

PARTS & SERVICE NEWS

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SUBJECT: REPAIR OF CRACKS FORMED IN WORK EQUIPMENT PUMP DISCHARGE TUBE ON GD825A-2

PURPOSE: To introduce modification procedures to repair cracks occurring in the discharge tube for the work equipment pump on GD825A-2 motor graders

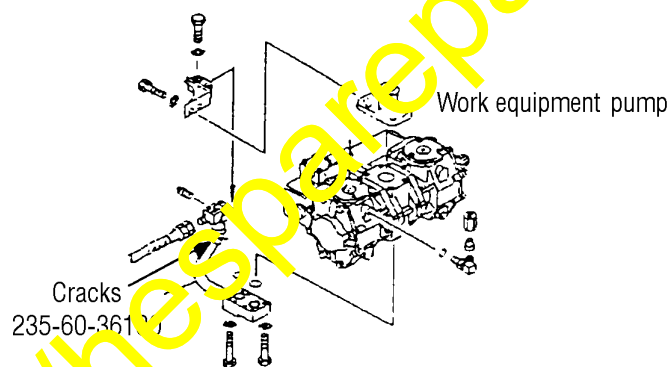
APPLICATION: GD825A-2 Motor Graders, Serial Nos. 11001 thru 12094

FAILURE CODE: 6A4137

DESCRIPTION:

1. Introduction

When cracks are found to be occurring in the welded section joining the block to the discharge tube (235-60-36130) for the work equipment pump on the GD825A-2 motor graders, implement the modification introduced in this Service News to repair the failure.



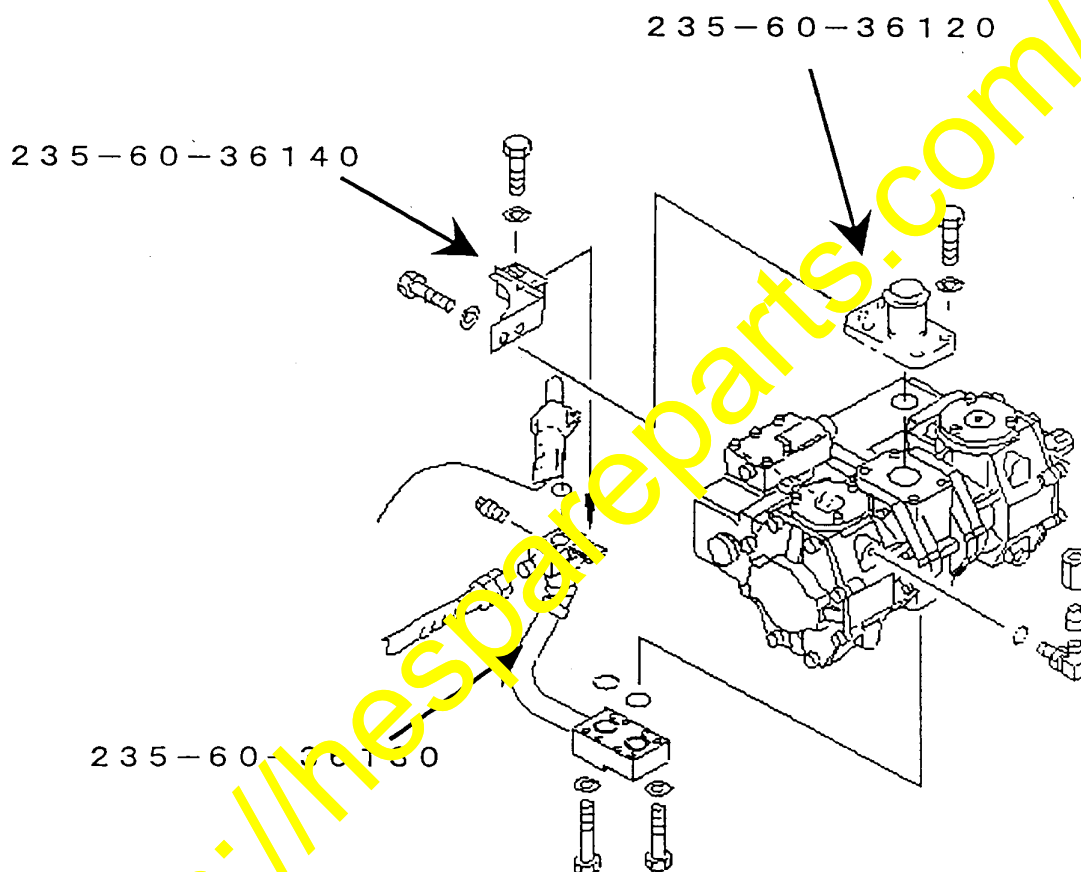
[By changing the clamping method for the piping, initial stress occurring from the binding structure can be alleviated.]

