

Field Assembly Manual

HD325-6

HD405-6

DUMP TRUCK

SERIAL NUMBERS	HD325-6	5680 and up
	HD405-6	1055 and up

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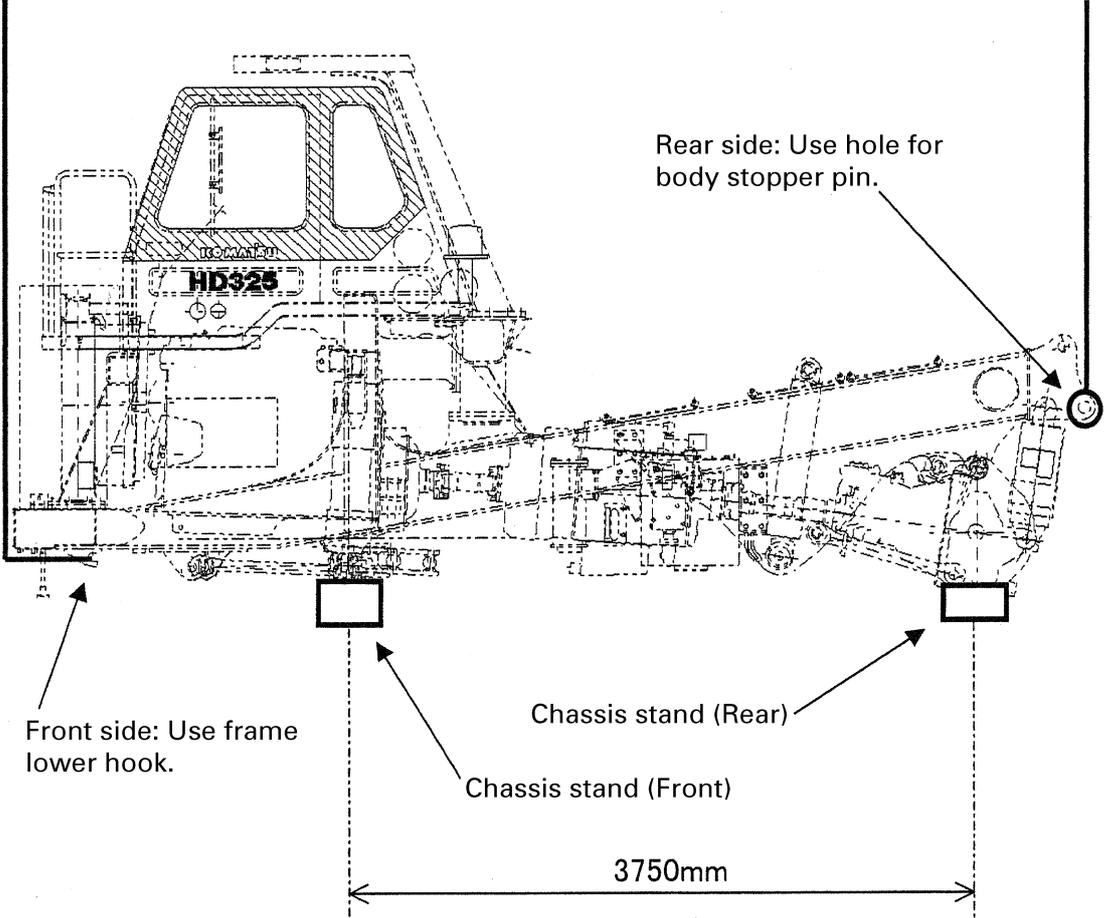
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FIELD ASSEMBLY INSPECTION REPORT	
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LIFTING UP CHASSIS ASSEMBLY

Process drawing

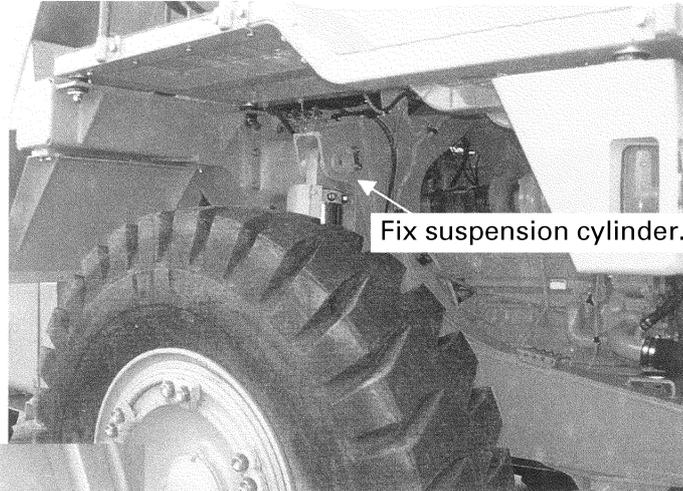
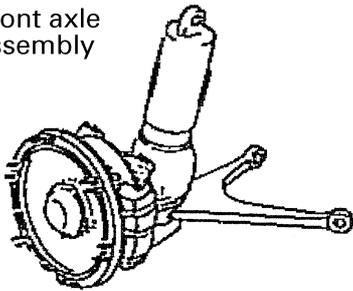


Order of work	Work procedure
<p>1. Prepare 2 cranes.</p> <p>2. Install slings to the points shown in the figure and lift up the chassis assembly.</p> <p>3. Remove the stands</p> <p>4. Lower the chassis assembly.</p>	<ul style="list-style-type: none"> • Work on a level and firm place. • Weight of chassis assembly: Approx. 18 tons When using mobile cranes <ul style="list-style-type: none"> • Front side: 45 tons • Rear side: 25 tons • Protect the front bumper. • Take care that the rear side will not interfere with the grease tubes, etc. • Secure the left front suspension cylinder with wires so that it will not be extended by its weight. • Place supports higher than 800 mm under the parts to which the stands were installed. (3 layers of a block 300 mm square, etc.)

INSTALLING FRONT AXLE

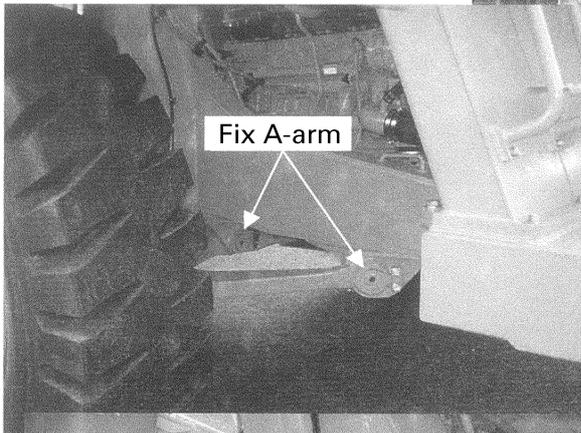
Process drawing

Front axle assembly

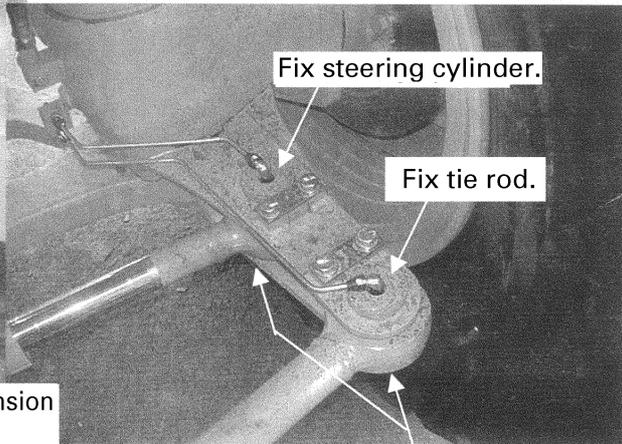


Fix suspension cylinder.

