

PARTS & SERVICE NEWS

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DATE	Nov. 5, 1999

(C)

SUBJECT: REPAIR PROCEDURE FOR THE MOUNTING PORTION OF BULKHEAD

PURPOSE: To introduce repair procedures for the cracks developing on the mounting portion of bulkhead

APPLICATION: WA600-3 Wheel Loaders, S/N's 50001 thru 50081, 50083 thru 50091, 50093 thru 50099, 50101 thru 50131, 50134 thru 50136, 50139 thru 50140, 50152 thru 50153, 50156 thru 50160
WA600-3L Wheel Loader S/N A52001 thru A52094

FAILURE CODE: 545137

DESCRIPTION:

When the machine is operated under severe conditions such as repetition of heavy digging operation, the cracks may develop on the mounting portion of the bulkhead. When such a failure occurs, repair it by reinforcing the mounting portion by following the procedures outlined in this **PARTS & SERVICE NEWS**.

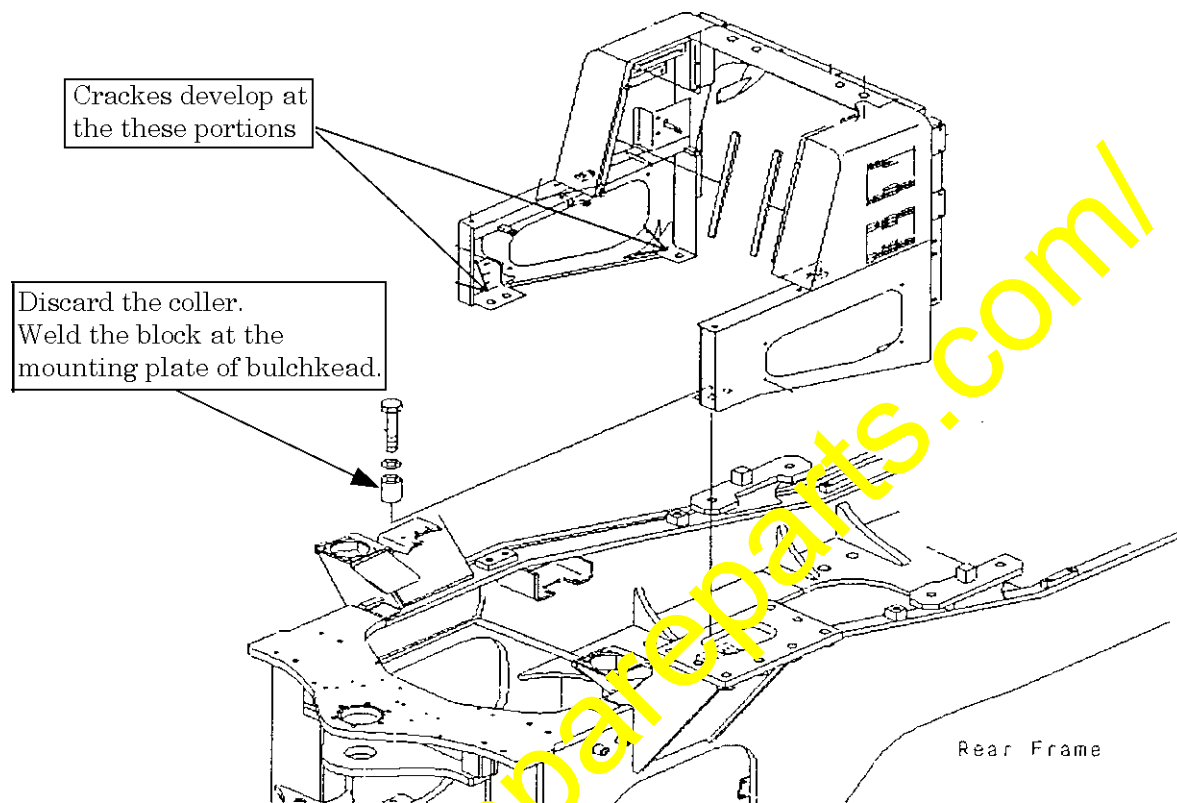
LIST OF PARTS:

Reinforcing members should be fabricated locally, so they are not registered spare parts.

