

**PARTS & SERVICE
NEWS**

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(C)

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SUBJECT: REPAIR PROCEDURE FOR EXHAUST MANIFOLD GASKET FOR SA12V140 ENGINES

PURPOSE: To introduce modification procedure to repair the breakage failure of the exhaust manifold gasket for the SA12V140 engines

APPLICATION: Refer to page 3

FAILURE CODE: A1PDFF

DESCRIPTION:

1. Introduction

- When the exhaust manifold gasket becomes broken by thermal expansion or contraction of the exhaust manifold for the SA12V140 engines, resulting in gas leakage failure, make the modification introduced in this Service News to repair the failure.
- When making reassembly after overhauling, install the improved gasket following the modification procedure described in this Service News.

2. List of parts

Part No.	Part Name	Purpose of part	Q'ty	Remarks
6218-11-5880 (6210-11-5881)	Gasket (Gasket)	Replacement	12 (12)	
6212-15-5831	Gasket		2	Consumable parts (For the mounting surface of the turbocharger)
02895-77075	O-Ring		8	Consumable parts (For the crossover connector section of the turbocharger)
6151-51-8167	Gasket		2	Consumable parts (For the oil inlet port of the turbocharger)
6151-51-8151	Gasket		2	Consumable parts (For the oil inlet port of the turbocharger)
6164-32-8241	Gasket		4	Consumable parts (For the water inlet/outlet port of the turbocharger)
07003-01419	Gasket		6	Consumable parts (For the water inlet/outlet port of the turbocharger)
6211-11-5890	Gasket		2	For the mounting section of the muffler (On D475 and WA800 Series machines only)

3. Details of the modification

- (1) Molybdenum disulfide coating is being applied to the exhaust manifold gasket on the contact surface side to the exhaust manifold.
(Even if the exhaust manifold moves by thermal deformation, the gasket will slip to avoid deformation. (To suppress the occurring stress))
- (2) The structure of the gasket has been changed from 3 layer structure to 5 layer structure to equalize the surface pressure of the gasket, and also, to suppress relative deformation.

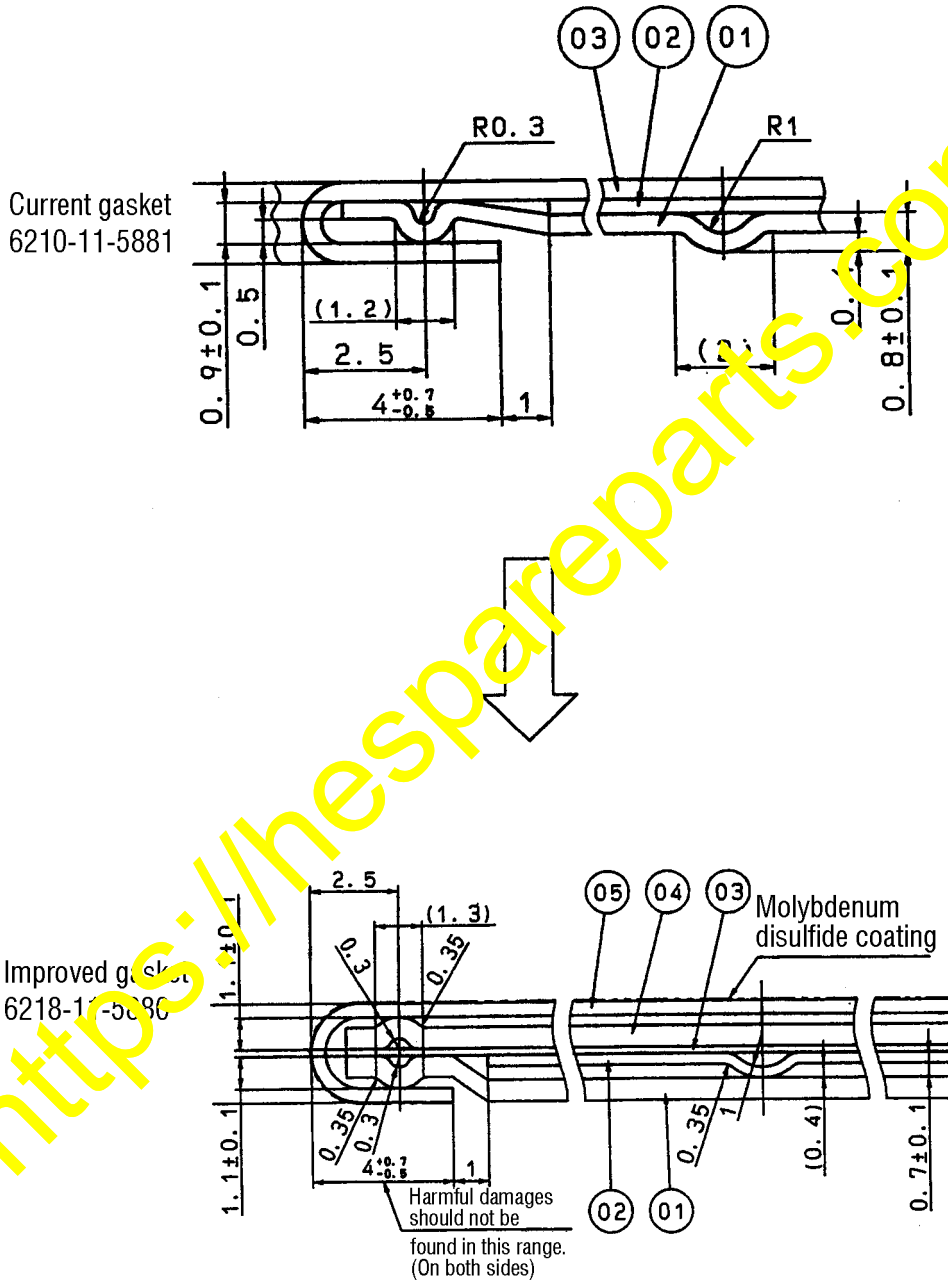


Fig. 1

4. Disassembly and reassembly

Carry out this modification following the instructions given in the Shop Manual.

(Check table for the serial numbers of the machines applicable to the design change per this Service News)

(Part No. change: 6210-11-5881 → 6218-11-5880)

No.	Applicable machine model	Serial No. of the engine		Modification starting from	Serial No. of the machine		Modification starting from
		Engines in the field	Engines shipped with the modification completed		Machines in the field	Machines shipped with the modification completed	
1	HD785-3		From the next shipment and up				
2	HD785-5	Up to 13614	13620 and up	2/24	Up to 4477	4478 and up	4/3
3	HD985-3		From the next shipment and up				
4	HD985-5		From the next shipment and up				
5	HD785-2*	Up to 13603	From the next shipment and up				
6	HD785-JK-5	Up to 13466	From the next shipment		Up to J10042	J10043 and up	
7	D475A-2		From the next shipment				
8	D475A-3		From the next shipment				
9	D475A-5	Up to 13580	13616	2/25	Up to 20021	20022 and up	
10	HV700-2		From the next shipment and up				
11	WA800-1		From the next shipment and up				
12	WA800-2		From the next shipment and up				
13	WA800-3	Up to 13627	13638	3/11	Up to 50043 Up to 51003	50044 and up 51004 and up	
14	WA900-1		From the next shipment and up				
15	WA900-3	Up to 13638	13639	3/15	Up to 50036	50037 and up	
16	WD900-3		From the next shipment and up				