

PARTS & SERVICE NEWS

REF NO.	AA03035A
DATE	August 14, 2003

This Parts & Service News supercedes the previous issuance, AA03035, dated February 27, 2003. AA03035 should be discarded.

SUBJECT: 730E FRAME RAIL CASTING REWORK PROCEDURE
PURPOSE: To inform the field of frame rail casting rework process.
APPLICATION: Komatsu 730E Dump Trucks A30079 - A30145
FAILURE CODE: 4711HA
DESCRIPTION: Frame Repair Process

Some trucks in the field may experience cracking at the weld joint of the inner side sheet to top rail bar joint. The typical crack location is found near the front finger of the drive tube casting approximately 1 foot forward of the drive tube center. Carefully inspect the weld joints at the front of the drive tube casting for cracks. Refer to Figure 2.

If cracks are found, follow the rework procedure found on Frame Rail Casting Rework Drawing (EK7314), Figure 3. Use this drawing and rework procedure to properly repair the cracks and reinforce the rail joint. Follow the guidelines that are outlined in the Parts & Service News "FIELD WELDING FOR ASSEMBLY OR REPAIR" (AA00046C). For additional welding guidelines, refer to Welding I (SEBF14001) and Welding II (SEBF15002) manual.

CAUTION

Disconnect the battery and any control circuit cards prior to performing the repair process.

The backer required for the installation of the access cover plate (Figure 1) can be made locally.

