

521F
Tier 4B (final)
Wheel Loader

SERVICE MANUAL

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SERVICE MANUAL

521F

Link Product / Engine

Product	Market Product	Engine
521F TIER4B Z-BAR	North America	F4HFE413N*B001
521F TIER4B XT	North America	F4HFE413N*B001
521F TIER4B XR	North America	F4HFE413N*B001

Contents

INTRODUCTION

Engine.....	10
[10.001] Engine and crankcase	10.1
[10.202] Air cleaners and lines	10.2
[10.500] Selective Catalytic Reduction (SCR) exhaust treatment	10.3
[10.400] Engine cooling system	10.4
[10.414] Fan and drive	10.5
[10.310] Aftercooler.....	10.6
[10.304] Engine lubrication system.....	10.7
Transmission.....	21
[21.113] Powershift transmission	21.1
[21.135] Powershift transmission external controls.....	21.2
[21.155] Powershift transmission internal components.....	21.3
Four-Wheel Drive (4WD) system	23
[23.314] Drive shaft.....	23.1
Front axle system	25
[25.100] Powered front axle	25.1
[25.102] Front bevel gear set and differential	25.2
[25.108] Final drive hub, steering knuckles, and shafts	25.3
[25.310] Final drives	25.4
Rear axle system.....	27
[27.100] Powered rear axle.....	27.1
[27.106] Rear bevel gear set and differential	27.2
[27.120] Planetary and final drives	27.3
[27.124] Final drive hub, steering knuckles, and shafts	27.4
Brakes and controls	33

[33.202] Hydraulic service brakes	33.1
[33.110] Parking brake or parking lock	33.2
Hydraulic systems.....	35
[35.000] Hydraulic systems.....	35.1
[35.300] Reservoir, cooler, and filters.....	35.2
[35.106] Variable displacement pump	35.3
[35.359] Main control valve	35.4
[35.357] Pilot system	35.5
[35.752] Hydraulic fan drive cooling system.....	35.6
[35.355] Hydraulic hand control	35.7
[35.701] Front loader arm hydraulic system	35.8
[35.723] Front loader bucket hydraulic system	35.9
[35.734] Tool quick coupler hydraulic system	35.10
Frames and ballasting	39
[39.100] Frame	39.1
Steering.....	41
[41.200] Hydraulic control components.....	41.1
[41.216] Cylinders	41.2
[41.910] Auxiliary steering	41.3
Wheels	44
[44.511] Front wheels.....	44.1
[44.520] Rear wheels.....	44.2
Cab climate control	50
[50.100] Heating.....	50.1
[50.200] Air conditioning	50.2
Electrical systems.....	55
[55.000] Electrical system	55.1

[55.100] Harnesses and connectors.....	55.2
[55.015] Engine control system.....	55.3
[55.201] Engine starting system	55.4
[55.301] Alternator.....	55.5
[55.302] Battery.....	55.6
[55.202] Cold start aid	55.7
[55.011] Fuel tank system	55.8
[55.988] Selective Catalytic Reduction (SCR) electrical system	55.9
[55.989] Exhaust Gas Recirculation (EGR) electrical system	55.10
[55.012] Engine cooling system	55.11
[55.024] Transmission control system.....	55.12
[55.519] Cab brake controls	55.13
[55.030] Service brake electrical system	55.14
[55.031] Parking brake electrical system	55.15
[55.512] Cab controls.....	55.16
[55.036] Hydraulic system control	55.17
[55.051] Cab Heating, Ventilation, and Air-Conditioning (HVAC) controls.....	55.18
[55.050] Heating, Ventilation, and Air-Conditioning (HVAC) control system.....	55.19
[55.047] Steering control system	55.20
[55.524] Cab controls (Lift arm, Boom, Dipper, Bucket)	55.21
[55.415] Loader arm and bucket control system	55.22
[55.518] Wiper and washer system.....	55.23
[55.404] External lighting	55.24
[55.405] External lighting switches and relays	55.25
[55.514] Cab lighting	55.26
[55.510] Cab or platform harnesses and connectors.....	55.27
[55.408] Warning indicators, alarms, and instruments	55.28
[55.DTC] FAULT CODES.....	55.29
Front loader and bucket.....	82

