

PARTS & SERVICE NEWS

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DATE

Page 1 of 3

(C)

SUBJECT: ENGINE SUBFRAME CRACKS

PURPOSE: To inform the field of a reinforcement procedure for strengthening the engine subframe.

APPLICATION: Komatsu Electric Drive Dump Trucks:
 930E: 32604-32816, A30019, A30026-A30120;
 930E-2: A30012, A30098, A30100, A30121-A30293, A30295, A30303;
 930E-3: A30294, A30304 & Up

FAILURE CODE: 0110HA

DESCRIPTION: Subframe Structure Reinforcement Procedure

Some trucks in operation may experience cracks in four locations on the engine subframe. Two crack locations are in the welded joints between the front engine mount and the main side rail. The other crack locations are in the weld joints between the rear cross tube and main side rail. A subframe structure reinforcement procedure has been developed to strengthen these areas to prevent cracking from occurring. Refer to Figure 4 for crack locations and details for installation of reinforcement components. Table 1 lists the necessary parts for completing the reinforcement. These parts are to be fabricated locally from ASTM A572 grade steel. Refer to Figures 1 - 3 for fabrication specifications.

TABLE 1. Subframe Structure Reinforcement Components

Part Number	Description	Quantity
EL2575	Gusset	2
EL3309	Gusset	8
EL3310	Plate	4

Before installing the reinforcement components, perform a frame inspection in the specified areas, and repair any cracks that are found. Follow the guidelines that are outlined in Parts and Service News, *Field Welding for Assembly or Repair* (AA00046C), Welding Manual I (SEBF14001), and Welding Manual II (SEBF15002). It is important that these instructions are read, fully understood, and followed.

