

# PARTS & SERVICE NEWS

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**SUBJECT:** REPAIR OF HYDRAULIC PIPING FLANGE PORTION CRACK ON WA1200-3

**PURPOSE:** To introduce modification procedures to prevent occurrence of cracks in the flanged sections of the hydraulic piping on WA1200-3 wheel loaders

**APPLICATION:** WA1200-3 Wheel Loaders, Serial Nos. 50001 thru 50007

**FAILURE CODE:** 6A6137

## DESCRIPTION:

### 1. Introduction

It has been found out that there is a fear of occurrence of cracks in the flanged sections of the hydraulic piping connecting to the boom cylinder and/or the return piping to the hydraulic tank on the WA1200-3 wheel loaders by vibrations of the machine.

Implement the modification being introduced in this Service News to prevent occurrence of the aforesaid cracks.

### 2. List of parts

Part No.	Part Name	Purpose of part	Q'ty	Remarks	
42C-62-13494 (42C-62-13492)	Tube (Tube)	Replacement	1 (1)	Thickness of the flange has been increased.	
42C-62-13514 (42C-62-13512)	Tube (Tube)		1 (1)		Tube bending radius has been enlarged.
42C-62-13484 (42C-62-13482)	Tube (Tube)		1 (1)		
42C-62-13475 (42C-62-13472)	Tube (Tube)		1 (1)	Tube bending radius has been enlarged.	
42C-62-13163 (42C-62-13162)	Tube (Tube)		1 (1)		
421-64-23140	Spacer	Additional	6		
07000-F3038	O-ring	Replacement	7	Consumable part	
07000-F3048	O-ring		3		
01010-81250 (01010-81240)	Bolt (Bolt)		12 (12)	For installation of the tube flange	
42C-46-11G90	Seat	Additional	2		
42C-62-14551	Bracket		2		

Part No.	Part Name	Purpose of part	Q'ty	Remarks	
01010-81660	Bolt	}	6		
421-70-11280	Washer		12		
421-64-23120	Cushion		12		
421-64-23130	Cushion		6		
07283-34354	Clip		} Additional		2
07283-54353	Seat				2
01597-01009	Nut				8
01643-31032	Washer				8
42C-62-15910	Bracket				1
42C-62-15920	Bracket				1
42C-62-15930 (42C-62-15412)	Bracket (Bracket)	Replacement	1 (1)		
42C-62-15940	Seat	} Additional	1		
01010-81230	Bolt		4		
01010-81235 (01435-01225)	Bolt (Bolt)	Replacement	2 (2)		
01643-31232	Washer	}	6		
07283-37671	Clip		} Additional	2	
42C-62-15491	Seat			2	

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### 3. Contents of the modification

To suppress vibrations of the hydraulic tubes (the pipings connecting between the work equipment valve and the boom cylinders and of the return piping to the hydraulic tank located inside the front frame), vibration preventive brackets are to be supplemented.

Preparations before starting the modification work

- (1) Prepare a container with a capacity of 20 liters or more to receive drained oil.
- (2) Prepare 20 liters of the hydraulic oil to refill after finishing this modification.
- (3) Park the machine on a level surface.
- (4) Lower the bucket to touch the ground, apply the parking brake and stop the engine.
- (5) Move the work equipment control levers to release the oil pressure in the piping connecting to the boom cylinder.

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4. Modification procedures

4.1. Modifying the pipings connecting between the work equipment valve and the boom cylinders located inside the front frame

1.1 Removing the hydraulic tubes

Remove the five hydraulic tubes marked "X". (Discard the removed tubes.)

The tube mounting bolts (01010-81250) and washers (01643-31232) are being reused.

