

PARTS & SERVICE NEWS

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SUBJECT: 930E FUEL AND HYDRAULIC TANK MOUNTING CRACKS

PURPOSE: Inform the field of the approved repair procedures for weld cracks near upper fuel tank mounts and hydraulic tank mounts.

APPLICATION: Komatsu 930E Dump Trucks AFE48-A - V; A30019, A30026 - A300173

FAILURE CODE: 4710HB

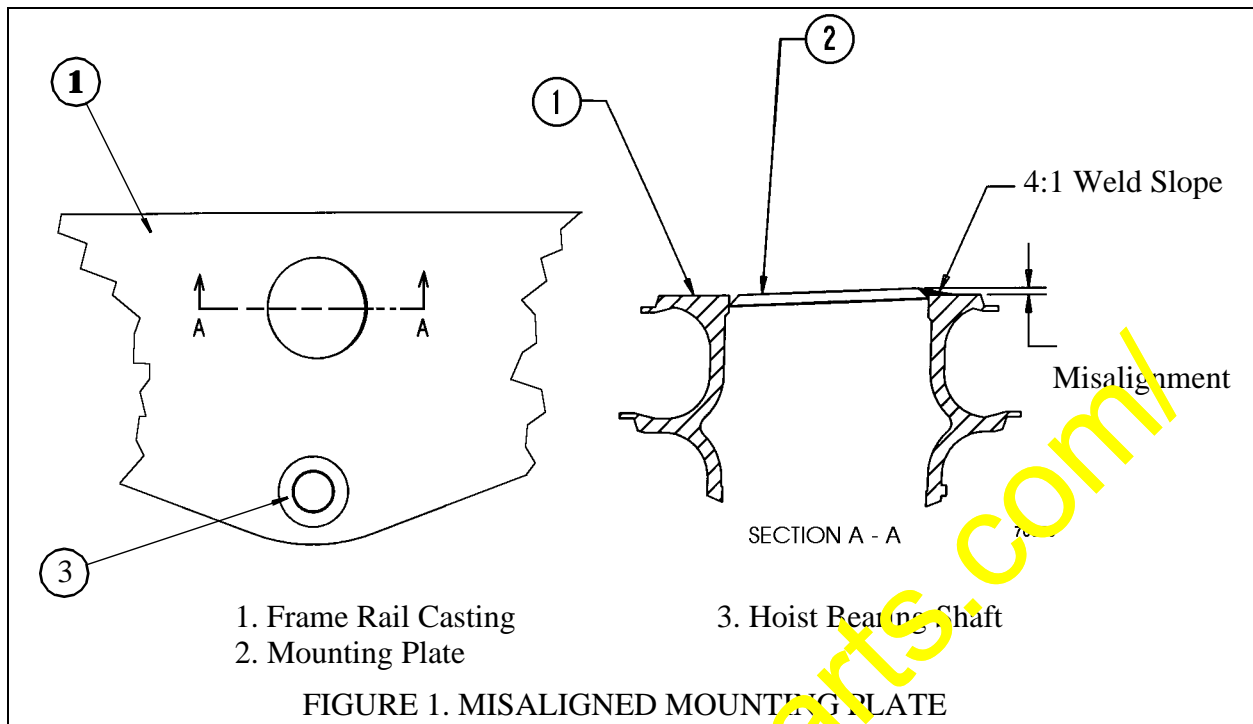
DESCRIPTION: Location and welding information for repairing weld cracks near upper fuel tank mounts and hydraulic tank mounts.

