



Kubota

Bulletin No : CM-24-022-01-KEEN
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 Ref.PB No :

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SUBJECT :

LEAK IN THE HYDRAULIC OIL COOLER

MODEL : KX060-5, U56-5, U50-5, KX057-5, U55-5, AND U48-5

AFFECTED SERIAL NUMBER : KX060-5 : UP TO 15460, U56-5 : UP TO 15591

U50-5 : UP TO 14023, KX057-5 : UP TO 19379

U55-5 : UP TO 14319, U48-5 : UP TO 11995

AFFECTED COUNTRY : KUK, KE, KBD, KTC, AND KCL

REASON FOR ISSUE :

Cases are reported that hydraulic oil leaks due to a crack on the oil cooler right hand side. The investigation revealed that brazing failures were found. This caused the oil cooler to lose stability. As countermeasure a CT scan check is implemented in the production process.

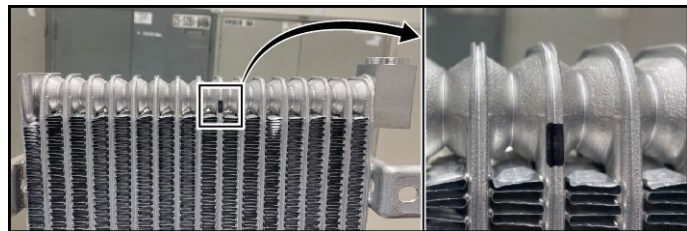
We herewith inform you of the measure to be taken in such cases.



PARTS INFORMATION :

No.	Parts No.	Parts Name	Q'ty	Remarks
1	RD579-64050	COOLER, OIL	1	-

The countermeasure parts have paint on the top of the outer side.



MODEL INFORMATION : Refer to the attached sheet.

☒ **WARRANTY INFORMATION**

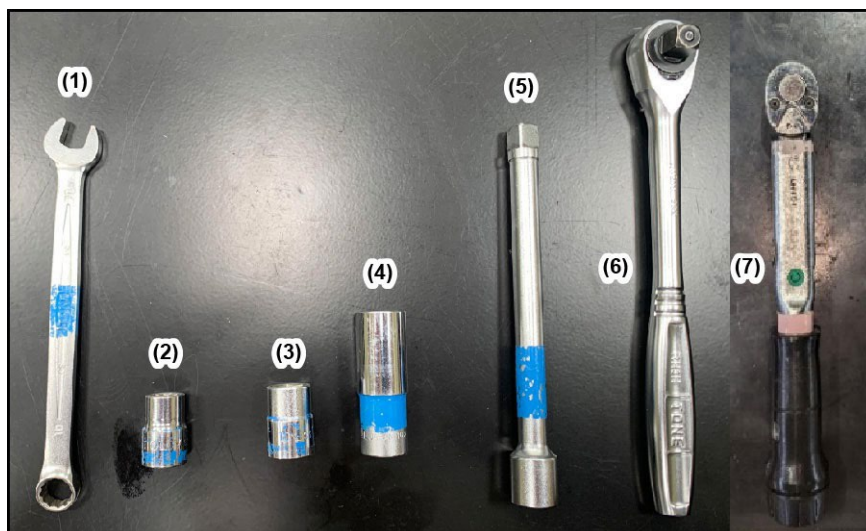
- ☐ Mandatory Campaign : Allowable Man-hours ;
- ☒ Technical Bulletin : Allowable Man-hours ; 3.7 hrs.
 Expiration date : 5 years from machine retail date
- ☐ Quality Related Information

REPAIR PROCEDURE

Required tools

No.	Tool Name	Remarks
1	10 mm spanner	
2	10 mm socket	
3	12 mm socket	
4	14 mm socket	
5	Extension bar (150mm)	
6	Ratchet wrench	
7	Torque wrench	Required torque: 2.5 to 63.7 N·m

