

PARTS & SERVICE NEWS

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SUBJECT: REPAIR PROCEDURE OF A/C COMPRESSOR BRACKET ON HM350-1, HM400-1

PURPOSE: To introduce modification procedure to repair the mounting bracket for the air compressor on HM350-1 and HM400-1 articulated dump trucks

APPLICATION: HM350-1 Articulated Dump Trucks, Serial Nos. 1001 thru 1042
HM400-1 Articulated Dump Trucks, Serial Nos. 1001 thru 1068
1071 thru 1076

FAILURE CODE: 874AHA

DESCRIPTION:

1. Introduction

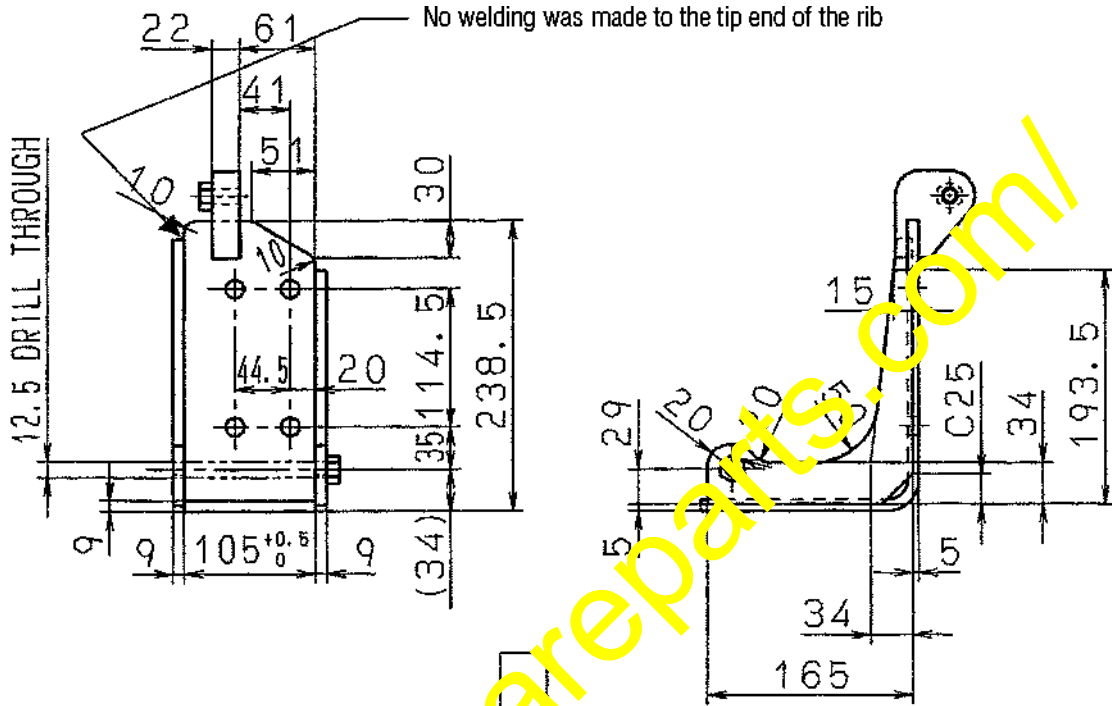
Since there is a possibility of occurrence of cracks in the mounting bracket for the air compressor on the HM350-1 and HM400-1 articulated dump trucks, make the modification being introduced in this Service News to replace the bracket with the improved one.