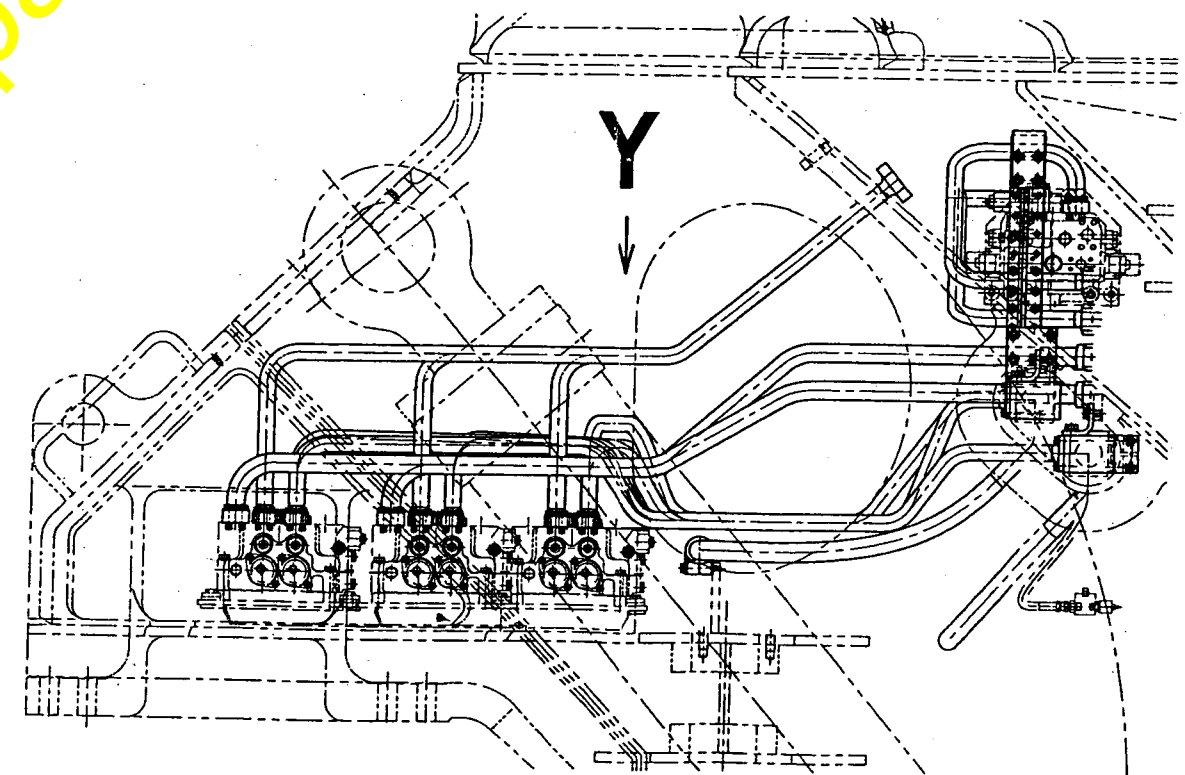
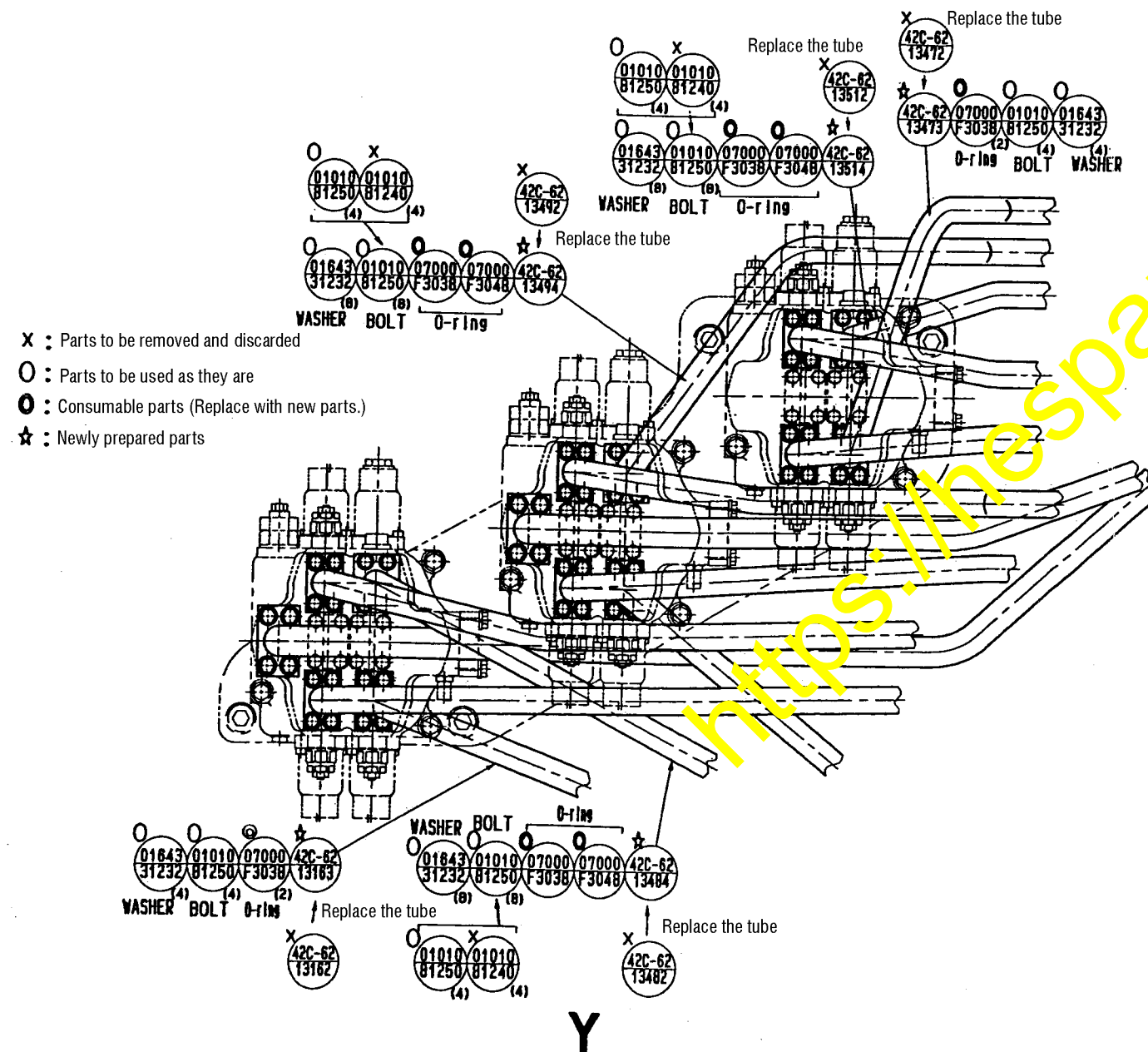
1.2 Installing the hydraulic tubes

Install the five newly prepared tubes marked ☆.

Note: Replace the O-rings with new parts.

All the mounting bolts are to carry the part no. 01010-81250.

