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(54) **SPACE FRAME CENTER UPPER FRAME
NODAL CONNECTION**

(52) **U.S. Cl.**
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(57) **ABSTRACT**

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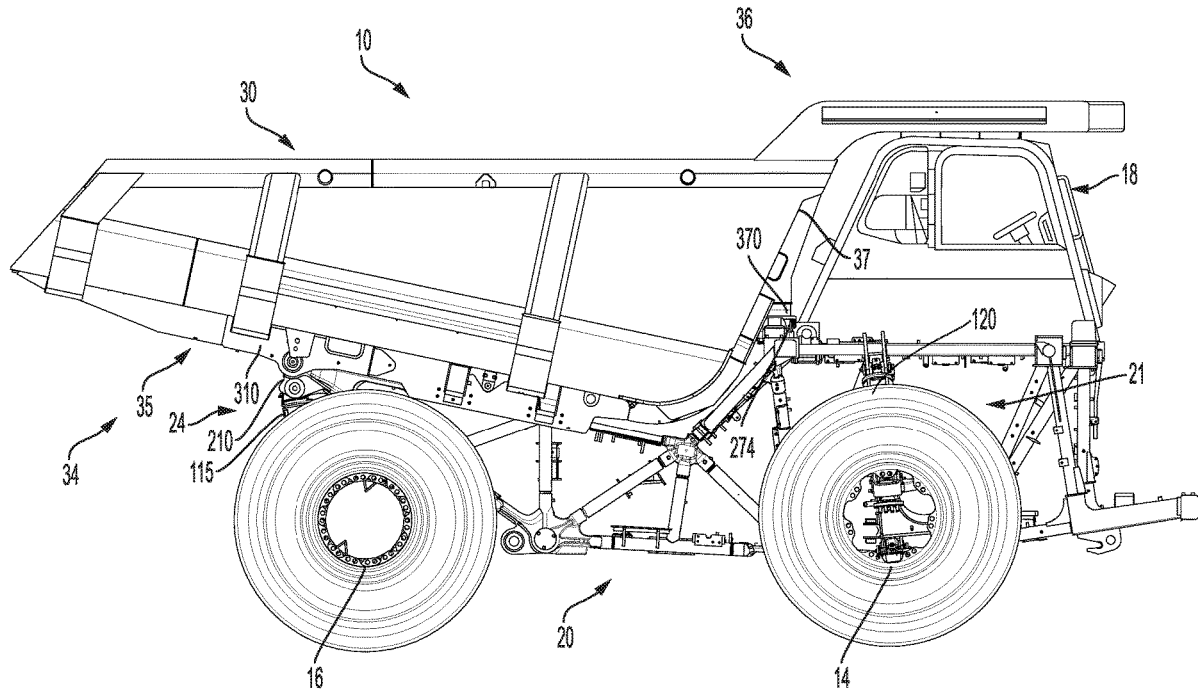
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A center upper frame nodal connection fabrication comprising a top surface, a bottom surface opposite the top surface, two side surfaces, a front surface having a plurality of integral planes oriented at angles relative to each other, and a rear surface opposite the front surface. The top surface, the bottom surface, and the two side surfaces can be weldably attached to each other and the front and rear surfaces to form a structure of the center upper frame nodal connection fabrication. The integral planes of the front surface are configured to weldably attach to respective elongate support members of a space frame. The rear surface is configured to weldably attach to a center upper frame connection casting of the space frame.

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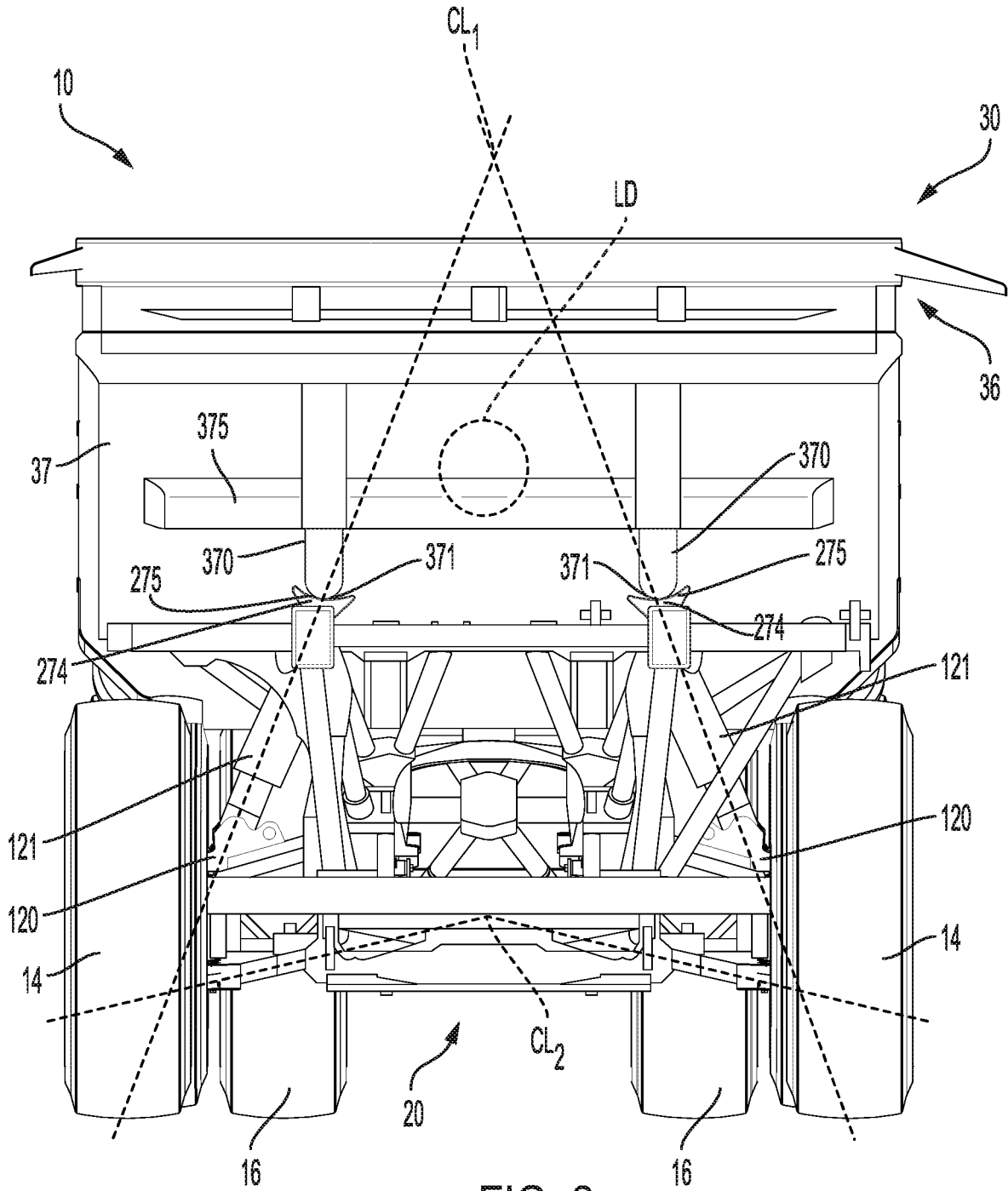


