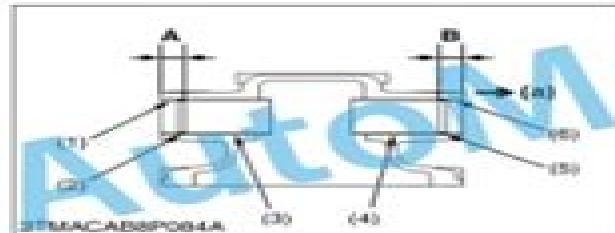


[4] SERVICING

(1) Hydraulic Cylinder



Hydraulic Cylinder Bore

1. Check the cylinder internal surface for scoring or damage.
2. Measure the cylinder I.D. with a cylinder gauge.
3. If the measurement exceeds the allowable limit, replace it.

Cylinder I.D.	Factory spec.	90.000 to 90.050 mm 3.5433 to 3.5452 in.
	Allowable limit	90.150 mm 3.5492 in.

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Clearance between Hydraulic Arm Shaft and Bushing

1. Measure the hydraulic arm shaft O.D. with an outside micrometer.
2. Measure the bushing I.D. with a inside micrometer, and calculate the clearance.
3. If the clearance exceeds the allowable limit, replace the bushing.

Clearance between hydraulic arm shaft and bushing (Right side)	Factory spec.	0.125 to 0.270 mm 0.00492 to 0.0106 in.
	Allowable limit	0.50 mm 0.020 in.

Hydraulic arm shaft O.D. (Right side)	Factory spec.	44.920 to 44.950 mm 1.7685 to 1.7696 in.
Bushing I.D. (After press-fitted) (Right side)	Factory spec.	45.075 to 45.150 mm 1.7746 to 1.7775 in.

Clearance between hydraulic arm shaft and bushing (Left side)	Factory spec.	0.125 to 0.220 mm 0.00493 to 0.00866 in.
	Allowable limit	0.50 mm 0.020 in.

Hydraulic arm shaft O.D. (Left side)	Factory spec.	39.920 to 39.950 mm 1.5717 to 1.5728 in.
Bushing I.D. (After press-fitted) (Left side)	Factory spec.	40.075 to 40.140 mm 1.5778 to 1.5803 in.

(When reassembling)

- When press-fitting a new bushing with a press-fitting tool (Refer to "B. SPECIAL TOOLS" at "G. GENERAL" section), observe the dimensions described in the figure.
- When press-fitting a new bushing, apply transmission fluid to the hydraulic cylinder liner boss and bushing.
- When press-fitting a new bushing, press-fit it so that each seam faces up.

Press-fit location of bushing	Reference value	A	21.5 to 22.5 mm 0.847 to 0.885 in.
		B	24.5 to 25.5 mm 0.965 to 1.00 in.

- (1) Collar (Left)
(2) O-ring
(3) Bushing (Left)
(4) Bushing (Right)
(5) O-ring
(6) Collar (Right)

- (a) Right Side
* Flush the end of collar with the end of hydraulic cylinder body

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Kubota Backhoe L45 Manual

Ying Liu



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Table of Contents Kubota Backhoe L45 Manual

1. Understanding the eBook Kubota Backhoe L45 Manual
 - The Rise of Digital Reading Kubota Backhoe L45 Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying Kubota Backhoe L45 Manual
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Kubota Backhoe L45 Manual
 - User-Friendly Interface

4. Exploring eBook Recommendations from Kubota Backhoe L45 Manual
 - Personalized Recommendations
 - Kubota Backhoe L45 Manual User Reviews and Ratings
 - Kubota Backhoe L45 Manual and Bestseller Lists
5. Accessing Kubota Backhoe L45 Manual Free and Paid eBooks
 - Kubota Backhoe L45 Manual Public Domain eBooks
 - Kubota Backhoe L45 Manual eBook Subscription Services
 - Kubota Backhoe L45 Manual Budget-Friendly Options
6. Navigating Kubota Backhoe L45 Manual eBook Formats
 - ePub, PDF, MOBI, and More
 - Kubota Backhoe L45 Manual Compatibility with Devices
 - Kubota Backhoe L45 Manual Enhanced eBook Features
7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Kubota Backhoe L45 Manual
 - Highlighting and Note-Taking Kubota Backhoe L45 Manual
 - Interactive Elements Kubota Backhoe L45 Manual
8. Staying Engaged with Kubota Backhoe L45 Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Kubota Backhoe L45 Manual
9. Balancing eBooks and Physical Books Kubota Backhoe L45 Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Kubota Backhoe L45 Manual
10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
11. Cultivating a Reading Routine Kubota Backhoe L45 Manual
 - Setting Reading Goals Kubota Backhoe L45 Manual
 - Carving Out Dedicated Reading Time

-
12. Sourcing Reliable Information of Kubota Backhoe L45 Manual
 - Fact-Checking eBook Content of Kubota Backhoe L45 Manual
 - Distinguishing Credible Sources
 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
 14. Embracing eBook Trends
 - Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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