

PARTS & SERVICE NEWS

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SUBJECT: COUNTERWEIGHT MOUNTING PLATE REWORK

PURPOSE: To supply a procedure to modify the counterweight mounting plate.

APPLICATION: WA700-1L Wheel Loader Serial Number A20001 thru A20015

FAILURE CODE: 462030

DESCRIPTION: The bottom counterweight mounting plate on the WA700-1L may become bent. If this happens, the counterweight mounting bolts will be misaligned causing undue stress and the possibility of the bolts breaking. To prevent a bolt failure, perform the modification in this Parts and Service News.

PREPARATIONS FOR WORK

IMPORTANT: Please observe all safety and precautionary standards as dictated by the environment and work conditions under which the equipment will be inspected, reworked and repaired. Consult "Shop Manual" WA700-1L and your Komatsu district service manager with any and all questions regarding safety.

1. Park the machine on a flat level surface, lower the boom and bucket to the ground. Shut off the engine and cycle the controls to remove any residual hydraulic pressure from the boom and bucket circuits. Fully apply the parking brake.
2. Place chocks at the front and rear of all wheels to prevent the machine from moving.
3. Place the safety bar on the machine.
4. Remove the key from the start switch and retain it until the repairs are complete. Place a tag on the steering wheel advising: " **This machine is being repaired. It should not be started or moved for any reason until the tag is removed by the person doing the repairs** ".

Modification Procedure

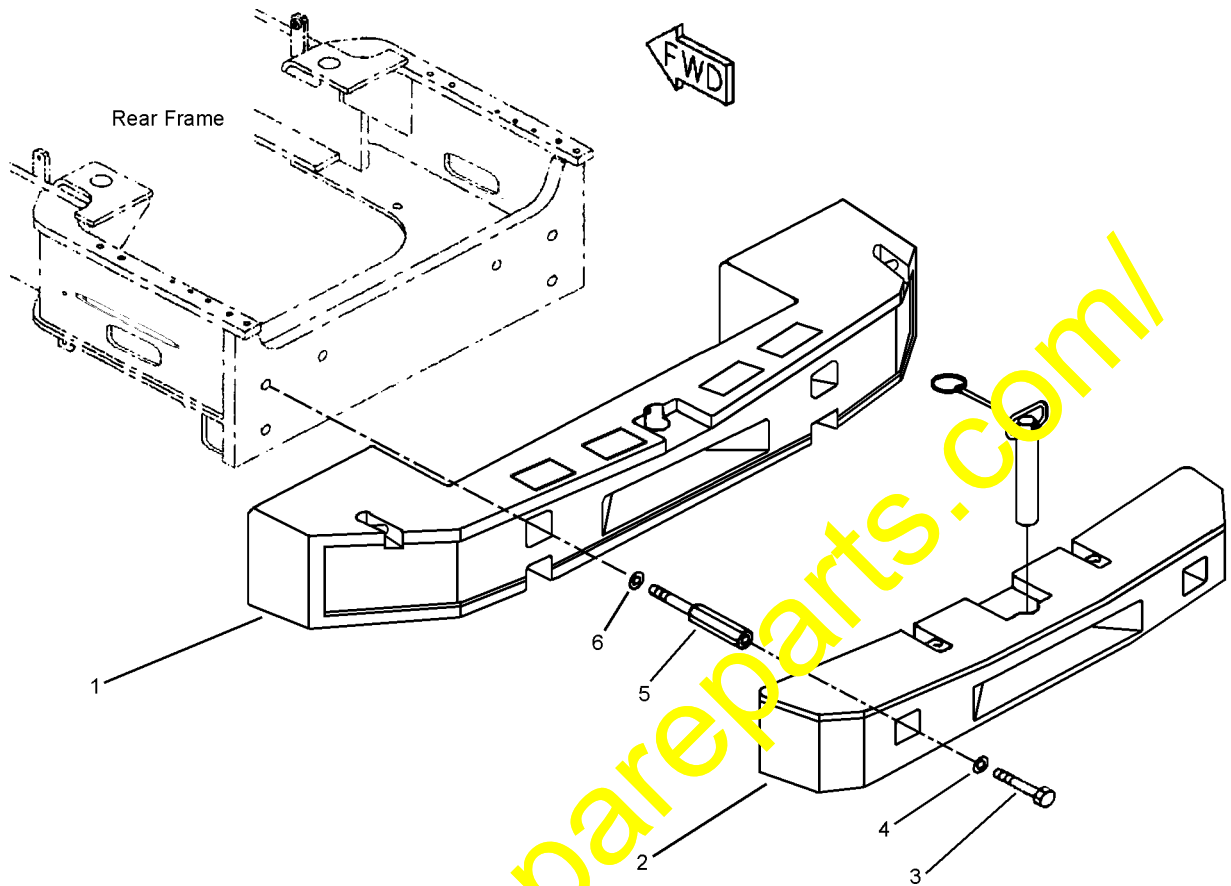


Figure 1 Counterweight Assembly

1. Remove counterweight from frame as follows:
 - a. Remove grille from radiator guard.



Counterweight: 2510 kg (5533.6 lbs.)
Additional Counterweight: 1040 kg (2292.81 lbs.)

