

PARTS & SERVICE NEWS

REF NO.	AA03004
DATE	January 6, 2003

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SUBJECT: CIRCLE REINFORCEMENT KIT

PURPOSE: To provide a circle weldment reinforcement.

APPLICATION: 830B Motor Grader Serial Number 200001 to 211060
 830C Motor Grader Serial Number 200001 to 211060
 850B Motor Grader Serial Number 200001 to 211060
 850C Motor Grader Serial Number 200001 to 211060
 870B Motor Grader Serial Number 200001 to 211060
 870C Motor Grader Serial Number 200001 to 211060
 GD530A-2B Motor Grader Serial Number 200001 to 211060
 GD530A-2C Motor Grader Serial Number 200001 to 211060
 GD530AW-2B Motor Grader Serial Number 200001 to 211060
 GD530AW-2C Motor Grader Serial Number 200001 to 211060
 GD650A-2B Motor Grader Serial Number 200001 to 211060
 GD650A-2C Motor Grader Serial Number 200001 to 211060
 GD650AW-2B Motor Grader Serial Number 200001 to 211060
 GD650AW-2C Motor Grader Serial Number 200001 to 211060
 GD670A-2B Motor Grader Serial Number 200001 to 211060
 GD670A-2C Motor Grader Serial Number 200001 to 211060
 GD670AW-2B Motor Grader Serial Number 200001 to 211060
 GD670AW-2C Motor Grader Serial Number 200001 to 211060

FAILURE CODE: 7C20FM

DESCRIPTION: This news will provide a reinforcement method for the circle weldments to prevent failure under severe duty applications.

The following rework parts kit must be ordered.

Item	Part No.	Description	Qty
	1440 411 H91	KIT, CIRCLE REWORK	1
①	1440 274 H1	EXTENSION, CIRCLE KNEE	2
②	1440 275 H1	GUSSET, LOWER RIGHT	1
③	1440 276 H1	GUSSET, LOWER LEFT	1
④	1440 411 H1	PLATE, DOUBLER	1
⑤	1440 405 H1	PLATE, DOUBLER	1

Tools Required Arc Welder
 Hand Grinder
 1-7/16 Open End Wrench

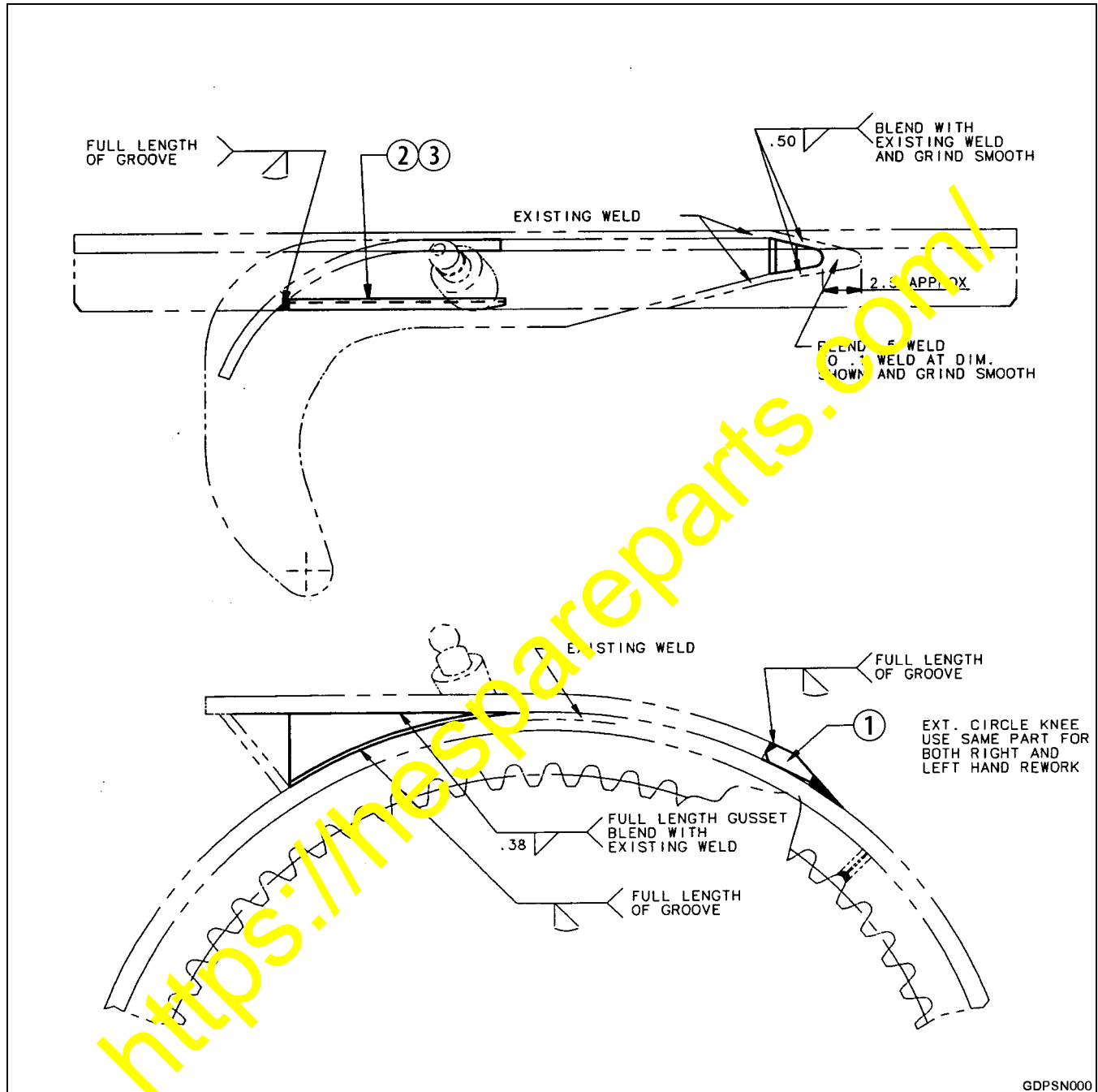
1. The circle can be reworked without having to be removed from the machine.
2. Put the circle in the right bank slope and rest the moldboard on the ground. Install the right knee extension, left lower gusset and the left doubler plate per drawings.

