



Kubota

Bulletin No :
CM-23-057-02-KEEN
Date : Feb. 09, 2024
Ref.PB No :

SUBJECT :
POSSIBLE MATERIAL FATIGUE ON THE
HYDRAULIC OIL TANK

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MODEL : U15-3 AND U17-3A

AFFECTED SERIAL NUMBER : U15-3 ; TO 70828, U17-3A ; FROM 20001 TO 79307

AFFECTED COUNTRY : KE, KUK, AND KBD

REASON FOR ISSUE :

Cases of hydraulic oil leakage from the oil tank have been reported.

The investigation revealed that the oil tank may crack due to material fatigue. We herewith inform you of the measure to be taken in such cases.



REASON FOR REVISION :

Affected serial number was updated.

PARTS INFORMATION :

No.	Parts No.	Parts Name	Q'ty	Remarks
1	RA231-62120	TANK, OIL	1	For U17-3A
2	RA221-62120			For U15-3
3	V0511-65170	PLUG	1	
4	04817-00290	O RING	1	
5	RA231-62130	COVER (TANK)	1	
6	RA011-62190	FILTER, RETURN	1	
7	04811-51200	O RING	1	
8	04811-50500	O RING	1	
9	RD706-62180	CAP, ASSY	1	
10	RA231-62250	TUBE (BREATHER)	1	
11	01123-50814	BOLT	9	
12	RB238-62150	FILTER, SUCTION	1	
13	68841-62170	GAUGE, OIL LEVEL	1	
14	04817-00110	O RING	1	
15	R1401-42840	PLUG, DRAIN	1	
16	04717-01610	WASHER SEAL	1	
17	RA221-42562	HEAT INSULATION, TANK	1	
18	RA221-62212	SPONGE, OIL TANK	1	
19	RA221-62220	SPONGE (OIL TANK, 3)	1	
20	RA221-62230	SPONGE (OIL TANK, 4)	1	
21	RA221-62240	SPONGE (OIL TANK, 5)	1	
22	RA221-62250	SPONGE (OIL TANK, 6)	1	
23	RA221-62260	SPONGE (OIL TANK, 7)	1	
24	RC108-57470	LABEL	1	

☒ **WARRANTY INFORMATION**

- ☐ Mandatory Campaign : Allowable Man-hours ;
- ☒ Technical Bulletin : Allowable Man-hours ; 4.0 hrs.
- Expiration date : 5 years from machine retail date
- ☐ Quality Related Information

REPAIR PROCEDURE

Required tools

No.	Tool Name	Remarks
(1)	Torque wrench	Required torque: 55.7 to 63.9 N·m
(2)	Torque wrench	Required torque: 9.8 to 27.5 N·m
(3)	38 mm socket	
(4)	19 mm socket	
(5)	12 mm socket	
(6)	Extension bar (150 mm)	

Photo of tools

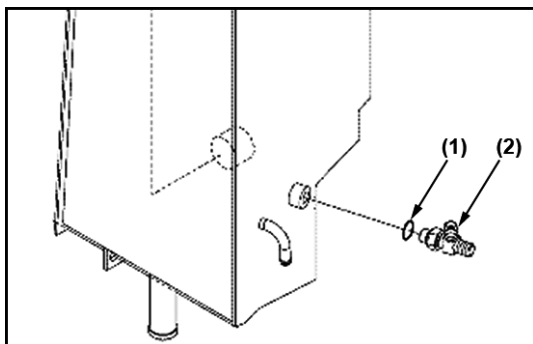


WARNING

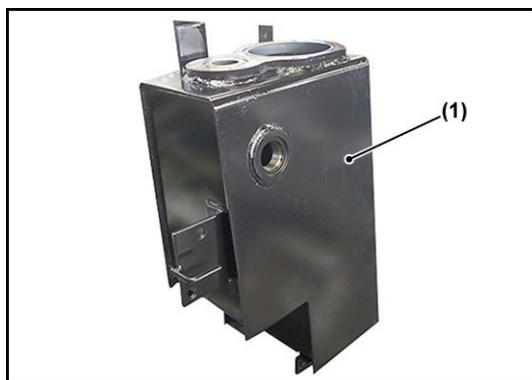
To avoid personal injury or death:

- Park the machine on a firm and level ground.
- Lower the bucket to the ground.
- Set all controls in their neutral positions.
- Release all residual pressure of the hydraulic system.
- Stop the engine. Remove the key from the ignition.
- The engine, hydraulic components and coolants can be hot.
Wait until all the components are cooled down sufficiently to avoid burns.
- Do not open the radiator cap soon after the engine has stopped. There is a possibility of serious burn injury due to the coolant blowing out from the radiator.
- Clean the work area and the machine.
- Disconnect the battery negative cable.
- Hang a "DO NOT OPERATE" tag on the operator station.
- Put on working clothes and personal protective equipment.
- Read all instructions and safety instructions in this bulletin and safety labels on your machine.
- Follow the local safety regulations and/or laws in your country.
- If you are working with other people, make sure that your signals and communications are fully understandable for additional safety.

