

# PARTS & SERVICE NEWS

REF NO.	AA03041
DATE	March 17, 2003

**SUBJECT:** REINFORCEMENT PROCEDURE FOR AXLE HOUSING CRACKS

**PURPOSE:** To inform the field of a reinforcement procedure for axle housing cracks.

**APPLICATION:** Komatsu Mechanical Drive Dump Trucks:  
 530M: 32628, A30001 - A30038;  
 HD1500: A30039 - A30069

**FAILURE CODE:** 2B11HC

**DESCRIPTION:** Reinforcement procedure for circumferential cracking between the suspension and lower trailing arm brackets.

Some trucks in the field may experience cracks in the rear axle housing. The circumferential cracks typically appear between the suspension and lower trailing arm brackets. It is important to include an inspection of the axle housing at regular intervals.

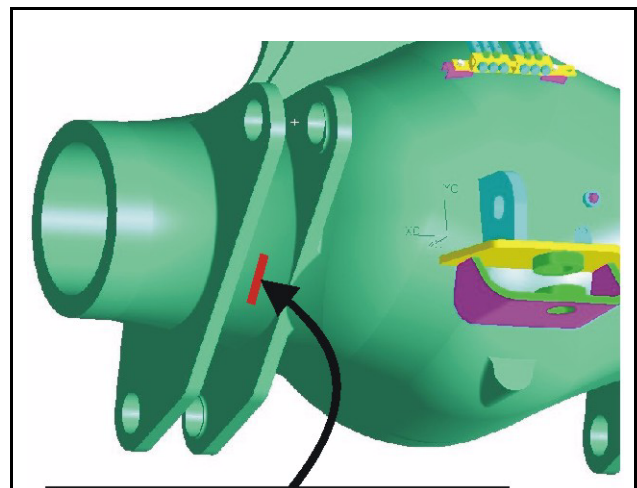
Figure 1 illustrates the typical failure location in the axle housing. If cracks exist, gouge out defects and weld repair as described in Parts & Service News AA02175A.

**▲ IMPORTANT ▲**

*Repair of axle housing cracks must be completed before reinforcements are made.*

*NOTE: The axle housing will be reinforced in production beginning with truck serial number A30070.*

Part Numbers:	562-22-33110 562-22-A3110
Part Description:	Axle Housing
Material Type:	Steel Casting
Preheat Temperature:	150°C (302°F)
Postheat Temperature:	Not Required
Postheat Time:	Not Required
Interpass Temperature (Minimum / Maximum):	150°C / 204°C (302°F / 400°F)
Filler Metal Classification:	GMAW-MIG - ER70-S6 / SMAW- E7016



**Potential Crack Area**

70842

FIGURE 1. AXLE HOUSING

**Axle Casting Reinforcement Procedure:**

After all cracks are repaired, reinforce the axle casting by welding additional plates to the casting as shown in Rework Drawing (EK3792). Refer to Figure 6.

Parts required to reinforce the axle housing are listed in the table below. Reinforcement parts are to be made locally from plate material (ASTM A36).

*NOTE: Prior to installation, Bars (EK3797) are to be temporarily tack welded between the suspension mounting ears in order to control distortion. Refer to Figure 5.*

AXLE HOUSING REQUIRED REINFORCEMENT PARTS		
Quantity	Part Number	Description
1	EK3792	Rework Drawing
1	562-22-33960	Plate
1	562-22-33970	Plate
2	562-22-33980	Plate
2	EK3797	Bar

