

PARTS & SERVICE NEWS

REF NO.	AA02169
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SUBJECT: WELD JOINT CRACKING AT REAR ENGINE MOUNTS

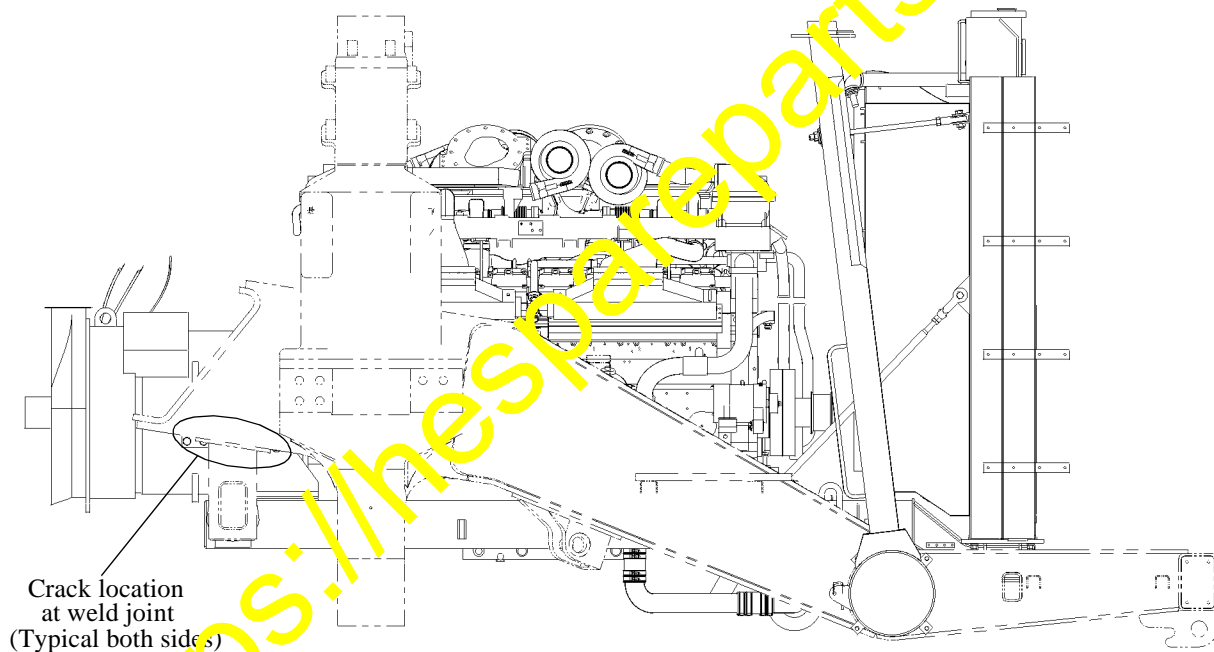
PURPOSE: To inform the field of possible crack locations and a kit for repair.

APPLICATION: Komatsu 930E Dump Trucks AFE48-A & Up, A30019, A30026 thru A30120

FAILURE CODE: 0110HA

DESCRIPTION: Engine Mount Reinforcement Kit (MK4027)

Some trucks in the field may experience cracking at the rear engine mount to frame rail weld joints. Refer to Figure 1. Carefully inspect each mount for cracking at the weld joint. Ensure a thorough inspection of these areas are performed during normal frame inspections at regular intervals.



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FIGURE 1. ENGINE MOUNT CRACK LOCATION

