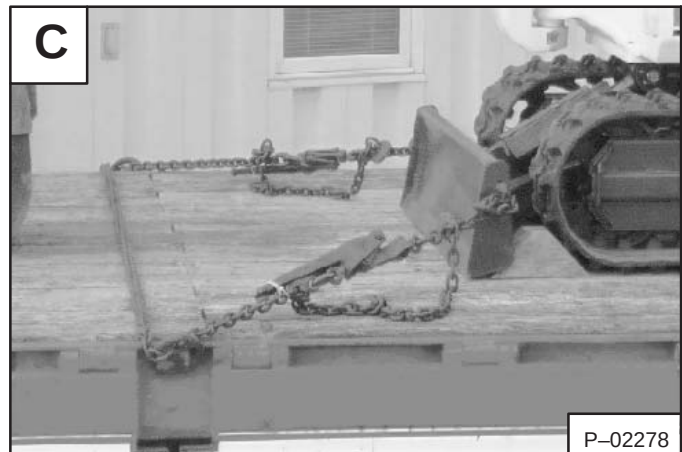
1. Put blocks under the front and rear of the track shoes.
  2. Fasten holddown chains to the front corners of the blade and to the tie down loop at the rear track frame to prevent it from moving when going up or down slopes, or during sudden stops [C] & [D].
  3. Use chain binders to tighten the chains and then tie the chain binder levers to prevent loosening.
- When transporting the machine, observe the rules, motor vehicle laws and vehicle limit ordinances. Use a transport and towing vehicle of adequate length and capacity.



## WARNING

Steel loading ramps are needed to support the weight of the machine when loading onto a transport vehicle. Wood ramps can break and cause personal injury.

W-2058-0887



## ENGINE COVER

### Opening The Engine Cover



## WARNING

### AVOID INJURY

Never service or adjust the machine when the engine is running unless instructed to do so in this manual.

W-2012-0290

Keep the engine cover closed when operating the machine.

W-2141-0189

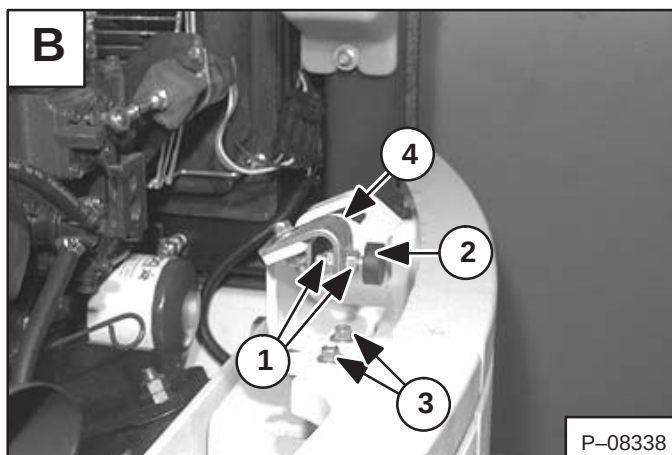
Open the engine cover to service the engine. Pull on the latch and lift the engine cover up until it is fully raised [A].

### Adjustment Of The Engine Cover Latch

Open the engine cover.

Loosen the nuts (Item 1) [B] and adjust the stop (Item 2) [B]. Tighten the nuts (Item 1) [B] when the stop (Item 2) [B] is in the correct position.

Loosen the two bolts (Item 3) [B] and adjust the striker plate (Item 4) [B] until it is in the correct position. Tighten the two bolts (Item 3) [B].



## AIR CLEANER

### Air Cleaner Service

**NOTE:** 331 (S/N 512915200 & Above) is shown. The procedure is the same for all serial number excavators.

See the *SERVICE SCHEDULE*, Page 1–3 or 1–4 for the correct service interval.

Check the air intake hose for damage. Check the air cleaner housing for damage. Check to make sure all connections are tight.

Replace the large (outer) filter element only when the red ring shows in the window of the condition indicator (Item 1) [A].

**NOTE:** Push the button on the condition indicator (Item 1) [A] and start the engine. If the red ring does not show, do not replace the filter element.

Service the air cleaner as follows:

Remove the dust cover clamps (Item 2) [A].

