

# Field Assembly Instruction

DUMP TRUCK

**HD325-7**

**HD405-7**

SERIAL NUMBERS

HD325-7001-7025  
HD325-7101 and up  
HD405-3001-3035  
HD405-7101 and up

**ecot3**

**KOMATSU**

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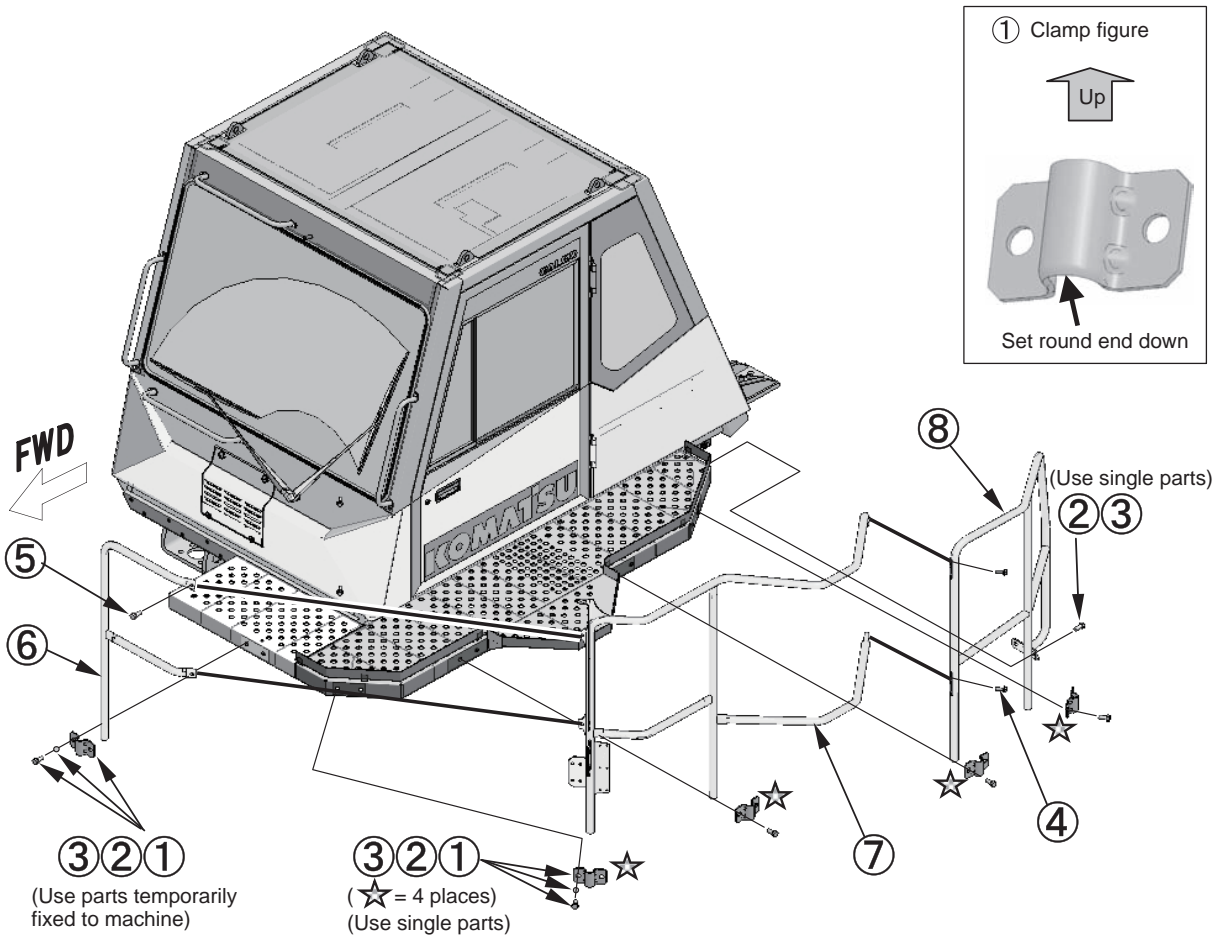
**Dump body lifting tool**

HEAT TREATMENT	MATERIAL
—	—
PART NAME	QTY
Split body sling	1
ATH-465-041	

**Universal lifting tool**

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

Assembly process No.	<b>Installation of left handrail (Diagonal ladder specification)</b>
<b>0091</b>	



1. Remove (1) – (3) temporarily fixed to the left platform and machine body.
2. Install left handrails (1) – (8) as shown in the above figure.

