

# PARTS & SERVICE NEWS

REF NO.	AA02202A
DATE	June 26, , 2003

(C)

This PARTS & SERVICE NEWS supercedes AA02202 dated September 23, 2002 and should be discarded

**SUBJECT:** RADIATOR MOUNT CRACK REPAIR PROCEDURE

**PURPOSE:** To notify the field of the procedure to repair cracks that occur in the radiator mount section of the rear frame.

**APPLICATION:** WA700-1L Wheel Loaders Serial Numbers A20001 to A20015  
 WA700-3L Wheel Loaders Serial Numbers A50001 to A50022  
 WA700-1 Wheel Loaders Serial Numbers 10001 thru 19999  
 WA700-3 Wheel Loaders Serial Numbers 50001 thru 50050

**FAILURE CODE:** 4771HA

**DESCRIPTION:**

1. Introduction

The radiator mount section may crack at the rear frame. When the cracks occur, repair the cracks per this Parts and Service News.

2. List of parts

Part Number	Part Name	Purpose of part	Qty.	Remarks
428-46-22R60	Plate	Addition	1	Local Source
428-46-22R70	Plate	Addition	1	Local Source
428-46-22R80	Plate	Addition	2	Local Source
01571-01016	Seat	Replacement	1	Parts at Ripley

<https://thespareparts.com/>

1. Repair procedure for the cracked section

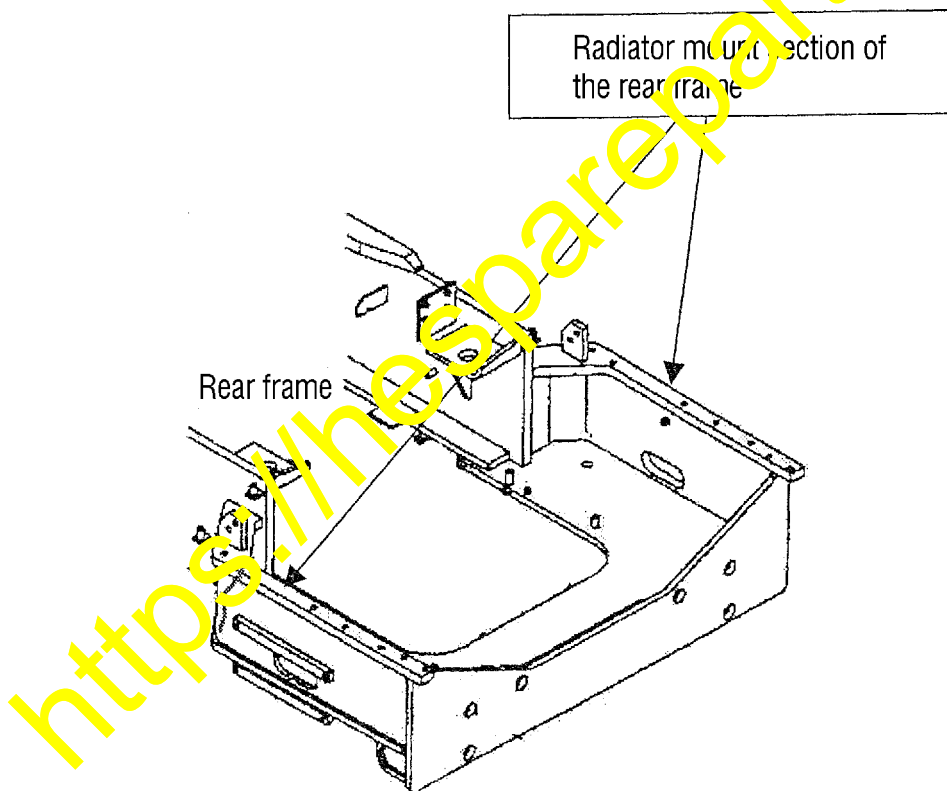
Refer to the shop manual regarding the removal and installation that is relevant to the procedure.

1. Completely remove the cracked sections with a grinder (or by gouging).
2. Perform a dye penetrant test (PT) to ensure that all cracks are completely removed. If any cracks remain, perform the gouging again.
3. Fill the gouged section with build-up welding.

