

PARTS & SERVICE NEWS

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SUBJECT: MODIFICATION OF THE AXLE SUPPORT RUBBER BUSHING FIXING PLATE

PURPOSE: To inform field personnel.

APPLICATION: HM350-1: 1001-1072
HM400-1: 1001-1139

FAILURE CODE: 5A52FA

DESCRIPTION:

Introduction

When rubber bush failed due to axle support fixing plate bolts are broken on HM350-1 and HM400-1, please repair in accordance with this Service News.

List of Parts

Part No.	Part Name	Purpose of Part	Qty	Remarks
56B-50-12142 (56B-50-12141)	Plate (Plate)	Replacement	3 (3)	
01010-81230 (01010-81230)	Bolt (Bolt)	Replacement	30 (30)	Articles of Consumption
01010-82475 (01010-82475)	Bolt (Bolt)	Replacement	12 (12)	Articles of Consumption
56B-50-12330 (56B-50-12330)	Bearing (Bearing)	Replacement	3 (3)	Articles of Consumption

1. Improvements

The thickness of the rubber bushing fixing plate has been changed from t9 to t14 to increase the rigidity of the plate. It decreases the stress applied to the bolt and prevents the bolts from being broken. (See Fig. 1)

If the bolts are broken, the rubber bushing will not be fixed in the axial direction and it will become broken.

If the bolts are broken with any of the axles, replace the rubber bushing also at the same time.

