

PARTS & SERVICE NEWS

REF NO.	AA01250
DATE	Dec. 13, 2001

SUBJECT: REPAIR PROCEDURE OF CAB DOOR

PURPOSE: To introduce modification procedure to prevent breakage of the cab door glass

APPLICATION: GD555-3C Motor Graders, S/N 50002 thru 50008, 50010 thru 50029
GD655-3C Motor Graders, S/N 50001, 50002, 50004, 50005 thru 50007, 50010 thru 50022, 50031 thru 50033, 50035 thru 50041, 50044 thru 50051, 50053 thru 50062, 50064 thru 50069, 50071 thru 50076
GD675-3C Motor Graders, S/N 50001 thru 50016

FAILURE CODE: 5522FE

DESCRIPTION:

Since there is a possibility of breakage of the cab door glass when the cab door is opened and pushed by a strong wind. The impact load is applied when the open lock is actuated. Make the modification of the door striker section and the stopper bolt per the modification procedure being described in this **PARTS & SERVICE NEWS** to prevent the above from occurring.

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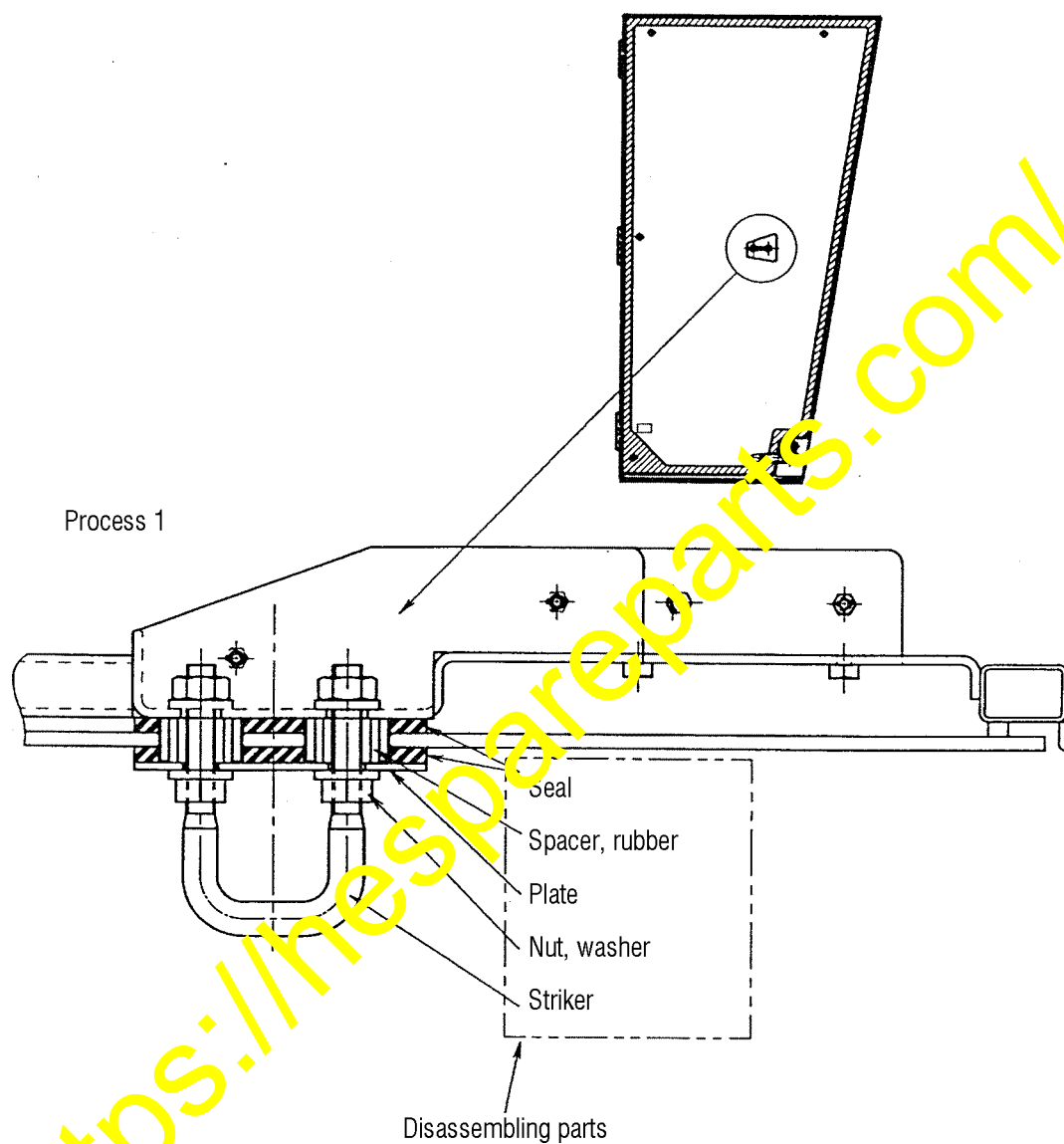
2. List of parts