※ When working actually, remove tires.

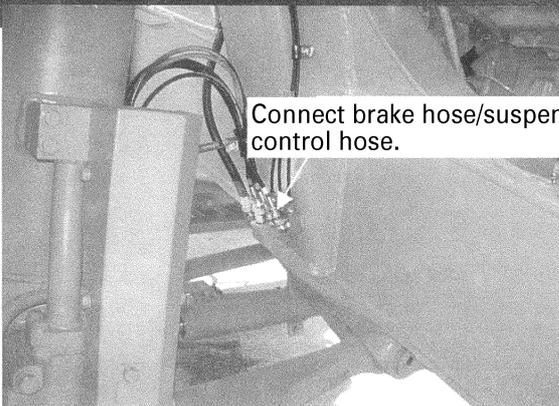


Fix A-arm



Fix steering cylinder.

Fix tie rod.



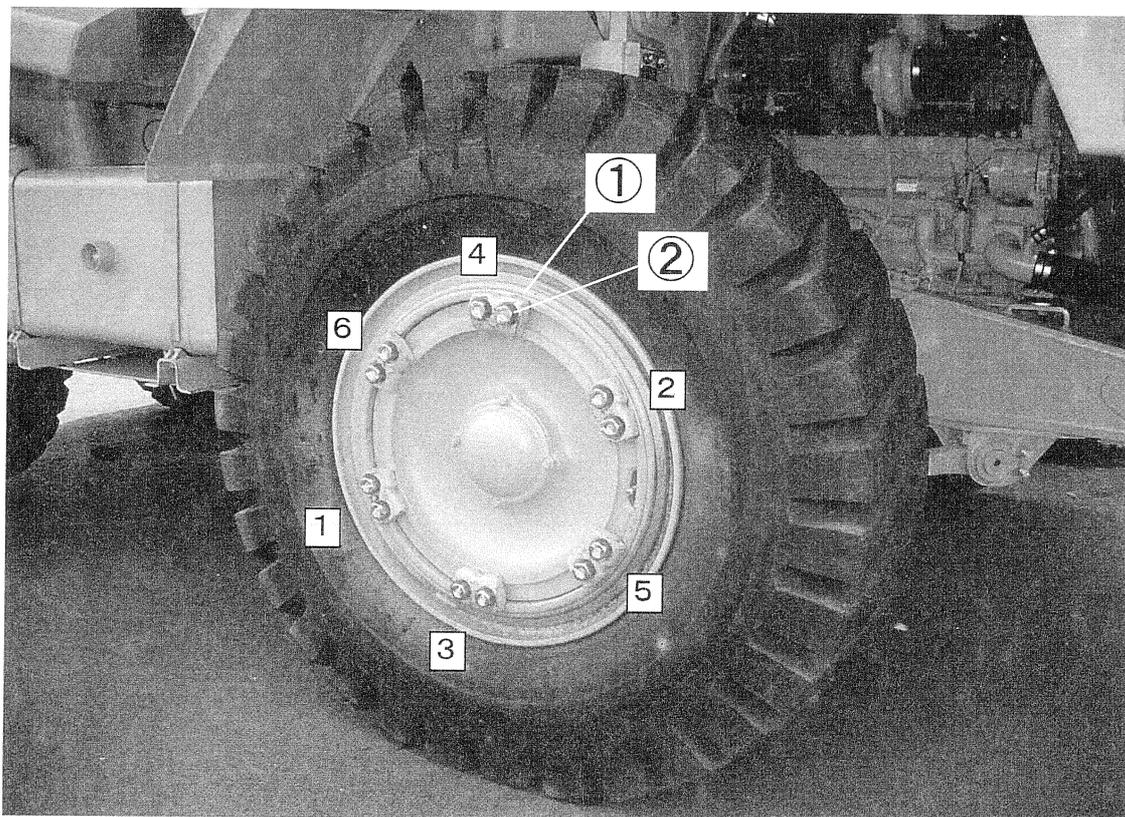
Connect brake hose/suspension control hose.

⊕ Tie rod fixing pin mounting bolt
Steering cylinder fixing pin mounting bolt

Tightening torque of these bolts:
490 – 608 N m {50 – 62.0 kg m}

INSTALLING FRONT TIRES

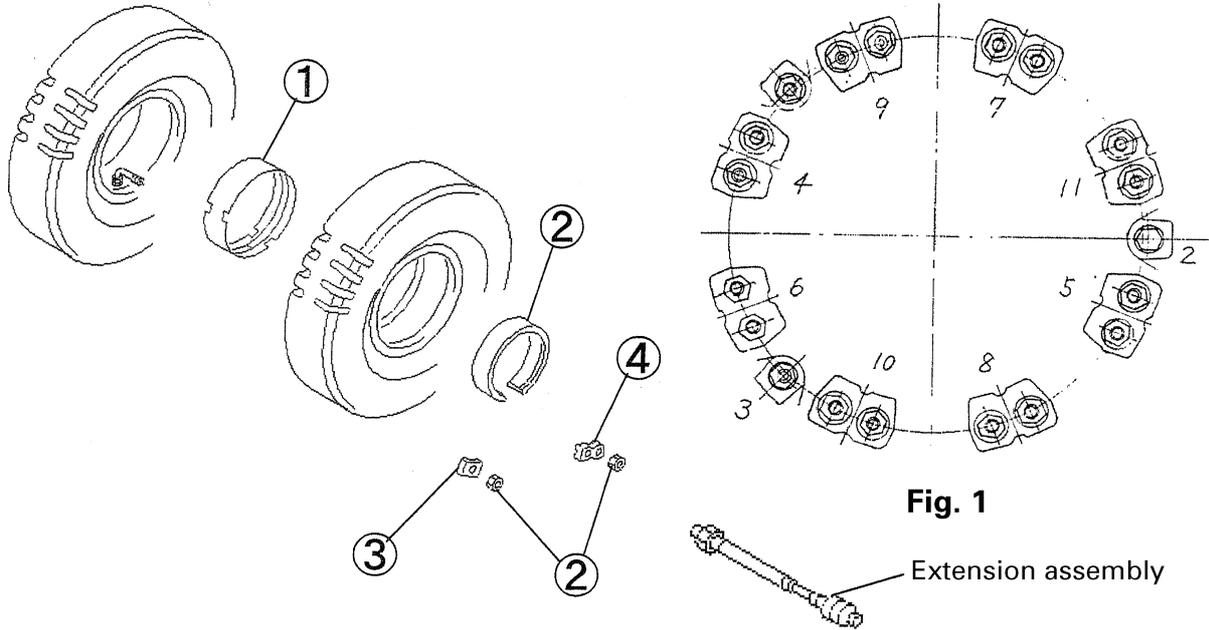
Process drawing



Order of work	Work procedure
<p>1. Install the right front tire.</p> <p>① 569-22-62841, 12 pieces, Clamp</p> <p>② 569-22-62870, 24 pieces, Nut</p> <ul style="list-style-type: none"> • Fix clamps ① with nuts ②. • Fix the clamps in the numerical order shown in the figure. • Tighten the nuts to the following torque. • When LM-G is applied to the threads and nut seats 84 – 105 kg·m (Target: 94.5 kg·m) • When nothing is applied to the threads and nut seats 110 – 135 kg·m (Target: 123.0 kg·m) 	<ul style="list-style-type: none"> • Reduce the sideways runout of the tire to below 5 mm.

