

PARTS & SERVICE NEWS

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SUBJECT: COUNTERMEASURE OF BODY PROTECTOR CRACK ON HM350-1, HM400-1

PURPOSE: To introduce modification procedure to prevent occurrence of cracks in the body protector area on HM400-1 and HM350-1 articulated dump trucks

APPLICATION: HM400-1 Articulated Dump Trucks, } Refer to page 2.
HM350-1 Articulated Dump Trucks, }

FAILURE CODE: 7940HA

DESCRIPTION:

1. Introduction

There is a possibility of occurrence of cracks in the welded section of the body protector rib on the HM400-1 and HM350-1 articulated dump trucks. To prevent the occurrence of the aforementioned cracks, make the modification following the procedure being outlined in this Service News.

2. List of part

Part No.	Part Name	Purpose of part	Q'ty	Remarks
(56B-99-11990)	(Plate)	Addition	(3)	

3. Table of the applicable vehicles to this modification

HM400-1: Table of Serial No. of the applicable vehicles
(Total 59 vehicles)

HM350-1: Table of Serial No. of the applicable vehicles (Total 37 vehicles)

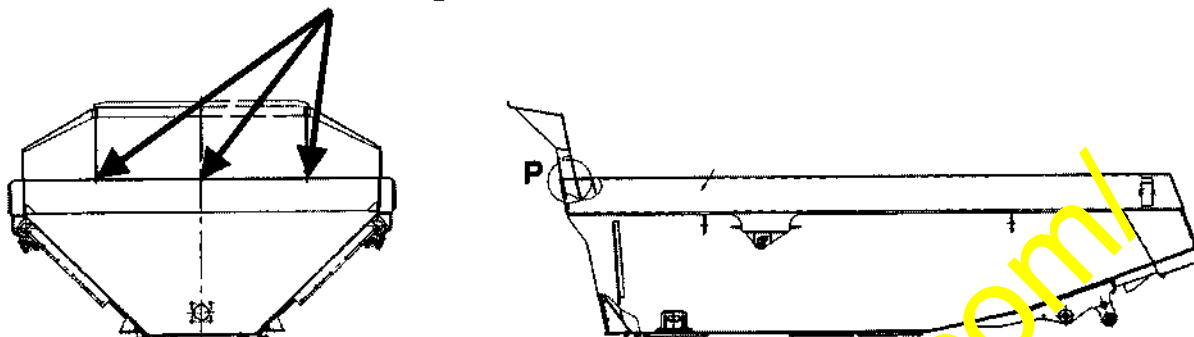
No.	Country	Model	Serial No.	Destination	Customer's name
1	U.S.A.	HM400-1	1001	U.S.A.	
2	(47 vehicles)	HM400-1	1002	U.S.A.	
3		HM400-1	1003	U.S.A.	
4		HM400-1	1007	U.S.A.	Longhorn Excavating
5		HM400-1	1008	U.S.A., MD	Central Contracting
6		HM400-1	1010	U.S.A., TX	Longhorn Excavating
7		HM400-1	1014	U.S.A., TX	Longhorn Excavating
8		HM400-1	1015	U.S.A., TX	Longhorn Excavating
9		HM400-1	1016	U.S.A., OK	Martin Marietta
10		HM400-1	1017	U.S.A., OH	Sidwell Materials
11		HM400-1	1018	U.S.A., OH	Sidwell Materials
12		HM400-1	1019	U.S.A., OH	Sidwell Materials
13		HM400-1	1020	U.S.A., AK	City of Fort Smith
14		HM400-1	1021	U.S.A., FL	URS Corporation
15		HM400-1	1022	U.S.A., FL	URS Corporation
16		HM400-1	1023	U.S.A., MD	Central Contracting
17		HM400-1	1028	U.S.A., FL	URS Corporation
18		HM400-1	1029	U.S.A., FL	URS Corporation
19		HM400-1	1030	U.S.A., TX	Longhorn Excavating
20		HM400-1	1031	U.S.A., TX	Longhorn Excavating
21		HM400-1	1033	U.S.A., TX	Longhorn Excavating
22		HM400-1	1034	U.S.A., FL	McDonald Construction
23		HM400-1	1035	U.S.A., FL	McDonald Construction
24		HM400-1	1036	U.S.A., OH	Sidwell Materials
25		HM400-1	1037	U.S.A., FL	McDonald Construction
26		HM400-1	1038	U.S.A., OH	Sidwell Materials
27		HM400-1	1039	U.S.A., OH	Sidwell Materials
28		HM400-1	1040	U.S.A., TX	Lattimore Materials
29		HM400-1	1041	U.S.A., OH	Sidwell Materials
30		HM400-1	1042	U.S.A.	
31		HM400-1	1043	U.S.A.	
32		HM400-1	1044	U.S.A.	
33		HM400-1	1046	U.S.A.	
34		HM400-1	1048	U.S.A.	
35		HM400-1	1049	U.S.A.	
36		HM400-1	1053	U.S.A.	
37		HM400-1	1054	U.S.A.	
38		HM400-1	1055	U.S.A.	
39		HM400-1	1056	U.S.A.	
40		HM400-1	1057	U.S.A.	
41		HM400-1	1058	U.S.A.	
42		HM400-1	1059	U.S.A.	
43		HM400-1	1060	U.S.A.	
44		HM400-1	1061	U.S.A.	
45		HM400-1	1062	U.S.A.	
46		HM400-1	1063	U.S.A.	
47		HM400-1	1064	U.S.A.	
48		Indonesia	HM400-1	1026	Indonesia
49	Australia	HM400-1	1071	Australia	
50	(6 vehicles)	HM400-1	1072	Australia	
51		HM400-1	1073	Australia	
52		HM400-1	1074	Australia	
53		HM400-1	1075	Australia	
54		HM400-1	1076	Australia	
55		Rep. of South Africa (3 vehicles)	HM400-1	1024	Rep. of South Africa
56	HM400-1		1025	Rep. of South Africa	
57	HM400-1		1047	Rep. of South Africa	
58	Belgium (2 vehicles)	HM400-1	1065	Belgium	
59		HM400-1	1067	Belgium	

