

# PARTS & SERVICE NEWS

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DATE	May 18, 2001
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**SUBJECT:** REPAIR METHOD OF T/C TRUNNION BOSS ON HD785-3, 5/  
HD985-3, 5/330M

**PURPOSE:** To introduce a spare part to repair excessive wear of the trunnion boss section of torque converter on HD785-3/5, HD985-3/5 and 330M dump trucks and relevant modification procedures  
[Applicable to the rebuilt torque converter]

**APPLICATION:** HD785-3 Dump Trucks, }  
HD785-5 Dump Trucks, } All serial Nos.  
HD985-3 Dump Trucks, }  
HD985-5 Dump Trucks, }  
330M Dump Trucks, }

**FAILURE CODE:** 1510CA

## DESCRIPTION:

### 1. Introduction

When excessive wear is found on the torque converter supporting section (trunnion boss section) of the rebuilt torque converter for use on HD785-3/5, HD985-3/5 and 330M dump trucks having been used for long time, repair the section following the modification procedures outlined in this Service News.

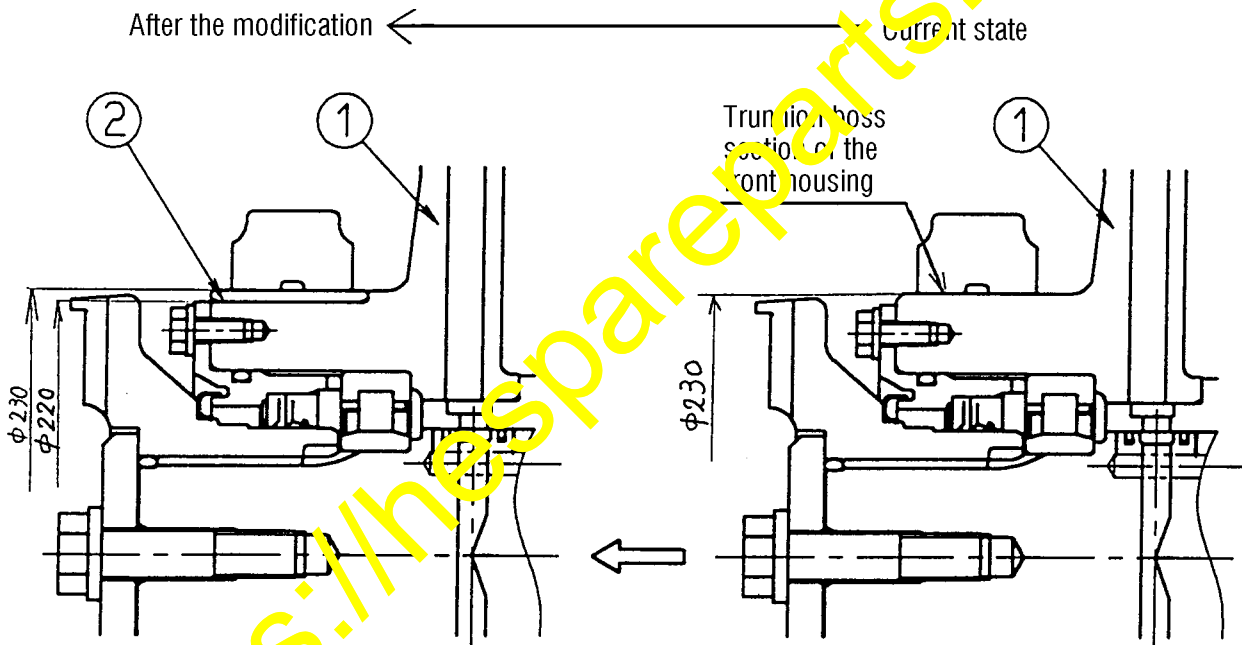
For your reference: The cause of excessive wear of the trunnion boss section is considered to be due to insufficient greasing by customers resulting in the drying up of the oil film.

2. Outline of the contents of the modification

Rework the worn trunnion boss section of the front housing of the torque converter and press-fit a bushing.

<Table 1>

No.	Part names	Part numbers	Contents of the modification
①	Front housing	561-13-43131	Machine the designated section of the trunnion boss from the current dimension of $\phi 230$ to $\phi 220$ .
②	Bushing	561-13-53380	New part (Press-fit it.)

