

Field Assembly Instruction

DUMP TRUCK

HD785-7

SERIAL NUMBERS 7001 and up



CONTENTS

1. Outline of division (Only main components).....	1
2. Dimensions of main components	2
3. Layout of work space	3
4. Rough schedule of assembly and welding	4
5. List of jigs, tools, and consumables for field assembling.....	9

CONTENTS

No.	Item	Page
0010	Oil, grease, and coolant	16
0020	Levels of oil, grease, and coolant	17
0030	Positioning rear axle assembly	18
0040	Sliding and moving of bare machine	19
0050	Connection of rod and rear suspension	20
0060	Positioning bare machine	21
0070	Connection of rear axle cooling hose	22
0080	Connection of rear axle brake hose	23
0085	Connection of rear axle brake hose (ASR specification: If equipped)	24
0086	Connection of valve sub-assembly wiring harness (ASR specification: If equipped)	25
0087	Connection and fixing of piping going to rear axle (Sand terrain/ASR specification: If equipped)	26
0090	Connection and fixing of rear grease piping and supply of grease	27
0100	Preparation for installing front axle	28
0110	Installation of front axle	29
0120	Connection of front axle suspension pressure sensor	30
0125	Connection of front axle wheel speed sensor (ABS specification: If equipped)	31
0130	Connection of steering cylinder and tie rod	32
0140	Connection of front axle brake cooling hoses	33
0150	Connection of front axle brake hoses	34
0160	Connection of front axle auto suspension piping	35
0165	Fixing of front axle auto suspension piping	36
0166	Fixing of front axle auto grease piping (If equipped: Auto grease specification)	37
0167	Connection of left front axle auto grease piping (If equipped: Auto grease specification)	38
0168	Connection of right front axle auto grease piping (If equipped: Auto grease specification)	39
0170	Installation of bumper and front axle steps	40
0171	Installation of front axle step (EU specification)	41
0180	Installation of tire and wheel assembly	42
0190	Installation of drive shaft	43
0200	Installation of oil quick charge box (If equipped: Oil quick charge specification)	44
0260	Installation of fuel tank wiring harness cover	45
0270	Installation of toolbox and tool kit	46
0275	Installation of fuel tank step (If equipped)	47
0280	Installation of rear support	48
0281	Installation of rear support (Muffler specification: If equipped)	49
0282	Installation of rear support (ABS specification: If equipped)	50
0283	Installation of rear support (Sand terrain specification: If equipped)	51
0290	Installation of muffler	52
0291	Installation of muffler (Body heating-less/Exhaust selector box specification: If equipped)	53
0300	Installation of fire prevention cover	54
0310	Installation of front support	55
0315	Installation of front support (Fog lamp specification: If equipped)	56
0317	Installation of front support (Fog lamp, beacon lamp, HID headlamp specification: If equipped)	57
0320	Installation of steering valve	58
0330	Preparation for installing cab	59
0340	Installation of cab	60
0345	Connection of ABS piping (If equipped)	61
0350	Connection of column	62
0355	Installation of washer tank	63
0370	Connection of cab wiring	64
0375	Connection of cab wiring (ASR/ABS specification: If equipped)	65
0376	Connection of engine prelubrication harness to cab (If equipped: Engine prelubrication specification)	66
0377	Connection and fixing of engine compartment lamp wiring harness (if equipped)	67
0378	Connection of auto grease harness to cab (If equipped: Auto grease specification)	68
0379	Connection of engine stop harness to cab (If equipped: Engine emergency stop specification)	69
0380	Installation and fixing of steering hoses	70

CONTENTS

No.	Item	Page
0385	Fixing of air conditioner drain hose	71
0390	Installation of steering hose cover	72
0395	Connection of air conditioner and heater hoses	73
0400	Connection of cab floor wiring	74
0405	Fixing of ASR/ABS wiring harness (If equipped)	75
0406	Connection and fixing of ABS wiring harness (ABS specification: If equipped)	76
0410	Installation of cover under cab	77
0415	Wiring of front glass with heater wire (If equipped)	78
0420	Installation of cab seal	79
0430	Installation of ambient temperature sensor wiring harness	80
0440	Installation of undercab wiring harness connector	81
0445	Connection and fixing of rear view camera wiring harness (if equipped)	82
0450	Installation of R.H platform assembly	83
0470	Installation of right fender	84
0472	Installation of right fender (If equipped: Body heating-less muffler specification)	85
0475	Installation of fuel tank quick charge-less hose (If equipped)	86
0476	Installation of fuel tank quick chargeless hose: Muffler specification (If equipped: muffler specification)	87
0480	Installation of cab step	88
0481	Assembly of diagonal ladder (if equipped)	89
0482	Installation of cab step: Diagonal ladder specification (if equipped)	90
0483	Installation of diagonal ladder 1 (if equipped)	91
0484	Installation of diagonal ladder 2 (if equipped)	92
0485	Installation of diagonal ladder 3 (if equipped)	93
0486	Installation of diagonal ladder (EU specification)	94
0487	Installation of diagonal ladder-2 (EU specification)	95
0488	Installation of diagonal ladder-3 (EU specification)	96
0490	Installation of L.H underview mirror (If equipped)	97
0500	Installation of fire extinguisher (If equipped)	98
0510	Installing radio antenna and fixing its cable	99
0520	Installation of L.H fender	100
0530	Installation of left side mudguard	101
0540	Installation of grille guard	102
0550	Installation of left payload lamp (If equipped)	103
0555	Installation of left side lamp (If equipped)	104
0560	Installation of right payload lamp (If equipped)	105
0565	Installation of right side lamp (If equipped)	106
0570	Installation of left fender side lamp wiring harness (If equipped)	107
0580	Installation of right fender side lamp wiring harness (If equipped)	108
0581	Installation of right fender side lamp wiring harness (If equipped: Body heating-less muffler, exhaust gas selector box muffler specification)	109
0590	Installation of KOMTRAX (If equipped)	110
0595	Fixing of ORBCOMM antenna (If equipped)	111
0597	Connection and fixing of harness and hose going to auto grease pump - 1 (If equipped: Auto grease specification)	112
0598	Connection and fixing of harness and hose going to auto grease pump - 2 (If equipped: Auto grease specification)	113
0600	Removal of hoist cylinder fixing bracket	114
0610	Connection of hoist cylinder piping	115
0620	Welding of body	116
0630	Sticking of body decal	117
0640	Supply of oil	118
0650	Sliding of body	119
0660	Installation of hinge pin	120
0670	Connecting hoist cylinder	121
0680	Hoist cylinder grease piping	122
0685	Fixing of auto grease piping to body (If equipped: Auto grease specification)	123
0700	Installation of field welding protection cover	124
0710	Installation of body mount	125
0720	Procedure for adjusting body mount shim	126
0730	Field welding of exhaust tube	127

CONTENTS

No.	Item	Page
0740	Assembly of body heater cover	128
0770	Installation of poke ejector	129
0780	Installation of poke ejector storage pin	130
0790	Installation of body mudguard	131
0800	Installation of body lock pin	132
0810	Installation of transmission underguard	133
0830	Installation of front handle	134
0850	Connection of dump sensor	135
0860	Procedure for adjusting dump sensor	136
0870	Calibrating dump control	137
0880	Adjustment of optical axis of light	138
0900	Bleeding air from brake	139
0901	Bleeding air from brake of ASR specification (ASR specification: If equipped)	140
0905	Bleeding air from ABS circuit (ABS specification: If equipped)	141
0910	Adjusting suspension	142
0920	Charging air conditioner with refrigerant	143
0930	Fitting of floating seal	144
0950	Painting	145
0960	Touchup	146
1000	Sticking of front axle decal	147
1020-1	Operating procedure of prelubrication system (If equipped: Engine prelubrication specification)	148
1020-2	Operating procedure of prelubrication system (If equipped: Engine prelubrication specification)	149
1100	Installation of chocks (If equipped)	150
1200	Installation of radiator curtain (If equipped)	151
1300	Installation and connection of beacon lamp (If equipped: Yellow beacon lamp specification)	152
1400	Assembly of power ladder step -1 (If equipped)	153
1410	Assembly of power ladder step -2 (If equipped)	154
1420	Assembly of power ladder step -3 (If equipped)	155
1430	Assembly of power ladder main part -1 (If equipped)	156
1440	Assembly of power ladder main part -2 (If equipped)	157
1450	Assembly of power ladder main part -3 (If equipped)	158
1460	Assembly of power ladder main part -4 (If equipped)	159
1470	Assembly of power ladder main part -5 (If equipped)	160
1480	Assembly of power ladder main part -6 (If equipped)	161
1490	Assembly of power ladder main part -7 (If equipped)	162
1500	Assembly of power ladder main part -8 (If equipped)	163
1510	Assembly of power ladder main part -9 (If equipped)	164
1520	Assembly of power ladder main part -10 (If equipped)	165
1530	Assembly of power ladder main part -11 (If equipped)	166
1540	Assembly of power ladder main part -12 (If equipped)	167
1550	Assembly of power ladder main part -13 (If equipped)	168
1560	Assembly of power ladder main part -14 (If equipped)	169
1570	Assembly of power ladder main part -15 (If equipped)	170
1580	Assembly of power ladder main part -16 (If equipped)	171
1590	Refilling power ladder with oil	172
1600	Adjustment of power ladder operating time	173
1610	Installation of additional under-view mirror	174

