

PARTS & SERVICE NEWS

REF NO.	AH03514
DATE	June 30, 2003

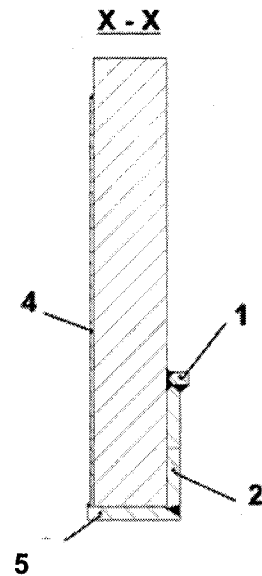
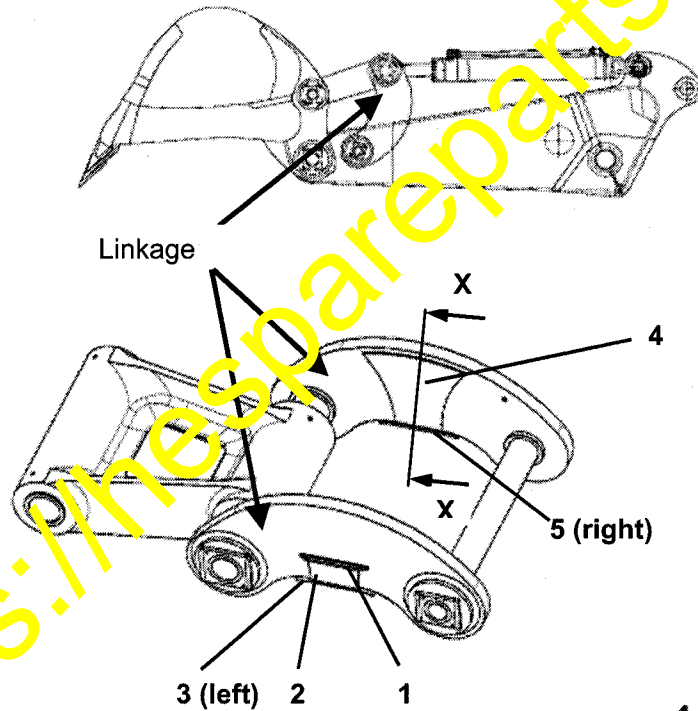
SUBJECT: LINKAGE MODIFICATION (BACKHOE ATTACHMENT)

PURPOSE: Wear reduction at the leakages

APPLICATION: H455S Hydraulic Shovel, S/N 15007
 PC4000 Hydraulic Excavator, S/N 08153
 PC5500 Hydraulic Excavator, S/N 15014 and 15015

FAILURE CODE: 716BCA

DESCRIPTION:



Required parts:

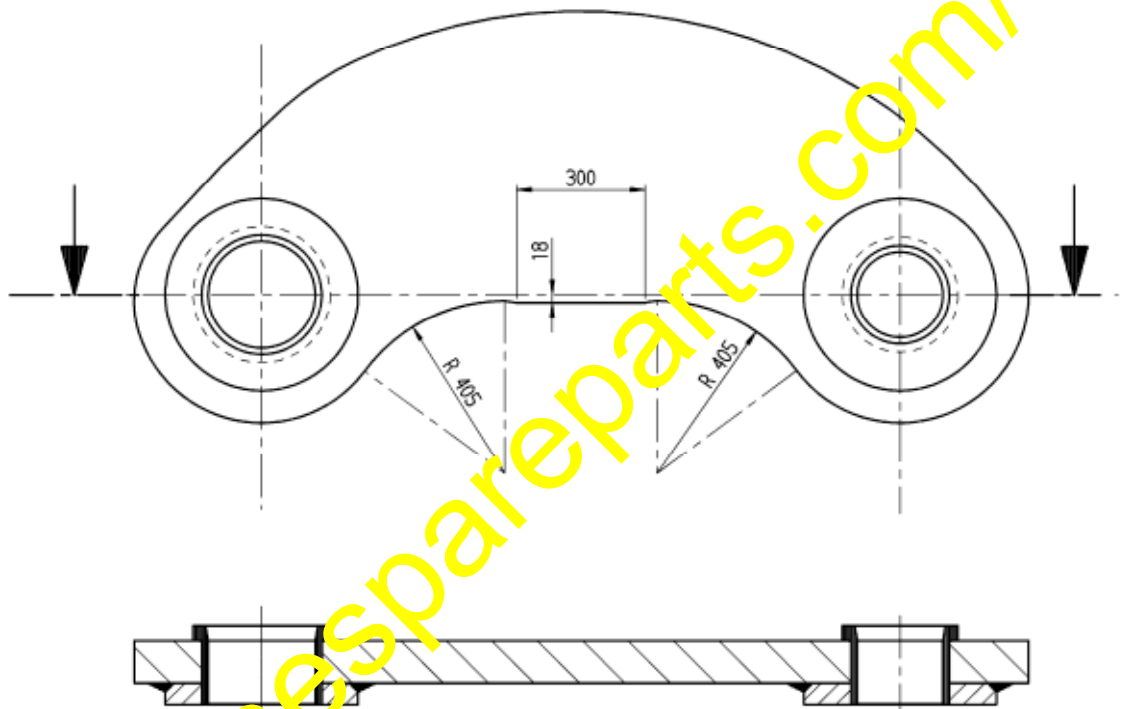
Position	Number	PC4000	PC5500
		Part number	Part number
1	2	924 556 40	924 556 40
2	2	924 553 40	924 553 40
3	1	925 388 40	925 385 40
4	2	924 554 40	925 913 40
5	1	925 549 40	925 551 40
Modification Kit:		925 387 40	925 380 40