Part No.	Part Name	Purpose of Part	Q'ty	Remarks
1	Block		2	Fabricate locally as per attached drawings
2	Block	Addition	2	
3	Plate		2	
4	Plate		2	
176-70-43220	Collar	Discontinued	6	Collars should be discarded. Use stocker collars for other purposes as KES parts
(176-70-53220)	(Collar)			

3. Improvements

The shape and the thickness of the plates at the bulkhead mounting sections have been changed and the side plate reinforcing plates have been added for reinforcement.



4. Modification procedures

(1) Preparation of parts

Prepare the parts shown on page 4, by local manufacturing.

(2) Rework procedure.

Remove the bulkhead from the frame. (Because it is difficult to rework the rear right hand side of frame.)

Weld the prepared parts (① ④) as specified in rework drawings.

(3) Assembling procedure

Assemble the reinforced bulkhead on the frame.

Collars (176-70-43220 6 pieces) are no longer used in continuation with the addition of blocks.

The bolts and washers are reused.

<Precaution>

- In order to prevent the movement of mounting hole pitch by welding distortion, trak weld the stay. (Refer to Fig-1.)
- Perform touch up painting after reworking.

(4) Reworking drawings

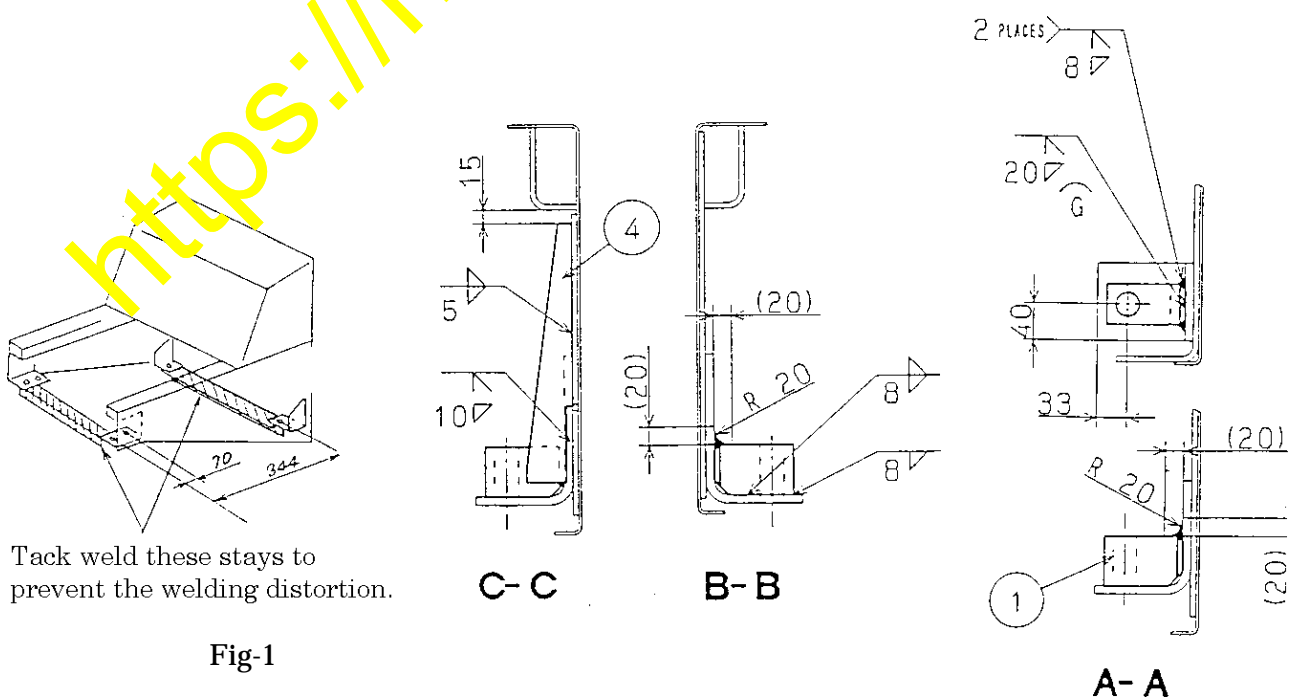
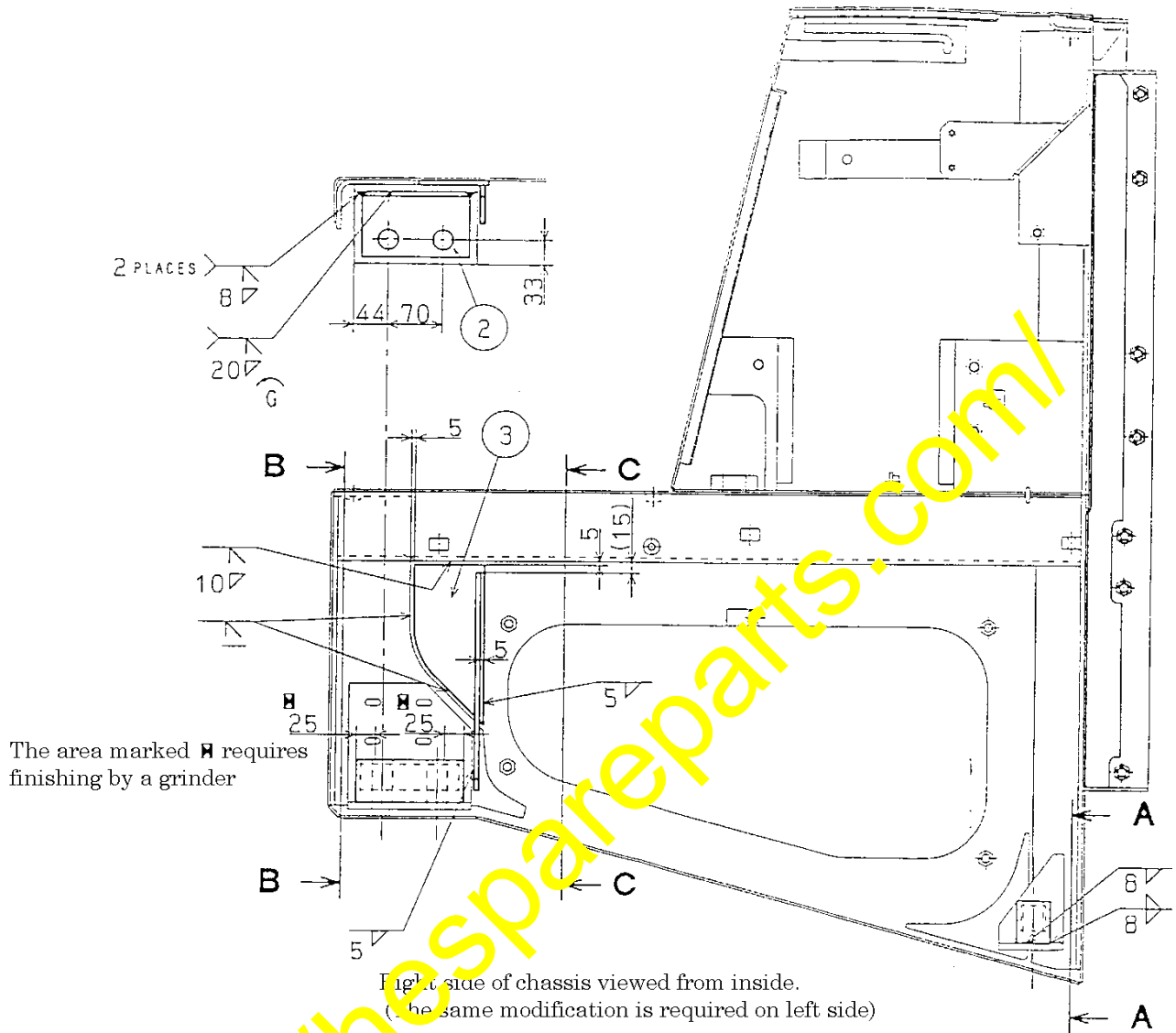
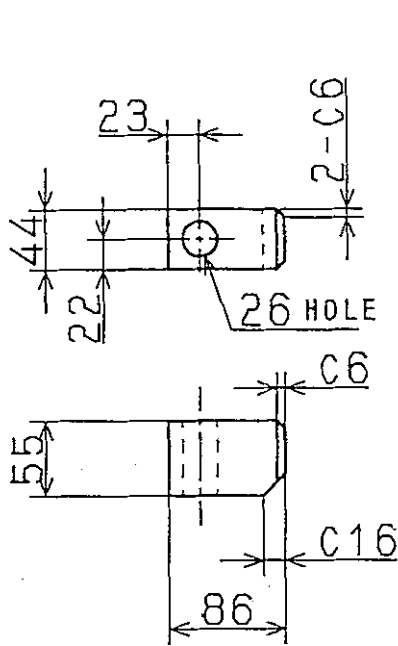
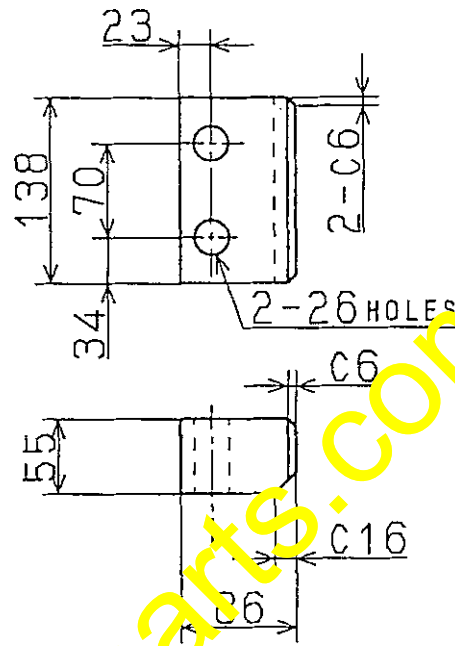


