

# Field Assembly Instruction

DUMP TRUCK

**HD325-6**

SERIAL NUMBERS HD325-6588-6591

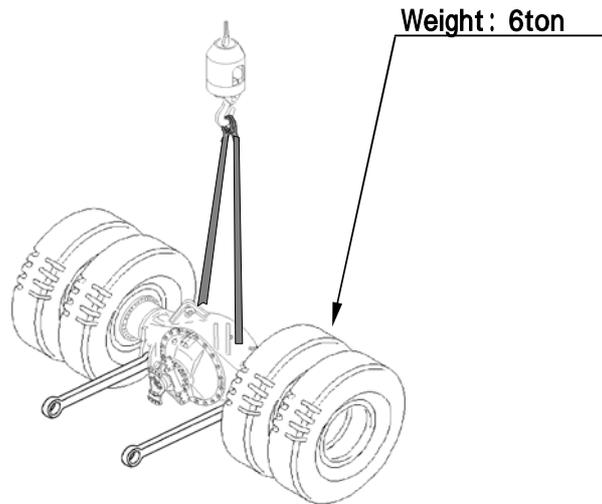
TRANSPORTED IN WIDTH OF 2,900mm

**KOMATSU**

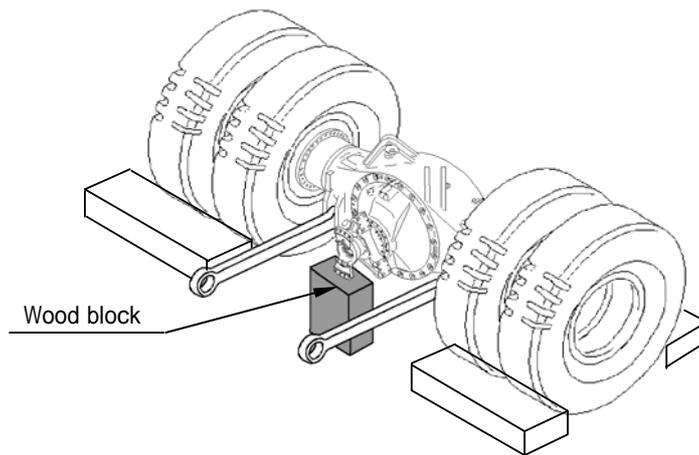
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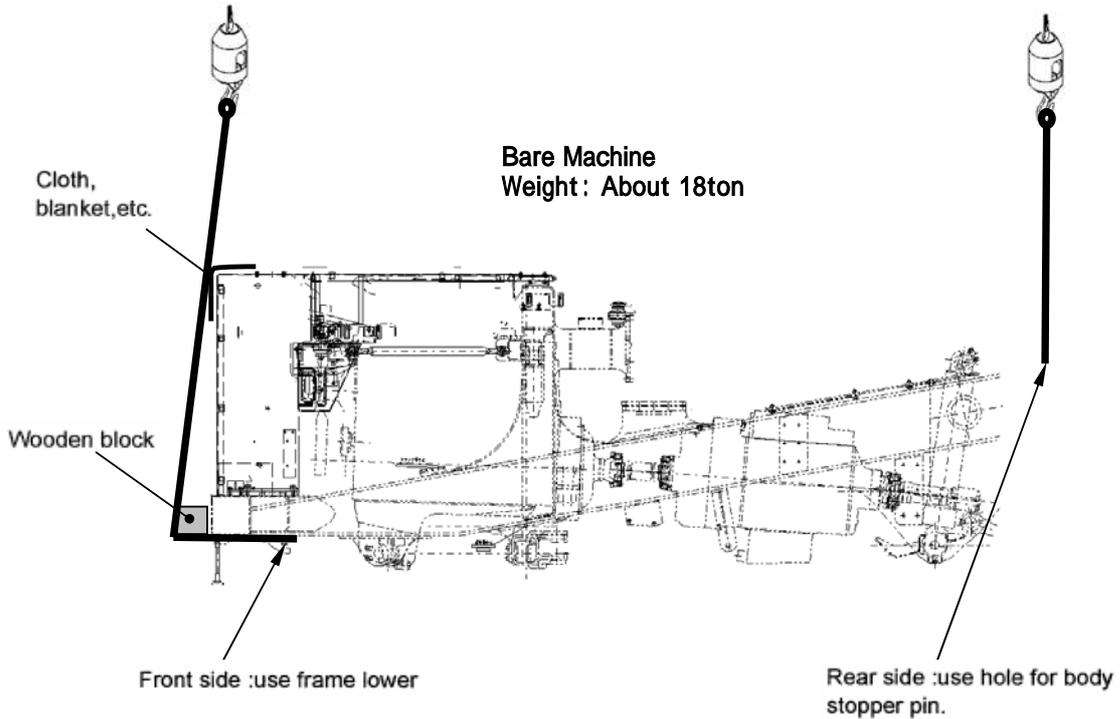


1. Sling the rear axle and tire assembly with 1,245 kN {25 ton} crane.  
Hanging points: Rod mounting parts on differential.



2. Position the rear axle as shown above.  
(Secure the clearance between the ground and coupling as shown above so that the rear axle assembly will be horizontal.)  
When positioning the assembly on the ground, take proper measures so that the assembly will not sink and lean.
3. Secure the rear axle with chocks.

Precautions	Necessary tools		Necessary equipment	
	Name	Q'ty	Name	Q'ty
Fix the wheels with chocks to prevent the rear axle from moving.				
Other remarks				