No.	Country	Model	Serial No.	Destination	Customer's name
1	U.S.A.	HM350-1	1001	U.S.A., OK	United General
2	(34 vehicles)	HM350-1	1002	U.S.A., FL	URS Corporation
3		HM350-1	1003	U.S.A., OH	Beaver Excavating
4		HM350-1	1005	U.S.A., OH	Beaver Excavating
5		HM350-1	1007	U.S.A., MS	Eutaw Construction
6		HM350-1	1008	U.S.A., MS	Eutaw Construction
7		HM350-1	1010	U.S.A., MS	Eutaw Construction
8		HM350-1	1012	U.S.A., MS	Eutaw Construction
9		HM350-1	1013	U.S.A., MS	Eutaw Construction
10		HM350-1	1014	U.S.A., OK	United General
11		HM350-1	1015	U.S.A.	
12		HM350-1	1016	U.S.A.	
13		HM350-1	1017	U.S.A., OK	United General
14		HM350-1	1018	U.S.A.	
15		HM350-1	1019	U.S.A.	
16		HM350-1	1020	U.S.A.	
17		HM350-1	1021	U.S.A.	
18		HM350-1	1022	U.S.A.	
19		HM350-1	1023	U.S.A.	
20		HM350-1	1024	U.S.A.	
21		HM350-1	1025	U.S.A.	
22		HM350-1	1026	U.S.A.	
23		HM350-1	1027	U.S.A.	
24		HM350-1	1028	U.S.A.	
25		HM350-1	1029	U.S.A.	
26		HM350-1	1030	U.S.A.	
27		HM350-1	1031	U.S.A.	
28		HM350-1	1032	U.S.A.	
29		HM350-1	1033	U.S.A.	
30		HM350-1	1034	U.S.A.	
31		HM350-1	1035	U.S.A.	
32		HM350-1	1036	U.S.A.	
33		HM350-1	1037	U.S.A.	
34		HM350-1	1038	U.S.A.	
35		Belgium	HM350-1	1039	Belgium
36	(2 vehicles)	HM350-1	1040	Belgium	
37		Russia	HM350-1	1042	C.I.S.

