

# PARTS & SERVICE NEWS

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(C)

**SUBJECT:** MODIFICATION TO FACILITATE SQUARE FUEL TANK CLEANING (JOINT SECTION)

**PURPOSE:** To introduce modification procedures to facilitate cleaning drift from the square shaped fuel tank (joint section)

**APPLICATION:** 330M Dump Trucks, S/N 24369, 24378, 24382, 24392 and up  
 HD785-3 Dump Trucks, S/N 2486 thru 2574  
 HD785-5 Dump Trucks, all Serial Numbers "A" prefix  
 HD785-5 Dump Trucks, S/N 4001 thru 4151  
 HD985-3 Dump Trucks, S/N 1002 thru 1020  
 HD985-5 Dump Trucks, S/N 1021 thru 1049

**FAILURE CODE:** 041199

**DESCRIPTION:**

With the square fuel tank of the dump trucks of the model names listed above, the space shaped like a pocket is formed at the section where the tank is mounted to the frame thus allowing accumulation of mud and sand, if this accumulates beyond the upper surface of the fuel tank, the dump truck when it is lowered may not be able to seat perfectly onto the guide.

If this occurs, make the modification introduced in this **PARTS & SERVICE NEWS** to facilitate the cleaning work and to supplement the mud and sand discharging holes.

Part Numbers of the applicable fuel tanks:

561-04-6A111 HD785-3 and HD985-3  
 561-04-6A112 & 561-04-6A113 HD785-6 and HD985-5

List of Parts:

Part Number	Part Name	Qty.	Remarks
561-04-6A150	Pipe	2	For modification of the fuel tank

3. Modification of the fuel tank (to supplement the mud and sand discharging holes)

When it is not easy to remove mud and sand accumulating in the section "P" in Fig. 1 below, modify the fuel tank following the procedures outlined below.

- (1) Open a  $\phi 100$  hole in each end plate at front and at rear of the tank, at the positions designated in the drawing. (At 1 place each on the front and rear end plates)  
Finish the bore surface of the opened hole to a smooth surface using a grinder. (Refer to Fig. 2.)
- (2) Prepare pipes of the shape shown in Fig. 3. (2 units per vehicle)
- (3) Open  $\phi 90$  holes at the positions designated in the drawing in the channel plate (at 2 places each in upper and lower sections) and weld the prepared pipes. (Refer to Fig. 4.)

After finishing welding, remove slugs from the weld beads and paint the welded surfaces.

(Note) Urge your customers to remove mud and sand from the pocket in the section "P" at the opportunities of periodical washing of the vehicle.