Part No.	Part Name	Purpose of part	Q'ty	Remarks
23B-952-2760 (23B-952-1340)	Striker (Striker)	} Replacement	2 (2)	The same part as 23B-99-35410
23B-952-2770 (23B-952-2321)	Boot (Seal)		4 (4)	The same part as 23B-99-35440
154-61-16570 (01643-71232)	Washer (Washer)		8 (8)	
01594-00807 (01594-01008)	Nut (Nut)		4 (4)	
(23B-952-2330)	(Seal)	} Not used	(4)	
(23B-952-2340)	(Collar)		(4)	
(23B-952-2351)	(Plate)		(2)	
(01584-31008)	(Nut)		(4)	
23B-952-2740 (23A-952-1430)	Stopper (Stopper)	Replacement	4 (4)	In case it is not possible to make the adjustment, use 23B-952-2750.

3. Modification procedure

3-1. Modification procedure of the door frame (1/3)

- (1) Referring to the Process 1, disassemble the parts of the striker section of the LH and RH doors.

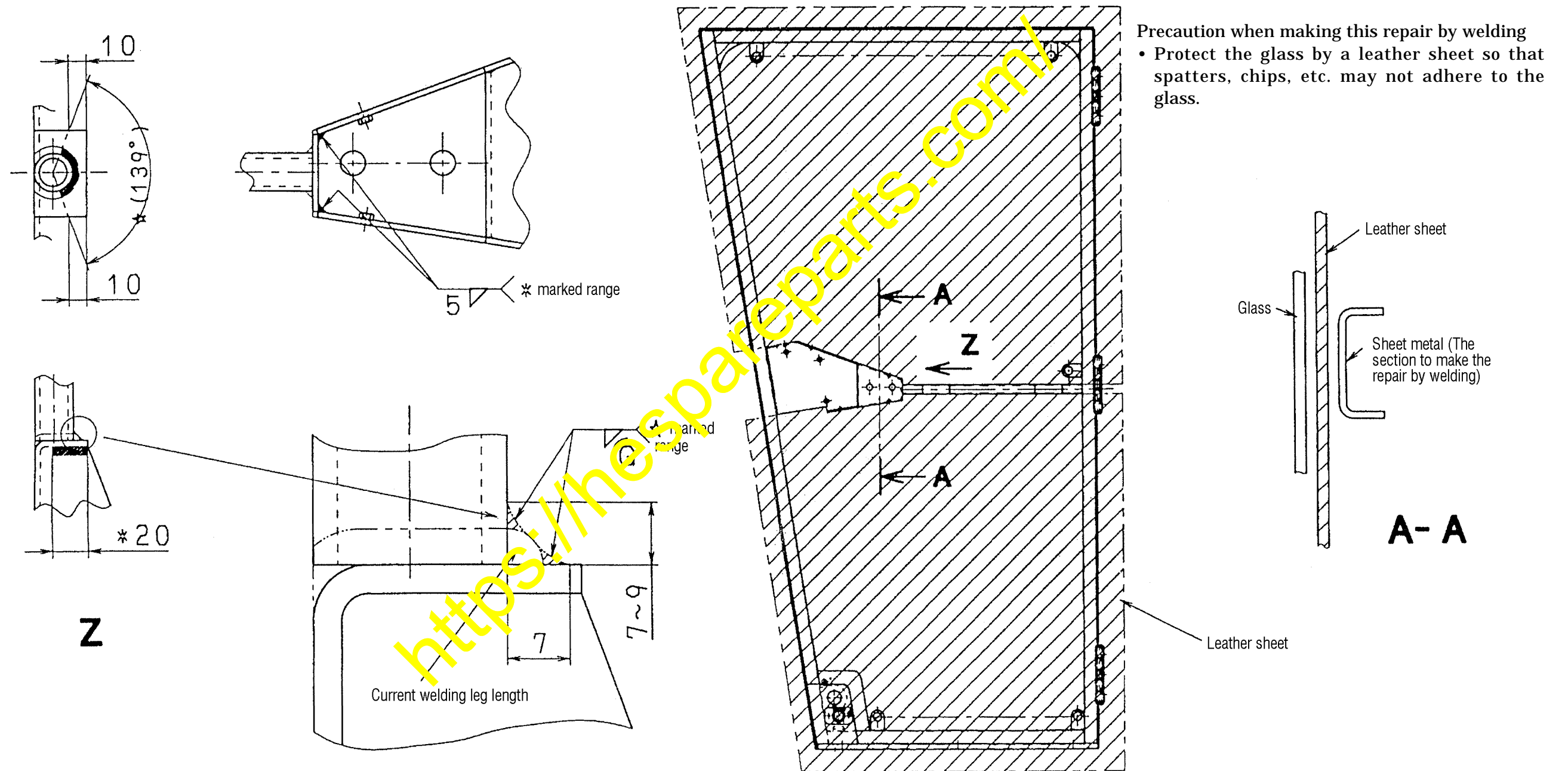


3-1. Modification procedure of the door frame (2/3)

(2) Referring to the Process 2, make repair of the LH and RH door frame by welding.

Process 2: Repair procedure of the door frame by welding

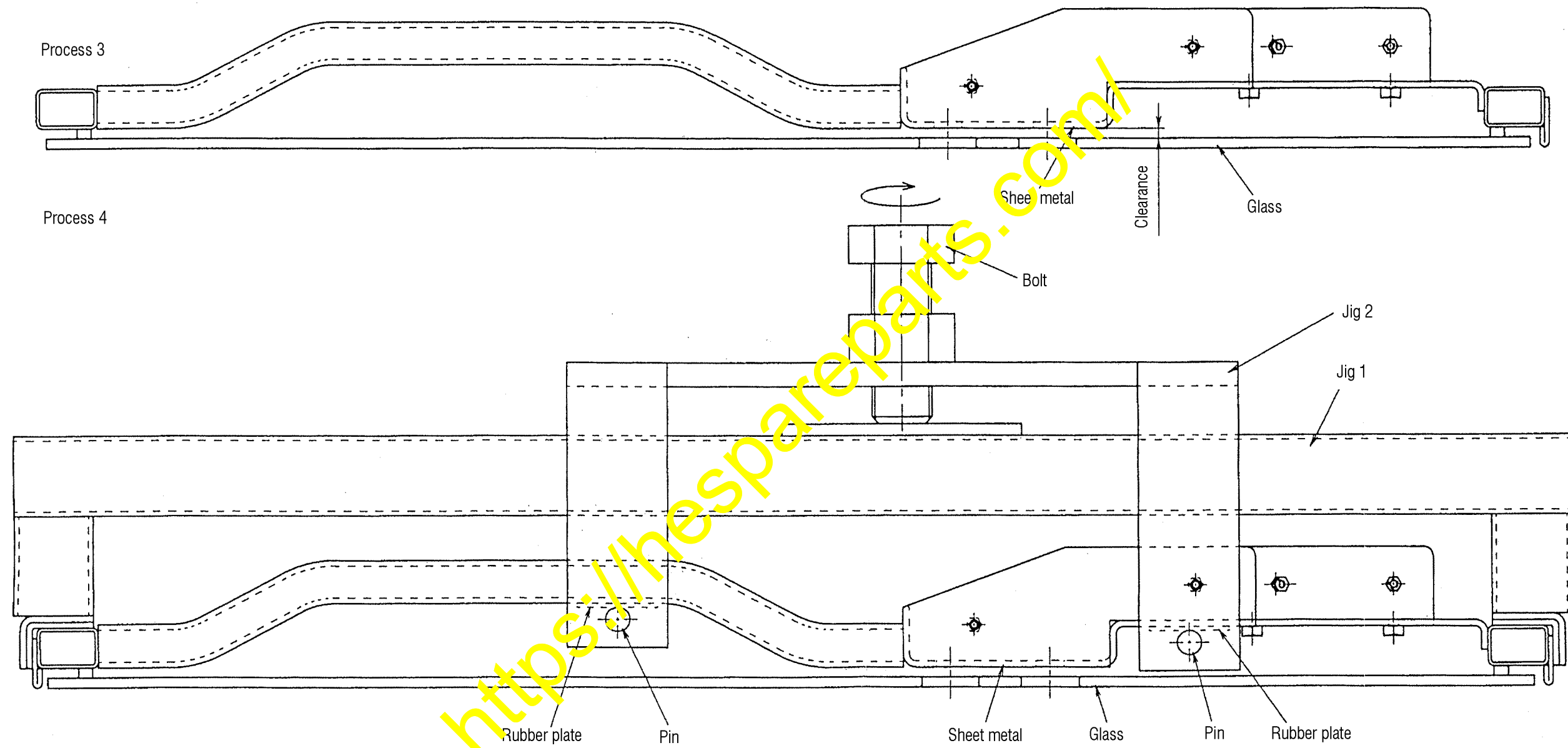
This drawing shows the repair procedure of the LH door frame by welding.
Make repair of the RH door frame in the similar way.



