

Product: KOMATSU HD785-3 Rigid Dump Truck Service Repair Field Assembly Manual(SEAWD05610300)

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SEAW05610300

FIELD ASSEMBLY INSTRUCTION

HD785-3

DUMP TRUCK

**MACHINE MODEL
HD785-3**

**SERIAL NO.
2001 AND UP**

KOMATSU

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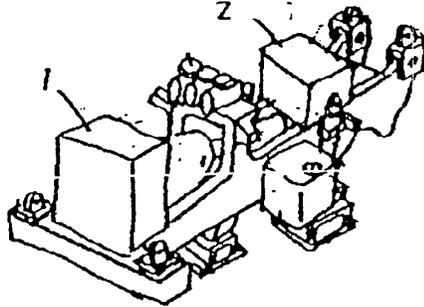
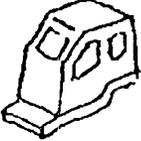
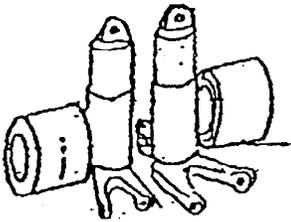
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PACKING LIST

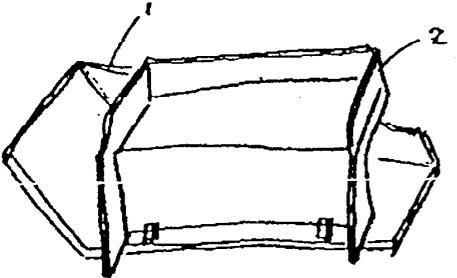
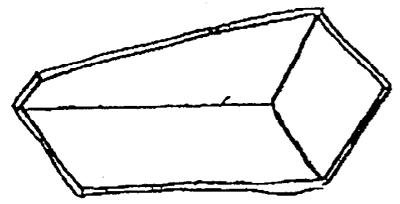
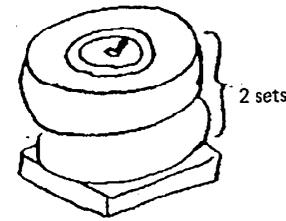
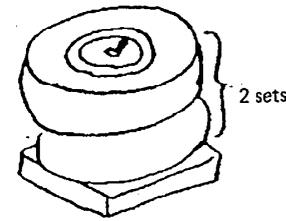
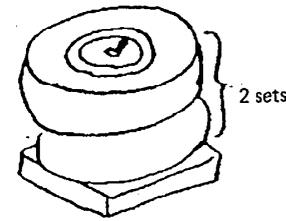
Note 1: The figures in () show the net dimensions and weights.

Note 2: Take the parts (bolts, washers, nuts, holding plates, etc.) installing the separately packed parts and install them to their correct positions.

Packing number	Unit name	Unit q'ty	Packing specification	Dimensions and weights per unit (Note 1)					Packing diagram	Content of each unit						
				L (mm)	W (mm)	H (mm)	m ³	W (kg)		Part Name	Part No.	Q'ty	Remarks			
1	Chassis	1	Skid	7755	3930	3000		25700		Chassis assembly [Engine Radiator Transmission Hydraulic tank Hoist cylinder Air cleaner Others]		1				
								(24000)								
2	Cab	1	Crate	2800	2000	1900		800		Cab assembly [Catwalk Guard Others]		1				
								(2540)						(1800)	(1600)	(600)
3	Front axle		Crate	3000	2200	2200		6000		Front axle assembly [Suspension Brake A-frame Others]		1				
								(2700)						(1950)	(1800)	(2500 x 2)
4	Rear axle		Skid	4848	1589	1560		10000		Rear axle assembly		1				
								(4848)						(1589)	(1260)	(9600)

Note 1: The figures in () show the net dimensions and weights.

Note 2: Take the parts (bolts washers, nuts, holding plates, etc.) installing the separately packed parts and install them to their correct positions.

Packing number	Unit name	Unit q'ty	Packing specification	Dimensions and weights per unit (Note 1)					Packing diagram	Content of each unit			
				L (mm)	W (mm)	H (mm)	m ³	W (kg)		Part Name	Part No.	Q'ty	Remarks
5	Body (R)	1	Skid	7380	3000	2900		9600 (8618)		Body (R)		1	
			Body					5091		Protector		1	
			Extention (opt)					177					
			Protector					1315					
			Wear plate (opt)					2035					
6	Body (L)	1	Skid	7380	2700	2900		8100 (7126)		Body (L)		1	
			Body					5091					
			Wear plate (opt)					2035					
7	Tire	1	Pallet	2700	2700	1800		2900		Wheel assembly		2	
						(780 x 2)		(1381 x 2)		Wheel assembly		2	
8	Tire	1	Pallet	2700	2700	1800		2900		Wheel assembly		2	
						(780 x 2)		(1381 x 2)		Wheel assembly		2	
9	Tire	1	Pallet	2700	2700	1800		2900					
						(780 x 2)		(1381 x 2)					

Note 1: The figures in () show the net dimensions and weights.

Note 2: Take the parts (bolts washers, nuts, holding plates, etc.) installing the separately packed parts and install them to their correct positions.

Packing number	Unit name	Unit q'ty	Packing specification	Dimensions and weights per unit (Note 1)					Packing diagram	Content of each unit			
				L (mm)	W (mm)	H (mm)	m ³	W (kg)		Part Name	Part No.	Q'ty	Remarks
10	Fuel tank	1	Crate	1560	1620	1770		800		Fuel tank		1	
				(1360)	(1420)	(1470)		(600)					
11	Right platform	1	Crate	2800	1800	1500		500		Right platform assembly		1	
				(2600)	(1600)	(1200)		(400)					
12	ROPS guard	1	Bare	2430	1500	1000		1000		ROPS Guard		1	Option

LILST OF FACILITIES AND TOOLS FOR FIELD ASSEMBLY

1. Facilities and the equipment

No.	Name of facility, equipment	Specification	Quantity/unit
1	Crane	Min. 30 ton Min. 20 ton	1 1
2	Chain block	3 ton 1.5 ton	1 2
4	Lever block	3/4 ton	2
5	Blocks	300 mm x 300 mm x 1 m 150 mm x 150 mm x 0.6 m 60 mm x 60 mm x 0.3 m	18 10 2
6	Compressor	3–7 kg/cm ² , Min. 15m ³ /min	1
7	Wire rope	32 mm x 5 m 32 mm x 6 m 20 mm x 3 m 24 mm x 4 m 16 mm x 2 m 12 mm x 2 m 12 mm x 1 m 12 mm x 0.5 m 10 mm x 1.5 m 10 mm x 2.0 m 10 mm x 3.0 m	2 } (Chassis) 2 } (Body) 2 (Front axle) 2 (Rear axle) 1 (Front axle) 2 } 2 } 1 } (General) 1 } 1 } 2 }
8	Nylon sling	Width 200 mm x 12 m Width 100 mm x 5 m	1 (Cab, tire) 2 (Fuel tank, general)
9	Shackle	Pin diameter 40 mm Pin diameter 26 mm Pin diameter 15 mm	4 2 6
10	C-clamp	Max. opening: 200 – 300 mm	2
11	Hydraulic jack	30 ton	1
12	Eyebolt	M12	4
13	Oil pump	Manual or electric	1
14	Grease gun	Manual (nozzle diameter: 6.5 mm)	1
15	Oil container	Capacity: 5 liters	1
16	Ladder	Aluminum 2 m	1
17	Air gun for painting	Suction type nozzle diameter: 1.5 mm Container capacity: 1000 cc	2
18	Air hose	Inside diameter 15 mm x 15 m	2
19	Nut runner	300 kgm	1 (For tire)

2. Special tools

No.	Name of tool	Specification	Quantity/unit
1	Body sling	For body (pin) 	4
2	Front axle sling	For front axle (band) 	1