REPAIR PROCEDURE

▲ IMPORTANT ▲

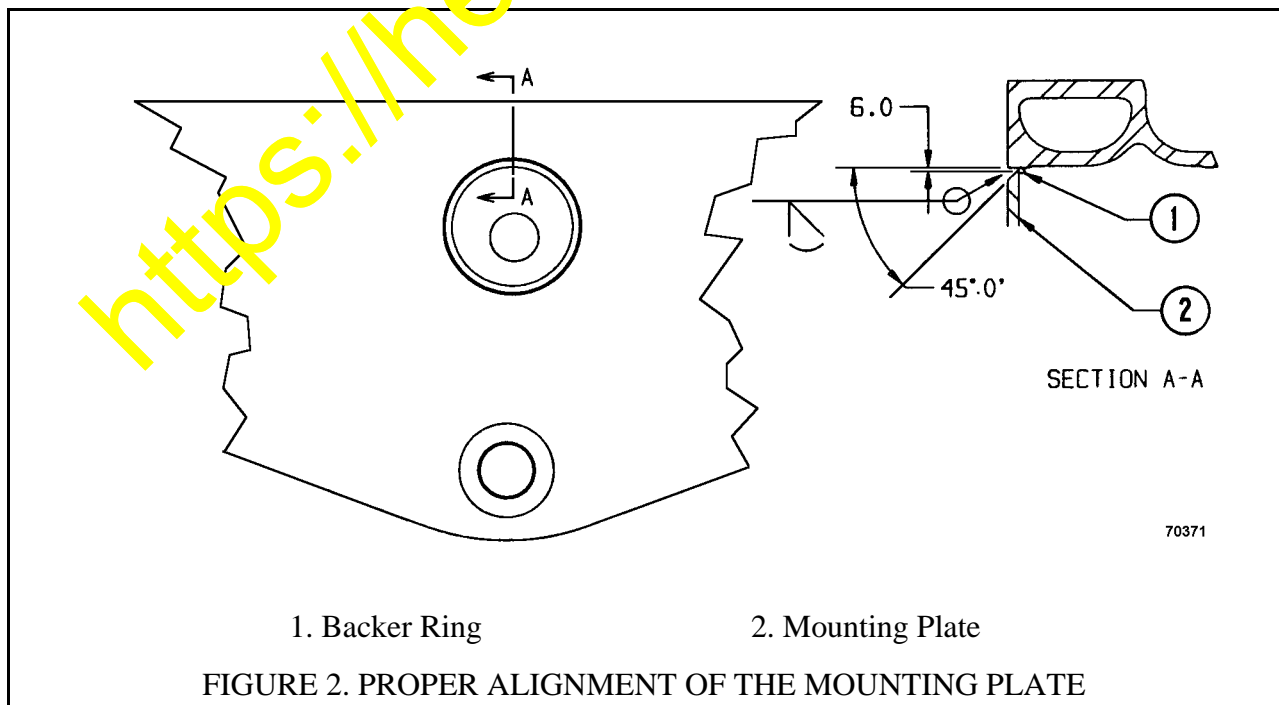
•Follow the guidelines that are documented in *Field Welding For Assembly or Repair per Parts and Service News* (Reference # AA00047B).

1. Remove the hydraulic tank and the fuel tank from the truck. Refer to the appropriate shop manual for the proper procedures.
2. Determine whether misalignment exists between tank mounting plate (2, Figure 1) and frame rail casting (1). The tank mounting plate may not be flush with the casting. Refer to Figure 1. If any cracks exist in the misalignment region, the crack repair weld should be tapered to the casting using a 4:1 slope, as shown. Grind the weld toe to make a smooth transition to the frame rail.



NOTE: Mounting plates (2) are only located at the tank mounts that are directly above hoist bearing shafts (3). Therefore, inspections and repairs must be performed at each location.