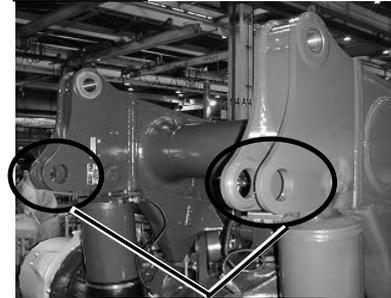


Front side



Front lifting point

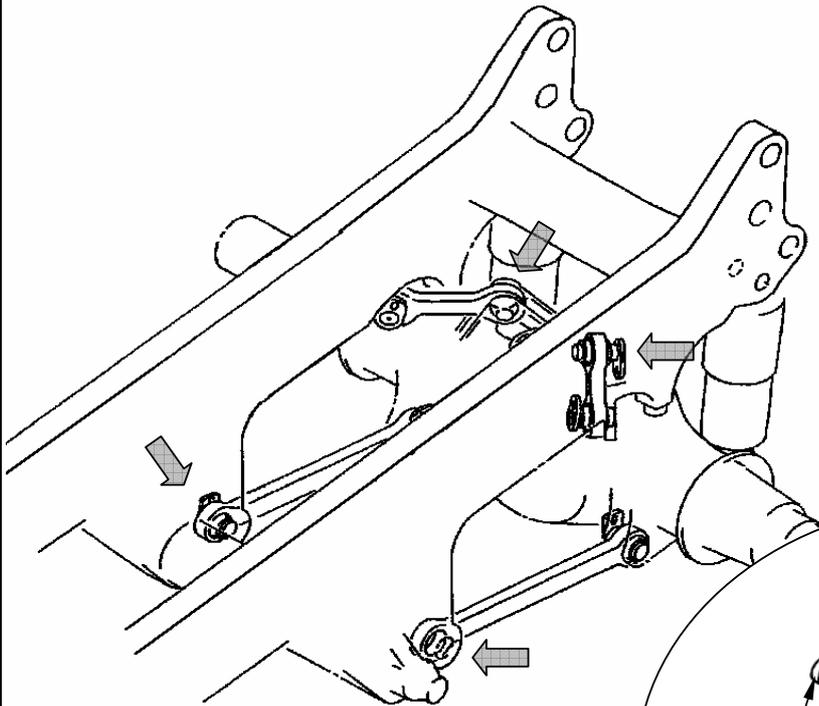
Rear side



Rear lifting point

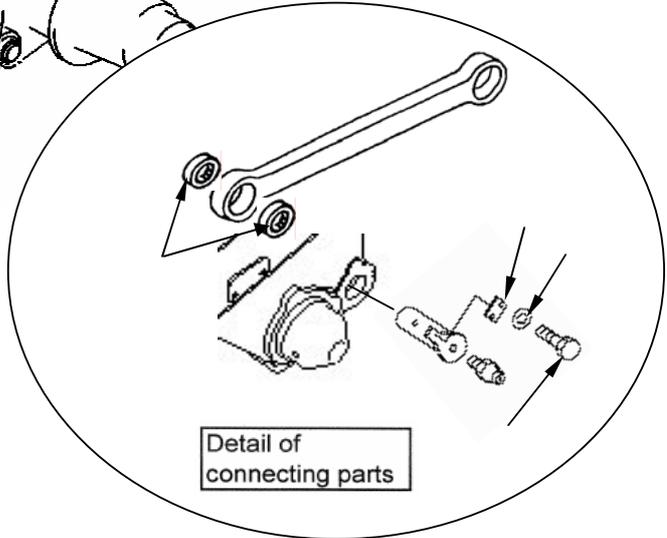
1. When slinging the chassis, apply cloths to protect it.
2. Lift up chassis using 25 tons crane for front side and 25 tons crane for rear side.  
 Sling : Chain sling (ATH-465-040) or wires 28 mm in diameter  
 Front hanging point: Hanging bracket of bumper  
 Rear hanging point: Mounting part of body lock pin (Use pin 60 mm in diameter × 250 or body lock pin)  
 Part No.: 569-74-61670 (Red)

Precautions	Necessary tools		Necessary equipment	
	Name	Q'ty	Name	Q'ty
			Crane: 25ton	2
			ATH-465-040	2
Other remarks				



Note: Thinly apply grease (G2-LI) to pin (1).

1. Install the upper axle rod.
2. Install the lower axle rod.

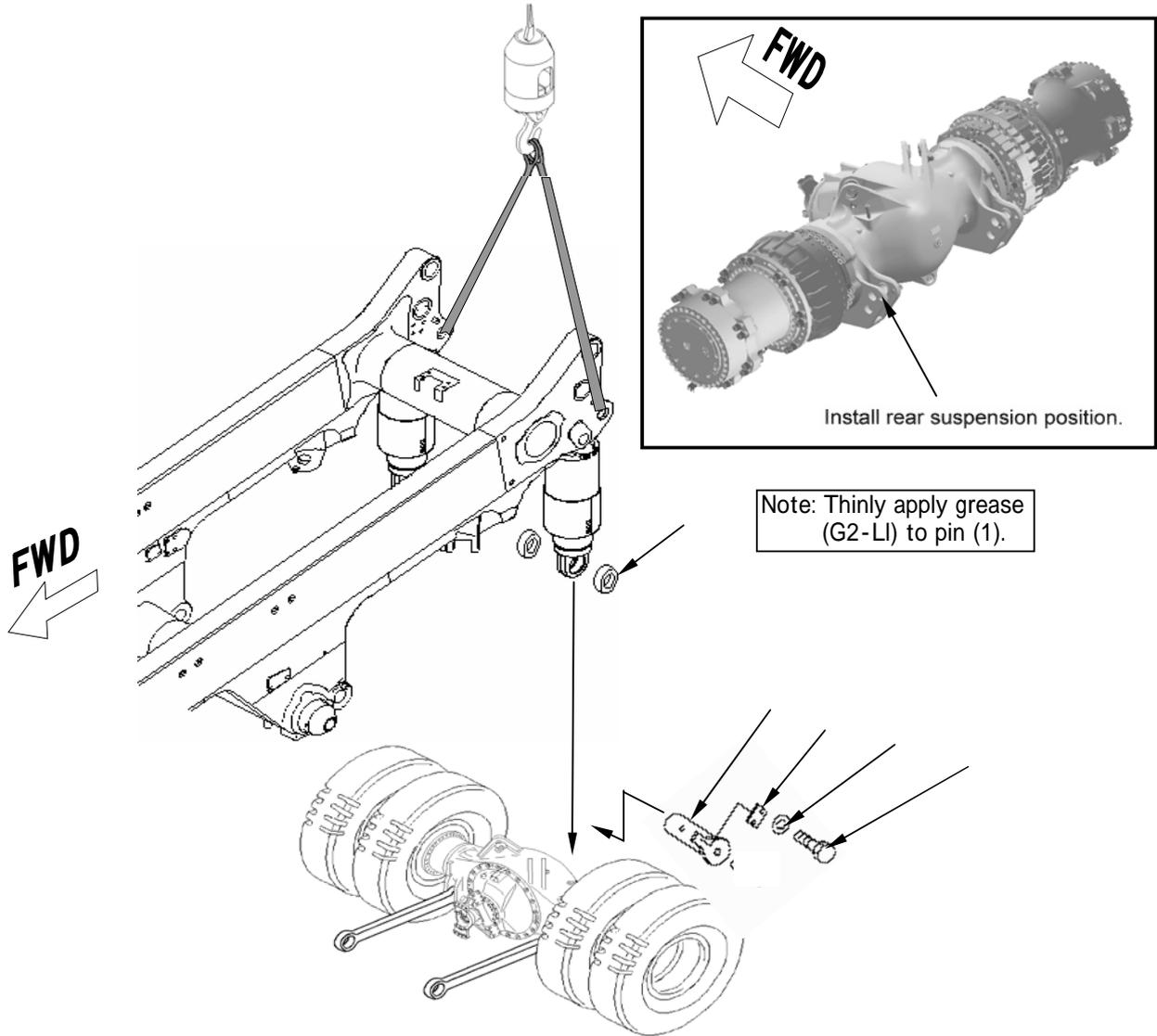


Detail of connecting parts

	Part No.	Part name	Q'ty	State of parts
(1)	566-52-11141	PIN	4	Temporarily installed to rear axle and chassis
(2)	01010-81425	BOLT	8	Temporarily installed to rear axle and chassis
(3)	01643-31445	WASHER	8	Temporarily installed to rear axle and chassis
(4)	281-70-15290	PLATE	4	Temporarily installed to rear axle and chassis
(5)	566-52-41950	SPACER	8	Temporarily installed to rear axle and chassis

1. Remove the pins from the upper rod connecting part on the axle side and the pins from the lower rod connecting part on the chassis side. ((1) – (5) in the figure)
2. Move the crane to match the pin holes and connect the axle rods.

