

# PARTS & SERVICE NEWS

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Page 1 of 3

**SUBJECT:** 830E FRAME REPAIR FOR CRACKING

**PURPOSE:** To inform the field of repair kits and repair procedures for cracking at four separate areas on 830E frames.

**APPLICATION:** AFE32-CG & Up, AFE50-A thru K, A30544 thru A30602

**FAILURE CODE:** 4711HA

**DESCRIPTION:** Frame repair kits: MK4157, MK4159, MK4161, MK4163

Some 830E trucks in operation have experienced frame cracking in the following areas:

- upper horsecollar
- lower horsecollar
- front knee of frame rail (behind horsecollar)
- forward of frame rail casting to rail connection

Clean the truck and closely inspect the frame. Check for cracking on both sides of the frame in the areas noted above. Refer to Figure 1 for approximate location on the frame.

Part Number of Kit	Kit Description
MK4157	Upper Horsecollar Rework
MK4159	Lower Horsecollar Rework
MK4161	Frame Rail (Knee) Rework
MK4163	Frame Rail Casting Rework

If a crack is found in one of the specified areas, choose the corresponding kit to repair the crack(s). Each kit contains a drawing with specific instructions for repair. The contents of each kit are listed in Tables 2 - 5.

Follow the welding procedures outlined in *Parts and Service News*, *FIELD WELDING FOR ASSEMBLY OR REPAIR* (#AA00046B). For additional welding guidelines, refer to *Welding I* (SEBF14001) and *Welding II* (SEBF15002).

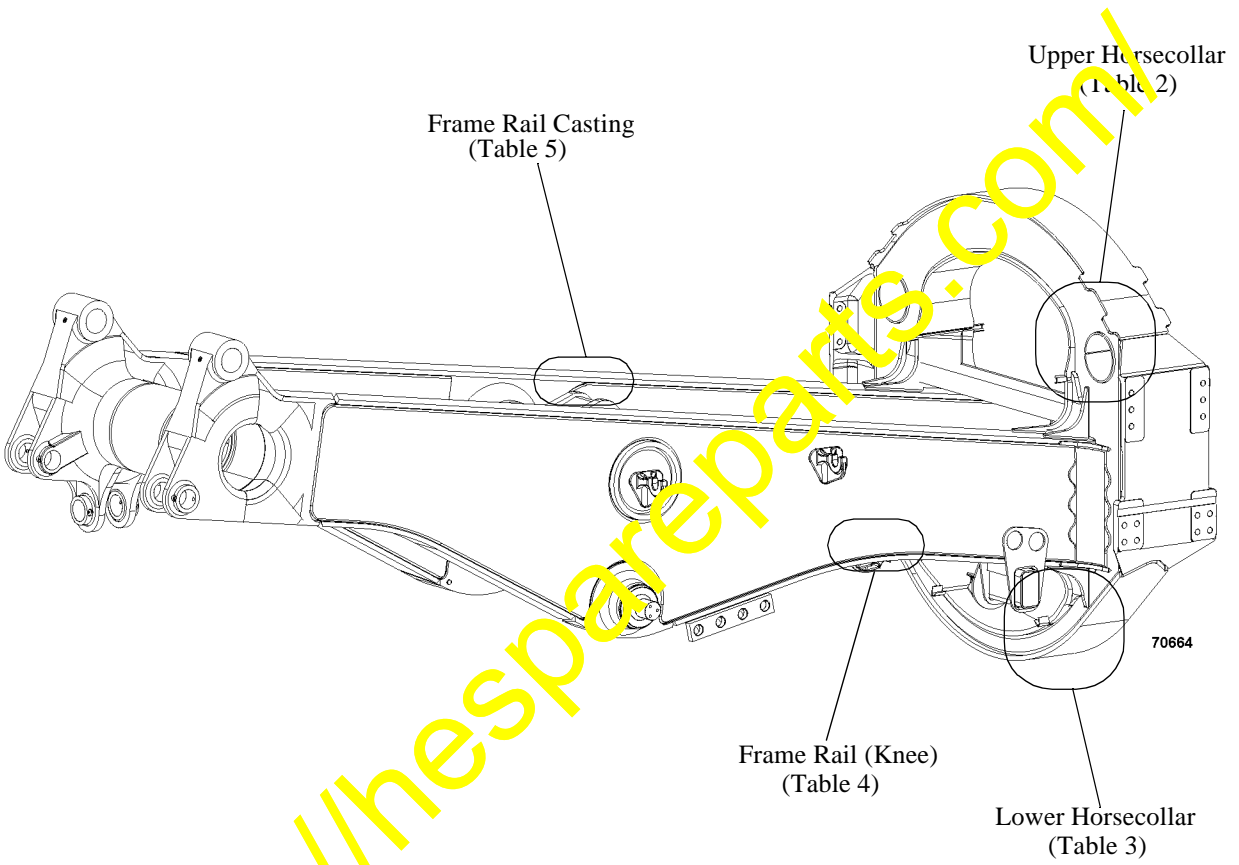


FIGURE 1. FRAME CRACK LOCATIONS

**TABLE 2. UPPER HORSECOLLAR REWORK KIT (MK4157)**

Part Number	Description	Quantity
EJ2360	Drawing, Upper Horsecollar Rework	1
EJ2356	Plate, Upper Loop	1
EJ2355	Plate, Upper Rear	2
ED8824	Bracket, Hydra Zorb	2
WA3565	Channel, Special	8
EJ2555	Backer	2
EJ2554	Backer	2
EJ2556	Backer	4
EJ2553	Plate, Gusset	2

**TABLE 3. LOWER HORSECOLLAR REWORK KIT (MK4159)**

Part Number	Description	Quantity
EJ2359	Drawing, Lower Horsecollar Rework	1
EJ2353	Plate, Lower Loop	1
EJ2354	Plate, Lower Rear	2

**TABLE 4. FRAME RAIL (KNEE) REWORK KIT (MK4161)**

Part Number	Description	Quantity
EJ2358	Drawing, Frame Rail (Knee) Rework	1
EF7482	Backer	4
EF7484	Backer	4
EF7483	Backer	4
EJ2357	Plate, Gusset	2

**TABLE 5. FRAME RAIL CASTING REWORK KIT (MK4163)**

Part Number	Description	Quantity
EJ2361	Drawing, Frame Rail Casting Rework	1
EJ2362	Backer	2
EJ2363	Backer	4
EJ2364	Backer	2