CONTENTS

7. Adjustment procedure

No.	Item	Page
T-0010	Bleeding air from fuel circuit 1 (If equipped: Extra low-grade fuel specification)	175
T-0020	Bleeding air from fuel circuit 2 (If equipped: Extra low-grade fuel specification)	176
T-0030	Setting of machine monitor	177
T-0040	Selection of machine model	178
T-0050	Selection of optional component	179
T-0060	Selection of option	180
T-0070	Option setting/no-setting selection screen - Saving of change of option selection	181
T-0080	OFF setting of corrosion resistor with maintenance monitor	182
T-0090	Adjustment of body positioner sensor	183
T-0100	Deletion of electrical system fault history (1)	184
T-0110	Deletion of electrical system fault history (2)	185

8. Welding procedure

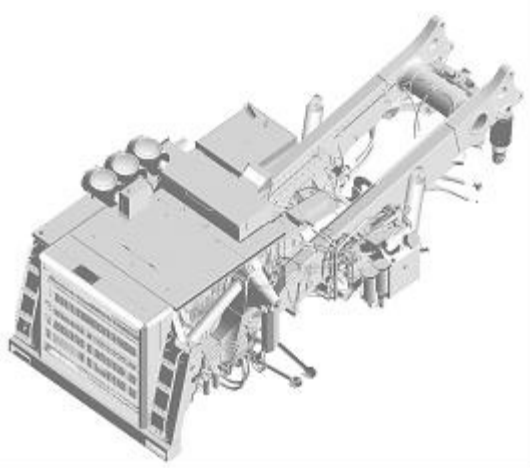
No.	Item	Page
C-0010	Preparation of welding body	186
C-0020	Assembly of split body (1/2)	187
C-0030	Assembly of split body (2/2)	188
C-0040	Tack welding body	189
C-0050	Welding body (1/2)	190
C-0060	Welding body (2/2)	191
C-0070	Welding body instruction (1/2)	192
C-0080	Welding body instruction (2/2)	193
C-0090	Turn over the body	194
C-0100	Welding body protector (1/2)	195
C-0110	Welding body protector (2/2)	196
C-0120	Finishing and painting welded parts of body	197
C-0130	Welding front body mount bracket	198

Appendix

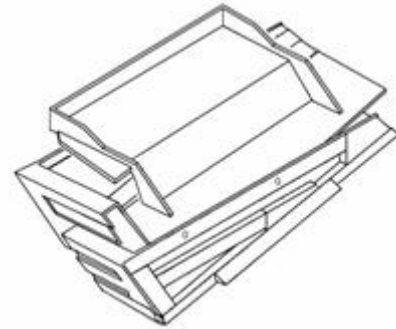
Field assembly inspection report

1. Outline of division (Only main components)

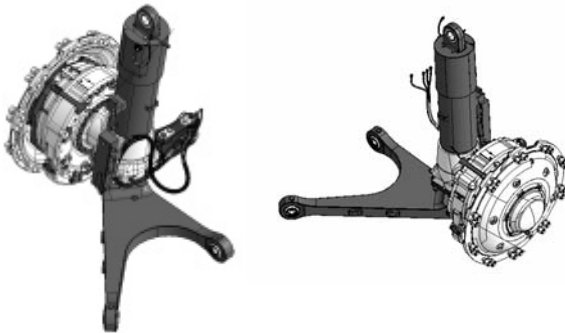
1. Bare machine



2. Dump body (Divided into 3)



3. Front axle assembly



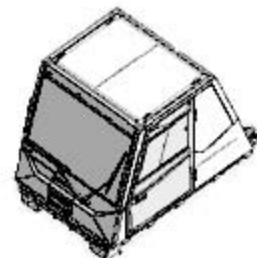
4. Rear axle and tire assembly



5. Front tire and wheel assembly



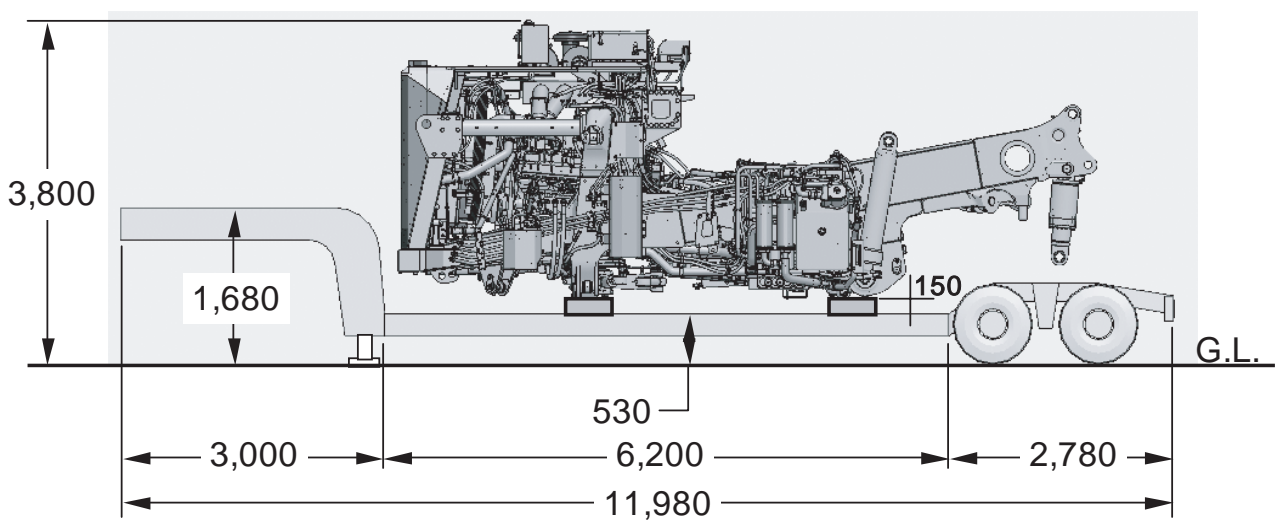
6. Cab assembly



2. Dimensions of main components

No.	Unit name	Weight (kg)	Overall length (mm)	Overall width (mm)	Overall height (mm)
1	Bare machine	21,600	7,930	3,190	3,120
2	Dump body	15,400	7,250	3,100	3,100
3	Right and left front axle assembly	2,400	2,200	1,700	2,100
4	Rear axle and tire assembly	17,000	4,390	2,700	2,700
5	Front tire and wheel assembly (1 set)	2,000	2,700	750	2,700
6	Cab	3,000	2,760	2,010	2,190