Precautions	Necessary tools		Necessary equipment	
	Name	Q'ty	Name	Q'ty
1. If the spacers are installed forcibly, they are deformed. Take care. 2. When holding a spacer, take care not pinch your fingers. 3. Do not break the bellows by installing it forcibly.				
Other remarks				

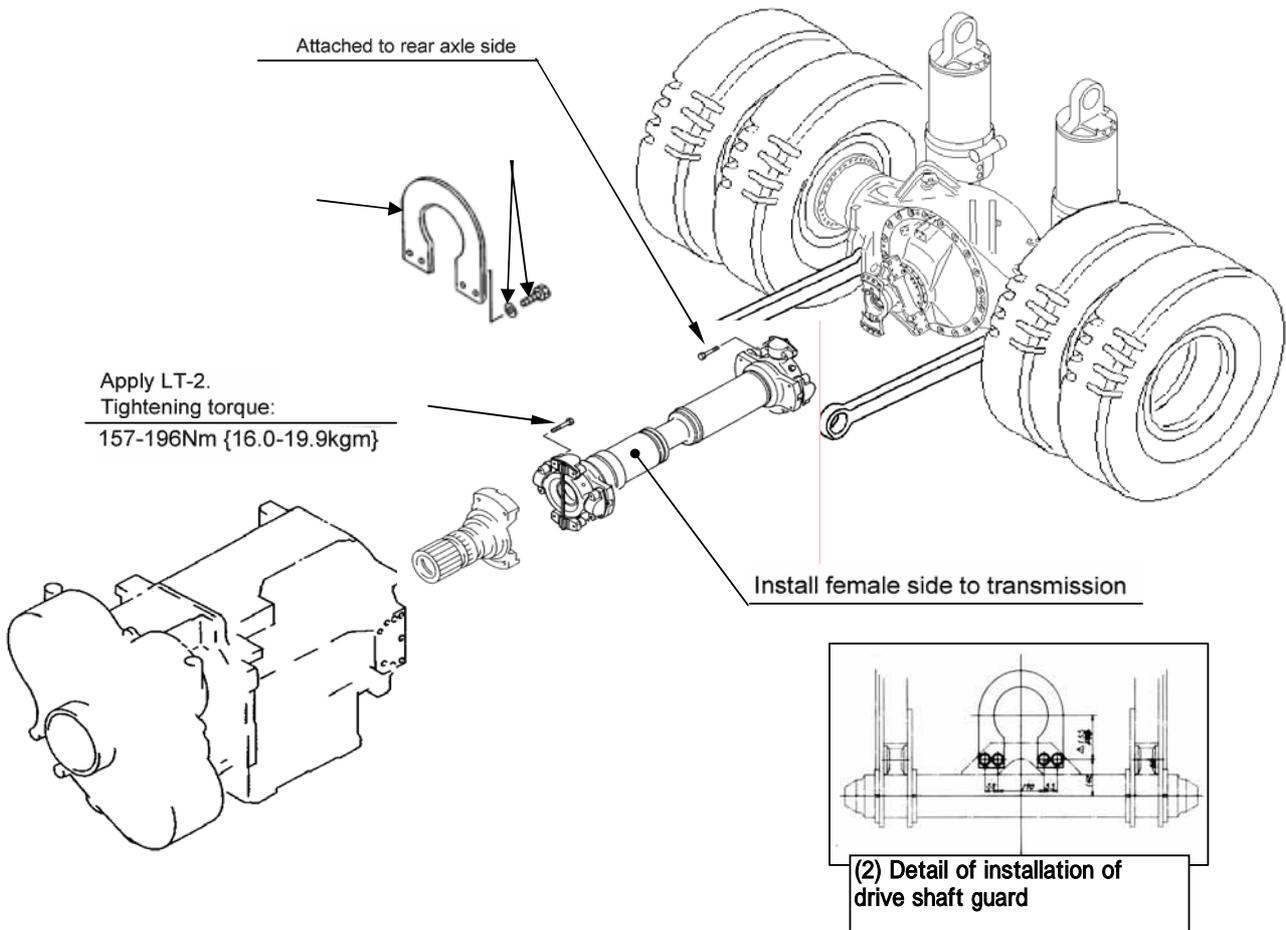


Note: Thinly apply grease (G2-LI) to pin (1).

	Part No.	Part name	Q'ty	State of parts
(1)	566-52-11141	PIN	2	Temporarily installed to rear axle
(2)	01010-81425	BOLT	4	Temporarily installed to rear axle
(3)	01643-31445	WASHER	4	Temporarily installed to rear axle
(4)	281-70-15290	PLATE	2	Temporarily installed to rear axle
(5)	566-52-11120	SPACER	4	Temporarily installed to rear axle

1. Guide the slung bare machine to above the rear axle.
2. Remove the pins ((1) – (4) in the figure) on the rear axle side.
3. While matching the rear suspension fixing hole, insert the pin and fix it with the bolt.

Precautions	Necessary tools		Necessary equipment	
	Name	Q'ty	Name	Q'ty
Fix the wheels with chocks to prevent the rear axle from moving.				
Other remarks				



	Part No.	Part name	Q'ty	State of parts
(1)	510-20-12820	BOLT	4	Loose-supply item (Packed separately)
(2)	569-89-62212	GUARD	1	Temporarily installed to frame
(3)	01010-82470	BOLT	4	Temporarily installed to frame
(4)	01643-31645	WASHER	4	Temporarily installed to frame

1. Remove guard (2) from the chassis (only when the attachment of rear drive shaft guard is installed).
2. Sling the drive shaft with the crane and put it between the rear axle and transmission.
3. Hit the drive shaft spider lightly with a hammer to fit the socket and spigot.
4. Check that the socket and spigot are fixed together, and then tighten the bolts. (For the tightening order, see Fig. 1)
5. Tighten the bolts again with the torque wrench.  
(Tightening torque: 157 – 196 Nm {16.0 – 19.9 kgm})
6. Install the guard (2) again.

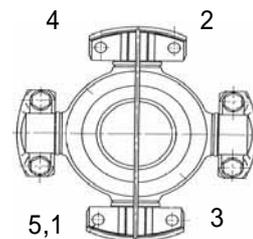
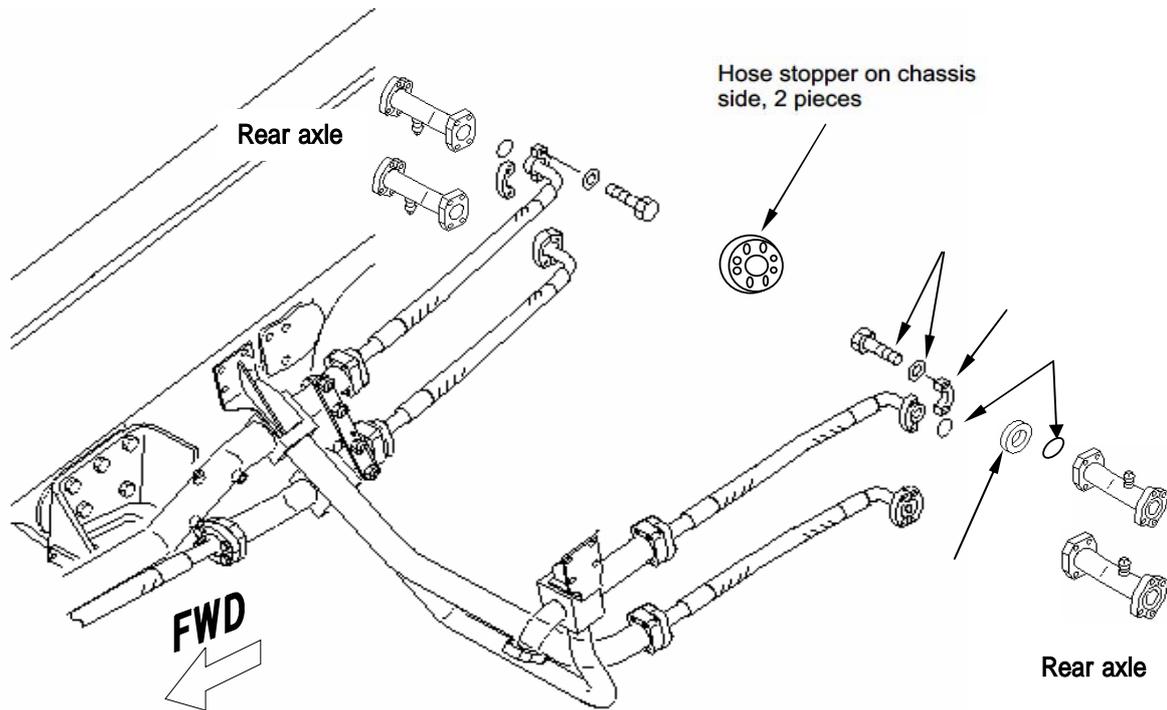


