

PARTS & SERVICE NEWS

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SUBJECT: REPAIR PROCEDURE FOR TAIL GATE (OPTION) ON HM400-1

PURPOSE: To introduce modification procedure to replace the tail gate on HM400-1 articulated dump trucks with the improved parts (optional)

APPLICATION: HM400-1 Articulated Dump Trucks, Serial Nos. 1071 thru 1076
Serial Nos. 1087 thru 1088
Serial Nos. 1118 thru 1119

FAILURE CODE: 792SEA

DESCRIPTION:

1. Introduction

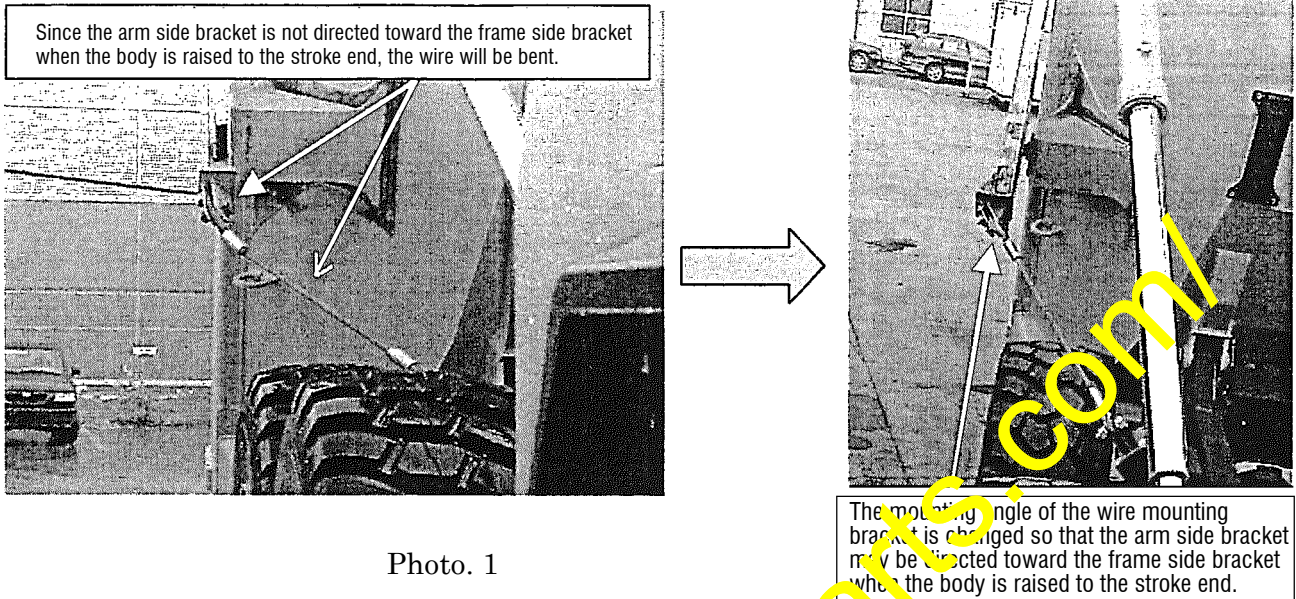
On the HM400-1 articulated dump trucks, the arm of the tail gate may be deformed to cause interference with the body. If the interference occurs with the tail gate arm, make the modification introduced in this Service News to repair the interference.