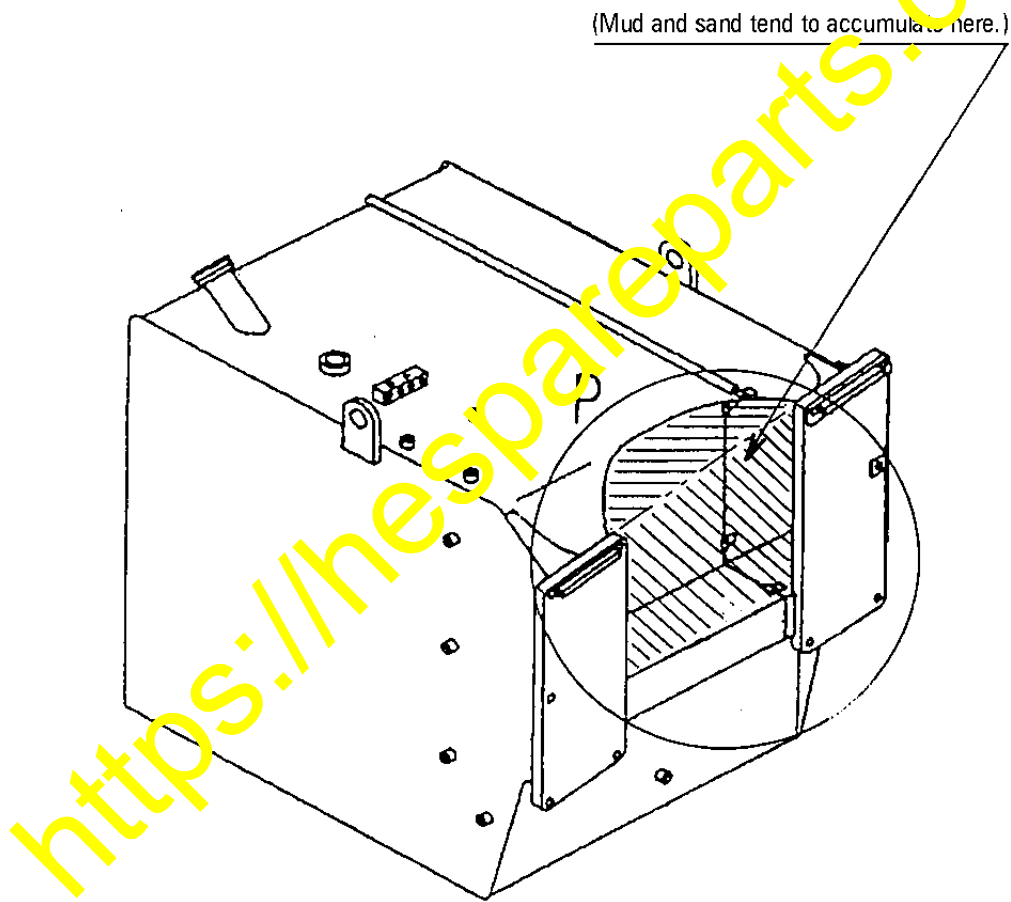


Fig. 1 Section where mud and sand tend to accumulate

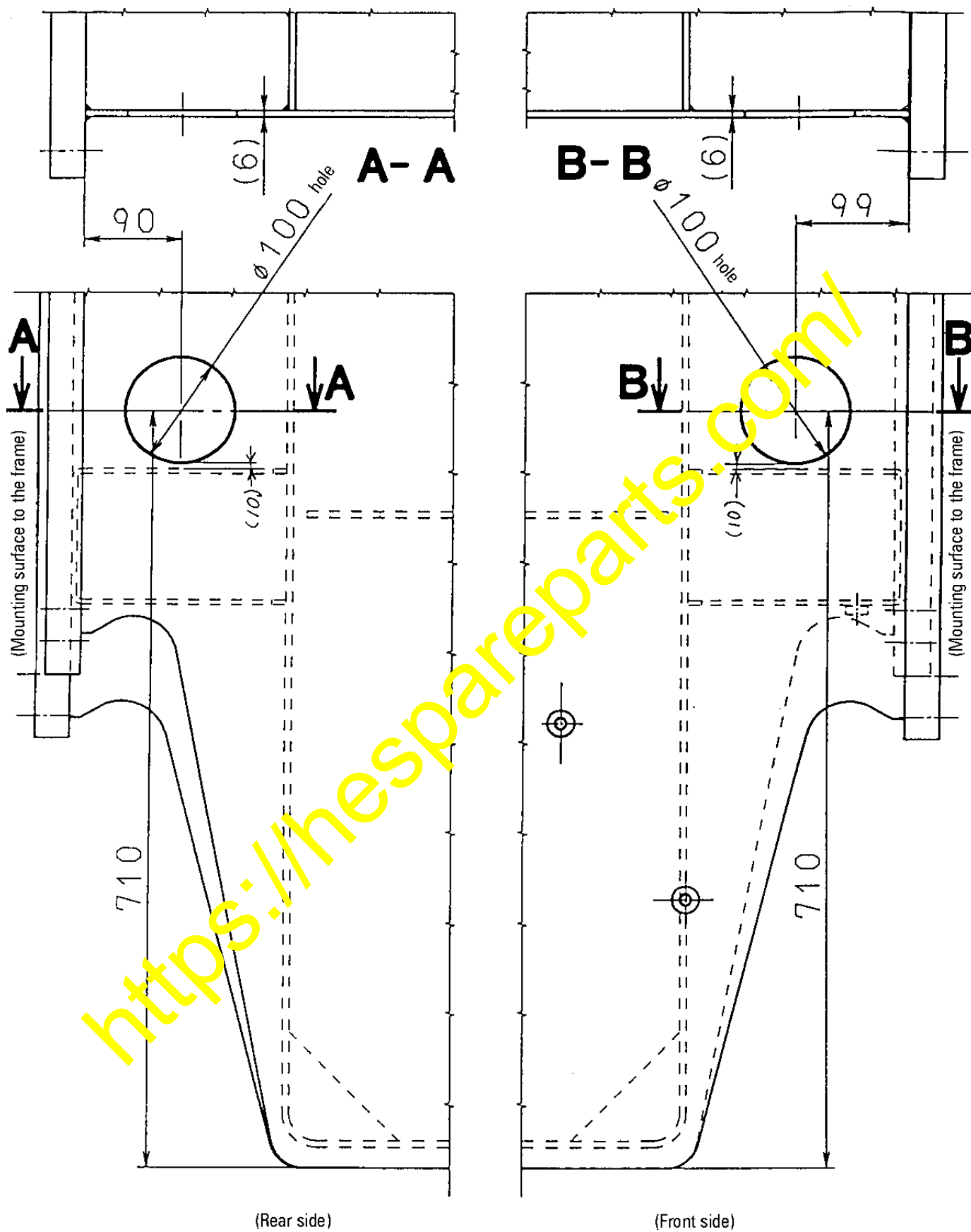
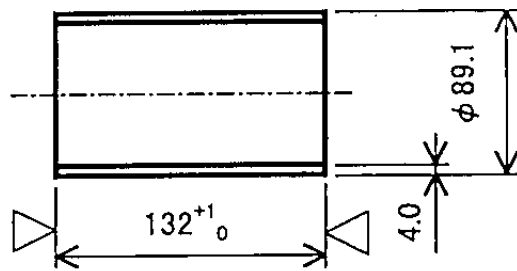