Fig. 1

Precautions	Necessary tools		Necessary equipment	
	Name	Q'ty	Name	Q'ty
Tighten the bolts in the order shown in the figure.	Torque wrench 1,800QL	1		
Other remarks				

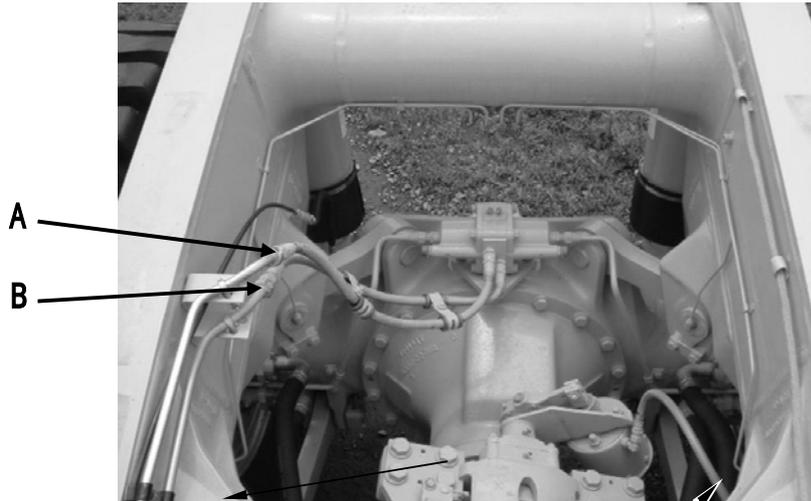


	Part No.	Part name	Q'ty	State of parts
(1)	07371-21465	FLANGE	8	Installed parts
(2)	07375-21240	BOLT	16	Installed parts
(3)	07000-F3048	O-RING	5	Installed parts
(4)	566-61-6F470	FLANGE	1	Installed parts

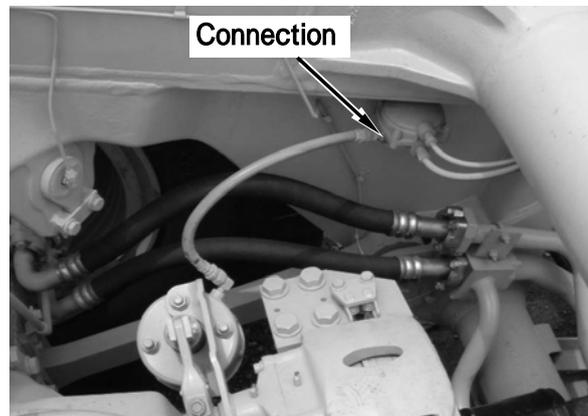
1. Remove hose stoppers on the chassis side (2 pieces) and tube stoppers on the rear axle (4 pieces).
2. Using the above parts, connect the cooling hose.  
(Use parts (1) – (3) attached on either axle side or chassis side. Discard the rest.)

\* Use flange for only left IN (upper) side.

Precautions	Necessary tools		Necessary equipment	
	Name	Q'ty	Name	Q'ty
1. When connecting, prevent foreign matter from entering. 2. Check that the O-ring is fitted securely.				
Other remarks				



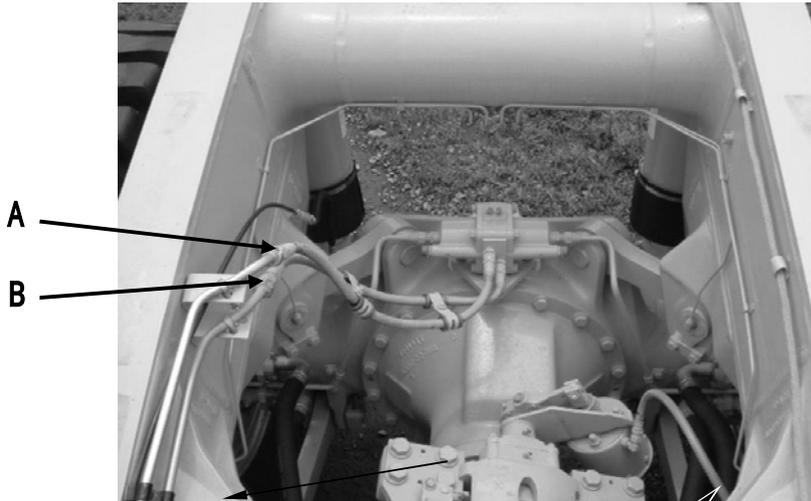
Parking



Detail of connection of parking

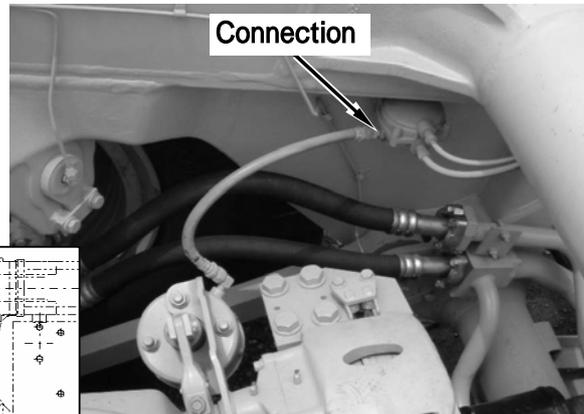
1. Remove the stopper from each opening.
2. Connect the 3 hoses.