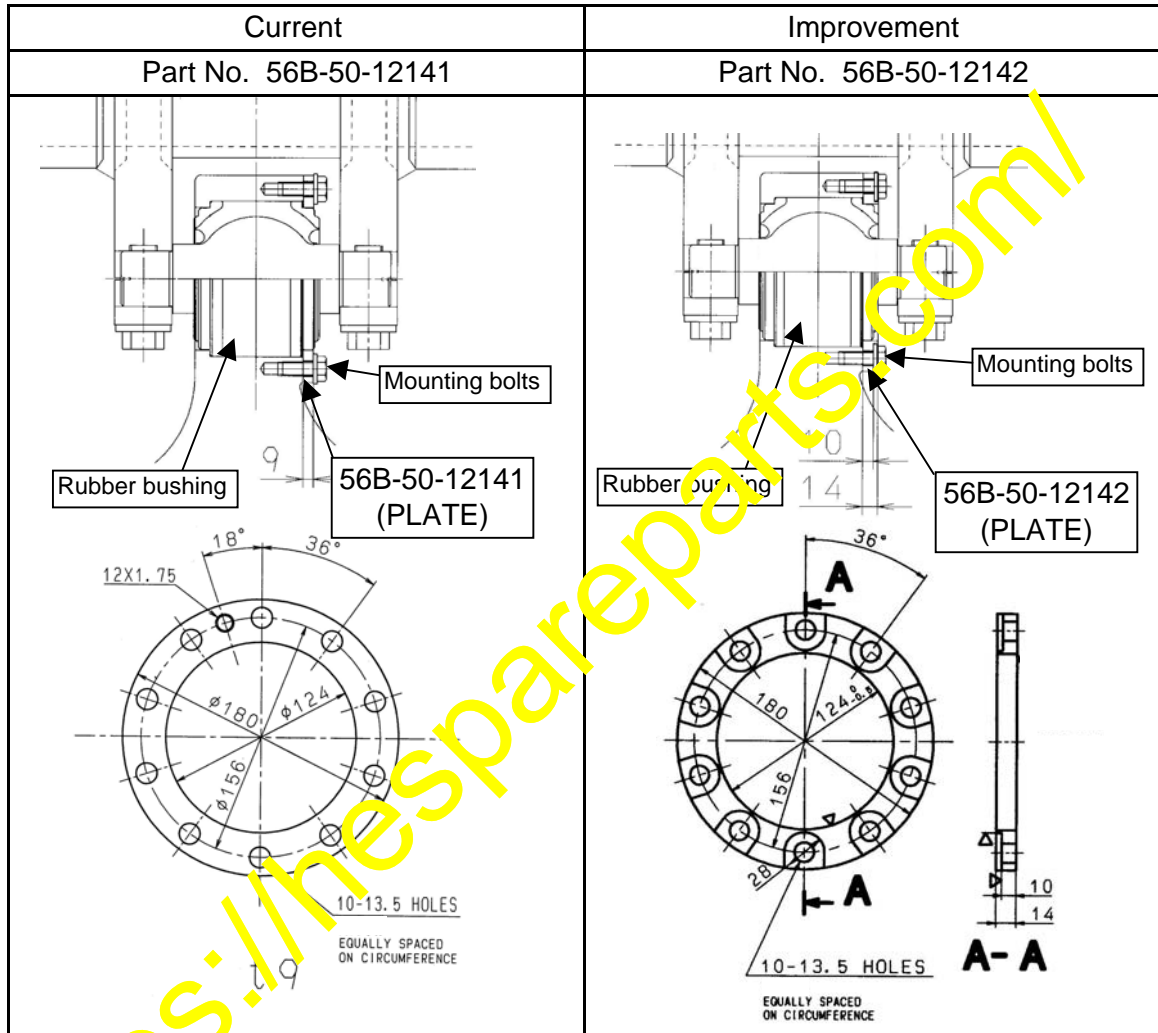


Fig. 1

2. Sections applicable to this modification

<HM350>

	Front axle		Center axle		Rear axle	
	Current	Improved	Current	Improved	Current	Improved
Plate Part No.	56B-50-12141	56B-50-12142	56B-50-12141	56B-50-12142	56B-50-12141	56B-50-12142
Bolt Part No.	01010-81230(10)	←	01010-81230(10)	←	01010-81230(10)	←
Bolt tightening torque	98 - 123 Nm Tighten with a set wrench.		98 - 123 Nm Tighten with a set wrench.		98 - 123 Nm Tighten with a set wrench.	
Notes	Tighten the bolts for 2 to 3 times each until the tightening torque is stabilized.		←		←	

<HM400>

	Front axle		Center axle		Rear axle	
	Current	Improved	Current	Improved	Current	Improved
Plate Part No.	56B-50-12141	56B-50-12142	56B-50-12141	56B-50-12142	56B-50-12141	56B-50-12142
Bolt Part No.	01010-81225(10)	01010-81230(10)	01010-81230(10)	←	01010-81230(10)	←
Bolt tightening torque	98 - 123 Nm Tighten with a set wrench.		98 - 123 Nm Tighten with a set wrench.		98 - 123 Nm Tighten with a set wrench.	
Notes	Tighten the bolts for 2 to 3 times each until the tightening torque is stabilized.		←		←	

Change the bolt length for the front axle on HM400 only.

3. Modification procedure

Make the modification work following the procedure indicated in Fig. 2 thru Fig. 7 for the axle with which the rubber bushing fixing plate has been broken.

Before starting the modification work, park the machined on a flat place and apply chocks to the tires.

3-1 HM350-1

3-1-1 Front axle

- 1) Axle support arm holding plate (56B-50-12150)
Loosen the mounting bolts (01010-82475) and remove the arm from the machine.
- 2) Replace the rubber bushing fixing plate with the improved one.
- 3) Replace the rubber bushing and mounting bolts with new parts and restore the original state.

Rubber bushing fixing plate
Mounting bolts
01010-81230 (10)
(Replace with a new one)
Tightening torque: 98 - 123 Nm

Rubber bushing fixing plate
56B-50-12141
↓
56B-50-12142

Bolt
01010-82475 (4)
(Replace with a new one)
Tightening torque: 785 - 980 Nm

3-1-2 Center axle

- 1) Axle support arm holding plate (56B-50-12150)
Loosen the mounting bolts (01010-82475) and remove the arm from the machine.
- 2) Replace the rubber bushing fixing plate with the improved one.
- 3) Replace the rubber bushing and mounting bolts with new parts and restore the original state.