INSTALLING REAR TIRES

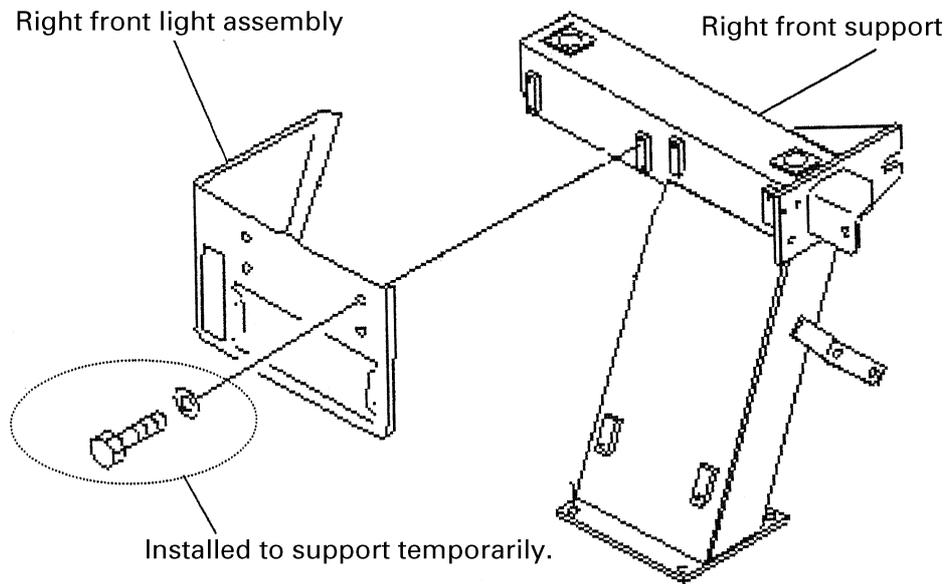
Process drawing



Order of work	Work procedure
<p>1. Install the rear tires.</p> <ul style="list-style-type: none"> ① 566-30-74120, 2 pieces, Spacer ② 566-81-14111, 2 pieces, Ring ③ 569-22-62830, 6 pieces, Clamp ④ 569-22-62841, 16 pieces, Clamp ⑤ 569-22-62870, 38 pieces, Nut <p>1) Install the inside wheel assembly and fix clamps 569-22-62830 No. 1, 2, and 3 shown in the figure with nuts 569-22-62870.</p> <ul style="list-style-type: none"> • Tighten the nuts to the following torque. • When LM-G is applied to the threads and nut seats 84 – 105 kg·m (Target: 94.5 kg·m) • When nothing is applied to the threads and nut seats 110 – 135 kg·m (Target: 123.0 kg·m) <p>2) Install spacer 566-30-74120, outside wheel assembly, and ring 566-81-14111, then fix 3 clamps 569-22-62841.</p> <p>3) Tighten nuts 569-22-62870 in the numerical order shown in Fig. 1. Observe the tightening torque shown in 1) above.</p> <p>4) Install the extension. Tightening torque: 0.3 ± 0.05 kgm</p>	<ul style="list-style-type: none"> • Remove paint, dirt, sand, rust, oil, grease, etc. from the contact faces of the wheel assembly and rear axle. • Reduce the sideways runout of the tire to below 5 mm. • Reduce the sideways runout of the tire to below 5 mm.

INSTALLING RIGHT FRONT LIGHT ASSEMBLY

Process drawing



Connection of wiring harness between headlight and chassi
CN32, CN33, CN34, CN35, CNB36, CN37

Order of work	Work procedure
<p>1. Install the front light to the front support. Connect the wiring harness between the light and chassis. (For the connectors, see the figure.)</p>	

INSTALLING GUARDS

Process drawing

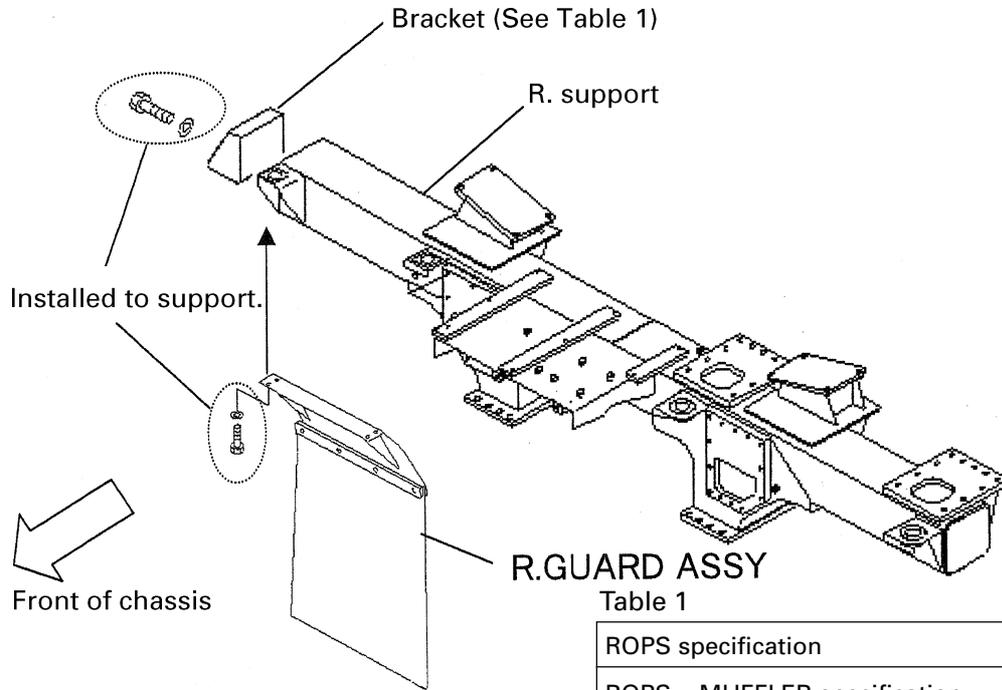
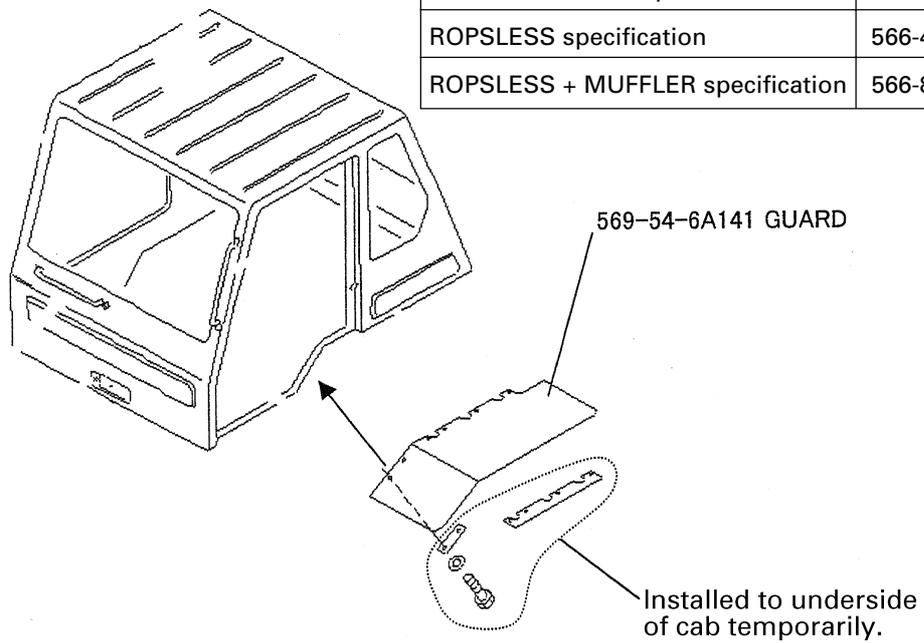