2. List of parts

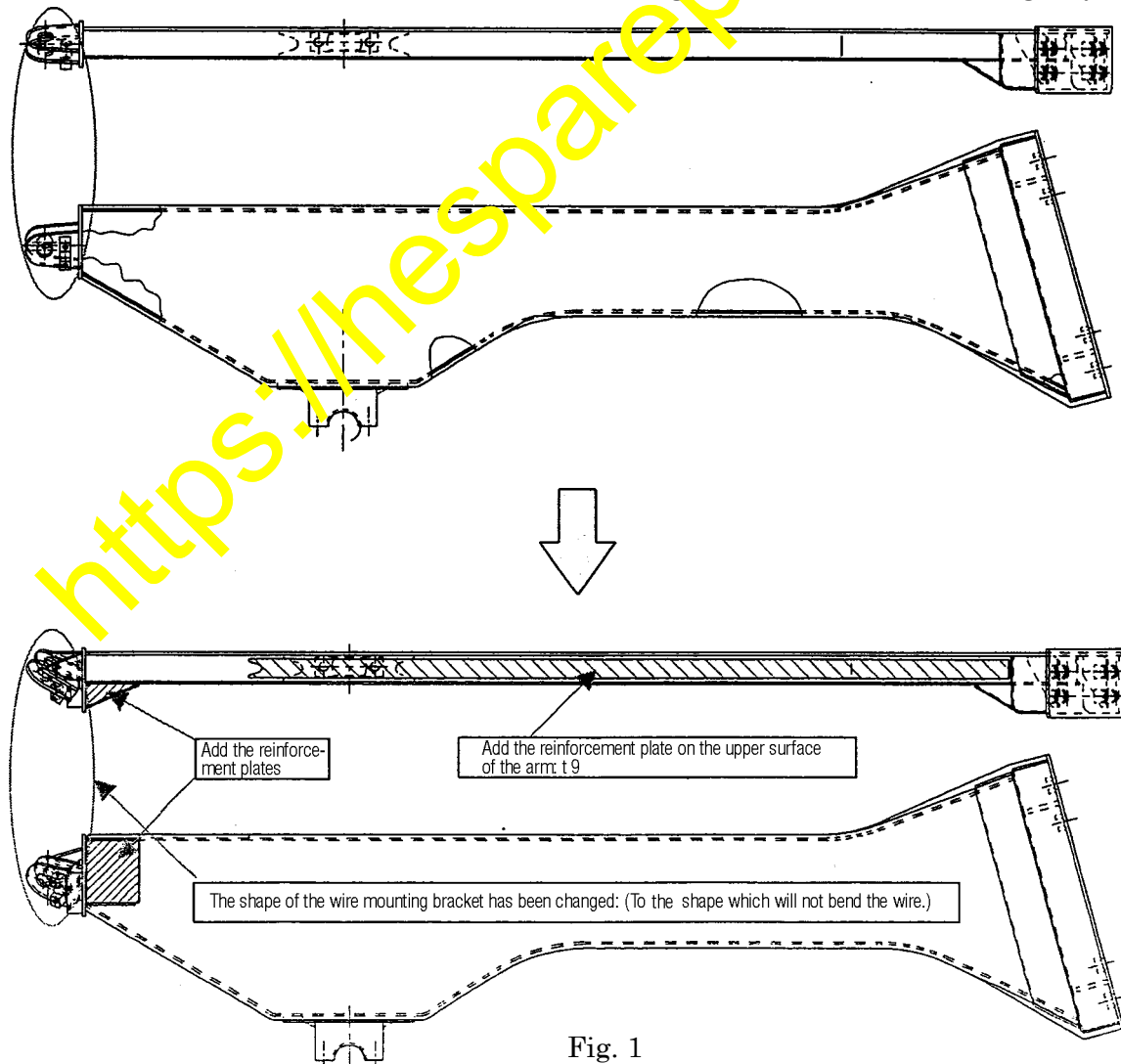
Part No.	Part Name	Purpose of part	Q'ty	Remarks
56B-83-14111 (56B-83-14110)	Gate, L.H. (Gate, L.H.)	} Replacement	1 (1)	
56B-83-14121 (56B-83-14120)	Gate, R.H. (Gate, R.H.)		1 (1)	
56B-83-14180	Plate		2	
56B-83-14290	Shim	Addition	15	

3. Details of the modification

- (1) The mounting angle of the wire mounting bracket is changed to make a structure where the wire may be pulled straight forward when the body is raised to the stroke end.



