

# PARTS & SERVICE NEWS

REF NO.	AA03059
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**SUBJECT:** REAR AXLE WELD CRACKS AT SUSPENSION MOUNTS & REINFORCEMENT PLATE

**PURPOSE:** To inform the field of repair instructions for weld cracks found in upper area of suspension mounts and around the bottom of axle housing access hole reinforcement plate.

**APPLICATION:** Komatsu Electric Drive Dump Trucks:  
930E: 32604 - 32816, A30019, A30026 and up;  
930E-2: A30012, A30098, A30100, A30121 and up

**FAILURE CODE:** 4765HB

## DESCRIPTION:

Some trucks in the field may experience weld cracks in the upper area of suspension mounts and around the bottom of axle housing access hole reinforcement plate. Carefully inspect each area for cracking at the welded joints. If cracks are found, follow the procedure outlined below to properly repair the cracks.

## REPAIR PROCEDURE:

1. Repair any weld cracks at the suspension mounts and reinforcement plates. Follow the guidelines that are outlined in Parts & Service News "FIELD WELDING FOR ASSEMBLY OR REPAIR" (AA00046B).
2. **Suspension Mounts** - Add 25 mm fillet weld around upper part of suspension mount as shown in Figure 1, Section A-A. The weld must have a smooth profile and the toe must have a good transition to the parent material before peening is performed. Grinding the weld face and toe area is permitted to correct unacceptable conditions.
3. Visually inspect the weld before peening.
4. Peen the toe of the 25 mm fillet weld per Parts & Service News (AA00046B, Annex B 1.0).
5. Visual inspection / acceptance is to be completed after peening per Parts & Service News (AA00046B, Annex B 1.0).
6. **Reinforcement Plates** - Grind the toe of the weld in the area shown in Figure 1, Section B-B per Parts & Service News (AA00046B, Annex B 2.0).
7. Visual inspection / acceptance is to be completed after grinding per Parts & Service News (AA00046B, Annex B 2.0).

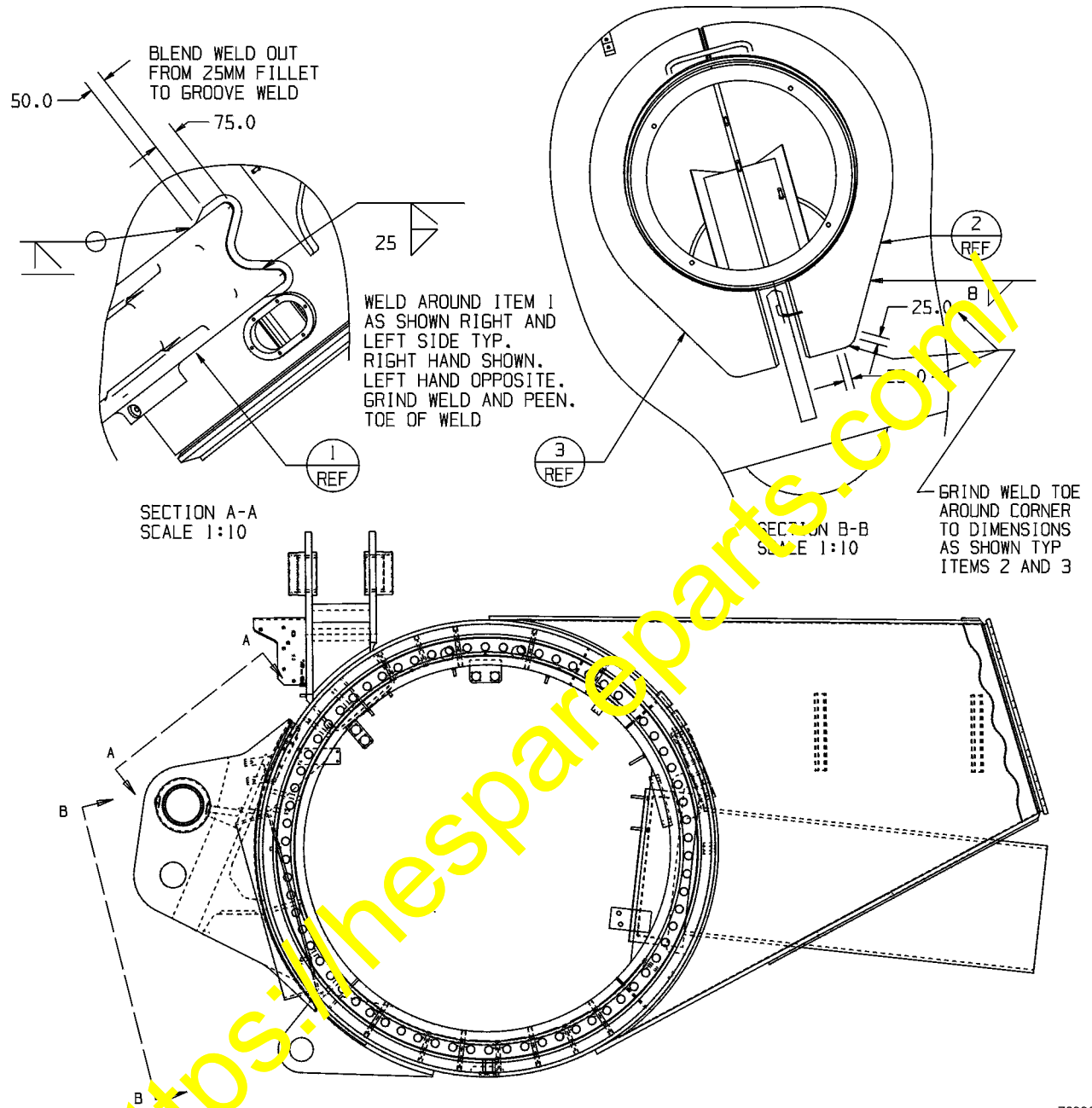


FIGURE 1. WELD CRACK REPAIR

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- 1. Suspension Mount Ears
- 2. Access Hole Reinforcement Plate RH
- 3. Access Hole Reinforcement Plate LH