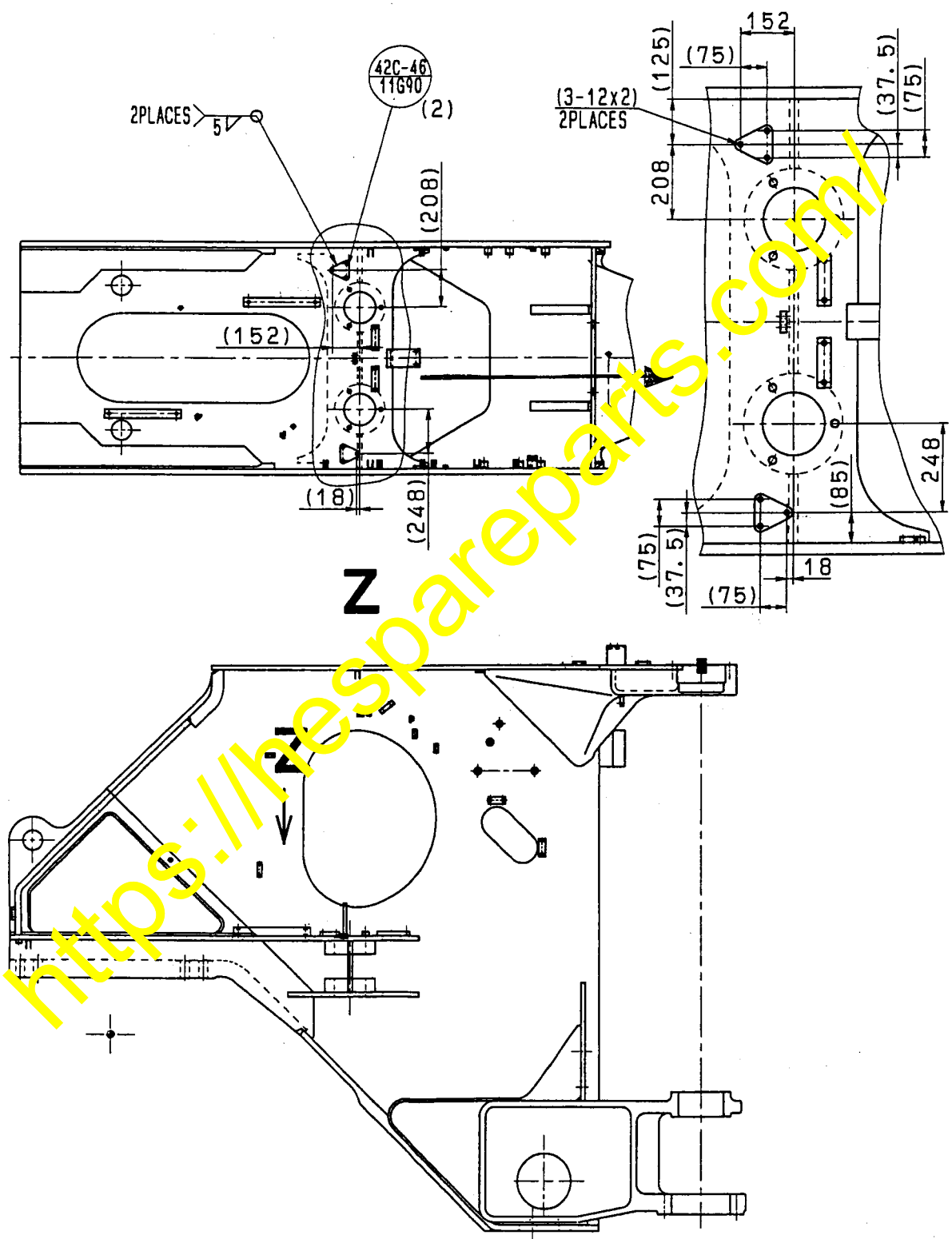
Tightening torque: 98 - 123 Nm (10 - 12.5 kgm)



1.3 Supplementing the seats to the front frame

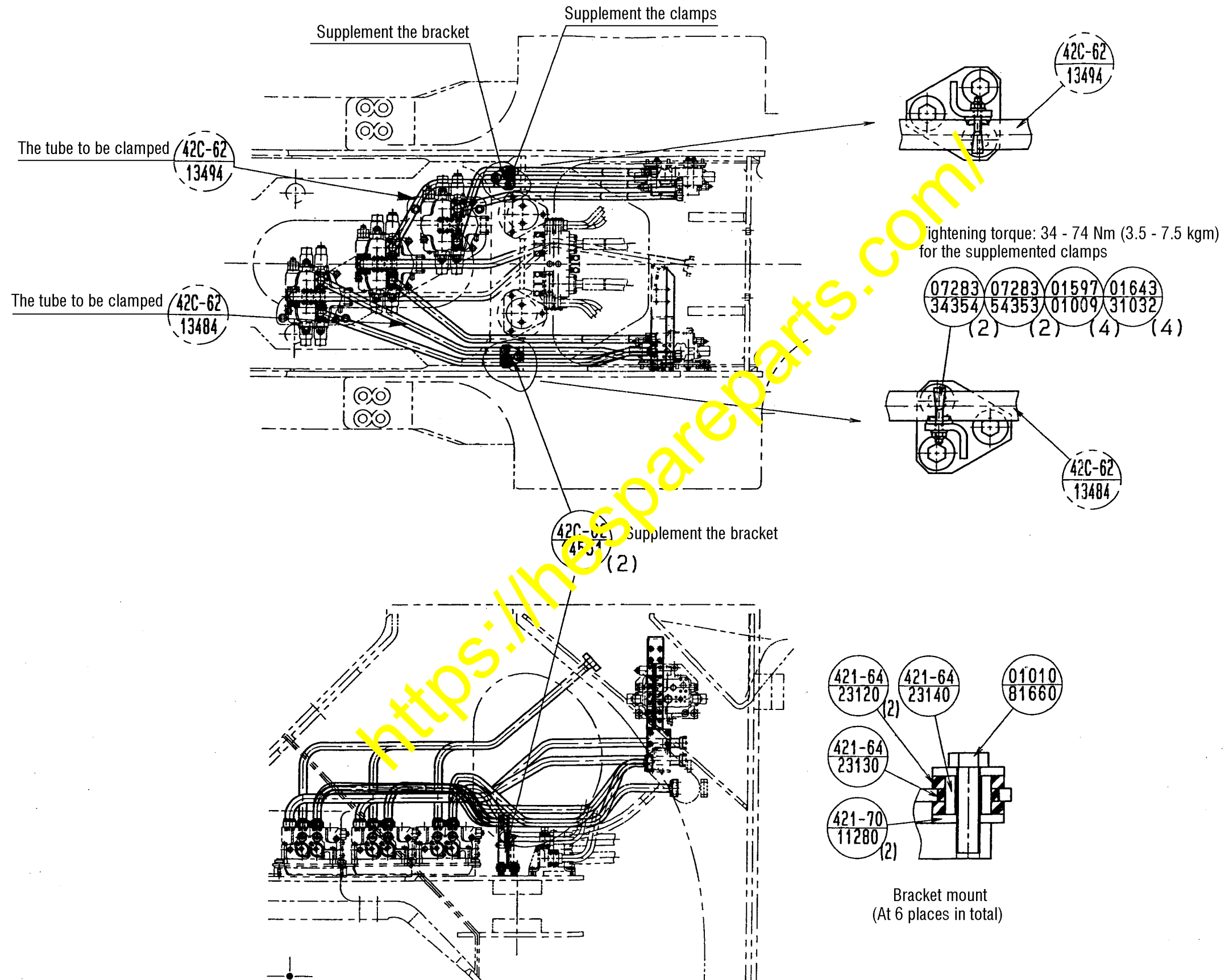
Weld the two seats (42C-46-11G90) to the positions designated in the drawing indicated below.