3. Tools

No.	Name of tool	Specification	Quantity/unit
1	Double-ended wrench (mm)	10 x 12, 11 x 13, 14 x 17, 17 x 19, 22 x 24, 27 x 30	2 sets
2	Single-ended wrench (mm)	32, 36, 41	1 set
3	Double-ended offset wrench set (mm)	8 x 10, 11 x 13, 12 x 14, 17 x 19, 22 x 24, 24 x 27	2 sets
4	Single-ended offset wrench	30, 32, 36, 41	1 set
5	Socket wrench set	(12.7 sq.) 10, 11, 12, 13, 14, 9/16, 5/8, 17, 11/16, 19, 22, 24, 27	2 sets
6	Socket wrench	(19 sq.) 24, 27, 30, 32, 36, 41	2 sets
7	Socket handle	12.7 sq. 19 sq.	2 2
8	Extension	12.7 sq., length 200 mm 19 sq., length 250 mm	2 1
9	Adapter	Female x male: 25.4 sq. x 19 sq. Female x male: 19 sq. x 12.7 sq.	2 2
10	Torque wrench	2000 kgcm, 25000 kgcm max	1 each
11	Pipe	45φ x L1000, 45φ x L1500	1 each
12	Hammer	Length of handle 300, 226 g Length of handle 450, 910 g	1 1
13	Large hammer	Length of handle 900, 3600 g	1
14	Pliers	Length 200 mm	1
15	Pincers		1
16	Adjustable wrench	Max. jaw size 29 mm Max. jaw size 53 mm	1 1
17	Pipe wrench	Applicable diameter 20 – 50 mm Applicable diameter 50 – 100 mm	1 1
18	Screwdriver	(Cross head) large, Length of shaft: min. 200 mm (Slot head) large, Length of shaft: min. 200 mm	1 1
19	Screwdriver set	Interchangeable head type	1
20	Bar	20 – 22φ, L = 750 mm 30 – 35φ, L = 1500 mm	1 1
21	Flat chisel	Blade width 16 mm	1
22	Impactor	13S, 16S 32S	2 each 2

4. Measuring tools

No.	Name of measuring tool	Specification	Quantity/unit
1	Tire gauge	Max. pressure 10 kg/cm ²	2
2	Feeler gauge	0.04 mm – 0.3 mm	1
3	Oil pressure gauge	0 – 500 kg/cm ² 0 – 50 kg/cm ²	2 2
4	Calipers	0 – 500 mm	1
5	Tape measure	10 m	1
6	Circuit tester		1

5. Consumable parts, auxiliary materials

No.	Name of material	Specification	Quantity/unit
1	Adhesive	Three Bond No. 1101 Three Bond No. 4 Three Bond No. 1515 Three Bond No. 200 Loctite 962 Hardlock (351) A, B	1 can 1 can 1 can 1 can 1 can 1 can each
2	Grease	Lithium grease 20 kg/can Molybdenum disulphide grease 1 kg/can	1 can 1 can
3	Engine oil	SAE 30, 200 liter/can SAE10W, 200 liter/can	1 can (1 can) 1 can (3 cans)
4	Paint	Phthalic acid primer 20 kg/can Thinner for above 18 liter/can Phthalic acid yellow E2 16 kg/can Thinner for above 18 liter/can Phthalic acid red 2 kg/can Retan GP primer 4 kg/can Hardening agent for above 4 kg/can Thinner for above 16 liter/can Retan 2000 yellow E2 10 kg/can Hardening agent for above 2 kg/can Thinner for above 16 liter/can Phthalic acid blue E2 16 kg/can	1 can 1 can
5	Sealing tape		2 rolls
6	Vinyl tape		2 rolls
7	Adhesive tape		2 rolls
8	Clath		20 kg
9	Work gloves		20 pairs
10	Penetrant dye check	Penetrant: 300 cc/can Detergent: 300 cc/can Developer: 300 cc/can	1 3 1
11	Sandpaper	#66 #120 #240 #320	3 3 3 3

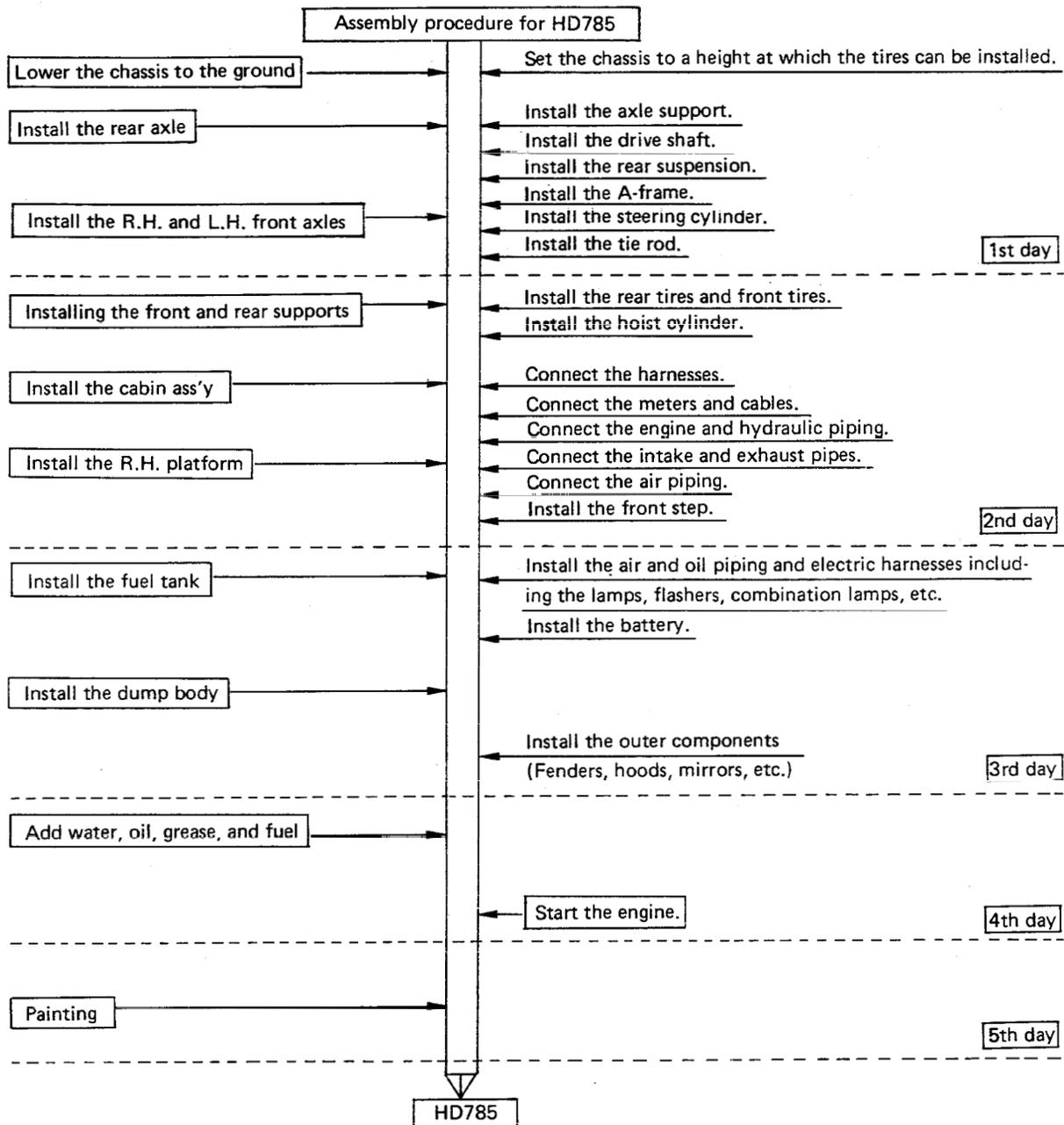
No.	Name of material	Specification	Quantity/unit
12	Wire brush		1
13	Paper mask	100 pieces/box	1 box

