

PARTS & SERVICE NEWS

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SUBJECT: REINFORCEMENT OF FRONT FRAME BOOM MOUNTING PLATES ON WA700-1

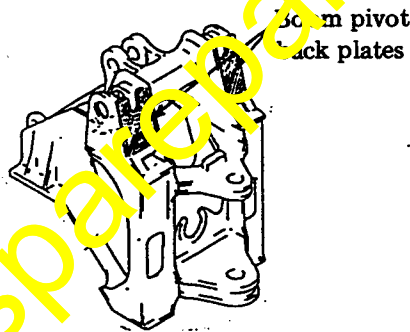
PURPOSE: To introduce how to reinforce front frame boom mounting plates on WA700-1

APPLICATION: WA700-1 Wheel Loaders, Serial Nos. 10001 thru 10082 (except 10077)

DESCRIPTION.

1. Introduction

If cracks are caused to the boom mounting plates (or boom pivot back plates) on the front frame on Wheel Loader Model WA700-1, repair to reinforce the plates as described in this PARTS & SERVICE NEWS.

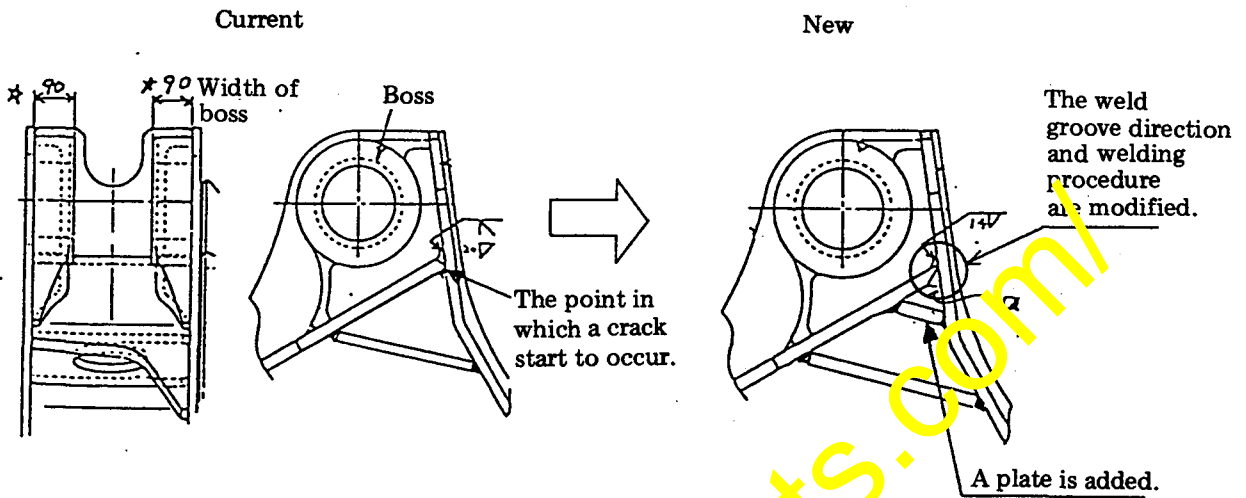


2. Parts required for repair

Part No.	Part Name	Q'ty	Purpose of part	Remarks
26-9-80892	Plate	2	Addition	Manufacture drawings are attached.

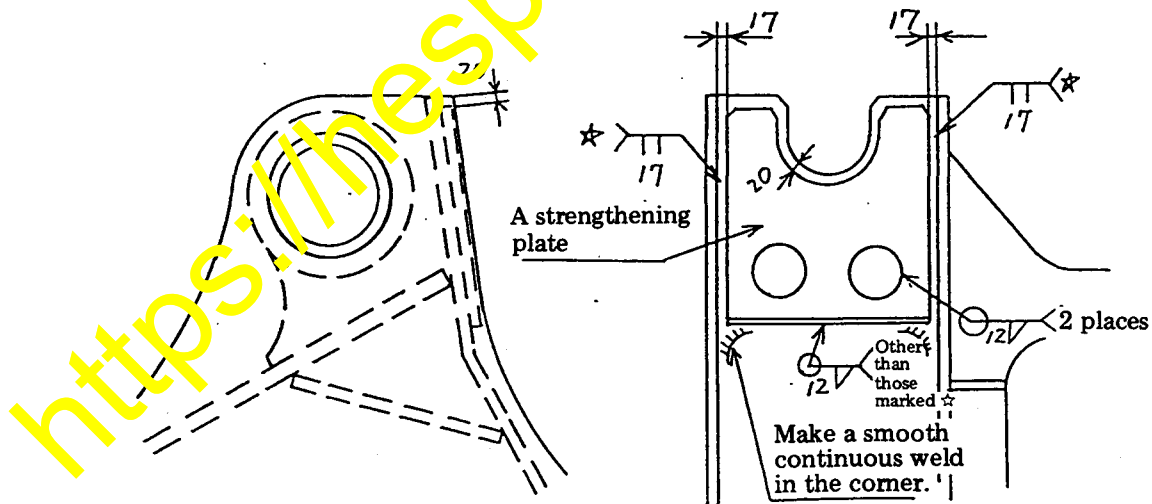
3. Improvement

1) For machines to be manufactured



- ① In order to make better welds in the boss bottoms on both sides of the boom pivot, the weld groove direction and the welding procedure for welding the plates are modified.
- ② Plates are added to the corners in order to improve rigidity and lessen the stress in the point in which a crack is likely to start to occur.