(Apply corrective painting to the welded surfaces.)



Front frame

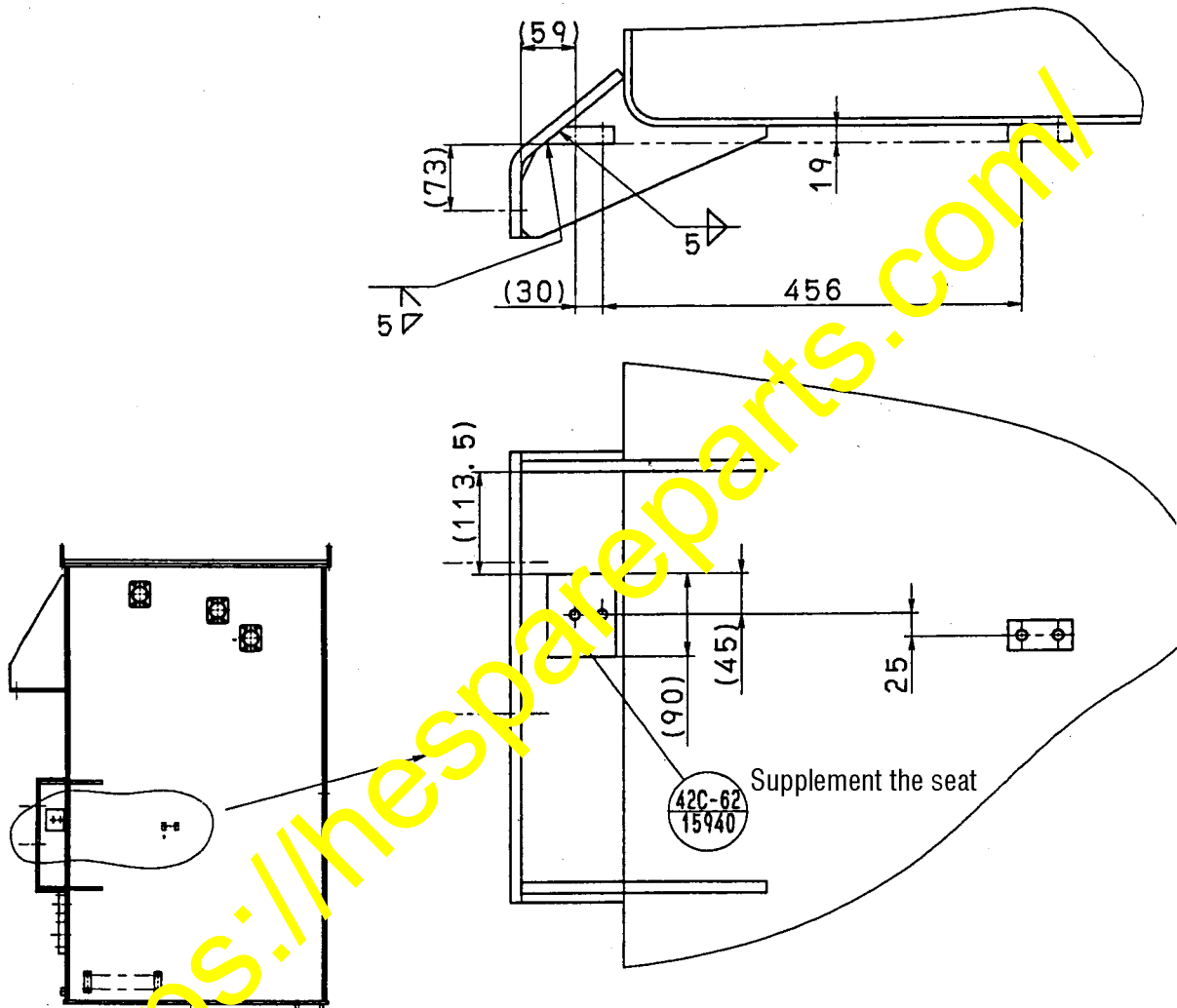
1.4 Supplementing the vibration preventive brackets  
Install the vibration preventive brackets (42C-62-14551) to clamp the tubes.