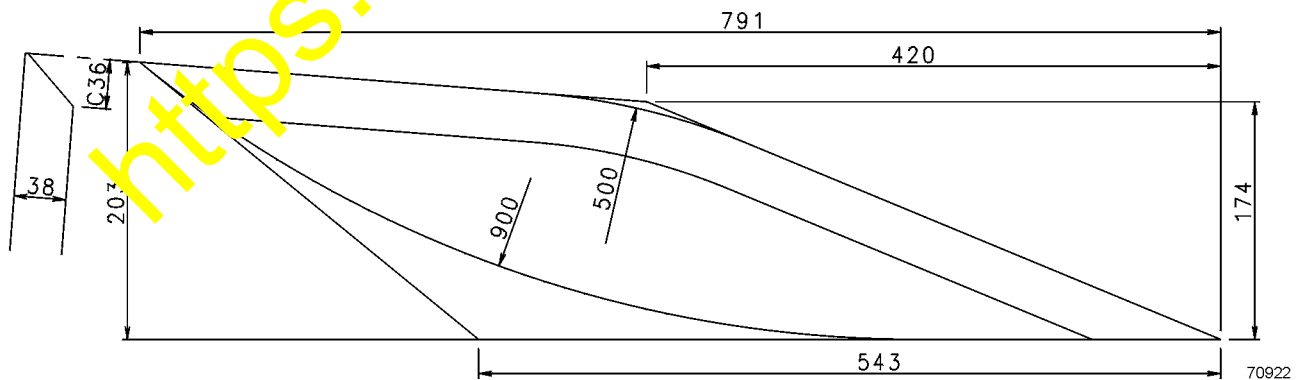


FIGURE 2. REINFORCEMENT PLATE L.H.(562-22-33960)

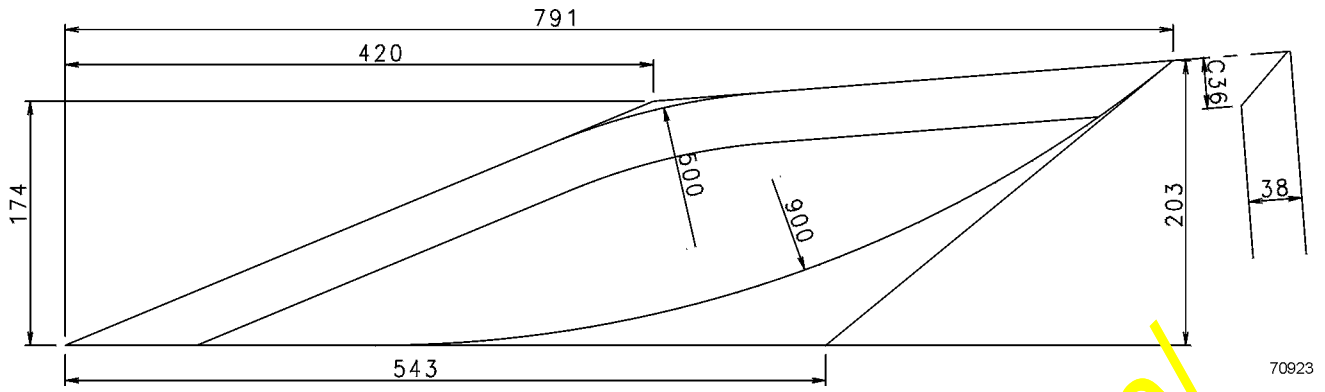


FIGURE 3. REINFORCEMENT PLATE R.H.(562-22-33970)

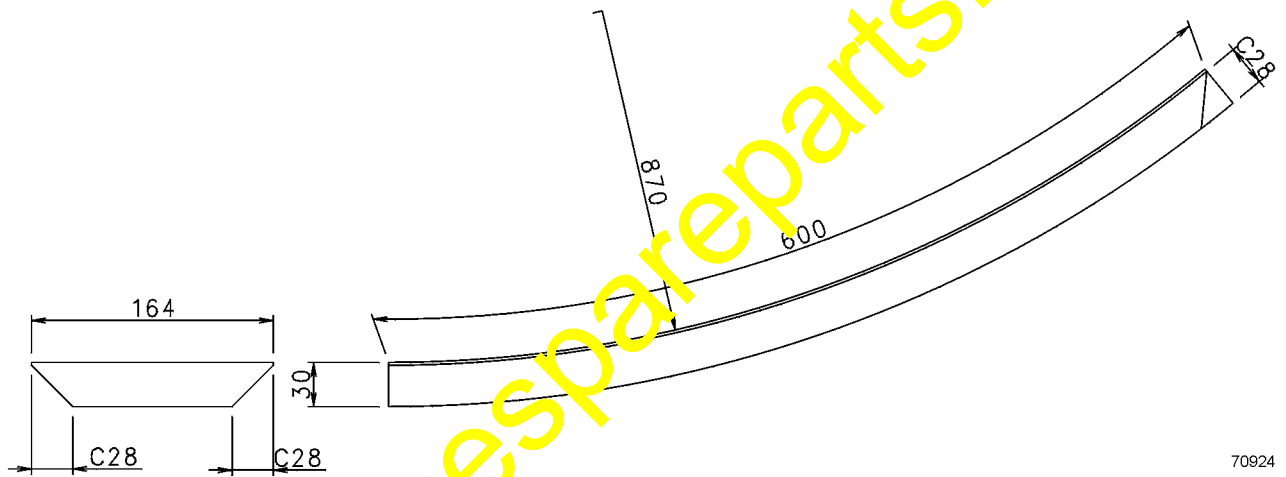


FIGURE 4. REINFORCEMENT PLATE L.H. and R.H. (562-22-33980)