Note) When installing each handrail, do not project it from the round end of the clamp.

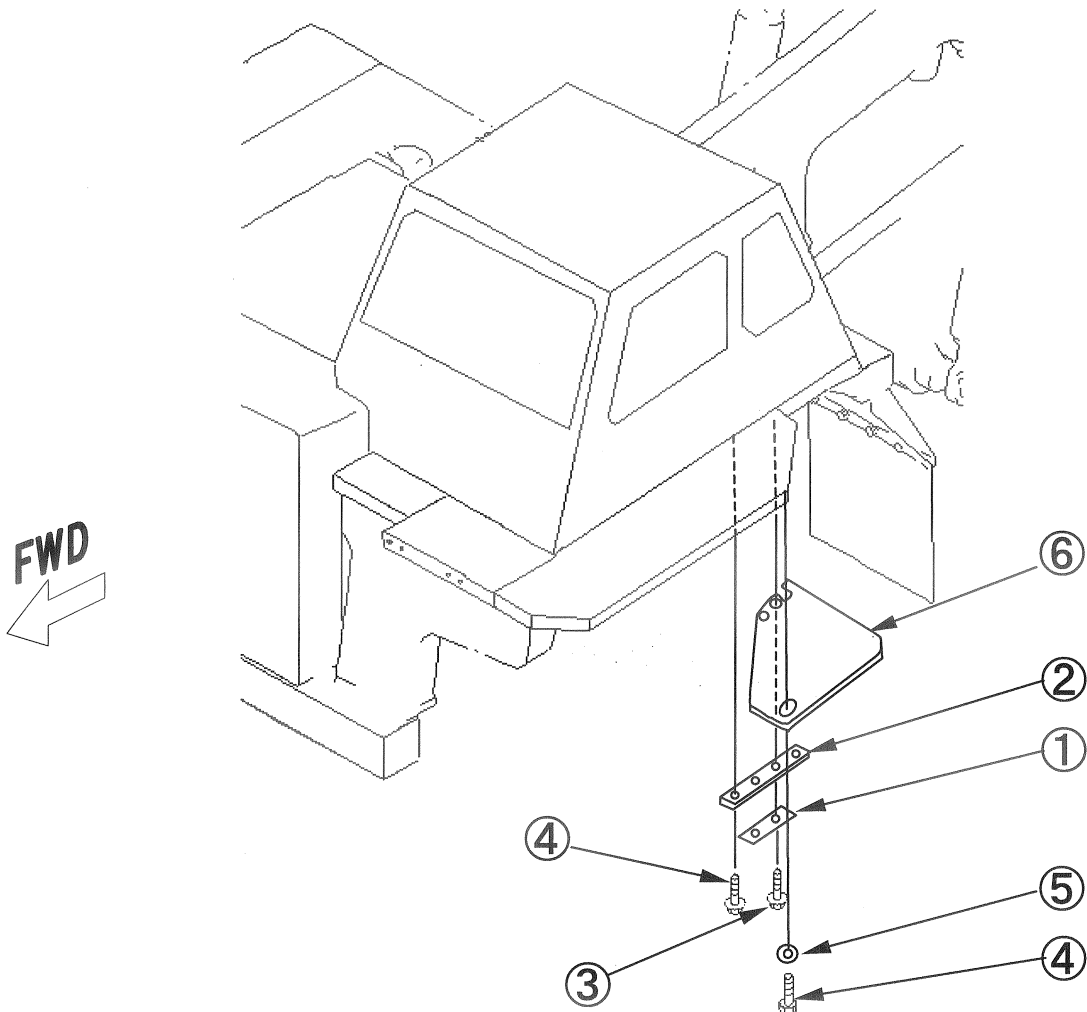
	Part No.	Part name	Q'ty	State of parts (Parts list No.)
(1)	561-54-61910	Clamp	5	Temporarily fixed to machine x 1
				Packed separately (H37-03-021) x 4
(2)	01010-81635	Bolt	12	Temporarily fixed to machine x 2
				Packed separately (H37-03-021) x 10
(3)	01643-31645	Washer	12	Temporarily fixed to machine x 2
				Packed separately (H37-03-021) x 10
(4)	01024-81240	Bolt, sems	2	Packed separately (H37-03-021)
(5)	01024-81245	Bolt, sems	2	Packed separately (H37-03-021)
(6)	566-89-88870	Guard	1	Packed separately (H37-03-021)
(7)	569-89-88890	Guard	1	Packed separately (H37-03-021)
(8)	569-54-88590	Guard	1	Packed separately (H37-03-021)

Precautions	Necessary tools		Necessary equipment	
	Name	Q'ty	Name	Q'ty
1. Each handrail must not project from the round end of the clamp.	Nylon sling (Width: 250 mm x 5 m)	1	Crane (25 tons)	1
Other remarks Sale code : 5AC11 (EC regulation)				

Assembly process No.