Photo of tools



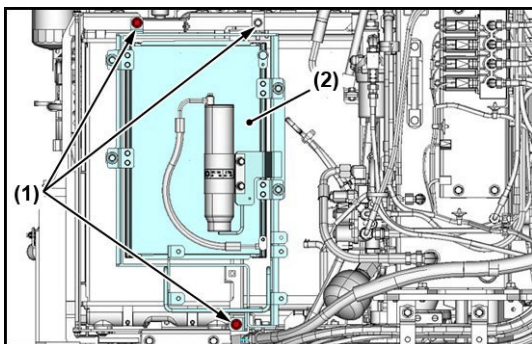
WARNING

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 cracked oil cooler

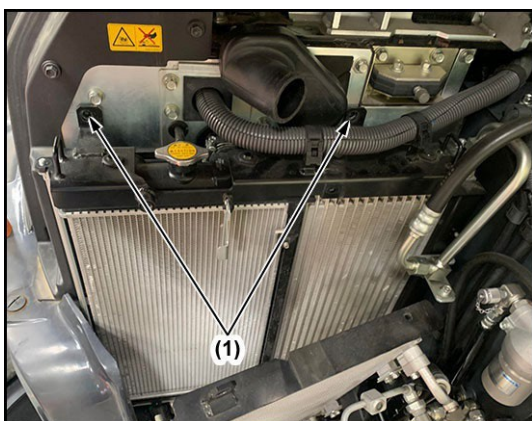
	<p>1. Remove the drain plug and drain the hydraulic oil according to the WSM.</p> <p>■ NOTE</p> <ul style="list-style-type: none">● Chapter 3. MAINTENANCE > EVERY 1000 HOURS > 3. Replacing the hydraulic oil and suction filter					
	<p>2. Remove the 4 bolts (1), (2), and then the bracket (3).</p> <table><tr><td rowspan="2">Tightening torque</td><td>Bolt (M8)</td><td>23.5 to 27.5 N·m 2.4 to 2.8 kgf·m 17.3 to 20.3 lbf·ft</td></tr><tr><td>Bolt (M10)</td><td>48.1 to 55.9 N·m 4.9 to 5.7 kgf·m 35.5 to 41.2 lbf·ft</td></tr></table> <p>(1) Bolt × 2 (2) Bolt × 2 (3) Bracket</p>	Tightening torque	Bolt (M8)	23.5 to 27.5 N·m 2.4 to 2.8 kgf·m 17.3 to 20.3 lbf·ft	Bolt (M10)	48.1 to 55.9 N·m 4.9 to 5.7 kgf·m 35.5 to 41.2 lbf·ft
Tightening torque	Bolt (M8)		23.5 to 27.5 N·m 2.4 to 2.8 kgf·m 17.3 to 20.3 lbf·ft			
	Bolt (M10)	48.1 to 55.9 N·m 4.9 to 5.7 kgf·m 35.5 to 41.2 lbf·ft				
	<p>3. Remove the wire bands (1), and then the engine air cleaner (2).</p> <table><tr><td>Tightening torque</td><td>Wire band</td><td>2.5 to 3.4 N·m 0.3 to 0.4 kgf·m 1.9 to 1.9 lbf·ft</td></tr></table> <p>(1) Wire band × 2 (2) Engine air cleaner</p>	Tightening torque	Wire band	2.5 to 3.4 N·m 0.3 to 0.4 kgf·m 1.9 to 1.9 lbf·ft		
Tightening torque	Wire band	2.5 to 3.4 N·m 0.3 to 0.4 kgf·m 1.9 to 1.9 lbf·ft				
	<p>4. Disconnect the clamps (1).</p> <p>(1) Clamp × 2</p>					



5. Remove the bolts (1), and then lean the condenser to the weight.

Tightening torque	Bolt (M10)	48.1 to 55.9 N·m 4.9 to 5.7 kgf·m 35.5 to 41.2 lbf·ft
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- (1) Bolt × 3
(2) Condenser