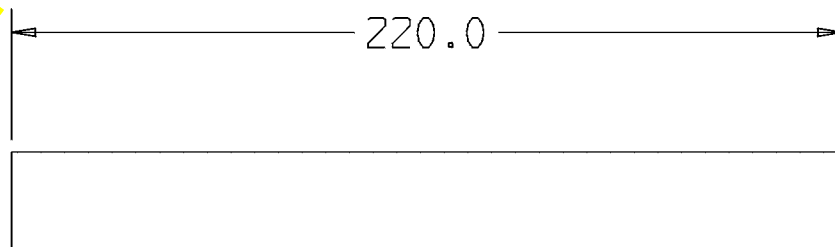
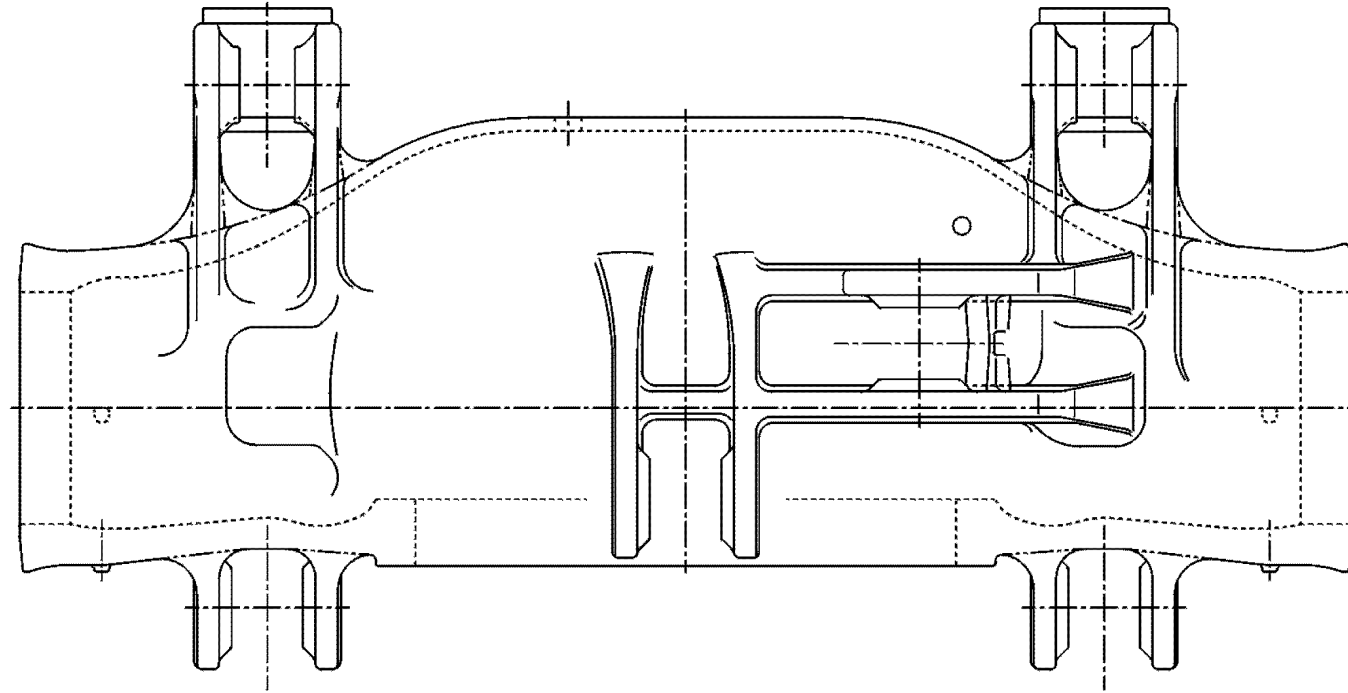
