

INSTALLATION MANUAL

REF NO.	BT02066
DATE	Oct. 31, 2002

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SUBJECT: INTRODUCTION OF REINFORCED TYPE MOUNTING BRACKET OF A/C COMPRESSOR ON WA1200-3

PURPOSE: To introduce modification procedure to reinforce the air compressor mounting bracket of the air conditioning system on WA1200-3 wheel loaders to prevent occurrence of cracks

APPLICATION: WA1200-3 Wheel Loaders, Serial Nos. 50001 thru 50012

FAILURE CODE: 8311HA

DESCRIPTION:

1. Introduction

On the WA1200-3 wheel loaders, there is a possibility of occurrence of cracks in the welded section between the pipe and the plate (refer to page 2 for the exact position) owing to insufficient strength of the air compressor mounting bracket of the air conditioning system.

This Service News will introduce the modification procedure to prevent occurrence of the aforementioned cracks.

2. List of parts

Part No.	Part Name	Q'ty	Remarks
42C-07-11162 (42C-07-11161)	Bracket (Bracket)	1 (1)	When replacing the bracket

When modifying the bracket, locally procure the following material and make the modification as per the modification procedure indicated on pages 3 and 4.

* 73 mm × 28 mm or larger in the longitudinal and crosswise dimensions

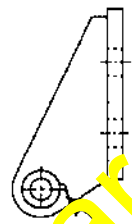
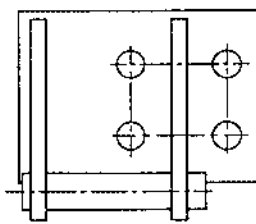
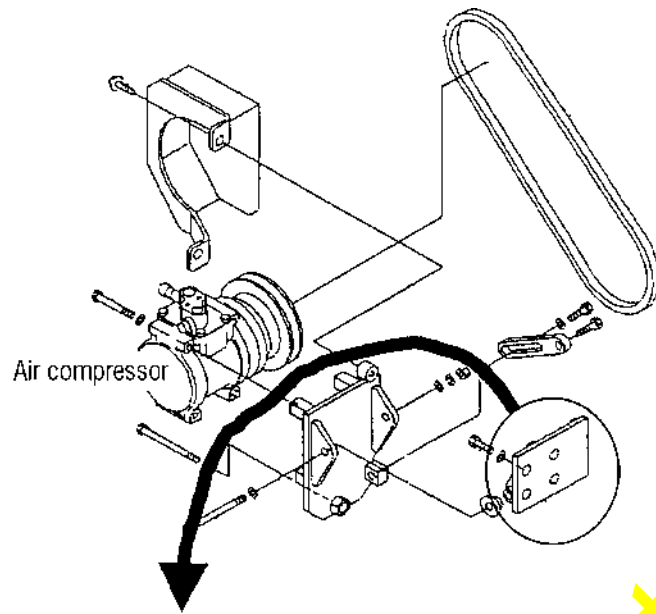
Plate thickness: 6 mm

Material: S3400

(Part number is not given to this modification part.)

When replacing the bracket, order the part indicated on this parts list.

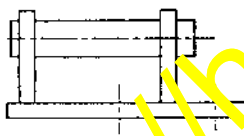
3. Contents of the modification



Air compressor mounting bracket (Part No. 42C-07-11161) of the air conditioning system:

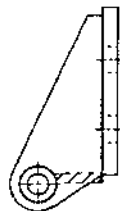
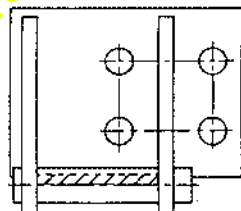
There is a possibility of occurrence in the welded section between the pipe and plate.

welded section between the pipe and the plate



- ① When modifying the bracket locally, make the modification as per the modification procedure being indicated on pages 3 and 4.
- ② When ordering the improved bracket (42C-07-11162) to replace the current bracket, it is not necessary to make the modification as per pages 3 and 4.

After the modification



Weld the reinforcement plate to the hatched section additionally.

New part number: Same as the current Part No. 42C-07-11162

4. Modification procedure

When locally modifying the bracket by reinforcement, follow the modification procedure described below.

(1) Preparation of the additional plate

Make the reinforcement plate as per the drawing shown below.