6. Remove the bolts (1).

Tightening torque	Bolt (M10)	48.1 to 55.9 N·m 4.9 to 5.7 kgf·m 35.5 to 41.2 lbf·ft
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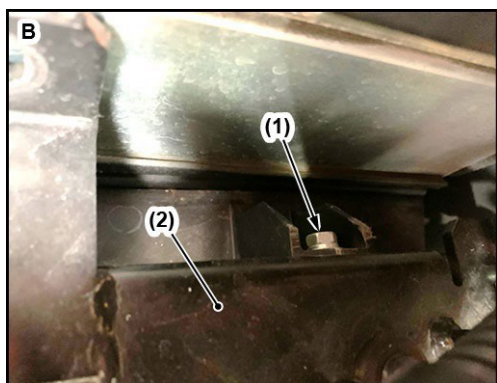
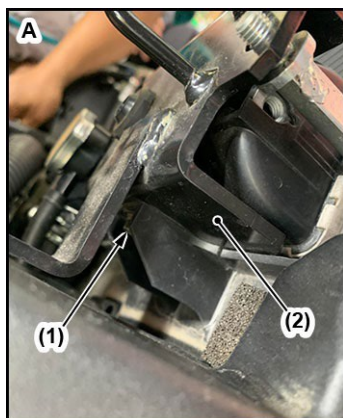
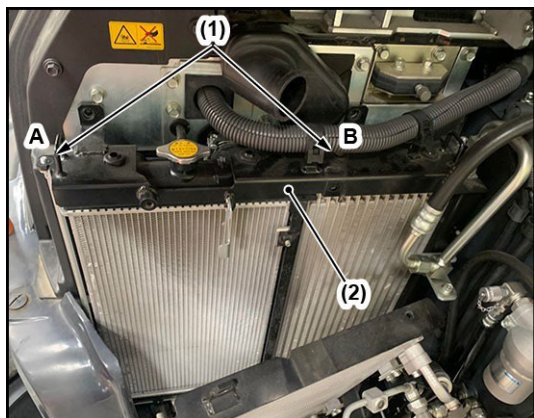
- (1) Bolt × 2



6. Remove the bolt (1).

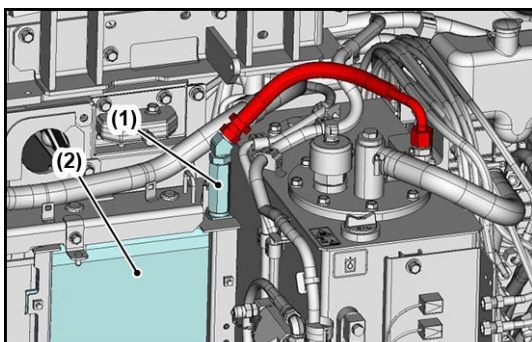
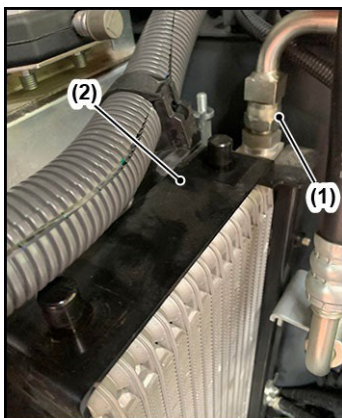
Tightening torque	Bolt (M8)	23.5 to 27.5 N·m 2.4 to 2.8 kgf·m 17.3 to 20.3 lbf·ft
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- (1) Bolt

**7. Remove the bolts (1) behind of the bracket (2).**

Tightening torque	Bolt (M6)	9.8 to 11.3 N·m 1.0 to 1.2 kgf·m 7.2 to 8.3 lbf·ft
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- (1) Bolt × 2
(2) Bracket



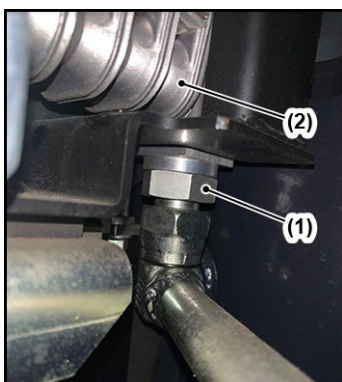
8. Disconnect the joint (1) from the oil cooler (2) upper side.

