

**PARTS & SERVICE
NEWS**

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SUBJECT: REPAIR OF STEERING CIRCUIT BLOCK ON WA1200-3

PURPOSE: To introduce modification procedures to strengthen the steering circuit block on WA1200-3 wheel loaders

APPLICATION: WA1200-3 Wheel Loaders, Serial Nos. 50001 thru 50010

FAILURE CODE: R110HA

DESCRIPTION:

1. Introduction

Cracks may occur in the inside structure of the welded section where a plug is welded, of the block contained in the steering circuit on the WA1200-3 wheel loaders because of dispersions of the fusing state of the plug, resulting in oil leakage failure.

When the aforesaid failure is found to be occurring or when preventing occurrence of such failure, make the modification introduced in this Service News to replace the part with the improved part with stronger welding.

2. List of parts

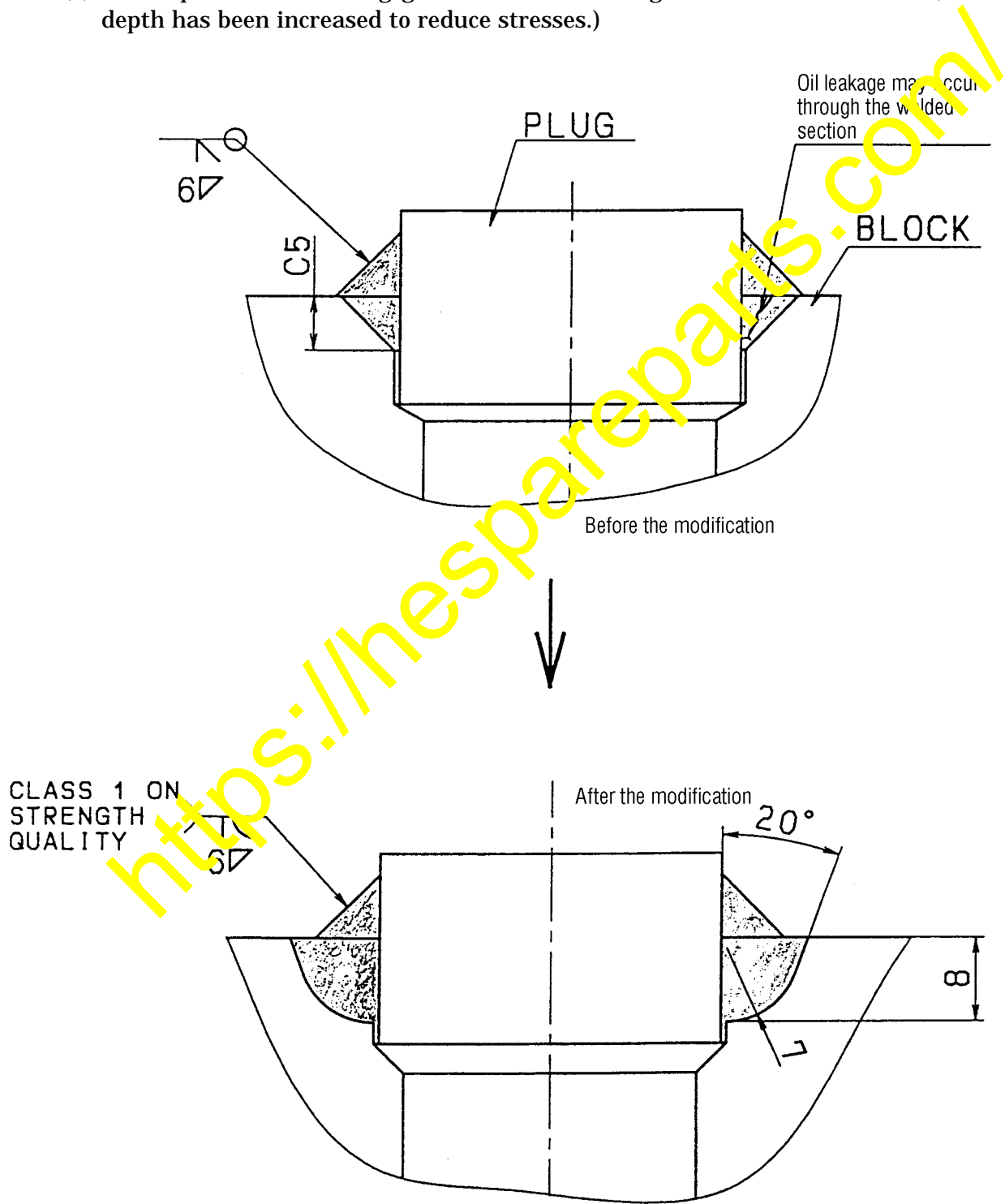
Part No.	Part Name	Purpose of part	Q'ty	Remarks
42C-62-11182 (42C-62-11181)	Block (Block)	} Replacement	1 (1)	Applicable to the machines with the Serial Nos. of 50001 and 50002 only.
42C-62-16193 (42C-62-16192)	Block (Block)		2 (2)	

3. Contents of the modification

(1) The welding groove shape of the section where the plug is being welded has been changed and the welding quality has been upgraded. (To cope with the imperfect fusing problem)

- Shape of the welding groove: "V" shape \rightarrow "J" shape
- Welding quality: Class 3 (Without designation in the drawing)
 \rightarrow Class 1 (Fusing: $\Delta 2$ mm \rightarrow +0.5 mm)

(2) The depth of the welding groove has been changed. 5 mm \rightarrow 8 mm (The throat depth has been increased to reduce stresses.)