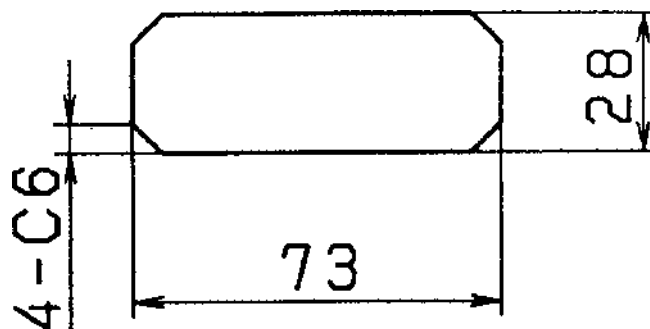
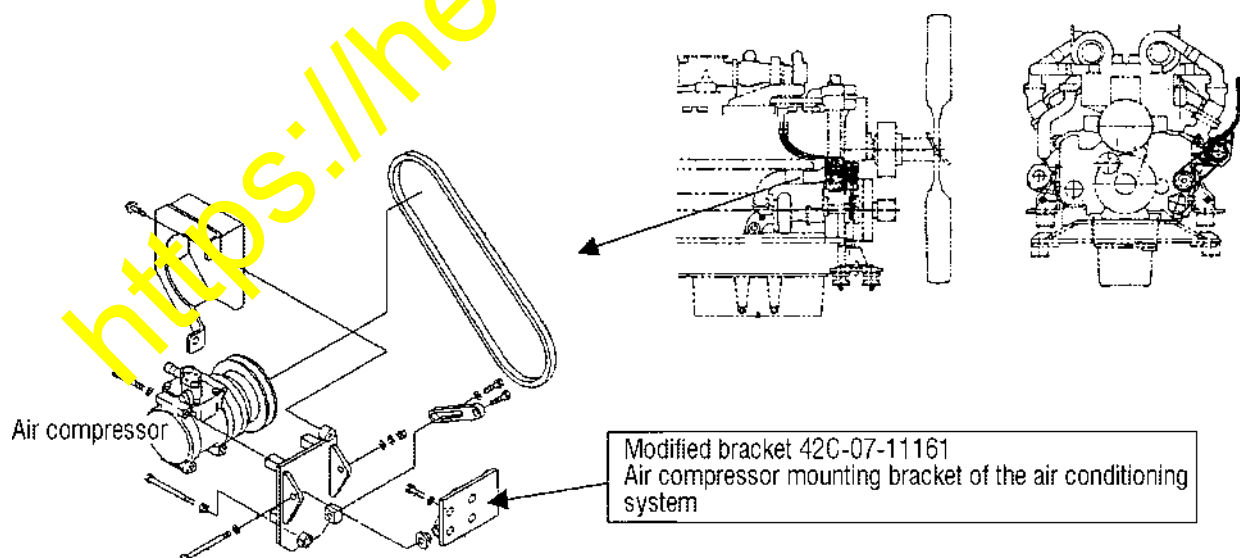