[82.100] Arm.....	82.1
[82.300] Bucket.....	82.2
Platform, cab, bodywork, and decals	90
[90.150] Cab.....	90.1
[90.156] Cab glazing	90.2
[90.105] Machine shields and guards	90.3



INTRODUCTION

Contents

INTRODUCTION

Foreword - Important notice regarding equipment servicing	3
Safety rules	4
Personal safety	5
Basic instructions - Important notice regarding equipment servicing	14
Basic instructions - How to use the maintenance standard and precautions	15
Basic instructions - Precaution for disassembly and assembly	17
Basic instructions - Electrical equipment precautions	19
Consumables	20
Consumables - Biodiesel Fuel	21
Hydraulic contamination	22
Product identification	23
Product identification	24

Foreword - Important notice regarding equipment servicing

All repair and maintenance work listed in this manual must be carried out only by qualified dealership personnel, strictly complying with the instructions given, and using, whenever possible, the special tools.

Anyone who performs repair and maintenance operations without complying with the procedures provided herein shall be responsible for any subsequent damages.

The manufacturer and all the organizations of its distribution chain, including - without limitation - national, regional, or local dealers, reject any responsibility for damages caused by parts and/or components not approved by the manufacturer, including those used for the servicing or repair of the product manufactured or marketed by the manufacturer. In any case, no warranty is given or attributed on the product manufactured or marketed by the manufacturer in case of damages caused by parts and/or components not approved by the manufacturer.

The manufacturer reserves the right to make improvements in design and changes in specifications at any time without notice and without incurring any obligation to install them on units previously sold. Specifications, descriptions, and illustrative material herein are as accurate as known at time of publication but are subject to change without notice.

In case of questions, refer to your CASE CONSTRUCTION Sales and Service Networks.

Safety rules

Personal safety



This is the safety alert symbol. It is used to alert you to potential personal injury hazards. Obey all safety messages that follow this symbol to avoid possible death or injury.

Throughout this manual you will find the signal words DANGER, WARNING, and CAUTION followed by special instructions. These precautions are intended for the personal safety of you and those working with you.

Read and understand all the safety messages in this manual before you operate or service the machine.

 DANGER indicates a hazardous situation that, if not avoided, will result in death or serious injury.

 WARNING indicates a hazardous situation that, if not avoided, could result in death or serious injury.

 CAUTION indicates a hazardous situation that, if not avoided, could result in minor or moderate injury.

FAILURE TO FOLLOW DANGER, WARNING, AND CAUTION MESSAGES COULD RESULT IN DEATH OR SERIOUS INJURY.

Machine safety

NOTICE: Notice indicates a situation that, if not avoided, could result in machine or property damage.

Throughout this manual you will find the signal word Notice followed by special instructions to prevent machine or property damage. The word Notice is used to address practices not related to personal safety.

Information

NOTE: Note indicates additional information that clarifies steps, procedures, or other information in this manual.

Throughout this manual you will find the word Note followed by additional information about a step, procedure, or other information in the manual. The word Note is not intended to address personal safety or property damage.

Personal safety

Carefully read this Manual before proceeding with maintenance, repairs, refuelling or other machine operations.

Repairs have to be carried out only by authorized and instructed staff; specific precautions have to be taken when grinding, welding or when using mallets or heavy hammers.

Non-authorized persons are not allowed to repair or carry out maintenance on this machine. Do not carry out any work on the equipment without prior authorization.

Ask your employer about the safety instructions in force and safety equipment.

Nobody should be allowed in the cab during machine maintenance unless he is a qualified operator helping with the maintenance work.