- (2) To prevent the deformation of the arm, add the reinforcement plates to the upper surface and to the rear section of the wire mounting section to increase the rigidity.



4. Modification procedure

4-1. Preparations before starting the modification work

- 1) Park the vehicle on a flat place and apply chocks to the tires.

4-2. Modification procedure

- (1) Remove the wire (56B-83-14160) and the cap (287-70-13330).

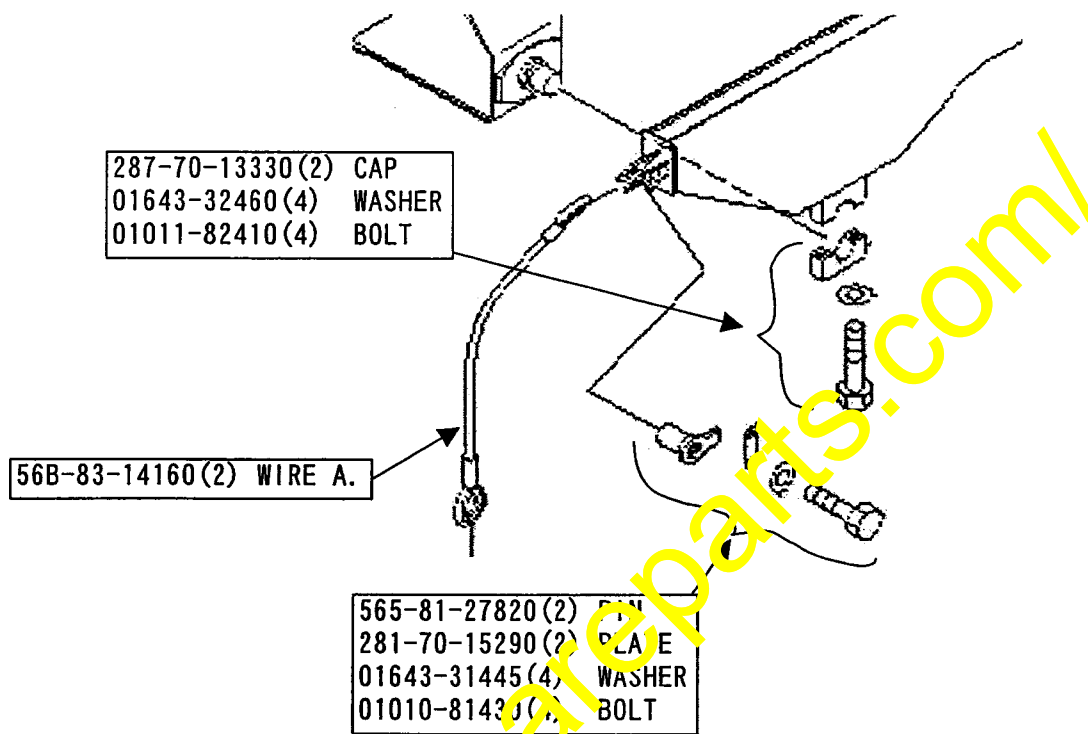


Fig. 2

- (2) Remove the tail gate sub ass'y