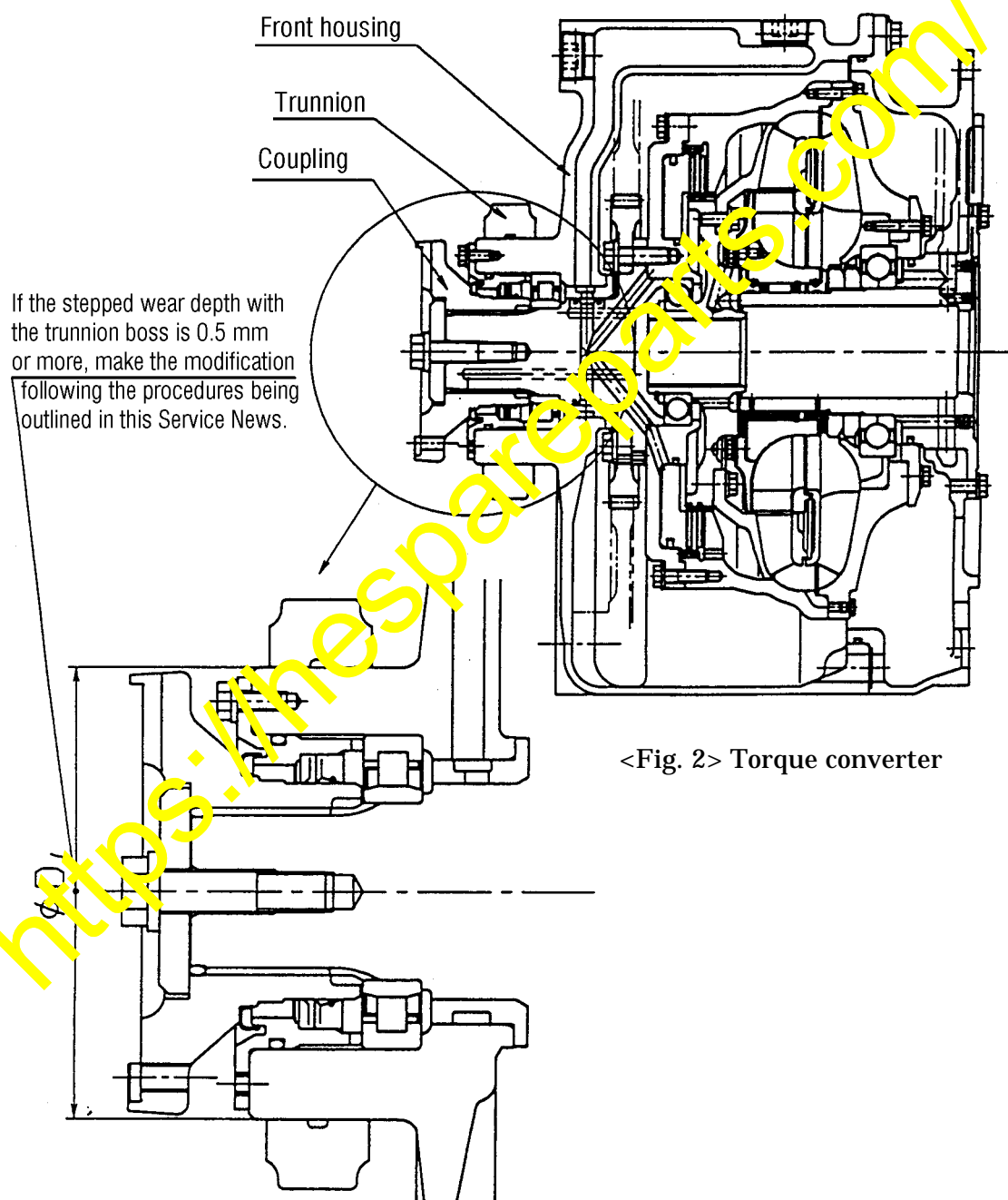


<Fig. 1> Contents of the modification

## 3. Criteria for determining if the modification (repair) is necessary or not

&lt;Table 2&gt;