If it is necessary to move the equipment to carry out repairs or maintenance, do not lift or lower the equipment from any other position than the operator's seat.

Never carry out any operation on the machine when the engine is running, except when specifically indicated.

Stop the engine and ensure that all pressure is relieved from hydraulic circuits before removing caps, covers, valves, etc.

All repair and maintenance operations should be carried out with the greatest care and attention.

Service stairs and platforms used in a workshop or in the field should be built in compliance with the safety rules in force.

Any functional disorders, especially those affecting the safety of the machine, should therefore be rectified immediately.

⚠ DANGER

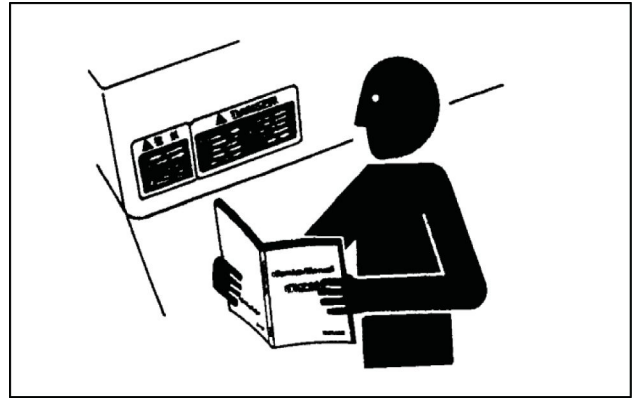
Unexpected movement!

Make sure parking brake is applied. Secure machine with wheel chocks.

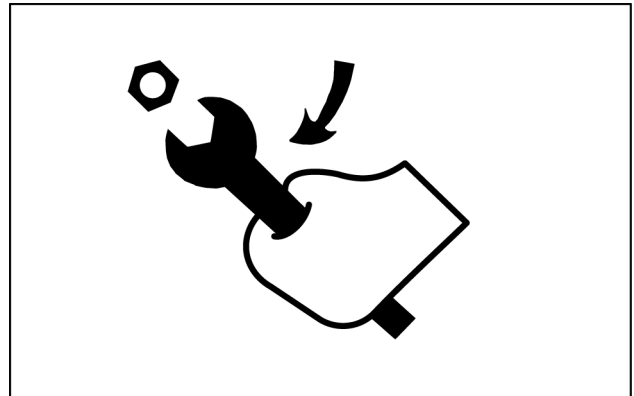
Failure to comply will result in death or serious injury.

D0013A

Before performing any work on the machine, attach a maintenance in progress tag. This tag can be applied on the left-hand control lever, safety lever or cab door.



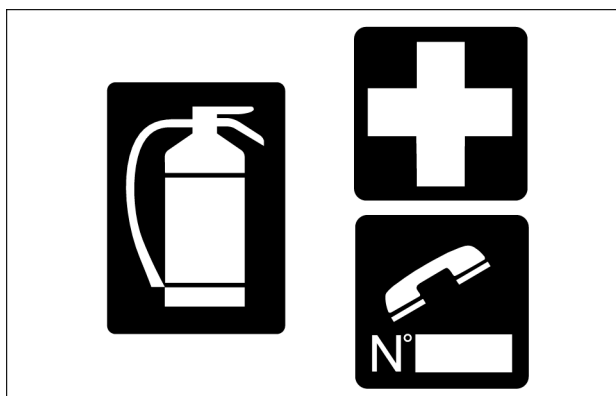
TULI12WEX2004AA 1



TULI12WEX2005AA 2

Emergency

Be prepared for emergencies. Always keep a fire extinguisher and first aid kit readily available. Ensure that the fire extinguisher is serviced in accordance with the manufacturer's instructions.