3-1. Modification procedure of the door frame (3/3)

(3) Referring to the Process 3, check the clearance between the glass and the sheet metal.

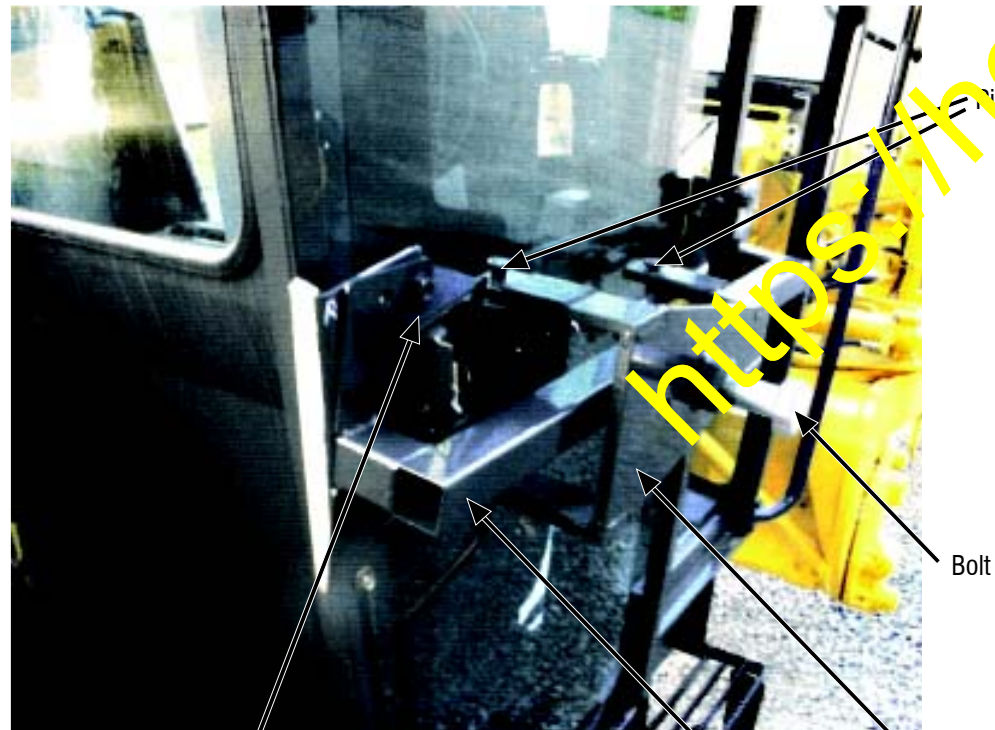
- It is OK if the clearance between the glass and the sheet metal is 5 – 6 mm.
- If the clearance between the glass and the sheet metal is less than 5mm, correct the clearance to 5 – 6 mm referring to the Process 4.



- Set the jig 1 and the jig 2 according to the position indicated in the above drawing.
- Turning the bolt clockwise, increase the clearance between the glass and the sheet metal.
Standard when increasing the clearance: Increase the clearance by about 6 mm more from the present clearance between the glass and the sheet metal and return the bolt. Then, the final clearance shall increase by about 1 mm.