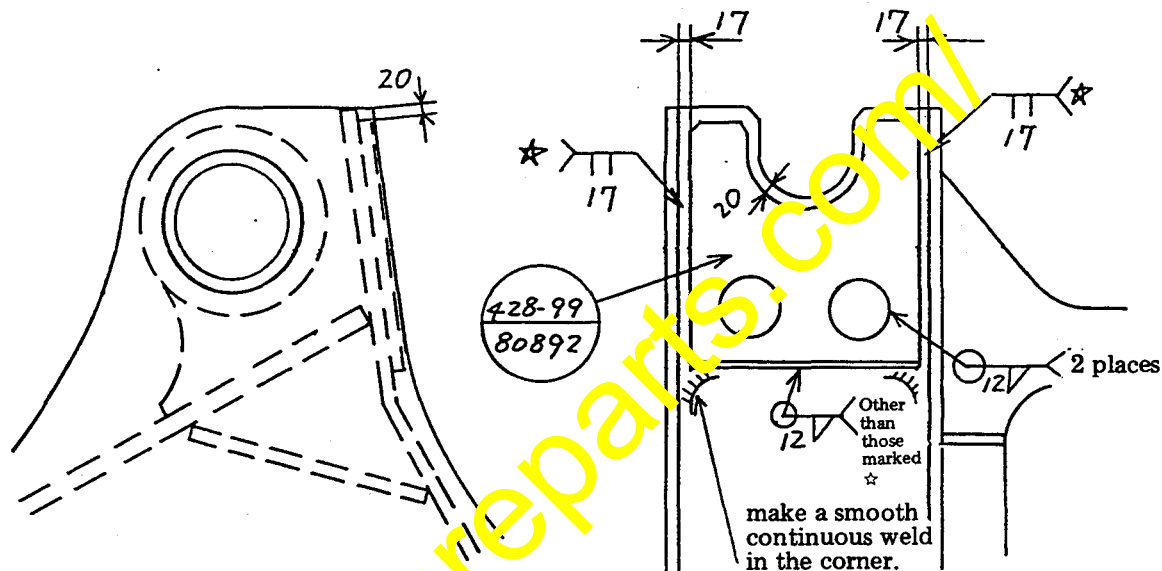
2) For the machines already shipped



After a repair weld has been made to the cracked area, weld the strengthening plate described above to the boom pivot back in order to improve rigidity.

4. Strengthening the boom pivot back plate

- 1) Gouge or grind to remove the cracked area, then build up the gouged or ground area with a weld. After a weld has been made, grind finish the surface smooth.
- 2) Weld plate 428-99-80892 to the boom pivot back plate.
Only the left side is shown. The right-hand side is symmetrically identical to the left.



5. When making plates 428-99-80892 locally, do by referring to the dimensions shown in the drawing below.

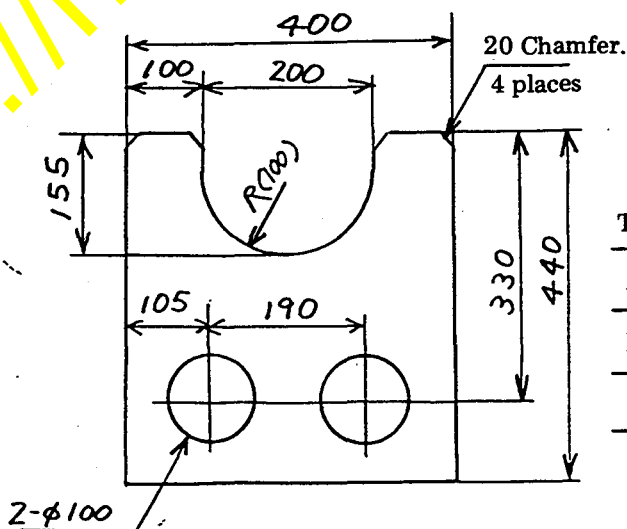


Plate thick : 19 mm
Quantity required:
2 pcs./machine unit

Table of materials

ASTM	A572 Gr. 60 A573 Gr. 70
BS	4360 Gr. 50A
DIN	17100 St50-2

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