



# Harsco Track Technologies

Harsco

www.harscotrack.com

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## SERVICE BULLETIN MAINTENANCE OF WAY EQUIPMENT

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**DATE:** 11-28-2007 **BULLETIN NO:** 07-016

**TITLE:** HOSE CLAMP CONVERSION GROUPS

**RATING:**

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

**PRODUCT SERIES / MODEL:** 6700 TAMPERS

**SERIAL NO:** All Models

**SUMMARY:** Some machines are experiencing hose clamp failure on the two Workhead Manifold return hoses. Depending upon the model year, there are two conversion groups available consisting of heavy duty weld-on clamps to resolve this issue.

**OPERATIONAL IMPACT:** Current clamps may fail allowing the hoses to chafe or wear causing potential hydraulic leaks.

**ACTION:** Inspect the Workhead Manifold return hoses for hose clamp failure. If failure is found, determine the return hose size. Conversion Group #2013181 is for machines that were manufactured in 2007 using #20 hoses. Conversion Group #2013219 is for machines that were manufactured in 2006 and prior using #16 hoses. Before ordering a conversion group, confirm the size of hoses used on the machine. Follow the Instructions in this Service Bulletin to install the new hose clamps.

**CONTACT:** If you have any questions or if we can be of any service, please contact Mark Scott at the Ludington, MI facility.  
phone: 231-843-3431  
e-mail: mscott@harscotrack.com.

**SAFETY INFORMATION**

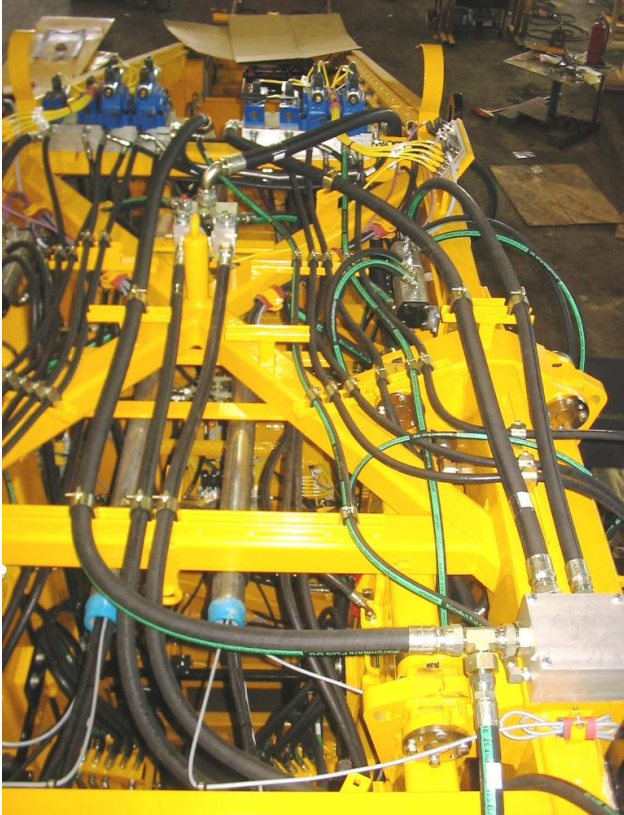
- n FOLLOW APPLICABLE RAILROAD LOCKOUT - TAGOUT PROCEDURE TO REMOVE MACHINE FROM ENERGY SOURCES. FAILURE TO COMPLY COULD RESULT IN SEVERE BODILY INJURY.**

**CONVERSION GROUP INSTALLATION**

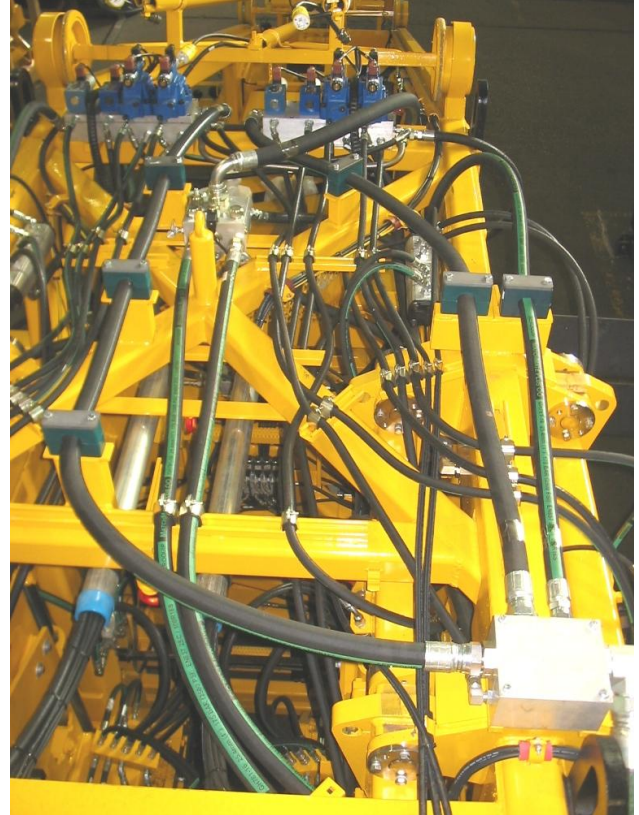
1. Determine the applicable drawing that is to be used for installation by the hose size of the Workhead Manifold return hoses.
  - a. Conversion Group #2013181 is for machines that were manufactured in 2007 using #20 hoses. See Drawing #2013181 Sheets 1 thru 3 and Figures 1 and 2 for installation.
  - b. Conversion Group #2013219 is for machines that were manufactured in 2006 and prior using #16 hoses. See Drawing #2013219 Sheets 1 thru 3 and Figure 3 for installation.
2. Remove the existing hose clamps and secure the hoses out of the area to be reworked.
3. Remove the existing mounting brackets from the machine that are specified on the applicable conversion drawing.
4. Weld the new clamps and mounting brackets on the machine in the locations specified on the applicable conversion drawing.
5. After welding, wire brush and clean all welds. Then prime and paint all welds and the new mounting brackets to prevent rust.
6. Install and secure the existing hoses in the new clamps.
7. Start the engine and pressurize the hydraulic system.
8. Check all hydraulic hose and fitting connections for leaks. Use a piece of cardboard or wood when checking for hydraulic leaks. **DO NOT USE YOUR BARE HANDS.**