Remove the dust cover (Item 3) [A].

Remove the large air filter element (Item 1) [B].

Install the new filter element. Install the dust cover and latch the two clamps.

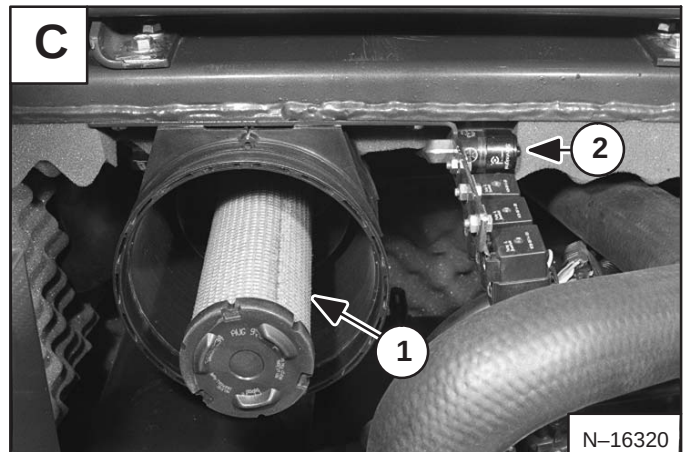
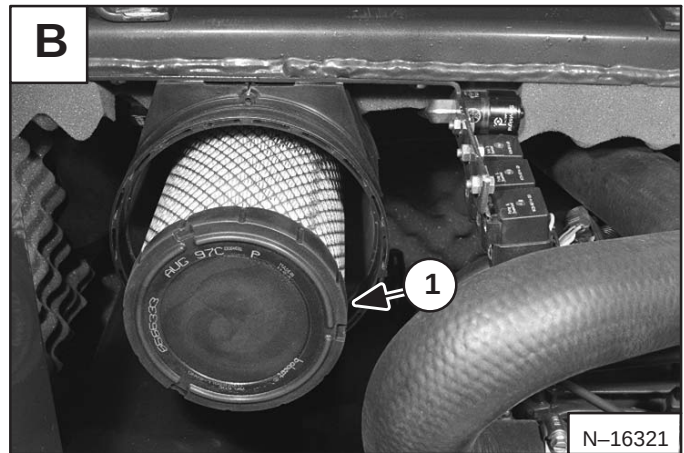
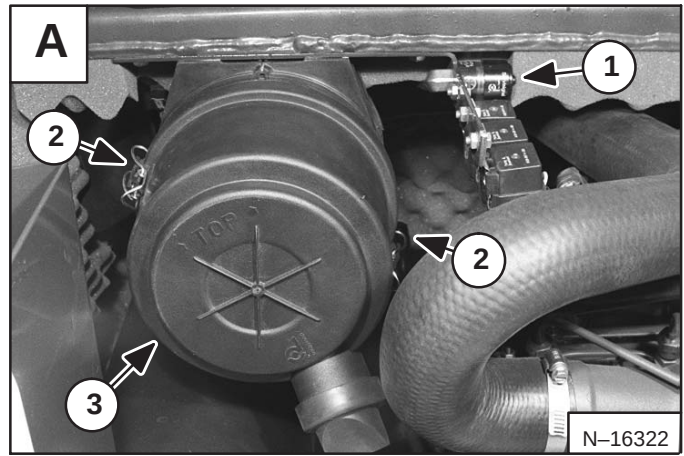
**NOTE:** Make sure all sealing surfaces are free of dirt and debris.

Only replace the inner filter element (Item 1) [C] under the following conditions.

- Replace the inner filter element every third time the outer filter element is replaced.
- Replace the inner filter element when the red ring still shows in the condition indicator window after the outer filter element is replaced.

**NOTE:** After replacing the primary (large) filter element, recheck the condition of the inner filter element by pushing the button on the condition indicator (Item 2) [C] and start the engine. Run the engine at full throttle. If the red ring on the condition indicator shows, replace the inner filter element.

Install the dust cover as shown [D].



## FUEL SYSTEM

### Fuel Specification

Use only clean, high quality diesel fuel, Grade No. 2 or Grade No. 1.