FIG. 2

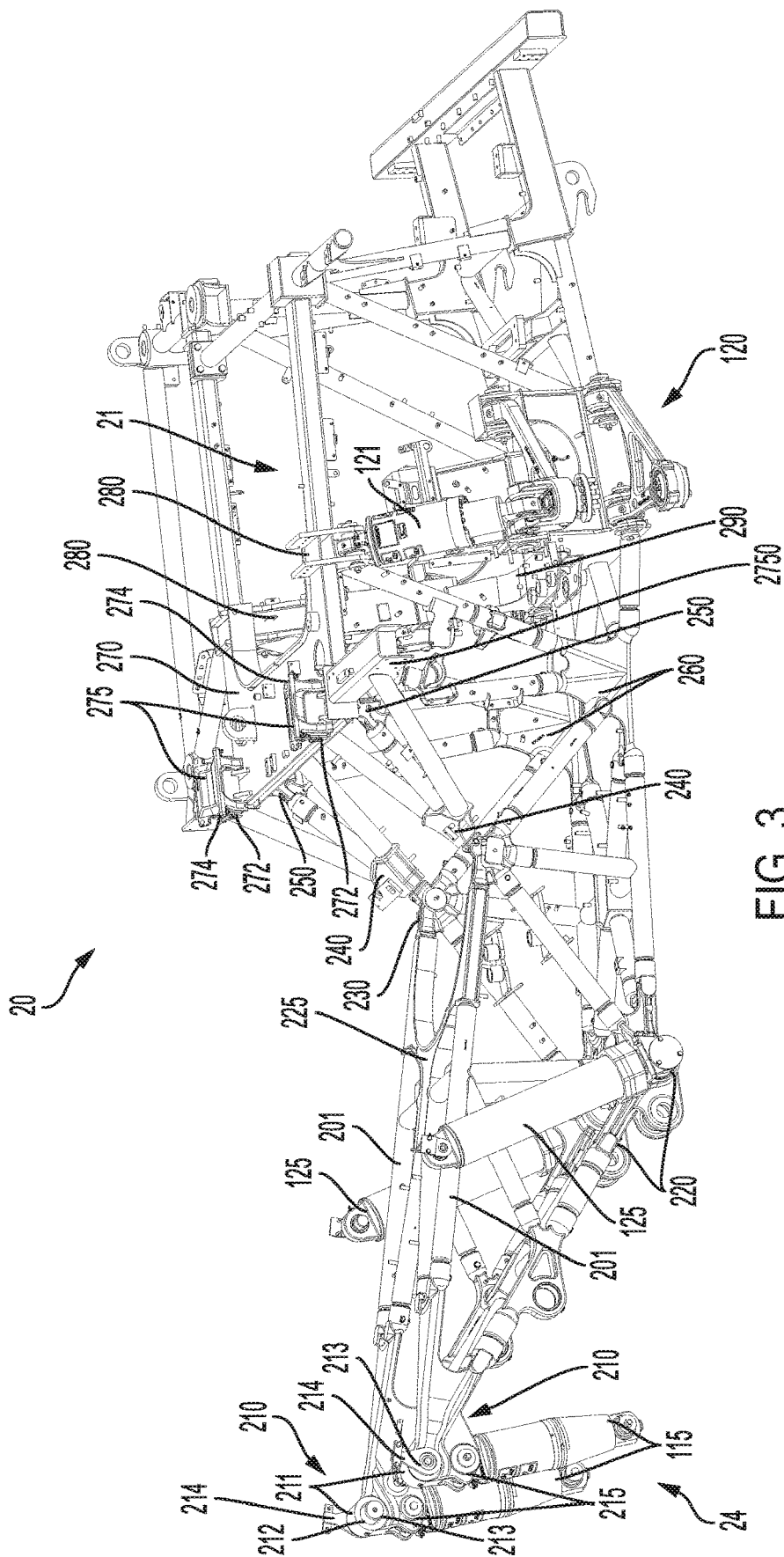


FIG. 3

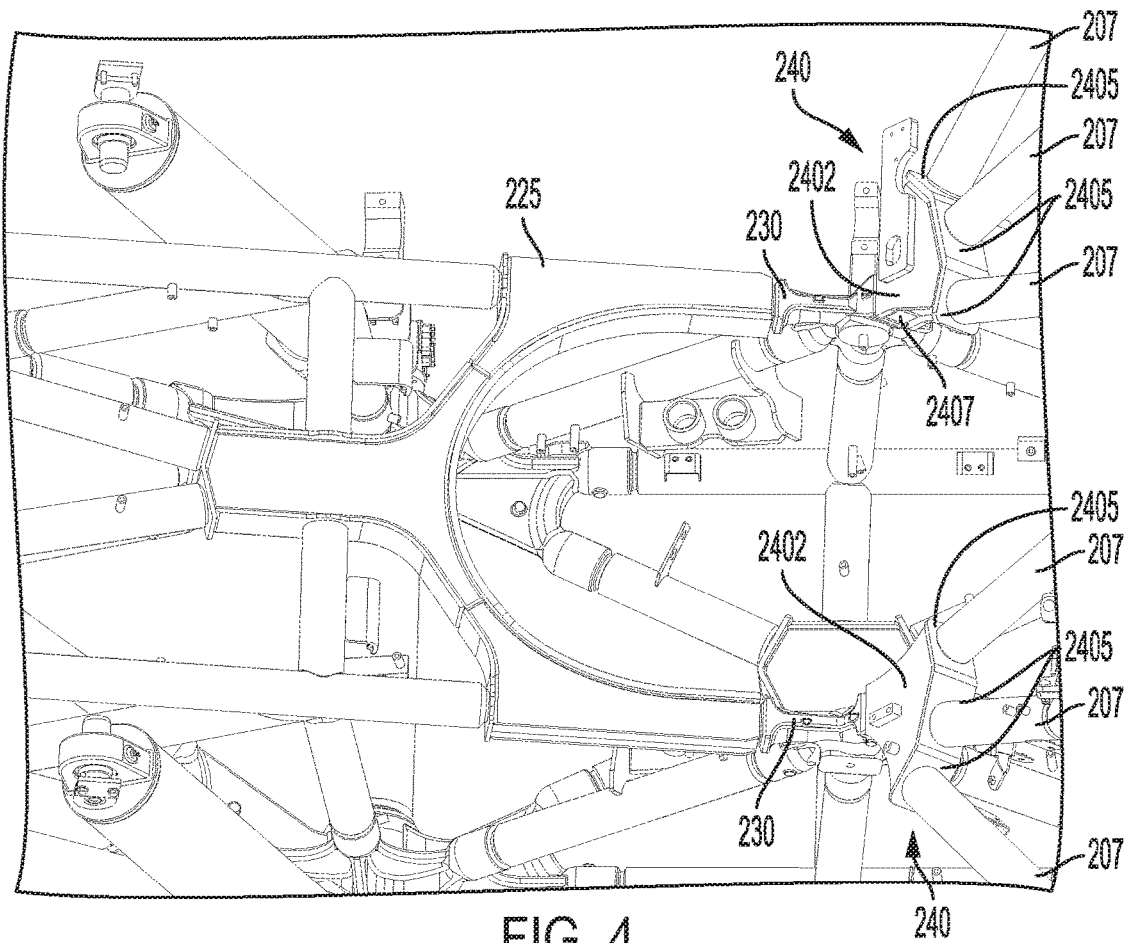


FIG. 4

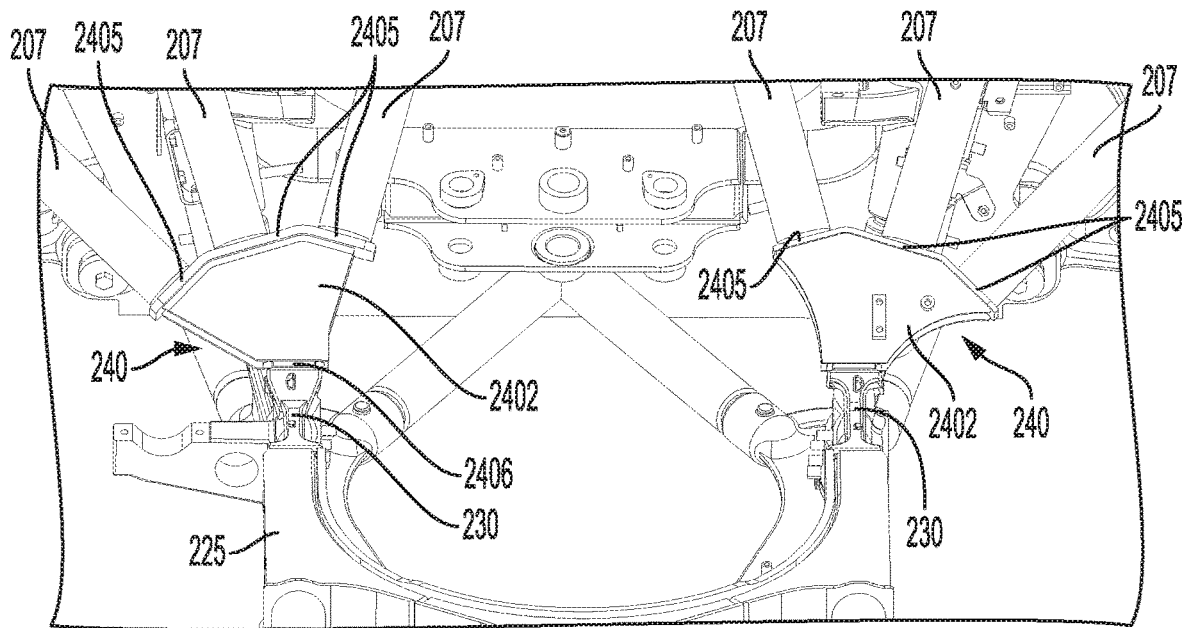


FIG. 5

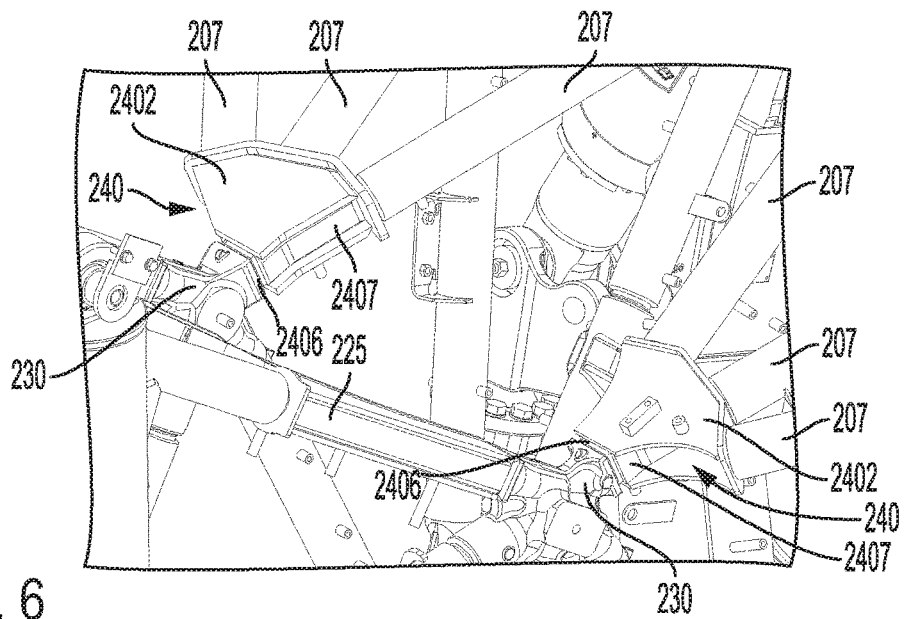


FIG. 6

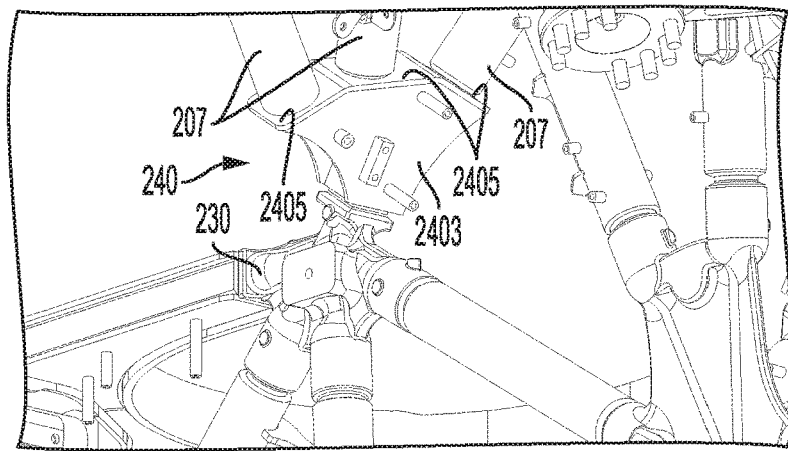


FIG. 7