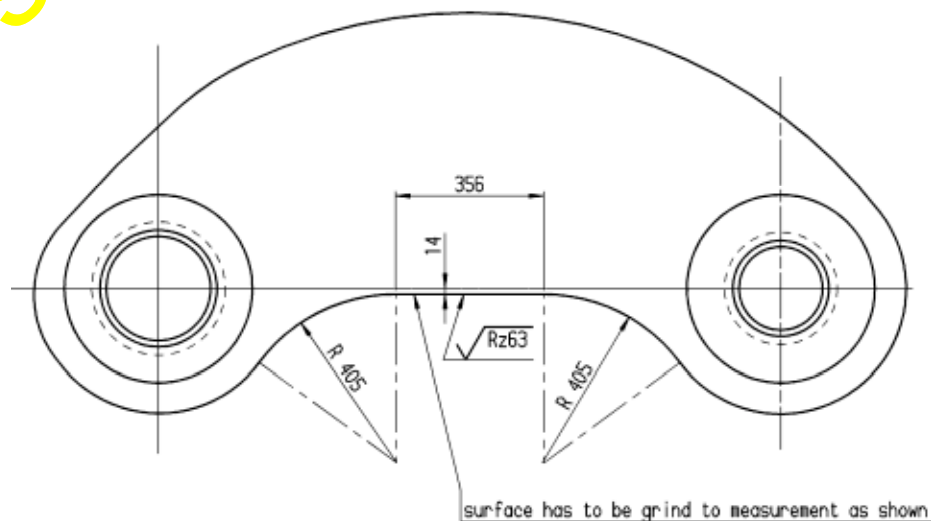
- We recommend to modify the above mentioned Excavators immediately.
- Heed the indications for welding at the last page!

Modification for PC5500:

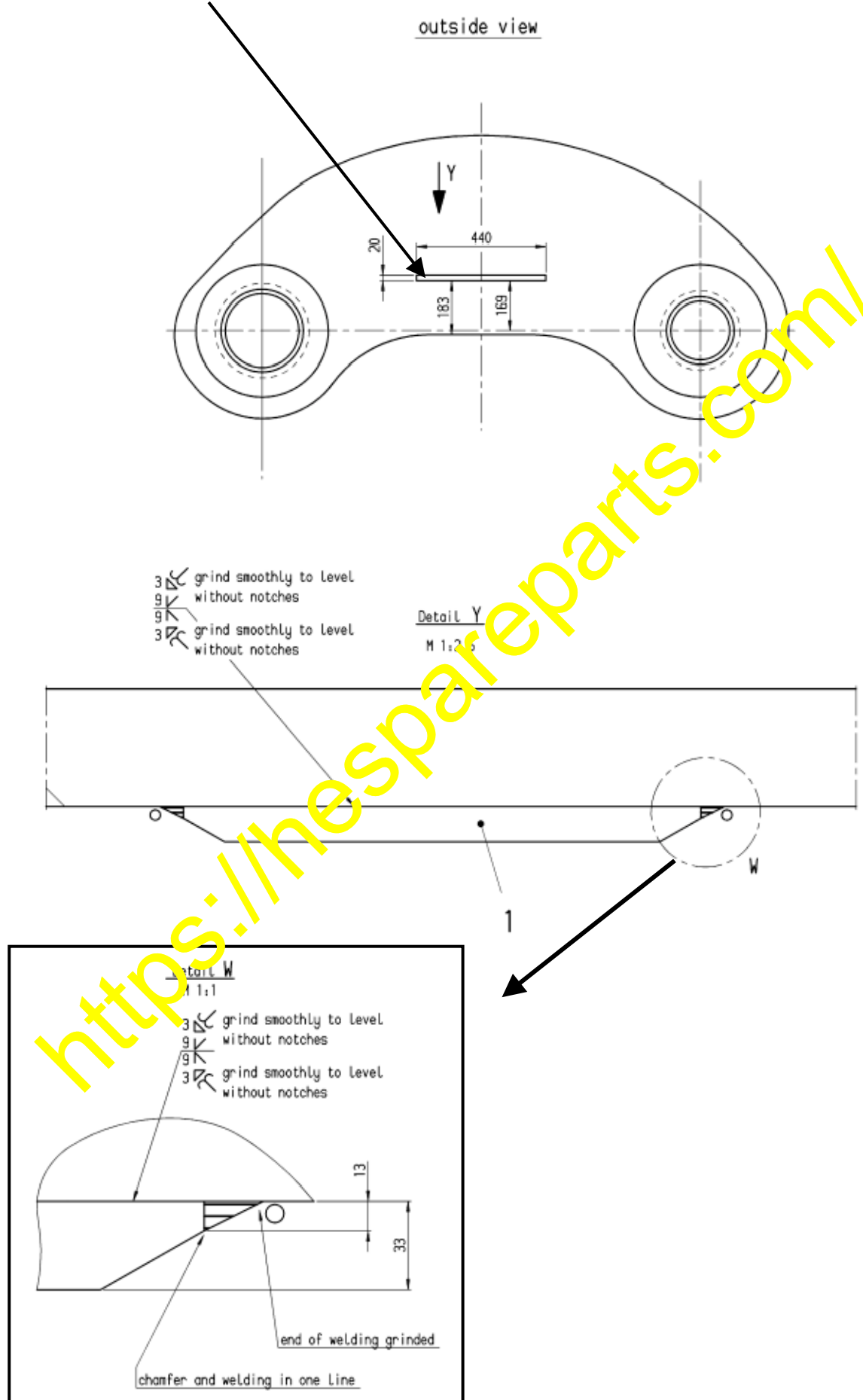
existing linkage



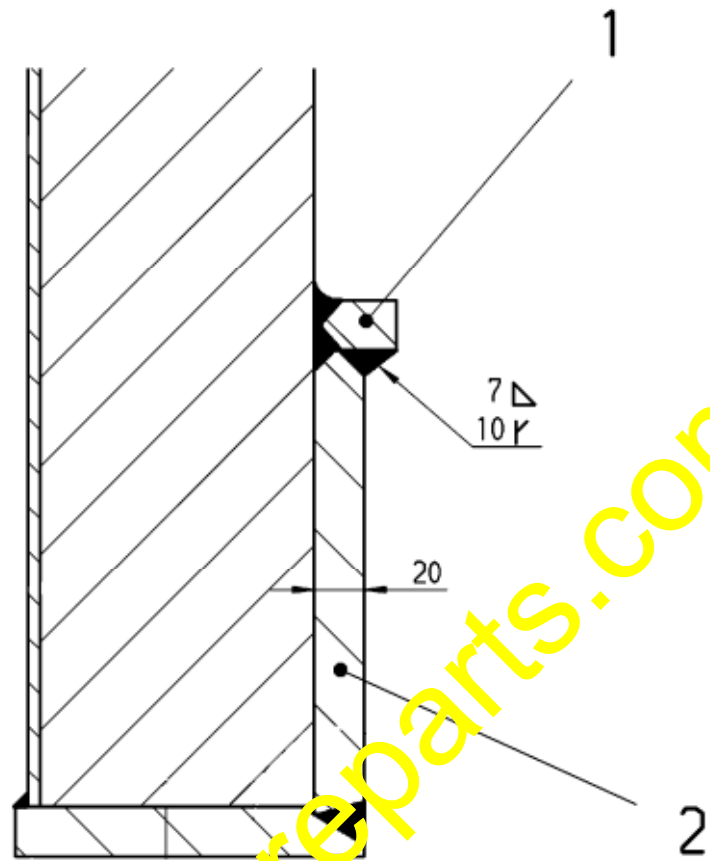
1. Grind the surface to the dimension as shown



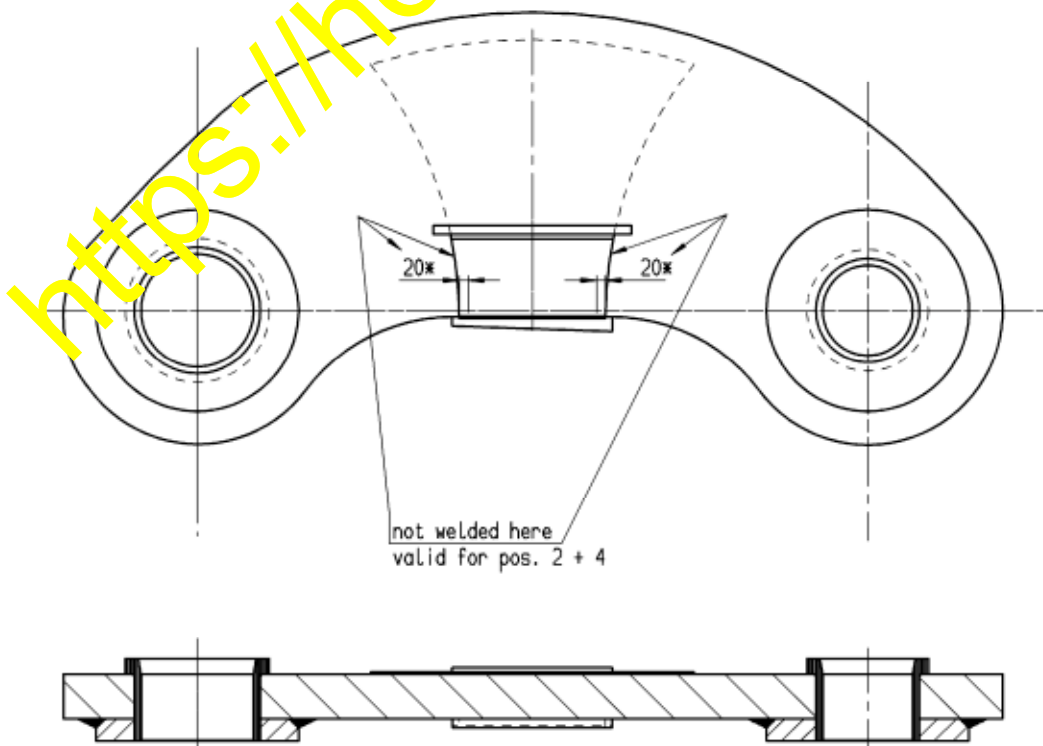
2. Weld on part (1)