6. Welding the dump body

No.	Name of equipment/ material	Specifications	Quantity		Remarks
			Per distination	Per unit	
1	CO ₂ arc welder	Semi-automatic 500A		1	
2	AC arc welder	Manual 500A		1	
3	Gas welder set	Regulator, cutting nozzle, hoses, lighter, etc.		1	
4	Welding rods (for manual welding)	AWS E7016G 4.0 mm dia. AWS E7016G 5.0 mm dia.		30 kg 50 kg	
5	Wire for semi- automatic welder	Solid MIG wire 1.2 mm dia.		60 kg	
6	Welding mask	Hand-held type Helmet type		2 2	
7	Welding goggles	Colored		3	
8	Chipping hammer			2	
9	Pneumatic grinder	Grinder dia.: 180 mm		1	
10	Air hose	Inside dia.: 15 mm x 20 m		2	
11	Port power	Manual pump + 4 ton ram + 3 m hose Manual pump + 10 ton ram + 3 m hose	1 1		
12	Chisel	Flat chisel, blade width: 32 mm	2		
13	C-clamp	Dimension in use: 200 mm	2		
14	Level		1		
15	Steel rule	150 mm 300 mm 600 mm 1000 mm	2 2	1 1	
16	Tape measure	2 m		2	
17	String	20 m		1	
18	Rule	L-shape type 500 mm x 200 mm		2	
19	Steel plate	SHF80 16t x 600 mm x 600 mm	12		
20	Welding gloves	(Short) (Long)		10 10	
21	Apron			5	
22	Gas nail			2	
23	Square bar	300 mm square x 1000 mm 150 mm square x 600 mm		6 6	
24	Grindstone	180 dia. x 6 x 22		10	
25	Welding rod holder		5		
26	Cutting nozzle	No. 2	10		
27	Welding lighter		5		
28	Tip for semi- automatic welding	1.2 mm dia. 10 pieces/case		1 case/4 units	
29	CO ₂ gas	30-kg cylinder		1	
30	Acetylene gas cylinder			1/2 unit	
31	Oxygen gas cylinder			1/2 unit	

FLOW CHART AND MAN-HOURS FOR FIELD ASSEMBLY

Flow chart



Man-hours

Field assembly : 4 men x 4 days = 128 hrs/unit (8hrs/day)
 Welding dump body : 2 men x 4 days = 64 hrs/unit (8hrs/day)
 Painting : 2 men x 1 day = 16 hrs/unit (8hrs/day)

PROCEDURE FOR FIELD ASSEMBLY

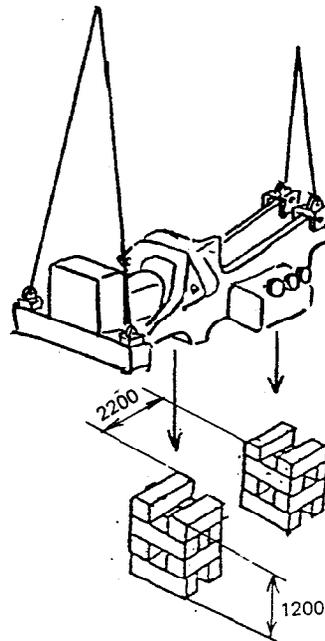
1. POSITIONING CHASSIS

Necessary facilities and tools

No.	Name (Part No.)	Q'ty
1	Crane (30-ton), Crane (20-ton)	each 1
2	Wire ($\phi 32$ -5 m)	2
3	Wire ($\phi 32$ -6 m)	2
4	Shackle (10-ton)	4
5	Block (300mm x 300mm x 1000mm) (Material : Pine)	16

1. When bringing in the frame, unload the packing holding the top part of the frame, then raise it as shown in the diagram and set it on the blocks prepared.
2. Pile the blocks as shown in the diagram.
3. Make the blocks at the front and rear the same height.

 Frame assembly: Approx. 25 tons



2. INSTALLATION OF REAR AXLE ASSEMBLY

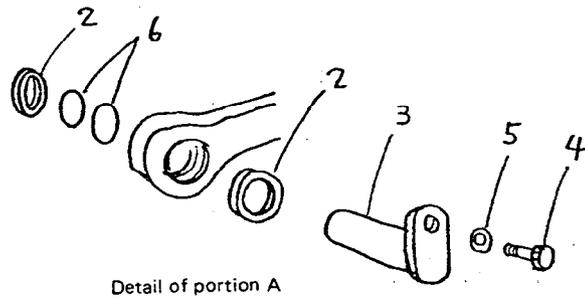
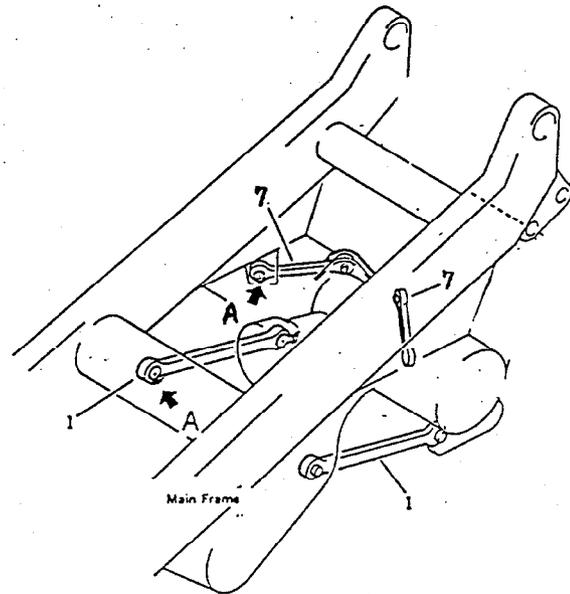
(1) Installation of rear axle support

Necessary facilities and tools

No.	Name (Part No.)	Q'ty
1	Copper hammer (3 kg)	1

Assembly parts

No.	Part Name	Part No.	Q'ty
1	Rod	561-52-61111	2
2	Ring	561-52-61150	8
3	Pin	561-52-61210	4
4	Bolt	01010-51430	4
5	Washer	569-40-61710	4
6	O-ring	07000-02080	8
7	Rod	561-52-61121	2



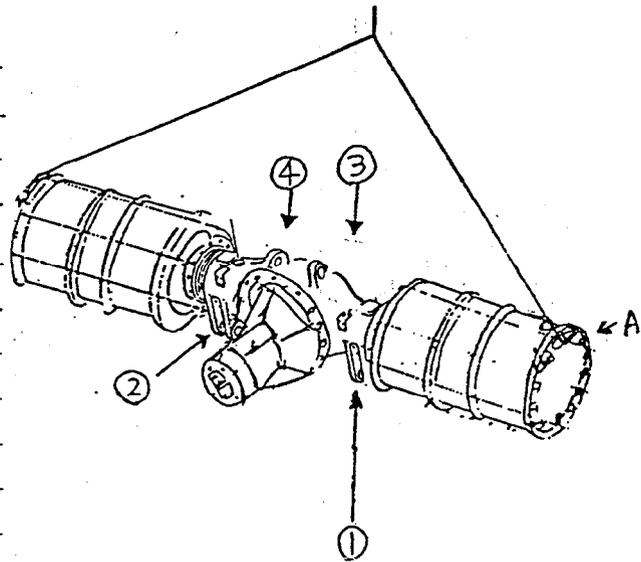
(2) Installation of rear axle assembly

Necessary facilities and tools

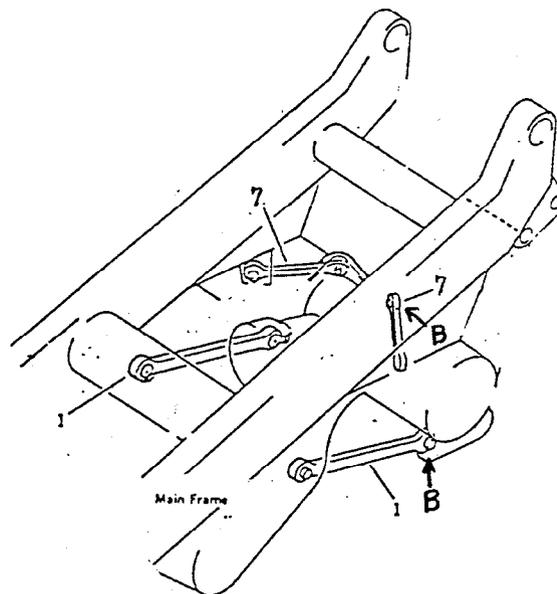
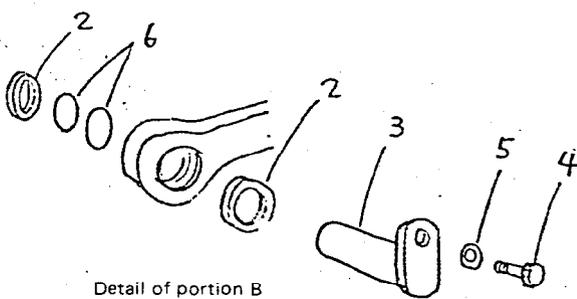
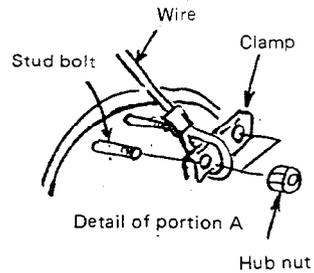
No.	Name (Part No.)	Q'ty
1	Wire ($\phi 24$ - 4m)	2
2	Copper hammer (3 kg)	1

Assembly parts

No.	Part Name	Part No.	Q'ty
1	Rod	561-52-61111	2
2	Ring	561-52-61150	8
3	Pin	561-52-61210	4
4	Bolt	01010-51430	4
5	Washer	569-40-61710	4
6	O-ring	07000-02080	8
7	Rod	561-52-61121	2



- Using the stud bolt, clamp, and hub nut for installing the tire, raise the rear axle. Then move it under the chassis a little at a time, align the rod holes in number order, and install.
- When the pins have entered all four rods, place blocks under the rear axle, and set at a height so that the tires can be installed. (Set so that the center of the axle is about 1400 mm from the ground.)