#### 4-2 Modifying the return piping connecting to the hydraulic tank

##### 2.1 Welding the seat to the hydraulic tank

Weld the seat to which the bracket is to be installed, to the hydraulic tank.  
After finishing welding, apply corrective painting to the welded surfaces.

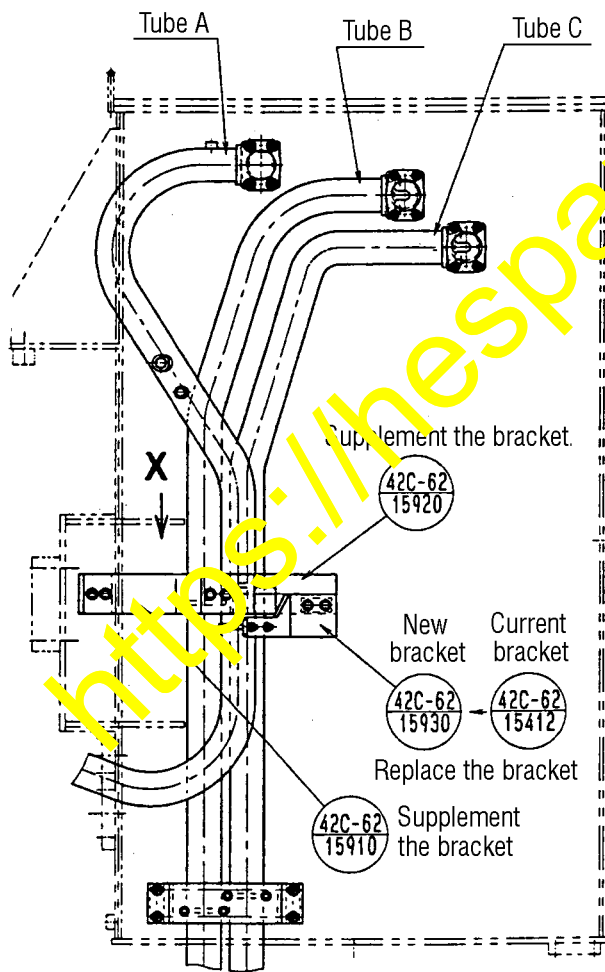
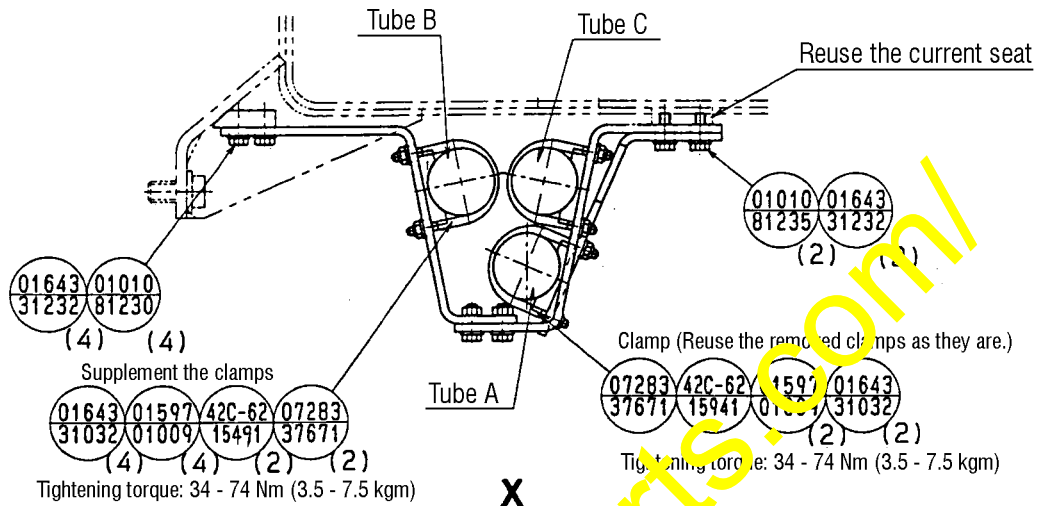


Hydraulic tank (when viewed from the rear side of the chassis)

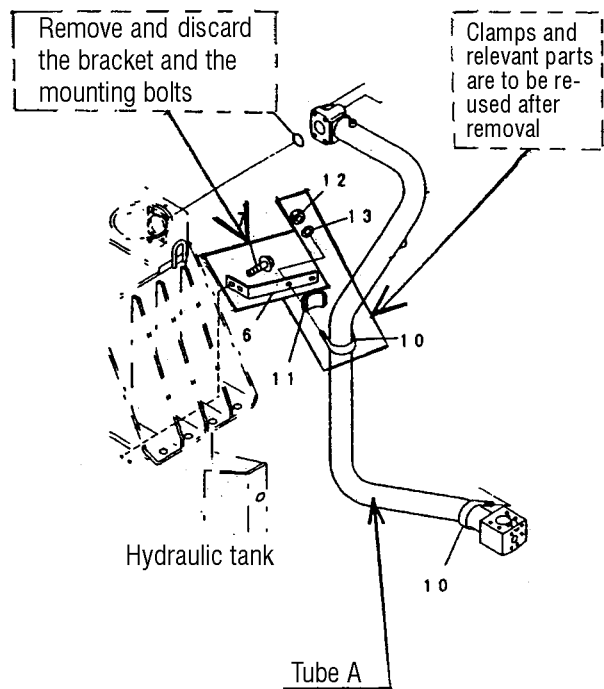
2.2 Supplementing the vibration preventive brackets

Remove the current bracket and clamps clamping the tube "A". (The clamp is being reused.)