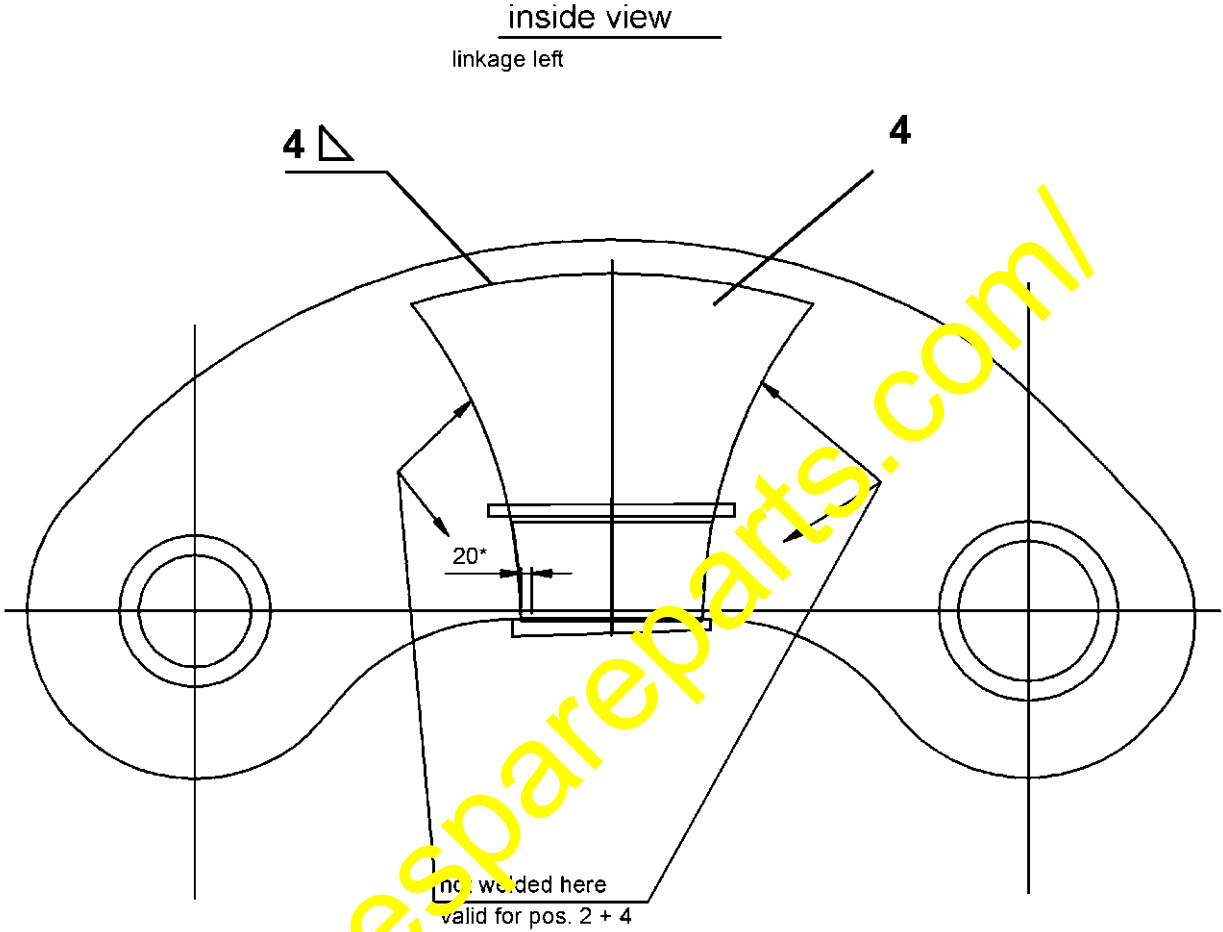
3. Weld part (2) only on part (1)



