

# PARTS & SERVICE NEWS

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(C)

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**SUBJECT:** REPAIR PROCEDURE FOR CRACKS IN FINAL DRIVE CASE REAR COVER SUPPORTING SECTION

**PURPOSE:** To inform Field Personnel

**APPLICATION:** GD825A-2 Motor Grader,S/N 12095 thru 12131

**FAILURE CODE:** 2B7BHB

**DESCRIPTION:**

1. Introduction:

When cracks are found in the final drive case rear cover supporting section of the motor graders, there is a possibility of adhesion of paint, oil, grease, etc. to the mounting surface (cap section) to the rear frame of the final drive side case section. Carry out the modification introduced in this **PARTS & SERVICE NEWS** to repair the cracks and to clean the mounting surface and the cap section.

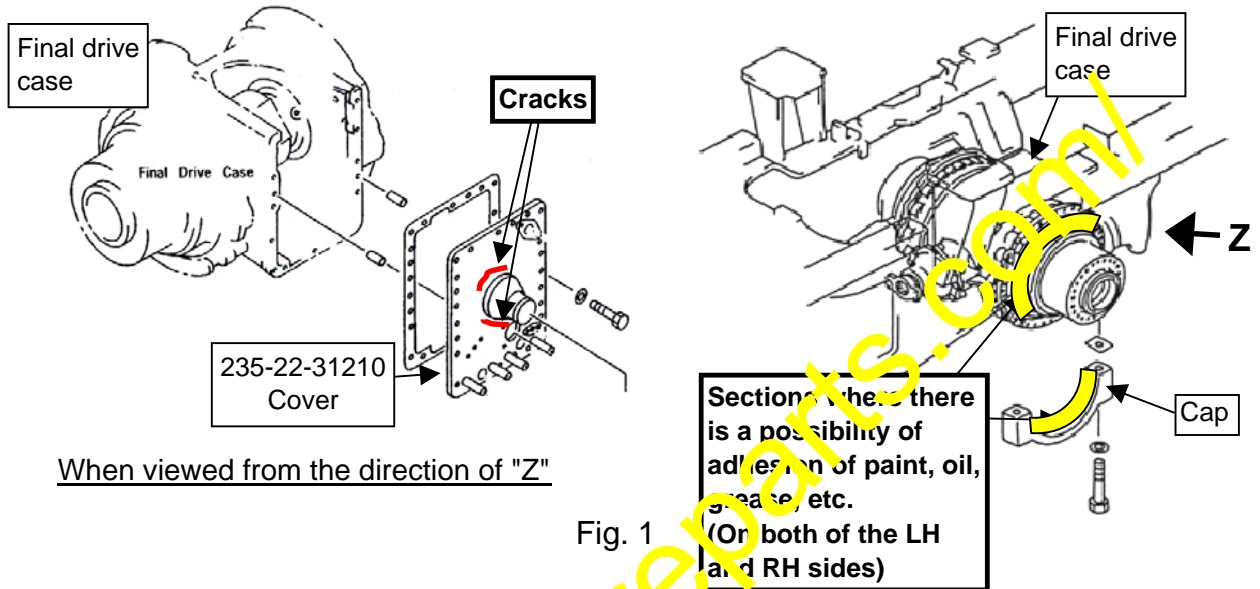
2. List of Parts:

Part No.	Part Name	Purpose of Part	Qty.	Remarks
235-22-31210 (235-22-31210)	Cover (Cover)	Replacement	1 (1)	Replace it since cracks occurred
235-22-31222 (235-22-31222)	Gasket (Gasket)		1 (1)	Consumable parts
04020-01638 (04020-01638)	Pin, Dowel (Pin, Dowel)		2 (2)	For replacement of the cover
07002-12434 (07002-12434)	O-Ring (O-Ring)		2 (2)	Consumable parts
07000-13022 (07000-13022)	O-Ring (O-Ring)		1 (1)	
07000-12070 (07000-12070)	O-Ring (O-Ring)		1 (1)	
07000-13045 (07000-13045)	O-Ring (O-Ring)		1(1)	
235-46-00010 (235-46-00010)	Shim Assembly (Shim Assembly)			1 (1)

### 1. Details of the modification

When cracks are found in the final drive case rear cover supporting section, since there is a possibility of adhesion of paint, oil, grease, etc. to the mounting surface (cap section) to the rear frame of the final drive side case section. Cleaning the section at the same time when making the replacement work for the rear cover.

\* If the replacement work for the rear cover only is carried out omitting the cleaning work, cracks may occur once again in a short period of time.



### 2. Modification procedure

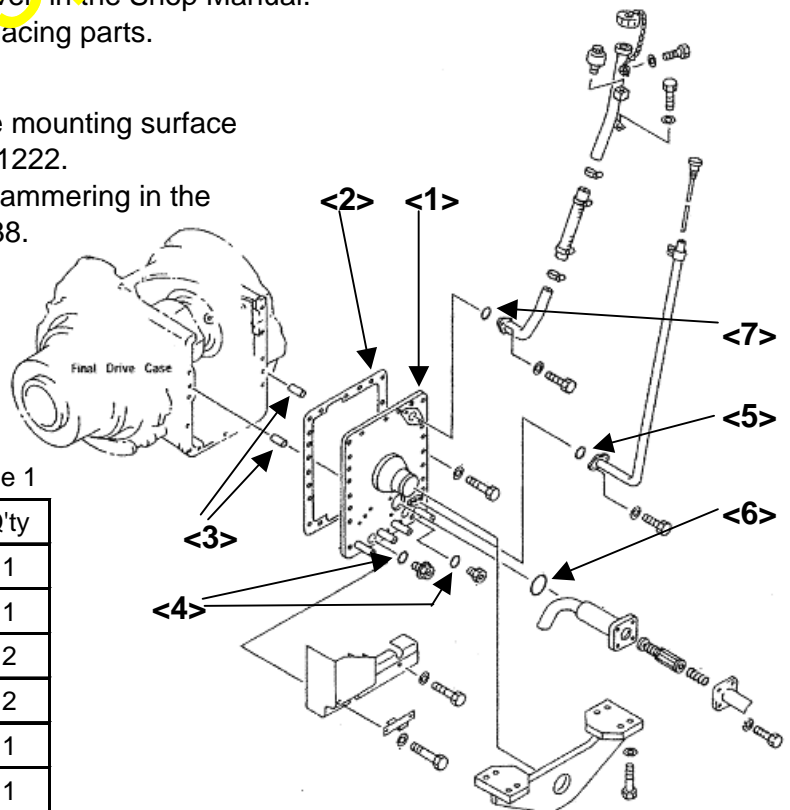
#### 2-1. Replacement of the final drive case rear cover

