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SERVICE BULLETIN

MAINTENANCE OF WAY EQUIPMENT

DATE: 9-2018

BULLETIN NO: 18-007

TITLE: Drive Axle Mounting Bracket Welding

RATING:

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

PRODUCT SERIES / MODEL: 6700, MARK IV and Drone Tampers

SERIAL NO: N/A

SUMMARY: The Right Hand and Left Hand drive axle mounting brackets have tabs in the axle cradle area that are to be welded when they are fitted to the chassis prior to installation of the drive axle assembly. The mounting brackets that are shipped directly to the customer as part of a service kit have tabs that are only tack welded in place during the manufacturing process. The Tack weld allows the customer to reposition tabs as needed to ensure a proper fit with the axle. After the axle is properly fitted, the tabs must be fully welded by the customer as shown in this Service Bulletin. Assemblies sent as rebuild kits and services parts are affected. The units installed in HarSCO manufacturing facilities are welded completely.

OPERATIONAL IMPACT: Tabs which are not welded can break off after the installation of drive axle assembly and can cause improper seating of the axle within the cradle. This could result to dangerous operating conditions.

ACTION: Inspect the machines listed above that are in your fleet and rebuild kits in your inventory to verify a permanent weld of the tabs. This can be done by visual inspection on the outside and inside of the machine at the drive axle assembly.

CONTACT: HarSCO Rail Service Department
Ludington, MI Facility
(231) 843-4830

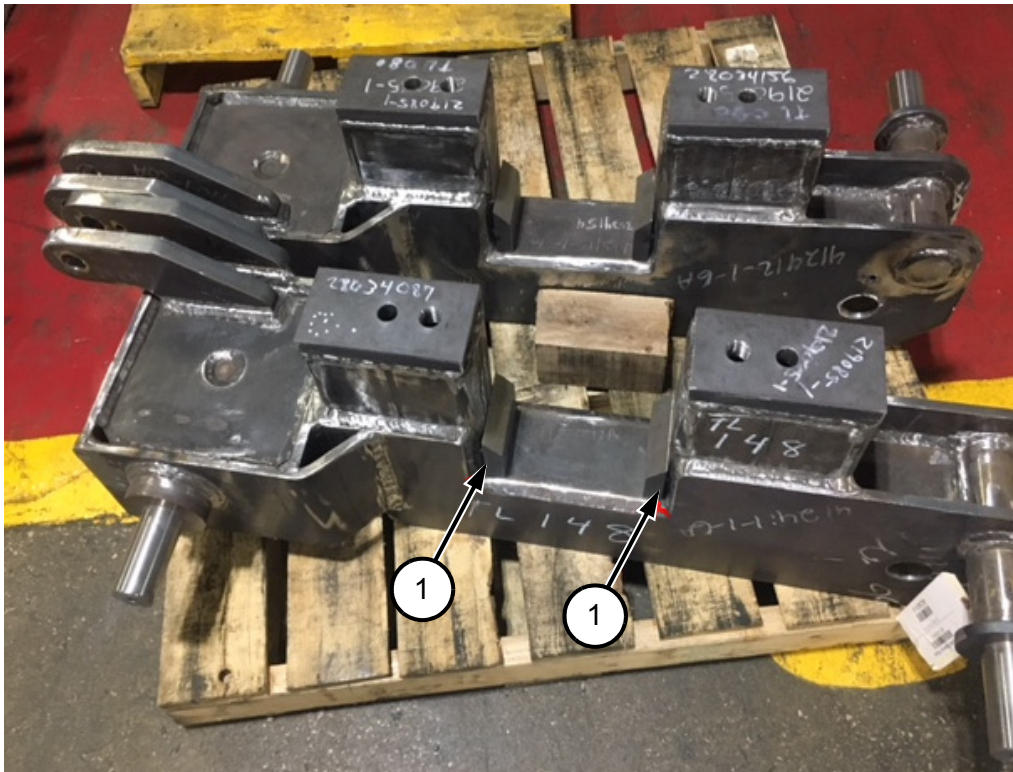
Safety Information

- FOLLOW APPLICABLE RAILROAD LOCKOUT - TAGOUT PROCEDURES AND MACHINE ENERGY CONTROL PROCEDURE TO DISABLE ENERGY SOURCES WHEN PERFORMING MAINTENANCE, MAKING ADJUSTMENTS OR REPAIRS TO THE MACHINE. FAILURE TO HEED THIS WARNING COULD RESULT IN SEVERE BODILY INJURY.

Drive Axle Mounting Bracket Inspection and Welding Instructions - See Figures 1, 2 and 3

1. Customers need to review purchase history and inventory of the assemblies to determine if tabs (1) are fully welded or just tack welded. If the assembly is on a machine, the tabs must be fully welded. If the assemblies are in you inventory, the tabs must be fully welded when they are installed on the machine. Harsco will provide a list of each sales order and delivery date for each unit sold as well as detailed shipping information upon request.