Drawing of bare machine on trailer



Reference

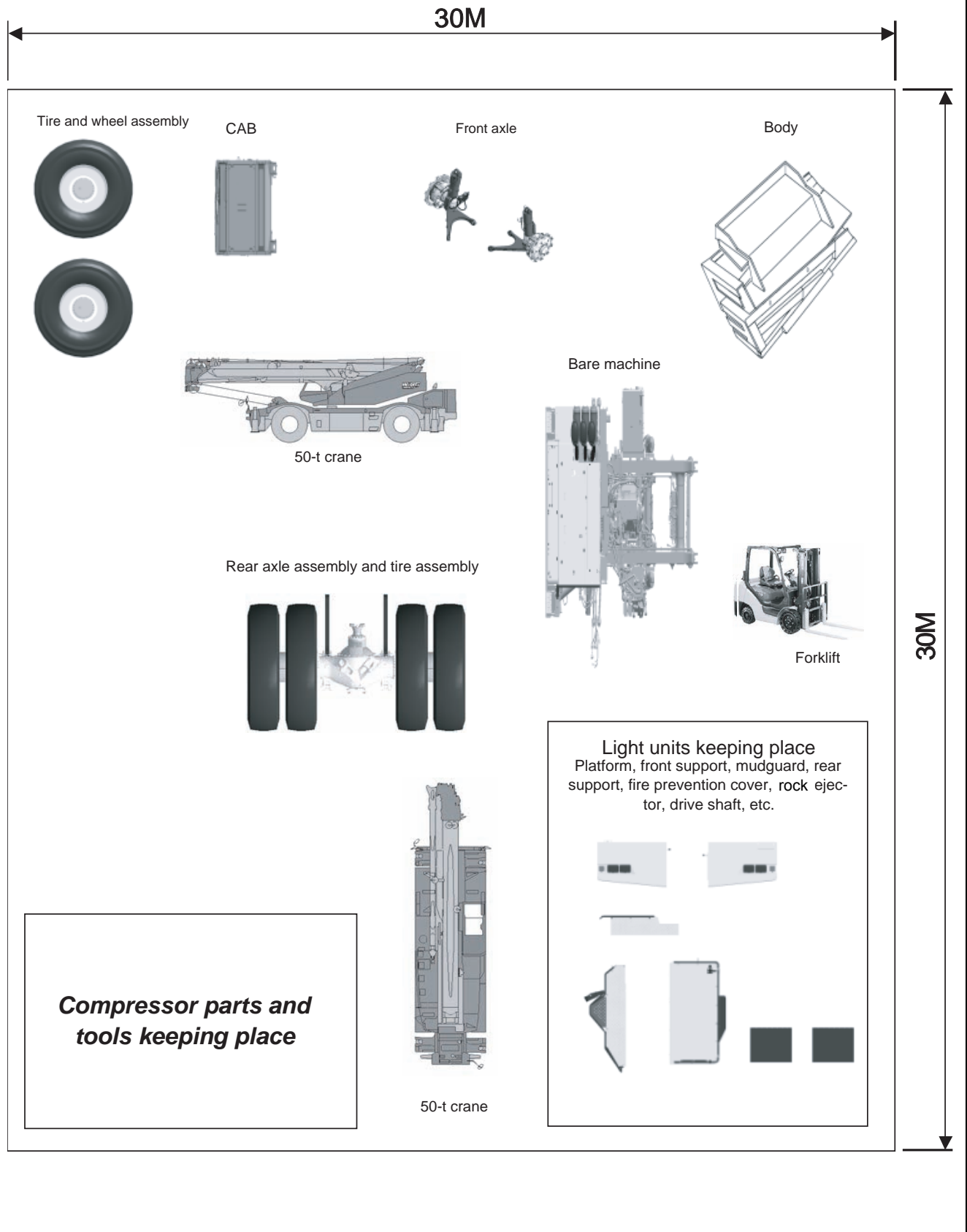
Specifications of completed truck

Specifications		Related items			
		Weight (kg)	Overall length (mm)	Overall width (mm)	Overall height (mm)
In self-propelled travel	HD785-7	64,600 (Mass of machine)	10,290 (Front bumper – End of body)	5,528	5,047 (When empty)

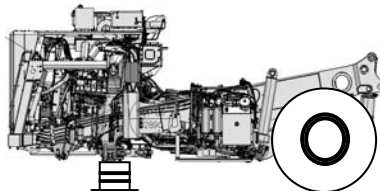
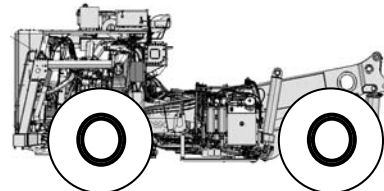



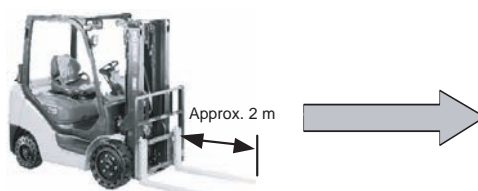

3. Layout of work space

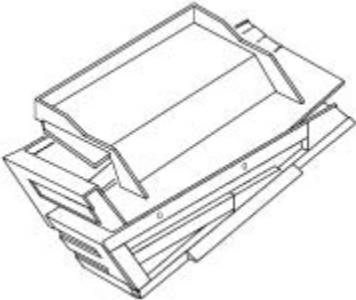
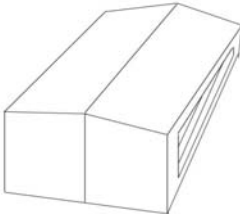




(The work space should be wider for the ease of work and must be at least 30 m square.)

Caution: The work space must be level and drained well.









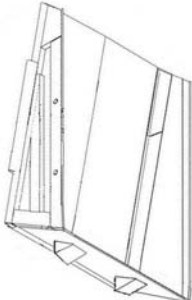
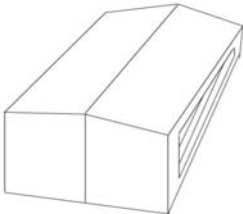



4-1. Rough schedule of assembly and welding

Day Hour	1st day							
	1	2	3	4	5	6	7	8
Condition of chassis								
Rough contents of assembly work	Positioning rear axle Positioning chassis				Installing front axle Installing tires			
Crane	 490 kN {50 ton}		 245 kN {25 ton}		 245 kN {25 ton} (98 kN {10 ton})			
Forklift	 4 ton * Fork length: Approx. 2 m							
Number of workers	2							





<div>Day</div> <div>Hour</div>	1st day							
	1	2	3	4	5	6	7	8
Condition of body								
Contents of welding work	Unloading Removal of stands and fixing parts				Positioning and fixing split body Welding back side			
Crane	 245 kN {25 ton}		 245 kN {25 ton}					
Number of workers	3							

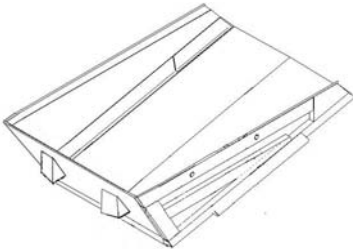
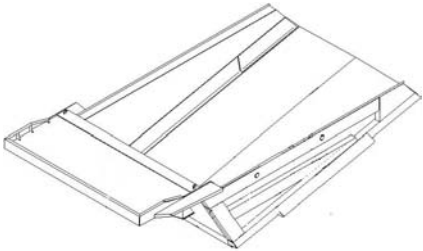



4-2. Rough schedule of assembly and welding

<div>Day</div> <div>Hour</div>	2nd day							
	1	2	3	4	5	6	7	8
Condition of chassis								
Rough contents of assembly work	Installing support Installing cab				Piping and wiring			
Crane	 490 kN {50 ton}				 490 kN {50 ton}			
Forklift								
Number of workers	2							







<div>Day</div> <div>Hour</div>	2nd day							
	1	2	3	4	5	6	7	8
Condition of body	<div></div>							
Contents of welding work	Positioning and fixing split body Welding back side				Turning over			
Crane	<div></div> <div>245 kN {25 ton}</div>							
Number of workers	<div>3</div>							

4-3. Rough schedule of assembly and welding

<div>Day</div> <div>Hour</div>	3rd day							
	1	2	3	4	5	6	7	8
Condition of chassis								
Rough contents of assembly work	Installing platform Painting				Supply of oil and coolant Starting engine			
Crane								
Forklift								
Number of workers	2							





<div>Day</div> <div>Hour</div>	3rd day							
	1	2	3	4	5	6	7	8
Condition of body								
Contents of welding work	Welding inside of body				Welding protector			
Crane	  245 kN {25 ton}							
Number of workers	3							

4-4. Rough schedule of assembly and welding

Day Hour	4th day							
	1	2	3	4	5	6	7	8
Condition of chassis								
Rough contents of assembly work	Mounting body Adjusting shims Field welding							
Crane	 490 kN {50 ton}		 245 kN {25 ton}		 245 kN {25 ton} (98 kN {10 ton})			
Number of workers	2							

Day Hour	4th day							
	1	2	3	4	5	6	7	8
Condition of body								
Contents of welding work								
Crane								
Number of workers								

4-5. Rough schedule of assembly and welding

Day Hour	5th day							
	1	2	3	4	5	6	7	8
Condition of chassis								
Rough contents of assembly work	Installing exterior parts Painting				Maintenance, adjustment Inspection			
Crane	 245 kN {25 ton} (98 kN {10 ton})							
Number of workers	2							

<div> Day Hour </div>	4th day							
	1	2	3	4	5	6	7	8
Condition of body								
Contents of welding work								
Crane								
Number of workers								

5-1 List of jigs, tools, and consumables for field assembling (1/2)

No.	Item	Specification	Q'ty	Remarks
1	Truck crane	25 tons	2	See Field Assembling Procedures
2	Truck crane	50 tons	2	See Field Assembling Procedures
3	Forklift	4 tons	1	See Field Assembling Procedures
4	Gas cutting machine		1	
5	Torch	1220N2	1	
6	Acetylene gas		1	For gas cutting machine
7	Oxygen gas	14.7 MPa {150kg/cm ² }	1	For gas cutting machine
8	Grinder (round)	FG50L-1	1	
9	Grindstone	SCW50 × 19 • 10	1	
10	Grinder	LISG-7S	1	For finishing
11	Grindstone	180ø × 6 × 22	3	
12	Dia. bar	CB7C105	1	
13	Dia. bar blade	6GH	1	
14	Semi-automatic welding machine	500A	3	
15	Hand shield	GP-1S	3	
16	Welding wire for semi-automatic welding machine	1.2 mm	80kg	
17	Chipper scaling hammer	FCM-20F	2	
18	Port power	300 mm for 10 tons	1	For adjustment of dump body deviation
19	Hydraulic jack	10 tons	1	For dump body
20	Hydraulic jack	5 tons	1	For dump body
21	Shaft	WJ-H46-74001-023	1	
22	Refractory cloth	1 m × 10 m	1	Protection when field welding
23	Spacer	ATH-465-027	3	Use when welding exhaust flange in field
24	Nitrogen gas injector	7926-10-1000	1	
25	Nitrogen gas bottle	14.7 MPa {150 kg/cm ² }	1	Injection into suspension
26	Tire inflation gauge	No. 2252	1	
27	Grease pump gun	For 20kg can	1	
28	Grease	GL-2	5 kg	
29	Footstool	3-step	1	
30	Footstool	6-step	1	
31	Blue sheet	5 m × 10 m	5	Protection for equipment
32	Wood block	300 mm square, 1 m long	12	* Quantity depends on using condition.
33	Oil jack	5 ℓ	1	For oil injection
34	Oil	See Field Assembling Procedures.	—	See Field Assembling Procedures.
35	Oil sump, washing can		2	
36	Drained oil can	Empty drum can	1	
37	Cloth		5kg	
38	Diesel fuel	See Field Assembling Procedures.		For refilling fuel
39	Antifreeze		5 ℓ	For adding in subtank (to change mixing ratio depending on local weather)
40	Air hose	6ø × 1m	1	For air bleeding