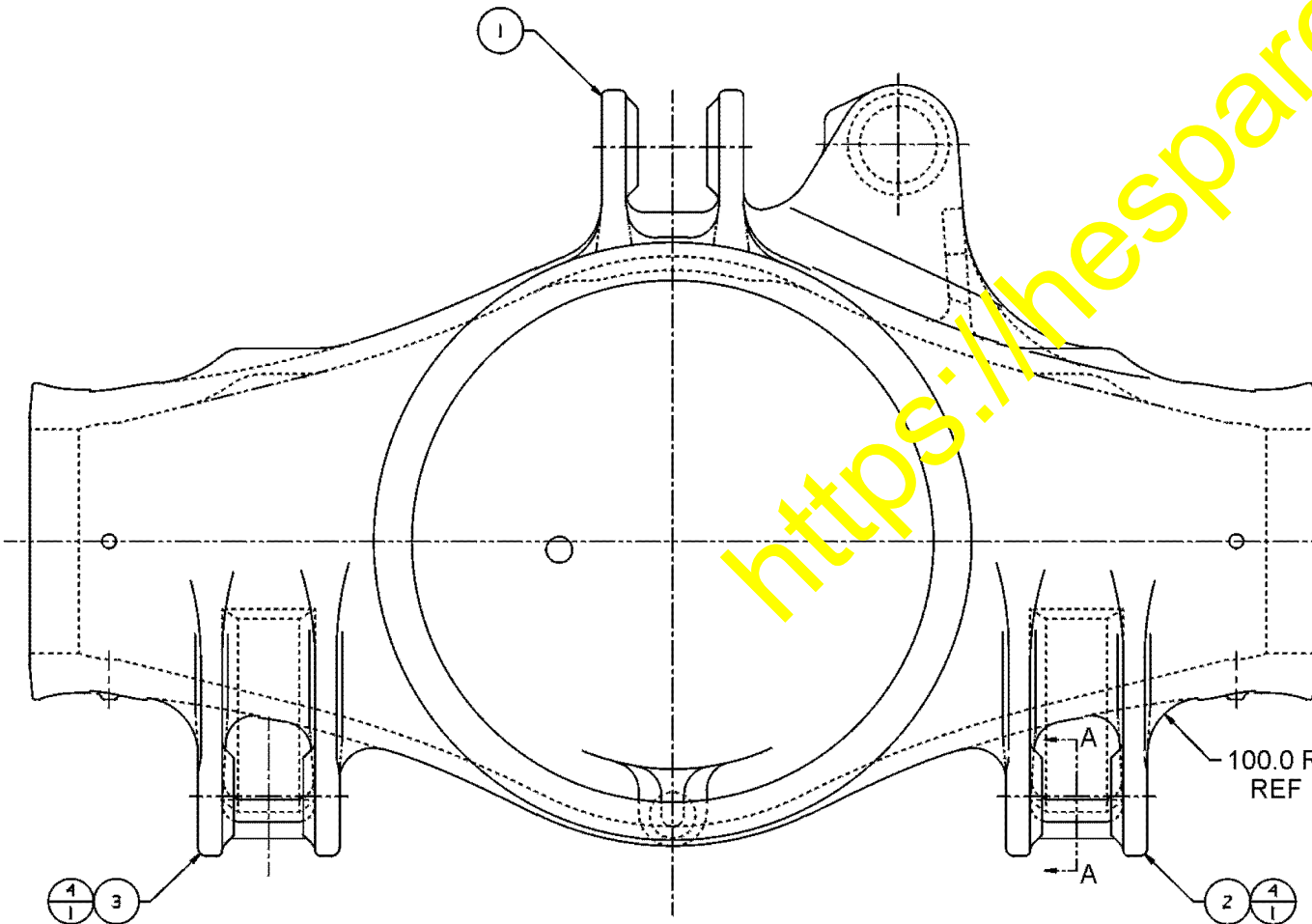
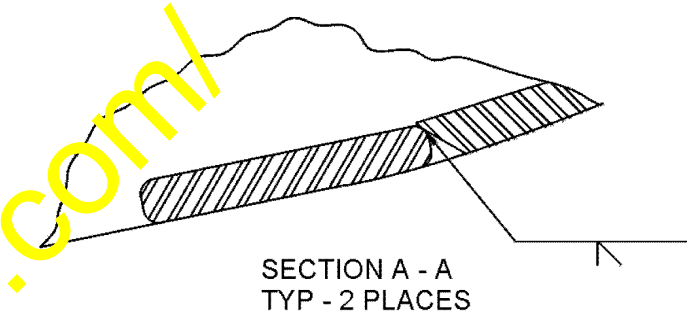