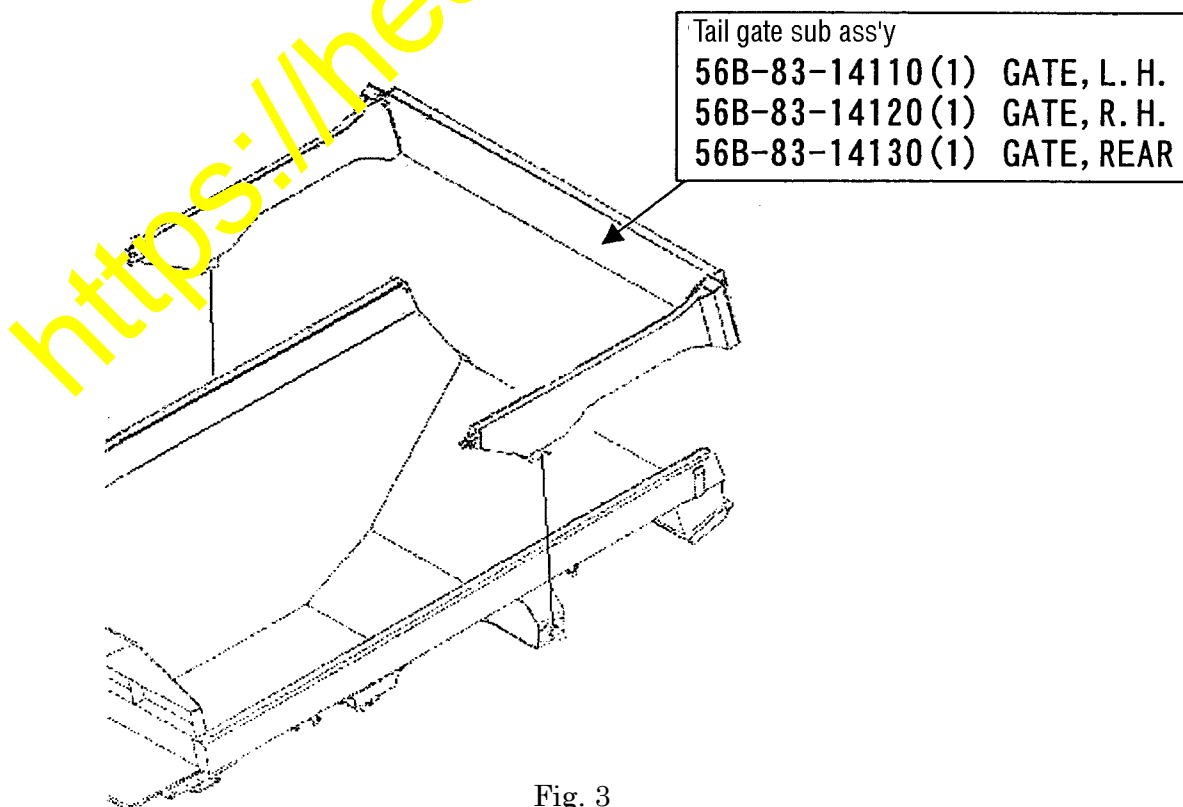


Fig. 3

- (3) Replace the current gate, L.H. with the new gate, L.H. 56B-83-14111 and replace the current gate, R.H. with the new gate, R.H. 56B-83-14121 and make the tail gate sub-ass'y with them using the bolts (01010-82460) and spacers (20Y-09-11150). Tighten the bolts (01010-82460) temporarily when making the gate sub-ass'y and tighten them at the specified tightening torque after installing the tail gate sub-ass'y onto the vehicle body.