5-2 List of jigs, tools, and consumables for field assembling (2/2)

No.	Item	Specification	Q'ty	Remarks
41	Sanding machine for scaling-off coating	914B	1	
42	Sandpaper	#80	100	
43	Sandpaper	#180	10	
44	Cup gun set	W87-20R2S	1	Use for coating
45	Brush		1	Use to repair coating.
46	Air compressor	Not less than 3.5 m³ or 7 kg/cm²	1	
47	Air hose	With mouthpiece of ø12	5	For impact grinder
48	Impact wrench	UW-13SK	2	
49	Impact wrench	KW-3800P	1	
50	Impact wrench	UW-9SK	2	
51	Extension for impact wrench 38S	150 mm long	1	
52	Socket	1 inch × 46 mm	1	For tightening tire
53	Socket	1 inch × 30 mm	1	For tightening support
54	Torque-wrench	2800QL	1	For drive shaft and body pin
55	Torque-wrench	21000QLE	1	For tightening tire
56	Convex	5m	1	
57	Loctite	LT-2	1	
58	Vinyl tape		1	Use to bundle harnesses
59	Standard tool (ISO specification)	700SX	2	
60	Bar	1m	1	
61	Pointed steel bar		1	For hole alignment
62	Large hammer	10 lb	1	
63	Axle pin installation guide	ATH-785-078	2	
64	Shackle	BD10 for 500 kg	4	
65	Shackle	BC40 for 10 tons	4	For mounting body
66	Chain	ATH-465-042	1	Multi purpose
67	Nylon shoe ring	100 mm wide × 5 m	2	For mounting fuel tank
68	Nylon shoe ring	60 mm wide × 3 m	2	For mounting support and small articles
69	Nylon shoe ring	100 mm wide × 12 m	1	For mounting front tires
70	Nylon shoe ring	30 mm wide × 2 m	3	For installing front axle
71	Nylon shoe ring	100 mm wide × 3 m	1	For installing front axle
72	Pin	ø60 × 250 mm	2	For slinging chassis, rear side (Safety pin can substitute)
73	Jig for slinging body	ATH-785-006	4	For mounting body
74	Lever block	3/4 tons, LB008	3	For installing front axle
75	Lever block	2 tons, LB020	1	For installing front axle
76	Wire	7m 28ø	2	For slinging chassis
77	Wire	4m 28ø	2	For mounting body
78	Wire	5m 28ø	2	For installing body
	The following items may be substituted for No. 76 to 78.			
		ATH-465-039	1	For mounting body
		ATH-465-040	2	For slinging chassis
		ATH-465-041	1	For slinging separated body

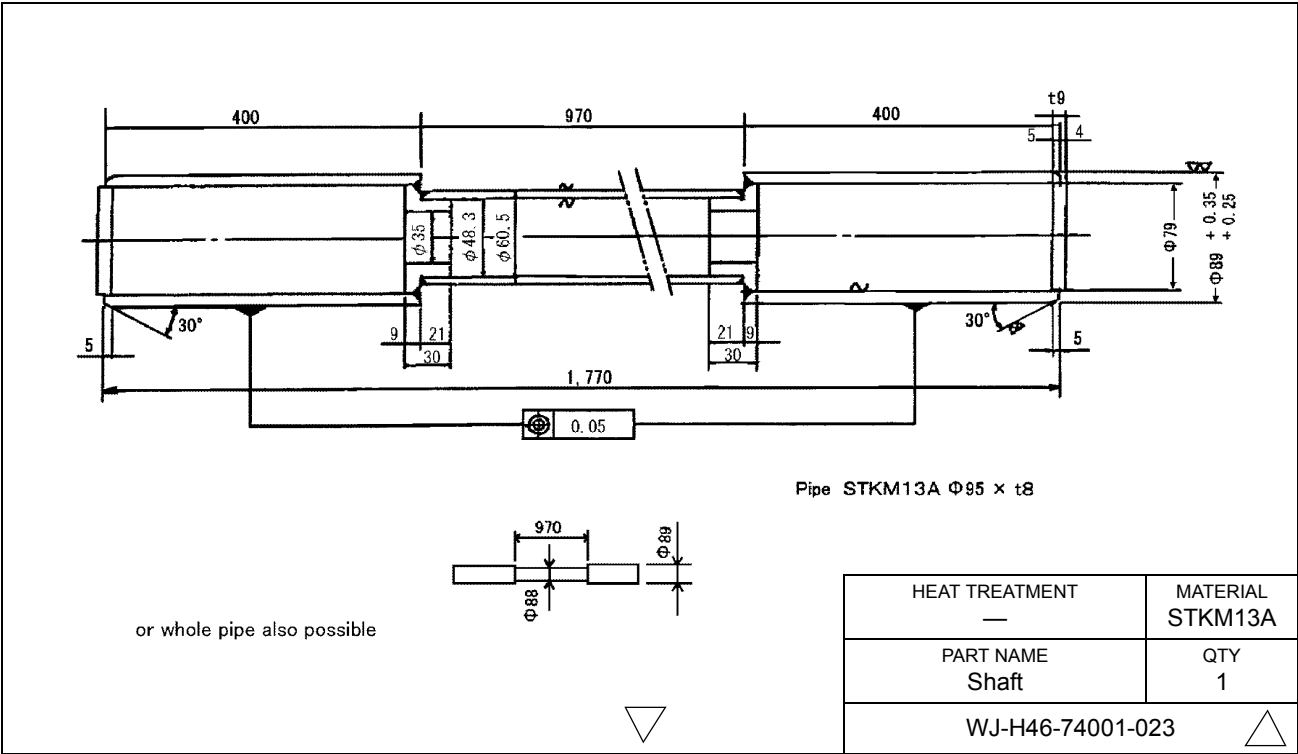
List of touch-up coating on body for overseas specifications

No.	Part Name	Unit	Q'ty
1	Retane GP primer	4kg	1
2	Retane GO hardener	0.8kg	1
3	Retane GP thinner	4ℓ	1
4	AX Mightylacq G2KB type natural yellow	16kg	1
5	NAX Mightylacq G2KB type hardener	15kg	1
6	X Mightylacq G2 500 standard thinner	17ℓ	1
7	Acryliquid cloud gray	Spray can	1
8	Heat-resistance silver	Spray can	1

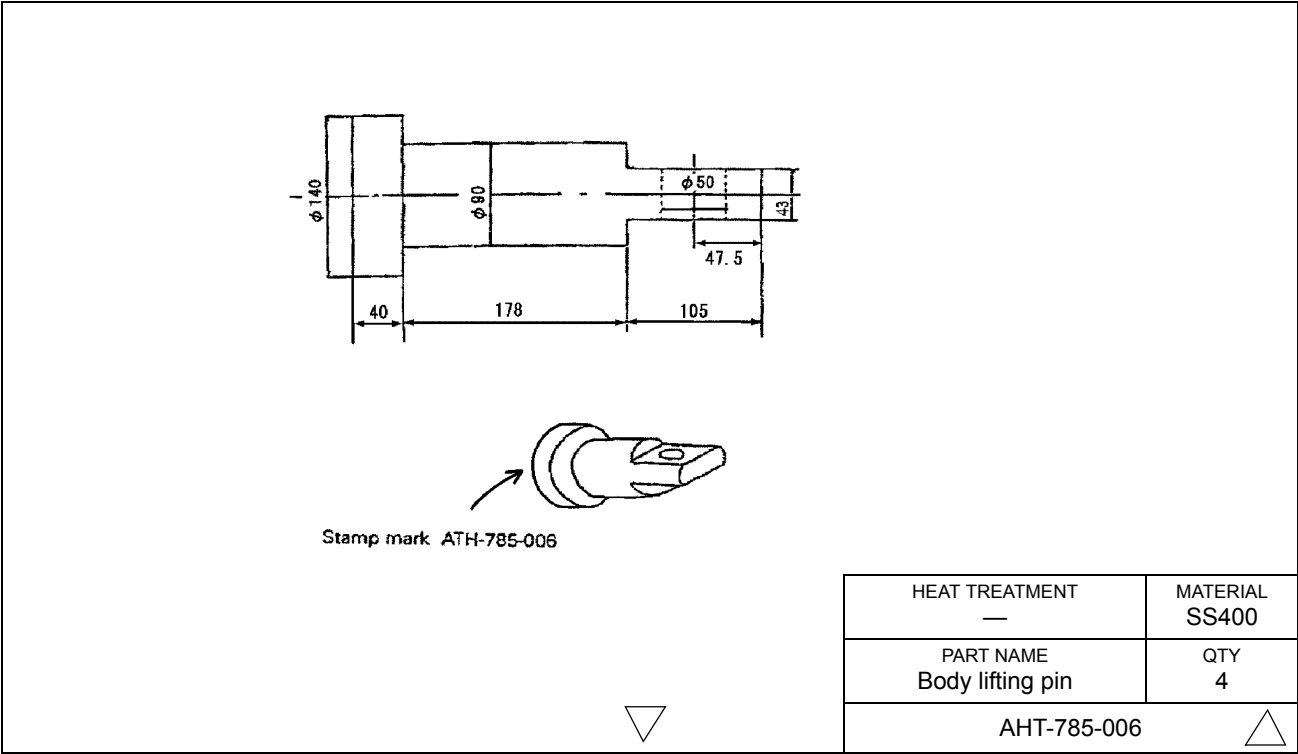
5-3. Tools and consumables

Note: Komatsu cannot accept any responsibility for special tools manufactured according to these sketches.