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Equipment

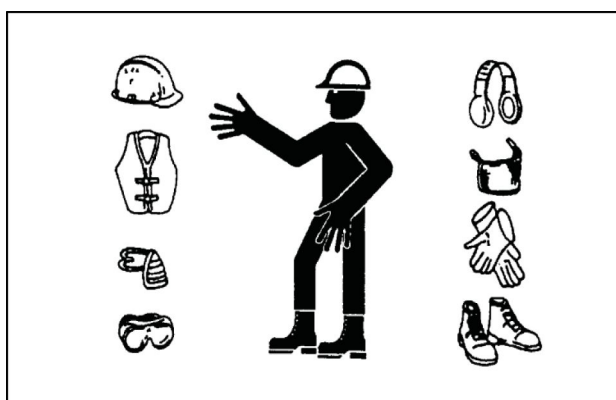
Wear close fitting clothing and safety equipment appropriate for the job:

- Safety helmet
- Safety shoes
- Heavy gloves
- Reflective clothing
- Wet weather clothing

If working conditions require, the following personal safety equipment should be on hand:

- Respirators (or dust proof masks)
- Ear plugs or acoustic ears protections
- Goggles with lateral shield or masks for eye protection

Do not wear rings, wristwatches, jewelry, unbuttoned or flapping clothing such as ties, torn clothes, scarves, open jackets or shirts with open zips which could get caught into moving parts.



TUL12WEX2008AA 4

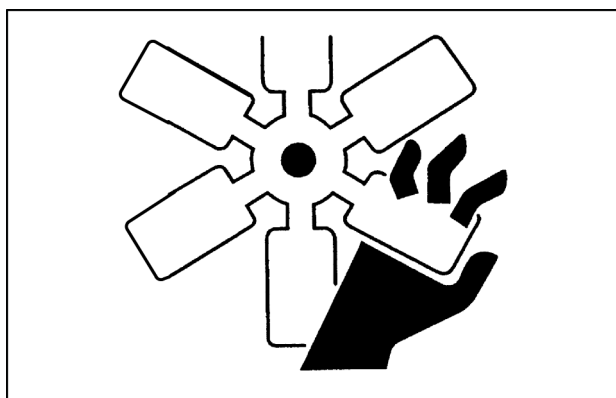
Engine - Radiator

Never leave the engine running in enclosed spaces without proper ventilation which is able to evacuate toxic exhaust gases- Keep the exhaust manifold and tube free from combustible materials.

Do not refuel with the engine running, especially if hot, as this increases fire hazard in case of fuel spillage.

Never attempt to check or adjust the belts when the engine is running.

Never lubricate the machine with the engine running.



TUL12WEX2009AA 5

Pay attention to rotating components and do not allow anyone to approach these areas to avoid becoming entangled.

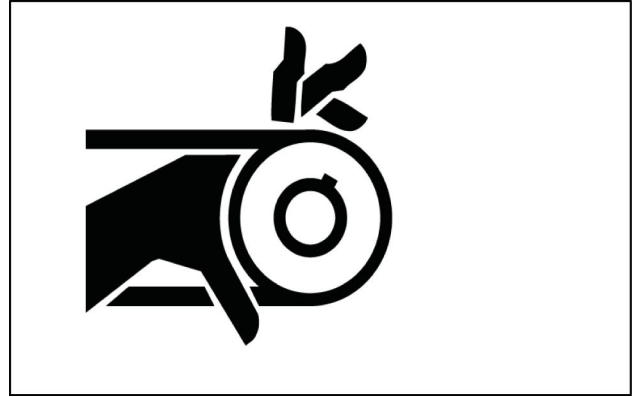
Hands, clothing or tools getting caught in the fan blades or engine belts, can cause amputations, violent hemorrhages and generate conditions of grave danger. For this reason avoid touching or approaching all rotating or moving parts.

A surging spray of the coolant from the radiator can cause serious burns and scalds.