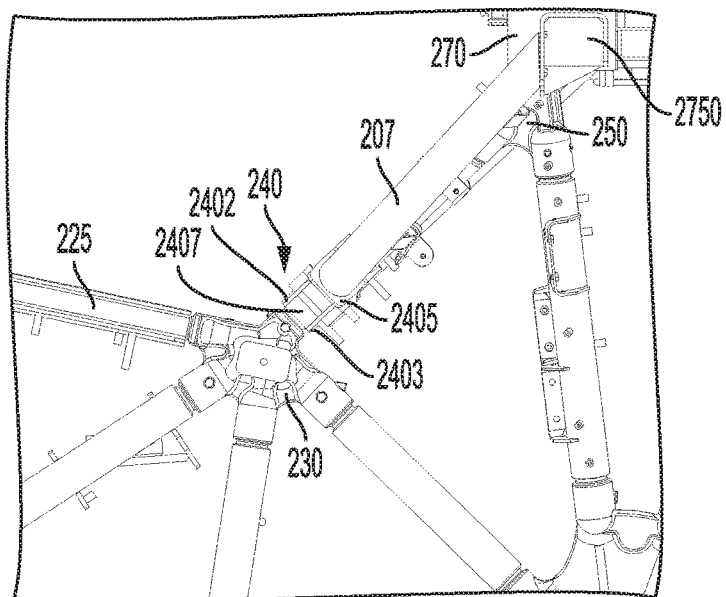


FIG. 8

SPACE FRAME CENTER UPPER FRAME NODAL CONNECTION

TECHNICAL FIELD

[0001] The present disclosure relates to space frames, and more particularly to space frame center upper frame nodal connections, and systems, components, and methods thereof.