Body alignment shaft



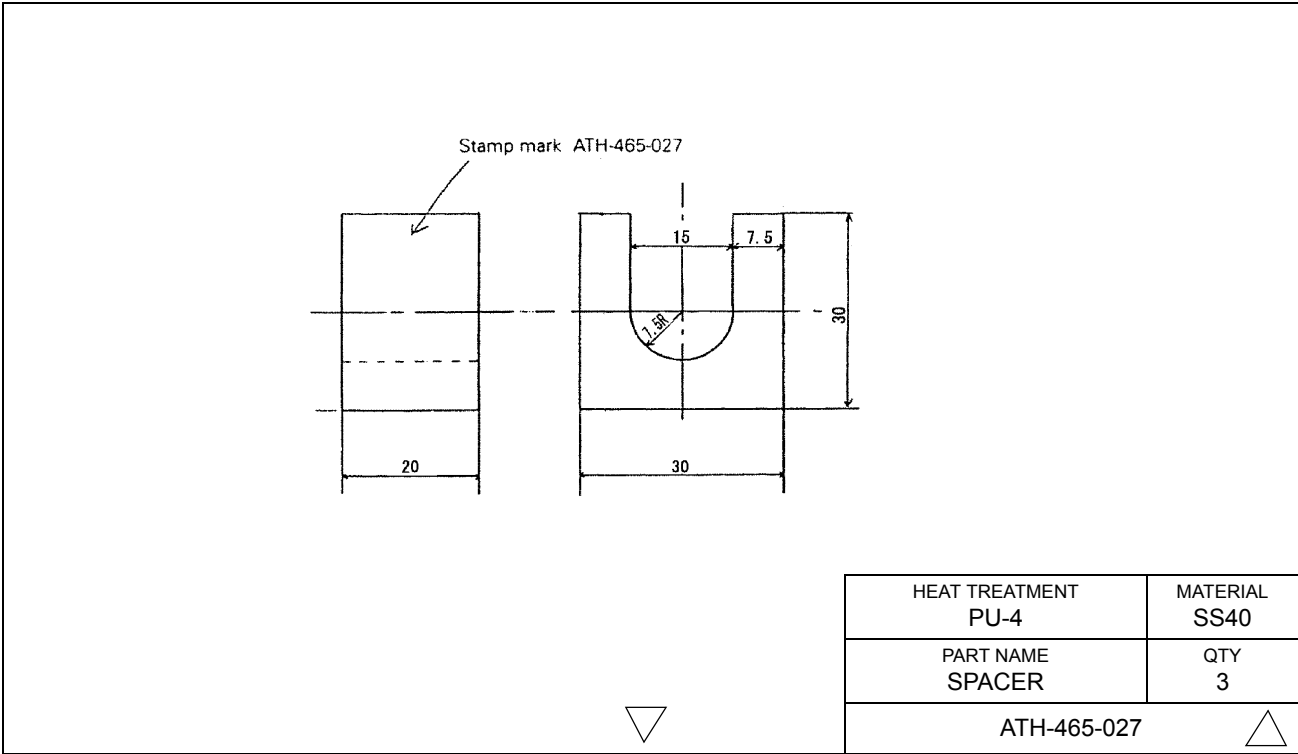
Body lifting pin



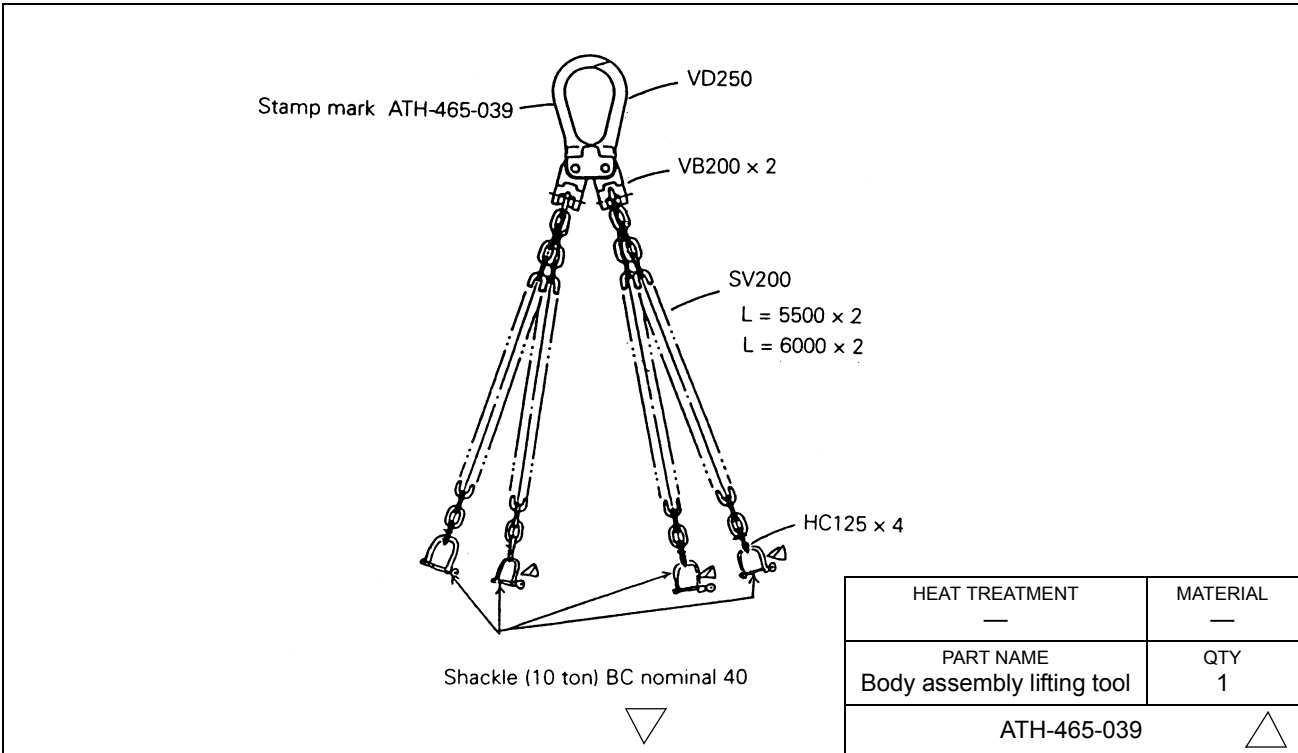
Sketches of special tools

Note: Komatsu cannot accept any responsibility for special tools manufactured according to these sketches.

When welding by actually positioning exhaust flange on machine

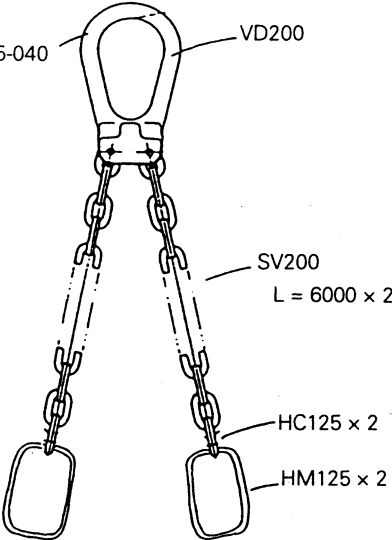


Body assembly lifting tool



Chassis lifting tool

Stamp mark ATH-465-040



VD200

SV200
L = 6000 × 2

HC125 × 2

HM125 × 2

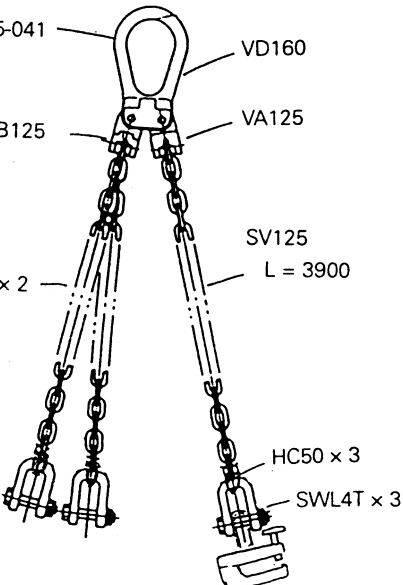
▽

HEAT TREATMENT	MATERIAL
—	—
PART NAME Chassis lifting tool	QTY 2
ATH-465-040	

△

Dump body lifting tool

Stamp mark ATH-465-041



VD160

VB125

VA125

SV125
L = 3900

L = 2900 × 2

HC50 × 3

SWL4T × 3

▽

HEAT TREATMENT	MATERIAL
—	—
PART NAME Split dump body lifting tool	QTY 1
ATH-465-041	

△

Universal lifting tool

Stamp mark ATH-465-042

HL030

HL030 x 2

HC013 x 8

SV063
L = 4000 x 4

HT013 x 4

QL-4 T

HEAT TREATMENT	MATERIAL
—	—
PART NAME	QTY
Universal lifting tool	1
ATH-465-042	

Front axle installation guide

108

50
±0.1

2-C1

HEAT TREATMENT	MATERIAL
—	—
PART NAME	QTY
Front axle installation guide	2
ATH-785-078	

Assembly process No.	Oil, grease, and coolant
0010	

Method of using fuel, lubricant, and coolant according to ambient temperature

■ Fuel, oil

Use the correct type for the ambient temperature as shown in the table below.