(3) Installation of rear suspension cylinder

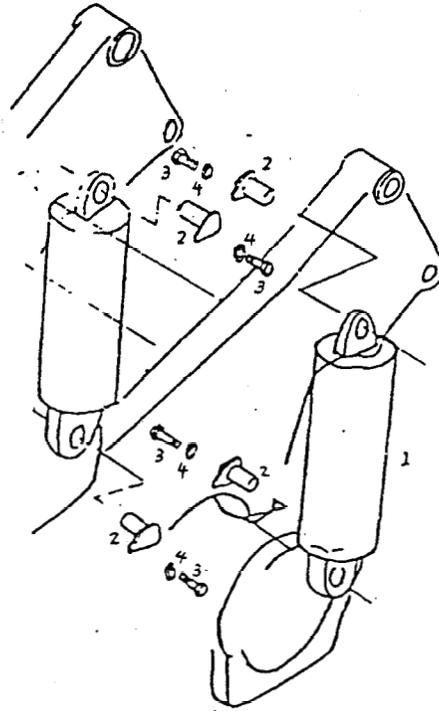
Necessary facilities and tools

No.	Name (Part No.)	Q'ty
1	Wire (φ10 - 3m)	1
2	Copper hammer (3 kg)	1

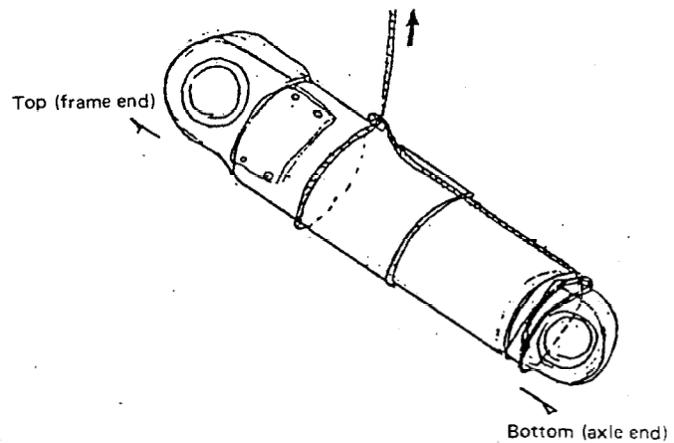
Assembly parts

No.	Part Name	Part No.	Q'ty
1	Rear suspension cylinder	561-50-64002	2
2	Pin		2
3	Bolt		4
4	Washer		4

- 1) Fix the wire to the rear suspension cylinder as shown in the diagram, and raise the cylinder.
- 2) When installing the rear suspension cylinder, install it at the frame end first (both left and right), then install the rear axle end.



Method of raising rear suspension cylinder



(4) Connecting rear brake cooling hoses

Assembly parts

No.	Part Name	Part No	Q'ty
1	Hose	07298-01411	4
2	Flange*	07377-01421	2
3	Flange	07371-31465	8
4	Bolt	07372-21240	16
5	Washer	01643-51232	16
6	O-ring	07000-23048	4
7	Bolt	07372-21240	16
8	Head*	07378-11400	4
9	O-ring*	07000-23048	4
10	Flange*	07371-31465	8
11	Bolt*	07372-21240	16
12	Washer*	01643-51232	16

*: These parts are not needed after field assembly

- 1) Remove the blind parts (② , ⑨ - ⑪). (Fig. 1)
- 2) Loosen bolts ⑦ , change the direction of hose ① , connect hose ① and the rear axle tube, then tighten bolts ④ and ⑦ . (Fig. 1, Fig. 2)