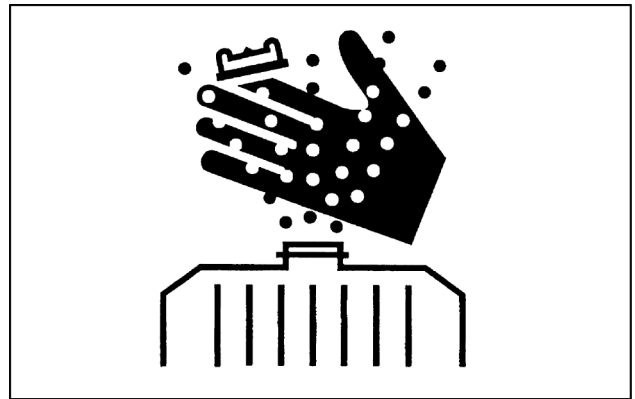
Before checking the coolant level, shut-off the engine and allow machine to cool down the radiator and hoses. Slowly unscrew the cap to release any residual pressure.

If it is necessary to remove the cap while engine is hot, wear safety clothes and equipment, then loosen the cap slowly to relieve the pressure gradually.

When checking the fuel, oil and coolant levels, use lights and lamps explicitly designated as explosion proof. If these types of lamps are not used, fires or explosions may occur.



TULI12WEX2010AA 6



TULI12WEX2011AA 7

Hydraulic systems

Jets of fluids under pressure can penetrate the skin causing serious injuries.

Avoid this hazard by relieving pressure before disconnecting hydraulic or other lines.

Relieve the residual pressure by moving the hydraulic control levers several times.

Tighten all connections before applying pressure.

To protect the eyes wear a facial shield or safety goggles.

Protect your hands and body from possible jets of fluids under pressure.

Swallowing hydraulic oil is a severe health hazard.



TULI12WEX2012AA 8

INTRODUCTION

When hydraulic oil has been swallowed, avoid vomiting, but consult a doctor or go to a hospital.

If an accident occurs, see a doctor familiar with this type of injury immediately.

Any fluid penetrating the skin must be removed within a few hours to avoid serious infections.

Flammable splashes may originate because of heating near lines with fluids under pressure, resulting in serious burns. Do not weld or use torches near lines containing fluids or other flammable materials.

Lines under pressure can accidentally be pierced when the heat expands beyond the area immediately heated.

Arrange for temporary fire resistant shields to protect hoses or other components during welding or torch use.

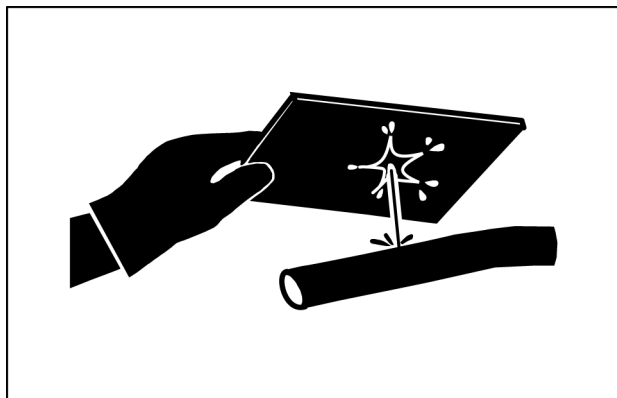
Have any visible leakage repaired immediately.

Discharged oil pollutes the environment. Soak up any oil that has spilled with a proper binding agent. Sweep up binding agent and dispose of it separately from other waste.

Never search for leakages with fingers; instead, use a piece of cardboard and always wear goggles.

Never repair a damaged line; always replace it. Replace hydraulic hoses immediately on detecting any damaged or moist areas.

Always store hydraulic oil in the original containers.



TULI12WEX2013AA 9

Hoses and tubes

Always replace hoses and tubes if the cone end or the end connections on the hose are damaged.

When installing a new hose, loosely connect each end and make sure the hose takes up the correct position before tightening the connections. Clamps should be tightened sufficiently to hold the hose without crushing and to prevent chafing.

After replacing a hose on a moving component, check that the hose does not fall by moving the component through the complete range of travel. Be sure any hose which has been installed is not kinked or twisted.