★ Specified capacity: Total amount of oil including oil for components and oil in piping

Refill capacity: Amount of oil needed to refill system during normal inspection and maintenance.

★ When starting the engine in an ambient temperature of less than 0°C, always use EOS0W30, or EOS5W40, even though the temperature goes up to 10°C during the daytime.

■ Coolant

Komatsu genuine super coolant (AF-NAC) is added to the cooling water, so there is no need to change it for temperatures down to -10°C.

If the temperature goes below -10°C, adjust the density. For details, see CLEANING INSIDE OF COOLING SYSTEM in the WHEN REQUIRED Section of the Operation and Maintenance Manual.

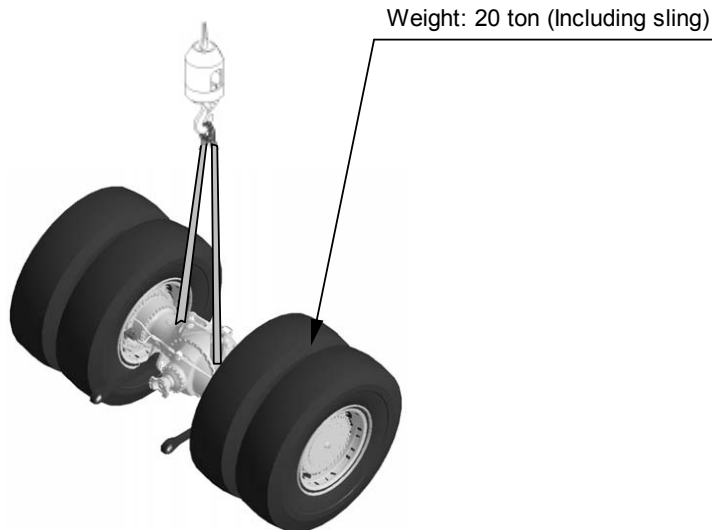
Reservoir	Fluid Type	Ambient Temperature, degrees Celsius										Recommended Komatsu Fluids
		-22	-4	14	32	50	68	86	104	122	°F	
		-30	-20	-10	0	10	20	30	40	50	°C	
Engine oil pan	Engine oil	(Note.1)										Komatsu EOS0W30
		(Note.1)										Komatsu EOS5W40
												Komatsu EO10W30DH
												Komatsu EO15W40DH
												Komatsu EO30DH
Transmission Case Brake sub tank	Power train oil (Note.2)											TO10
												TO30
Steering, hoist oil tank	Power train oil											TO10
	Hydraulic oil											HO46-HM
Front suspension Rear suspension	Hydraulic oil											HO-MVK
Differential case Final drive case	Power train oil											TO30
												TO50
Grease fitting	Hyper grease (Note.3)											G2-T, G2-TE
	Lithium EP grease											G2-LI
Cooling system	Supercoolant AF-NAC (Note.4)											AF-NAC
Fuel tank	Diesel fuel											ASTM Grade No.1-D S15 ASTM Grade No.1-D S500
												ASTM Grade No.2-D S15 ASTM Grade No.2-D S500

★ For details of the notes (e.g., Note. 1, Note.2 ...) in the table, see the Operation and Maintenance Manual.

Assembly process No.	Positioning rear axle assembly
0030	

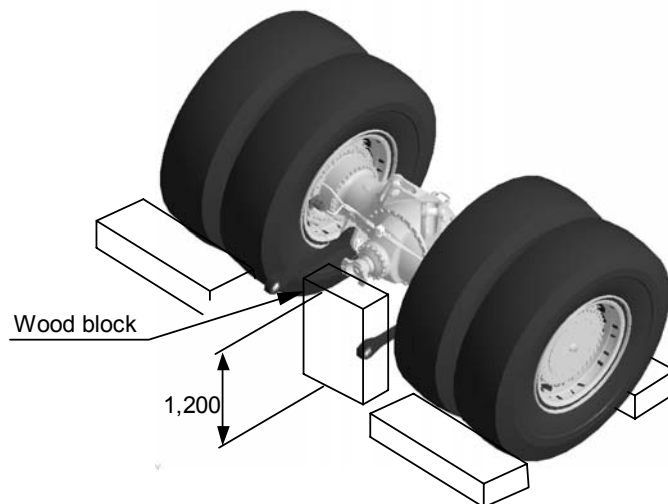
Slinging of rear axle

1. Sling the rear axle and tire assembly with a 50 ton crane.
Slinging position: Rod mounting portion on differential



Positioning of rear axle

1. Position the rear axle. See the following figure.
(Secure the ground clearance under the coupling section so that the rear axle assembly will be horizontal.)
When positioning the rear axle on the ground, prevent slanting of the machine caused by subsidence of the ground.
2. Lock the wheels with chocks to prevent the rear axle from moving.



Precautions	Necessary tools		Necessary equipment	
Lock the wheels with chocks to prevent the rear axle from moving.	Name	Q'ty	Name	Q'ty
	Nylon sling (250 mm wide × 5 m)	1	Crane (50 ton)	1
Other remarks				

Assembly process No.

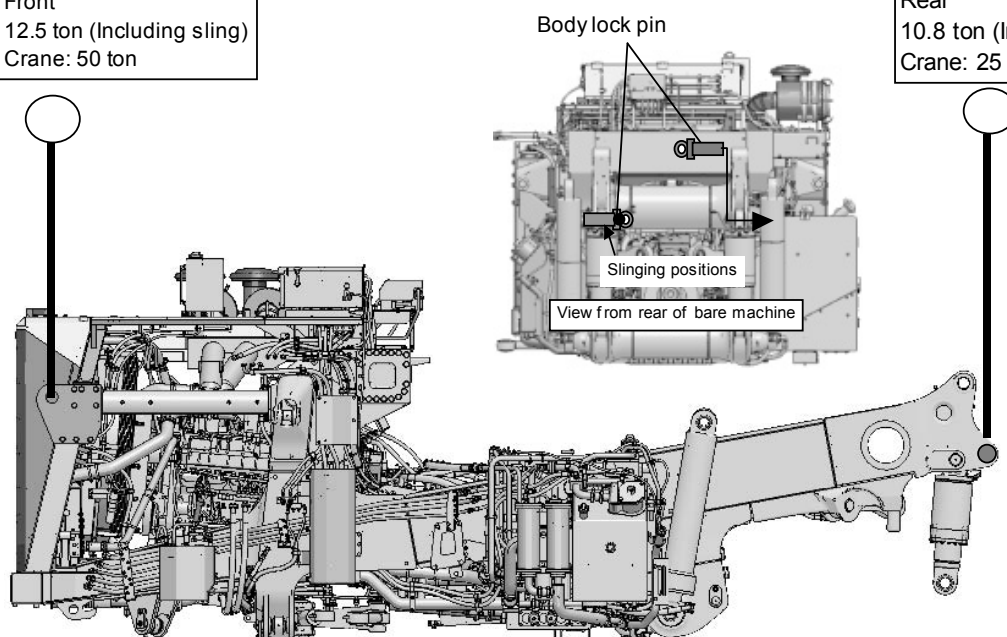
0040

Slinging and moving of bare machine

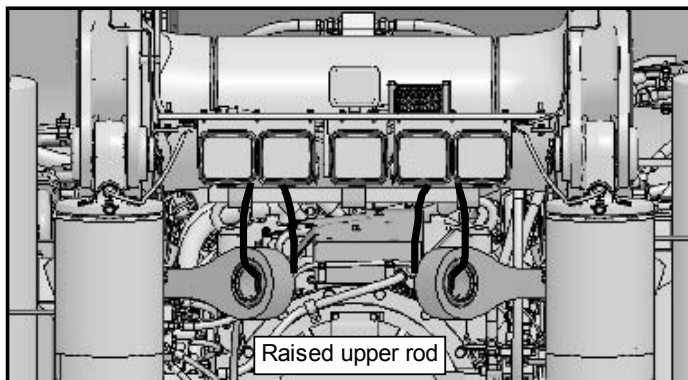
Slung of bare machine

Front
12.5 ton (Including sling)
Crane: 50 ton

Rear
10.8 ton (Including sling)
Crane: 25 ton



1. Apply cloths etc. to the body so that the body will not be damaged when it is slung.
2. Sling the bare machine with 2 cranes (Front side: 50 ton, Rear side: 25 ton).
 Sling : Chain sling (ATH-465-040) or $\phi 28$ wire
 Slinging position on front side : Frame slinging bracket
 Slinging position on rear side : Body lock pin installing position
 * Insert the body lock pin from inside of the machine (See the above figure).
3. Raise the differential upper part installing rod (upper rod).