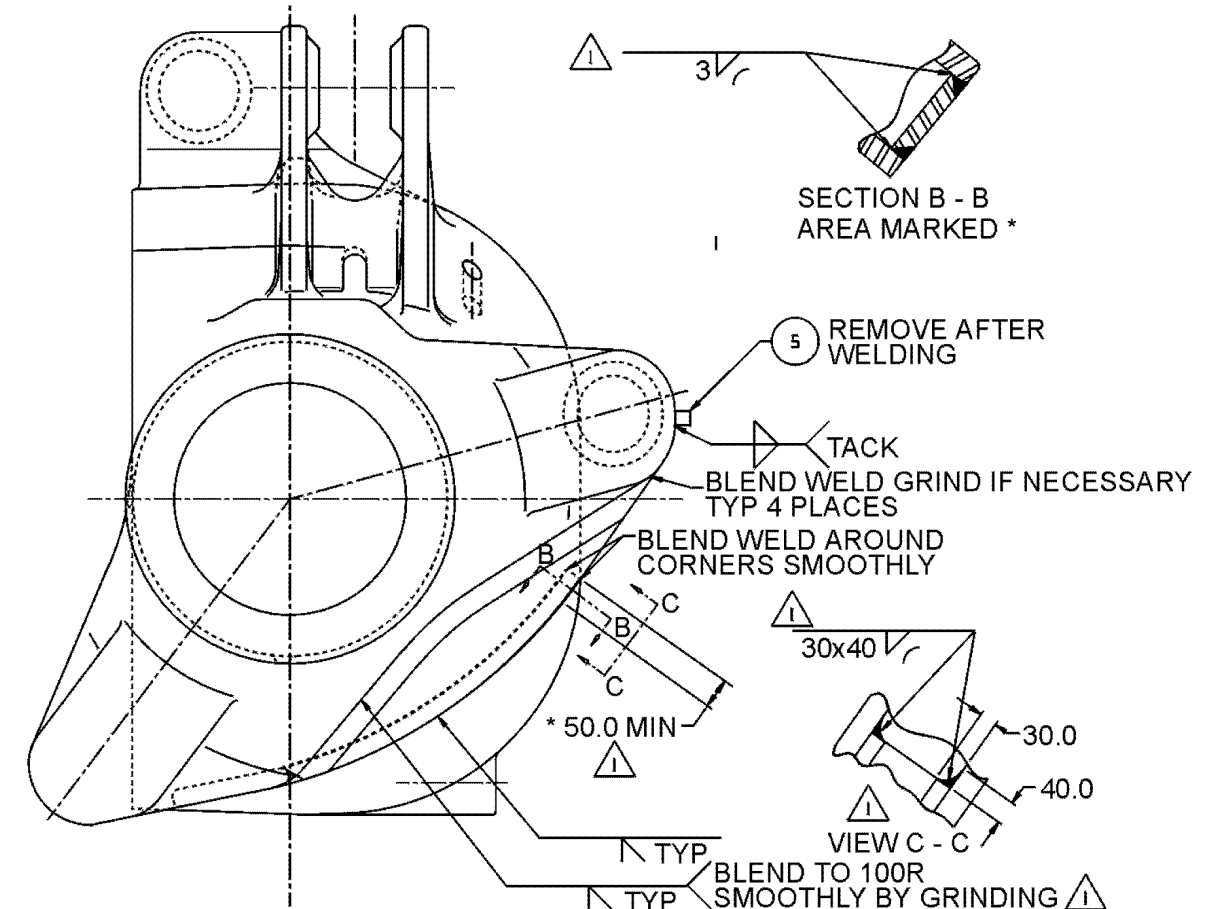
FIGURE 5. TEMPORARY BAR (EK3797)



ITEM	QTY	PART NO	DESCRIPTION
1	1	562-22-A3110	HOUSING
2	1	562-22-33960	PLATE
3	1	562-22-33970	PLATE
4	2	562-22-33980	PLATE
5	2	EK3797	BAR



AXLE TUBES NOT SHOWN



TYP BOTH SIDES

70921

FIGURE 6. AXLE HOUSING REWORK DRAWING (EK3792)