The following is a suggested blending guideline which should prevent fuel gelling problems during cold weather use.

| Temp. F° (C°)       | No. 2 | No.1 |
|---------------------|-------|------|
| +15°(9°)            | 100%  | 0%   |
| Down to -20° (-29°) | 50%   | 50%  |
| Below -20° (29°)    | 0%    | 100% |

For local recommendations, the operator can contact his fuel supplier.

### Filling The Fuel Tank


**WARNING**

Stop and cool the engine before adding fuel, NO SMOKING! Failure to obey warnings can cause an explosion or fire.

W-2063-0887

The fuel level in the tank is indicated by the fuel gauge (Item 1) [A] & [B] when the ignition switch is ON.

**NOTE:** When the fuel level reaches approximately the 2.5 gals. (9,3 L.) fuel level, the low fuel light (Item 2) [A] & [B] will come ON to alert the operator of this condition.

Use the key to unlock the fuel fill door [C].

Turn the fuel cap to remove it [D].

Use a clean, approved safety container to add fuel to the tank.

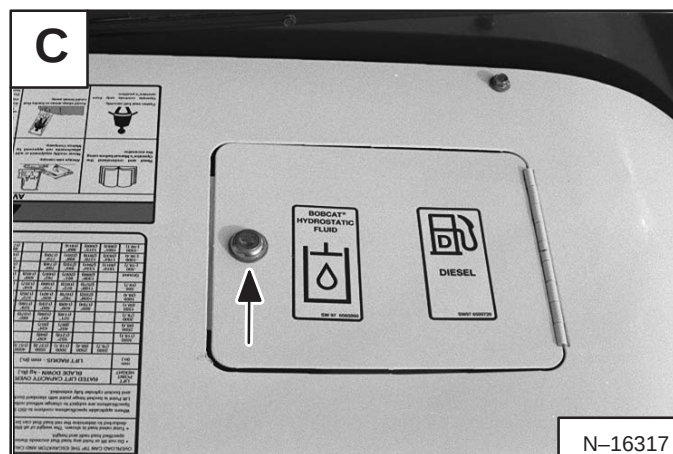
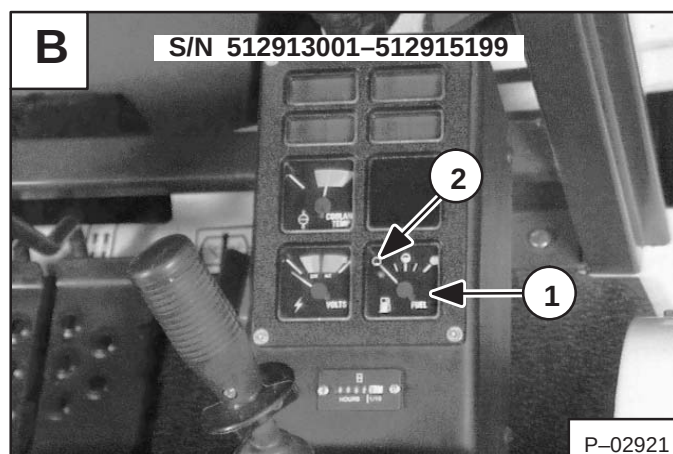
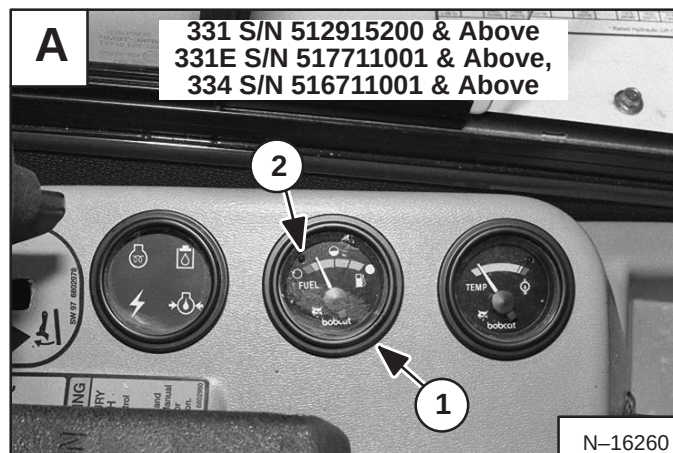
Add fuel only in an area that has a free movement of air and no flames or sparks. NO SMOKING!