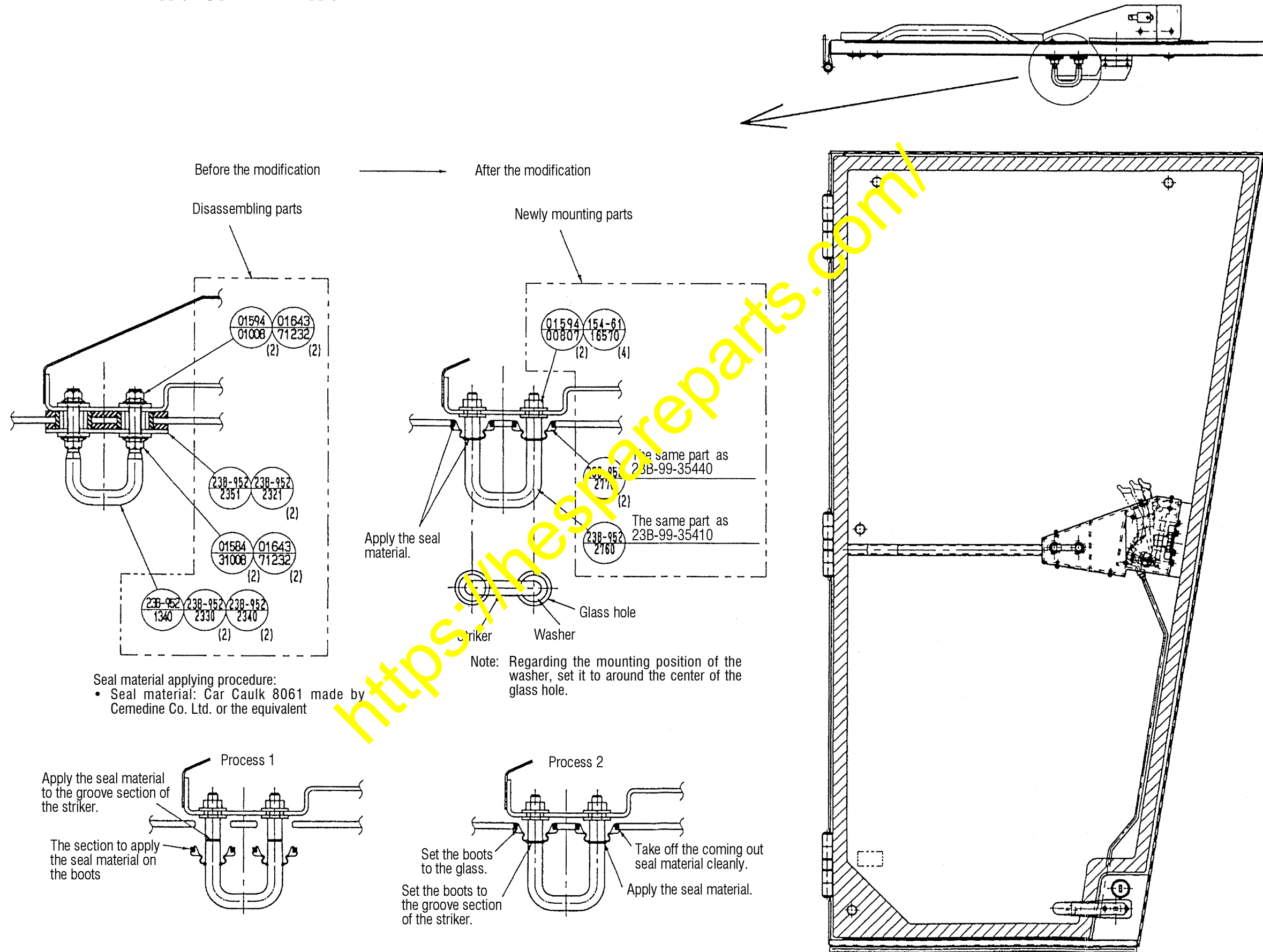
(4) Carry out correction painting of the section where the repair by welding was made.

Photograph of the installed status of the jig to correct the clearance between the glass and the frame (sheet metal)



3-2. Modification procedure of the door striker section

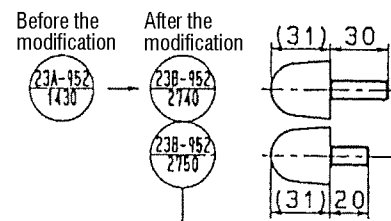
- (1) Mount the new parts.
- (2) Referring to the seal material applying procedure, apply the seal material.