Welding conditions:

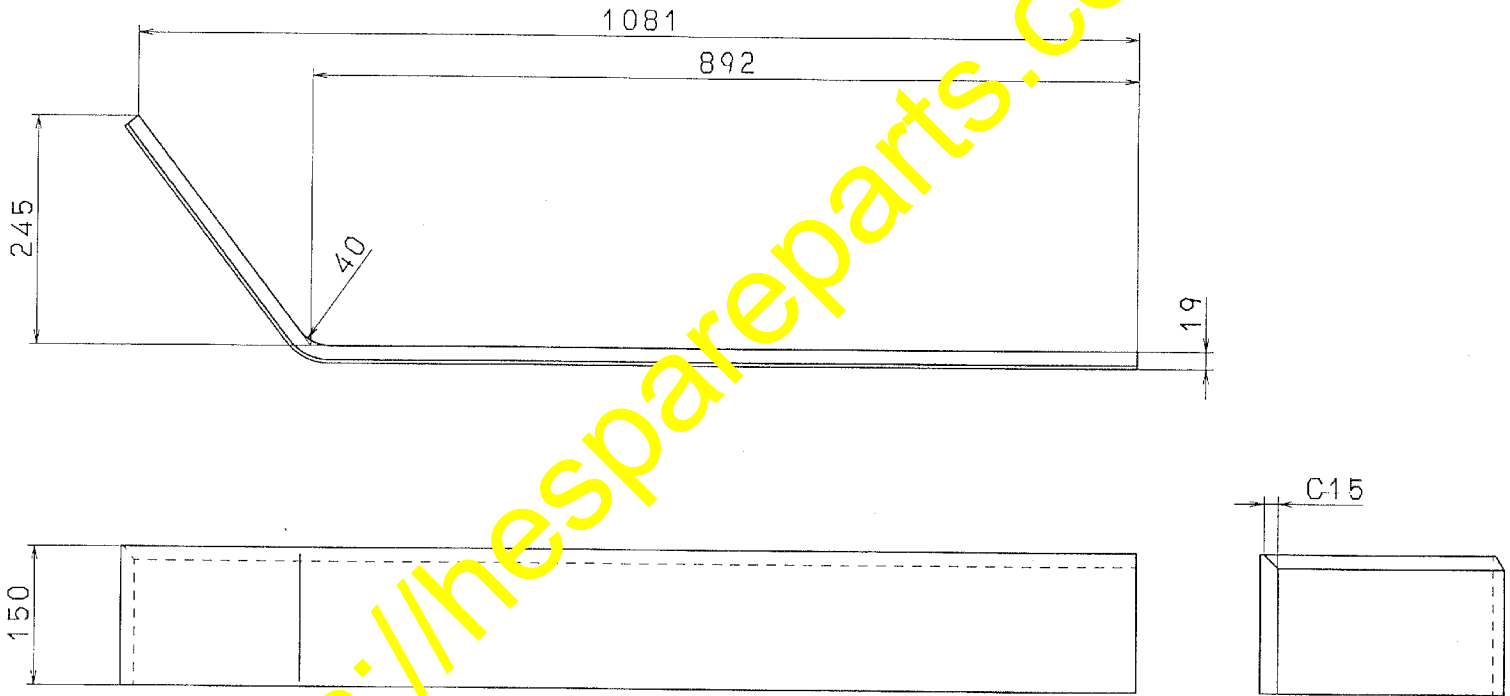
Welding rod: Low hydrogen type 50 kg/mm<sup>2</sup> grade welding rods JIS D5816 type (AWE8016-G equivalent).

4. Grind the welded section smooth.
5. Perform a dye penetrant test again.
6. Paint the welded section with the same color paint.