After the tank is full, install and tighten the fuel cap. Close and lock the fuel door.


**WARNING**

Always clean up spilled fuel or oil. Keep heat, flames, sparks or lighted tobacco away from fuel and oil. Failure to use care around combustibles can cause explosion or fire which can result in injury or death.

W-2103-1285



## FUEL SYSTEM (Cont'd)

### Fuel System Maintenance (331 S/N 512913001–512915199)

See the *SERVICE SCHEDULE*, Page 1–3 for the correct service interval. To remove water and sediment from the fuel tank, turn the upperstructure until the fuel tank is centered between the rear tracks.

Open the drain valve (Item 1) **[A]** at the bottom of the fuel tank.

Drain all water and sediment into a container.

See the *SERVICE SCHEDULE*, Page 1–3 for the service interval when to remove the water from the fuel filter.

Loosen the drain (Item 1) **[B]** at the bottom of the filter element to drain any water from the fuel filter.

Tighten the drain when all the water has been removed from the fuel filter.

### Fuel Filter (331 S/N 512913001–512915199)

See the *SERVICE SCHEDULE*, Page 1–3 for the service interval when to replace the fuel filter.

Remove the filter element (Item 2) **[B]**.

Clean the area around the filter housing. Put oil on the seal of the new filter element. Install the fuel filter and hand tighten.

Remove the air from the fuel filter.

### Removing Air From The Fuel System (331 S/N 512913001–512915199)

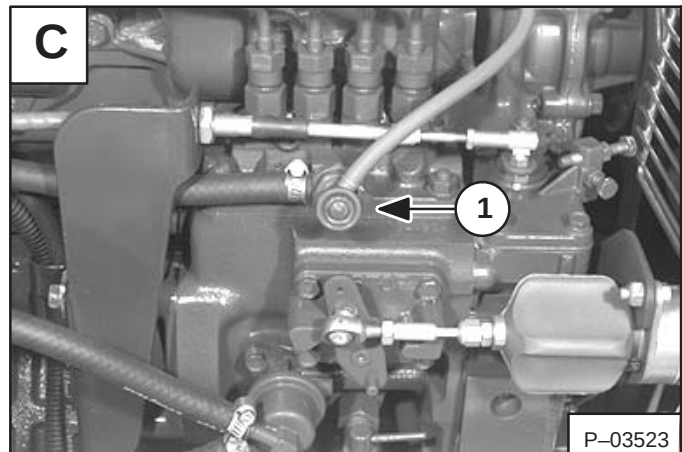
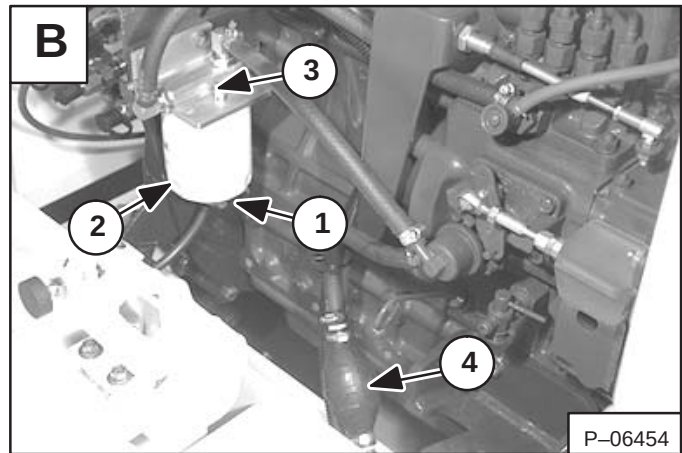
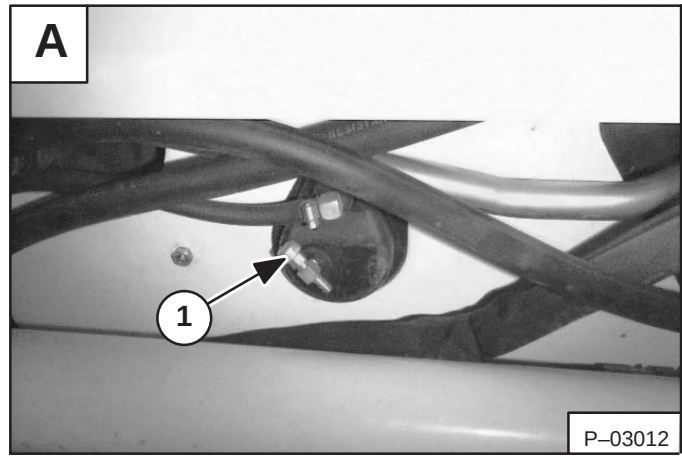
After replacing the fuel filter or when the fuel tank has run out of fuel, the air must be removed from the fuel system prior to starting the engine.