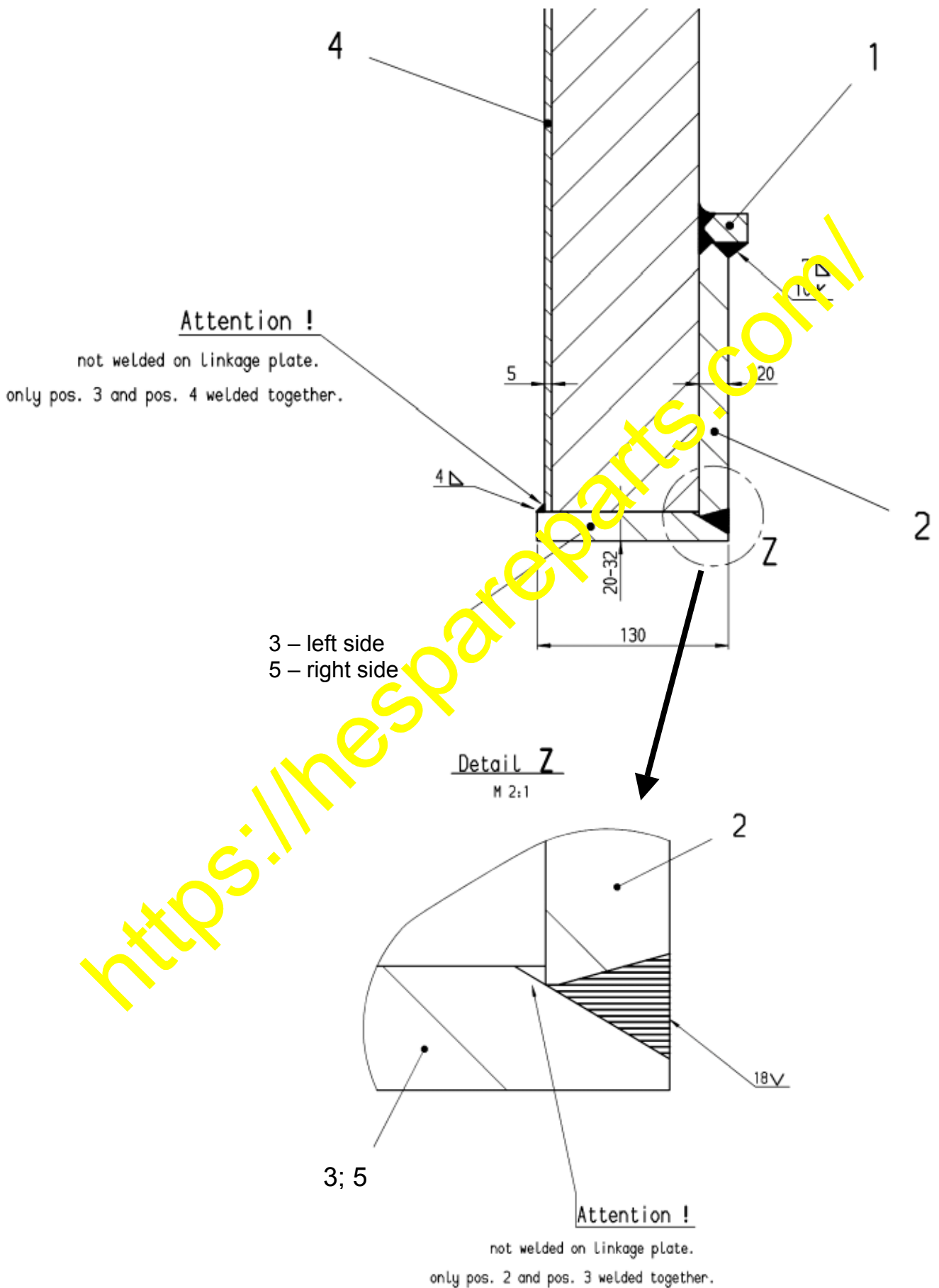
outside view
Linkage Left



4. Weld part (4) on the linkage

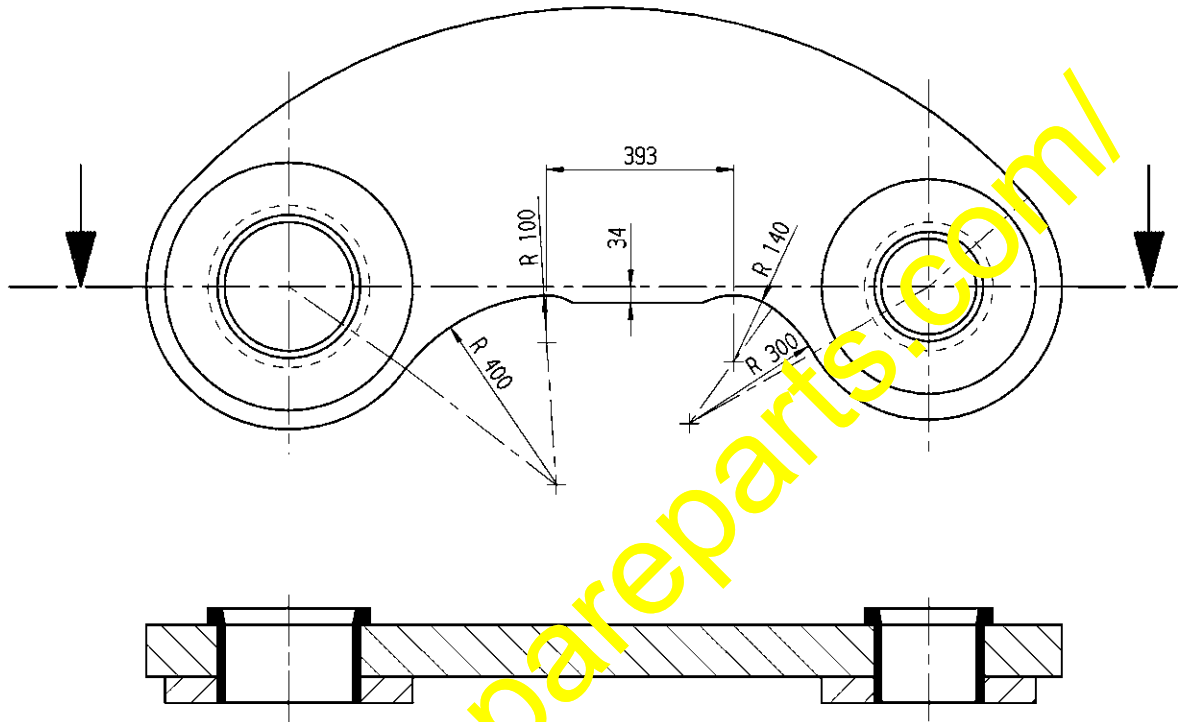