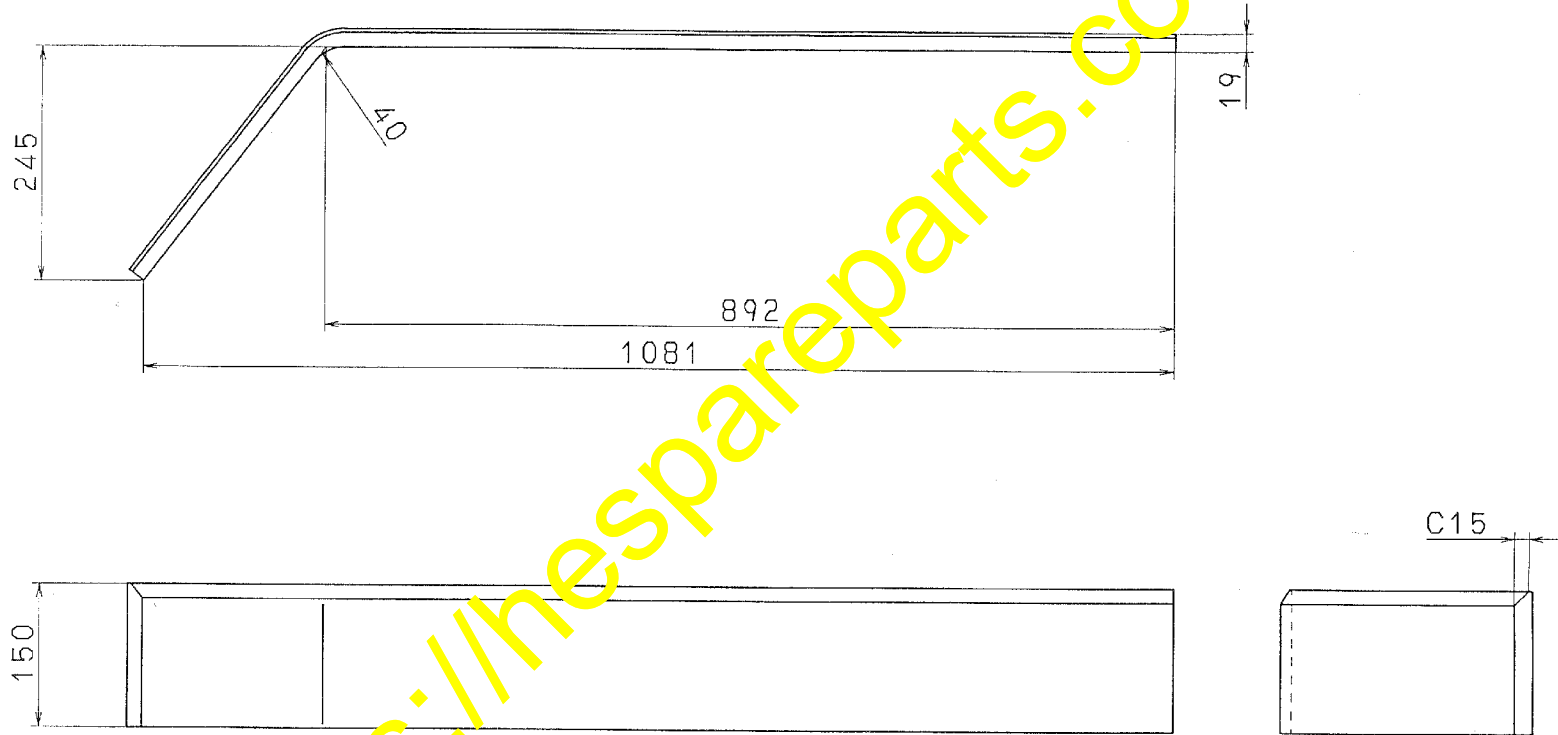
- Reinforcement plate to be added



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Part No. 428-46-22R60  
Part name: Plate  
Material: SS400P  
Q'ty: 1

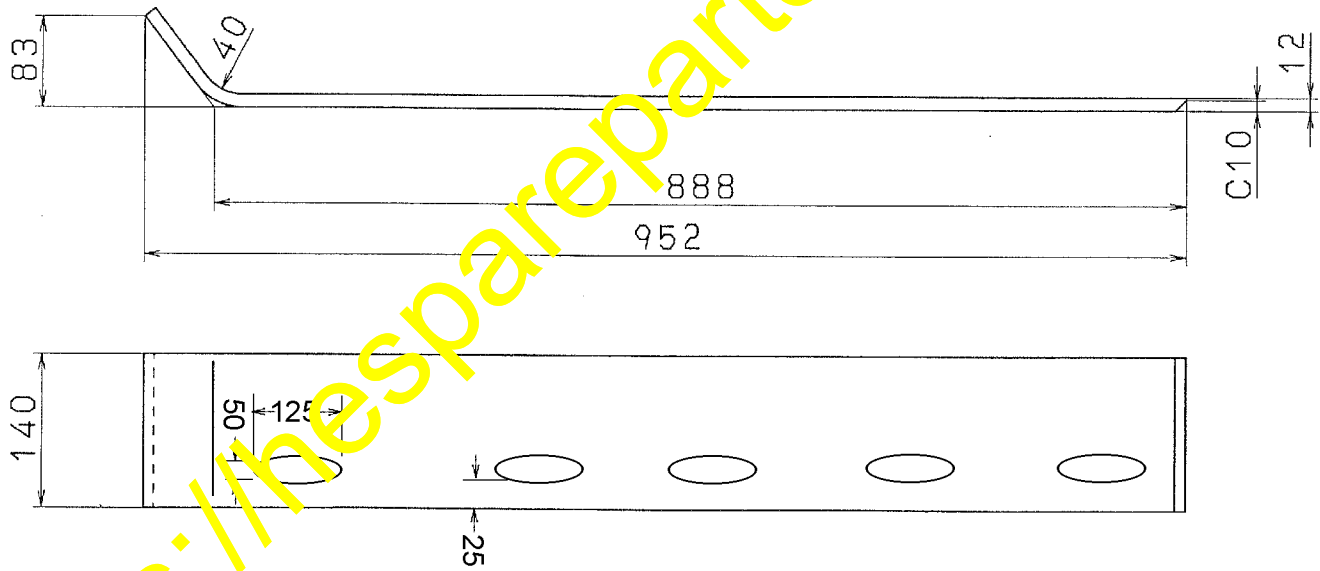
- Reinforcement plate to be added



Part No. 428-46-22R70  
Part name: Plate  
Material: SS400P  
Q'ty: 1

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- Reinforcement plate to be added



Part No. 428-46-22R80  
Part name: Plate  
Material: SS400P  
Q'ty: 2

<https://mespareparts.com/>