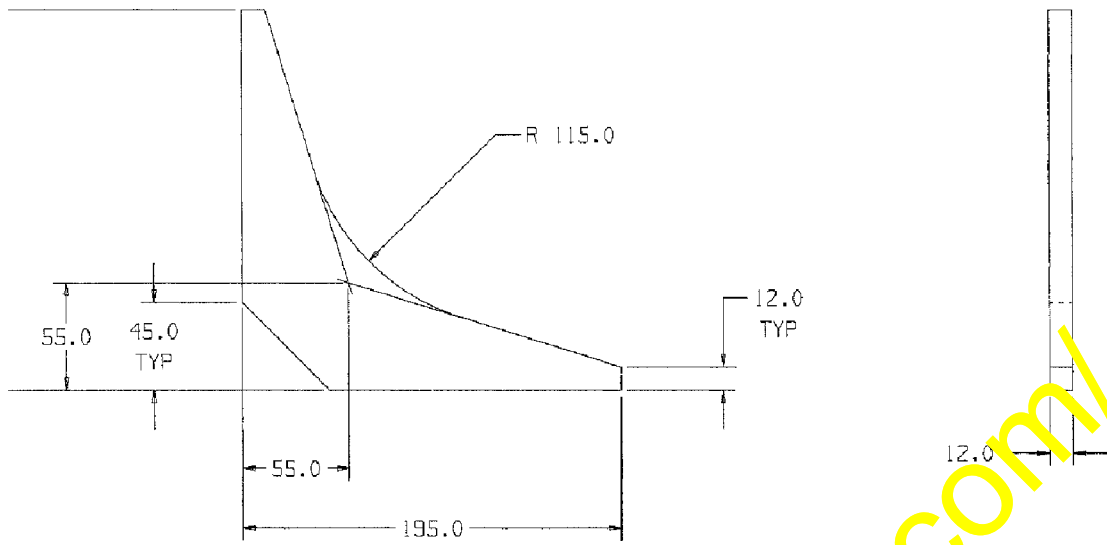


FIGURE 1. GUSSET - EL2575

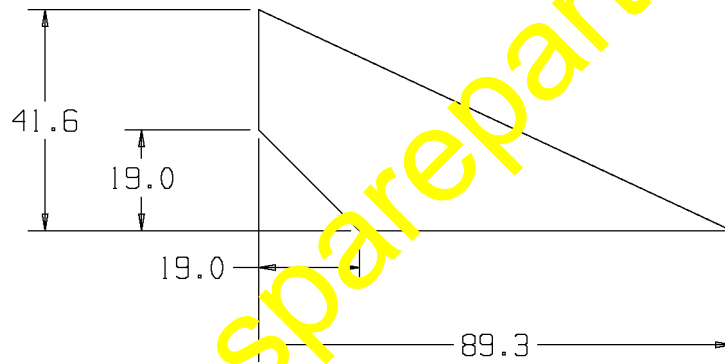


FIGURE 2. GUSSET - EL3309

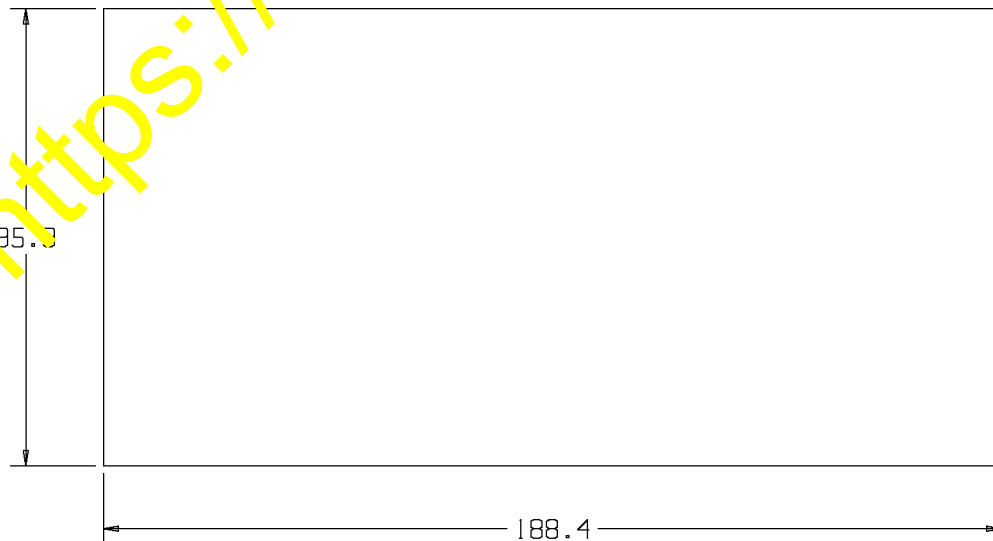


FIGURE 3. PLATE - EL3310

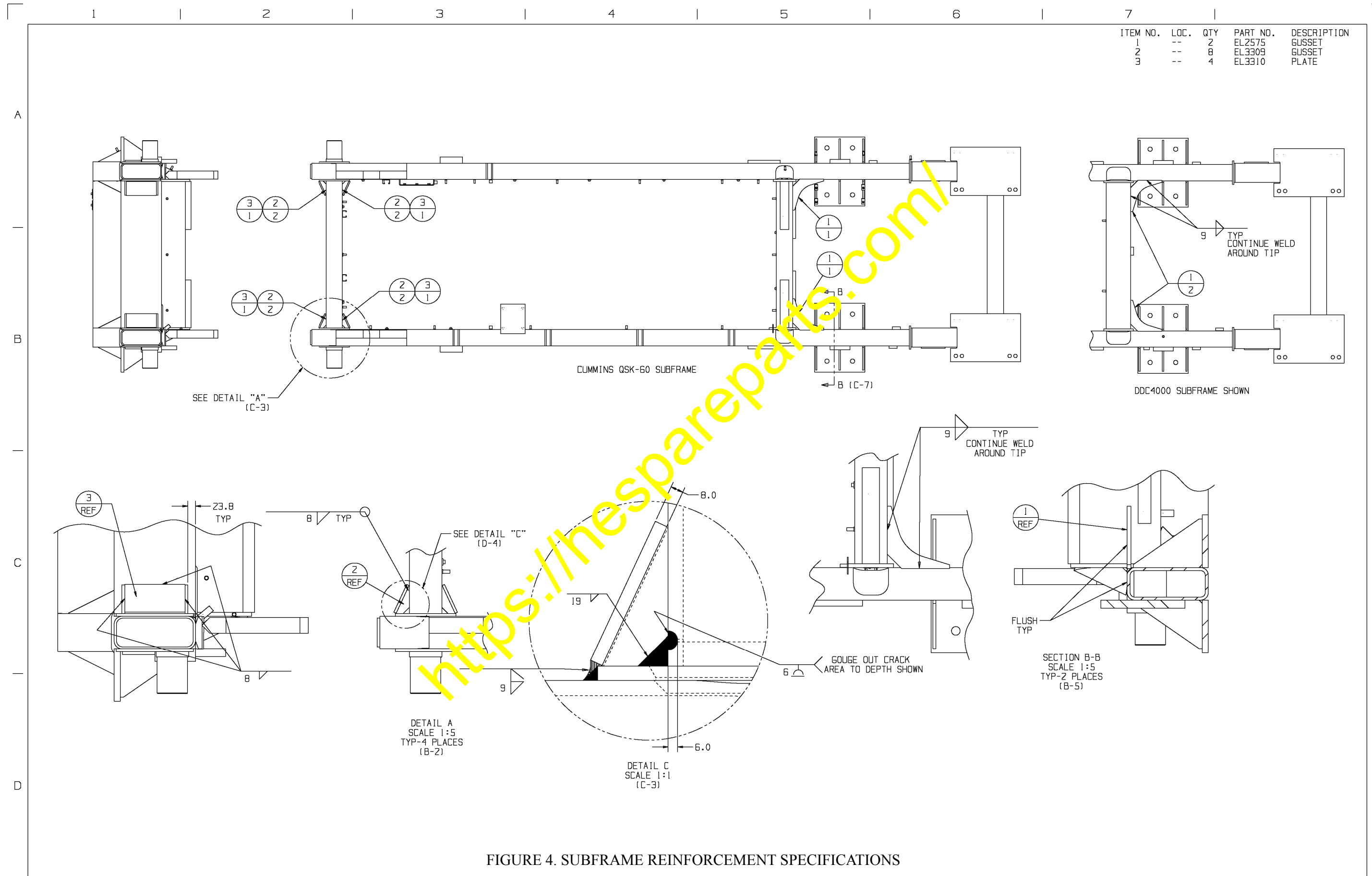


FIGURE 4. SUBFRAME REINFORCEMENT SPECIFICATIONS