Precautions	Necessary tools		Necessary equipment	
	Name	Q'ty	Name	Q'ty
1. Do not mistake the positions of hoses A and B for each other. 2. When remove a stopper from each opening, do not lose the O-ring.				
Other remarks				

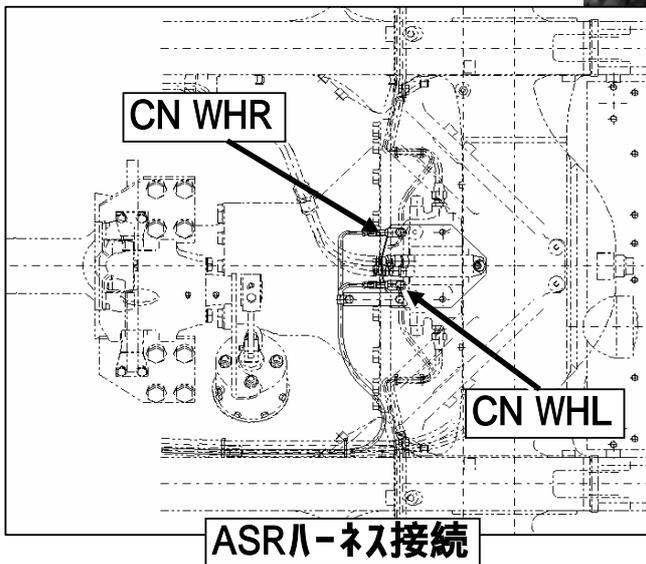


1. Remove the stopper from each opening.
2. Connect the 3 hoses.
3. Connect the ASR wiring harness.

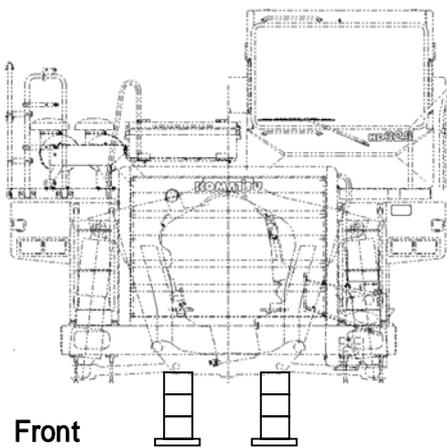
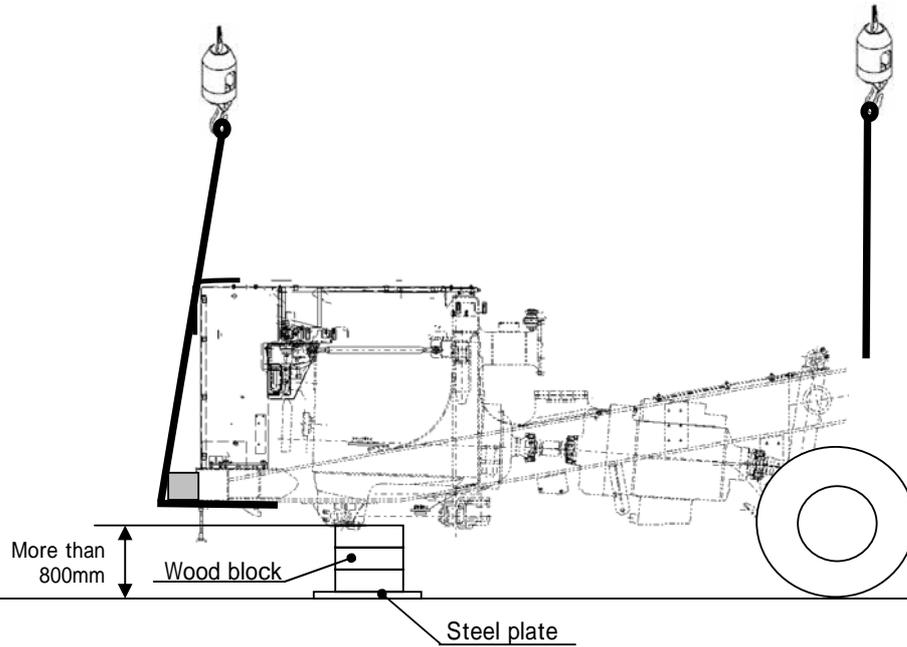
Parking



Detail of connection of parking

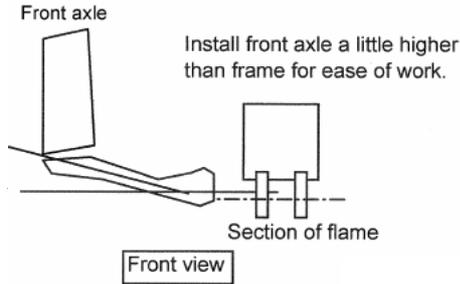


Precautions	Necessary tools		Necessary equipment	
	Name	Q'ty	Name	Q'ty
1. Do not mistake the positions of hoses A and B for each other. 2. When remove a stopper from each opening, do not lose the O-ring.				
Other remarks				

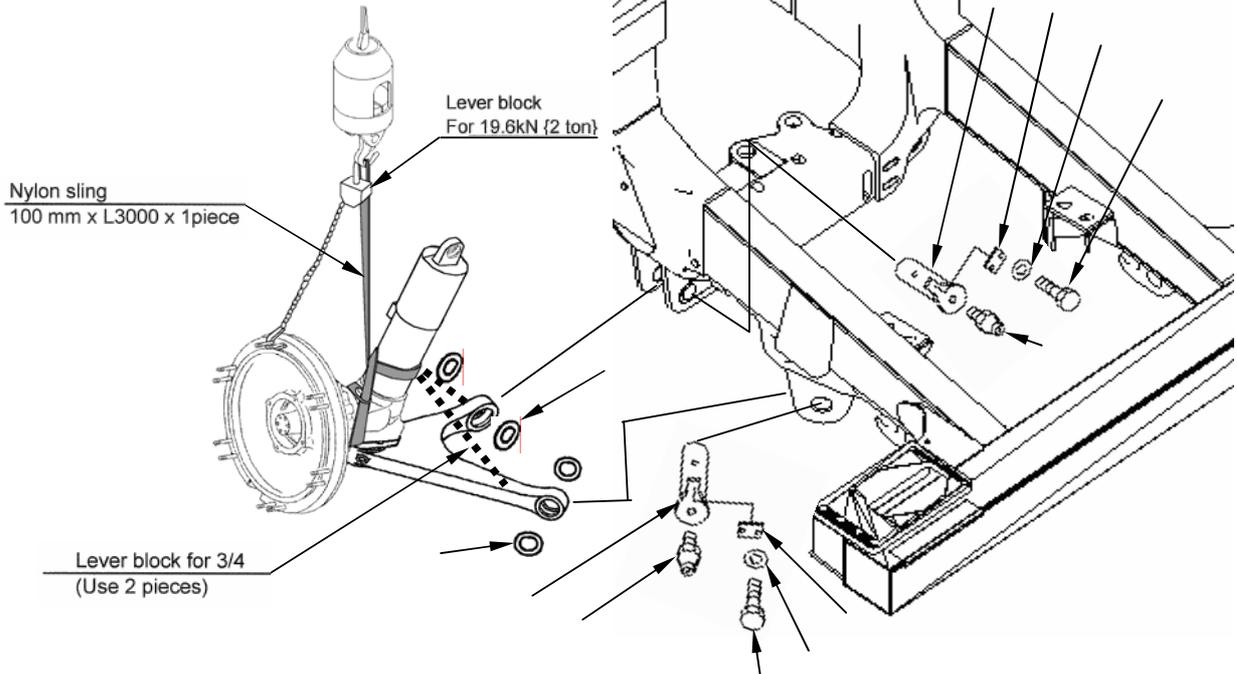


1. Position the frame vertical of the bare machine on wood blocks as shown above.  
 (Secure the clearance above the ground as shown above so that you can install the front tires.)  
 When positioning the bare machine on the ground, place a steel plate under the wood blocks so that the bare machine will not sink and lean.
2. Remove the sling.