3-3. Modification procedure of the stopper bolt

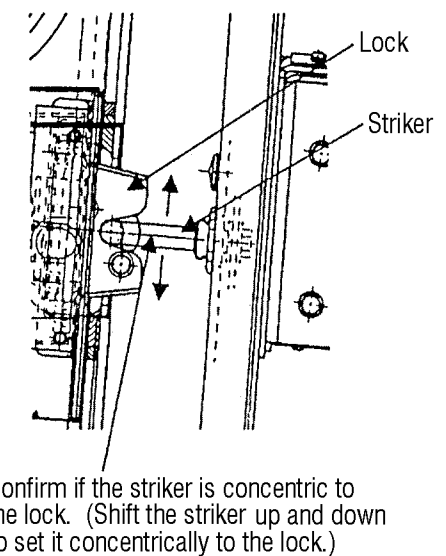
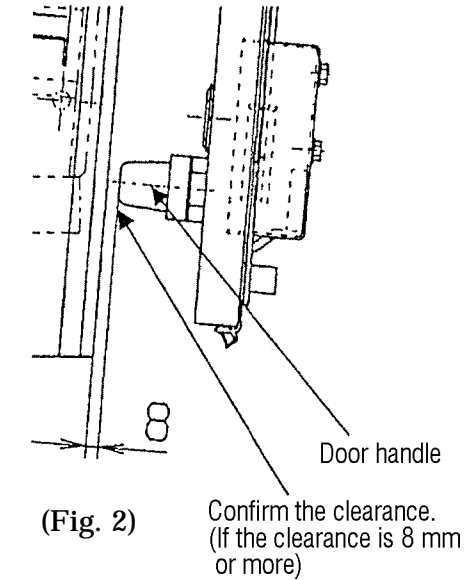
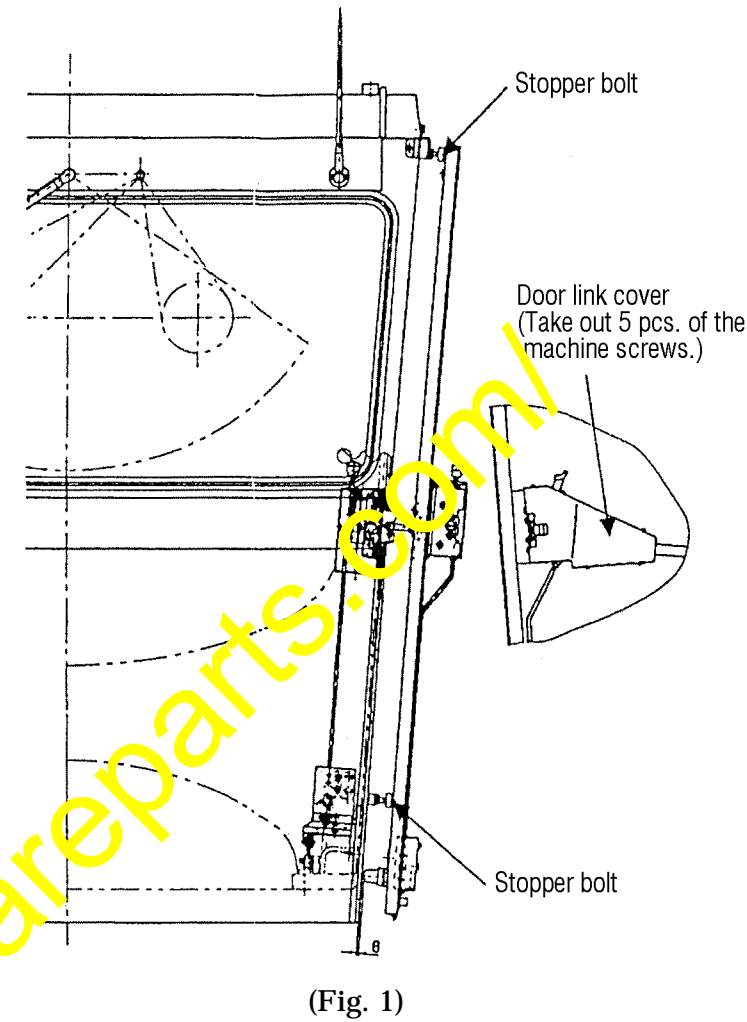
- (1) Disassemble the stopper bolt. (4pcs. on the LH, RH, upper and lower sides)
- (2) Set the door strike section to the lock section of the cab body.
- (3) Confirm if the striker and the lock are concentric. (Refer to Fig. 3.)
 - Mount the striker without inclination to the LH side or to the RH side. (Refer to Fig. 4.)
 - Confirm if the striker and the case of the lock are not rubbing. (Refer to Fig. 4.)
- (4) If the striker is being mounted without inclination to the LH side or to the RH side and, also, if it is set concentrically to the lock, adjustment of the door striker section is OK. (As the next step, make the adjustment from No. 6.)
- (5) If the striker is not being set concentrically to the lock, disassemble the door link cover and shift the striker up and down to set it concentrically to the lock. (Refer to Fig. 1 and Fig. 3.)
- (6) In the state in which the stopper bolt is disassembled, set the door striker section to the lock section of the cab body and measure the clearance between the cab body and the door glass. (Refer to Fig. 5.)
- (7) Releasing the door open lock, extend the top end position of the stopper bolt by "plus 7 mm" to the clearance which was measured as indicated in No. 6 to set to the position. (Refer to Fig. 6.) (4pcs. on the LH, RH, upper and lower sides)