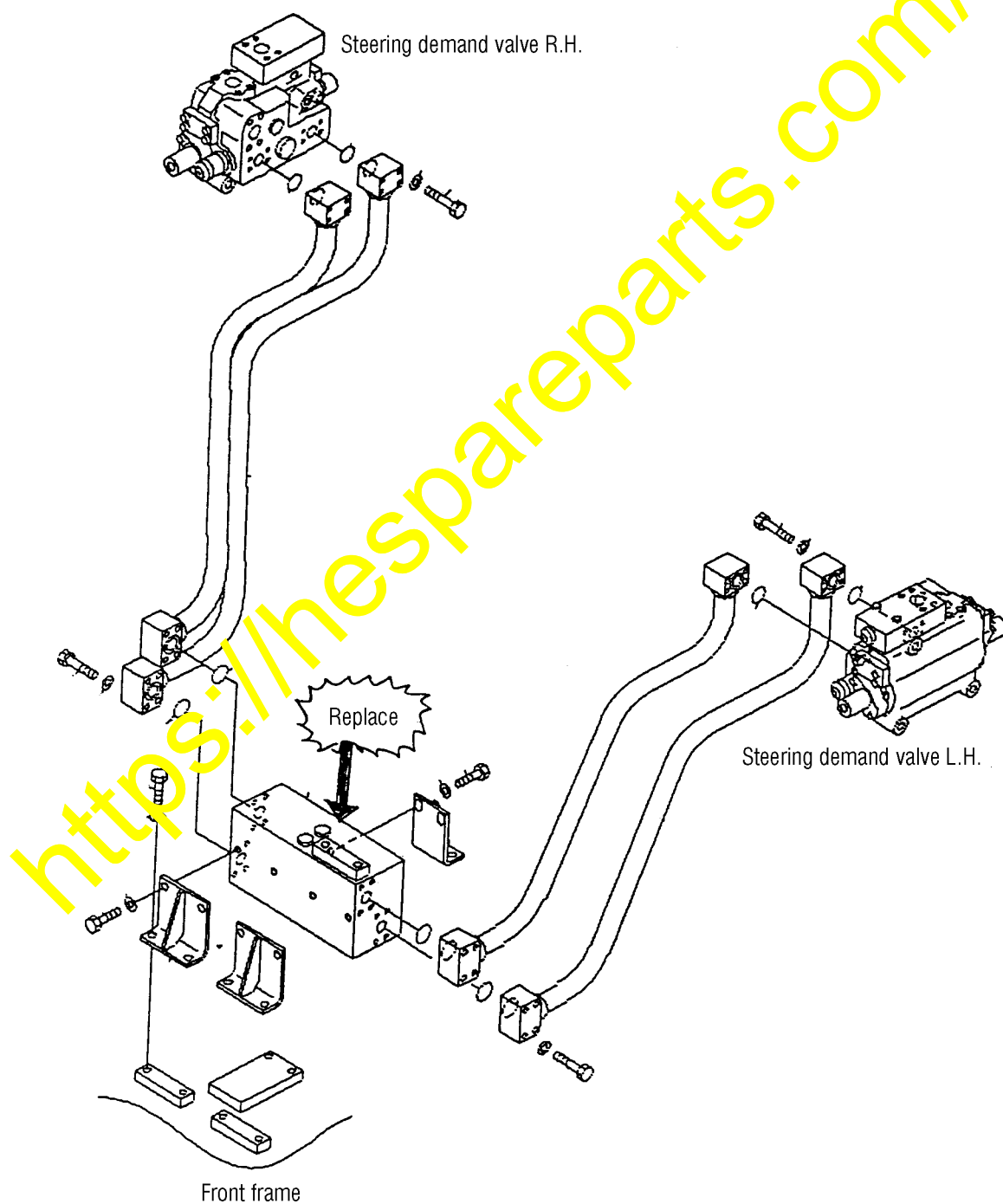


4. Replacing the parts for this modification

Precaution: For hazard preventing purposes, observe the instructions and designations of the Shop Manual (in the Section "Precautions when carrying out disassembly and assembly work" in the Chapter "Disassembly and Assembly") and the Operation and Maintenance Manual (in the Chapter "Inspection and Maintenance") when carrying out this replacement work.

- (1) Replacing the block for the circuit connecting between the steering valve and the steering cylinder inside the front frame

Replace the block 42C-62-11181 with the newly prepared block 42C-62-11182.



- (2) Replacing the junction block for the emergency steering pump circuit and the steering pump circuit inside the rear frame

Replace the blocks 42C-62-16192 with the newly prepared blocks 42C-62-16193.

(2 units)

Precaution: This replacement is applicable to the machines with the Serial Nos. of 50001 and 50002 only. These blocks are not being used with machines of other serial numbers.

