

PARTS & SERVICE NEWS

REF NO. AA97040A

DATE June 8, 1999

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This Parts & Service News supercedes AA97040 dated April 29, 1997 and should be discarded.

SUBJECT: CIRCLE DRIVE GEAR CASE OIL LEAKAGE

PURPOSE: To provide instructions to stop the Circle Drive Gear Case from leaking oil on the below listed graders.

APPLICATION: 830 Graders Serial Number 100496 thru 203839
 850 Graders Serial Number 100477 thru 203839
 870 Graders Serial Number 100481 thru 203839
 GD530/AW Graders Serial Number 200840 thru 203839
 GD650/AW Graders Serial Number 200840 thru 203839
 GD670/AW Graders Serial Number 200840 thru 203839

FAILURE CODE: 7C3F10

DESCRIPTION:

Introduction:

This **PARTS & SERVICE NEWS** presents the proper procedure for sealing the Gear Case Cover and Bearing Retainer.

—NOTE—

The information in this **PARTS & SERVICE NEWS** does not authorize or imply any obligation on the part of Komatsu America International Company to provide reimbursement for any expenses. Machines requiring part repair or part replacement during the machine warranty are covered under normal warranty. Out-of-warranty machines are the responsibility of the distributor/customer.

INSTRUCTIONS TO SEAL CIRCLE DRIVE GEAR CASE

1. Remove six bolts and washers (1) from bearing retainer (2).
2. Remove bearing retainer and shims. Use extreme care not to damage shims. These shims will be used in reassembly to preload bearings.
3. Remove six bolts and washers (3) from circle drive case cover (4).
4. Remove cover. Bearing cup will also be removed with cover.

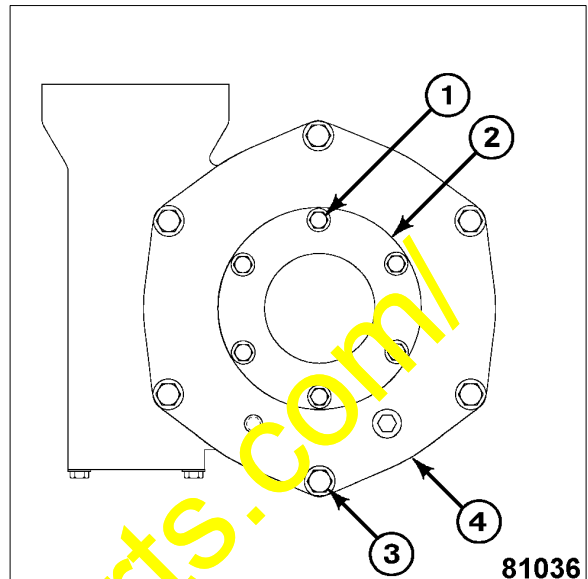


Figure 1

5. Chamfer (.03 inches x 45°) case at (1, Figure 2) and case cover at (2). Protect the inside of the gearcase from foreign material.
6. Thoroughly clean mating surfaces of case and cover with degreasing solvent; apply primer "N" to chamfered case surface (1) and apply .06 bead of Loctite 518 to cover (3) on mating surface between the cover and case.

NOTE: An alternate sealing system is available which replaces the cover (3) with a new cover (1421165H93) and uses an o-ring (26533R1) to seal. The .06 bead of Loctite 518 would not be required.

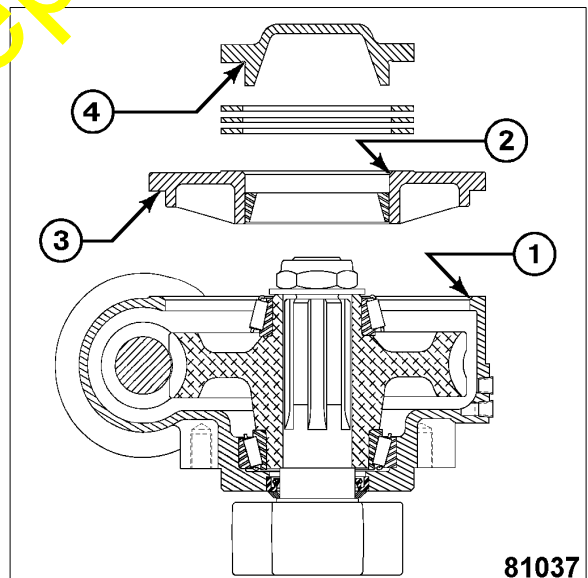


Figure 2

7. Install cover to case, circle bolt holes with Loctite, apply Loctite to threads of two bolts used in through holes at worm pinion (1, Figure 3); install six washers and bolts. Cross tighten bolts to 70 lbf ft 9.7 kg•m).

8. See Shop Manual Section F-01.30 for preload adjustment procedure.
9. After shim pak is determined, thoroughly clean mating surfaces with degreasing solvent; apply primer "N" to chamfered cover surface (2, Figure 2) and apply .06 bead of Loctite 518 to bearing retainer (4) at the root of the radius.
10. Place determined shim pak on bearing retainer, Install bearing retainer and shims to circle drive case cover; circle bolt holes with Loctite, and install six washers and bolts (2, Figure 3). Tighten to 32 lbf ft. (4.4 kg•m).

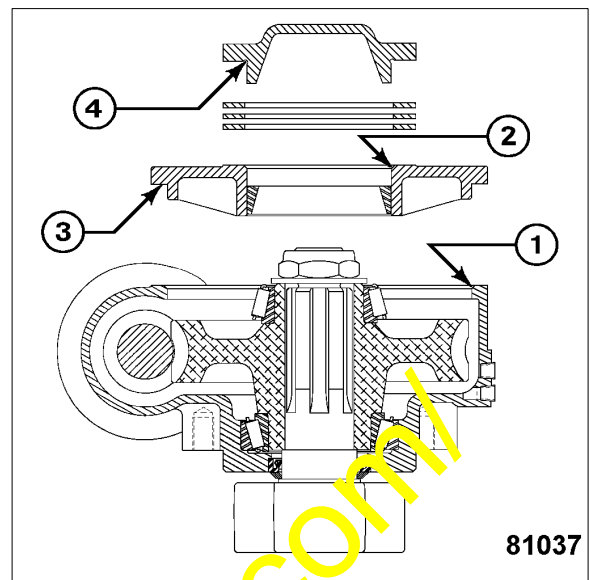


Figure 3

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