

# PARTS & SERVICE NEWS

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Page 1 of 3

**SUBJECT:** REPAIR OF O-RING OF FRONT AXLE ON GD555, 655, 675-3C

**PURPOSE:** To introduce modification procedure to repair the O-ring of the front axle on GD555, GD655 and GD675-3C motor graders.

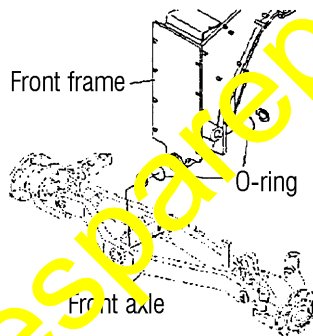
**APPLICATION:** GD555-3C Motor Graders, Serial Nos. 50001 thru 50026  
GD655-3C Motor Graders, Serial Nos. 50001 thru 50069  
GD675-3C Motor Graders, Serial Nos. 50001 thru 50014

**FAILURE CODE:** 2AA7HD

**DESCRIPTION:**

1. Introduction

When the crack occurs to the O-ring of front axle, repair it according to the procedure introduced by this service news.



2. List of parts

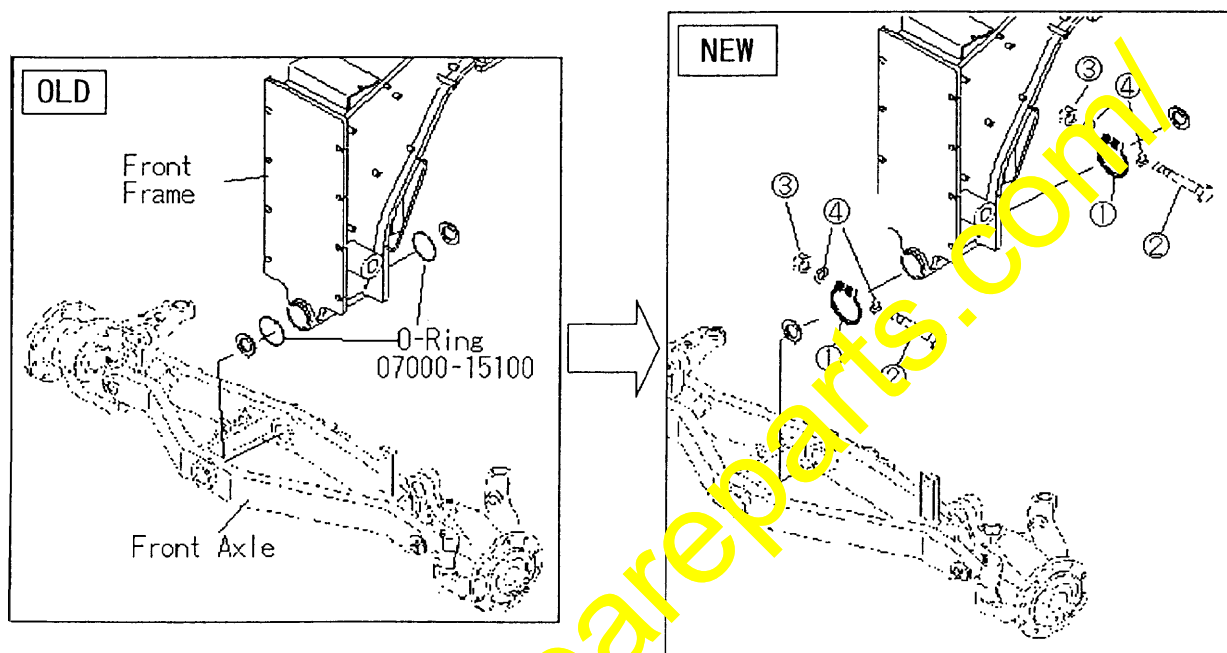
Part No.	Part Name	Purpose of part	Q'ty	Remarks
23E-46-31010 (07000-15100)	O-ring (O-ring)	Replacement	2 (2)	Replace in a set of these 4 items.
419-70-11490	Bolt		2	
01596-00606	Nut	Additional	2	
01640-20610	Washer		4	

3. Items of improvement

- 1) Change of material to prevent degradation of the O-ring by ozone. (CR-7B ← NBR-1B)
- 2) A slit O-ring was developed for easy installation.

4. Modification procedure

- 1) Order new parts and install them as follows.
- 2) See next page for the installation procedure.



No.	Parts Number	Parts Name	Q' ty
①	23B-46-31810	O-RING	2
②	419-70-11490	BOLT	2
③	01596-00606	NUT	2
④	01640-20610	WASHE	4

## Assembly instruction

1. O-ring should be assembled in the direction shown in the drawing.
2. The assembled length(L) of a bolt and nut should be as below.  
The length after tightening = The length before tightening – 1 mm.  
(1 mm = 1 turn of nut)