Hose connections which are damaged, dented, crushed or leaking, restrict oil flow and the productivity of the components being served. Connectors which show signs of movement from the original position have failed and will ultimately separate completely.

A hose with a frayed outer sheath will allow water penetration. Concealed corrosion of the wire reinforcement could subsequently occur along the hose length with resultant hose failure.

Ballooning of the hose indicates an internal leakage due to structural failure. This condition rapidly deteriorates and total hose failure soon occurs.

Kinked, crushed, stretched or deformed hoses generally suffer internal structural damage which can result in oil restriction, a reduction in the speed of operation and ultimate hose failure.

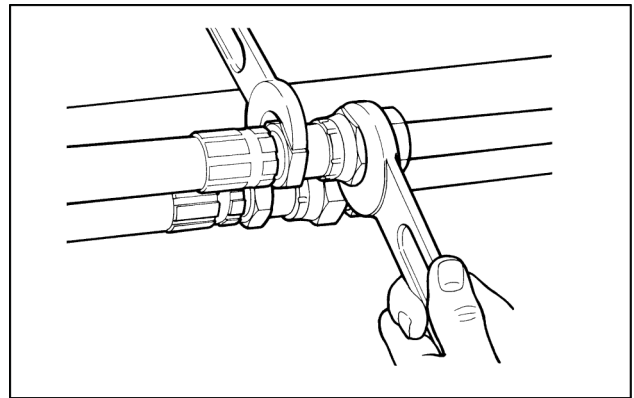
Free-moving, unsupported hoses must never be allowed to touch each other or related working surfaces. This causes chafing which reduces hose life.

O-rings

Replace O-rings, seal rings and gaskets whenever they are disassembled.

Never mix new and old seals or O-rings, regardless of condition. Always lubricate new seal rings and O-rings with hydraulic oil before installation to relevant seats.

This will prevent the O-rings from rolling over and twisting during mounting which will jeopardize sealing.



TULI12WEX2014AA 10

Battery

Batteries give off explosive gases.

Never handle open flames and unshielded light sources near batteries. (No smoking is addressed in the next instruction).

To prevent any risk of explosion, observe the following instructions:

- When disconnecting the battery cables, always disconnect the negative (-) cable first.
- To reconnect the battery cables, always connect the negative (-) cable last.
- Never short-circuit the battery terminals with metal objects.
- Do not weld, grind or smoke near a battery.

Battery electrolyte causes severe burns. The battery contains sulphuric acid. Avoid any contact with the skin, eyes or clothing.

Treatment:

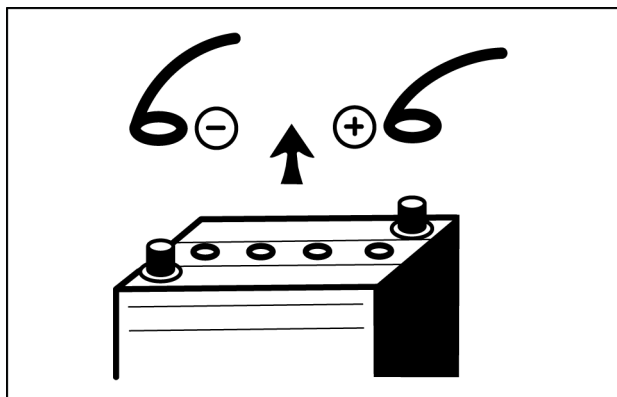
- **EXTERNAL:** Rinse well with water, removing any soiled clothing.
- **INTERNAL:** Avoid vomiting. Drink water to rinse your mouth. Consult a doctor.
- **EYES:** Rinse abundantly with water for **15 min** and consult a doctor.
- When the electrolyte of a battery is frozen, it can explode if you attempt to charge the battery or if you try to start the engine using a booster battery. Always keep the battery charged to prevent the electrolyte freezing.

Provide good ventilation when changing a battery or using a battery in an enclosed space. Always protect your eyes when working near a battery.