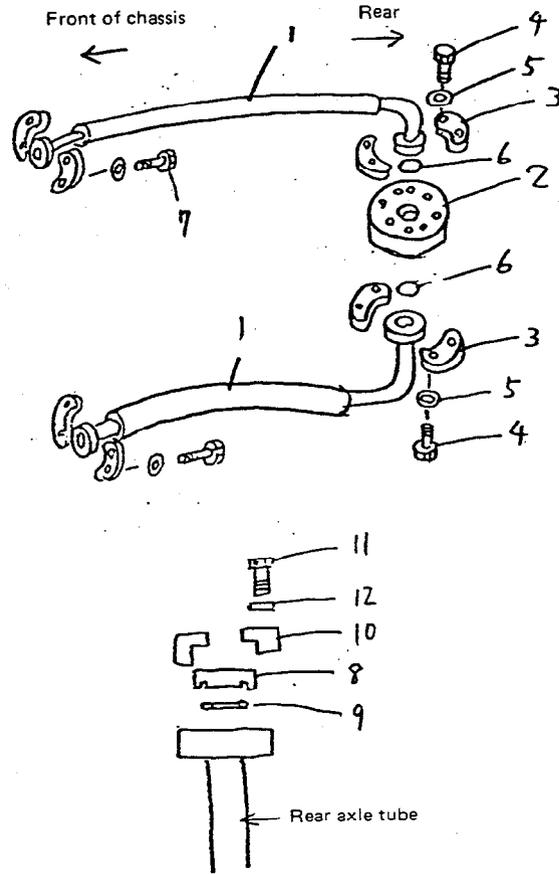


Fig. 1 Method of installing blind parts

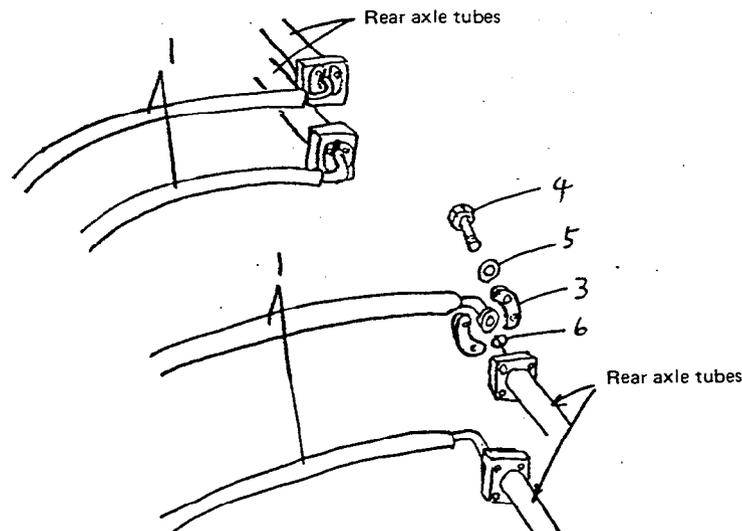


Fig. 2 Method of connecting hoses after removing blind parts

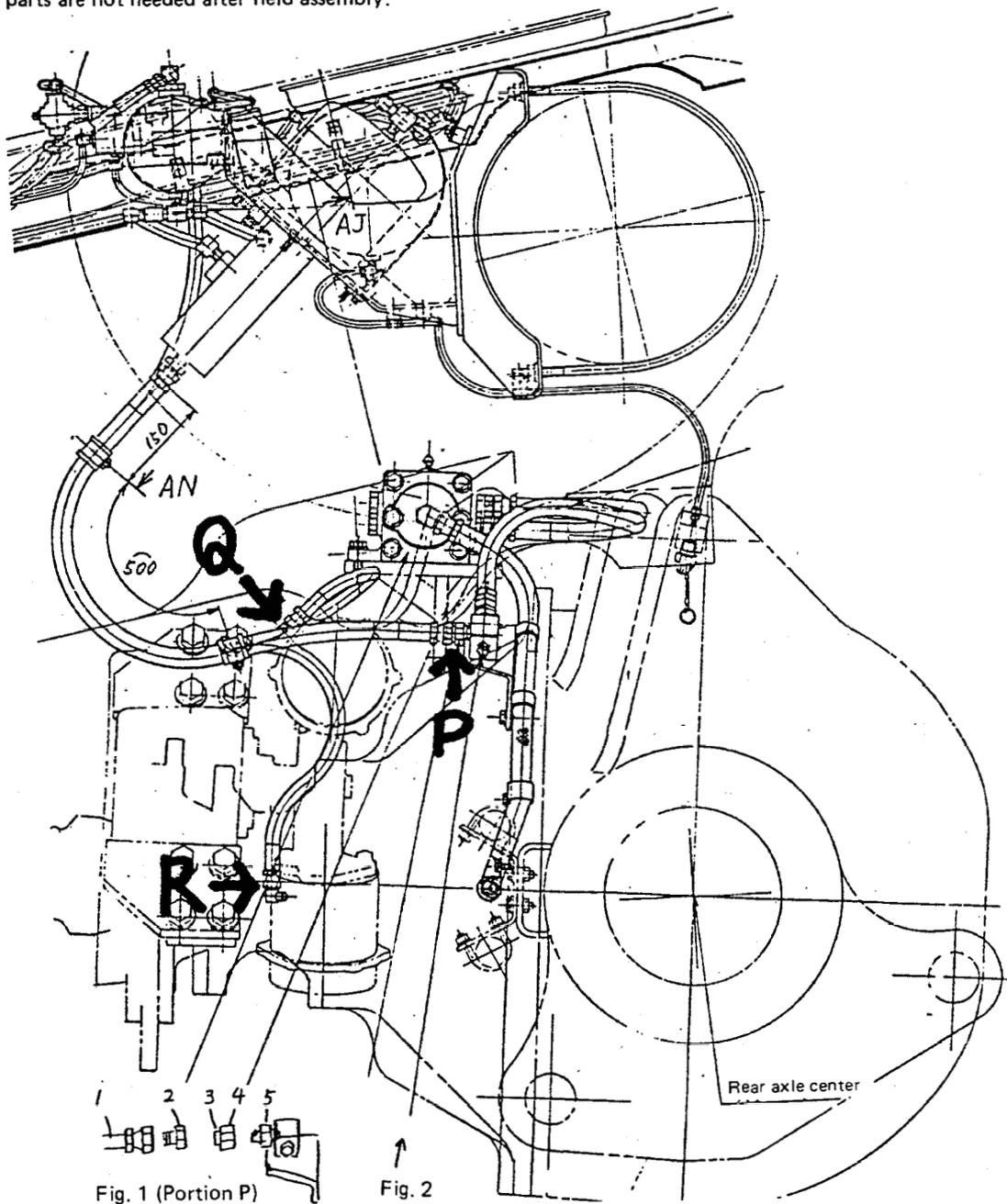
(5) Connecting rear brake hoses

Assembly parts

No.	Part Name	Part No.	Q'ty
1	Hose	07113-00510	2
2	Plug*	07376-50522	2
3	Plug*	07222-00515	2
4	Sleeve nut*	07221-20522	2
5	Nipple	07238-00522	2

- 1) Remove the blind parts (② - ④). (Fig. 1)
- 2) Connect portion P (2 places), portion Q and portion R. (Fig. 2)

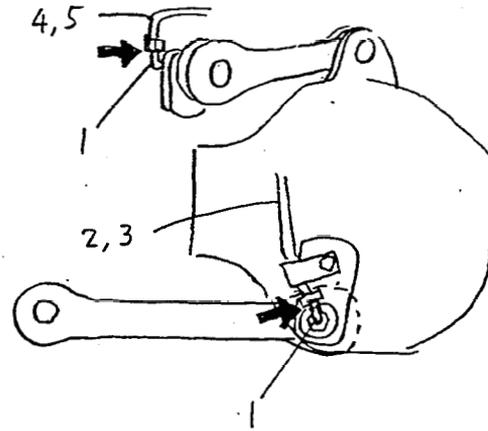
*: These parts are not needed after field assembly.



(6) Connecting greasing tube for rear axle support pin

Assembly parts

No.	Part Name	Part No	Q'ty
1	Elbow	581-52-12410	4
2	Tube (bottom left)	561-52-62650	1
3	Tube (bottom right)	561-52-62660	1
4	Tube (top left)	561-52-62570	1
5	Tube (top right)	561-52-62580	1



3. INSTALLATION OF DRIVE SHAFT

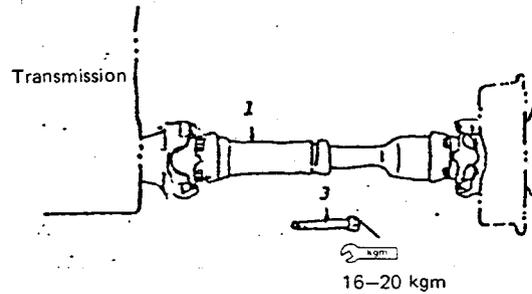
Necessary facilities and tools

No.	Name (Part No.)	Q'ty
1	Torque wrench	1
2	Wire ($\phi 10$ - 2m)	1

Assembly parts

No	Part Name	Part No.	Q'ty
1	Drive shaft	561-20-62000	1
2	Bolt		8

- 1) Check that the drive shaft yokes are facing in the same direction, then assemble.
- 2) When installing the bolts, remove all grease and oil, dry completely, then coat with LT-2.



4. INSTALLATION OF FRONT AXLE

(1) Installation of front axle

Necessary facilities and tools

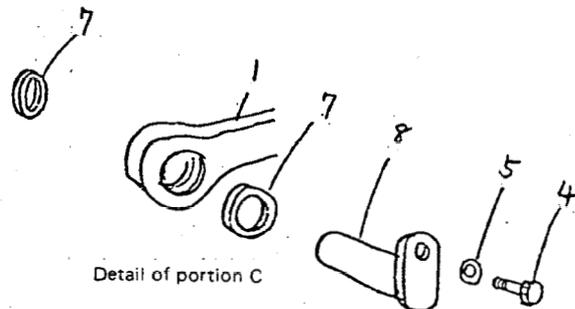
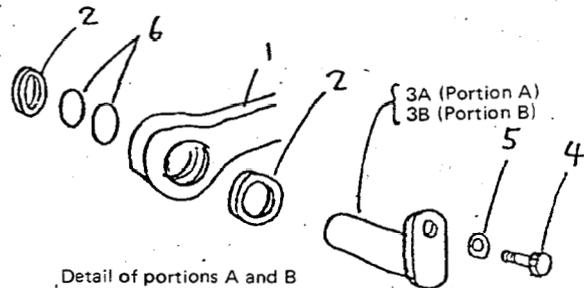
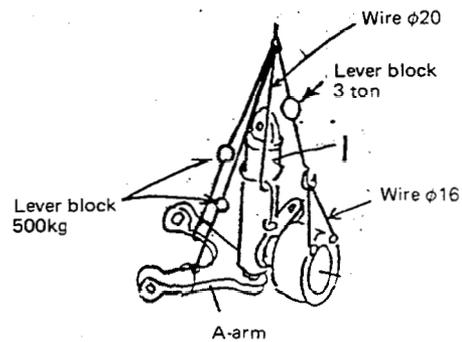
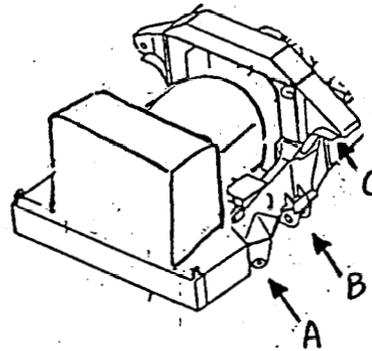
No.	Name (Part No.)	Q'ty
1	Lever block (3-ton)	1
2	Lever block (500 kg)	2
3	Wire ($\phi 20$ - 3m)	1
4	Wire ($\phi 16$ - 2m)	1

Assembly parts

No.	Part Name	Part No.	Q'ty
1	Front axle	561-27-61000	2
2	Spacer	566-52-41950	8
3A	Pin	561-40-61550	2
4	Bolt	01010-51425	6
5	Washer	569-40-61710	6
6	O-ring	07000-02060	8
7	Spacer	569-52-11130	4
8	Pin	561-40-61541	2
3B	Pin	561-40-61560	2

Raise the front axle as shown in the diagram on the right, and install to the frame.