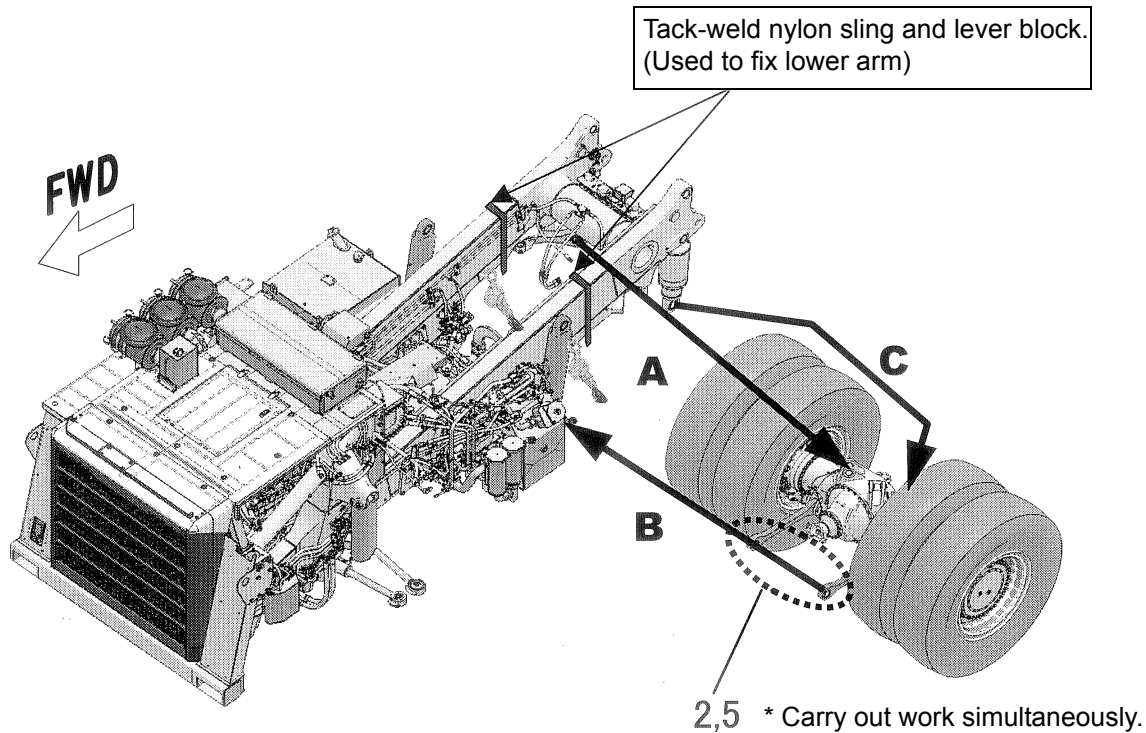
Moving of bare machine

1. Move the bare machine to above the rear axle.

Precautions	Necessary tools		Necessary equipment	
Insert the body lock pin for slinging the rear side from inside of the machine. (If it is inserted from outside, it cannot be removed after the tire is installed.)	Name	Q'ty	Name	Q'ty
			Cranes (50 ton, 25 ton)	1 each
			Sling (ATH-465-040)	2
			Pin (60 ϕ \times 250 mm)	2
			Wire (7 m, 28 ϕ)	2
Other remarks				

Assembly process No.	Connection of rod and rear suspension
0050	

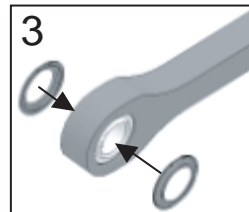
Connection of rod and rear suspension



1. Connect A, B and C in order.
Remove the pins installed temporarily and the spacers and bolts to be used in step 3.

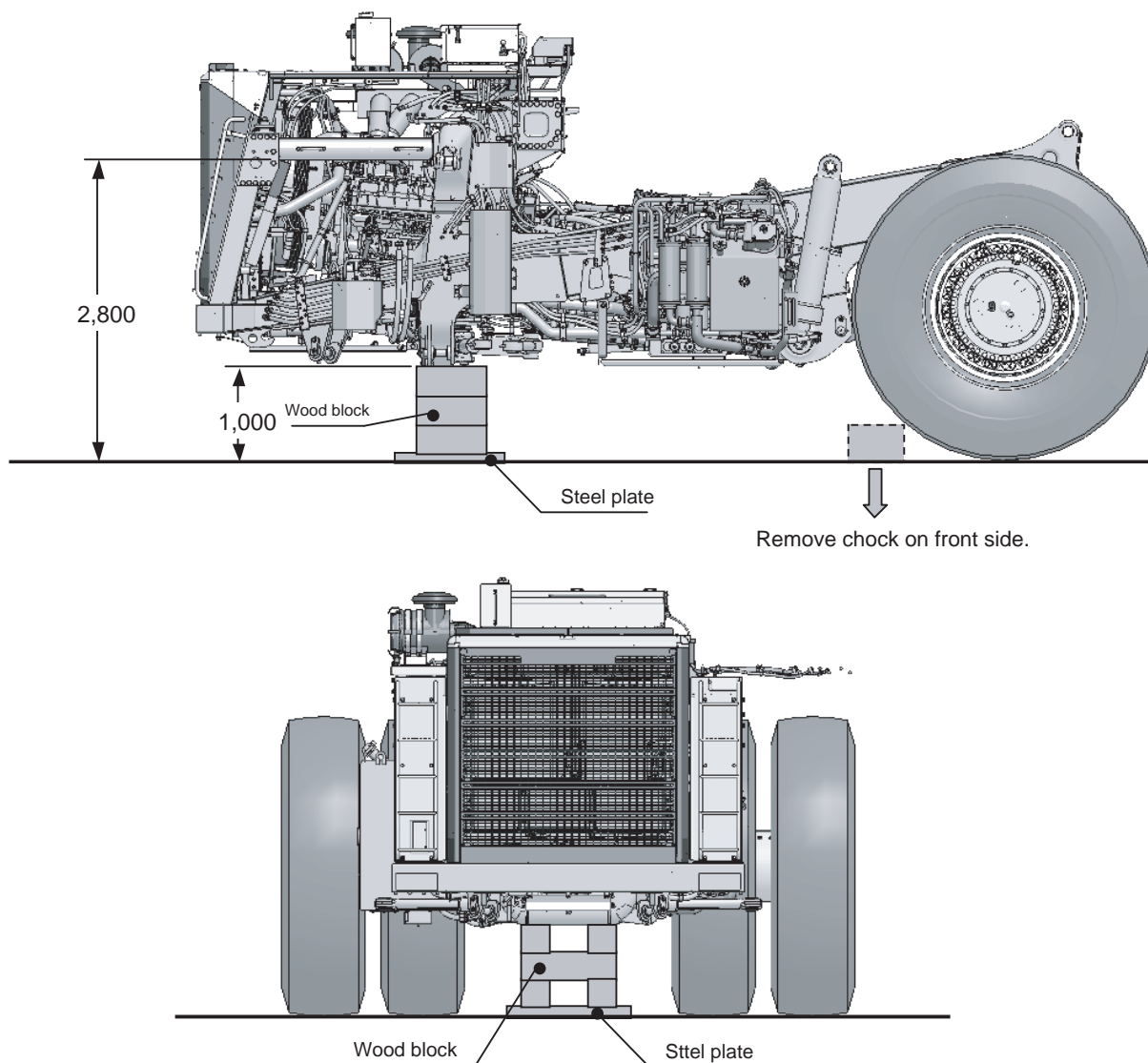
		Part No.	Part name	Q'ty	Condition of parts
A	(1)	561-52-81210	Pin	2	Temporarily installed to rear axle A
	(2)	01010-81430	Bolt	2	Temporarily installed to rear axle A
	(3)	569-40-61710	Washer	2	Temporarily installed to rear axle A
B	(4)	561-52-81210	Pin	2	Temporarily installed to frame B
	(5)	01010-81430	Bolt	2	Temporarily installed to frame B
	(6)	569-40-61710	Washer	2	Temporarily installed to frame B
C	(7)	561-52-81210	Pin	2	Temporarily installed to rear axle C
	(8)	01010-81425	Bolt	2	Temporarily installed to rear axle C
	(9)	569-40-61710	Washer	2	Temporarily installed to rear axle C

2. Adjust the pin holes and remove the rod from the pin holes temporarily.
3. Put the spacer in the rubber part of the spherical bushing. (See the figure at right.)
4. Adjust the pin holes and insert the pin.
5. Install the lock bolt and washer.
6. Supply grease.