4. Details of the modification

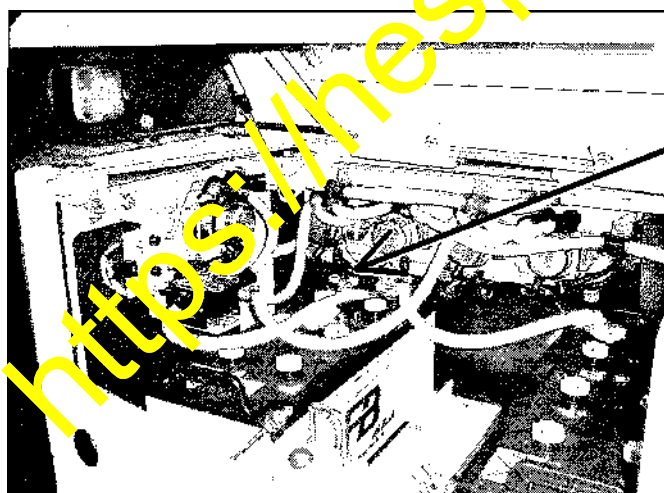
Reinforcement plates are to be welded to the toes of weld of the body protector rib.

Places where cracks may occur
(in the (P) section)



5. Preparations before starting the modification work

- 1) Park the vehicle on a flat place and apply chocks to the tires.
- 2) To protect the electronic equipment and devices, disconnect the cable from the (+) terminal of the battery.

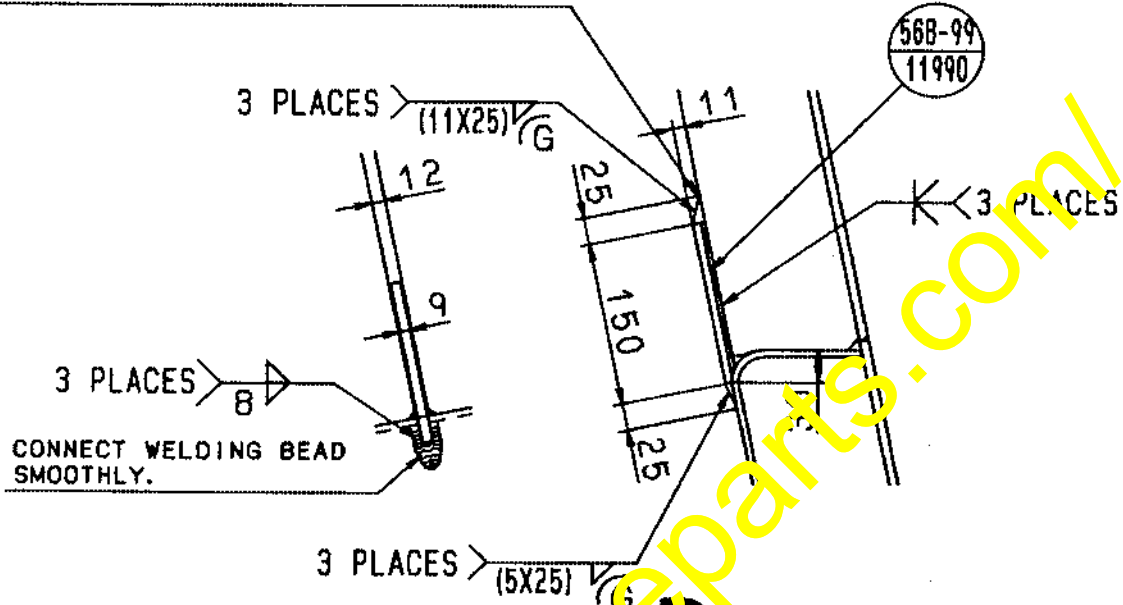


Disconnect the cable from the (+) terminal of the battery.