- b. Sling additional counterweight (2), then remove mounting bolts (3) and washers (4) and lift off additional counterweight.

NOTE: Use care not to damage lamps and oil cooler fins when removing counterweight.

- c. Sling counterweight (1), then remove mounting bolts (5) and washers (6) and lift counterweight from frame.

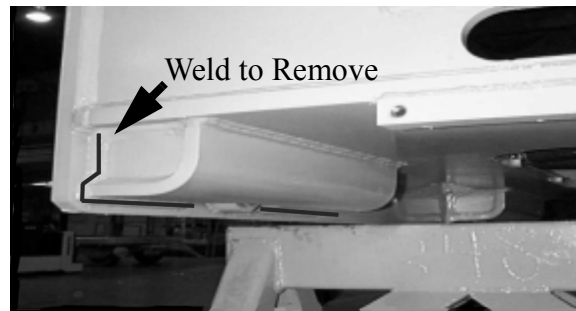


Figure 2 Box Gusset

NOTE: When removing weld from gusset, remove as little metal as possible as this area will be rewelded after frame plate is repaired.

2. Referencing Figure 2, remove welds from between counterweight mounting plate and box gussets.

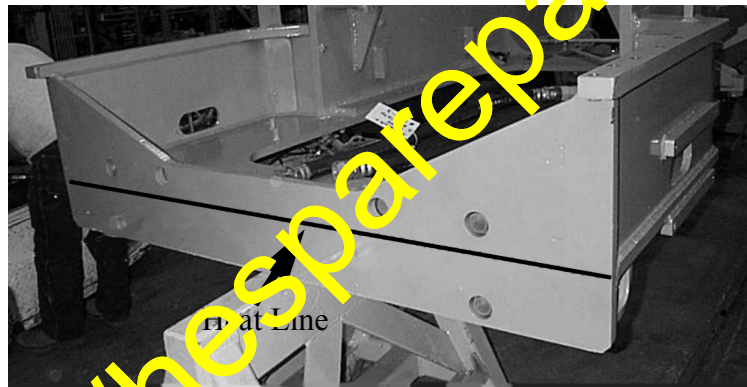


Figure 3 Mounting Plate

3. As shown in Figure 3, apply pressure from the back side of plate, then heat plate along heat line until plate is straight within 1.5mm (0.059 inch) from top to bottom.

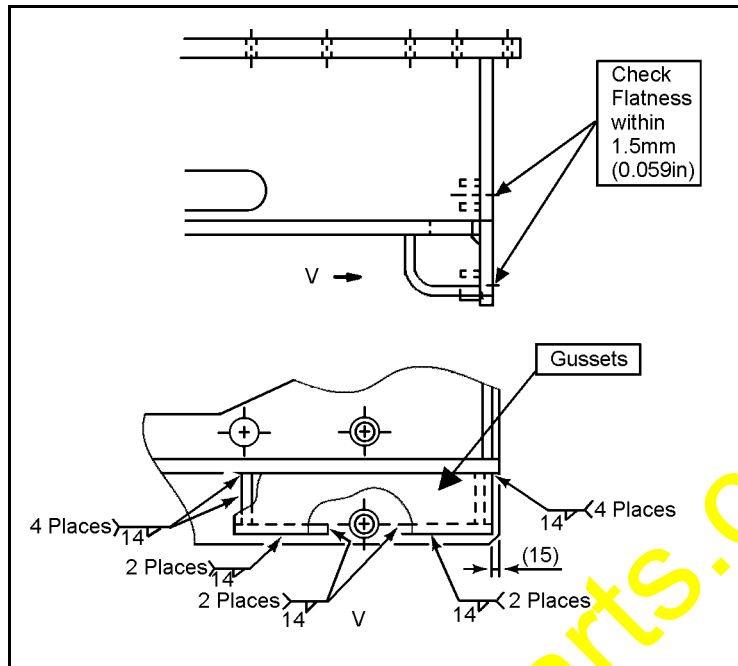


Figure 4 Welding Diagram

NOTE: Alternately weld box gussets to distribute heat evenly across mounting plate. Check plate during welding process to ensure plate stays straight within 1.5mm (0.059 in).