## Installing left side mudguard

**0140**



1. Remove (1) – (5) installed temporarily to the left platform.
2. Install left side mudguards (1) – (6) as shown above.

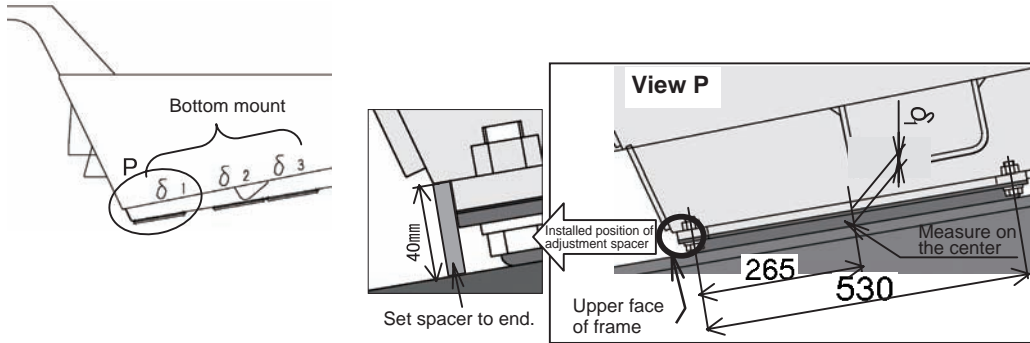
	Part No.	Part name	Q'ty	State of parts
(1)	283-54-11470	Plate	1	Temporarily installed to left platform
(2)	566-54-8A140	Bracket	1	Temporarily installed to left platform
(3)	01435-01220	Bolt	2	Temporarily installed to left platform
(4)	01435-01205	Bolt	3	Temporarily installed to left platform
(5)	417-43-16210	Washer	1	Temporarily installed to left platform
(6)	566-54-8A740	Guard	1	Loose-supply item (Packed separately)

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

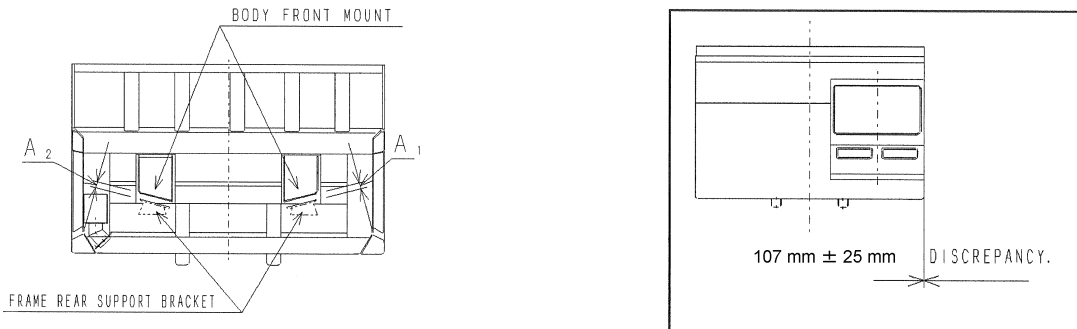
Assembly process No.	<b>Adjusting body shims</b>
<b>0240</b>	

Adjust the body mount parts as follow.

1. Bottom mount (rubber mount of dump body bottom plate)
  - (1) Insert a spacer of height 40 mm at the tip of the dump body.
  - (2) Measure dimension d of the frame and center position of the bottom mount. (Left and right: 6 places)
  - (3) Make the shims at  $d_1$ ,  $d_2$ , and  $d_3$  ( $d_1-26$ ) mm, ( $d_2-26$ ) mm, and ( $d_3-26$ ) mm respectively.
  - (4) Install the bottom mount and remove the spacer.
  - (5) Lower the dump body and check that the bottom mount contacts the top surface of the frame at all 6 places.
  - (6) After finish the adjustment of bottom mount, adjust the front parts (rubber mount of body front plate).