Table 1

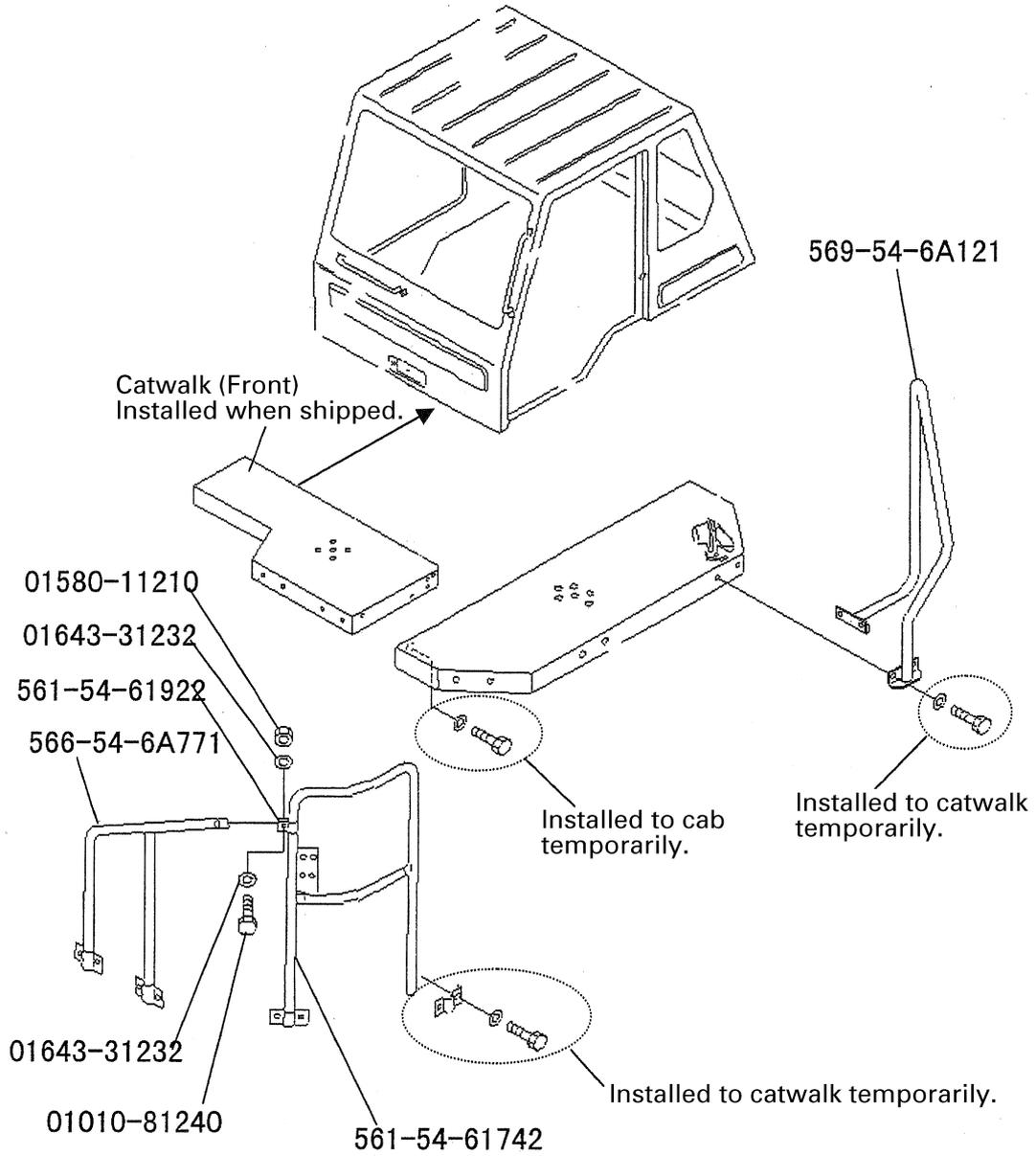
ROPS specification	566-89-6A990
ROPS + MUFFLER specification	566-84-6A790
ROPSLESS specification	566-46-6A980
ROPSLESS + MUFFLER specification	566-84-6A770



Order of work	Work procedure
<p>1. Install the bracket to the right of the rear support. Install the guard to the right underside of the rear support.</p> <ul style="list-style-type: none">• The parts for installation are installed to the chassis temporarily when shipped. <p>2. Install the guard to the left underside of the cab.</p> <ul style="list-style-type: none">• The parts for installation are installed to the chassis temporarily when shipped.	