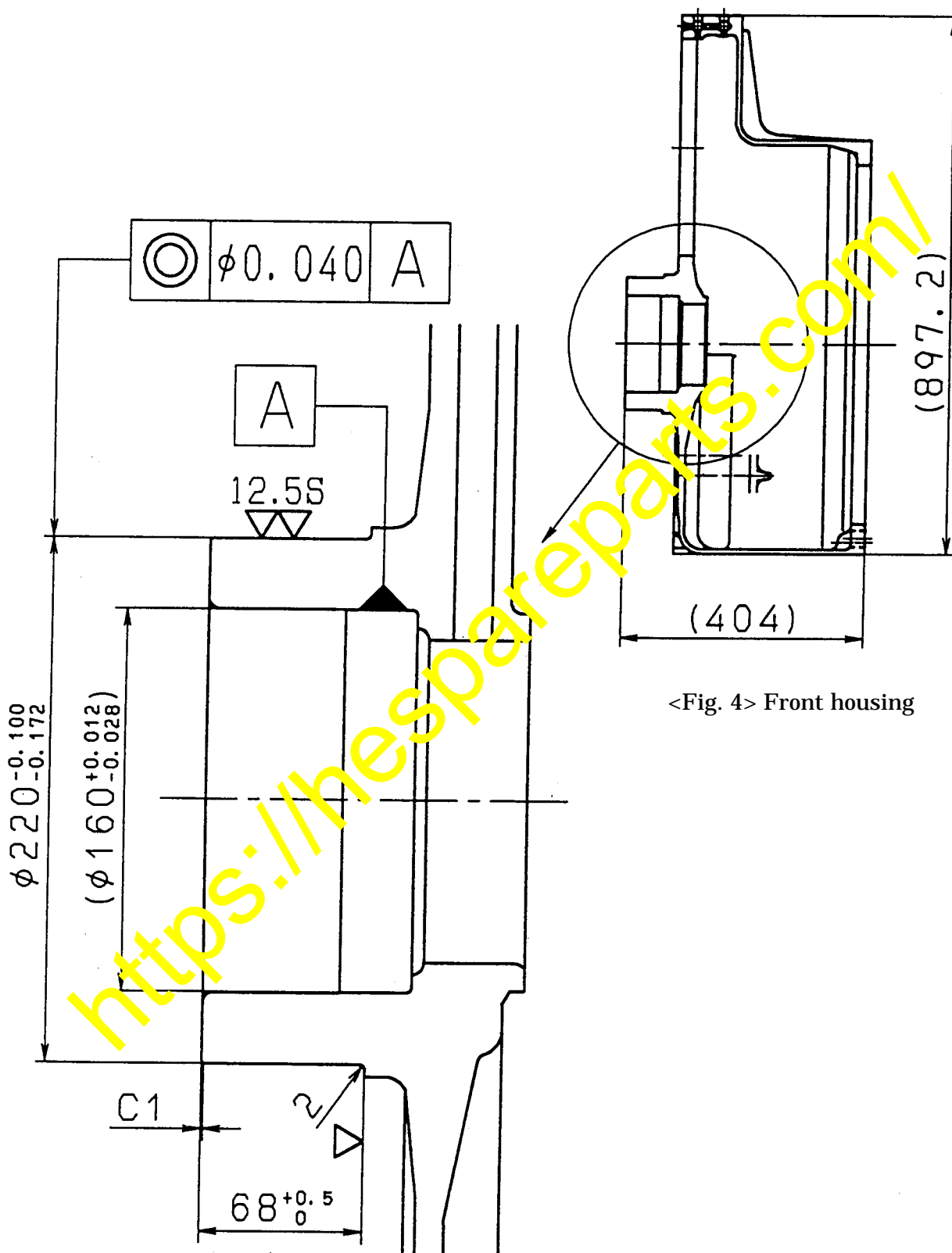
Checking point	Initial dimension	Criteria
Trunnion boss section of the front housing (The section "D1" in Fig. 3.)	$\phi 230 \begin{matrix} -0.100 \\ -0.172 \end{matrix}$	If the stepped wear depth with the trunnion boss is 0.5 mm or more, make the modification following the procedures being outlined in this Service News.