3. Put the circle in the left bank slope and rest the moldboard on the ground. Install the left knee extension, right lower gusset and the right doubler plate per drawings.
4. Repaint reworked areas same color as base machine.

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GUSSET AND CIRCLE KNEE EXTENSION

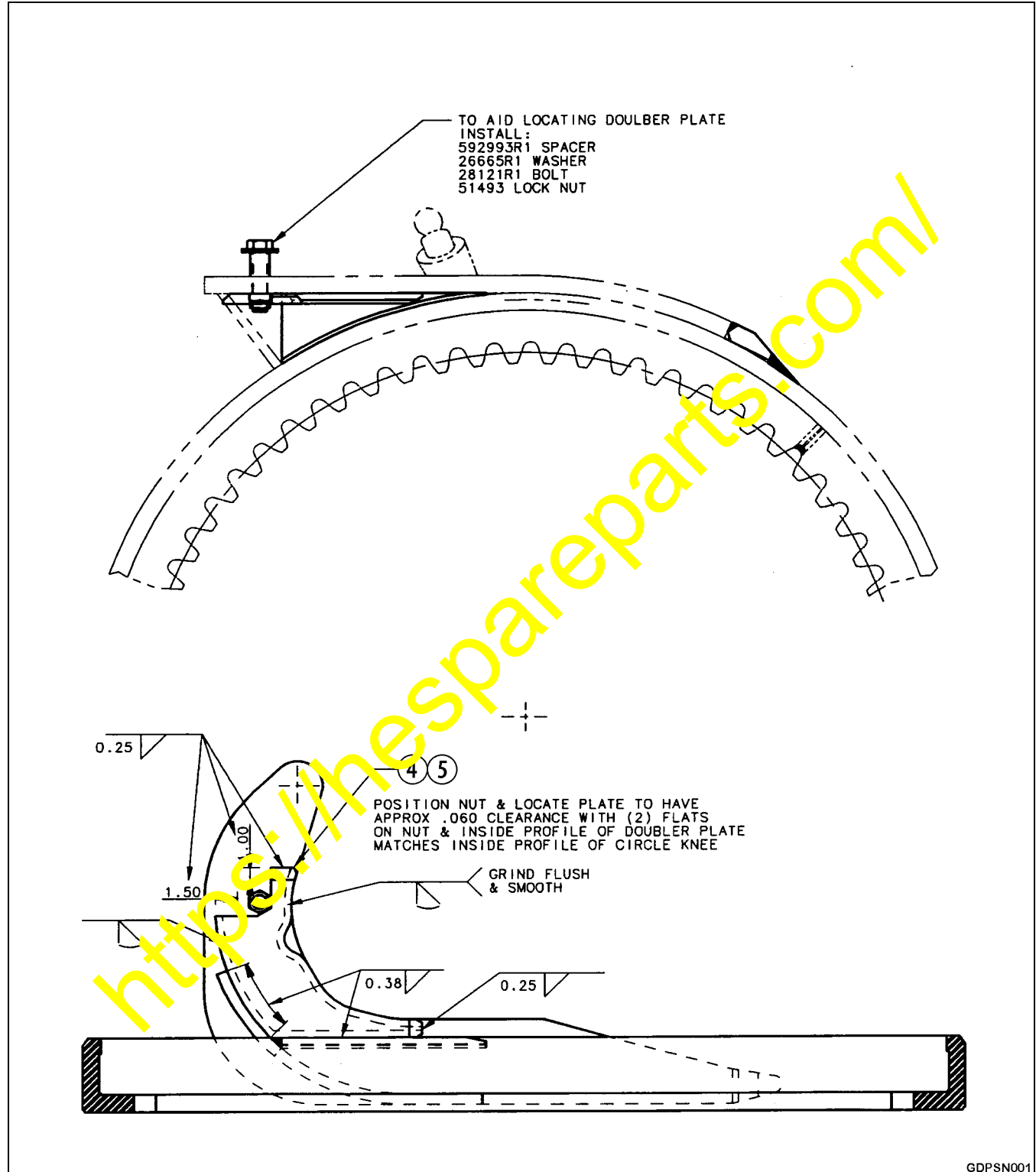
★ The gussets and circle knee extensions are to be installed before the doubler plate.



★ The rework shown is for the right side, the same rework is required for the left side.

DOUBLER PLATE INSTALLATION

- ★ The doubler plates are to be installed after the gussets and circle knee extensions are installed.



- ★ The rework shown is for the right side, the same rework is required for the left side.