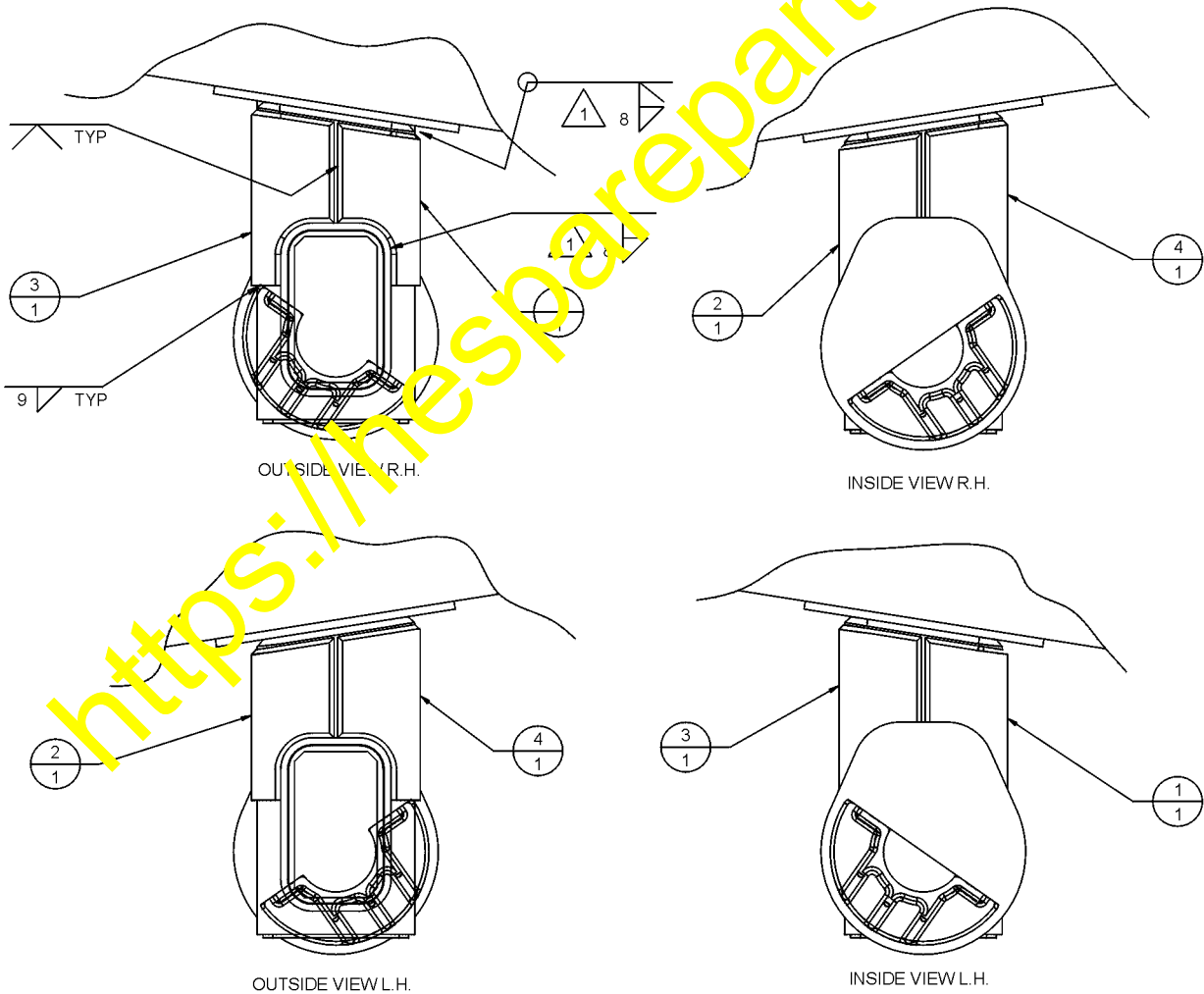
If cracks are found in the specified area, the frame must be repaired, accordingly. Follow the guidelines that are outlined in Parts and Service News, "FIELD WELDING FOR ASSEMBLY OR REPAIR" (AA00046B). For additional welding guidelines, refer to Welding I (SEBF40001) and Welding II (SEBF15002).

Engine Mount Reinforcement Kit (MK4027) has been developed to reinforce the rear engine mounts. Contents of the kit are listed in Table 1. Welding specifications and component locations are shown in Figure 2, and on drawing (EH5509) included in the kit. Each kit contains the necessary parts to reinforce both rear engine mounts.

TABLE 1. ENGINE MOUNT REINFORCEMENT KIT (MK4027)			
Item Number	Part Number	Description	Quantity
-	EH5509	Engine Mount Rework Drawing	1
1	EH5513	LH Front Bent Plate	2
2	EH5512	RH Front Bent Plate	2
3	EH5517	LH Rear Bent Plate	2
4	EH5516	RH Rear Bent Plate	2

CAUTION

Before any welding repairs are performed, ensure that the piston rods on the suspension and steering cylinders are not exposed. Wrapping of the front suspension piston rod, steering cylinder rods, and front tires is mandatory when grinding and welding in this area. Also, be sure to disconnect the batteries prior to performing the repair process.



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FIGURE 2. REAR ENGINE MOUNT REINFORCEMENT