INSTALLING CATWALK AND GUARD

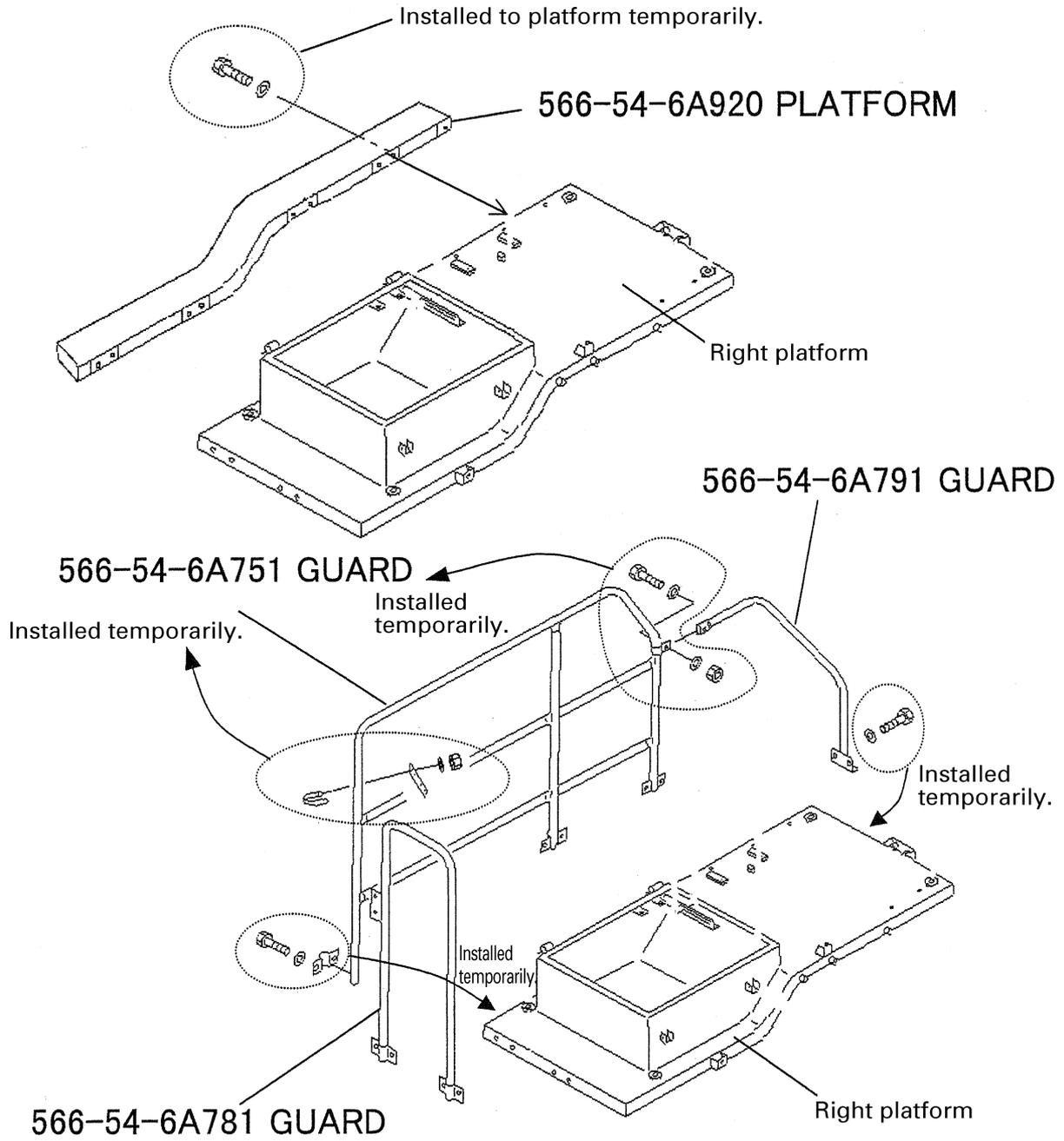
Process drawing



Order of work	Work procedure
<ol style="list-style-type: none"><li data-bbox="188 320 791 443">1. Install the catwalk assembly to the left side of the cab.<ul style="list-style-type: none"><li data-bbox="236 383 791 443">• The parts for installation are installed to the cab temporarily when shipped. <li data-bbox="188 640 791 741">2. Install the guard to the catwalk.<ul style="list-style-type: none"><li data-bbox="236 680 791 741">• The parts for installation are installed to the catwalk temporarily when shipped.	

ASSEMBLING RIGHT PLATFORM

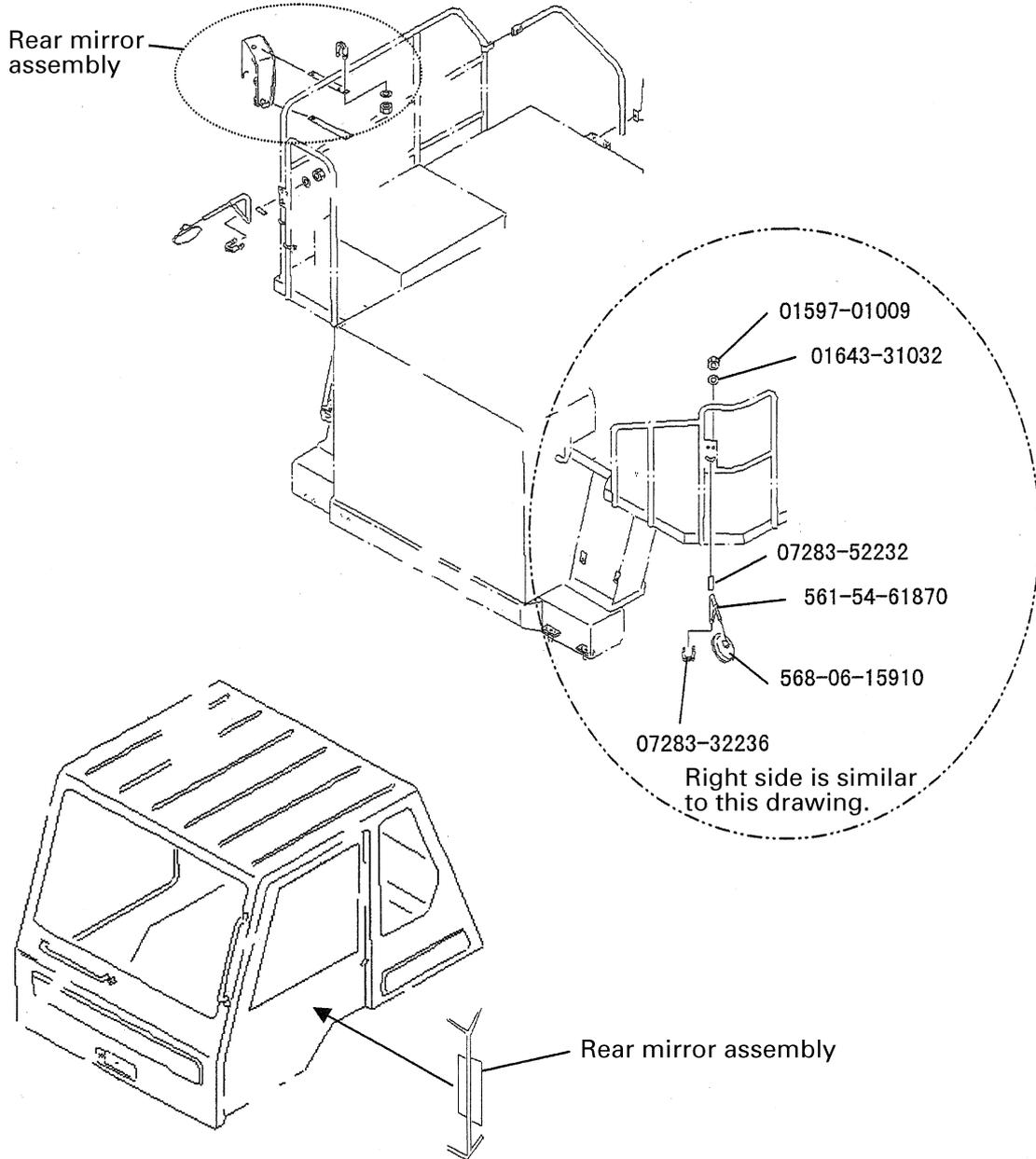
Process drawing



Order of work	Work procedure
<ol style="list-style-type: none"><li data-bbox="188 327 790 454">1. Install the platform to the side of the right platform.<ul style="list-style-type: none"><li data-bbox="236 389 790 454">• The bolts and washers are installed to the platform temporarily when shipped. <li data-bbox="188 931 790 1155">2. Install the guards to the right platform.<ul style="list-style-type: none"><li data-bbox="236 965 790 1059">• The parts for connecting the guards are installed to 566-54-6A751 temporarily when shipped.<li data-bbox="236 1059 790 1155">• The parts for installation of the guards are installed to the platform temporarily when shipped.	