■ **NOTE**

- The upper connection of the oil cooler was changed in the current series. The top picture shows the old, the bottom picture the new connection of the oil cooler.

Tightening torque	Joint	58.8 to 63.7 N·m 6.0 to 6.5 kgf·m 43.4 to 46.0 lbf·ft
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- (1) Joint: Reuse
(2) Oil cooler



9. Disconnect the joint (1) from the oil cooler (2) lower side.

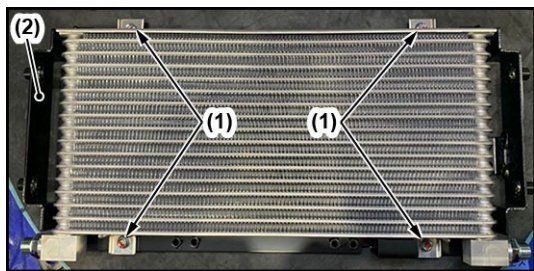
Tightening torque	Joint	58.8 to 63.7 N·m 6.0 to 6.5 kgf·m 43.4 to 46.0 lbf·ft
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- (1) Joint: Reuse
(2) Oil cooler



10. Remove the oil cooler (1) with the bracket (2).

- (1) Oil cooler
(2) Bracket

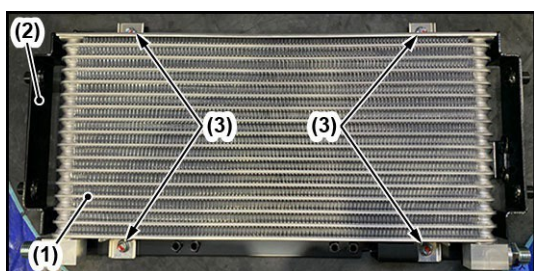


10. Remove the bolts (1) from the bracket (2).

Tightening torque	Bolt (M8)	23.5 to 27.5 N·m 2.4 to 2.8 kgf·m 17.3 to 20.3 lbf·ft
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- (1) Bolt × 4
(2) Bracket

2. Installing the new oil cooler



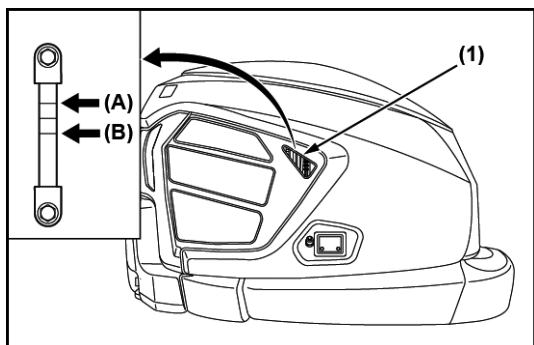
1. Install the new oil cooler (1) in the bracket (2) with the bolts (3). Remove all joints from the old oil cooler, and use them on the new one.

Tightening torque	Bolt (M8)	23.5 to 27.5 N·m 2.4 to 2.8 kgf·m 17.3 to 20.3 lbf·ft
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- (1) Oil cooler: RD579-64050
(2) Bracket
(3) Bolt × 4

2. Reassemble the oil cooler with the bracket, the engine air cleaner and the condenser, in the reverse order of the disassembling procedure.

3. Refilling the hydraulic oil



1. Refill the hydraulic oil, start the engine carefully in idle speed and check for any oil leaks.

■ NOTE

- Make sure that the oil level is in between half and three-quarters on the level gauge (1).

- (1) Level gauge
(A) MAX
(B) MIN