&lt;Fig. 3&gt; Trunnion boss section

4. Modification procedures

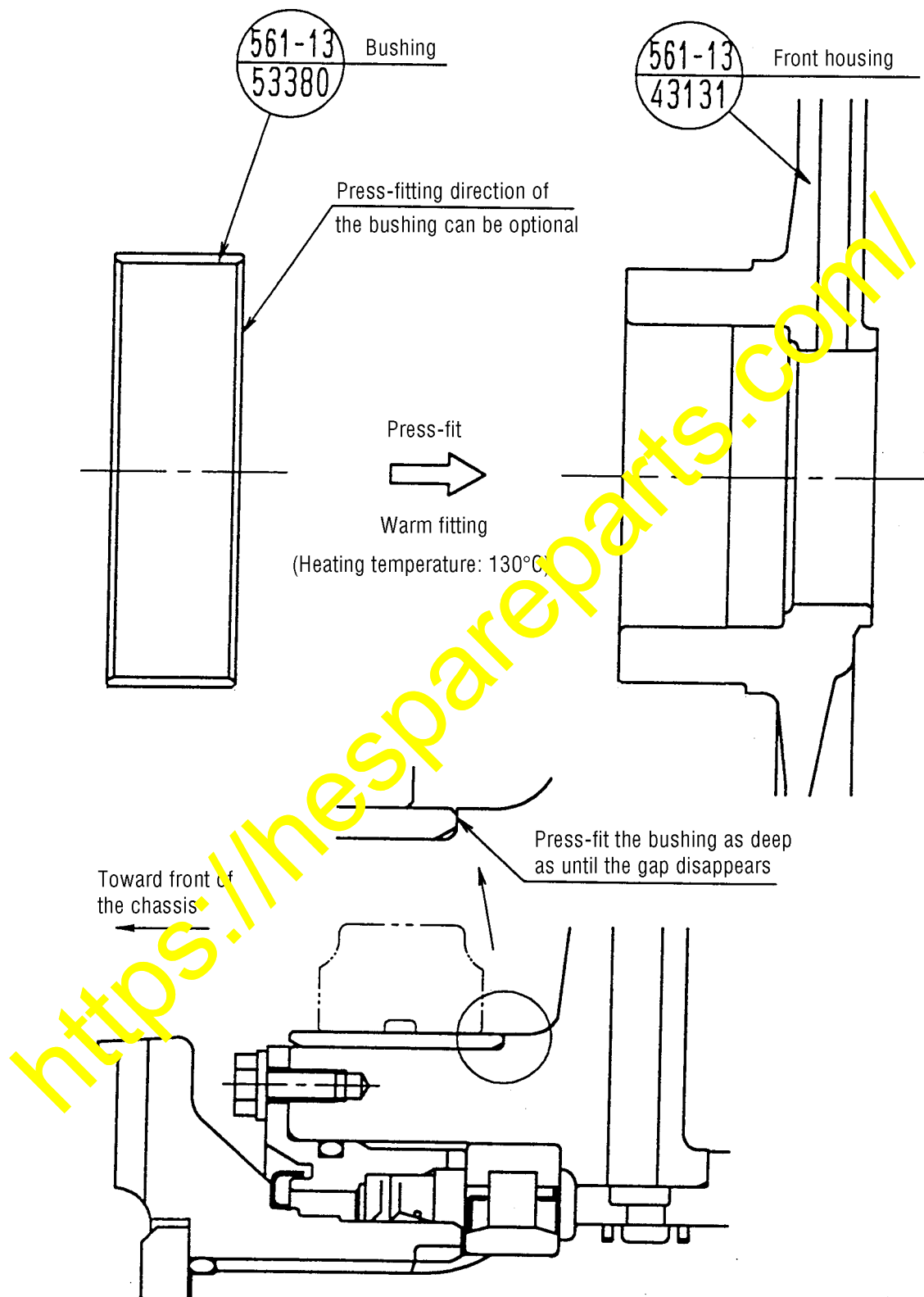
- (1) Rework the trunnion boss section of the front housing (561-13-43131) of the torque converter according to the instructions given in Fig. 5 below by machining.