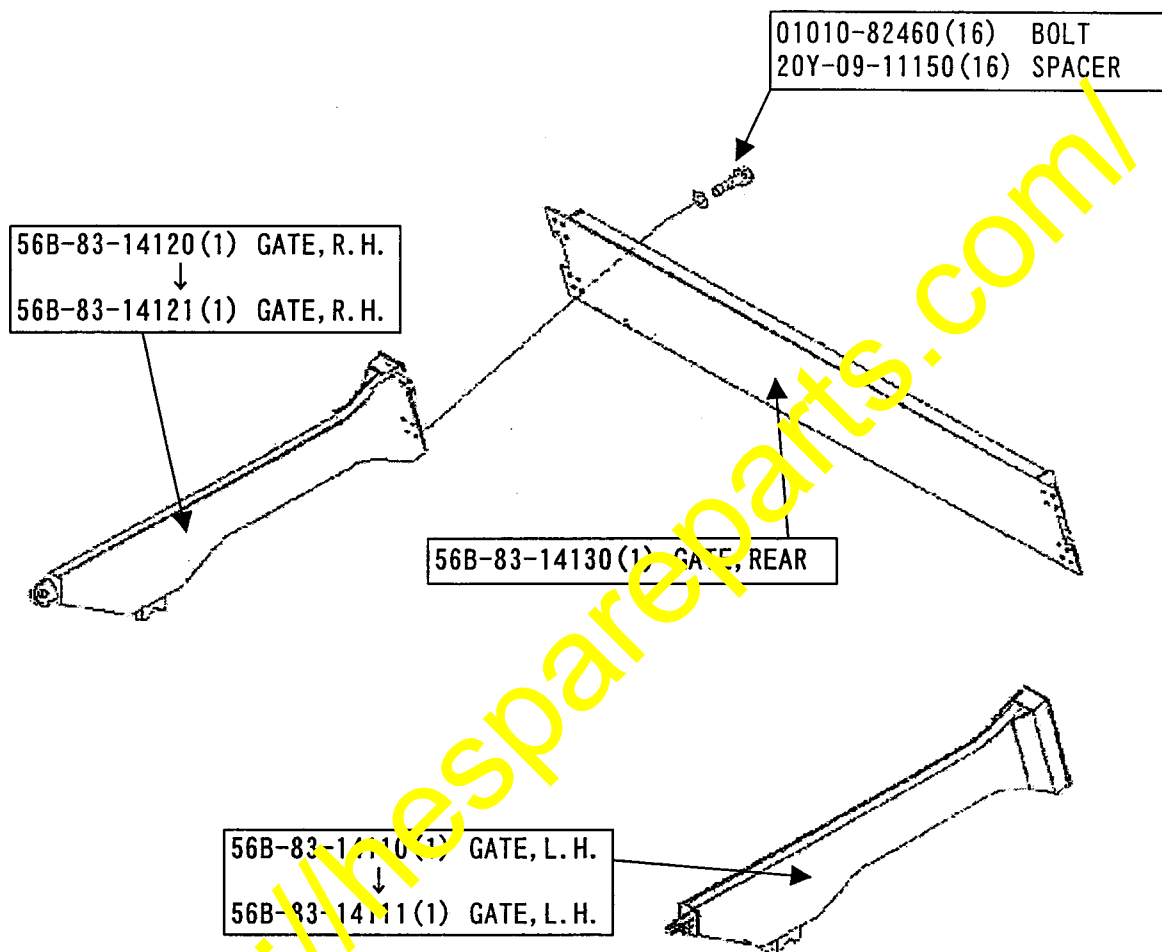


Fig. 4

- (4) Install the tail gate sub-ass'y onto the vehicle body.
- (5) Adjust the position of the tail gate sub-ass'y by use of the shims (56B-83-14290) so that the cushion (56B-83-14170) may be depressed evenly on the LH side and RH side.
- (6) Install the cap (287-70-13330).
- (7) Install the wire (56B-83-14160).
- (8) Tighten the bolts (01010-82460) to mount the tail gate and the arm at the specified tightening torque.
{Tightening torque: 824 - 1,030 Nm (84 - 105 kgm)}
- (9) Weld the plate (56B-83-14180).
- (10) Make touch-ups on the modified sections.