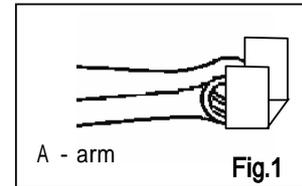
Precautions	Necessary tools		Necessary equipment	
	Name	Q'ty	Name	Q'ty
Choose a flat large prace.  The care that the chassis will not move.  Set the bare machine to proper height so that you can install the front tires.				
Other remarks				



\* Same work on right and left sides



1. Remove (1) - (6) installed to the chassis temporarily.
2. Before installing, clean the pin holes.
3. Match the mounting holes of the chassis and A-arm.  
(Adjust them with lever blocks, etc.)
4. Install (1) - (4) and fix them with lock bolts (5) and (6).  
(You can walk easily by bending a thin sheet and using it to hold each spacer.)

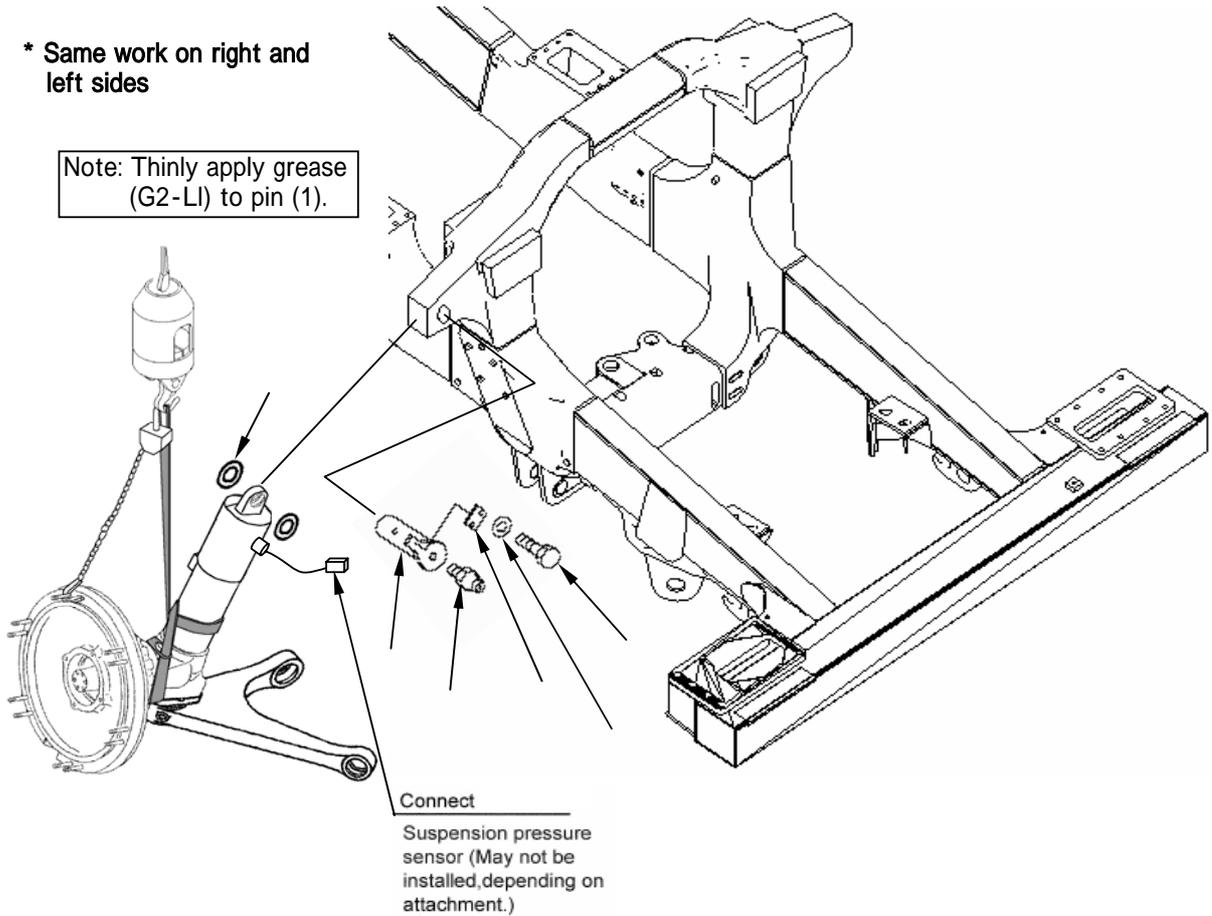


	Part No.	Part name	Q'ty	State of parts
(1)	286-70-15330	PIN	2	Temporarily installed to chassis
(2)	07020-00000	FITTING	2	Temporarily installed to chassis
(3)	566-52-41950	SPACER	4	Temporarily installed to chassis
(4)	281-70-15290	PLATE	2	Temporarily installed to chassis
(5)	01010-81425	BOLT	4	Temporarily installed to chassis
(6)	01643-31445	WASHER	4	Temporarily installed to chassis

Precautions	Necessary tools		Necessary equipment	
	Name	Q'ty	Name	Q'ty
1. Do not install the spacer forcibly. If it is installed so to will be deformed.			Lever block (For 2 ton)	1
			Lever block (For 3/4 ton)	2
2. When holding the spacer, take care not to catch your fingers in it.			Nylon sling (100mm x L3,000)	1
Other remarks				

\* Same work on right and left sides

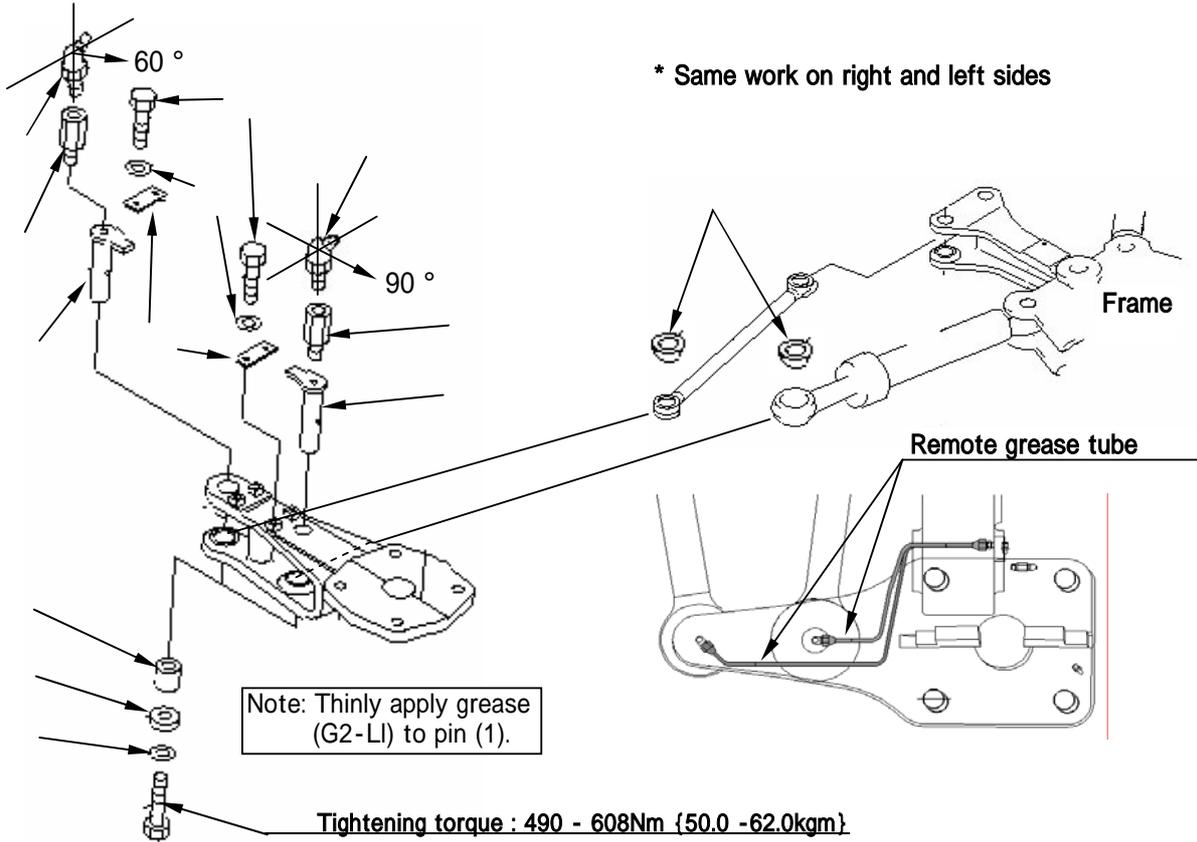
Note: Thinly apply grease (G2-LI) to pin (1).