5. Weld parts (3) and (5) only on part (4) and part (2)

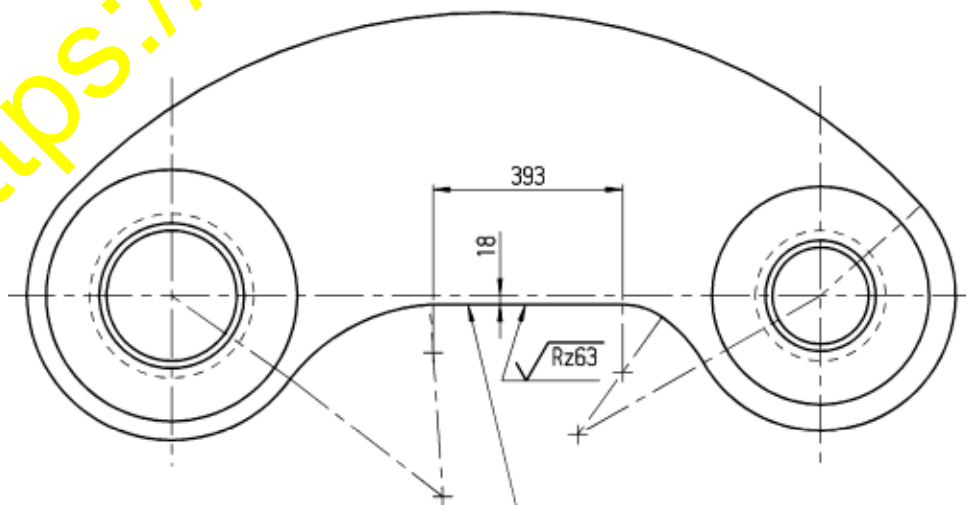


Modification for PC4000

existing linkage