BACKGROUND

[0002] Conventional haul trucks, such as off-highway rear haul trucks, may use welded steel frames that can be extremely heavy and may require many meters of welding to fabricate a completed frame. Space frames offer a lighter and stronger alternative to traditional welded steel frames, since far less steel is required. As a result, space frames offer considerable benefits in terms of cost, manufacturability, and performance. For example, haul trucks with space frames comparatively can haul larger payloads and consume less fuel.

[0003] Conventional space frame structures may use fabricated nodal connections. Such nodal connections may be used to create space frame structures associated with static applications. However, vehicular applications are, at least in part, dynamic in nature, and haul trucks can represent a particularly difficult application because of loads applied to the space frame as well as bending, twisting, and/or flexing that can occur as the haul truck travels on various types of terrain, such as off highway terrain. Carefully designed high-strength castings and fabrications can be required to provide appropriate stiffness and flexibility characteristics while insuring proper load transfer from the dump body to the wheels.

[0004] U.S. Patent App. Pub. No. 2016/0264189 (“the ’189 publication”) describes a node for a space frame. The ’189 publication describes that the node can have a first structural member and a second structural member at an angle relative to the first structural member. The ’189 publication also describes that the node may have a first end plate attached to a first end of the first structural member, a second end plate attached to a second end of the second structural member, and a connector plate attached to the first end plate and the second end plate. According to the ’189 publication, the connector plate may be disposed generally orthogonal to the first end plate and the second end plate.

SUMMARY OF THE DISCLOSURE

[0005] In one aspect, a center upper frame nodal connection fabrication is disclosed. The center upper frame nodal connection fabrication can comprise a top surface; a bottom surface opposite the top surface; two side surfaces; a front surface having three integral planes oriented at obtuse angles relative to each other, wherein the three integral planes are configured to weldably attach to respective elongate support members of a space frame; and a rear surface opposite the front surface configured to weldably attach to a center upper frame connection casting of the space frame. The top surface, the bottom surface, and the two side surfaces can be weldably attached to each other and the front and rear surfaces.

[0006] In another aspect, a space frame for an off-highway rear haul truck is disclosed. The space frame can be comprised of a first center upper frame nodal connection fabri-

cation; and a second center upper frame nodal connection fabrication spaced from the first center upper frame nodal connection fabrication in a width direction of the space frame. Each of the first and second center upper frame nodal connection fabrications can include a top surface, a bottom surface opposite the top surface, two side surfaces, a front surface having three integral planes oriented at obtuse angles relative to each other, wherein each of the three integral planes is configured to weldably attach a respective frame tube perpendicular thereto, and a rear surface opposite the front surface configured to weldably attach a center upper frame connection casting. The top surface, the bottom surface, and the two side surfaces can be weldably attached to each other and the front and rear surfaces to create a box structure.

[0007] And in yet another aspect, a method regarding a fabrication is disclosed. The method can comprise providing a top surface of a center upper frame nodal connection fabrication; providing a bottom surface of the center upper frame nodal connection fabrication opposite the top surface; providing two side surfaces of the center upper frame nodal connection fabrication; providing a front surface of the center upper frame nodal connection fabrication, the front surface having three integral planes oriented at obtuse angles relative to each other, wherein the three integral planes are configured to weldably attach to respective frame tubes of a space frame; and providing a rear surface of the center upper frame nodal connection fabrication, the rear surface being configured to weldably attach to a center upper frame connection casting of the space frame. The top surface, the bottom surface, and the two side surfaces can be weldably attached to each other and the front and rear surfaces.

[0008] Other features and aspects of this disclosure will be apparent from the following description and the accompanying drawings.

BRIEF DESCRIPTION OF THE DRAWINGS

[0009] FIG. 1 is a side view of a machine according to embodiments of the disclosed subject matter.

[0010] FIG. 2 is a front view of the machine of FIG. 1 with an operator cabin thereof removed to show a space frame and a dump body thereof according to embodiments of the disclosed subject matter.

[0011] FIG. 3 is a side view of a space frame according to embodiments of the disclosed subject matter.

[0012] FIGS. 4-8 are views of a center upper frame nodal connection fabrication according to embodiments of the disclosed subject matter.

[0013] FIG. 9 is an exploded view of the space frame and dump body to show defined contact points according to embodiments of the disclosed subject matter.

DETAILED DESCRIPTION

[0014] Referring now to the drawings and with specific reference to FIG. 1 and FIG. 2, these figures illustrate an exemplary embodiment of a machine 10. Machine 10 may be a mobile machine that performs some type of operation associated with an industry such as mining, construction, or any other industry known in the art. For example, as shown in FIG. 1 and FIG. 2, machine 10 may be an earth moving machine, particularly, an off-highway rear haul truck 10.

[0015] Machine 10 may have a space frame 20 supported by front wheels 14 and rear wheels 16 (including respective

tires). The front and rear wheels **14**, **16** may be connected to space frame **20** by front suspension members and rear suspension systems, respectively. Machine **10** may also include a bed or body **30** supported by the space frame **20**. Such bed or body **30** may be referred to herein as a dump body **30**. The dump body **30** can be configured as a receptacle to receive hauling material.

[0016] A rear portion **34** of the dump body **30** can be pivotably coupled or attached to a portion (including portions) at a rear **24** of the space frame **20**. Discussed in more detail below, portions of the dump body **30** between the rear portion **34** and a front portion **36** of the dump body **30** can be movably positioned relative to respective portions of the space frame **20** to support the dump body **30** on the space frame **20** at a rest position of the dump body **30**. The rest position of the dump body **30** may be considered as positioning of the dump body **30** such that the front portion **36** of the dump body **30** is at a lower-most position (i.e., not raised). The dump body **30** can be pivoted at the rear portion **34** about the rear **24** of the space frame **20** to raise or lower the portion of the dump body **30** in front of the pivot (and hence move the portion of the dump body **30** behind the pivot in the opposite direction). Such pivoting of the dump body **30** to raise the front portion **36** of the dump body **30** can be to dump content from within the dump body **30**. Likewise, pivoting of the dump body **30** to lower the front portion **36** of the dump body **30** to the rest position can be to receive content in the dump body **30**.

[0017] Machine **10** may have an operator cabin **18** supported by the space frame **20**. Machine **10** may also be equipped with a steering mechanism and controls to move the machine **10** and controls to raise and lower dump body **30**. The steering mechanism and the controls may be located within the operator cabin **18** of the machine **10**.