Open the vent (Item 3) **[B]** on the fuel filter housing.

Operate the hand pump (priming bulb) (Item 4) **[B]** until the fuel flows from the vent with no air bubbles.

Tighten the vent plug.

Start the engine. It may be necessary to open the vent (Item 1) **[C]** at the fuel injection pump briefly until the engine runs smooth.



## WARNING

Always clean up spilled fuel or oil. Keep heat, flames, sparks or lighted tobacco away from fuel and oil. Failure to use care around combustibles can cause explosion or fire which can result in injury or death.

W-2103-1285

## FUEL SYSTEM (Cont'd)

### Fuel System Maintenance (331 S/N 512915200 & Above), (331E S/N 517711001 & Above) & (334 S/N 516711001 & Above)

See the *SERVICE SCHEDULE*, Page 1–4 for the correct service intervals.

To remove water and sediment from the fuel tank, turn the upperstructure until the fuel tank is centered between the rear tracks.

Open the drain valve (Item 1) **[A]** at the bottom of the fuel tank.

Drain contaminated fuel into a container.

Loosen the drain (Item 1) **[B]** at the bottom of the filler element to drain any water from the fuel filter.

Tighten the drain when all the water has been removed from the fuel filter.

### Fuel Filter (331 S/N 512915200 & Above), (331E S/N 517711001 & Above) & (334 S/N 516711001 & Above)

See the *SERVICE SCHEDULE*, Page 1–4 for the correct service intervals.

Remove the filter element (Item 2) **[B]**.

Clean the area around the filter housing. Put oil on the seal of the new filter element. Install the fuel filter and hand tighten.

Remove the air from the fuel filter.

### Removing Air From The Fuel System (331 S/N 512915200 & Above), (331E S/N 517711001 & Above) & (334 S/N 516711001 & Above)