Fig-1

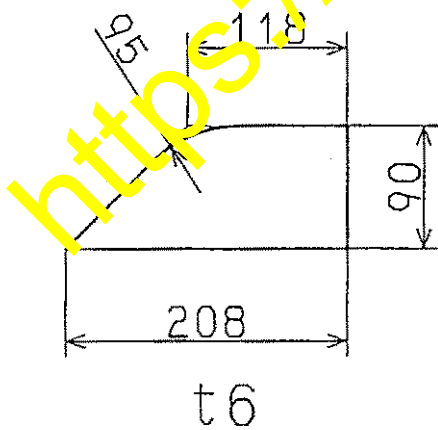
(5) Drawings for local manufacturing



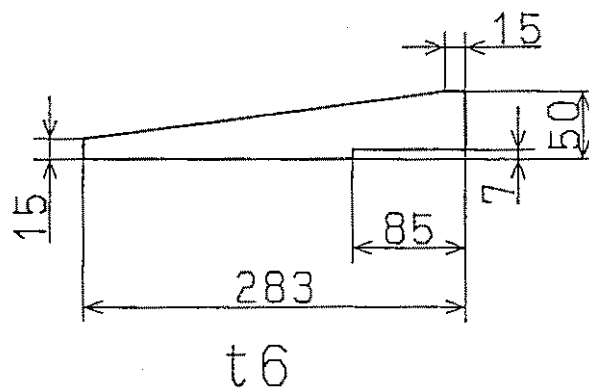
Part No. : ①
 Part name : BLOCK
 Material : SS400P
 Q'ty : 2 pieces / machine



Part No. : ②
 Part name : BLOCK
 Material : SS400P
 Q'ty : 2 pieces / machine



Part No. : ③
 Part name : PLATE
 Material : SS400F
 Q'ty : 2 pieces / machine



Part No. : ④
 Part name : PLATE
 Material : SS400F
 Q'ty : 2 pieces / machine