[0018] Machine **10** may have a prime mover (not expressly shown) supported by the space frame **20**. Generally, the prime mover may be provided in a space **21** of the space frame **20**. The prime mover may be configured to propel the front and rear wheels **14**, **16** in the forward or rearward direction. The prime mover may be lengthwise aligned on space frame **20** along a travel direction of the machine **10**. One skilled in the art will recognize, however, that the prime mover may be aligned transversally. In one exemplary embodiment, the prime mover may be an internal combustion engine, which may be a two-stroke or four-stroke diesel engine, for instance. One skilled in the art will recognize, however, that the prime mover may be any other type of internal combustion engine, such as a gasoline engine or a gaseous fuel-powered engine. The prime mover may be connected to front and/or rear wheels **14**, **16** via other components such as a drive train (not shown) to transfer motive power to move the front and/or rear wheels **14**, **16** in a forward or rearward direction.

[0019] Exhaust from the prime mover may be output from one or more exhaust outputs (not expressly shown). Optionally, the one or more exhaust outputs may be provided generally between the operator cabin **18** and a front wall **37** of the dump body **30** such that exhaust is provided toward at least a predetermined portion of the front wall **37**. A coupling (e.g., bellows) may be provided to connect the one or more exhaust outputs to the front wall **37** of the dump body **30**, for instance, to a heating channel provided in or on the front wall **37** of the dump body **30** to heat the material carried in the dump body **30**.

[0020] In general, a space frame according to embodiments of the disclosed subject matter, such as space frame **20**, may be a frame that includes structural members connected to each other at nodes and/or joints. The structural members can include hollow tubes and/or solid tubes, and in some instances can be connected according to a triangulated structural. The structural members can be made of metal, metal alloys, or reinforced composite materials, for instance.

[0021] FIG. 3 is a more detailed view of the space frame **20**. As shown, the space frame **20** can include a pair of rear frame connections **210** at the rear **24** of the space frame **20**, a pair of center lower frame connections **220**, a center upper horizontal frame connection **225**, a pair of center upper frame connections **230**, a pair of center upper frame nodal connections **240**, a pair of front upper frame connections **250**, a pair of front lower frame connections **260**, a front upper frame connection **270**, a pair of front upper suspension connections **280**, and a front lower suspension connection **290**. Though the foregoing connections are described as pairs, the connections of a pair may not be identical. For instance, the connections of a pair may be symmetrical, generally, but not necessarily identical. The foregoing connections can be castings or fabrications. In general, a casting may refer to a connection that is not welded to another support component of the space frame **20**, and a fabrication may refer to a connection that is welded to another support component of the space frame **20**.

[0022] The center lower frame connections **220** and corresponding connections can be as set forth in U.S. application Ser. No. 16/663,892 filed Oct. 25, 2019 (Case 19-0767); the center upper horizontal frame connection **225** and corresponding connections can be as set forth in U.S. application Ser. No. 16/663,930 filed Oct. 25, 2019 (Case 19-0768); the center upper frame connections **230** and corresponding connections can be as set forth in U.S. application Ser. No. 16/664,042 filed Oct. 25, 2019 (Case 19-0773); the front upper frame connection **250** and corresponding connections can be as set forth in U.S. application Ser. No. 16/664,010 filed Oct. 25, 2019 (Case 19-0772); the front lower frame connections **260** and corresponding connections can be as set forth in U.S. application Ser. No. 16/664,104 filed Oct. 25, 2019 (Case 19-0762); the front upper suspension connections **280** and corresponding connections can be as set forth in U.S. application Ser. No. 16/664,124 filed Oct. 25, 2019 (Case 19-0759); and/or the front lower suspension connection **290** and corresponding connections can be as set forth in U.S. application Ser. No. 16/664,169 filed Oct. 25, 2019 (Case 19-0760). The foregoing applications are incorporated herein by reference in their entireties.

[0023] The space frame **20** can also include a plurality of elongate support members, such as elongate support members **201** and elongate members **207**. Elongate support members, according to embodiments of the disclosed subject matter, can be in the form of rods and/or tubes, circular, for instance, where some or all of the rods and/or tubes may be solid or hollow.

[0024] Turning to FIGS. 4-8, each center upper frame nodal connection **240**, which may be a fabrication, can be coupled between the center upper frame connection **230**, the front upper frame connection **250**, and the front upper frame connection **270** (including the horizontal arm **2750** extending therefrom). Each center upper frame nodal connection **240** can include a top surface **2402**, a bottom surface **2403** opposite the top surface **2402**, two side surfaces **2407**, a

front surface **2405**, and a rear surface **2406**. According to one or more embodiments, the top surface **2402**, the bottom surface **2403**, and the two side surfaces **2407** can be fixedly attached (e.g., welded) to each other and the front and rear surfaces **2405**, **2406**, for instance, to create a structure. The structure may be in the form of a box, for instance, a hollow box. Optionally, the box can be a fan shape in a top plan view of the center upper frame nodal connection **240**, such as shown in FIG. 5. Also, the center upper frame nodal connections **240** on opposite sides of the space frame **20** may be generally symmetrical or mirror images of each other, through some variation, such as surface features, may exist between the two center upper frame nodal connections **240**.

[0025] In general, the front surface **2405** can be wider than the rear surface **2406**. Additionally, as shown in FIG. 6, for instance, opposite ends of the front surface **2405** can extend past side edges of the top and bottom surfaces **2402**, **2403**. Optionally, the side surfaces **2407** can be recessed from side edges of the top and bottom surfaces **2402**, **2403**, such as shown in FIGS. 4 and 6-8.

[0026] A plurality of planes can be integral to the front surface **2405**. FIGS. 4-8, for instance, show three integral planes. Optionally, the rear surface **2406** and a middle integral plane of the front surface **2405** can be parallel to each other. According to one or more embodiments, the integral planes of the front surface **2405** can be angled with respect to each other. For instance, the integral planes of the front surface **2405** may be angled or oriented relative to each other at an obtuse angle or angles. Optionally, all of the angles may be the same.

[0027] The rear surface **2406** can be fixedly coupled (e.g., welded) to the center upper frame connection **225**. The front surface **2405** can also be fixedly coupled (e.g., welded), to a plurality of elongate support members **207**, which may be frame tubes. FIGS. 4-8 show, as an example, that three of the elongate support members **207** can be fixedly coupled to the front surface **2405**, one elongate support member **207** on each integral plane of the front surface **2405**. According to one or more embodiments of the disclosed subject matter, the elongate support members **207** can be perpendicular to the corresponding integral planes of the front surface **2405**.

[0028] As shown in FIG. 8, when the center upper frame nodal connection **240** is provided in the space frame **20**, the front surface **2405** can face upward and the rear surface **2406** can face downward. For example, the front surface **2405** can face upward at a positive acute angle relative to horizontal, and the rear surface **2406** can face downward at a negative acute angle relative to horizontal.

[0029] Turning back to FIG. 3, each elongate support member **201** can be provided between the rear frame connections **210** and the front upper frame connection **270** in a top plan view of the space frame **20**. More specifically, each elongate support member **201** can be provided between the center upper horizontal frame connection **225** and one of the rear frame connections **210**. Further, each elongate support member **201** can extend lengthwise generally horizontally, in this case rearward from the center upper horizontal frame connection **225** at a positive acute angle relative to a horizontal plane running through the front wheels **14** and the rear wheels **16**. In that the elongate support members **201** are provided at an outer portion of the space frame **20** in a width direction of the space frame **20**, the elongate support members **201** may be considered outer elongate support members

201. As an example, the outer elongate support members **201** may be outer frame tubes.

[0030] Each rear frame connection **210**, which may be a casting, can have a rear support **211** and a rear suspension node **215**. Discussed in more detail below, the rear support **211** can directly support the dump body **30**, and the rear suspension node **215** can be coupled to a rear suspension member **115** of the rear suspension system. The rear frame connections **210** can also be coupled to a plurality of elongate support members, including elongate support members **201**. According to one or more embodiments of the disclosed subject matter, each of the rear frame connections **210** can be seven-point connections. For instance, according to embodiments of the disclosed subject matter, the rear frame connections **210** and corresponding connections can be as set forth in U.S. application Ser. No. 16/663,815 filed Oct. 25, 2019 (Case 19-0764), which is incorporated herein by reference in its entirety.