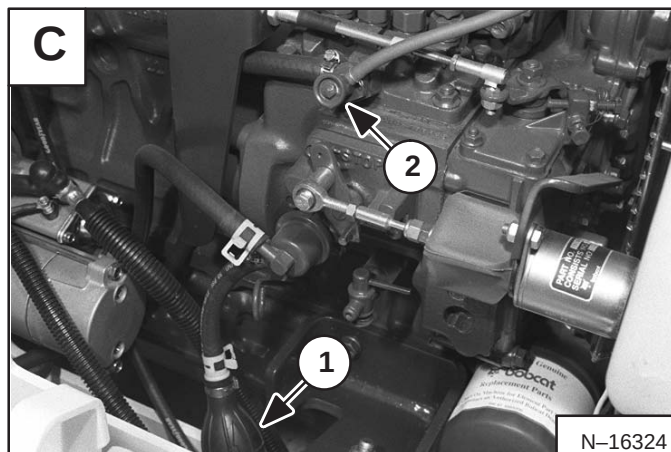
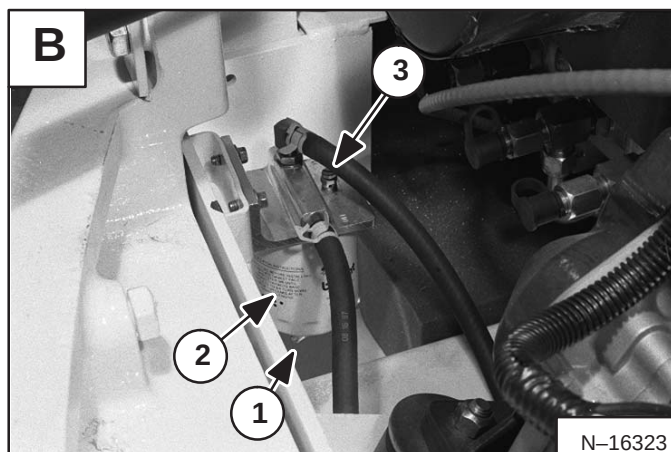
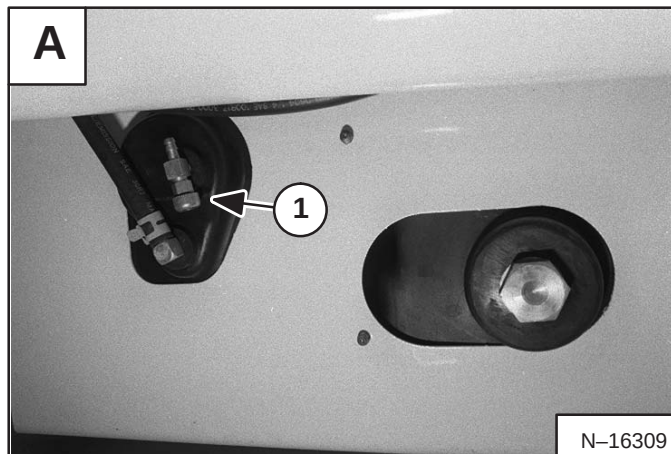
After replacing the fuel filter or when the fuel tank has run out of fuel, the air must be removed from the fuel system before starting the engine.

Open the vent (Item 3) **[B]** on the fuel filter housing.

Operate the hand pump (priming bulb) (Item 1) **[C]** until the fuel flows from the vent with no air bubbles.

Tighten the vent (Item 3) **[B]**.

Start the engine. It may be necessary to open the vent (Item 2) **[C]** at the fuel injection pump briefly until the engine runs smoothly.



## WARNING

Always clean up spilled fuel or oil. Keep heat, flames, sparks or lighted tobacco away from fuel and oil. Failure to use care around combustibles can cause explosion or fire which can result in injury or death.

W-2103-1285

## ENGINE LUBRICATION SYSTEM

### Checking Engine Oil

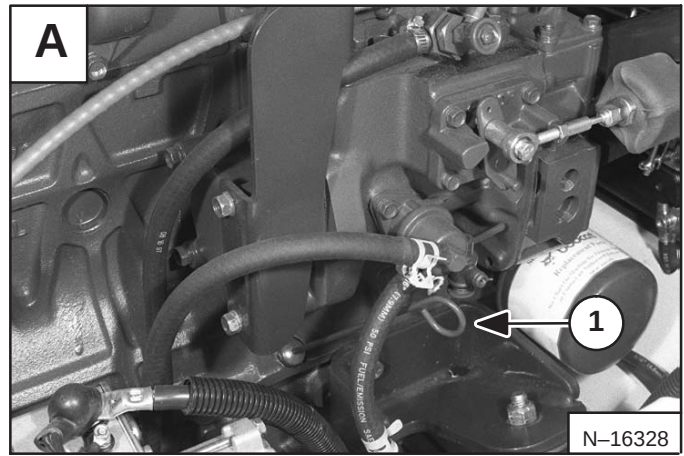
Check the engine oil every day.

Stop the engine. Open the engine cover.

Remove the dipstick (Item 1) [A].

Keep the oil level between the marks on the dipstick.

Use a good quality motor oil that meets the correct API Service Classification. (See *FUEL, COOLANT AND LUBRICATION Chart*, Page 8–1.)