Plate thickness: t 6
Material: SS400

(2) Removal of the parts

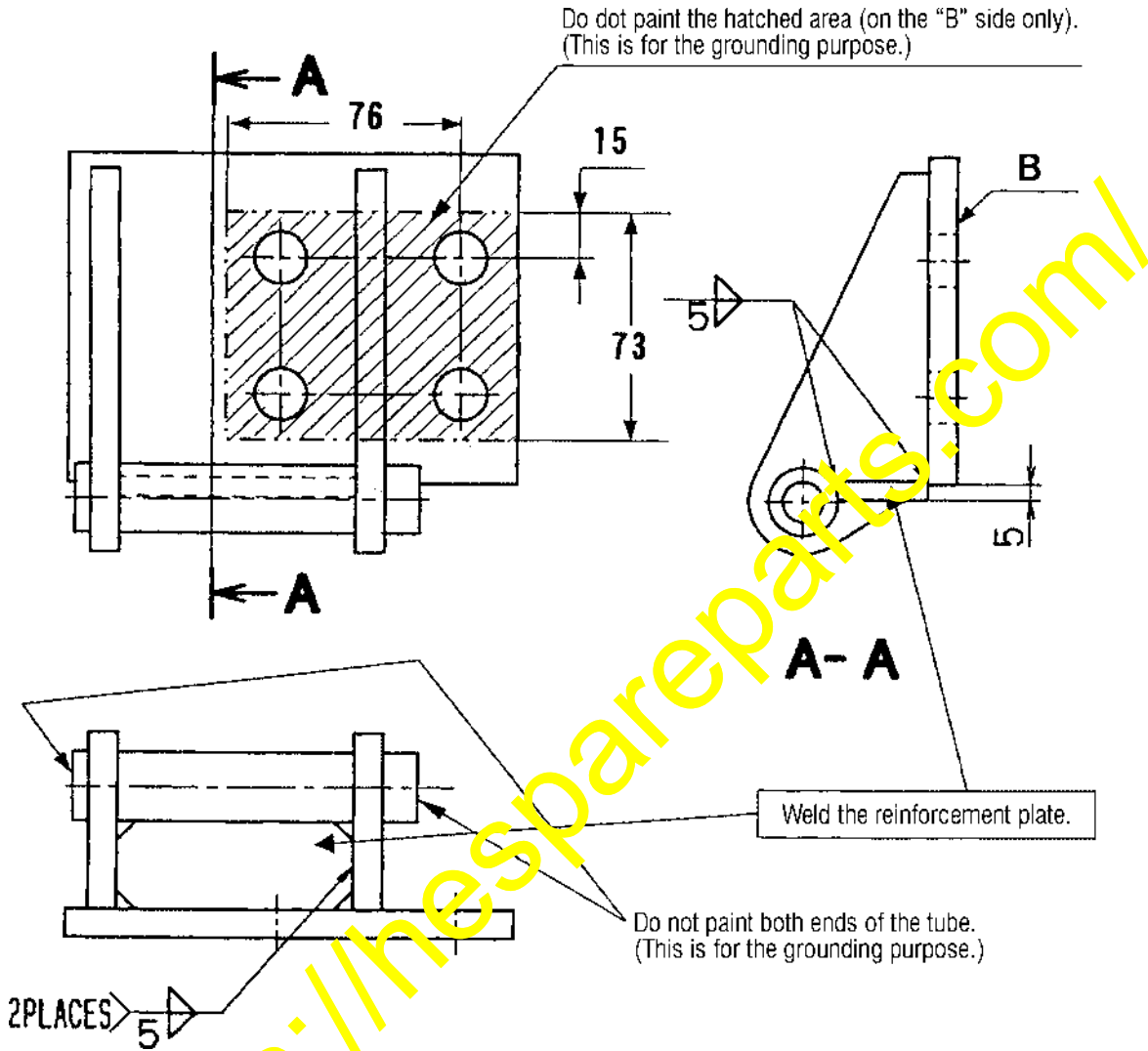
Remove the air compressor mounting bracket (42C-07-11161) of the air conditioning system from the engine.

When removing the air compressor of the air conditioning system from the engine, leave the air conditioner hose being connected to the air compressor and remove them together.