Rubber bushing fixing plate
Mounting bolts
01010-81230 (10)
(Replace with a new one)
Tightening torque: 98 - 123 Nm

Rubber bushing fixing plate
56B-50-12141
↓
56B-50-12142

Bolt
01010-82475 (4)
(Replace with a new one)
Tightening torque: 785 - 980 Nm

Arm holding plate
56B-50-12150
(To be reused)

3-1-3 Rear axle

- 1) Axle support arm holding plate (56B-50-12150)
Loosen the mounting bolts (01010-82475) and remove the arm from the machine.
- 2) Replace the rubber bushing fixing plate with the improved one.
- 3) Replace the rubber bushing and mounting bolts with new parts and restore the original state.

Rubber bushing
56B-50-12330
(Replace with a new one)

Arm holding plate
56B-50-12150
(To be reused)

Rubber bushing fixing plate
Mounting bolts
01010-81230 (10)
(Replace with a new one)
Tightening torque: 98 - 123 Nm

Rubber bushing fixing plate
56B-50-12141
↓
56B-50-12142

Rubber bushing
56B-50-12330
(Replace with a new one)

Axle support arm holding plate
56B-50-12150
(To be reused)

Rubber bushing
56B-50-12330
(Replace with a new one)

Axle support arm
Bolt
01010-82475 (4)
(Replace with a new one)
Tightening torque: 785 - 980 Nm

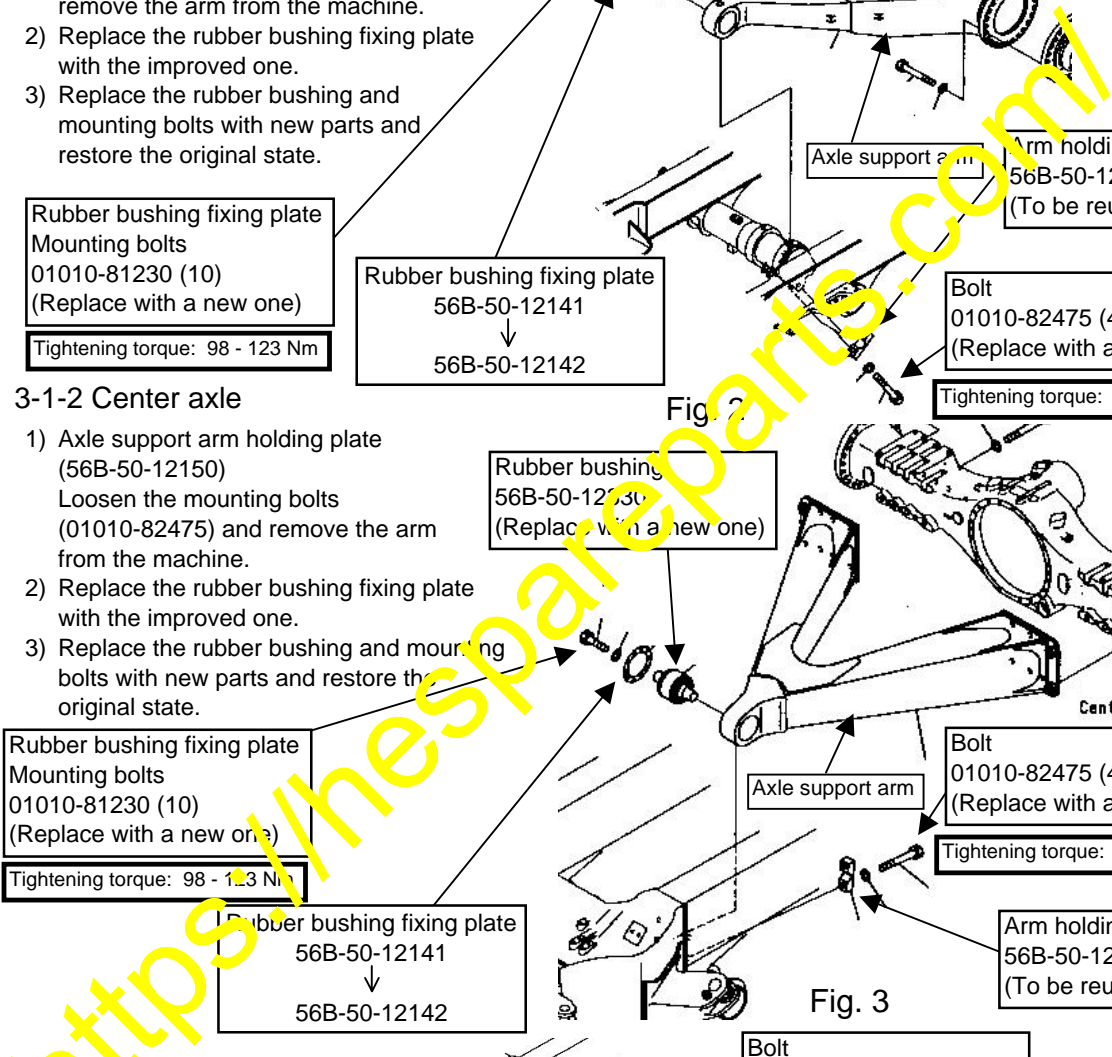
Rear Frame
Bolt
01010-82475 (4)
(Replace with a new one)
Tightening torque: 785 - 980 Nm