• Stopper bolt

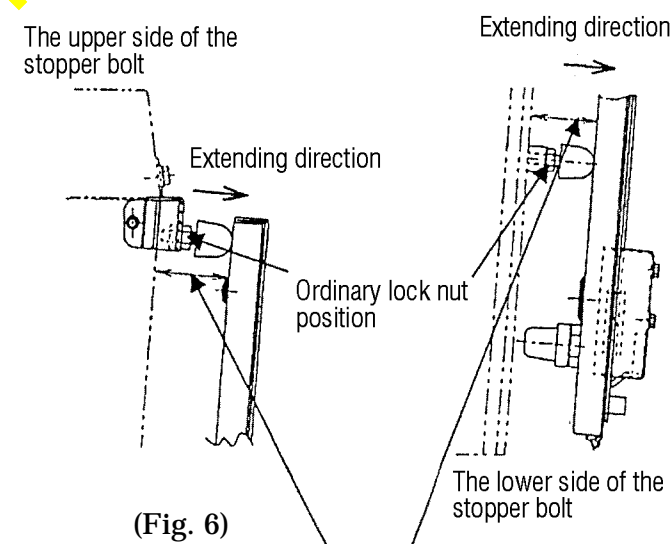
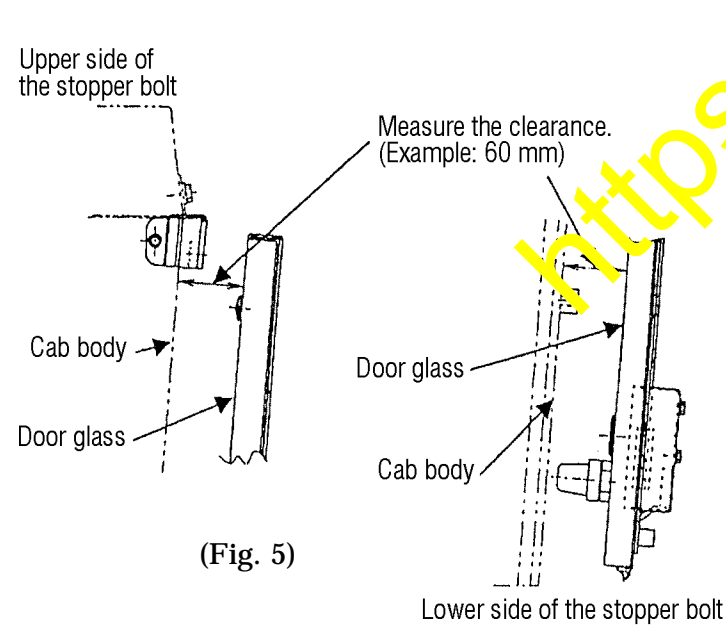


Use this in case it is not possible to make the adjustment by the 23B-952-2740.

The position of the lock nut when it is not possible to make the adjustment.



- (8) Confirm the clearance between the door handle and the cab body (glass surface). (Refer to Fig. 2.)



Extend it by "plus 7 mm" to the clearance as indicated in Fig. 5 to set to the position. (Example: The setting dimension is 67 mm.)