Precautions		Necessary tools		Necessary equipment	
		Name	Q'ty	Name	Q'ty
1. When adjusting the holes, take care not to catch your finger. 2. If the spacer is installed forcibly, it is deformed. Take care. 3. When hitting the pin, take care not to crash the grease fitting. 4. Clean the pins installed temporarily and parts A, B and C.		Nylon sling (60 mm wide × 3 m)	2		
		Lever block (2 ton, LB020)	2		
Other remarks					

Assembly process No.	Positioning bare machine
0060	

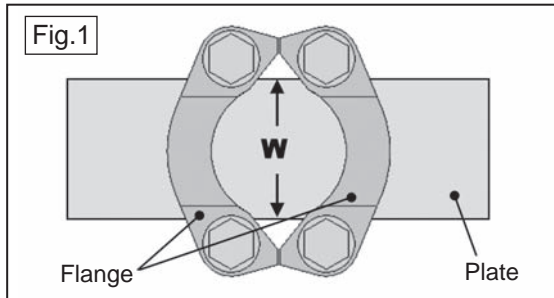
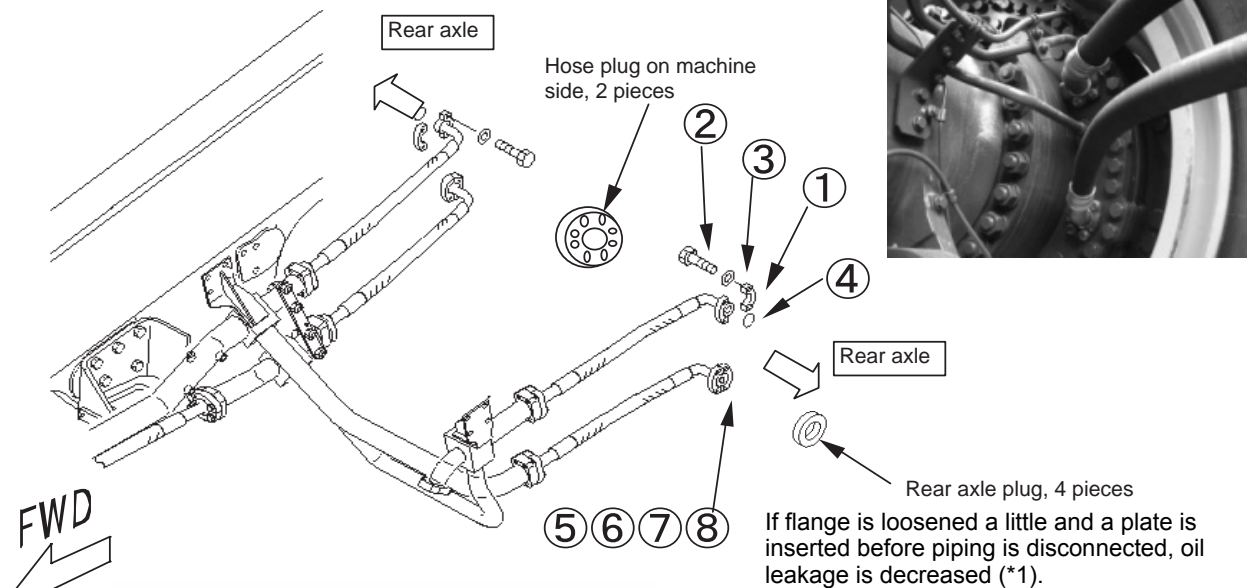


1. Set the wooden blocks 1 m high under the vertical member as shown above.
(If wooden blocks are set under the bumper, the machine is more stabilized.)
When positioning the bare machine on the ground, place a steel plate under the wood blocks so that the bare machine will not sink and lean.
2. Remove the sling.
3. Discard the bolts and washers used to install the sling since they are not used any more.

Precautions	Necessary tools		Necessary equipment	
Take care that the chassis will not move. Set the bare machine to proper height so that you can install the front tires.	Name	Q'ty	Name	Q'ty
	Wood block (300 mm square, 1 m)	6		
	Steel plate	1		
Other remarks				

Assembly process No.	Connection of rear axle cooling hose
0070	

Connection of rear axle cooling hose



1. Remove all of the hose plugs on the machine side (2 pieces) and rear axle plugs (4 pieces).
2. Connect the hoses by using the following parts.



Note) Do not damage the O-ring.

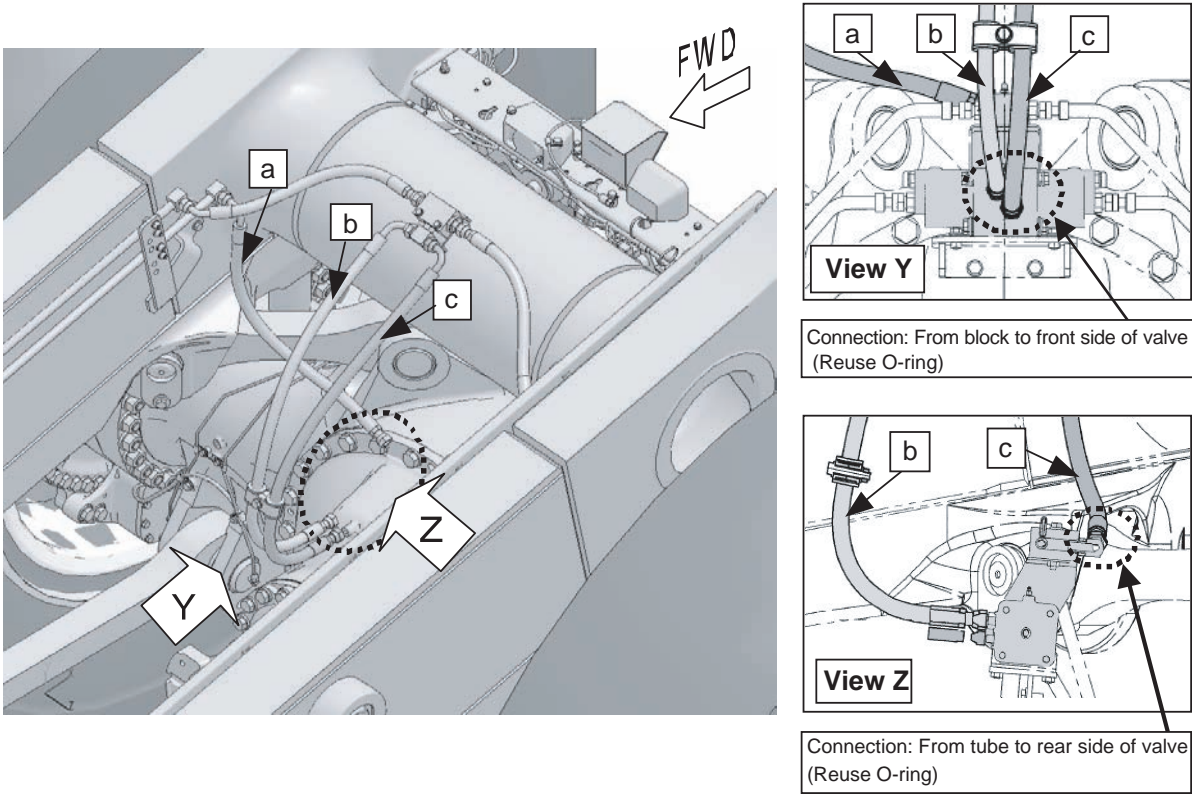
	Part No.	Part name	Q'ty	Condition of parts
(1)	07371-21465	Flange	4	Installed parts
(2)	07372-21245	Bolt	8	Installed parts
(3)	01643-51232	Washer	8	Installed parts
(4)	07000-F3048	O-ring	2	Installed parts
(5)	07371-32076	Flange	4	Installed parts
(6)	07372-21240	Bolt	8	Installed parts
(7)	01643-51232	Washer	8	Installed parts
(8)	07000-F2060	O-ring	2	Installed parts

3. Clean the parts stained with oil.

Precautions	Necessary tools		Necessary equipment	
When connecting each hose, check that no dirt is in the hose and the O-ring is fitted securely.	Name	Q'ty	Name	Q'ty
	Impact wrench (For M12 mm)	1		
When removing each plug, set an oil drain case to receive the leaking oil.	Socket (19 mm)	1		
*1. Dimension of plate (See "Fig 1") Large pipe: W = 63 mm Small pipe: W = 55 mm				
Other remarks				

Assembly process No.	Connection of rear axle brake hose
0080	

Connection of rear axle brake hose



- 1. Remove the plugs from each part.
- 2. Connect the 3 hoses.
- 3. Clean the parts stained with oil.

Caution: Install the hoses horizontally.

Precautions	Necessary tools		Necessary equipment	
	Name	Q'ty	Name	Q'ty
1. Take care extremely not to mistake the connecting positions. 2. When removing each plug, do not lose the O-ring.				
Other remarks				