### Replacement Of Oil And Filter

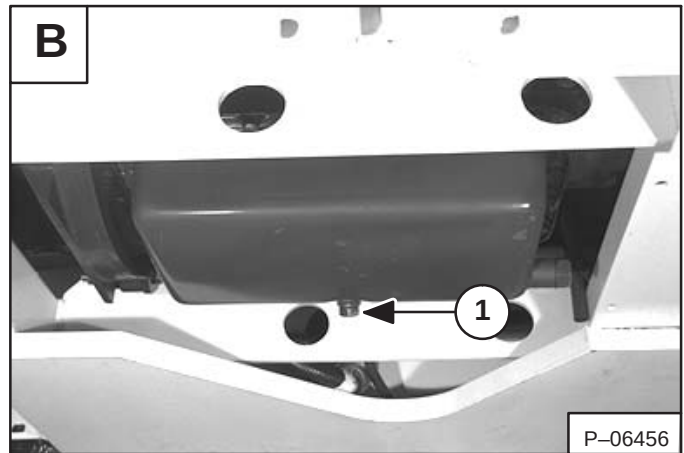
See the *SERVICE SCHEDULE*, Page 1–3 or 1–4 for the correct service interval.

**NOTE:** 331 S/N 512915200 & Above is shown. The procedure is the same for all serial number machines.

Run the engine until it is at operating temperature. Stop the engine.

Open the engine cover.

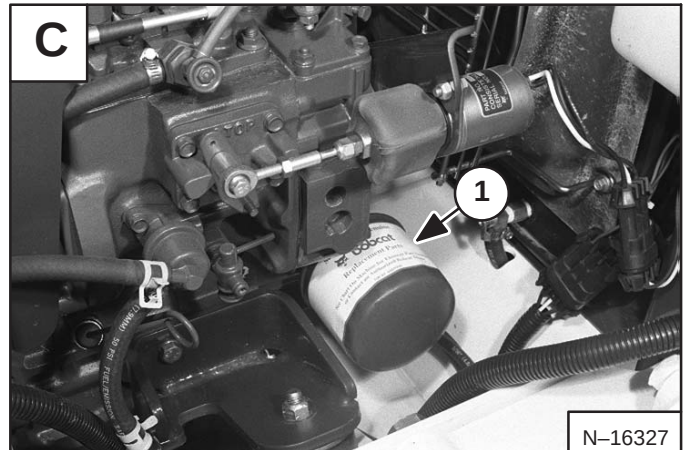
Remove the drain plug (Item 1) [B] from the oil pan. Drain the oil into a container.



Remove the oil filter (Item 1) [C], using a filter wrench.

Clean the filter housing surface. Put clean oil on the filter gasket. Install the new filter and hand tighten only.

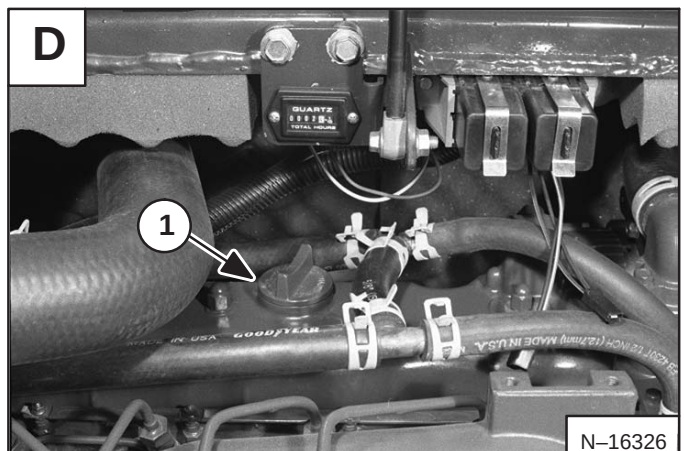
Install and tighten the oil drain plug.



Remove the oil fill cap (Item 1) [D]. Put in 7.5 qts. (7,1 L) of oil into the engine. (SEE *FUEL, COOLANT AND LUBRICANTS Chart*, Page 8–1.)

Start the engine and let it run for several minutes. Stop the engine. Check for leaks at the oil filter and the oil drain plug.

Check the oil level and add oil as needed if it is not at the top mark on the dipstick.





**Suggest:**

**If the above button click is invalid.**

**Please download this document  
first, and then click the above link  
to download the complete manual.**

**Thank you so much for reading**

## COOLING SYSTEM

### Coolant Level



## WARNING

Do not remove radiator cap when the engine is hot. You can be seriously burned.

W-2070-1285

When the engine is cool, the coolant level in the recovery tank (Item 1) [A] must be half full.