2. List of parts

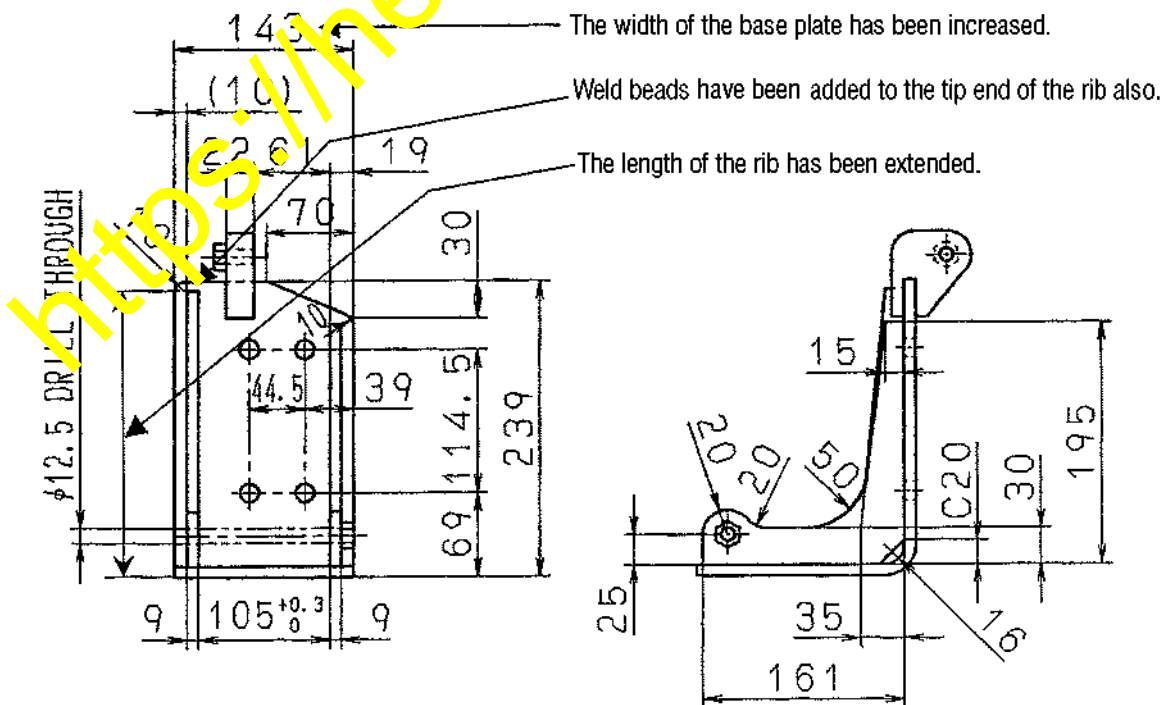
Part No.	Part Name	Purpose of part	Q'ty	Remarks
56B-07-12764 (56B-07-12763)	Bracket (Bracket)	Replacement	1 (1)	

3. Details of the modification

- The shape of the base plate of the bracket has been changed. Also, the installation method of the rib has been changed from welding to the side surface of the base plate to welding the rib onto the base plate.
- The length of the rib has been changed to increase the strength.
- Weld beads have been added to the tip end of the rib also to prevent occurrence of cracks from the welding end.



Current Part No.: 56B-07-12763



New Part No.: 56B-07-12764

Details of the changes made to the bracket

4. Modification procedure

4-1. Preparations before starting the modification work

- (1) Park the vehicle on a flat place, stop the engine and apply chocks under the tires.
- (2) Open the engine hood fully and lock it to the position.

4-2. Modification procedure

(1) Disassembly procedure

- ① Loosen the bolt (01435-01020) to remove the air compressor belt cover (56B-07-12831) for the air compressor of the air conditioning system.
- ② Turning the two nuts (01580-01613) to loosen the tension rod (6240-81-8610), remove the air compressor belt (04120-21766) from the air compressor pulley.
- ③ Loosen the eye joint side bolt (01010-81275) of the tension rod (6240-81-8610) and separate the tension rod from the engine side bracket (56B-07-12763).
 - At this time, do not remove the pin (6215-81-6150) from the tension rod.
- ④ Loosen the bolt (125-70-21210) to remove the air compressor (421-07-31220) and the air compressor side bracket (56B-07-12774) in the assembly state.
- ⑤ Loosen the bolt (01010-81230) and remove the engine side bracket (56B-07-12763).

(Note) Be careful not to lose the reusing parts.