[0031] The rear support **211** can be configured as a pivot pin boss with a pivot pin bore or opening **212**. According to one or more embodiments, an outer surface of the rear support **211** (i.e., pivot pin boss) and the pivot pin bore **212** can be cylindrical. An axis of the pivot pin bore **212** can extend in a width direction of the space frame **20**. Moreover, the axes of the pivot pin bores **212** from the rear supports **211** of the pair of rear frame connections **210** may be aligned with each other. That is, the axes of the pivot pin bores **212** can be coaxial or common. The pivot pin bore **212** can be configured to receive a pivot pin of a pivot pin interface **213** such that the pivot pin interface **213** is pivotally coupled to the rear support **211** via the pivot pin bore **212** and the pivot pin interface **213** can pivot or rotate about the axes of the pivot pin bore **212** and the pivot pin of the pivot pin interface **213**. Discussed in more detail below, the pivot pin interface **213** can also be coupled to a bottom **35** of the dump body **30**.

[0032] As shown in FIG. 3, the front upper frame connection **270** can be fixedly coupled to the front upper suspension connections **280**, and a bottom of the front upper frame connection **270** can be fixedly coupled to the front upper frame connections **250**. Additionally, the front upper frame connection **270**, which may be a fabrication, can have a body with a pair of rocker attachment interfaces **272** on a top surface thereof. According to one or more embodiments, the front upper frame connection **270** and corresponding connections can be as set forth in U.S. application Ser. No. 16/663,849 filed Oct. 25, 2019 (Case 19-0766), which is incorporated herein by reference in its entirety.

[0033] The rocker attachment interfaces **272** can be spaced from each other in a width direction of the space frame **20**, for instance, provided at opposite outer lateral edges of the body of the front upper frame connection **270**, such as shown in FIG. 3. Each rocker attachment interface **272** can have a pivot pin bore configured to receive a pivot pin. Optionally, the pivot pin can be considered part of the rocker attachment interface **272**. An axis of rotation for the pivot pin bore and the pivot pin can run horizontally or substantially horizontally in a length direction of the space frame **20**. Moreover, the axes of rotation for the rocker attachment interfaces **272** can be parallel to each other.

[0034] Each rocker attachment interface **272** can have rotatably attached thereto a support rocker **274** via the pivot pin. In that the rocker attachment interfaces **272** can be spaced apart from each other in the width direction of the space frame **20**, so too can be the support rockers **274**.

Moreover, the support rockers 274 can rotate or pivot laterally or in a width direction of the space frame 20 about the respective axes of rotation defined by the rocker attachment interfaces 272.

[0035] According to embodiments of the disclosed subject matter, each support rocker 274 can have an upward-facing contact surface 275. The upward-facing contact surface 275 can be concave, for instance, semi-cylindrical, elliptical, or multi-planar. Additionally, the upward-facing contact surface 275 can be or include a padding. Discussed in more detail below, the support rockers 274, particularly the upward-facing contact surfaces 275 thereof, can receive a portion of corresponding vertical support structures 370 of the dump body 30 (see FIG. 2 and FIG. 9).

[0036] Turning now to FIG. 9, the dump body 30 can have, on the bottom 35 thereof, a rear pivot support 310 and a pair of flat contact surfaces 301, and on the front wall 37 thereof, a pair of vertical support structures 370.

[0037] The rear pivot support 310 can be provided at the rear portion 34 of the dump body 30, such as shown in FIG. 9. The rear pivot support 310 can have a pair of rear pivots 311. The rear pivots 311 can be spaced apart from each other in a width or lateral direction of the dump body 30, such as shown in FIG. 9. The rear pivot support 310 can also include a cross-member 314, which can be provided between the rear pivots 311, fixedly connected to or part of the rear pivots 311 (i.e., integral and/or one-piece with).

[0038] The rear pivot support 310 can be fixedly coupled to the bottom 35 of the dump body 30. For example, the rear pivot support 310 can be welded to the bottom 35 of the dump body 30. More specifically, according to one or more embodiments of the disclosed subject matter, each rear pivot 311 can be welded to a corresponding longitudinal body support member 377 on the bottom of the dump body 30. As shown in FIG. 9, for instance, each rear pivot 311 can be welded in-line with the corresponding longitudinal body support member 377. Thus, the rear pivot 311 can be considered as part of the longitudinal body support member 377 (i.e., integral and/or one-piece with).

[0039] Each rear pivot 311 can also include a plurality of cut-outs, for instance, two cut-outs, spaced apart from each other in a length direction of the dump body 30. Each cut-out can receive or accept a transverse body support member 378. Moreover, the cut-outs of one of the rear pivots 311 can receive different transverse body support members 378, for instance, adjacent transverse body support members 378, such as shown in FIG. 9. Additionally, as shown, each transverse body support member 378 can extend through one cut-out of one rear pivot 311 and through an opposing cut-out of the other rear pivot 311.

[0040] According to one or more embodiments of the disclosed subject matter, the rear pivots 311 can also include an attachment interface 312 on an outer side surface thereof, such as shown in FIG. 9. As a non-limiting example, the attachment interface 312 can include a pair of projections configured to mate with corresponding notches of the pivot pin interface 213. The rear pivot support 310 and corresponding connections can be as set forth in U.S. application Ser. No. 16/663,627 filed Oct. 25, 2019 (Case 19-0763), which is incorporated herein by reference in its entirety.

[0041] The rear pivots 311 can be pivotally coupled to the rear supports 211 of the space frame 20 via the pivot pin interface 213. More specifically, for each rear pivot 311/rear support 211 pair, the rear support 211 can be provided in a

pivot bore of the rear pivot 311 (e.g., between the two pivot bore portions of a single rear pivot 311) such that the pivot bore 212 of the rear support 211 is aligned with the pivot bore and such that a pin of the pivot pin interface 213 extends through the pivot bore 212 of the rear support 211 and the pivot bore of the rear pivot 311. An arm 214 of the pivot pin interface 213 can have one or more notches configured to be mated with corresponding one or more projections of the attachment interface 312.

[0042] The pivot pin interface 213 can be held in place by way of the interconnection between the notches of the pivot pin interface 213 and the projections of the attachment interface 312. Moreover, the arm 214 can be fixedly coupled to the attachment interface 312. For example, a bracket can be fixedly or removably coupled to the projections, over the arm 214 of the pivot pin interface 213, to prevent the pivot pin interface 213 from moving laterally outward from the rear pivot 311. The bracket can be fixed to the projections via bolts, rivets, or welding as non-limiting examples.