1. Remove (1) - (6) installed to the chassis temporarily.
2. Before installing the axle, clean the pin insertion part.
3. Align the pin holes and connect the axle.
4. Install (1) - (4) and fix them with lock bolts (5) and (6).

	Part No.	Part name	Q'ty	State of parts
(1)	566-52-11141	PIN	1	Temporarily installed to chassis
(2)	07020-00000	FITTING	1	Temporarily installed to chassis
(3)	566-52-11120	SPACER	2	Temporarily installed to chassis
(4)	281-70-15290	PLATE	1	Temporarily installed to chassis
(5)	01010-81425	BOLT	2	Temporarily installed to chassis
(6)	01643-31445	WASHER	2	Temporarily installed to chassis

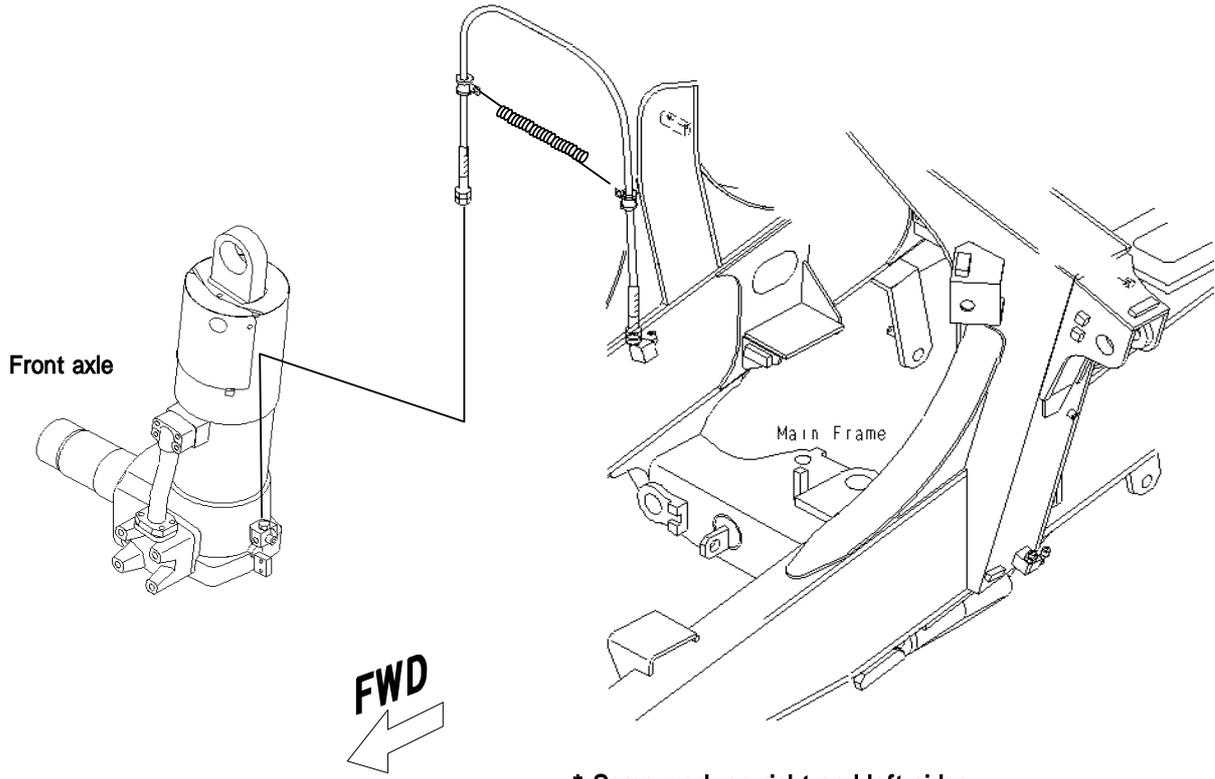
Precautions	Necessary tools		Necessary equipment	
	Name	Q'ty	Name	Q'ty
1. Do not install the spacer forcibly. If it is installed so to will be deformed.				
2. When holding the spacer, take care not to catch your fingers in it.				
Other remarks				



1. Remove the pin side of the remote grease tube, and then remove the pins.
2. Adjust the axle so that the steering cylinder and tie rod will be in parallel with the axle lever.
3. Set (2) and install the pin, aligning the pin holes.
4. Fix the pin with the set bolt.
5. Connect the remote grease tube again.
6. After connecting, supply grease. (See No. 0420 .)

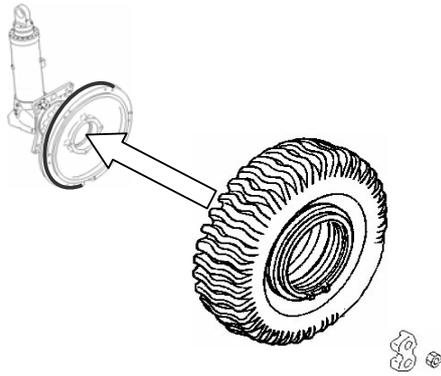
	Part No.	Part name	Q'ty	State of parts
(1)	566-40-41510	PIN	2	Temporarily installed to front axle
(2)	566-40-51530	BUSHING	2	Temporarily installed to front axle
(3)	566-40-41550	SPACER	2	Temporarily installed to front axle
(4)	566-40-41540	PLATE	2	Temporarily installed to front axle
(5)	01010-82050	BOLT	2	Temporarily installed to front axle
(6)	01643-32060	WASHER	2	Temporarily installed to front axle
(7)	281-70-15290	PLATE	2	Temporarily installed to front axle
(8)	01010-81430	BOLT	4	Temporarily installed to front axle
(9)	01643-31445	WASHER	4	Temporarily installed to front axle
(10)	421-09-12540	ELBOW	2	Temporarily installed to front axle
(11)	562-95-13150	NIPPLE	2	Temporarily installed to front axle

Precautions	Necessary tools		Necessary equipment	
	Name	Q'ty	Name	Q'ty
1. Check that the O-rings are fitted to the steering cylinder and tie rod spherical bushing.				
Other remarks				



1. Connect the brake hoses of the right and left front axes.

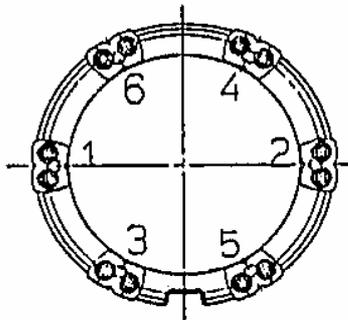
Precautions	Necessary tools		Necessary equipment	
	Name	Q'ty	Name	Q'ty
Other remarks				



Before installing the tire, remove masking tape or rust-preventive oil from tire mounting taper surface.