1. Removing the oil tank

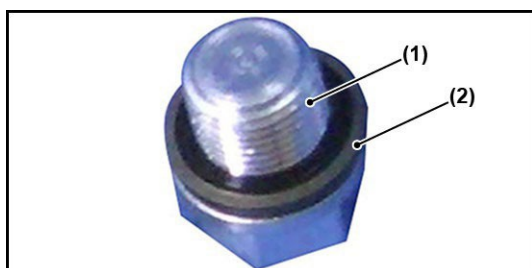
	<p>1. Remove the oil tank according to the WSM.</p> <p>■ NOTE</p> <ul style="list-style-type: none"> • U17-3A: 6. HYDRAULIC SYSTEM > SERVICING > 4. Repairing > 4.13 Hydraulic oil tank • U15-3: Refer to the WSM of U17-3A
	<p>2. Remove the O-ring (1) and the pipe joint (2) from the oil tank.</p> <p>(1) O RING: 04817-00110 (2) T JOINT, PIPE (F): Reuse</p>

2. Preparing the oil tank



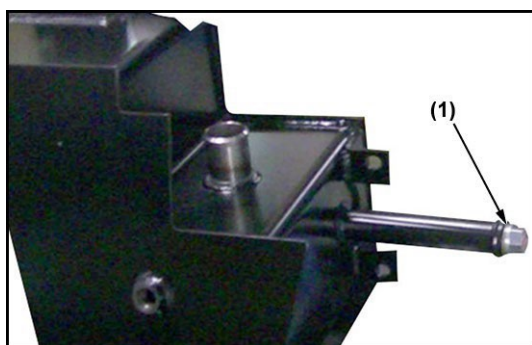
1. Prepare the new oil tank (1).

- (1) TANK, OIL: RA231-62120 (For U17-3A)
RA221-62120 (For U15-3)



2. Attach the washer seal (2) to the drain plug (1).

- (1) PLUG, DRAIN: R1401-42840
(2) WASHER SEAL: 04717-01610



3. Install the drain plug (1) with the washer seal to the oil tank.

Tightening torque	PLUG, DRAIN	55.7 to 63.9 N·m 5.7 to 6.5 kgf·m 41.1 to 47.1 lbf·ft
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- (1) PLUG, DRAIN: R1401-42840

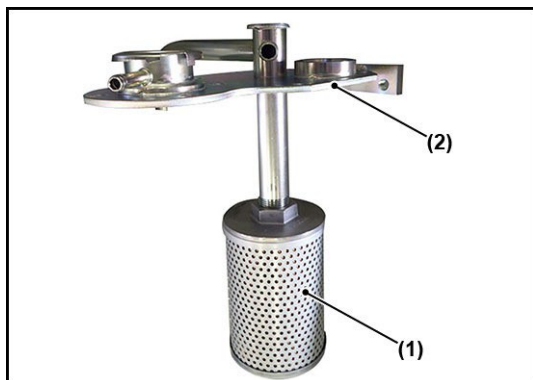


4. Install the suction filter (1) into the hydraulic oil tank according to the WSM.

■ **NOTE**

- **U17-3A: 3. MAINTENANCE**
 - > **EVERY 1000 HOURS**
 - > **1. Replacing the hydraulic oil and suction filter**
 - > **Replacing**
- **U15-3: Refer to the WSM of U17-3A**