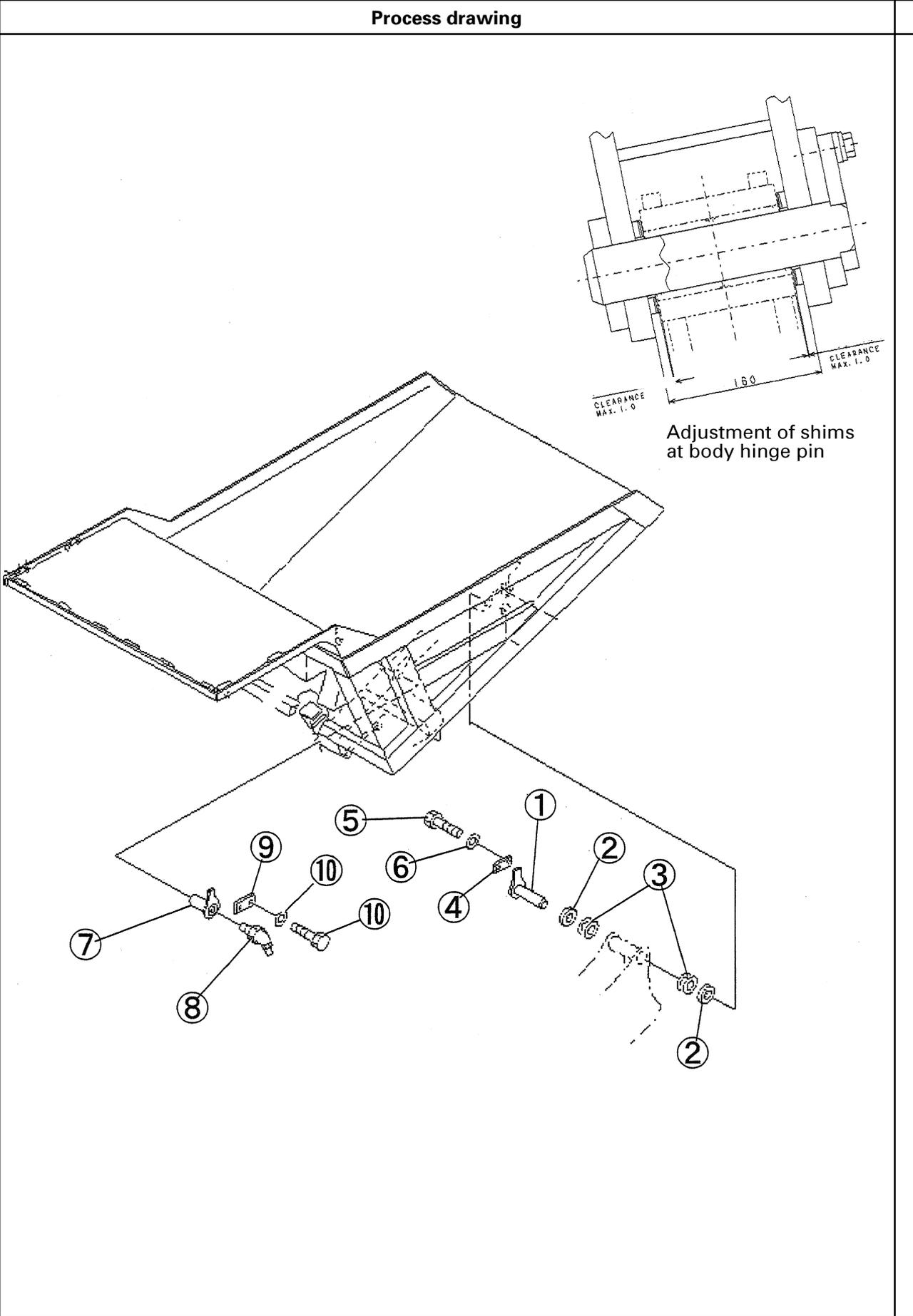
INSTALLING MIRRORS

Process drawing



INSTALLING BODY PINS

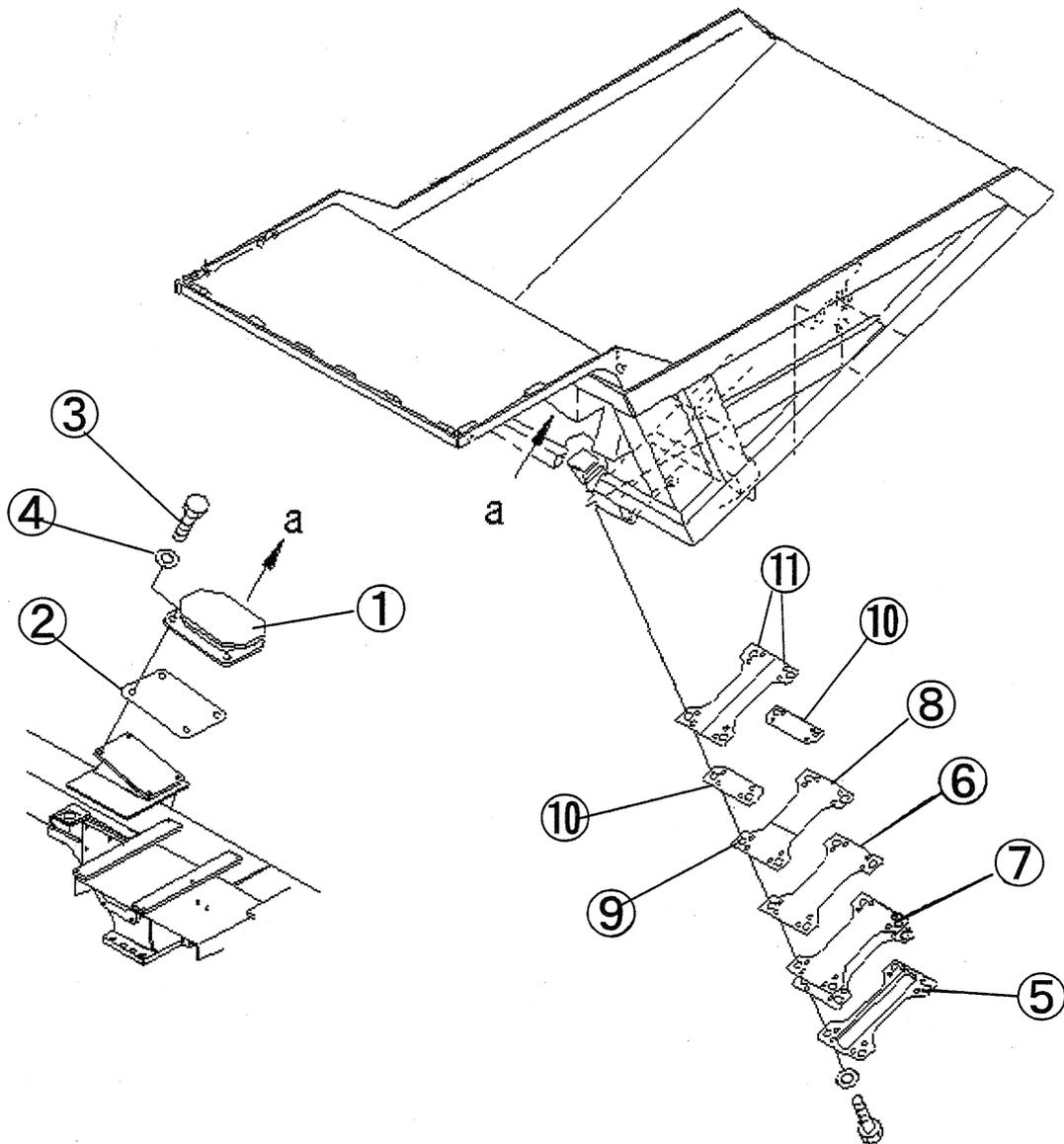
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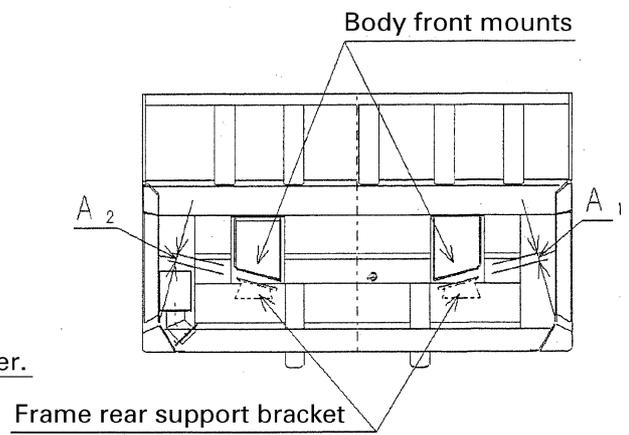
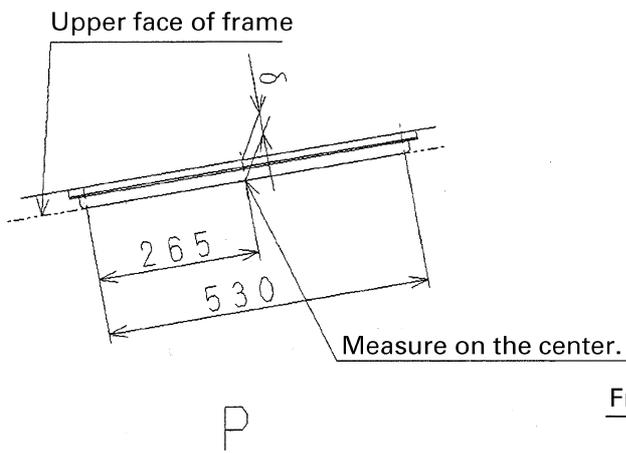
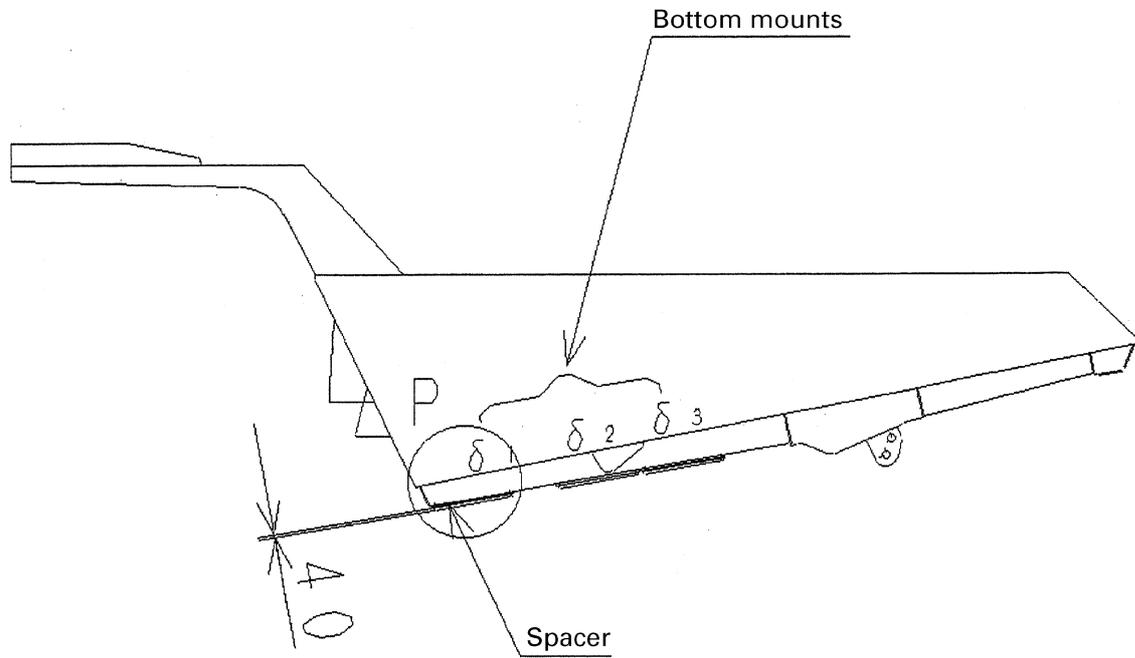
Order of work	Work procedure
<p>1. Install the hinge pins (on both sides).</p> <ul style="list-style-type: none"> ① 566-97-46170, 2 pieces, Pin ② 566-74-11270, 4 pieces, Shim ③ 566-74-11280, 16 pieces, Shim ④ 281-70-15290, 2 pieces, Plate ⑤ 01010-81425, 4 pieces, Bolt ⑥ 01643-31445, 4 pieces, Washer <p>2. Fix the hoist cylinders (on both sides).</p> <ul style="list-style-type: none"> ⑦ 566-97-46180, 2 pieces, Pin ⑧ 07020-00675, 2 pieces, Fitting ⑨ 281-70-15290, 2 pieces, Plate ⑩ 01010-81425, 4 pieces, Bolt ⑪ 01643-31445, 4 pieces, Washer 	