- Check that there is an O-ring fitted to the ball portion of the A-arm.
- Wash off the rust-prevention oil from the pin with diesel oil.



(2) Installation of tie rod, steering cylinder

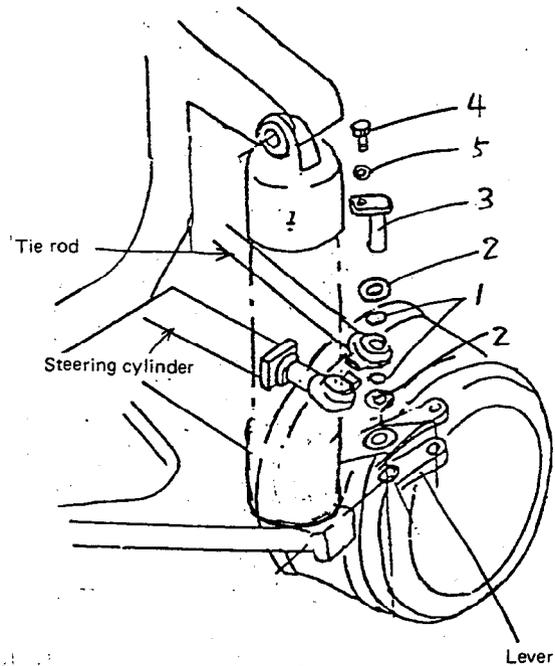
Necessary facilities and tools

No.	Name (Part No.)	Q'ty
1	Bar	1
2	Hammer	1

Assembly parts

No	Part Name	Part No.	Q'ty
1	O-ring	07000-02050	8
2	Seal	561-40-61631	8
3	Pin	561-40-61531	4
4	Bolt	01010-51425	4
5	Washer	569-40-61710	4

- 1) Set the hub of the front axle straight, extend the steering cylinder with the bar, and insert the tie rod into the lever.
 - a) Check that there is an O-ring at the ball portion of the steering cylinder and tie rod.
 - b) Wash off the rust-prevention oil from the pin with diesel oil.
- 2) Align the holes, then knock in the pin with a hammer to install the stopper.
- 3) Check that the center of the front axle is about 1400 mm from the ground, then remove the wire and lever block.



(3) Installation of front brake hoses, suspension control hoses

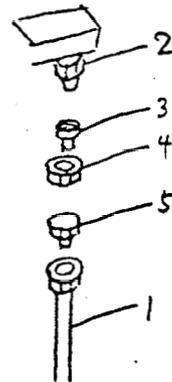
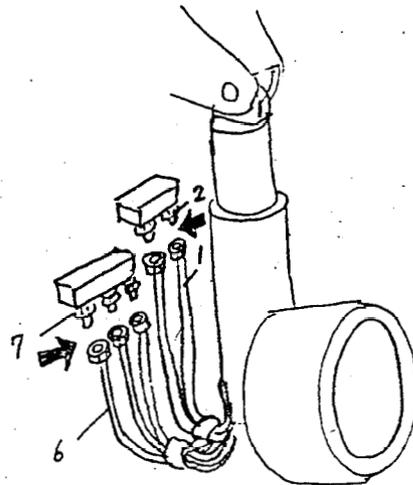
Assembly parts

No.	Part Name	Part No.	Q'ty
1	Hose		4
2	Nipple		4
3	Sleeve*		4
4	Nut*		4
5	Plug*		4
6	Hose	561-44-67441	6
7	Nipple	566-52-43290	6

* These parts are not needed after field assembly.

- 1) Remove the blind parts (③ - ⑤).
- 2) Connect hose ① .

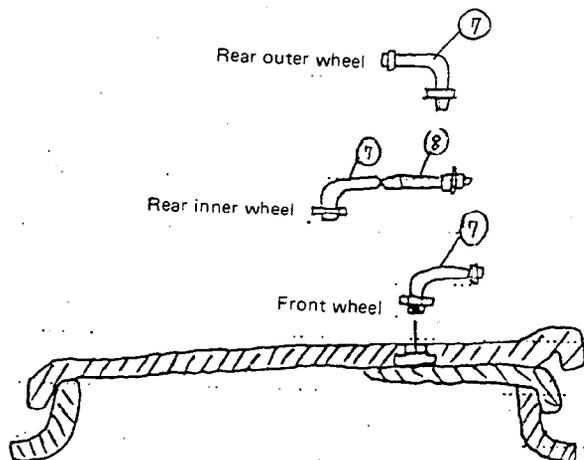
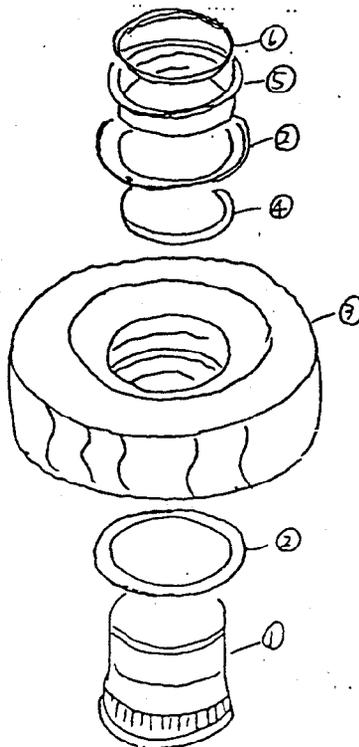
*: Match the tag numbers when connecting.



5. WHEEL ASSEMBLY

Assembly parts

No.	Part Name	Part No.	Q'ty
1	Rim base	561-30-61210	6
2	Side ring	561-30-61330	12
3	Tire	561-30-11110	6
4	O-ring	561-30-11250	6
5	Band	561-30-61320	6
6	Ring	561-30-11540	6
7	Valve	569-30-11611	6
8	Extension	09284-00045	2



- 1) Set jig ③ on the assembly stand, then set rim ① on the jig. (Fig. 1)
- 2) Insert side ring ②, then insert tire ③. (Fig. 2)
- 3) Install side ring ② and band ④. (Fig. 3)
- 4) Push in band ⑤ with a press. (Until the O-ring groove can be seen.)
- 5) Install O-ring ⑤ and ring ⑥. (Fig. 5)
 Note: When installing the O-ring, check that the O-ring is not scratched. If it is scratched, replace it with a new O-ring.
- 6) Install valve assembly ⑧ to rim ①. (Fig. 8)
- 7) Pump in air.
- 8) Using soapy water, check for any leakage of air. (Fig. 9)

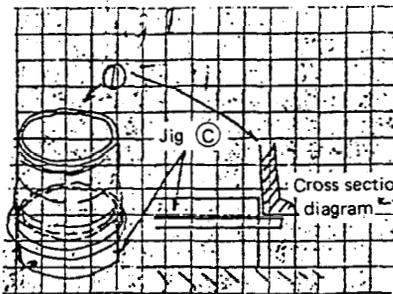
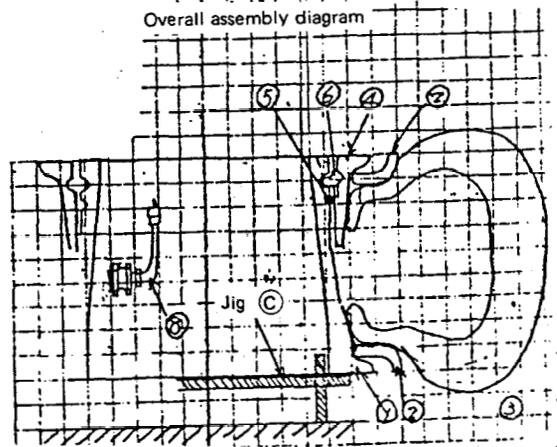