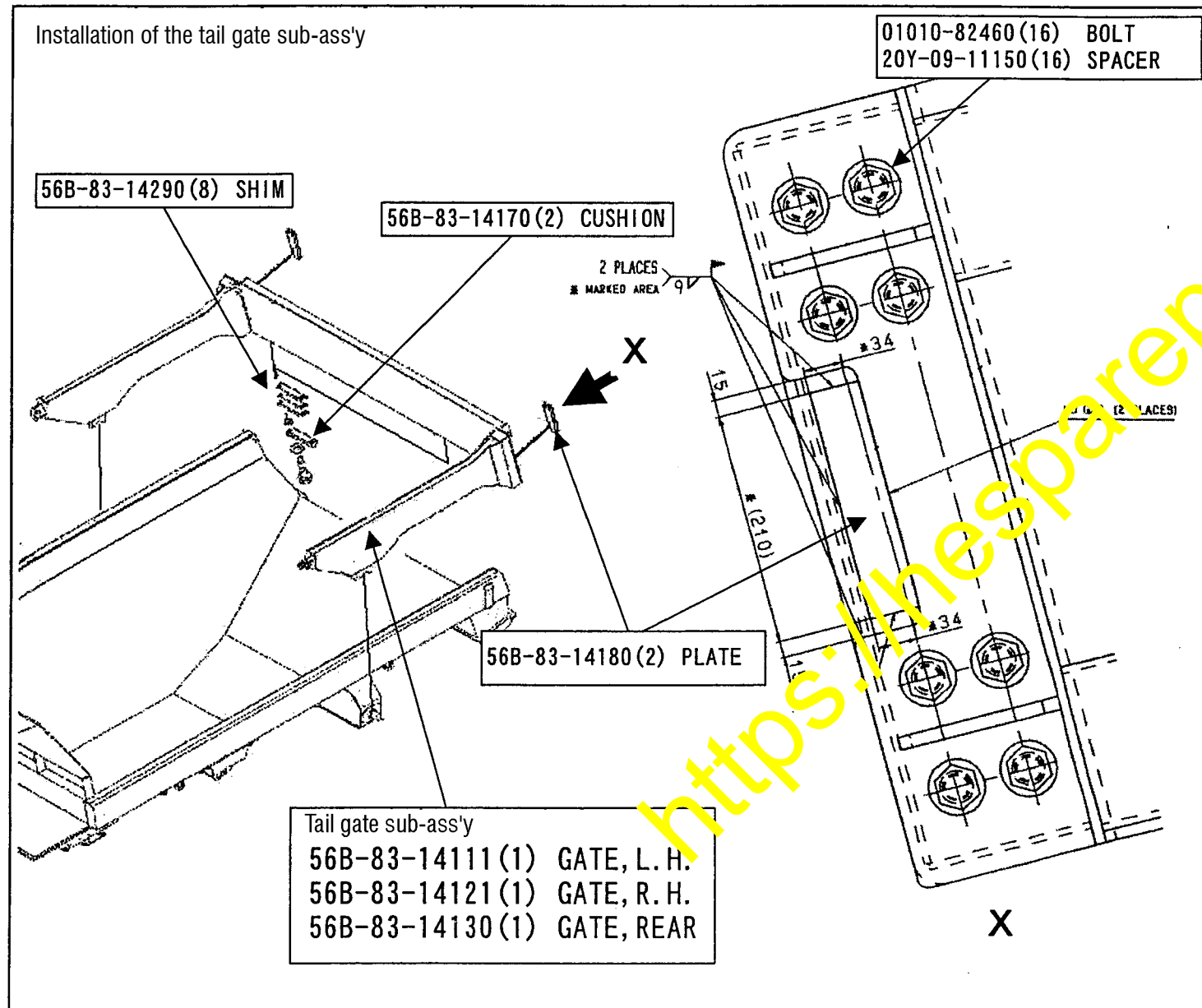


Fig. 5

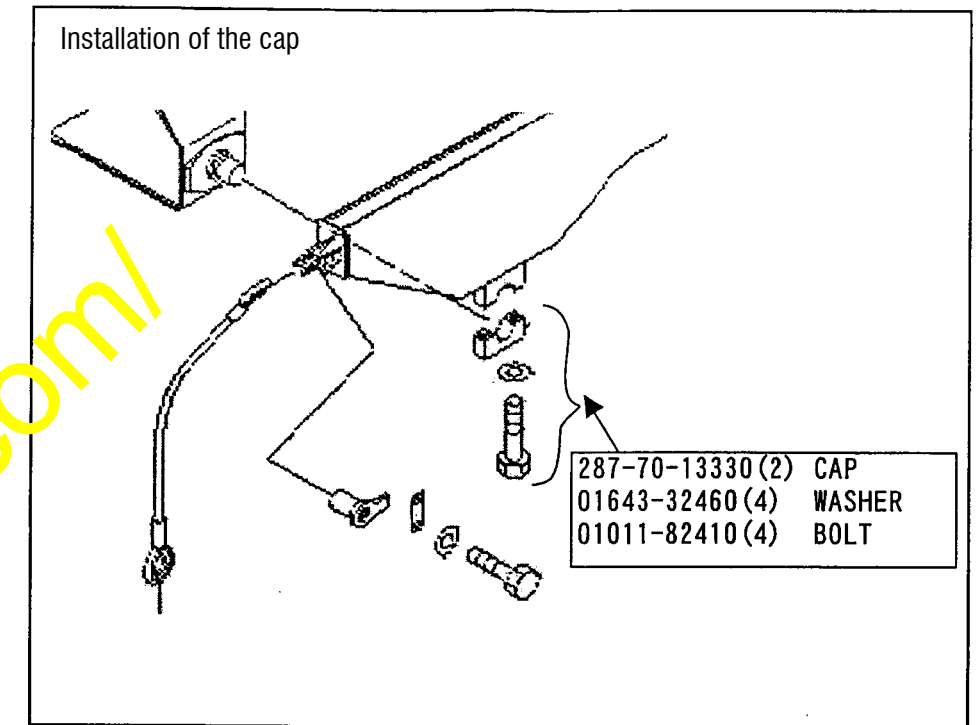


