

PARTS & SERVICE NEWS

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(C)

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SUBJECT: REPAIR PROCEDURE OF BOSS OF STEERING CYLINDER

PURPOSE: To introduce modification procedure to prevent early stage abrasion of the steering cylinder mounting box

APPLICATION: WA600-3 Wheel Loaders, S/N 50001 and up
WA600-3A Wheel Loaders, S/N 50001 and up
WA600-3D Wheel Loaders, S/N 50001 and up
WA600-3L Wheel Loaders, S/N A52001 and up
WA600-3LK Wheel Loaders, S/N A53001 and up

FAILURE CODE: H1XRCA

DESCRIPTION:

1. Introduction:

When wheel loaders are being used on a work site handling objects containing coarse particles including large quantity of components causing abrasion, like quartz sand, alumina, etc., the steering cylinder pin hole on the frame can wear prematurely. Install the sealing parts following the modification procedure being described in this **Parts & Service News** to prevent entry of coarse particles into the pin hole section.

2. Body of part:

Part No.	Part Name	Qty.	Remarks
141-30-00630 (141-30-36290)	O-ring (O-ring)	1 (2)	The Part Number of the O-ring is a set of 2 pieces The Part Number of the O-ring as a single part
419-70-11430	Shim	2	

3. Modification procedure

- (1) When the pin hole is worn, apply build-up welding and carry out boring once again. Regarding the boring dimensions, refer to Fig. 1 or refer to the Shop Manual. As the welding rod, use a low hydrogen type 50 kg/mm, Class 2 welding rod.