Never set tools down on the battery. They may induce a short circuit, causing irreparable damage to the battery and injuring persons.

Never wear metal necklaces, bracelets or watch straps when working on the battery. The metal parts may induce a short circuit resulting in burns.

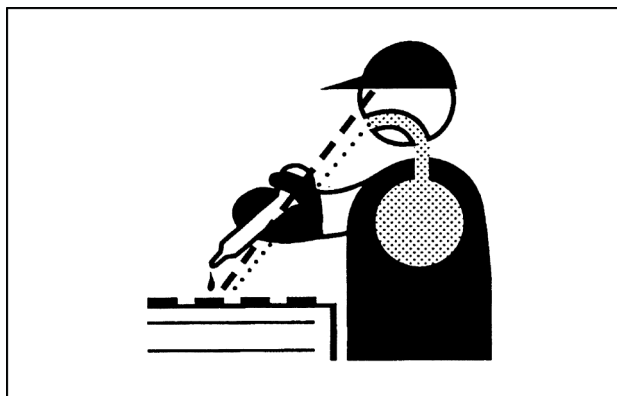
Dispose of used batteries separately from other waste in the interests of environmental protection.



TULI12WEX2015AA 11



TULI12WEX2016AA 12



TULI12WEX2017AA 13

Flammable liquids

When handling flammable liquids:

- Do not smoke.
- Keep away from unshielded light sources and open flames.

Fuels often have a low flash point and are readily ignited.

Never attempt to extinguish burning liquids with water.
Use:

- Dry powder
- Carbon dioxide
- Foam

Water used for extinguishing purposes would vaporize instantaneously on contact with burning substances and spread burning oil, for example, over a wide area. Water generates short circuits in the electrical system, possibly producing new hazards.

Stay away from open flames during refilling of hydraulic oil or fuel.

Fuel or oil spills can cause slipping hazards; thoroughly contain and clean affected areas.

Always tighten the safety plugs of fuel tank and hydraulic oil tank firmly.

Never use fuel to clean machine parts that will be exposed to dirt or debris.

Use a non-flammable product for cleaning parts.

Always perform fuel or oil refilling in well aired and ventilated areas.

During refuelling hold the pistol firmly and always keep it in contact with the filler neck until the end of the refuelling, to avoid arcing due to static electricity.

Do not overfill the tank but leave a space for fuel expansion.

Never refuel when the engine is running.

Take all the necessary safety measures when welding, grinding or when working near a naked flame.



TULI12WEX2016AA 14



TULI12WEX2018AA 15



TULI12WEX2019AA 16

Tires

Before inflating the tires, always check the condition of rims and the outer condition of tires for the presence of dents, cuts, tears of reinforcement plies or other faults. Before inflating a tire, make sure that there are no nearby persons, then position yourself at tread side.

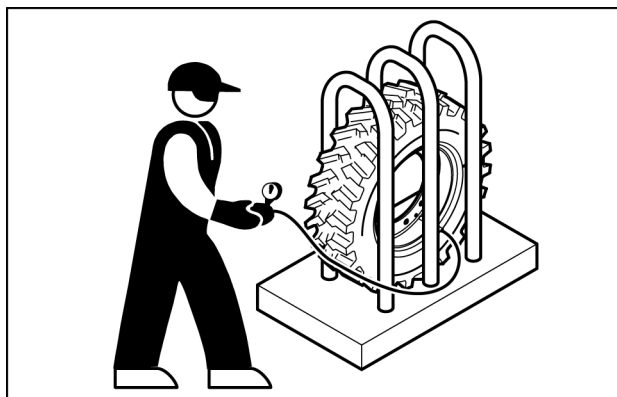
When inflating tires, ensure tire pressure does not exceed that prescribed by the tire manufacturer. Ensure that the pressure of the right tire corresponds to the pressure of the left tire.

NOTE: *The front and rear tire pressures may be different.*

Never use reconditioned rims because possible welds, heat treatments or brazings not performed correctly can weaken the wheels and cause damage or failure. Deflate the tires before their disassembly.