- (1) FILTER, SUCTION: RB238-62150



5. Preassemble the return filter (1) to the tank cover (2) according to the WSM.

■ **NOTE**

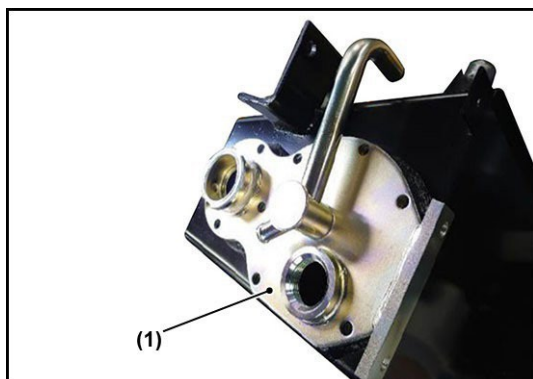
- **U17-3A: 3. MAINTENANCE**
 > **INITIAL 250 HOURS / EVERY 500 HOURS**
 > **5. Replacing the return filter > replacing**
 > **step 3.**
- **U15-3: Refer to the WSM of U17-3A**

- (1) FILTER, RETURN: RA011-62190
 (2) COVER (TANK): RA231-62130



6. Insert the O-rings (1) and (2) into the O-ring grooves.

- (1) O RING: 04811-50500
 (2) O RING: 04811-51200

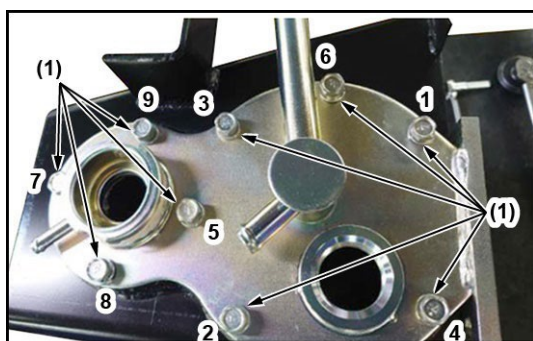


7. Install the tank cover (1).

■ **NOTE**

- **When installing the tank cover, make sure the O-rings fitted in step 2-6 are properly inserted into the grooves.**

- (1) COVER (TANK): RA231-62130



8. Install and tighten the bolts (1).

■ **NOTE**

- **Tighten the bolts in the order of 1 to 9. Finally, retighten once again.**

Tightening torque	BOLT	23.5 to 27.5 N·m 2.4 to 2.8 kgf·m 17.4 to 20.2 lbf·ft
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- (1) BOLT: 01123-50814 X9

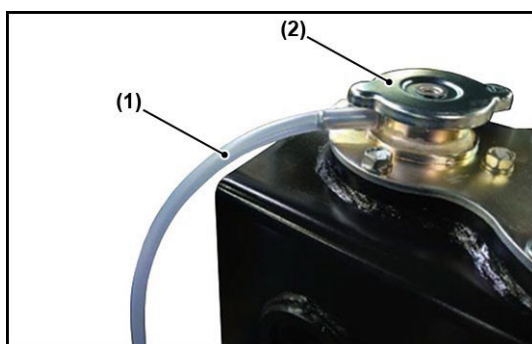


9. Attach the cap assy (1).

■ **NOTE**

- **Rotate the cap until the claws are hooked.**

(1) CAP ASSY: RD706-62180



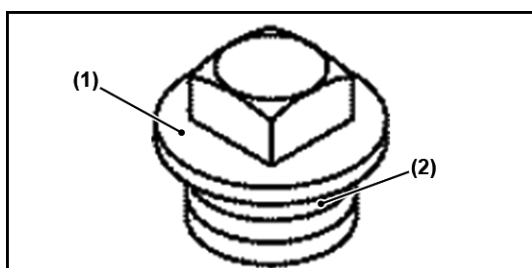
10. Install the breather tube (1) to the cap (2).