2. Front mount (rubber mount of dump body front surface plate)
  - (1) Measure the dimensions of body front mounts and frame rear support brackets.
  - (2) Set the thicknesses (quantity) of shims (569-74-61580) to (A1-51) mm and (A2-51) mm respectively.
  - (3) Install the shims having the thicknesses calculated in (2) above and then install rubber pad (569-74-61520).
  - (4) 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)
  - (5) Finish adjustment of the front mount.



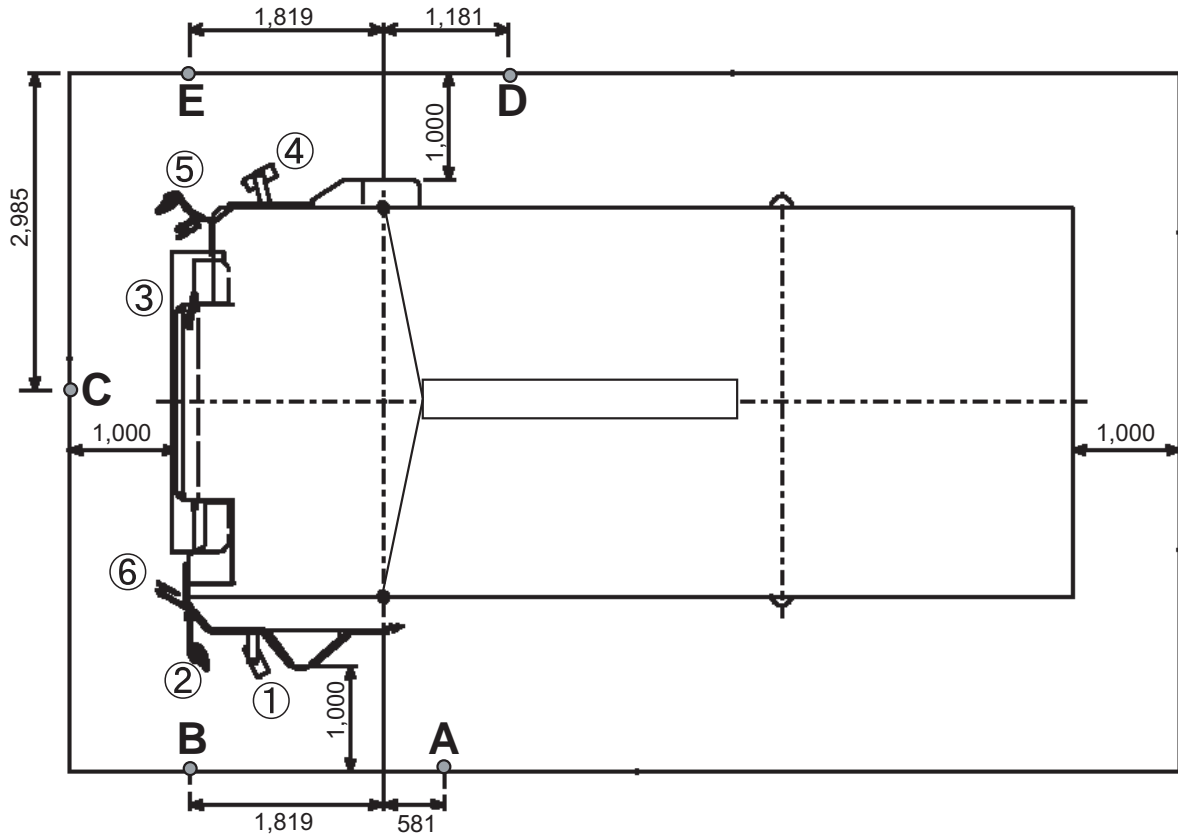
Note: After the body is installed, the positional difference between the protector and cab must be 107 mm ± 25 mm. If the discrepancy exceeds 25 mm, adjust it to below 25 mm with the shims of hinge pin (566-97-46170).

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

Assembly process No.

**0341**

**Adjustment of view range in mirror  
(For general overseas countries)**



1. Erect poles at points A, B, C, D and E.

2. Adjust each mirror so that you will see the objective poles.

- (1) → Part behind pole A, around ground contact point of tire and top edge of body
- (2) → Poles A and B and a part of machine
- (3) → Poles B and C and a part of machine
- (4) → Part behind pole D, around ground contact point of tire and top edge of body
- (5) → Poles D and E and a part of machine
- (6) → Poles C and E and a part of machine

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



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