Fig. 1

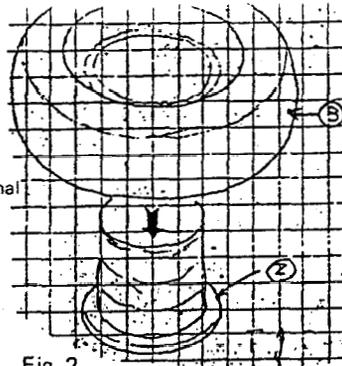


Fig. 2

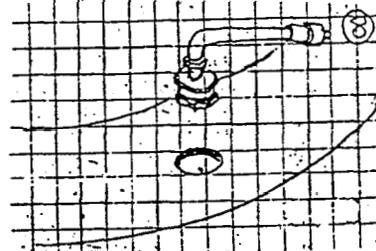


Fig. 8

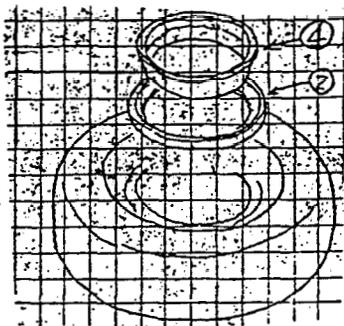


Fig. 3

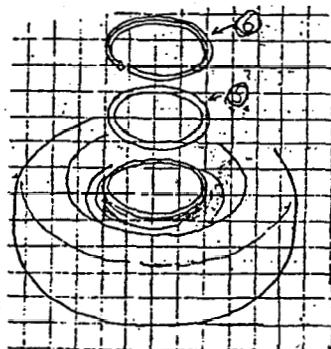


Fig. 5

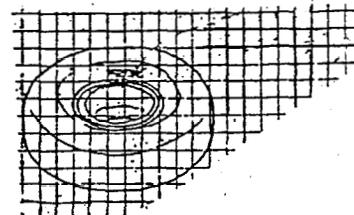


Fig. 9

6. INSTALLATION OF WHEEL

(1) Installation of front wheel

Necessary facilities and tools

No.	Name (Part No.)	Q'ty
1	Torque wrench	1
2	Wire (φ16 - 12m)	1

Assembly parts

No.	Part Name	Part No.	Q'ty
1	Wheel	561-30-61200	2
2	Clamp	561-22-62841	16
3	Nut	561-22-62870	32

- 1) Tie the wire around the wheel and raise with a crane. (Fig. 1)

(Hit the loop in the wire with a hammer to make sure that the wire is held securely.
When raising the wheel, do not stand close to it.)

 Wheel: Approx. 1.8 tons

- 2) Align the notched position of the front axle valve and the position of the clamps, and push the tire onto the hub. (Fig. 2)

(Remove all mud, dirt, rust, and oil or grease from the contact surface of the rim and hub before assembling.)

- 3) Rotate the wheel to center it, then tighten the hub nuts with a torque wrench (Fig. 3).

(Make sure that the runout of the tire face is within 5 mm.)

 Hub nut: 200–250 kgm

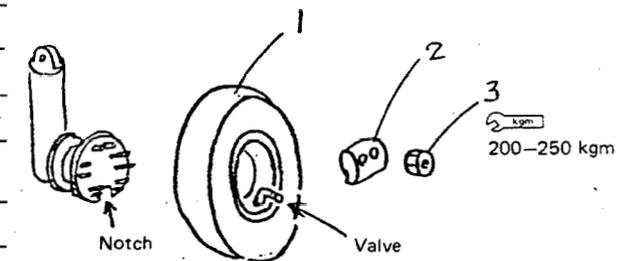


Fig. 2

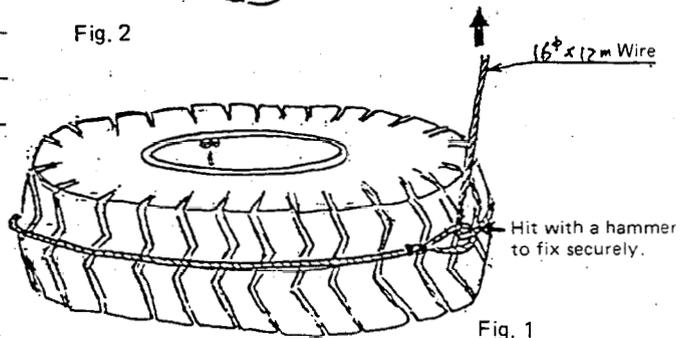
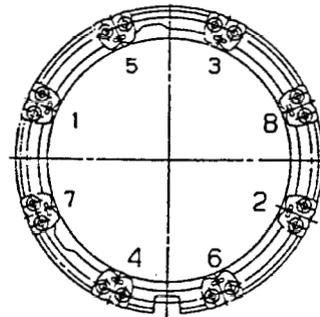


Fig. 1



Order for tightening clamps

Fig. 3

(2) Installation of rear wheel

Necessary facilities and tools

No.	Name (Part No.)	Q'ty
1	Torque wrench	1
2	Wire (φ16 - 12m)	1

Assembly parts

No.	Part Name	Part No	Q'ty
1	Wheel	561-30-61200	4
2	Spacer	561-30-62120	2
3	Wedge ring	561-30-62111	2
4	Clamp (inner)	561-22-62830	6
5	Clamp (outer)	561-22-62841	20
6	Nut	561-22-62870	46
7	Plate	565-22-14660	2
8	Bolt	01010-51220	4
9	Washer	01643-31232	4
10	Extension	09284-00045	2

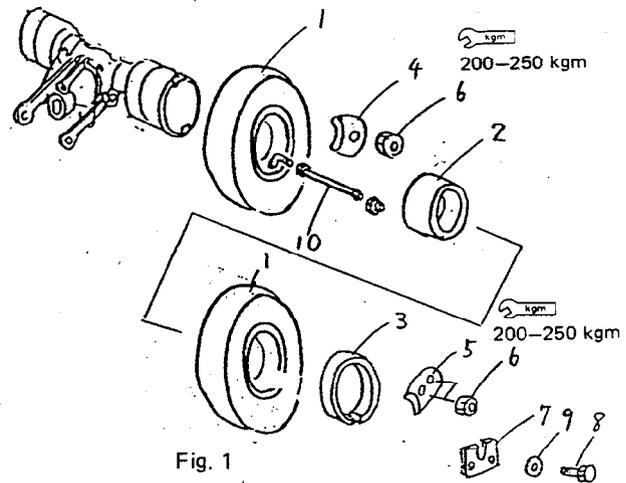


Fig. 1

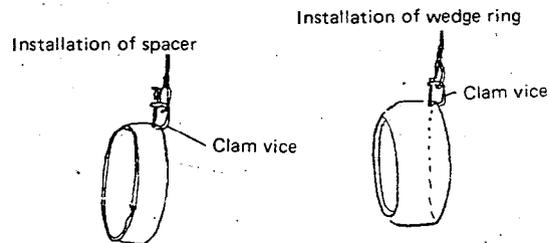


Fig. 2

Fig. 3

- 1) Raise the inner rear wheel (this wheel is the same for the front and rear) in the same way as for the front wheel, fit it on the inner hub, and tighten with the hub nuts. (Fig. 1)

(When fitting the wire, check the position of the notch on the rear axle, and position the point to tie the wire (decide the position approximately).)

- 2) Insert the extension in the valve core, remove the valve core from the valve of the wheel that is installed, then screw in the extension. When doing this, check the tightening of the valve nut also. (Fig. 1)

Valve core: 0.03 kgm

Extension connector and connector nut
valve cap: 0.3 ± 0.05 kgm

Valve nut: 0.5 ± 0.1 kgm

- 3) Using a clam vice, raise the spacer as shown in Fig. 2, and insert it inside the rear axle. When it is fitted on the rear axle, remove the clam vice, and push it in by hand. (Fig. 1)
- 4) Raise the outer wheel in the same way, align the position of the notch, and insert it on the rear axle. (Fig. 1)

5) Raise the wedge with a clam vice in the same way as with the spacer. When doing this, install the clam vice on the opposite side to the tapered side. (Fig. 3)

6) Insert the wedge between the rear axle hub and the rear wheel, then tap around the circumference uniformly. If the wedge is hit too strongly, the edge will be damaged, so we recommend using a wooden block between the hammer and the wedge.