Before taking out possible jammed objects from the rims, it is necessary to deflate the tires. Inflate tires by means of an inflation pistol complete with extension and pressure control valve.

Need to maintain inflation cage



TUL12WEX2020AA 17

Cleaning

Clean the exterior of all components before carrying out any form of repair. Dirt and dust can reduce the efficient working life of a component and lead to costly replacement.

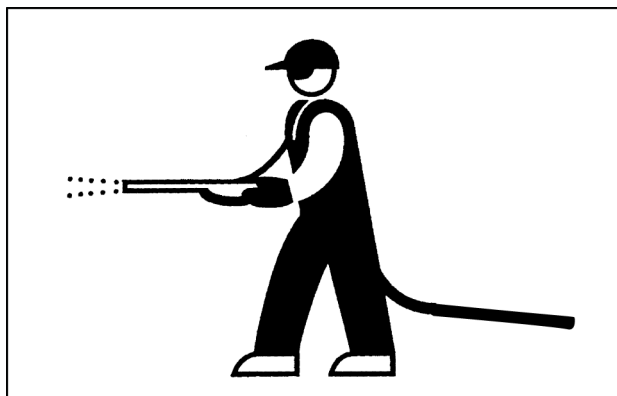
Solvents should be checked that they are suitable for the cleaning of components and also that they do not risk the personal safety of the user.

Dirt, oil, grease and scattered tools are dangerous for people, because they can create slipping or tripping hazards.

For machine cleaning, use a jet of warm water or steam under pressure and commercial detergents. Never use fuel, petroleum or solvents, because they can leave an oily residue that attracts dust, and solvents (even if weak) damage the paint and can lead to the formation of rust.

Never use water jets or steam on sensors, connectors or other electric components.

Avoid direct spray of seals and seams to prevent water penetration inside the cab.



TUL12WEX2021AA 18

Waste disposal

Improperly disposing of waste can threaten the environment.

Each country has its own Regulations on this subject. It is therefore advisable to prepare suitable containers to collect and store momentarily all solid and fluid materials that must not be scattered in the environment to avoid pollution.

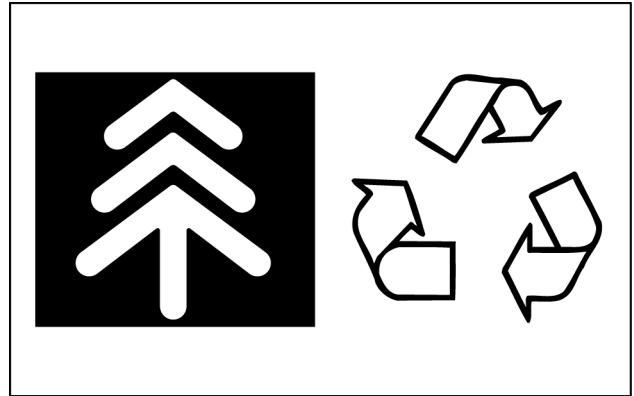
These products will be delivered at preset intervals following the forward environmental regulation.

Below are listed some products from the machine requiring disposal:

- Lubricating oil
- Brake system oil
- Coolant mixture, condensation rests and pure antifreeze
- Fuel
- Filter elements, oil and fuel filters
- Filter elements, air filters
- Battery

Also polluted rags, paper, sawdust and gloves must be disposed in compliance with the same procedures.

Do not use food or beverage containers that may mislead someone into drinking from them. Do not pour waste onto the ground, down a drain, or into any water source. Air conditioning refrigerants escaping into the air can damage the Earth's atmosphere. Government regulations may require a certified air conditioning service centre to recover and recycle used air conditioning refrigerants. Obtain information on the proper way to recycle or dispose of waste from your local environmental or recycling centre, or from your Dealer.



TULI12WEX2022AA 19

Click on the image link below for the full version of the service manual