**<FRONT TIRE>**

1. Rim size: 13:00 x 33 (Tire size: 18.00-33)
2. Tire inflation pressure (At normal temperature)
  - 18.00-33-28-PR 0.49 MPa { 5.0 kg/cm<sup>2</sup> }
  - 18.00-33-32-PR 0.56 MPa { 5.7 kg/cm<sup>2</sup> }
  - 18.00R33 0.69 MPa { 7.0 kg/cm<sup>2</sup> }
3. Tighten valve nut to torque of  $4.9 \pm 1.0$  Nm {  $0.5 \pm 0.1$  kgm }, valve core to 0.29 Nm { 0.03 kgm }, and valve cap to  $2.9 \pm 0.5$  Nm {  $0.3 \pm 0.05$  kgm }.
4. Before installing the tire, remove dirt, sand, rust, oil and grease.
5. Tighten clamp 569-22-62841 according to the following procedure.
  - 1) Tighten clamp (569-22-62841) with nuts (569-22-62870). Tighten the nuts in the order shown in Fig 1. At this time, reduce the lateral runout of the tire to 5 mm or less.
  - 2) Tightening torque for clamp nut
    - When threads and nut seat are coated with LM-G: 824 - 1,030 Nm <Target: 924 Nm>  
(84 - 105 kgm <Target: 94.5 kgm>)
    - When threads and nut seat are coated with nothing: 1,079 - 1,324 Nm <Target: 1,206 Nm>  
(110 - 135 kgm <Target: 123 kgm>)



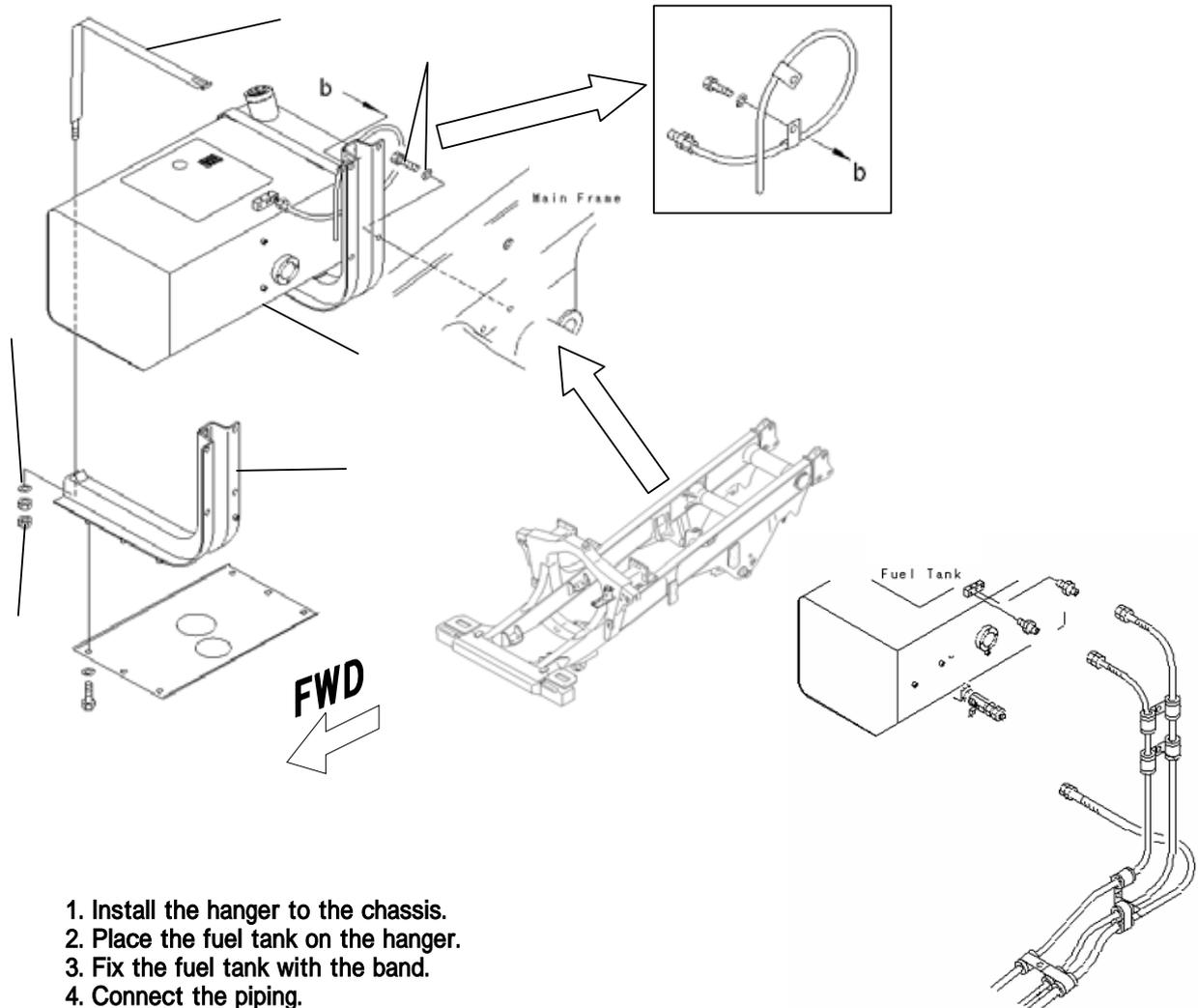
Installation procedure for clamp

	Part No.	Part name	Q'ty	State of parts
(1)	569-22-62841	CLAMP	24	Temporarily installed to axle
(2)	569-22-62870	NUT	24	Temporarily installed to axle

Precautions	Necessary tools		Necessary equipment	
	Name	Q'ty	Name	Q'ty
Other remarks				

**Assembly process No. 0140**

**Installation of fuel tank**



1. Install the hanger to the chassis.
2. Place the fuel tank on the hanger.
3. Fix the fuel tank with the band.
4. Connect the piping.

**Detail of connection**

	Part No.	Part name	Q'ty	State of parts
(1)	566-04-6A30A	FUEL TANK ASSEMBLY	1	Loose-supply item (Packed separately)
(2)	566-04-1314A	HANGER	2	Temporarily installed to fuel tank
(3)	566-04-41131	BAND	2	Temporarily installed to fuel tank
(4)	01580-11210	NUT	4	Temporarily installed to fuel tank
(5)	01643-31232	WASHER	2	Temporarily installed to fuel tank
(6)	01010-82040	BOLT	8	Temporarily installed to frame
(7)	01643-32060	WASHER	8	Temporarily installed to frame

Precautions	Necessary tools		Necessary equipment	
	Name	Q'ty	Name	Q'ty
Other remarks				