If the coolant level is low, add premixed coolant to the recovery tank (See type of coolant information below).

### Coolant Replacement

See the *SERVICE SCHEDULE*, Page 1-3 or 1-4 for the correct service intervals.

Turn the upperstructure so there is access to the engine and radiator from between the tracks. Stop the engine.

When the engine is cool, loosen and remove the radiator cap (Item 2) [A].

Open the radiator drain valve (Item 1) [B] at bottom of radiator. Drain the coolant into a container.

Open the engine block drain valve (Item 2) [B] and drain the coolant into a container.

After all the coolant is removed, close both drain valves.

Remove all coolant from the coolant recovery tank (Item 1) [A] also.

Mix the coolant in a separate container. (See *SPECIFICATIONS* Page 8-1, for correct capacity).

**NOTE:** The excavator is factory filled with propylene glycol. **DO NOT** mix propylene glycol with ethylene glycol.

Add premixed coolant; 47% water and 53% propylene glycol to the recovery tank if the coolant level is low.

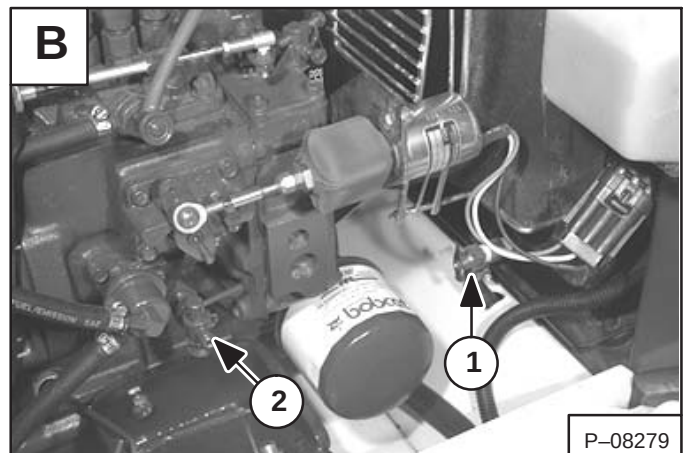
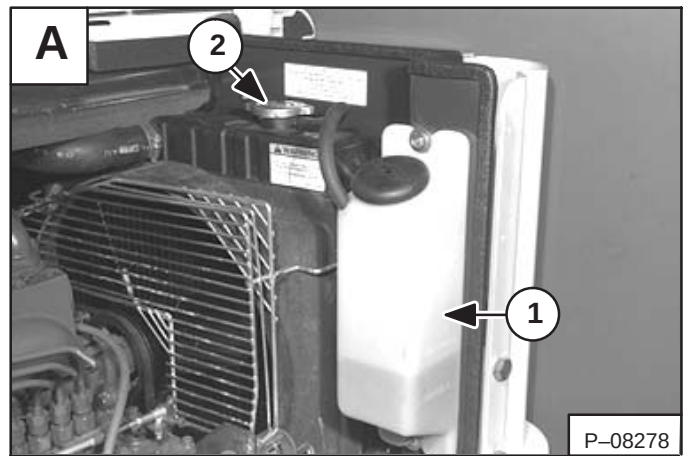
One gallon and one pint of propylene glycol mixed with one gallon of water is the correct mixture of coolant to provide a -34°F (-37°C) freeze protection.

Use a refractometer to check the condition of propylene glycol in your cooling system.

Fill the radiator with the premixed coolant until it is full. Add coolant to the recovery tank until it is half full.

Run the engine at idle speed for about 5 – 10 minutes to remove the air from the cooling system (leave the radiator cap off during this operation).

Stop the engine. Check the coolant level and add as needed to bring it up to the radiator filler neck. Install the radiator cap and tighten.



## IMPORTANT

### AVOID ENGINE DAMAGE

Always use the correct ratio of water to anti-freeze.

Too much antifreeze reduces cooling system efficiency and may cause serious premature engine damage.

Too little antifreeze reduces the additives which protect the internal engine components; reduces the boiling point and freeze protection of the system.

Always add a premixed solution. Adding full strength concentrated coolant can cause serious premature engine damage.

I-2124-0497

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