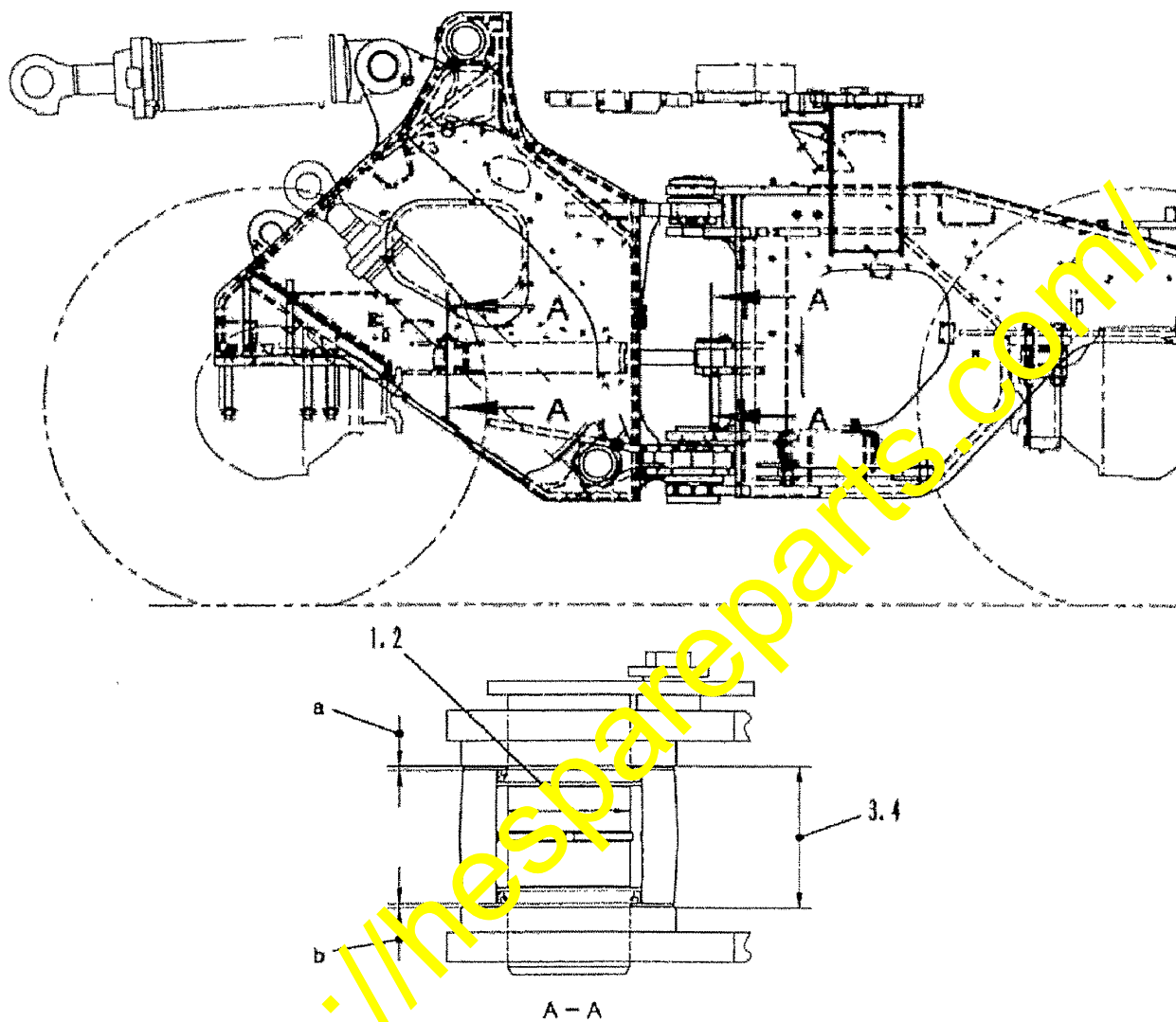


Fig. 1

No.	Item	Judgment standard				
		Basic dimension	Tolerance		Standard clarions	Allowable clearance
Shaft	Hole					
1	Clearance between the bushing and the mounting pin at the connecting section between the steerage cylinder rod and the frame	75	-0.030 -0.076	+0.350 +0.250	0.280 - 0.426	1.0
2	Clearance between the bushing and the mounting pin at the connecting section between the steerage cylinder bottom and the frame	75	-0.030 -0.076	+0.350 +0.250	0.280 - 0.426	1.0
3	The connecting section between the steerage cylinder and the front frame	Width of the boss		Width of the hinge	Standard clearance (clearance a + b)	
		85 ⁰ _{-0.5}		90.5±1.2	0.5 or less (After carrying out the shim adjustment)	
4	The connecting section between the steerage cylinder and the rear frame	85 ⁰ _{-0.5}		90.5±1.2	0.5 or less (After carrying out the shim adjustment)	

- (2) Install the sealing parts (O-ring and spacer) between the pin and the hinge plate. Referring to Fig. 2, carry out the shim adjustment to adjust the thrust clearance between the cylinder and the hinge.

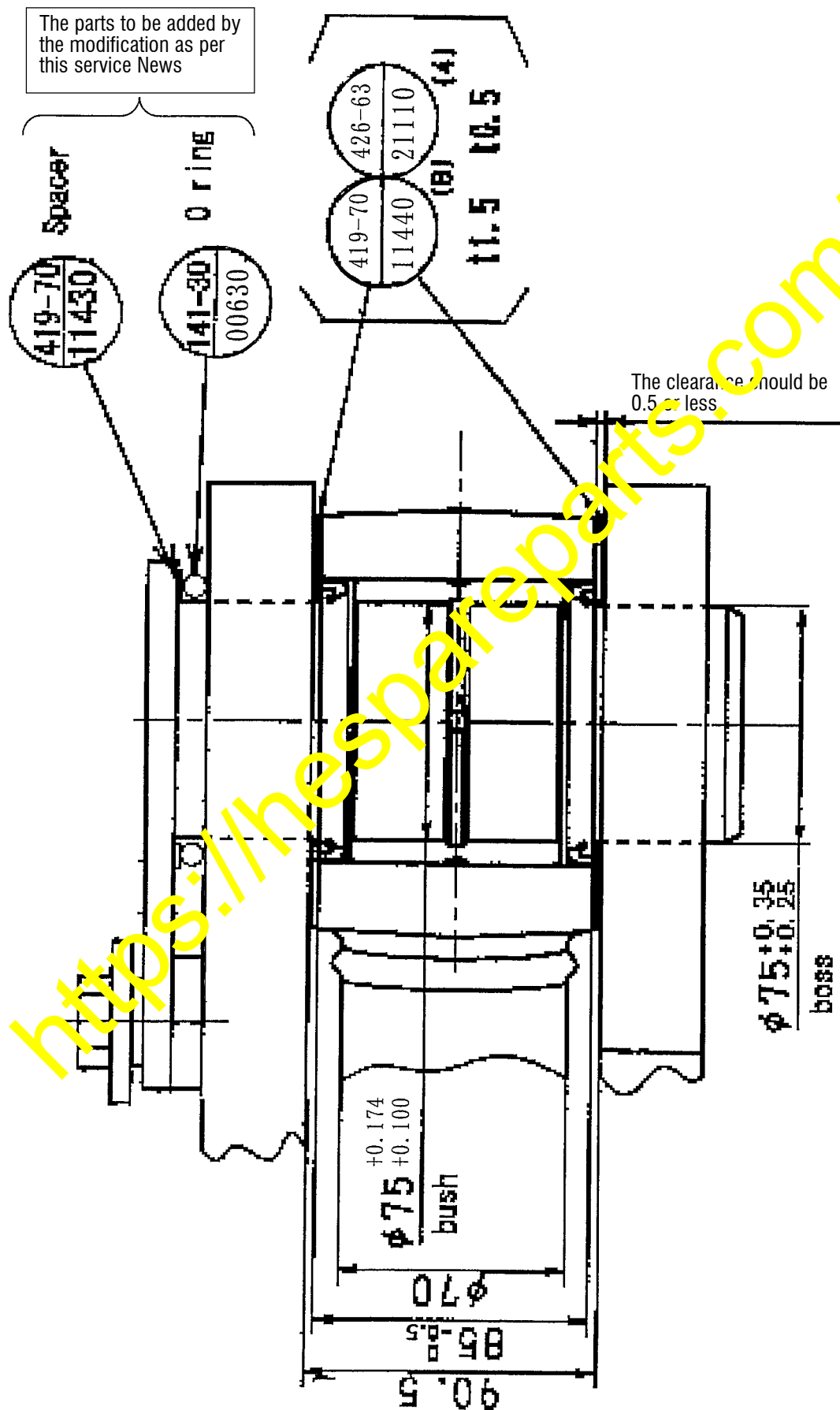


Fig. 2