Fig. 6

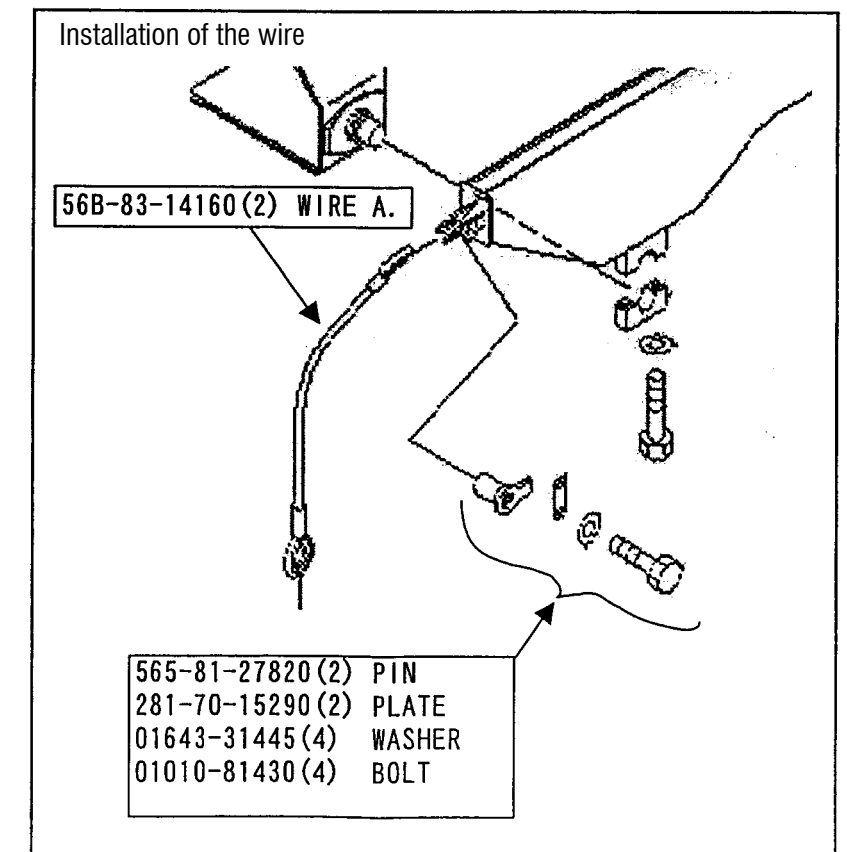


Fig. 7