(3) Modification of the removed bracket

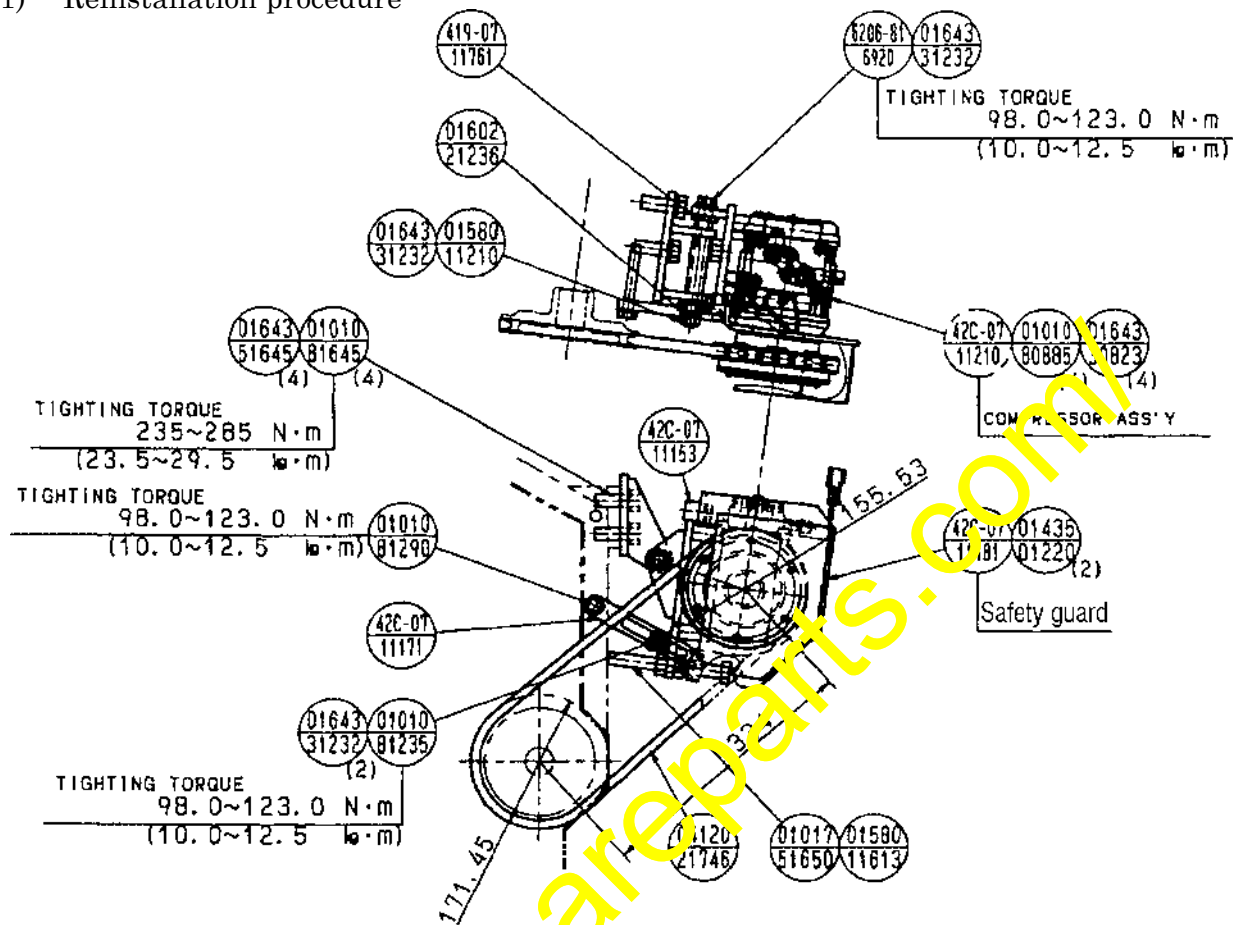
Weld the plate which has been made out as per the instructions given in the above Section (1) onto the bracket which has been removed as per the instructions given in the above Section (2).



After finishing the welding work, paint the modified surfaces.
However, do not paint the areas instructed not to paint in the above drawings.

5. Reinstallation of the air compressor of the air conditioning system

1) Reinstallation procedure



When carrying out the above reinstallation work, pay attention to the alignment error of the belt. Make the reinstallation work maintaining the alignment error (the dimension "a" in Fig. 2 below) of the belt within 2 mm.

- 2) After finishing the reinstallation work, adjust the belt tension as per the procedure given in Fig. 1. below.

Belt tension adjustment procedure

Adjust the belt tension so that a deflection of 9 to 12.5 mm occurs when the center point between the air compressor pulley and the drive pulley on the V-belt is depressed by the ball of the thumb (with a force of about 10 kg).

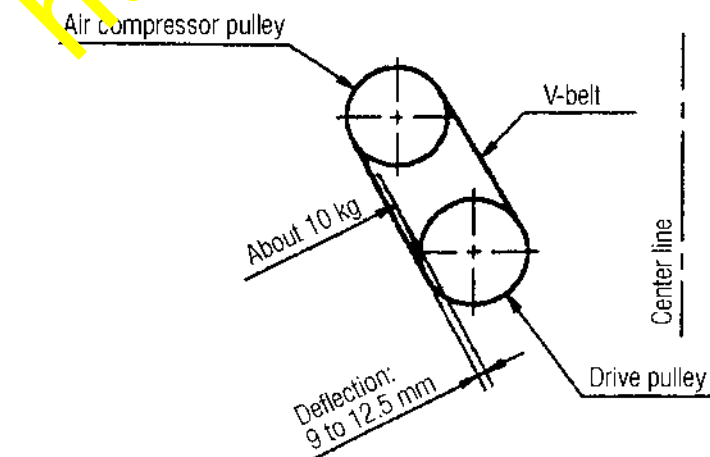


Fig. 1

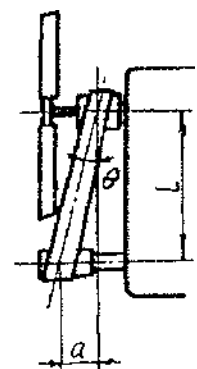


Fig. 2