Rear Axle Housing
Axle support arm

Fig. 2

Fig. 3

Fig. 4



3-2 HM400-1

3-2-1 Front axle

- 1) Axle support arm holding plate (56B-50-12150)
Loosen the mounting bolts (01010-82475) and remove the arm from the machine.
- 2) Replace the rubber bushing fixing plate and mounting bolts with the improved one.
- 3) Replace the rubber bushing with new parts and restore the original state.

Rubber bushing fixing plate
Mounting bolts
01010-81225 (10)
↓
01010-81230 (10)
Tightening torque: 98 - 123 Nm

Rubber bushing fixing plate
56B-50-12141
↓
56B-50-12142

Rubber bushing
56B-50-12330
(Replace with a new one)

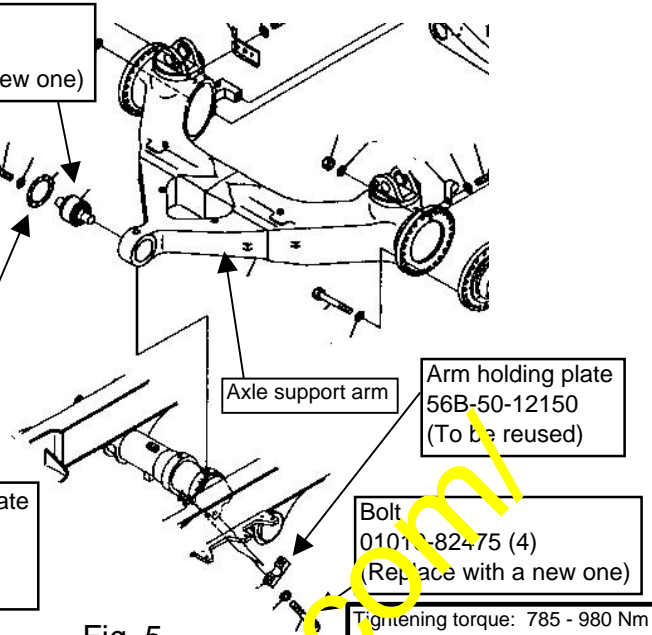


Fig. 5

3-2-2 Center axle

- 1) Axle support arm holding plate (56B-50-12150)
Loosen the mounting bolts (01010-82475) and remove the arm from the machine.
- 2) Replace the rubber bushing fixing plate with the improved one.
- 3) Replace the rubber bushing and mounting bolts with new parts and restore the original state.