Fig. 2 Reworking the end plates (to supplement sand discharging holes)



Material: STKM13A ( $\phi 89.1 \times t4.0$ )  
or SGP80A ( $\phi 89.1 \times t4.2$ )

Fig. 3 Pipe (561-04-6AE50)

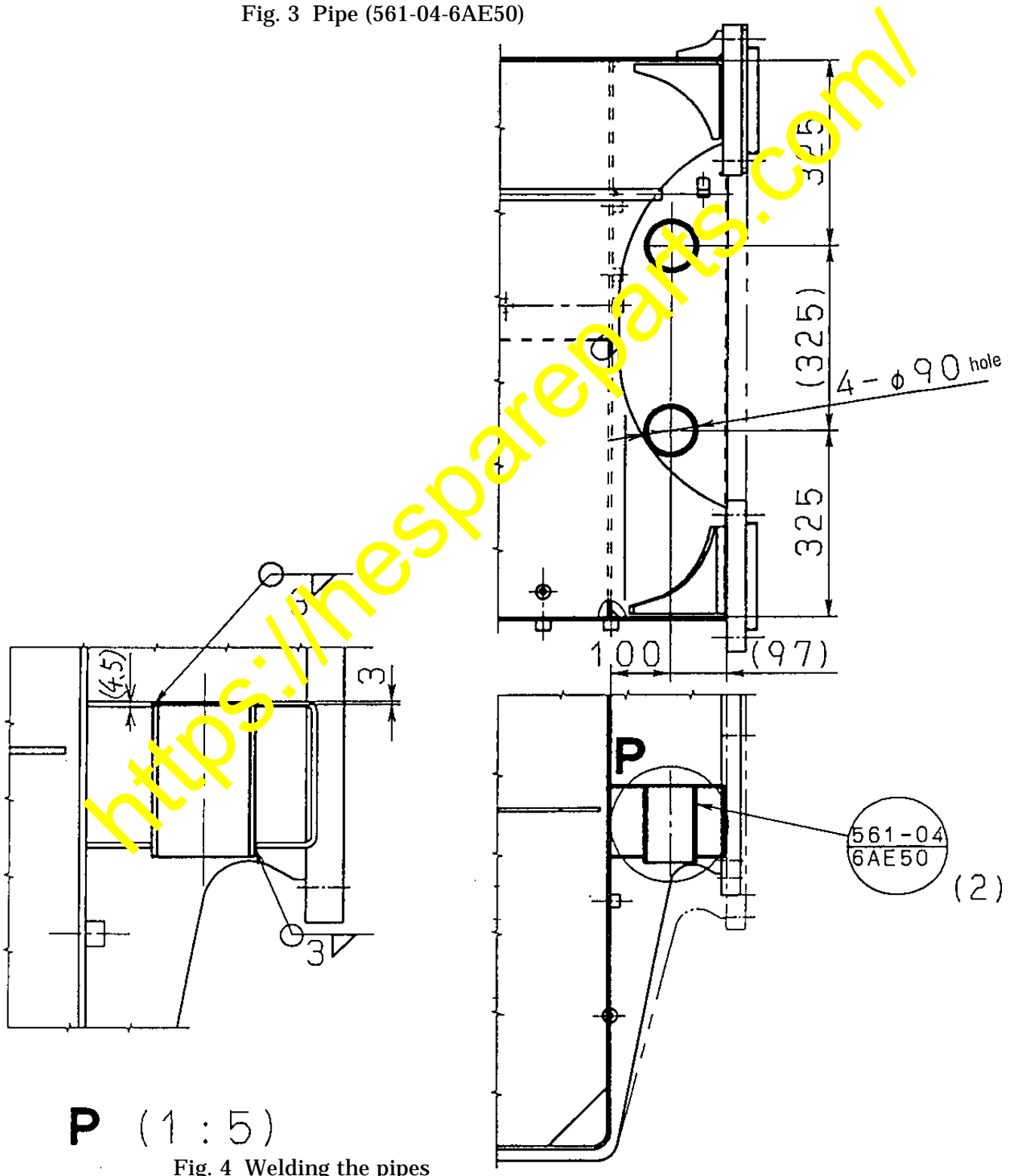


Fig. 4 Welding the pipes