Install the new brackets and clamp the tubes A thru C.



Removing the current bracket and clamps



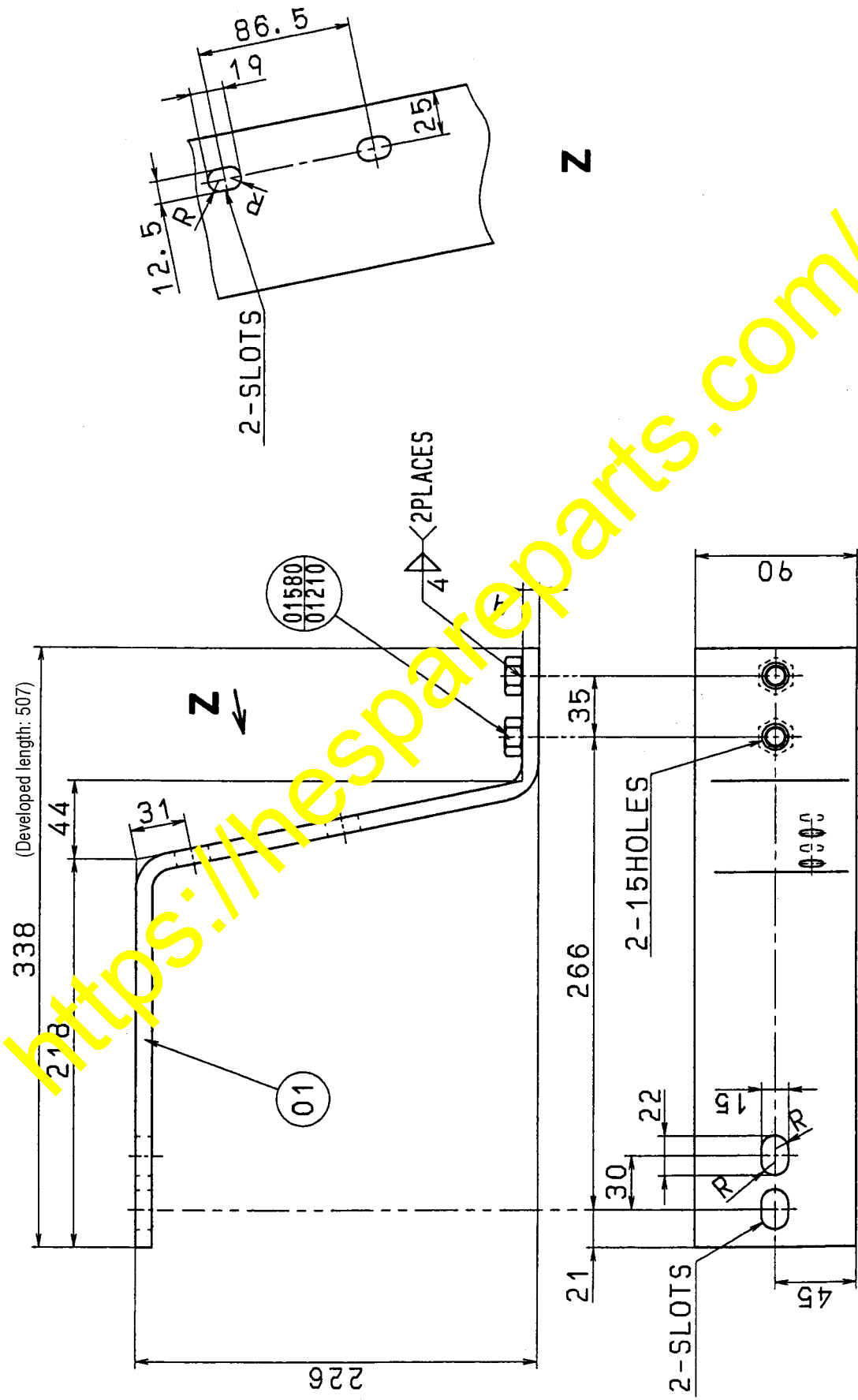


5. After finishing the modification work

- (1) Refill the hydraulic oil and release air from the hydraulic circuits referring to the Section "Air bleeding procedures from the hydraulic oil circuits" in the Chapter "Inspection and Maintenance" in the Operation and Maintenance Manual.
- (2) After finishing the air bleeding work, inspect the oil level in the hydraulic tank and refill oil to the prescribed level when found in short.