6. Modification procedure

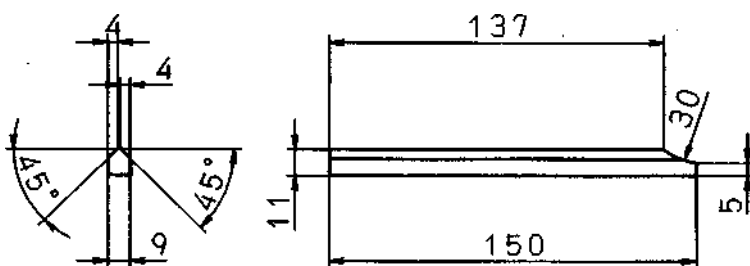
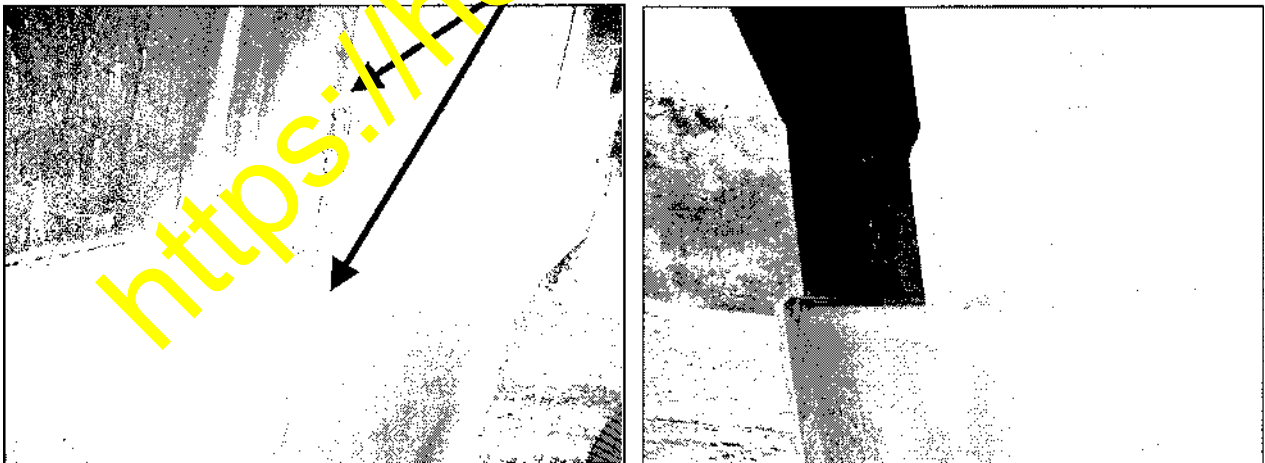
- 1) Wash the modifying section.
- 2) If cracks are already occurring or when the paint has been peeled off and rust is occurring, repair the defective sections completely before welding the reinforcement plates as per the instructions given below.

EXTENDED BEAD ENDS TO BE SMOOTHLY BLENDED WITH BASE METALS.



- 3) Check that welding defects (undercuts or overlaps) are not occurring at the toes of weld.
- 4) Wash the reinforcement plates and the welded sections before applying paint.

Finish the toes of weld smoothly using a grinder.



Detail drawing of the part
56B-99-11990

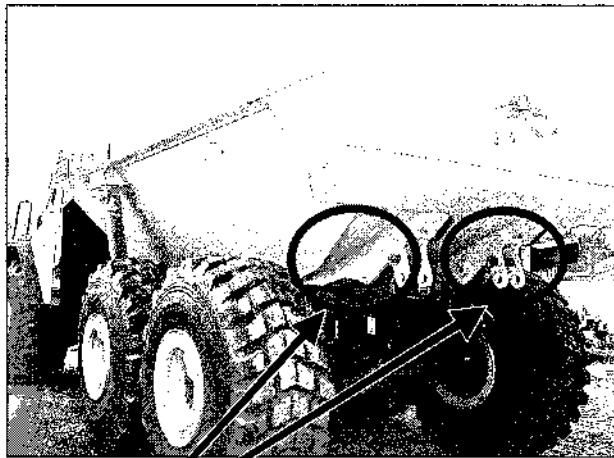
Material : SS400P

Necessary q'ty : 3 pcs./vehicle

7. The check of cracks in the welded section of the hinge bracket

After fully washed the hinge bracket periphery, perform a color check for the welded section as shown below to see if cracks are occurring or not.

If cracks are occurring, perform welding modification after removing cracks by gouging.



Check if cracks are occurring or not at the right and left sides.



welded section to check if cracks are occurring or not.

Welding drawing of the hinge bracket