4. Prior to relieving pressure and referencing Figure 4, reweld box gussets to counterweight mounting plate.
5. After welds and plate have cooled, release pressure from behind plate.
6. Clean welds and heated area of paint and debris, then prime and paint reworked area.

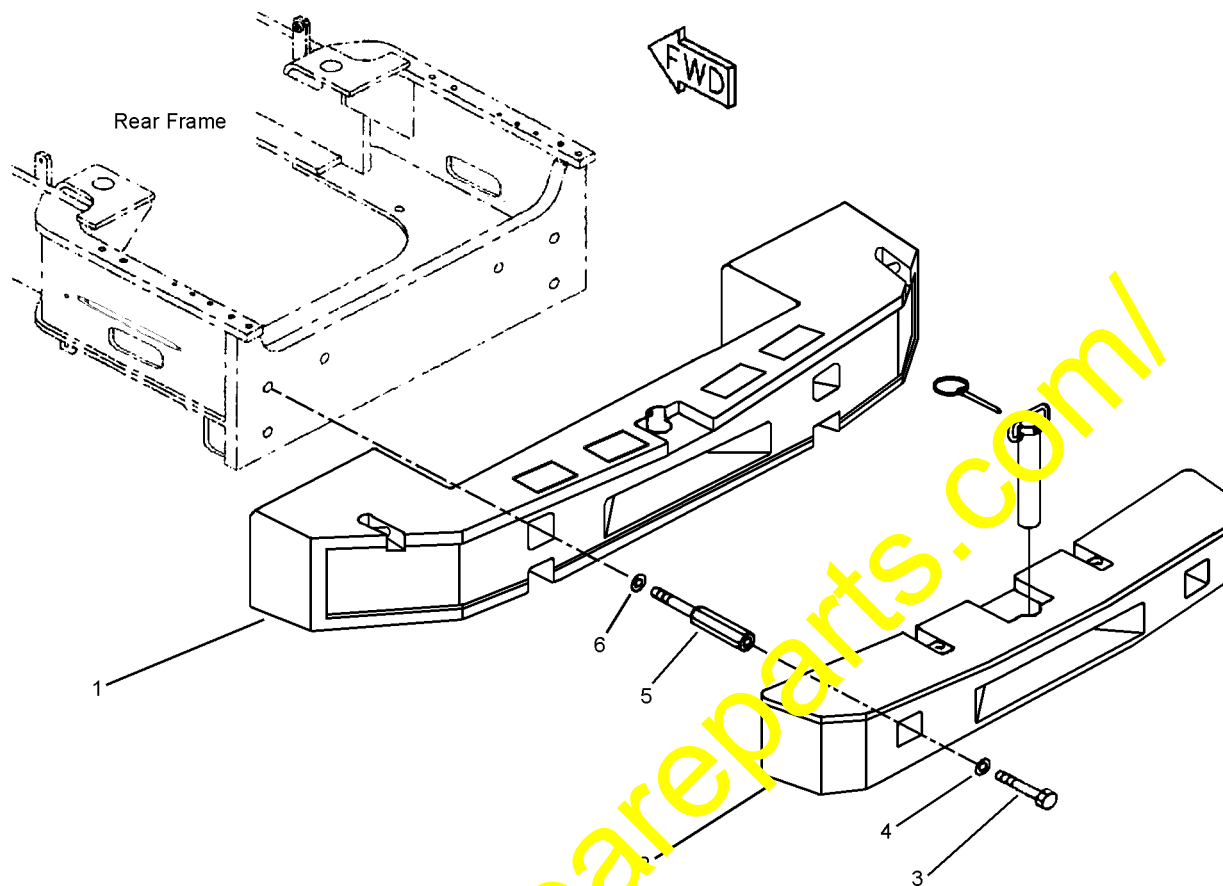


Figure 5 Counterweight Assembly

7. Reinstall counterweight to frame as follows:



Counterweight: 2510 kg (5533.6 lbs.)
Additional Counterweight: 1040 kg (2292.81 lbs.)

- a. Raise counterweight (1) to frame mounting position and tighten with mounting bolts (5) and washers (6) to 2746Nm (2025 ft. lbs.).



Counterweight: 2452 to 3040 Nm (1808 to 2242 ft.lbs.) acceptable range.

- b. Raise additional counterweight (2) to counterweight mounting position and tighten mounting bolts (3) and washers (4) to 2746 Nm (2045 ft. lbs.).



Additional Counterweight: 2452 to 3040 Nm (1808 to 2242 ft.lbs.) acceptable range.

- c. Reinstall grille to radiator guard.