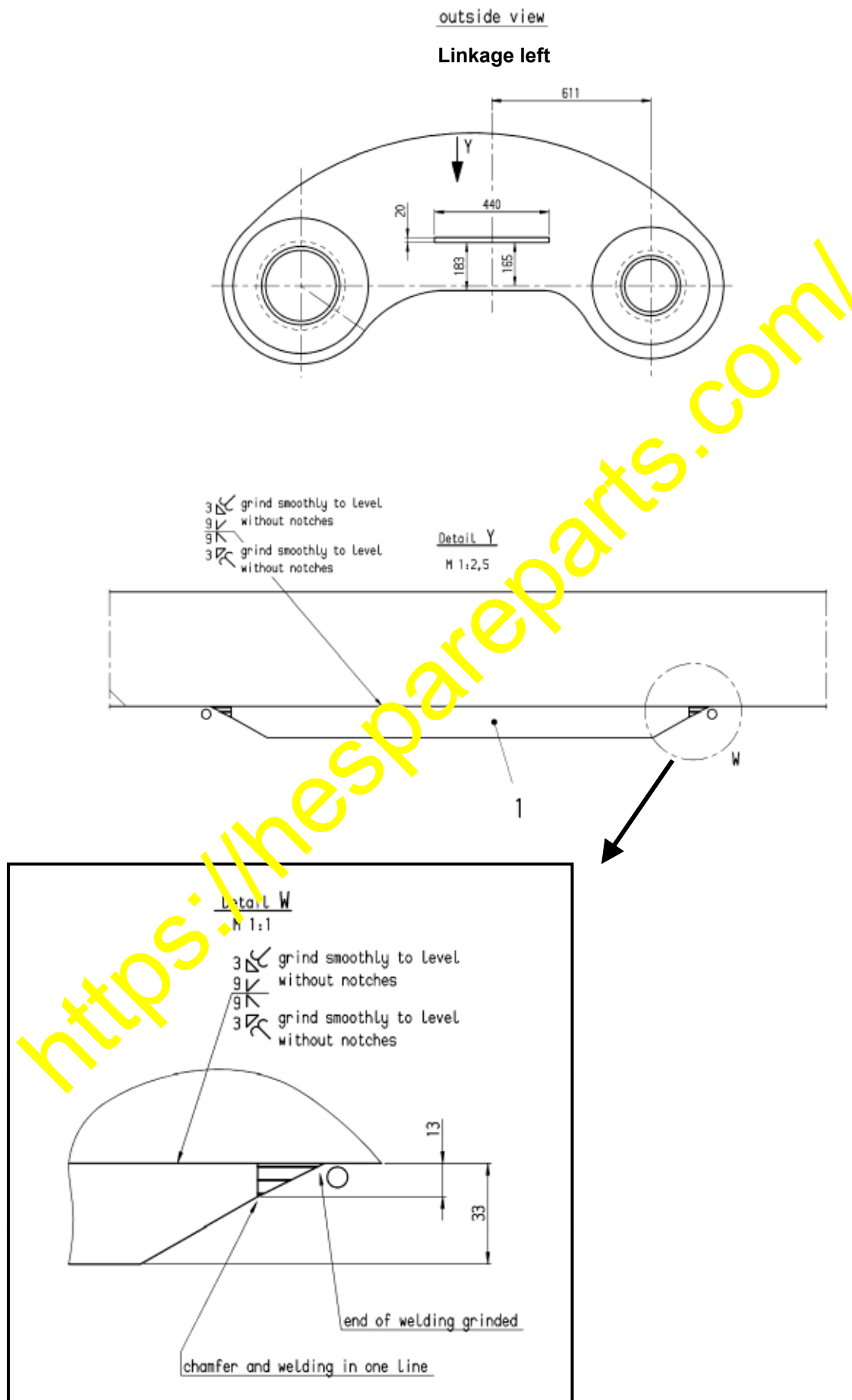


1. Grind the surface to the dimension as shown

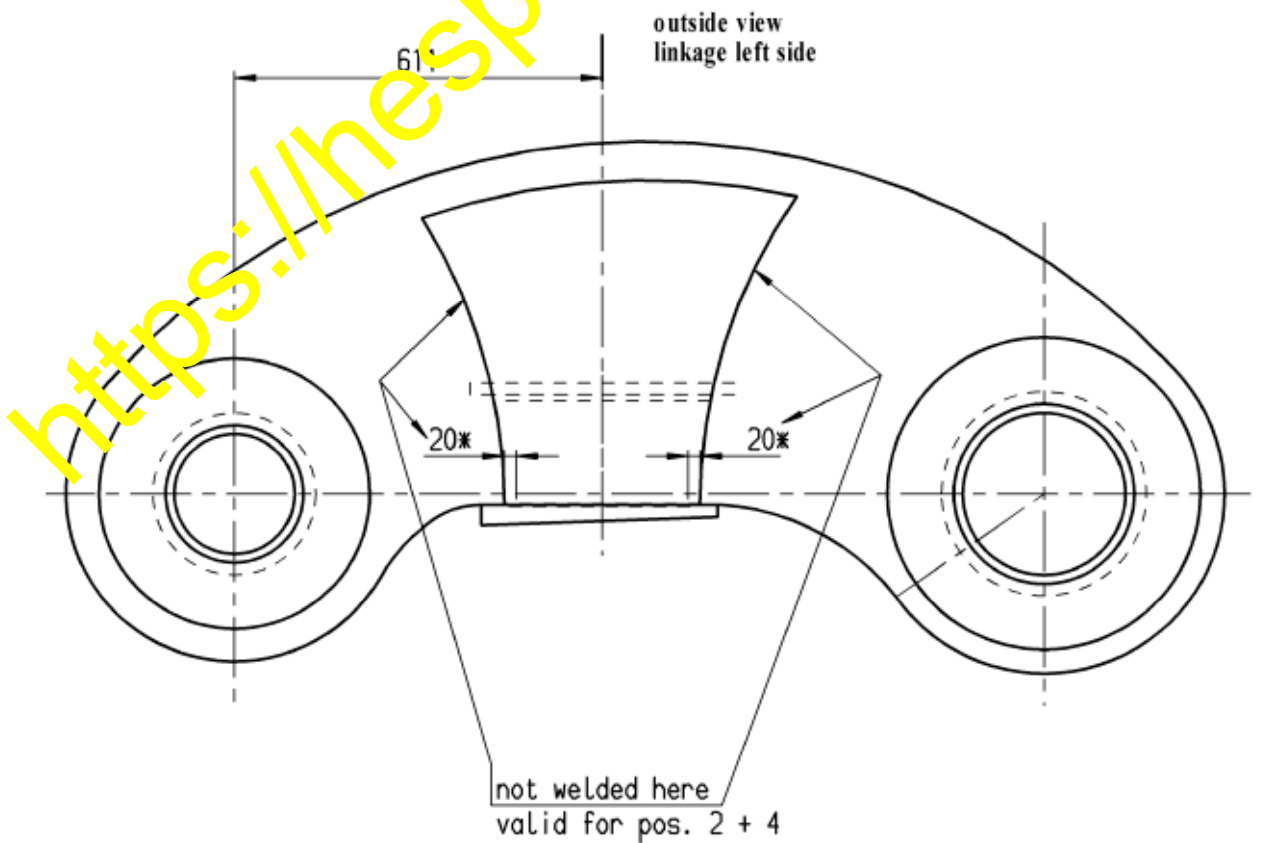
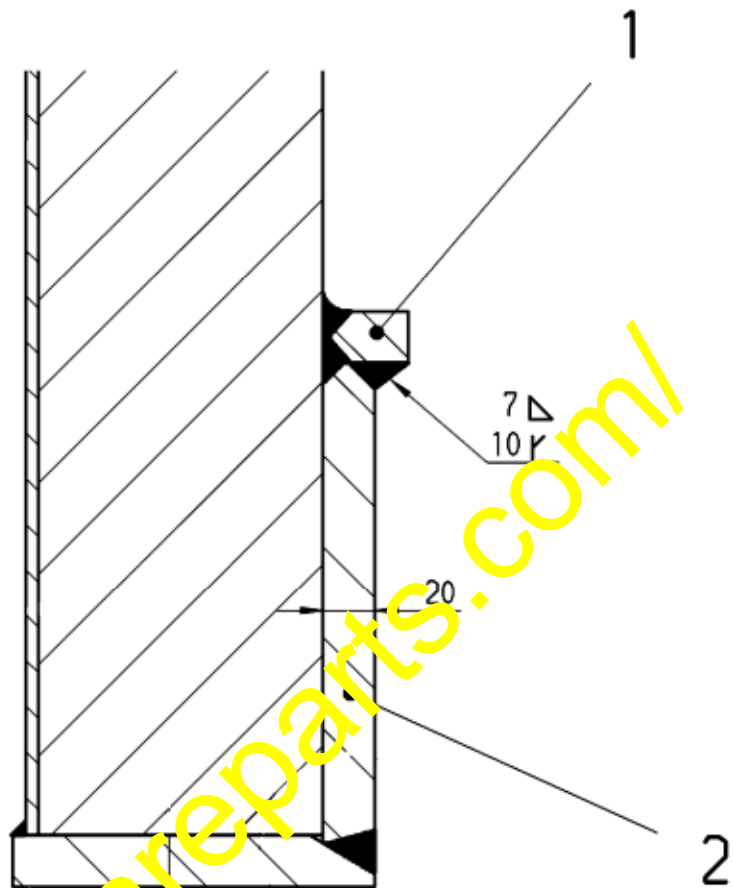