<Fig. 4> Front housing

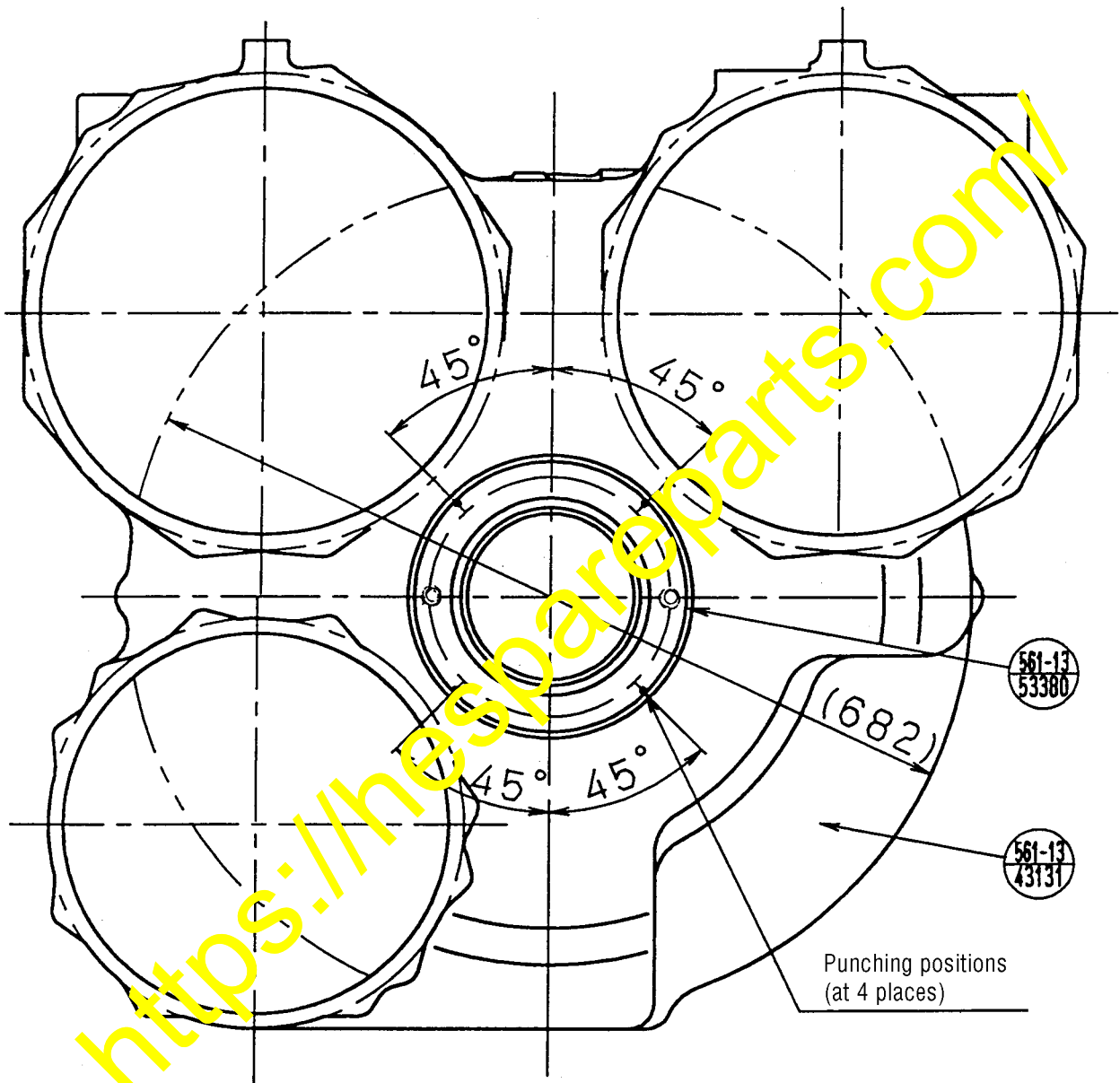
<Fig. 5> Machining procedures

- (2) Heat up the bushing (561-13-53380) in a heating unit, etc. (heating temperature: 130°C) before press fitting to the machined section of the front housing.



<Fig. 6> Assembling procedures

- (3) After press-fitting the bushing (561-13-53380) to the front housing, punch the positions marked • (around the peripheral edge of the front housing) using an appropriate punch until the punched projections dig into the bushing.  
Be sure to thoroughly remove burrs and fins resulting from the punching work.



<Fig. 7> Punching positions to fasten the bushing.

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Part No.	Part Name	Q'ty	Remarks
561-13-53380	Bushing	1	

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<https://hespareparts.com/>