■ **NOTE**

- **Insert the tube (breather) all the way in.**

(1) TUBE (BREATHER): RA231-62250

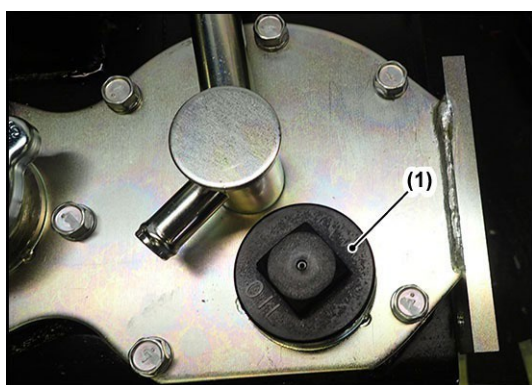
(2) CAP ASSY: RD706-62180



11. Attach the O-ring (2) to the oil filler plug (1).

(1) PLUG: V0511-65170

(2) O RING: 04817-50290



12. Attach the oil filler plug (1) to the tank cover.

■ **NOTE**

- **Tighten the plug by hand to a degree that it does not fall off.**

(1) PLUG: V0511-65170



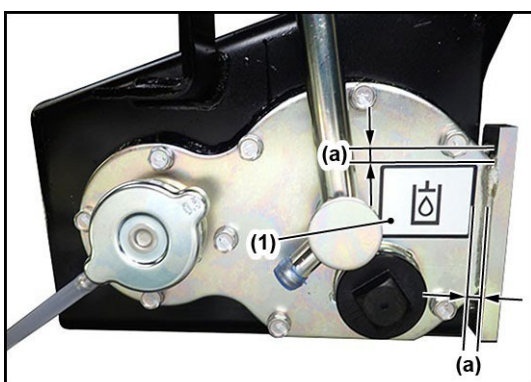
13. Install the oil level gauge (1).

■ **NOTE**

- If oil is deposited on the part to be screwed, clean it in advance.

Tightening torque	GAUGE, OIL LEVEL	9.8 to 11.3 N·m 1.0 to 1.15 kgf·m 7.3 to 8.3 lbf·ft
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(1) GAUGE, OIL LEVEL: 68841-62170



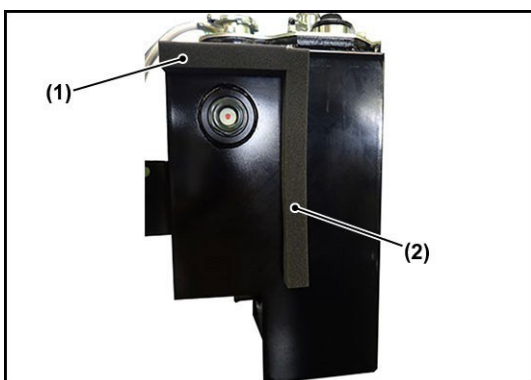
14. Affix the label (1) to the tank cover.

■ **NOTE**

- Clean the surface of cover with cleaning solution before attaching the label.
- Make sure that the label position is correct and there are no wrinkles or air bubbles.

(1) LABEL: RC108-57470

(a) 10 mm



15. Affix the sound absorbing material (1) by aligning it with the top surface from the upper left corner of the oil tank. Attach the sound absorbing material (2) on the left end of the sound absorbing material (1), perpendicular to the top surface of the oil tank.

■ **NOTE**

- After affixing the sound absorbing materials, press down the entire surface and gently pinch to check that there is no peeling.

(1) SPONGE (OIL TANK, 5): RA221-62240

(2) SPONGE (OIL TANK, 7): RA221-62260

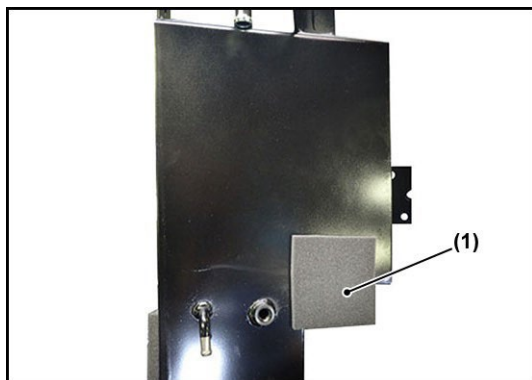


16. Affix the sound absorbing material (1) by aligning it with the bottom on the right side face toward the oil level gauge face.

■ **NOTE**

- After affixing the sound absorbing materials, press down the entire surface and gently pinch to check that there is no peeling.

(1) SPONGE, OIL TANK: RA221-62212

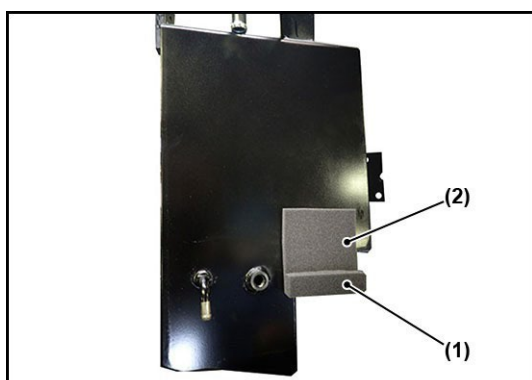


17. Affix the sound absorbing material (1) by aligning it with the bottom right corner on the opposite face of the oil level gauge face.

■ **NOTE**

- After affixing the sound absorbing materials, press down the entire surface and gently pinch to check that there is no peeling.

