

# PARTS & SERVICE NEWS

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**SUBJECT:** 730E FRAME REPAIR AND INSPECTION

**PURPOSE:** To inform the field of the Frame Repair and Inspection Process.

**APPLICATION:** Komatsu 730E Dump Trucks AFE47 & Up, A30079 & Up

**FAILURE CODE:** 4710HB

**DESCRIPTION:** Frame Repair and Inspection Process.

An evaluation of 730E dump trucks in service has revealed cracks in the area of the frame that is in front of the drive tube casting. Inspect the area in front of the drive tube casting for cracks in the frame.

Due to the location of the cracks (A, Figure 1), field repairs in this area can be difficult to complete. A typical crack is found on the inside of the frame where corner joint backer bar (1, Figure 2) connects with top bar (2) and casting (3).

If required, backing bars may be welded to the drive tube casting in order to provide greater strength. The (1.25 x 1.25 inch) ASTM A36 / UNS K02600 backer bar (4) need to be beveled and welded 100% to casting (3). The backer bars (4) should be used to back the crack in the parent metal, and to connect existing corner joint backer bar (1) up to casting (3).



*Use caution when welding a crack or when welding the backer bars. It is important that the welder is aware that a crack may be adjacent to the casting internally.*

Follow the guidelines that are outlined in Parts and Service News "FIELD WELDING FOR ASSEMBLY OR REPAIR" (#AA00046B), Welding Manual I (SEBF14001), and Welding Manual II (SEBF15002). It is important that these instructions are read, fully understood, and followed.

Also, carefully inspect the shimming of the body pad, body guide, and the body pivot. The shimming of these areas can affect the frame structure and if improperly maintained can cause additional failures.

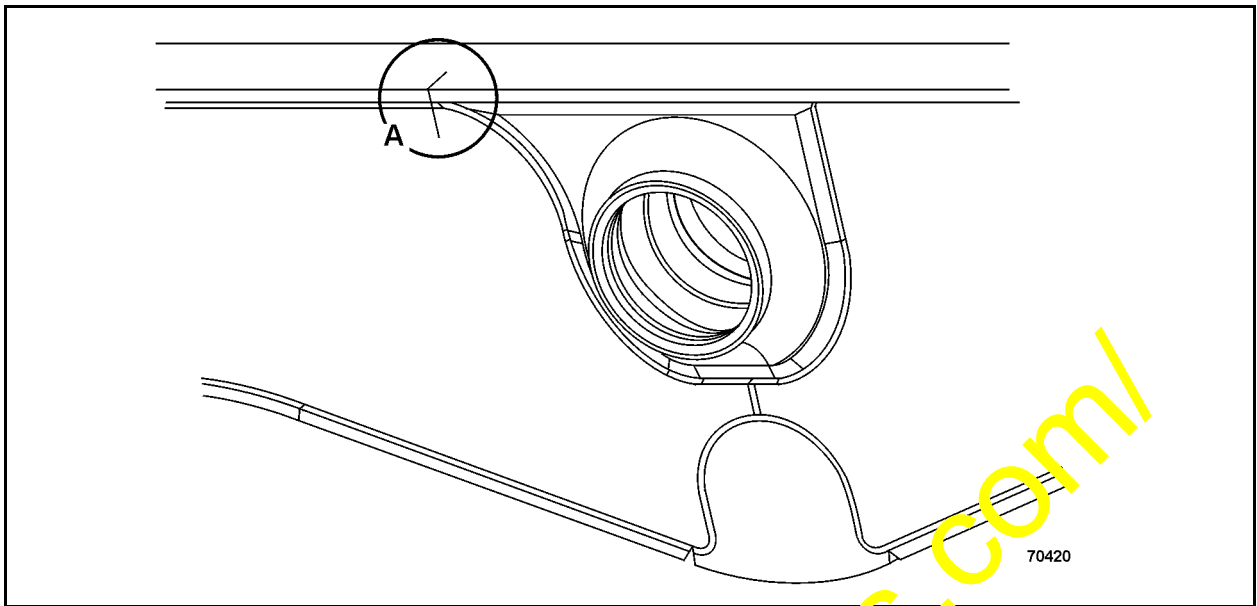


FIGURE 1. DRIVE TUBE CASTING

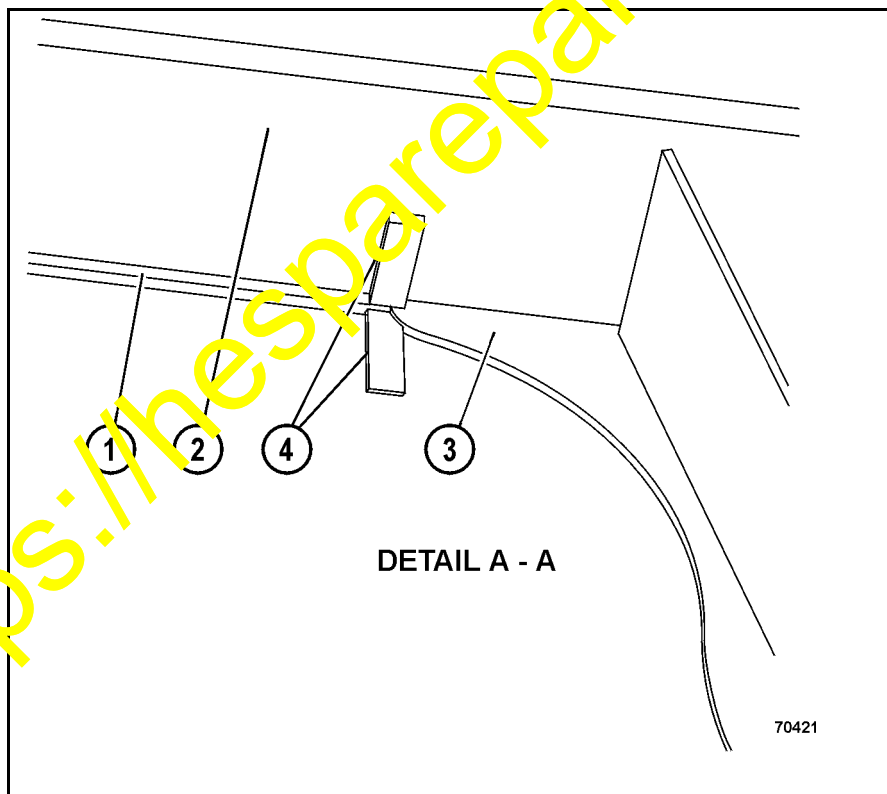


FIGURE 2. INSIDE VIEW OF THE FRAME RAIL

- |   |                                  |
|---|----------------------------------|
| 1. Corner joint backer bar (.5 x .5 inch) | 3. Casting                       |
| 2. Top Bar                                | 4. Backer bar (1.25 x 1.25 inch) |