



Harsco Track Technologies

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SERVICE BULLETIN MAINTENANCE OF WAY EQUIPMENT

DATE: 8-1-2001 **BULLETIN NO:** 01-007

TITLE: 2004316 RETURN LINE MANIFOLD SERVICE GROUP

RATING:

<input type="checkbox"/>	ALERT (Potential Problem)	<input checked="" type="checkbox"/>	INFORMATION (Action Is Optional)
<input type="checkbox"/>	DIRECTIVE (Action Is Required)	<input type="checkbox"/>	PRODUCT IMPROVEMENT (Enhance Product)

PRODUCT SERIES / MODEL: 6700S TAMPERS

SERIAL NO: Models 151871 and Higher

SUMMARY: The two screws that hold the return line manifold to the frame of the machine have broken on occasion due to hydraulic impulses in the return line. This Service Group adds two additional mounting screws to the manifold.

OPERATIONAL IMPACT: To eliminate the possible breakage of the mounting screws on the return line manifold.

ACTION: The installation of this Service Group requires:

- Removing the existing return line manifold.
- Reworking the existing return line manifold by drilling two additional mounting holes.
- Welding a new mounting bracket onto the machine frame.
- Re-installing the re-worked return line manifold on the new mounting bracket.

CONTACT: If you have any questions or if we can be of any service, please contact Bill Perry at the Ludington, MI. facility, (231) 843-7416.

SAFETY INFORMATION

- **FOLLOW APPLICABLE RAILROAD LOCKOUT - TAGOUT PROCEDURE TO REMOVE MACHINE FROM ENERGY SOURCE. FAILURE TO COMPLY COULD RESULT IN SEVERE BODILY INJURY.**

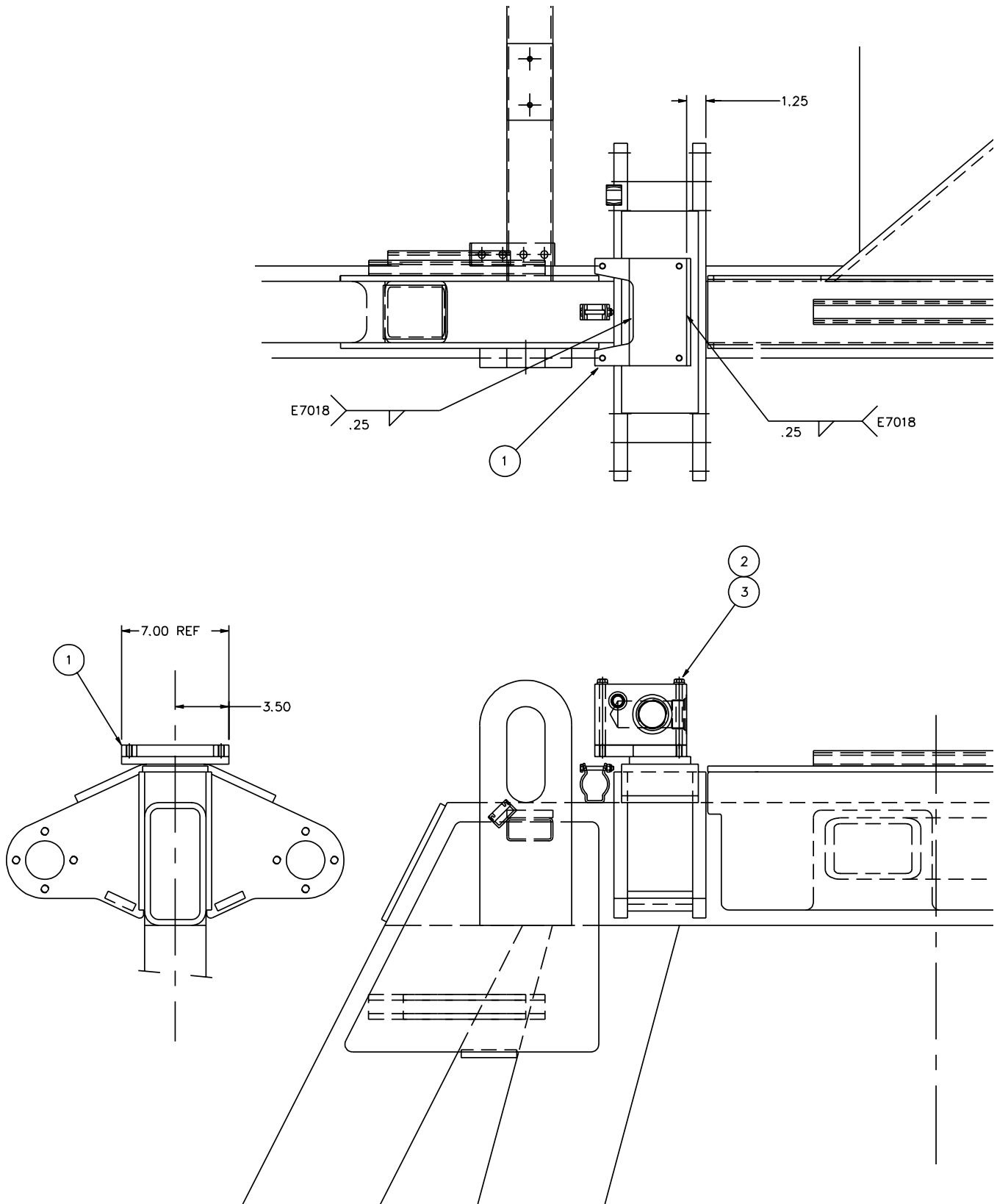
SERVICE GROUP INSTALLATION - See Figure 1

