

**PARTS & SERVICE
NEWS**

REF NO.	AT04831
DATE	Jun. 24, 2004

(C)

Page 1 of 3

SUBJECT: MODIFICATION PROCEDURE FOR EXHAUST MANIFOLD ON HD325/
HM350/HM400

PURPOSE: To introduce modification procedure to repair gas leakage from the ex-
haust manifold for the engines on HD325, HM350 and HM400 dump
trucks

APPLICATION: HD325-6 Dump Trucks, Serial Nos. up to 6287
(Engine Nos. up to 113060)
HD405-6 Dump Trucks, Serial Nos. up to 2140
(Engine Nos. up to 113060)
HM350-1 Articulated Dump Trucks, Serial Nos. up to 1093
(Engine Nos. up to 113129)
HM400-1 Articulated Dump Trucks, Serial Nos. up to 1188
(Engine Nos. up to 113046)

FAILURE CODE: A1P5AJ

DESCRIPTION:

1. Introduction

In case of the engines equipped with the exhaust brake being used for the HD325, HM350 and HM400 dump trucks, while the exhaust brake is in operation, the gas pressure inside the exhaust manifold may rise to cause gas leakage from the engaging section of the exhaust manifold. Therefore, repair the failure following the modification procedure described in this Service News.

2. List of parts

Part No.	Part Name	Purpose of part	Q'ty	Remarks
6218-11-5740 (6211-11-5140)	Manifold (Manifold)	Replacement	1 (1)	The current exhaust manifold can be used for the engines not equipped with the exhaust brake.
6218-11-5760 (6211-11-5160)	Manifold (Manifold)		1 (1)	
6218-11-5880 (6218-11-5880)	Gasket (Gasket)		6 (6)	Consumable parts
6218-11-5830 (6218-11-5830)	Gasket (Gasket)		1 (1)	
6151-51-8161 (6151-51-8161)	Gasket (Gasket)		1 (1)	
6151-51-8151 (6151-51-8151)	Gasket (Gasket)		1 (1)	
6127-51-6822 (6127-51-6822)	Gasket (Gasket)		1 (1)	
6212-11-5940 (6212-11-5940)	Gasket (Gasket)		1 (1)	
6151-11-5751 (6151-11-5751)	Gasket (Gasket)	2 (2)		

3. Details of the modification

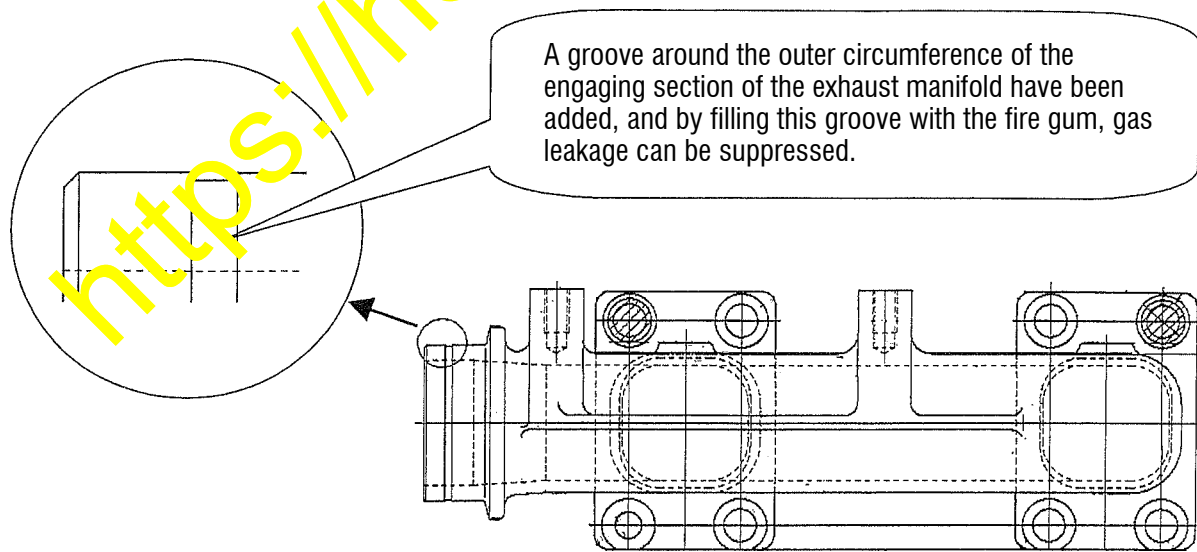


Fig. 1

4. Modification procedure

- 1) Carry out the disassembly work referring to the Shop Manual and replace the front and rear side exhaust manifolds with the improved ones.
- 2) Although the center exhaust manifold is being reused, if foreign substance, etc. is adhering to the inside surface of the engaging section, carefully clean to remove it.
- 3) Apply the fire gum (MH705 made by Musashi Holt) all around the groove on the engaging section of the front side and rear side exhaust manifolds with a thickness of about $\phi 4$ before inserting to the center exhaust manifold.
- 4) When disassembly is made at sections where gaskets are used, replace these gaskets with new parts.