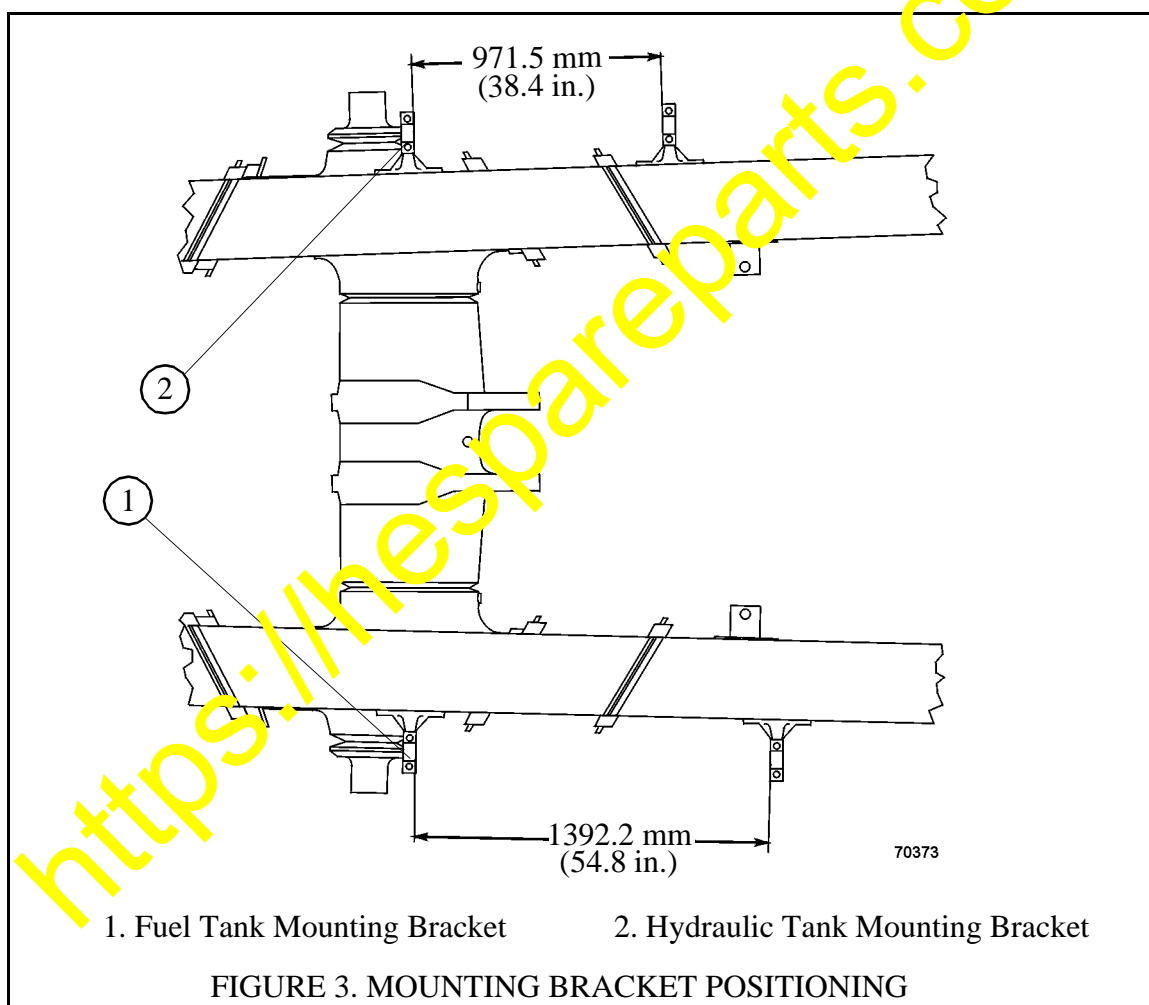
3. If cracks are present and tank mounting plate (2) is flush with casting (1), the plate must be removed. After the plate has been removed, clean all foreign material, weld debris, etc. from the plate and from backer ring (1, Figure 2). Install plate (2) flush with backer ring (1). Ensure that the mounting plate is flush with the frame rail casting. It may be necessary to reposition the backer ring. The slotted section of the backer ring should face the rear of the truck.



- If the mounting plates were removed, ensure that mounting brackets (1 & 2, Figure 3) are perpendicular to the ground and are positioned at the correct distances upon installation. It may be necessary to temporarily lift the tanks into position above the mounts to ensure proper alignment.

▲ IMPORTANT ▲

If the mounting brackets are not correctly positioned, proper installation of the tanks may not be attainable.



- Install the hydraulic tank and the fuel tank after the completion of repairs to the mounts. Refer to the appropriate shop manual for the proper procedures.