[0043] The bottom 35 of the dump body 30 can include the plurality of flat contact surfaces 301, such as shown in FIG. 9. The flat contact surfaces 301 may be in the form of a plate, such as a rectangular or square plate, though embodiments of the disclosed subject matter are not limited to the foregoing geometries. Optionally, the flat contact surfaces 301 can have a chamfered portion on a bottom edge thereof.

[0044] The flat contact surfaces 301 can be provided generally at a middle portion of the dump body 30. In a top plan view of the dump body 30, the pair of flat contact surfaces 301 can be between the rear pivot support 310 and the pair of vertical support structures 370 in the length direction of the dump body 30. Additionally, the flat contact surfaces 301 can be provided on corresponding longitudinal support body members 377. For instance, the flat contact surfaces 301 can be provided on inward-facing surfaces of the longitudinal support body members 377. Thus, in embodiments of the disclosed subject matter, the flat contact surfaces 301 can be vertically-oriented, such as shown in FIG. 9. Moreover, the flat contact surface 301 on one longitudinal support body member 377 can be spaced apart from the flat contact surface 301 on the opposing longitudinal support body member 377 in the width direction of the dump body 30. The flat contact surfaces 301 can be coupled to the longitudinal support body members 377, for instance, by welding, rivets, or bolts, as non-limiting examples.

[0045] According to one or more embodiments, each flat contact surface 301 can be comprised of a first flat contact surface portion and a second flat contact surface portion spaced from the first flat contact surface portion in the length direction of the dump body 30, such as shown in FIG. 9. Optionally, the first and second flat contact surface portions of the flat contact surface 301 may be of the same configuration. Of course, each flat contact surface 301, according to one or more embodiments of the disclosed subject matter, may be represented by a single flat contact surface (e.g., a single plate). For example, only one of the first or second flat contact surface portions shown in FIG. 9 may constitute the flat contact surface 301.

[0046] Discussed in more detail below, when the dump body 30 is in a lowered position (i.e., rest position), the flat contact surfaces 301 attached to the dump body 30 can be positioned as shown in FIG. 9. That is, the flat contact surfaces 301 can be provided adjacent to outer or lateral sides of the outer elongate support members 201. According

to one or more embodiments, the flat contact surfaces 301 can be parallel to the outer elongate support members 201. [0047] The vertical support structures 370 of the dump body 30 can extend from a front face of front wall 37 of the dump body 30. The vertical support structures 370 can be fixed to the front face of the front wall 37, for instance, via welding. The vertical support structures 370 can be spaced apart from each other in the width direction of the dump body 30. According to one or more embodiments, the vertical support structures 370 can be centered on opposite sides of a vertical centerline of the dump body 30 in a front view of the machine 10, such as shown in FIG. 2. The vertical support structures 370 can be as set forth in U.S. application Ser. No. 16/663,825 filed Oct. 25, 2019 (Case 19-0770), which is incorporated herein by reference in its entirety.

[0048] Vertical support structures 370 can be vertical in at least the front view of the dump body 30. Depending upon the configuration of the front wall 37 of the dump body 30, in a side view of the dump body 30 the vertical support structures 370 may be generally vertical, for instance, at an angle 10 degrees or less from vertical.

[0049] According to one or more embodiments, the vertical support structures 370 can extend through a horizontal support structure 375, which can also be fixed (e.g., welded) to the front face of the front wall 37. Intersecting surfaces of the horizontal support structure 375 and each vertical support structure 370 can be fixedly attached via welding, for instance.

[0050] Each vertical support structure 370 can have a down-facing contact surface 371. According to one or more embodiments, the down-facing contact surface 371 can be convex, for instance, semi-cylindrical, elliptical, or multi-planar. The down-facing contact surfaces 371 can be configured to be received or seated in the upward-facing contact surfaces 275 of the support rockers 274. Unlike the support rockers 274, the vertical support structures 370, themselves, do not pivot.

INDUSTRIAL APPLICABILITY

[0051] As noted above, embodiments of the present disclosure relate to space frame center upper frame nodal connections, and systems, components, and methods thereof.

[0052] Embodiments of the disclosed subject matter can provide a lightweight, durable machine configuration with a reliable support definition of load points between the dump body 30 and the space frame 20, for instance, in light of dimensional variations due to tolerances and/or component deflection.

[0053] In terms of components of the space frame 20, the space frame 20 can include a pair of the center upper frame nodal connections 240. Each center upper frame nodal connection 240, which may be a fabrication, can be coupled between the center upper frame connection 230, the front upper frame connection 250, and the front upper frame connection 270. The center upper frame nodal connection 240 can include a top surface 2402, a bottom surface 2403 opposite the top surface 2402, two side surfaces 2407, a front surface 2405, and a rear surface 2406. The top surface 2402, the bottom surface 2403, and the two side surfaces 2407 can be fixedly attached (e.g., welded) to each other and the front and rear surfaces 2405, 2406 to create a structure, such as a box. A plurality of the elongate support members

207 can be fixedly coupled (e.g., welded) to the front surface 2405, particularly integral planes thereof. The rear surface 2406 can be fixedly coupled (e.g., welded) to the center upper frame connection 230.

[0054] According to embodiments of the disclosed subject matter, the dump body 30 can operatively contact the space frame 20 according to a predetermined contact arrangement. For example, embodiments of the disclosed subject matter can provide for a six-point contact arrangement between the dump body 30 and the space frame 20. According to embodiments of the disclosed subject matter, such contact arrangement can be provided when the dump body 30 is in a rest position. Rest position as used herein can mean that the dump body 30 is in a lower-most or fully down position and not raised by the lift cylinders 125, which may be coupled to the center lower frame connections 220.

[0055] Referring to FIG. 9, which shows an exploded view of the space frame 20 and the dump body 30 of the machine 10, a first pair of contact points can be provided by the rear supports 211 of the space frame 20 and the rear pivots 311 of the rear pivot supports 310 of the dump body 30. Each rear support 211 can be pivotally connected to the dump body 30 via the rear pivot 311. Such connection can allow the front portion 36 of the dump body 30 to be raised and lowered between upper-most and lower-most positions via rotation about the common pivot axis created by the connection between the rear supports 211 and the rear pivots 311.

[0056] A second pair of contact points can be provided by the positioning of the flat contact surfaces 301 relative to the elongate support members 201. In particular, the flat contact surfaces 301, which notably can be on or part of the dump body 30 and not the space frame 20, can be provided adjacent to outer or lateral sides of the elongate support members 201, such as shown in FIG. 9. As noted above, the flat contact surfaces 301 may be positioned parallel to the elongate support members 201. Additionally, according to one or more embodiments of the disclosed subject matter, the flat contact surfaces 301 can contact the elongate support members 201. Such positioning of the flat contact surfaces 301 can be when the dump body 30 is in the lower-most or rest position. Moreover, such positioning of the flat contact surfaces 301 can accommodate for lateral or horizontal forces from the corresponding the elongate support members 201 of the space frame 20. Additionally, as noted above, the flat contact surfaces 301 may have a chamfered portion on a bottom edge thereof. Such chamfered portion can aid in the centering of the dump body 30 when the dump body 30 is transitioned to the rest or fully down position.