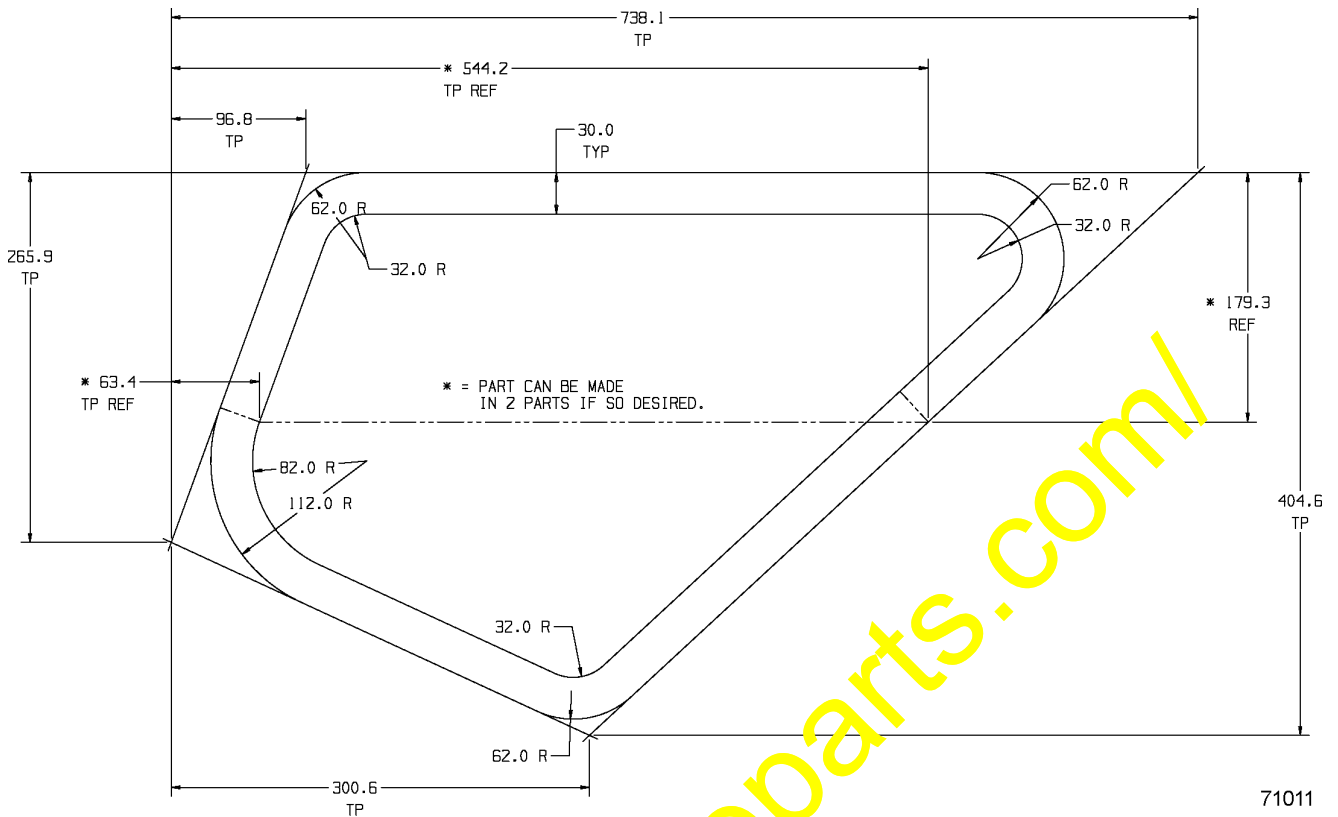


FIGURE 1. BACKER (EK7315)

Material: 6.0 Plate

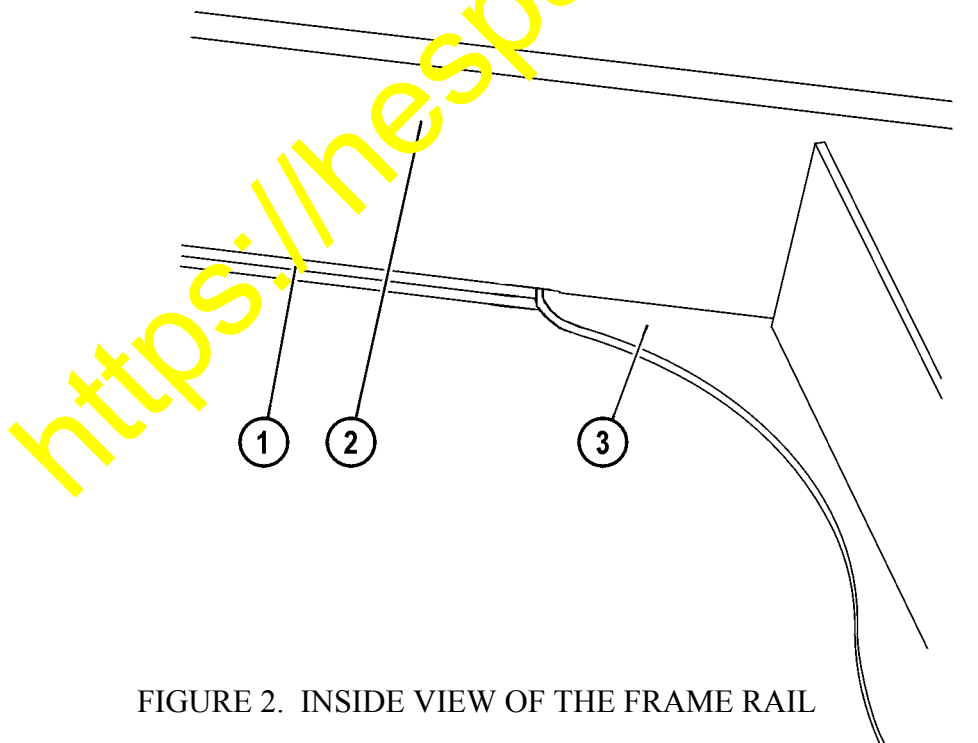
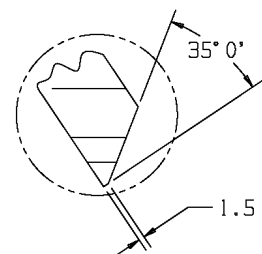
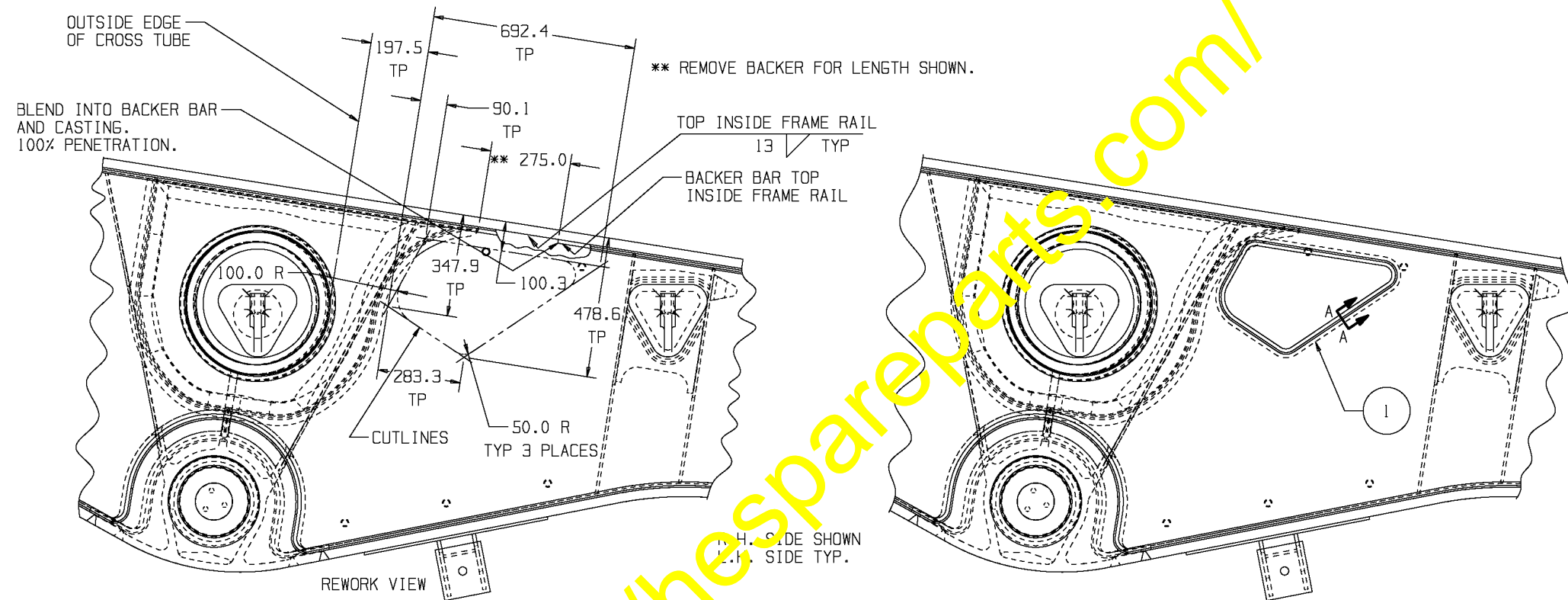