FIGURE 1
UNWELDED ASSEMBLIES



Drive Axle Mounting Bracket Inspection and Welding Instructions (Contd...)

- 2. Weld tabs (1) on the drive axle mounting brackets installed on the machine per details shown in Figure 2 and 3.

FIGURE 2
WELD DETAIL

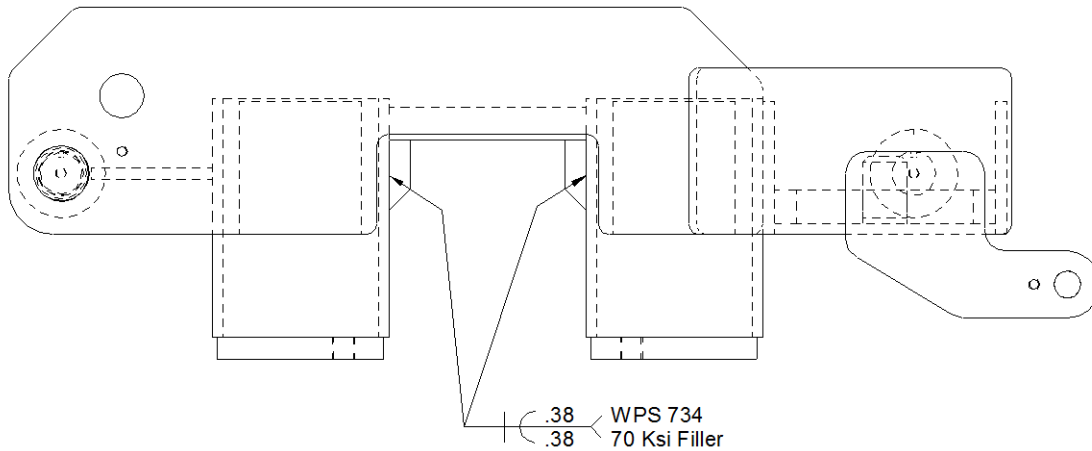
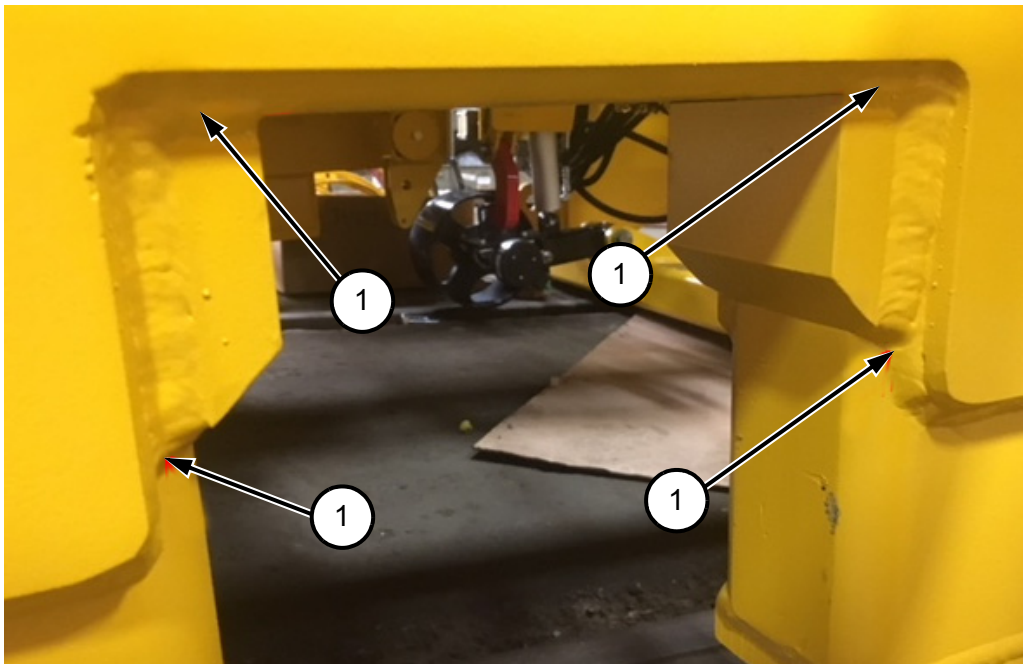


FIGURE 3
WELDED ASSEMBLIES



Notes:

- 1. For the rebuild process the customer should either have a fixture made or have these welded in place once the rear drive is installed to ensure correct alignment.
- 2. Axles can be used as a fixture.

List of Assemblies Affected

6700 Tampers

PART NO	DESCRIPTION	QTY
412411-1	Mounting Bracket Right Hand Drive Axle	1
412412-1	Mounting Bracket Left Hand Drive Axle	1

Drone Tampers

PART NO	DESCRIPTION	QTY
2019394	Mounting Bracket Left Hand Drive Axle	1
2019386	Mounting Bracket Right Hand Drive Axle	1

Mark IV Tampers

PART NO	DESCRIPTION	QTY
5005043	Mounting Bracket Right Hand Drive Axle	1
5005044	Mounting Bracket Left Hand Drive Axle	1

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