1. Locate the return line manifold mounted on the top right side of the truss on the machine.
2. **Important:** Before disconnecting or removing any fittings from the return line manifold, be sure to mark all hydraulic lines and fittings for proper re-assembly.
3. Disconnect all hydraulic lines from the existing return line manifold. Remove the existing return line manifold from the machine. Remove all hydraulic fittings from the manifold.
4. Rework the existing return line manifold by drilling two 13/32" diameter holes in the manifold per the dimensions shown in Figure 2. Clean the manifold thoroughly of all debris.
5. **Important:** Before welding on the machine:
 - 5.1 Shut off the battery disconnect switch.
 - 5.2 Disconnect all electrical wires from the alternator.
 - 5.3 If the machine has the Auto Curve Computer, disconnect cable #15.
 - 5.4 If the machine has the Auto Workhead Computer, disconnect cable #14.
 - 5.5 Disconnect cables #12 and #13 going to the module panels.
6. Weld the new mounting plate (1) onto the machine frame per the dimensions and weld symbols as shown.
7. Re-install all hydraulic fittings in the reworked return line manifold. Tighten all fittings securely.
8. Install the reworked return line manifold to the new mounting bracket (1) using four 3/8"-16 x 4-1/2" long hex head cap screws (2) and four 3/8" lock washers (3). Tighten all cap screws securely.
9. Reconnect all hydraulic lines to the hydraulic fittings in the reworked return line manifold. Tighten all hydraulic connections securely.
10. Reconnect all wires and cables that were disconnected in Step 5.
11. Start the engine and pressurize the hydraulic system.
12. Check the reworked return line manifold and all hydraulic fittings and hose connections for hydraulic leaks.

SERVICE GROUP INSTALLATION

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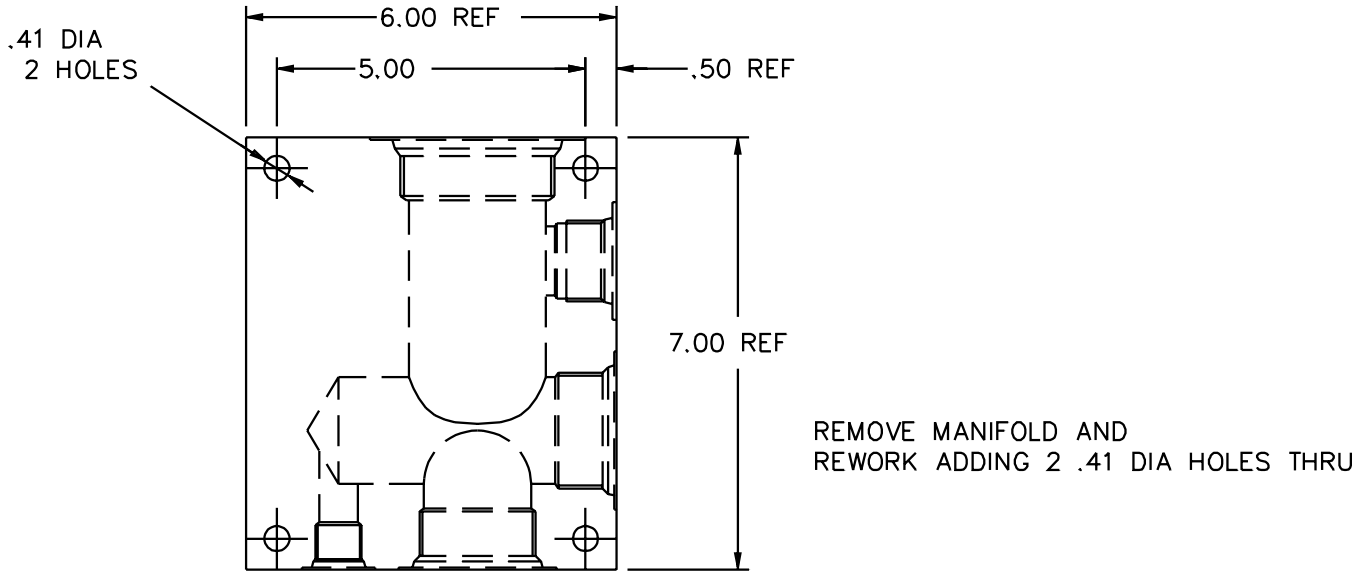
FIGURE 1



SERVICE GROUP INSTALLATION

1003841-2

**FIGURE 2
RETURN LINE MANIFOLD RE-WORK**



SERVICE GROUP PARTS LIST - See Figure 1

ITEM	PART NO	DESCRIPTION	QTY
	2004316	RETURN LINE MANIFOLD SERVICE GROUP	1
1	2004297	Mounting Bracket	1
2	250010-118	Screw - Hex Head Cap, 3/8"-16 x 4-1/2" Long	4
3	150988-11	Washer - Lock, 3/8"	4
	2004316-DWG	Drawing / Bill of Material	1

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