



TSB090908-012

TECHNICAL SERVICE BULLETIN

SUBJECT: CAVITY PLUG LEAKAGE

AFFECTED MODELS: SR SERIES HARVESTERS

If hydraulic fluid leakage is noted at the area around the cavity plug, the plug may be loose causing the O-ring to fail. The cavity plug is located on the bottom of the flow control valve body assembly. **Figure 1** shows the cavity plug with the flow control valve body removed and inverted.

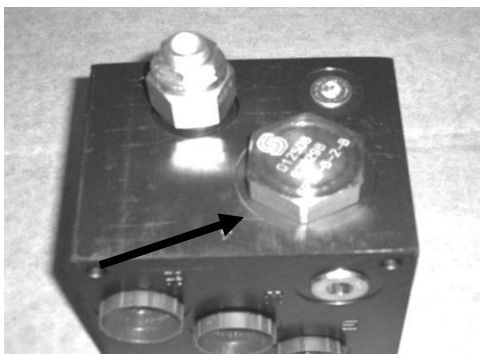


Figure 1—Cavity Plug

If necessary, contact Bucyrus Equipment Company Inc. (800-330-0857) to obtain replacement O-rings (part No. 3-916) and special sealant (part No. 0471767) used to repair the leakage. We recommend replacing the O-rings on all three cavity plugs.

To replace the O-rings, proceed as follows:

1. Thoroughly clean the area around the cavity plug to prevent contaminating the hydraulic system.
2. Remove the cavity plug using a 1-1/2 in. wrench or socket.
3. Remove and discard the O-ring (**Figure 2**).



Figure 2—Cavity Plug O-Ring

4. Clean the threads on the plug and in the flow control valve body. Do not allow any contamination to enter the valve body or cavity plug.
5. Install a new O-ring on the cavity plug and apply a light coat of sealant to the threads.
6. Install the cavity plug into the valve body and tighten to 140 ft.-lbs. (190

N.m) using an accurate torque wrench.
Allow the sealant to cure for 10-15

minutes before resuming operation.