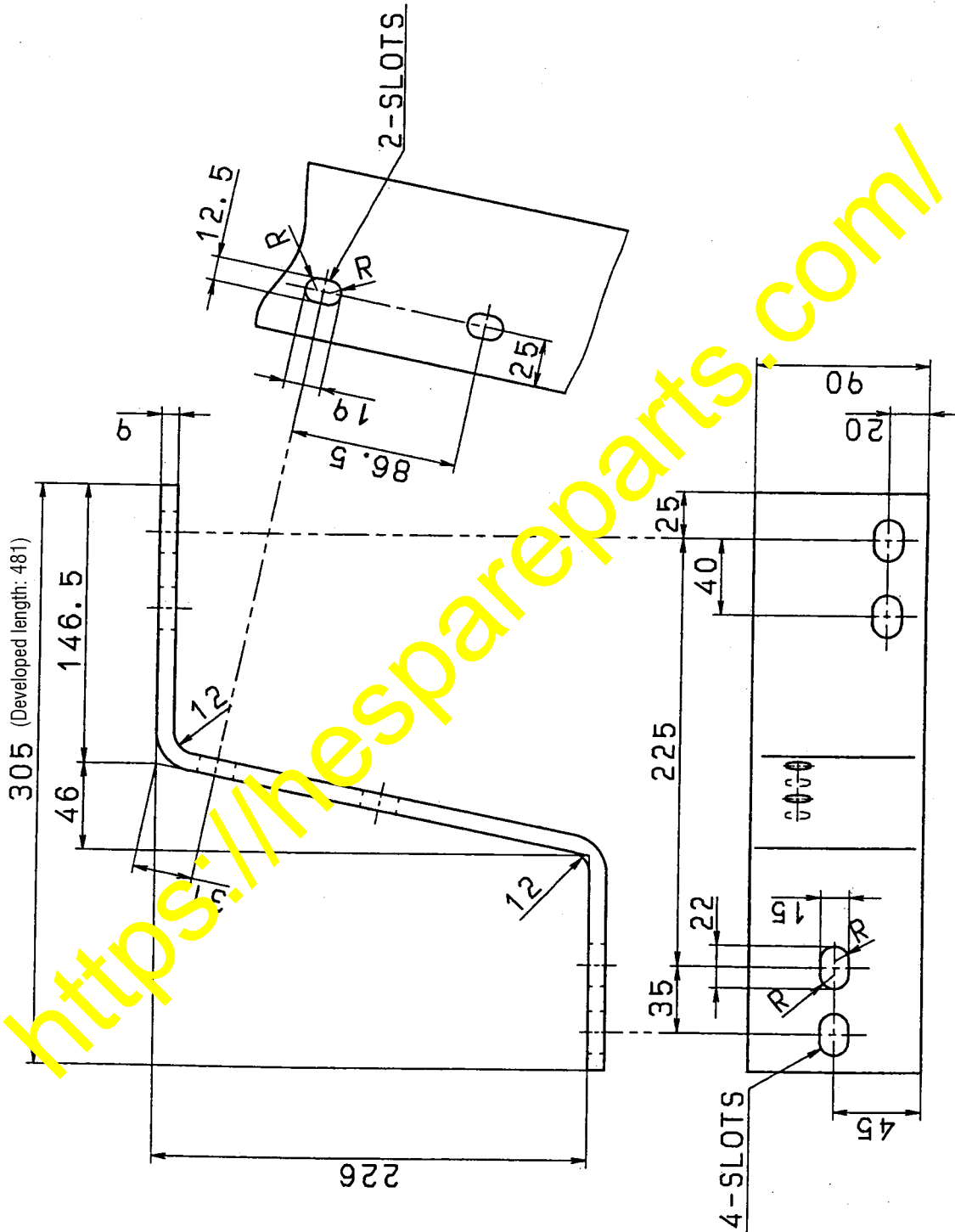
<https://hespareparts.com/>

Reference: The shape of the part 42C-62-15910  
Material: SS400F (01 material)