surface has to be grind to measurement as shown

2. Weld on part (1)

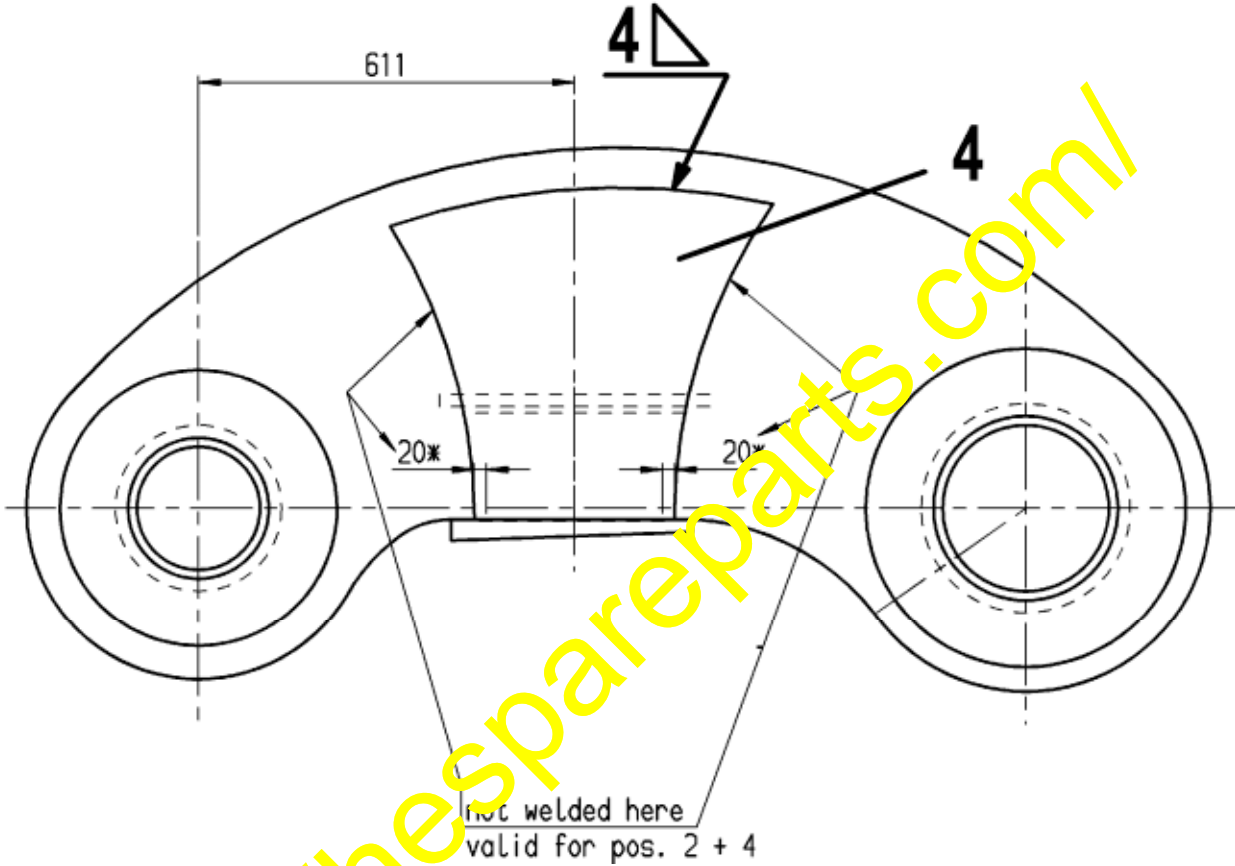


3. Weld part (2) only on part (1)

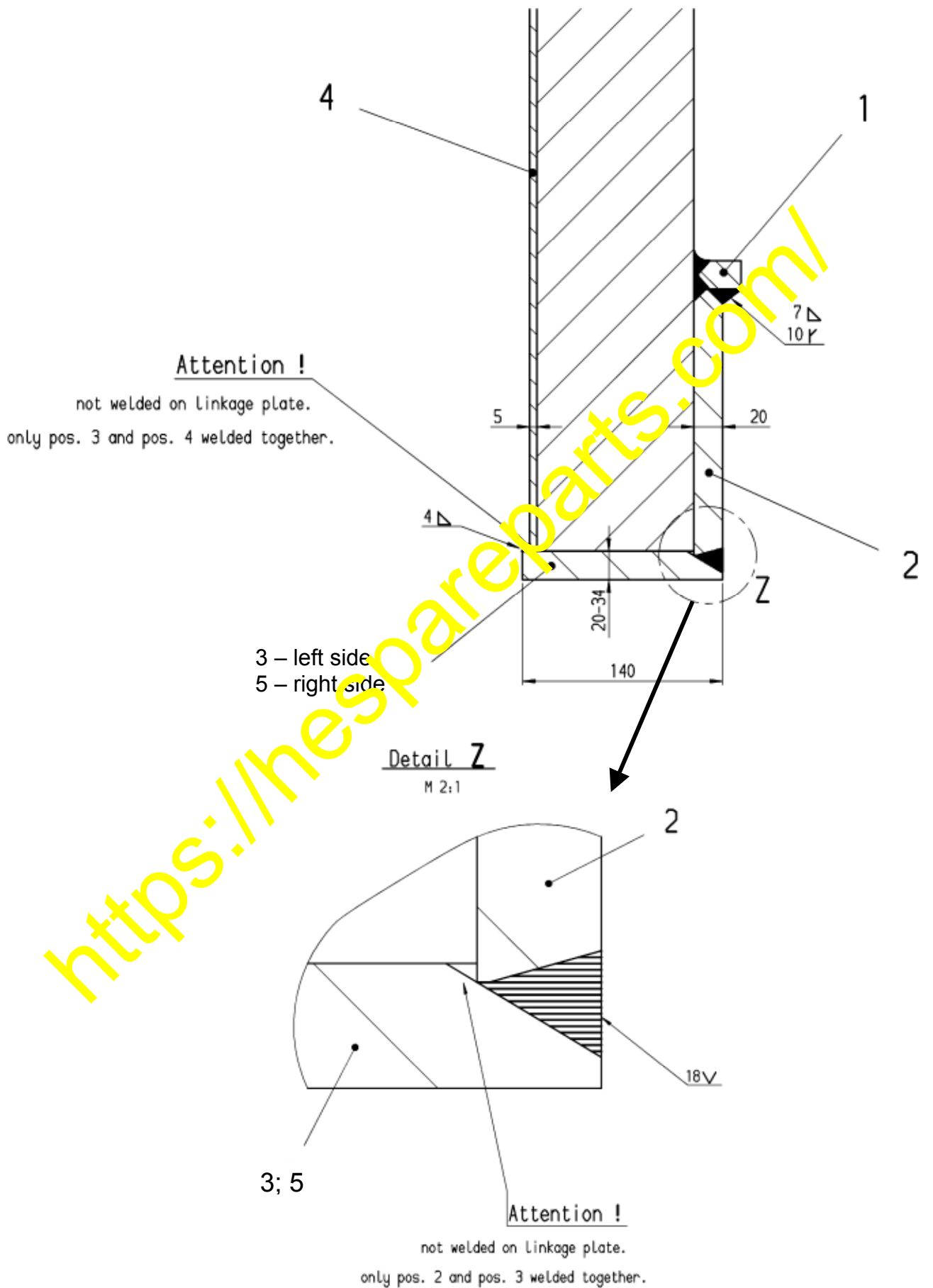


4. Weld part (4) on the linkage

inside view
Linkage left



5. Weld parts (3) and (5) only on part (4) and part (2)



Indications for welding

1. The repair area has to be preheated up to 150 °C.
2. The max. working temperature has not to be higher than 220 °C.
3. Use the following welding electrodes:
 - Welding seams "A": AWS E 8018-G
 - Welding seams "B": AWS E 7016