Rubber bushing fixing plate
Mounting bolts
01010-81230 (10)
(Replace with a new one)
Tightening torque: 98 - 123 Nm

Rubber bushing fixing plate
56B-50-12141
↓
56B-50-12142

Rubber bushing
56B-50-12330
(Replace with a new one)

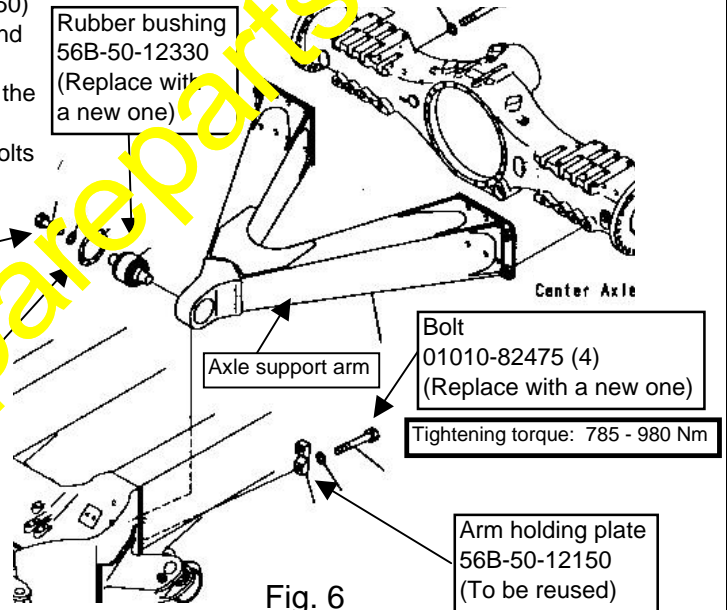


Fig. 6

3-2-3 Rear axle

- 1) Axle support arm holding plate (56B-50-12150)
Loosen the mounting bolts (01010-82475) and remove the arm from the machine.
- 2) Replace the rubber bushing fixing plate with the improved one.
- 3) Replace the rubber bushing and mounting bolts with new parts and restore the original state.

Rubber bushing fixing plate
Mounting bolts
01010-81230 (10)
(Replace with a new one)
Tightening torque: 98 - 123 Nm

Rubber bushing fixing plate
56B-50-12141
↓
56B-50-12142

Rubber bushing
56B-50-12330
(Replace with a new one)

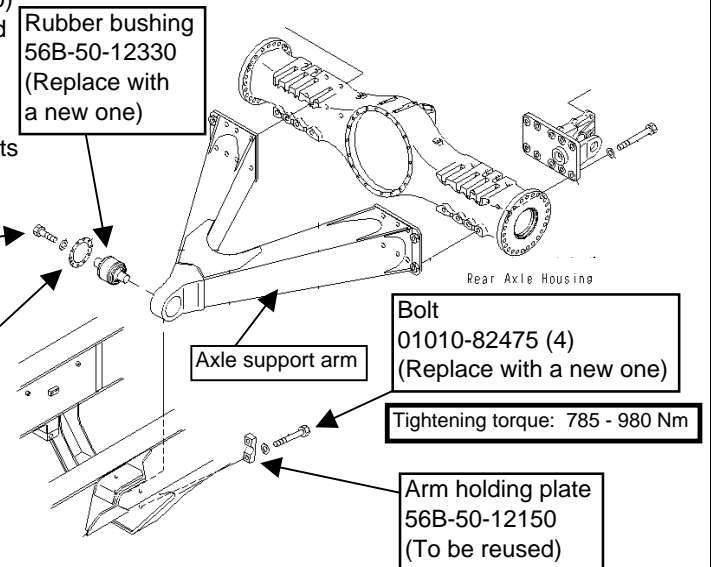


Fig. 7