(1) SPONGE (OIL TANK, 3): RA221-62220

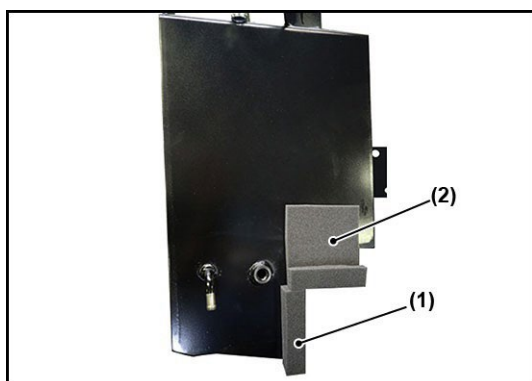


18. Affix the sound absorbing material (1) by aligning it with the bottom right corner on sound absorbing material (2).

■ **NOTE**

- After affixing the sound absorbing material, press down the entire surface and gently pinch to check that there is no peeling.

(1) SPONGE (OIL TANK, 4): RA221-62230

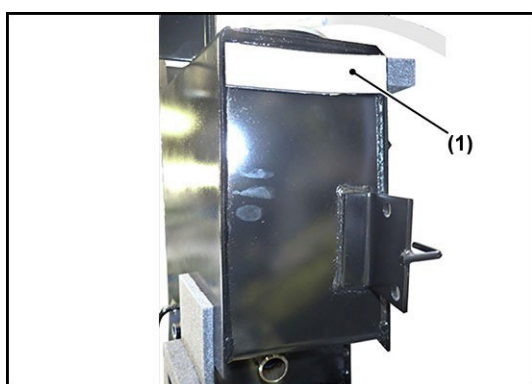


19. Affix sound absorbing material (1) by aligning it with the bottom end of the sound absorbing material (2) and align it vertically with the right end of the oil tank.

■ **NOTE**

- After affixing the sound absorbing material, press down the entire surface and gently pinch to check that there is no peeling.

(1) SPONGE (OIL TANK, 6): RA221-62250

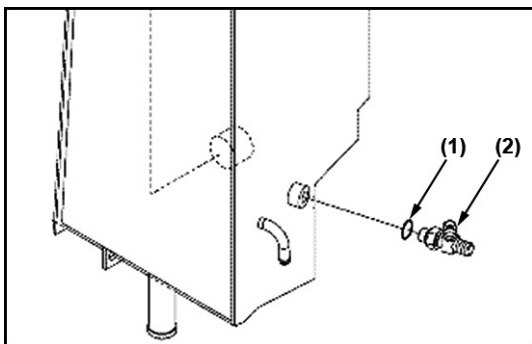


20. Affix the heat insulation (1) by aligning it with the top surface of the tank.

■ **NOTE**

- After affixing the heat insulating material, press down the entire surface and gently pinch to check that there is no peeling.

(1) HEAT INSULATION, TANK: RA221-42562



21. Attach the new O-ring (1) to the pipe joint (2) and assemble it to the oil tank.

■ **NOTE**

- **U17-3A : 6. HYDRAULIC SYSTEM**
 > **SERVICING** > 4. Repairing
 > 4.12.3 Installing adapters for the hydraulic oil
- **U15-3 : Refer to the WSM of U17-3A**

- (1) O RING: 04817-00110
 (2) T JOINT, PIPE (F): Reuse

3. Installing the hydraulic oil tank

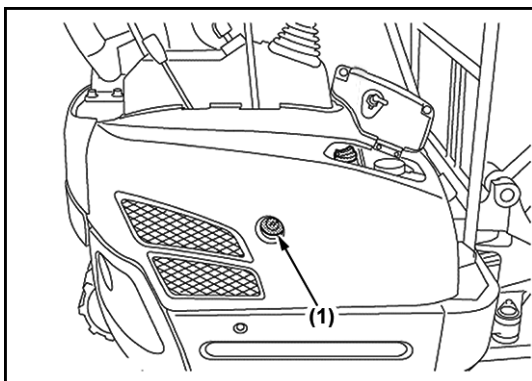


1. Install the fully preinstalled hydraulic oil tank according to the WSM.

■ **NOTE**

- **U17-3A: 6. HYDRAULIC SYSTEM**
 > **SERVICING** > 4. Repairing
 > 4.13 Hydraulic oil tank
- **U15-3: Refer to the WSM of U17-3A**

4. Refilling the hydraulic oil



1. Refilling the hydraulic oil and check for any oil leaks.

■ **NOTE**

- **Check the oil level as to whether it lies on the center of the gauge (1).**