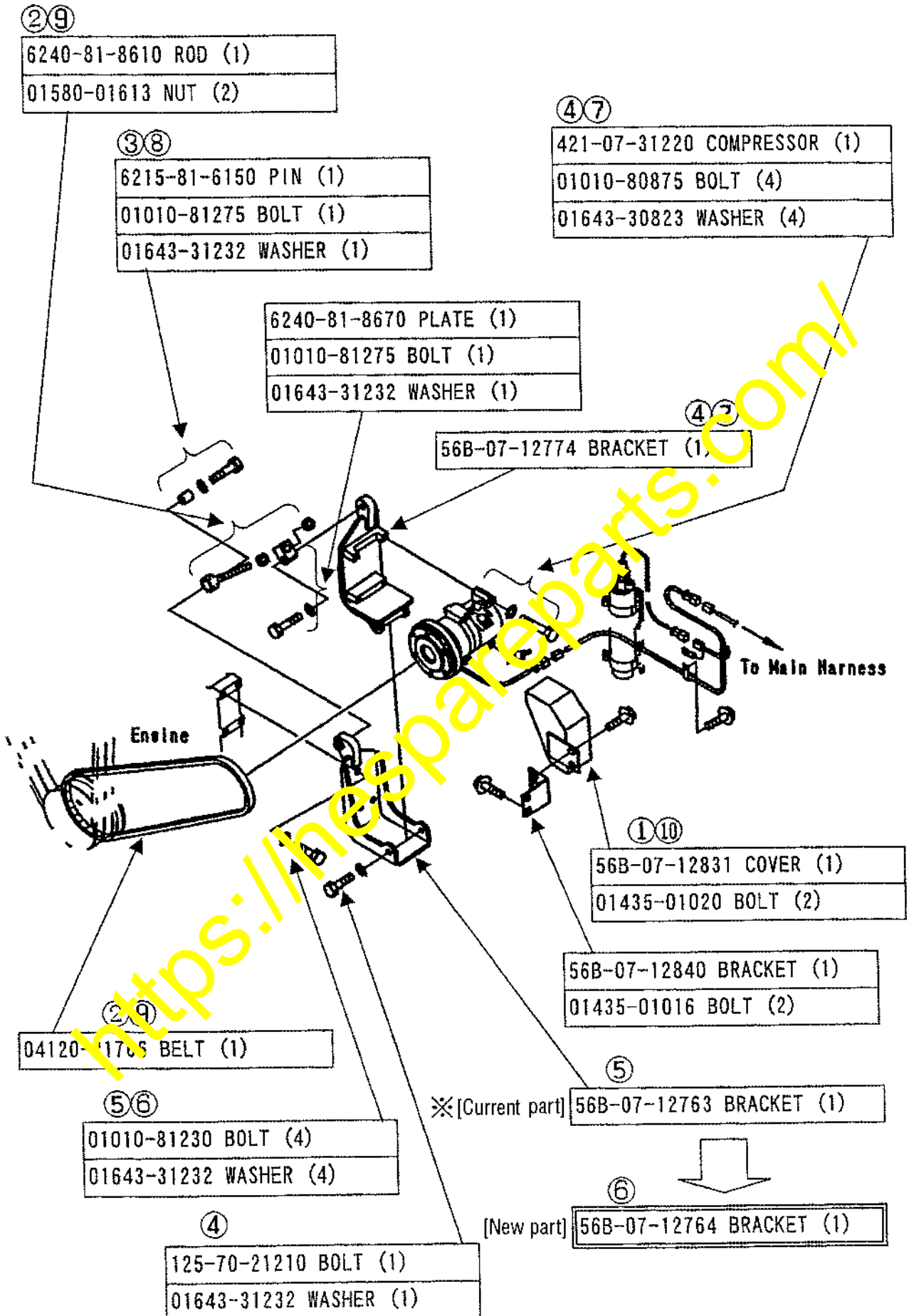
(2) Assembly procedure

- ⑥ Install the improved engine side bracket (56B-07-12764) with the bolt (01010-81230) and washer (01643-31232) to the engine.
- ⑦ Install the previously removed assembly of the air compressor and the bracket onto the engine side bracket with the bolt (175-70-21210) and washer (01643-31232).
- ⑧ Connect the eye joint side of the tension rod (6240-81-8610) to the engine side bracket (56B-07-12764) with the bolt (01010-81275) and washer (01643-31232).
- ⑨ Setting the belt (04120-21766) to the pulley for the air compressor (421-07-31220), turn the nut (01580-01613) of the tension rod (6240-81-8610) to tighten the belt.

(Note) Adjust the belt tension properly. Adjust it so that about 10 mm of deflection occurs when the center point between the air compressor pulley and the drive pulley is depressed by the ball of the thumb (at about 59 N {6 kgf}).

Install the nut (01580-01613) to both sides of the plate (6240-81-8670) securely.

- ⑩ Install the air compressor cover (56B-07-12831) with the bolt (01435-01020).



(Note) Numbers in circles stand for the sequence numbers of the disassembly and reassembly processes. Except for the ※ marked part, all the parts indicated here are being reused.