

PARTS & SERVICE NEWS

REF NO.	AA01053
DATE	February, 09, 2001

SUBJECT: BODY PIVOT CASTING

PURPOSE: Inform the field of an approved repair procedure for repairing cracks in the body pivot casting.

APPLICATION: Komatsu 930E Dump Trucks AFE48- A & up, A30019 & up

FAILURE CODE: 4710HB

DESCRIPTION:

Some trucks in the field have experienced cracking near the rear body pivot castings due to thin casting walls. This approved procedure is intended to pad weld the walls of the castings in order to prevent further cracking in this area. Follow the proceeding instructions and specifications in order to repair the castings.

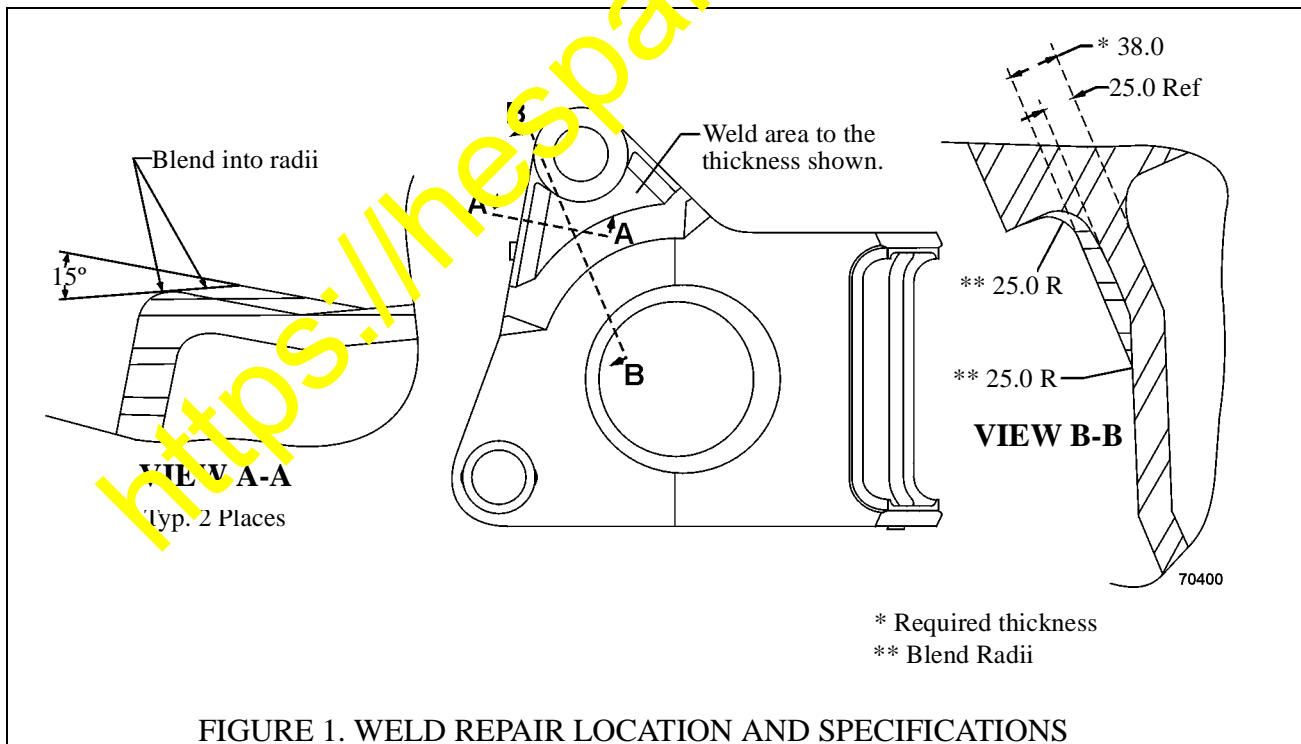
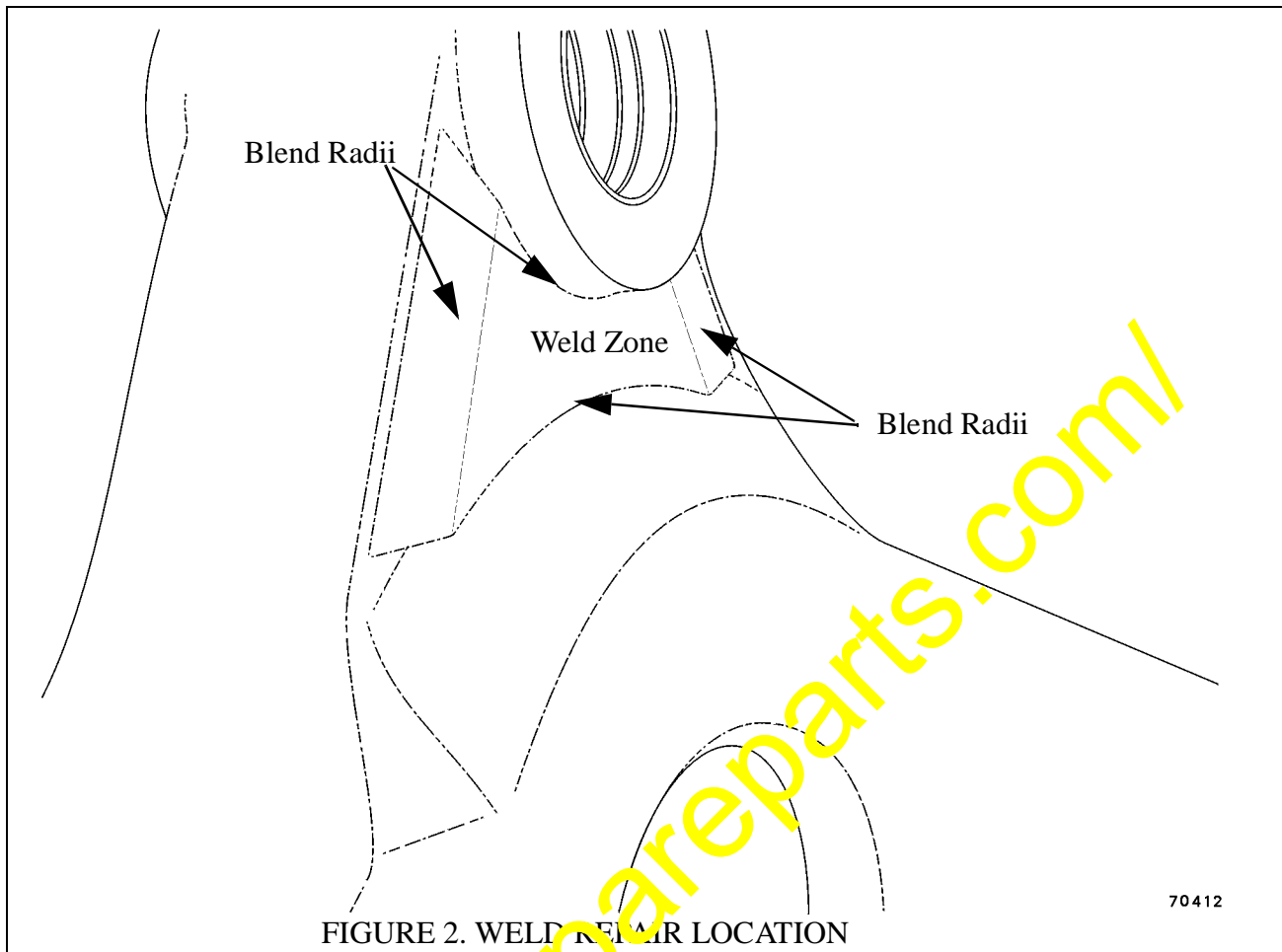


FIGURE 1. WELD REPAIR LOCATION AND SPECIFICATIONS



WELD REPAIR PROCEDURE

NOTE: Refer to Parts and Service News "FIELD WELDING FOR ASSEMBLY OR REPAIR" (# AA00046B) for detailed information on welding repairs.

1. Inspect the entire welding area and remove any grease, paint, and foreign objects.

NOTE: Do not remove the pivot bushing from the bushing bore until the welding and inspection procedure is complete.

2. Pre-heat the welding area to 250° F (121° C).
3. Use E7018, 5/32 in. weld wire.
4. Weld the casting using small beads.
5. Hammer peen the weld with a 0.25 in. radius tool after each pass.
6. Post heat the weld area plus an additional 3in. (76.2 mm) to 1000° F (538° C).
7. Grind the toe of the weld in order to form a smooth transition with the casting.
8. Perform a magnetic particle inspection (MPI) on the welded area plus an additional 0.25 in. (6.35 mm). Repair any defects if necessary.
9. Replace the bushing in the body pivot bore.