7) When it becomes possible to install the clamps, push the wedge ring in by hub nuts. Tighten the nuts in turn on diametrically opposite side.

8) When they are tightened uniformly, use a torque wrench, (Fig. 4).

(Tighten for 2 – 3 cycles, and continue to tighten until the proper tightening torque is obtained. The wedge rings will gradually sink in, so they must be tightened several times.

Note: After driving for a short distance, tighten the hub nuts of both front and rear wheels again.

 Hub nut: 200–250 kgm

9) Tighten the extension to the plate with a double nut. (Fig. 5)

10) Install the valve cap to the end of the valve and extension, and screw in. (Fig. 5)

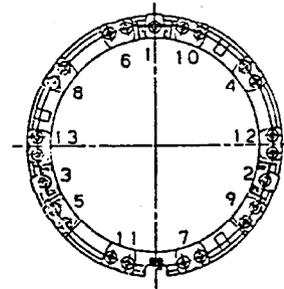


Fig. 4 Order for tightening clamps

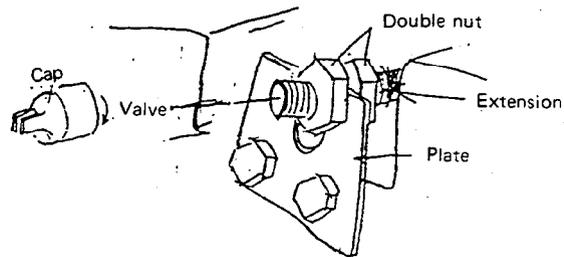


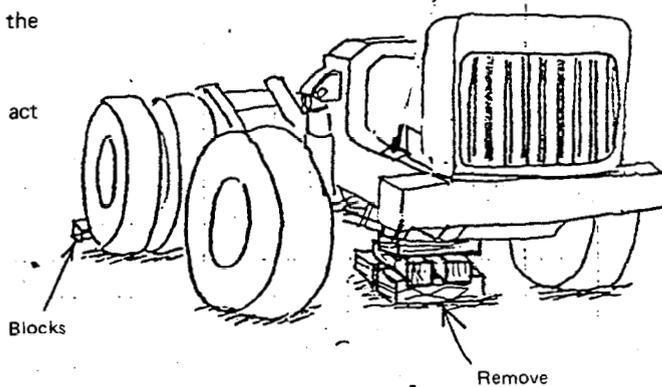
Fig. 5

7. REMOVAL OF BLOCKS FROM UNDER CHASSIS ASSEMBLY

1. When installation of the front and rear tires is completed, use the wires that were used when raising the chassis assembly, raise uniformly at the front and rear, and remove the blocks from under the machine.

(The hook positions are the same as when lifting the chassis assembly.)

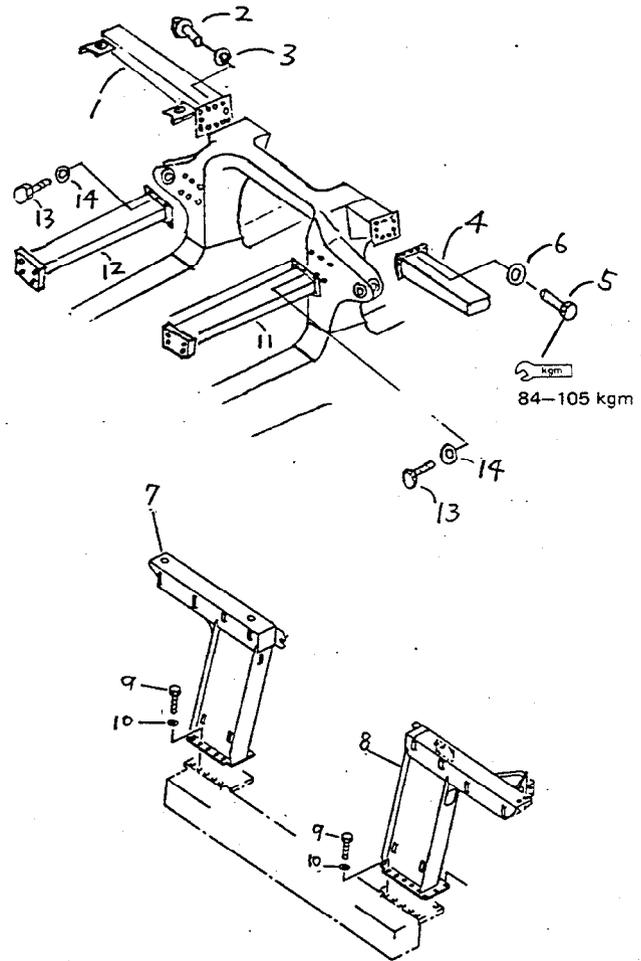
2. Put blocks in front and behind the rear tires to act as stoppers.



8. INSTALLATION OF CAB SUPPORT

Assembly parts

No.	Part Name	Part No.	Q'ty
1	Support	561-46-61791	1
2	Bolt	01010-52465	9
3	Wahser	01643-32460	9
4	Support (ROPS)	561-89-67122	1
5	Bolt	01011-52406	16
6	Washer	01643-32460	16
7	Support	561-54-61321	1
8	Support	561-54-61312	1
9	Bolt	01010-52050	12
10	Washer	01643-32060	12
11	Stay	561-54-61951	1
12	Stay	561-54-61961	1
13	Bolt	01010-52050	6
14	Washer	01643-32060	6

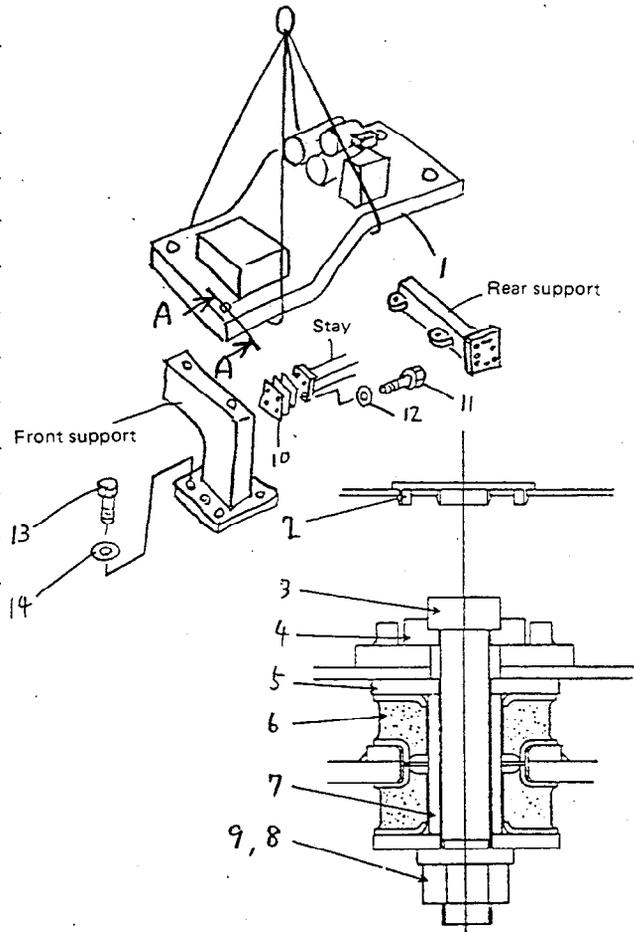


- 1) Tighten the rear support and stay fully to the frame.
- 2) Tighten the front support temporarily.
- 3) After mounting the platform, tighten the front support mounting bolts fully.

(1) Installation of R.H. platform

Assembly parts

No.	Part Name	Part No.	Q'ty
1	R.H. platform		
2	Cap	09414-01053	4
3	Bolt	01011-82020	4
4	Washer	566-54-21931	4
5	Washer	566-54-21920	8
6	Cushion	566-54-12212	8
7	Bushing	566-54-21910	4
8	Nut	01580-12016	4
9	Washer	01643-32060	4
10	Shim	561-54-61970	Adjust
11	Bolt	01010-52050	10
12	Washer	01643-32060	10
13	Bolt	01010-52050	6
14	Washer	01643-32060	6



- 1) Raise as shown in the diagram, align the position of the holes of the front support and rear support, and install.
- 2) Insert shims between the front support and stay, then tighten the bolts.
- 3) Tighten the front support mounting bolts.