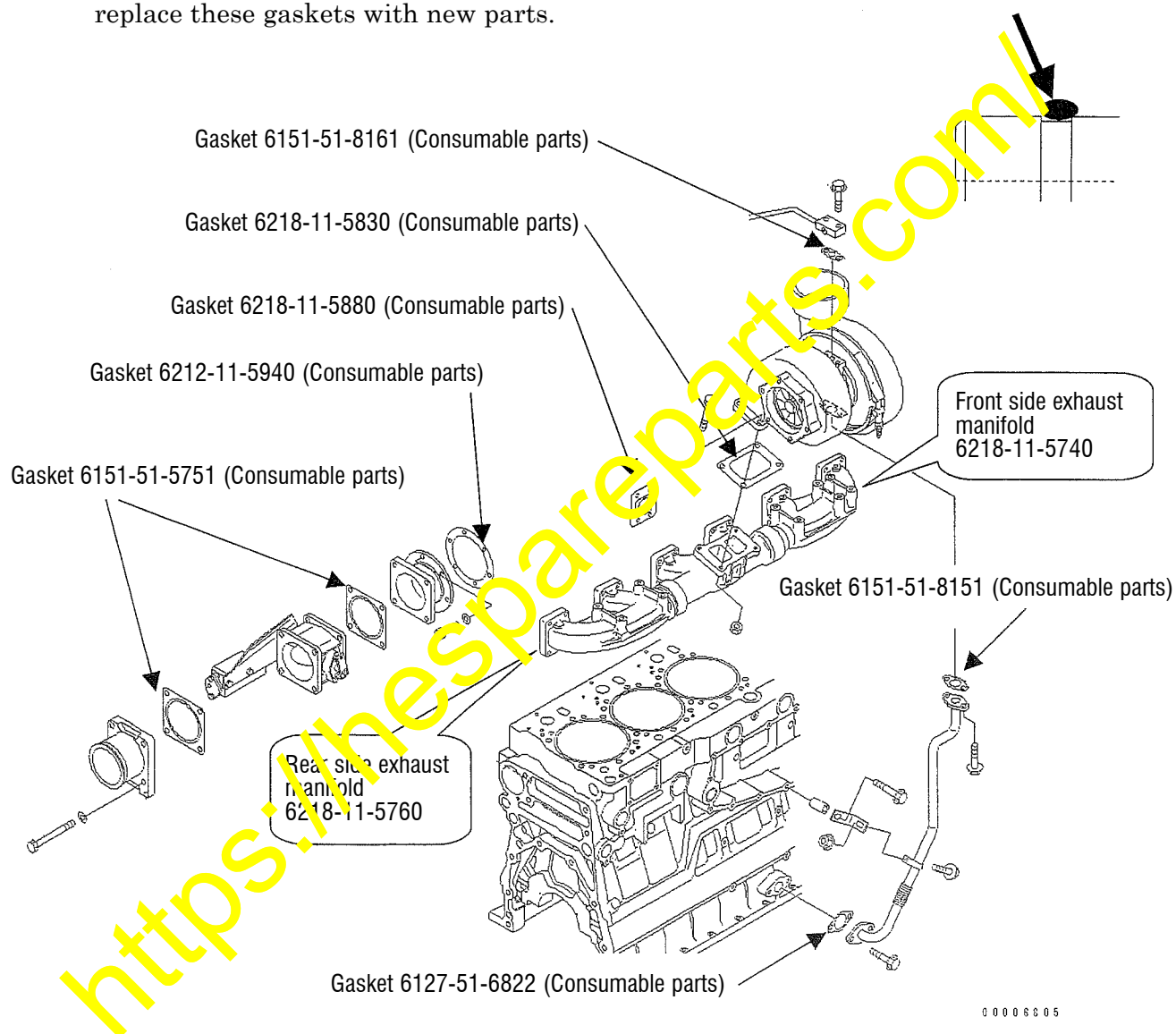


Fig. 2