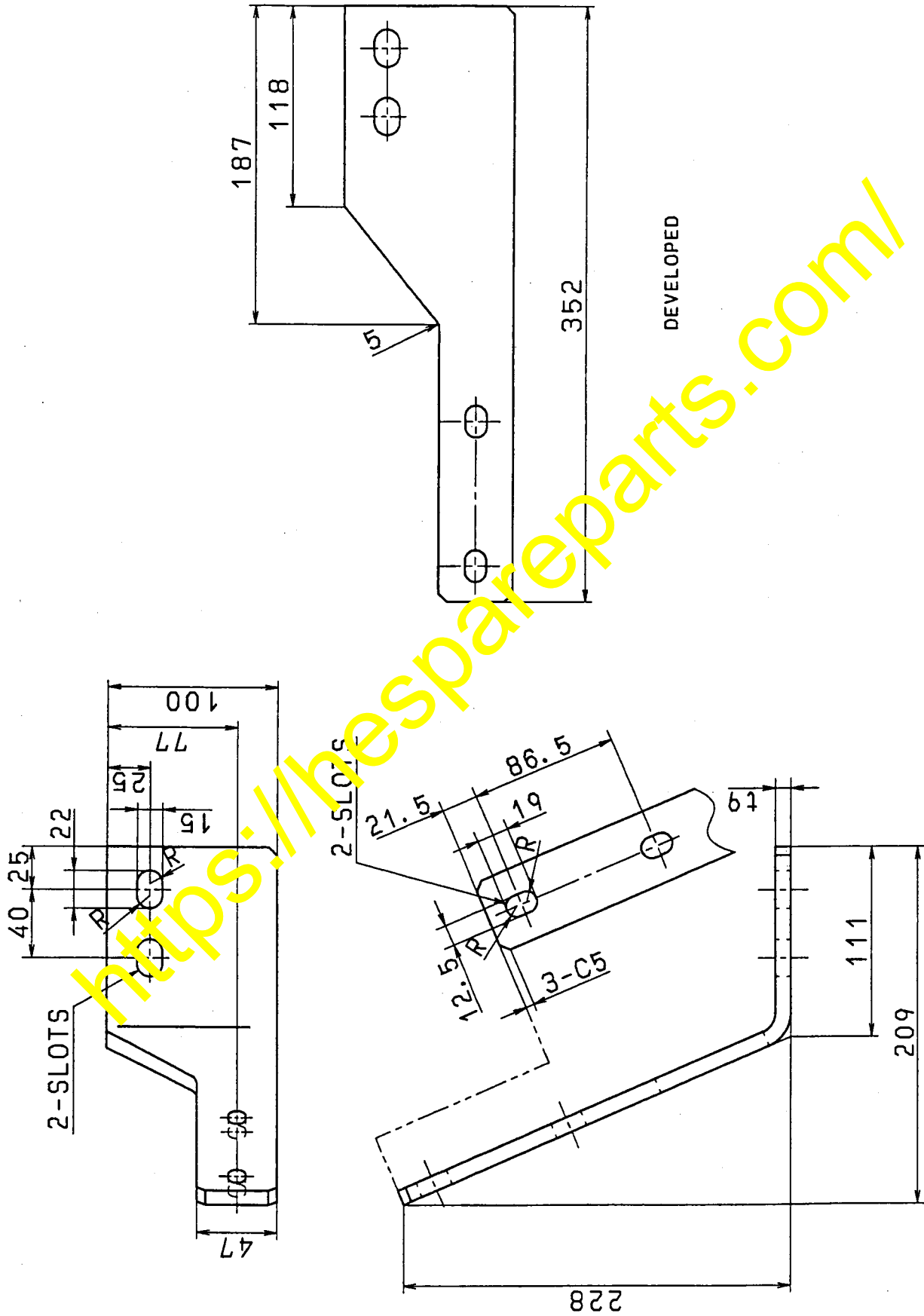


<https://thespareparts.com/>

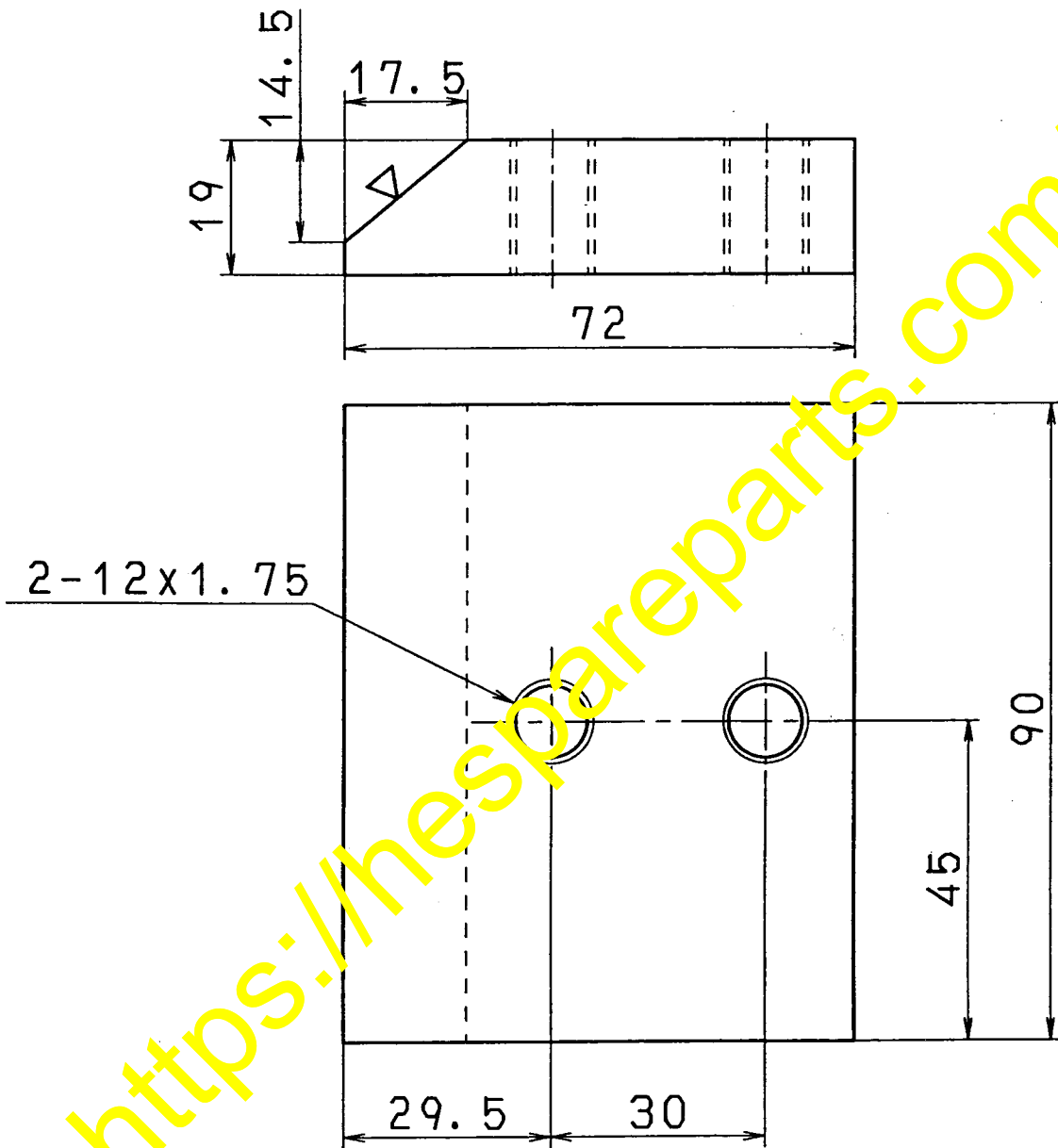
Reference: The shape of the part 42C-62-15920  
Material: SS400F



Reference: The shape of the part 42C-62-15930  
Material: SS400P



Reference: The shape of the part 42C-62-15940  
Material: SS400F



Reference: The shape of the part 42C-46-11G90  
Material: SS400P