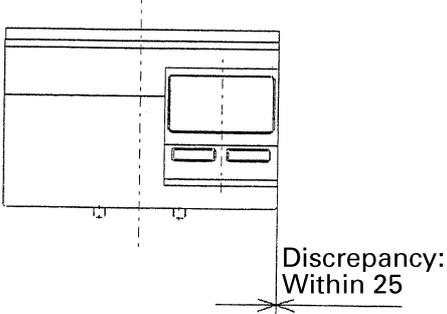
ADJUSTING BODY SHIMS

Process drawing



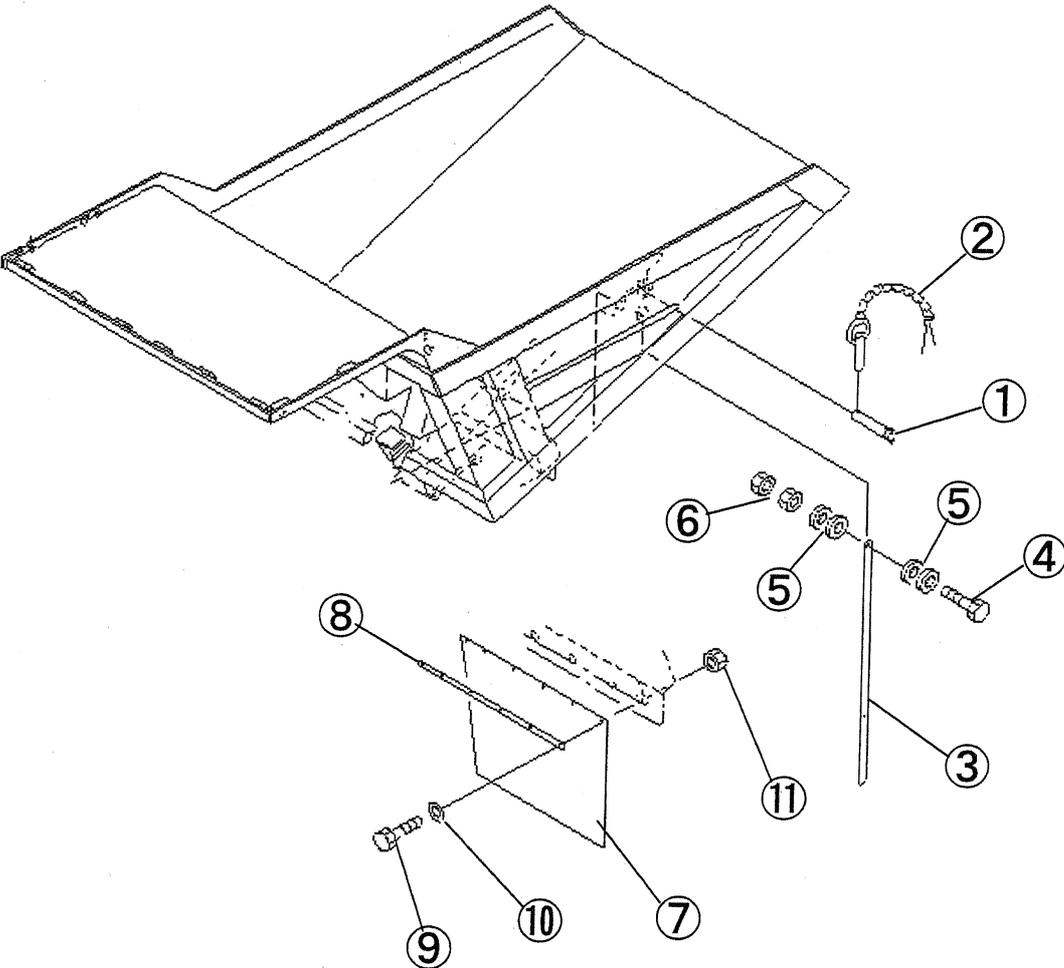
Process drawing



Order of work	Work procedure
<p>1. Adjusting the body mount shim Adjust the body mount shim according to the following procedure.</p> <p>(1) Bottom mounts (Rubber mounts of body bottom plate)</p> <ol style="list-style-type: none"> A. Insert a spacer 40 mm thick in the body end. B. Measure distance δ between the center of the body mount and the frame (6 places on both sides). C. Insert shims ($\delta 1 - 38$), ($\delta 2 - 38$), and ($\delta 3 - 38$) thick in the points of $\delta 1$, $\delta 2$, and $\delta 3$ respectively. D. Install the bottom mounts and remove the spacers. E. Lower the body and check that all of the 6 bottom mounts are in contact with the frame top. F. Finish adjustment of the bottom mounts. <p>(2) Front mounts (Rubber mounts of body front plate)</p> <ol style="list-style-type: none"> A. After the above adjustment of the bottom mounts, measure distances A1 and A2 between the body front mount and frame rear support. B. Set the thicknesses (quantity) of shims (569-74-61580) to (A1 - 51) mm and (A2 - 51) mm respectively. C. Install the shims having the thicknesses calculated in B above and then install rubber pad (569-74-61520). D. Lower the body and check that the total thickness of the rubber pad is 51 mm. If the total thickness is not 51 mm, adjust it to 51 mm with the shims. (Deflection: 1 mm) E. Finish adjustment of the front mount. 	<p>• After the body is installed, the discrepancy between the protector and cab must be 25 mm or less. If the discrepancy exceeds 25 mm, adjust it to below 25 mm with the shims of hinge pin (566-97-46170).</p> 

INSTALLING BODY ACCESSORIES

Process drawing



Order of work	Work procedure
<p>1. Install the safety pins.</p> <ul style="list-style-type: none"> ① 569-74-61670, 2 pieces, Pin ② 569-74-61470, 2 pieces, Pin <p>2. Install the poke ejector.</p> <ul style="list-style-type: none"> ③ 566-74-6A620, 2 pieces, Bar ④ 01011-82405, 2 pieces, Bolt ⑤ 01640-22540, 8 pieces, Washer ⑥ 01580-12419, 4 pieces, Nut <p>3. Install the mudguard.</p> <ul style="list-style-type: none"> ⑦ 566-74-41512, 2 pieces, Plate ⑧ 566-74-41521, 2 pieces, Plate ⑨ 01010-81235, 12 pieces, Bolt ⑩ 01643-31232, 12 pieces, Washer ⑪ 01580-11210, 12 pieces, Nut 	

Order of work	Work procedure
<p>1. Install the spill guard and platform guard to the body.</p> <ul style="list-style-type: none"> ① 566-74-41431, 1 piece, Guard ② 566-74-41460, 1 piece, Guard (L) ③ 566-74-41470, 1 piece, Guard (R) ④ 01010-81225, 20 pieces, Bolt ⑤ 01643-31232, 20 pieces, Washer ⑥ 566-74-41480, 2 pieces, Plate ⑦ 01010-81225, 8 pieces, Bolt ⑧ 01643-21232, 8 pieces, Washer <p>HD325-6</p> <ul style="list-style-type: none"> ⑨ 566-74-41442, 1 piece, Guard ⑩ 566-74-41451, 1 piece, Guard ⑪ 01010-81225, 20 pieces, Bolt ⑫ 01643-31232, 20 pieces, Washer <p>HD405-6</p> <ul style="list-style-type: none"> ⑬ 569-83-65920, 1 piece, Guard ⑭ 569-83-65930, 1 piece, Guard ⑮ 01010-81440, 16 pieces, Bolt ⑯ 01643-31445, 16 pieces, Washer ⑰ 01010-81435, 8 pieces, Bolt ⑱ 01643-31445, 8 pieces, Washer 	