2. List of parts

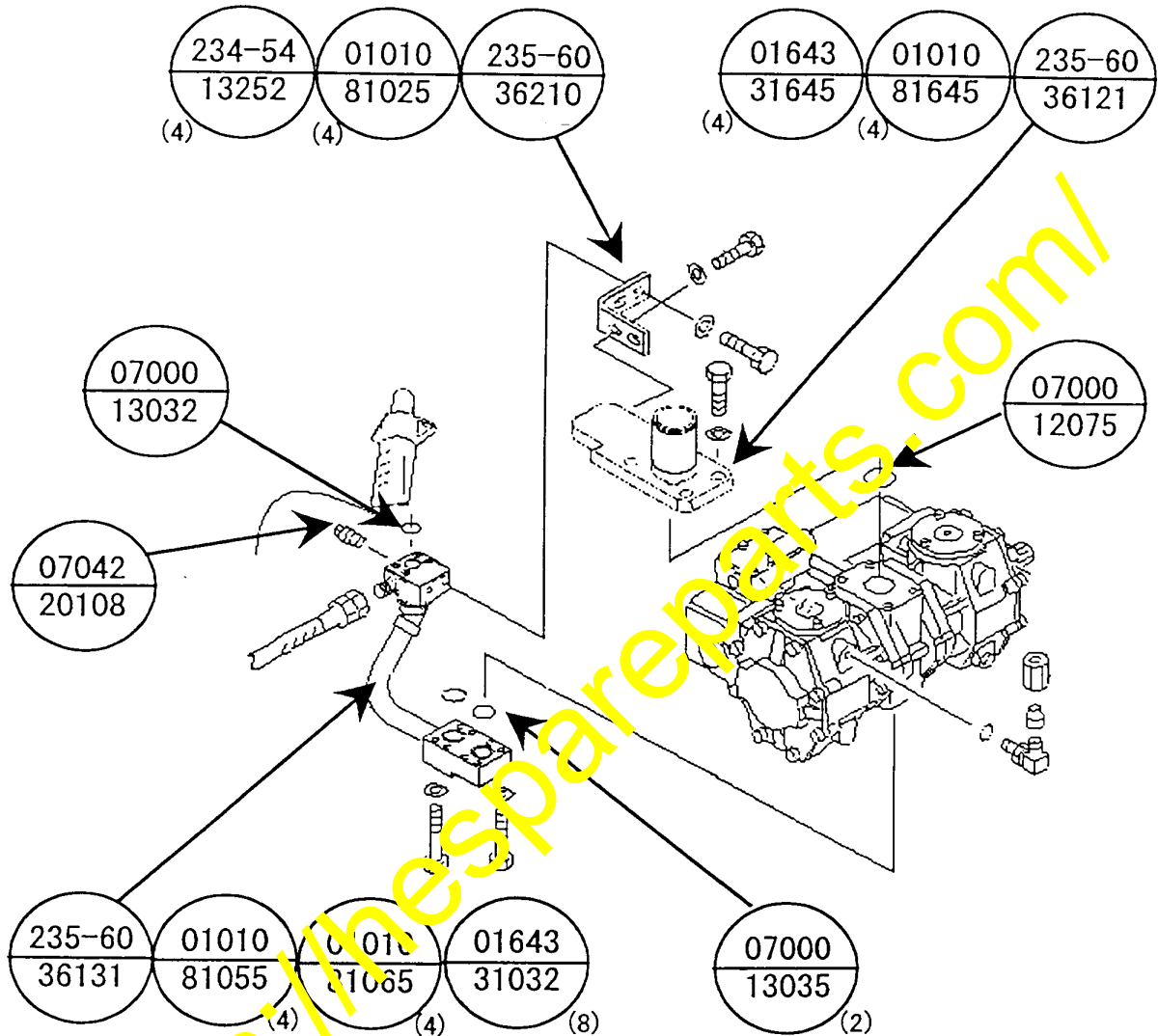
Part No.	Part Name	Purpose of part	Q'ty	Remarks		
235-60-36121 (235-60-36120)	Tube (Tube)	}	1 (1)			
01010-81640 (01010-51640)	Bolt (Bolt)		4 (4)			
01643-31645 (01643-31645)	Washer (Washer)		4 (4)			
07000-12075 (07000-12075)	O-ring (O-ring)		1 (1)		Consumable part to replace the existing part	
235-60-36131 (235-60-36130)	Tube (Tube)		1 (1)		Consumable part to replace the existing part	
07000-13035 (07000-13035)	O-ring (O-ring)		2 (2)			
01010-81055 (01010-51055)	Bolt (Bolt)		} Replacement		4 (4)	
01010-81065 (01010-51065)	Bolt (Bolt)				4 (4)	
01643-31032 (01643-31032)	Washer (Washer)		8 (8)			
07042-20108 (07042-20108)	Plug (Plug)		1 (1)			
07000-13032 (07000-13032)	O-ring (O-ring)		1 (1)			Consumable part to replace the existing part
235-60-36210 (235-60-36140)	Bracket (Bracket)		1 (1)			
01010-81025 (01010-51020)	Bolt (Bolt)		4 (2)			
(01010-81025)	(Bolt)	Unnecessary	(1)			
234-54-3232 (01643-31032)	Washer (Washer)	Replacement	4 (2)			

Modification procedures**1) Removing the parts to be replaced**

- (1) As for relevant work procedures, refer to the Section "Removal of hydraulic (work equipment) pump ass'y" in the Shop Manual.
- (2) Remove the parts with the part numbers designated below since they need to be replaced.



2) Installing the replacing parts



- (1) As for relevant work procedures, refer to the Section "Installation of hydraulic pump assembly" in the Shop Manual.
- (2) Bleed air from the work equipment pump referring to the Shop Manual.