[0057] A third pair of contact points can be provided by the positioning of the vertical support structures 370, particularly the down-facing contact surfaces 371 thereof, removably on the support rockers 274, particularly the upward-facing contact surfaces 275 thereof. According to embodiments of the disclosed subject matter, the down-facing contact surface 371 can be removably seated on the upward-facing contact surface 275. Additionally, in a front view of the machine 10 a vertical centerline axis of the down-facing contact surface 371 of each of the vertical support structures 270 can be offset from the axis of rotation (i.e., pivot axis) of a corresponding one of the support rockers 274. For example, as shown in FIG. 2, the vertical centerline axis of the down-facing contact surface 371 can

be offset inward in a width direction of the machine 10 relative to the axis of rotation for the support rocker 274.

[0058] The vertical support structures 370, particularly the down-facing contact surfaces 371 when contacting the upward-facing contact surfaces 275 of the support rockers 274, can transfer loading through the space frame 20 to the front suspension system and the front wheels 14. Moreover, the vertical support structures 370 can provide support for horizontal components of force vectors with respect to the dump body 30 load being transferred through the space frame 20 and the front suspension system to the front wheels 14. Additionally, because the support rockers 274 can pivot laterally and independently of each other, and because both the support rockers 274 and the vertical support structures 371 have cooperating contact surfaces (i.e., upward-facing contact surfaces 275 and down-facing contact surfaces 371, respectively), proper seating between the vertical support structures 371 and the support rockers 274 can be maintained, particularly when the dump body 30 is in the at-rest position, even when the machine 10 is moving, for instance. Such arrangement, as diagrammatically shown in FIG. 2, can thus provide an even load distribution LD with respect to each side of the support arrangement (i.e., side to side or laterally).

[0059] Additionally shown in FIG. 2, in a front view the support rocker 274/support vertical structure 270 combinations can be located along longitudinal axes of respective front struts 121 connected to respective front suspension members 120 on same sides of the space frame 20. For example, the pivot axis of the support rocker 274 may be aligned with a longitudinal axis a corresponding front strut 121. The longitudinal axes can intersect at a point CL_1 at a vertical centerline at a top of the dump body 30. Of course, embodiments of the disclosed subject matter are not so limited, and the longitudinal axis of the front strut 121 may not be aligned with the support rocker 271/support structure 270 combination, such as the pivot axis of the support rocker 274. Also shown in FIG. 2, longitudinal axes of additional suspension members on opposite sides of the space frame 20 can intersect at a point CL_2 at the same vertical centerline of the machine 10 as point CL_1 . The arrangement of the third pair of contact points, therefore, can uniformly transfer load from the dump body 30 through the support rockers 274 and the space frame 20 to the front suspension system.

[0060] While aspects of the present disclosure have been particularly shown and described with reference to the embodiments above, it will be understood by those skilled in the art that various additional embodiments may be contemplated by the modification of the disclosed machines, assemblies, systems, and methods without departing from the spirit and scope of what is disclosed. Such embodiments should be understood to fall within the scope of the present disclosure as determined based upon the claims and any equivalents thereof.

1. A space frame for an off-highway rear haul truck comprising:

a first center upper frame nodal connection fabrication; and

a second center upper frame nodal connection fabrication spaced from the first center upper frame nodal connection fabrication in a width direction of the space frame, wherein each of the first and second center upper frame nodal connection fabrications includes:

a top surface,

a bottom surface opposite the top surface,

two side surfaces,

a front surface having three integral planes oriented at obtuse angles relative to each other, wherein each of the three integral planes is configured to weldably attach a respective frame tube perpendicular thereto, and

a rear surface opposite the front surface configured to weldably attach a center upper frame connection casting,

wherein the top surface, the bottom surface, and the two side surfaces are weldably attached to each other and the front and rear surfaces to create a box structure.

2. The space frame according to claim 1, wherein the three integral planes of the first and second center upper frame nodal connection fabrications face upward and the rear surfaces face downward.

3. The space frame according to claim 1, wherein, in a side view of the space frame, the three integral planes of each of the first and second center upper frame nodal connection fabrications face at a positive acute angle relative to horizontal.

4. The space frame according to claim 1, wherein the rear surface is parallel to a middle integral plane of the three integral planes of the front surface.

5. The space frame according to claim 1, wherein the front surface is wider than the rear surface.

6. The space frame according to claim 1, wherein the side surfaces are recessed from side edges of the top and bottom surfaces.

7. The space frame according to claim 1, wherein opposite ends of the front surface extend past side edges of the top and bottom surfaces.

8. A center upper frame nodal connection fabrication comprising:

a top surface;

a bottom surface opposite the top surface;

two side surfaces;

a front surface having three integral planes oriented at obtuse angles relative to each other, wherein the three integral planes are configured to weldably attach to respective elongate support members of a space frame; and

a rear surface opposite the front surface configured to weldably attach to a center upper frame connection casting of the space frame,

wherein the top surface, the bottom surface, and the two side surfaces are weldably attached to each other and the front and rear surfaces.

9. The center upper frame nodal connection fabrication according to claim 8, wherein the three integral planes are configured to face upward when provided in the space frame.

10. The center upper frame nodal connection fabrication according to claim 8, wherein, in a side view the three integral planes are configured to face at a positive acute angle relative to horizontal when provided in the space frame.

11. The center upper frame nodal connection fabrication according to claim 8, wherein the rear surface is parallel to a middle integral plane of the three integral planes of the front surface.

12. The center upper frame nodal connection fabrication according to claim **8**, wherein the front surface is wider than the rear surface.

13. The center upper frame nodal connection fabrication according to claim **8**, wherein the side surfaces are recessed from side edges of the top and bottom surfaces.

14. The center upper frame nodal connection fabrication according to claim **8**, wherein opposite ends of the front surface extend past side edges of the top and bottom surfaces.

15. The center upper frame nodal connection fabrication according to claim **8**, wherein each of the three integral planes of the front surface is configured to weldably attach the respective elongate support member thereto such that a longitudinal axis of the respective elongate support member is perpendicular to the corresponding integral plane.

16. A method comprising:

providing a top surface of a center upper frame nodal connection fabrication;

providing a bottom surface of the center upper frame nodal connection fabrication opposite the top surface;

providing two side surfaces of the center upper frame nodal connection fabrication;

providing a front surface of the center upper frame nodal connection fabrication, the front surface having three integral planes oriented at obtuse angles relative to each

other, wherein the three integral planes are configured to weldably attach to respective frame tubes of a space frame; and

providing a rear surface of the center upper frame nodal connection fabrication, the rear surface being configured to weldably attach to a center upper frame connection casting of the space frame,

wherein the top surface, the bottom surface, and the two side surfaces are weldably attached to each other and the front and rear surfaces.

17. The method according to claim **16**, further comprising welding the top surface, the bottom surface, and the two side surfaces to each other and the front and rear surfaces to create a box structure, the box structure having a fan shape in a top plan view of the center upper frame nodal connection fabrication.

18. The method according to claim **16**, further comprising welding the frame tubes to the front surface.

19. The method according to claim **18**, wherein said welding is such that respective longitudinal axes of the frame tubes are perpendicular to corresponding ones of the three integral planes of the front face.

20. The method according to claim **16**, further comprising welding the rear surface to the center upper frame connection casting.

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