FIGURE 2. INSIDE VIEW OF THE FRAME RAIL

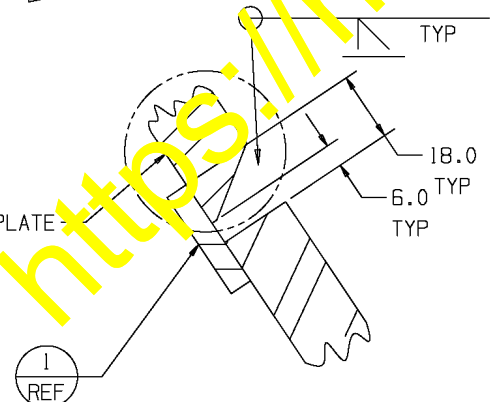
1. Corner Joint Backer Bar
2. Top Rail Bar
3. Casting

- REWORK PROCEDURE
1. CUT ACCESS HOLES IN FRAME RAIL PLATE AS SHOWN IN THE R.H. & L.H. OUTSIDE PLATES. RETAIN ACCESS PLATES FOR REINSTALLATION LATER.
 2. REMOVE BACKER BAR AS NOTED ON THE TOP INSIDE FRAME RAIL.
 3. REWELD TOP INSIDE FRAME RAIL AS NOTED.
 4. PREPARE ACCESS PLATES FOR REINSTALLATION BY BEVELING ALL EDGES AS SHOWN IN "ACCESS PLATE BEVEL DETAIL".
 5. INSTALL ACCESS PLATE AS SHOWN IN SECTION A-A. GRIND ACCESS PLATE WELDS AND PAINT.

ITEM NO	QTY	PART NO	DESCRIPTION
1	2	EK7315	BACKER



ACCESS PLATE BEVEL DETAIL
SCALE 1:1
TYP ALL EDGES OF
ACCESS PLATE
SEE SECTION A-A



SECTION A-A
SCALE 1:1

NOTE:
BACKERS MUST BE TACK WELDED IN A LOCATION WHERE THE TACK WILL BE BURNED AWAY ON THE NEXT WELD PASS UNLESS OTHERWISE SPECIFIED.

ALL BACKERS MUST BE WELDED FOR COMPLETE PENETRATION SO A CONTINUOUS BAR IS FORMED.

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FIGURE 3. FRAME RAIL CASTING REWORK DRAWING (EK7314)