Replace the cracked rear cover and consumable parts following the instructions given in the Shop Manual. Refer to Table 1 for the replacing parts.

Notes:

Apply LG-1 to the case side mounting surface of the gasket <2> 235-22-31222.

Make cross caulking after hammering in the dowel pins <3> 04020-01638.



List of replacing parts

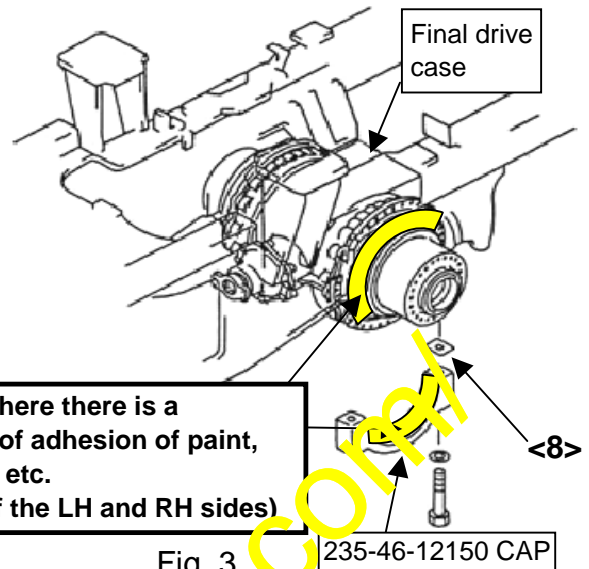
Table 1

No.	Part No.	Part name	Q'ty
<1>	235-22-31210	COVER	1
<2>	235-22-31222	GASKET	1
<3>	04020-01638	PIN,DOWEL	2
<4>	07002-12434	O-RING	2
<5>	07000-13022	O-RING	1
<6>	07000-12070	O-RING	1
<7>	07000-13045	O-RING	1

2-2. Cleaning of the mounting surface to the rear frame of the final drive side case section

- Remove the final drive & tandem ass'y, in the ass'y state, from the rear frame following the instructions given in the Shop Manual.
- Clean the mounting surface to the rear frame of the final drive side case section and the surface of the cap 235-46-12150 shown in Fig. 3 using sand paper and, after that, carry out degreasing work to remove adhered paint chips, oil, grease, etc.

(Clean the mounting surface and the cap on both of the LH and RH sides.)



Sections where there is a possibility of adhesion of paint, oil, grease, etc. (On both of the LH and RH sides)

Fig. 3

235-46-12150 CAP

2-3. Reinstallation of the axle and readjustment of the shims

- Reinstall the final drive & tandem ass'y which has been removed in the assembly state to the rear frame following the instructions given in the Shop Manual.
- Readjust the shim ass'y <8> 235-46-00010 following the procedure described below.

[Shim adjustment procedure]

- 1) Tighten the "A" side bolt. (Specified tightening torque: 250 - 310 kgm)
- 2) Tighten the "B" side bolt. (Specified tightening torque: 250 - 310 kgm)
- 3) Measure the "B" side clearance.
- 4) After loosening both of the "A" side bolt and "B" side bolt, insert the shims of 1/2 of the dimension of the clearance which has been measured by the above Process 3) to both of the "A" side and "B" side, respectively.  
After that, tighten the bolts at the specified tightening torque.  
\* Apply LT-2 to the thread surface.
- 5) Make sure that there is no gap at the contact sections (the sections where shims have been inserted).

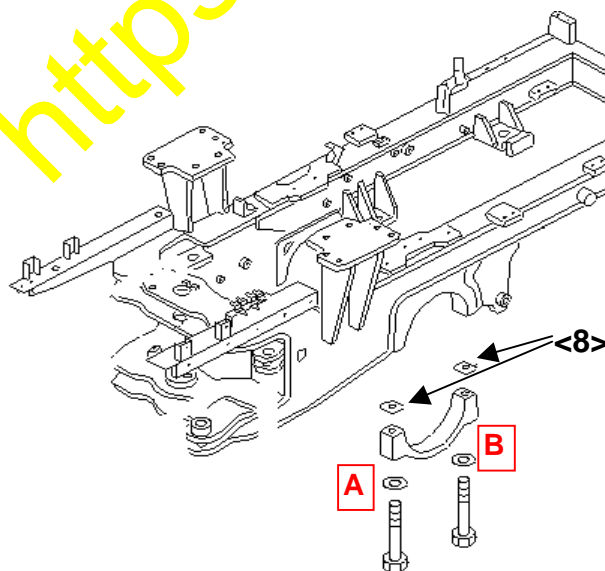


Fig. 4

List of using parts Table 2

No.	Part No.	Part name	Q'ty
<8>	235-46-00010	SHIM ASSY	1