**CONVERSION GROUP INSTALLATION**

**FIGURE 1  
#20 HOSES BEFORE CONVERSION**



**FIGURE 2  
#20 HOSES AFTER CONVERSION**



**FIGURE 3  
#16 HOSES BEFORE CONVERSION**



**#2013181 CONVERSION GROUP PARTS LIST** - See Drawing #2013181 Sheets 1 thru 3  
 (for machines manufactured in 2007 using #20 hoses)

ITEM	PART NO	DESCRIPTION	QTY
1	2013179	STAUFF CLAMP - HV DUTY WELD-ON (1.38 ID) .....	1
2	2013180	STAUFF CLAMP - HV DUTY WELD-ON (1.66 ID) .....	5
3	91052-036M	RECT TUBE 4.00 X 2.00 X 11.00 LG .....	1
4	91052-036M	RECT TUBE 4.00 X 2.00 X 9.00 LG .....	1
5	91052-036M	RECT TUBE 4.00 X 2.00 X 5.00 LG .....	1
6	91052-036M	RECT TUBE 4.00 X 2.00 X 4.50 LG .....	1
7	91007-008M	FLAT 0.50 X 2.00 X 8.00 LG .....	1
8	2013181-DWG	HARD COPY OF DRAWING / BILL OF MATERIAL .....	1

**#2013219 CONVERSION GROUP PARTS LIST** - See Drawing #2013219 Sheets 1 thru 3  
 (for machines manufactured in 2006 and prior using #16 hoses)

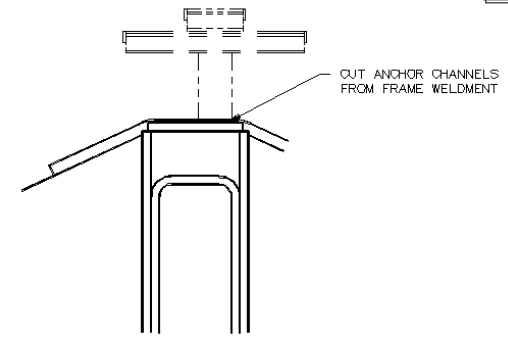
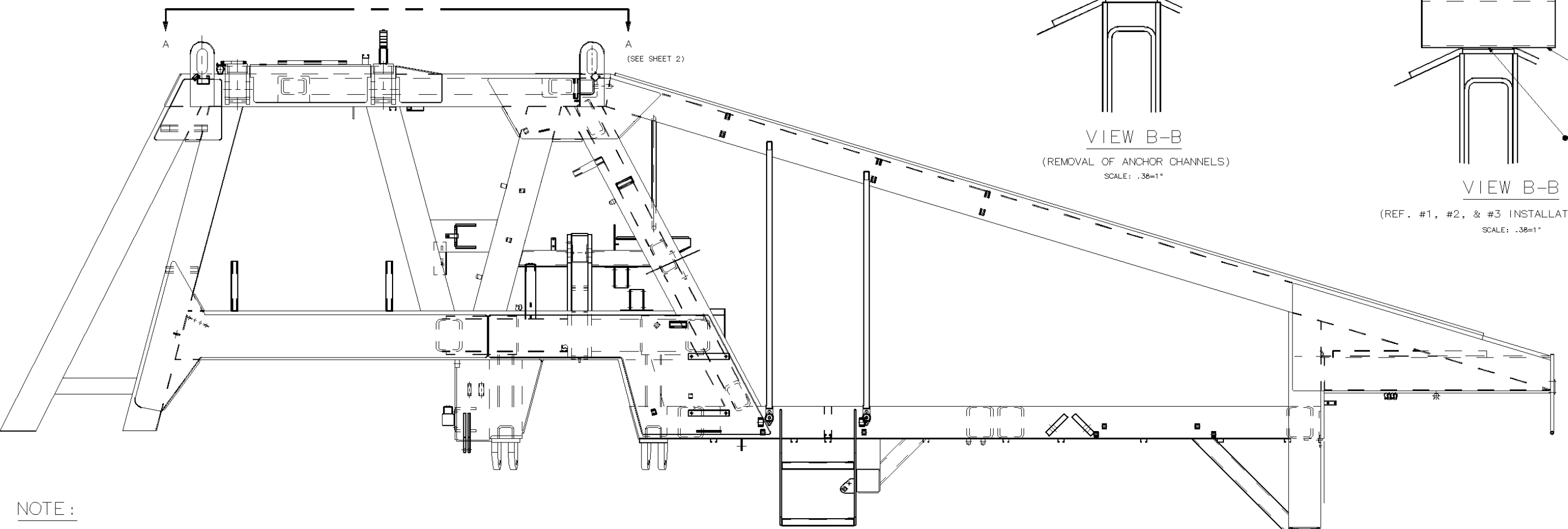
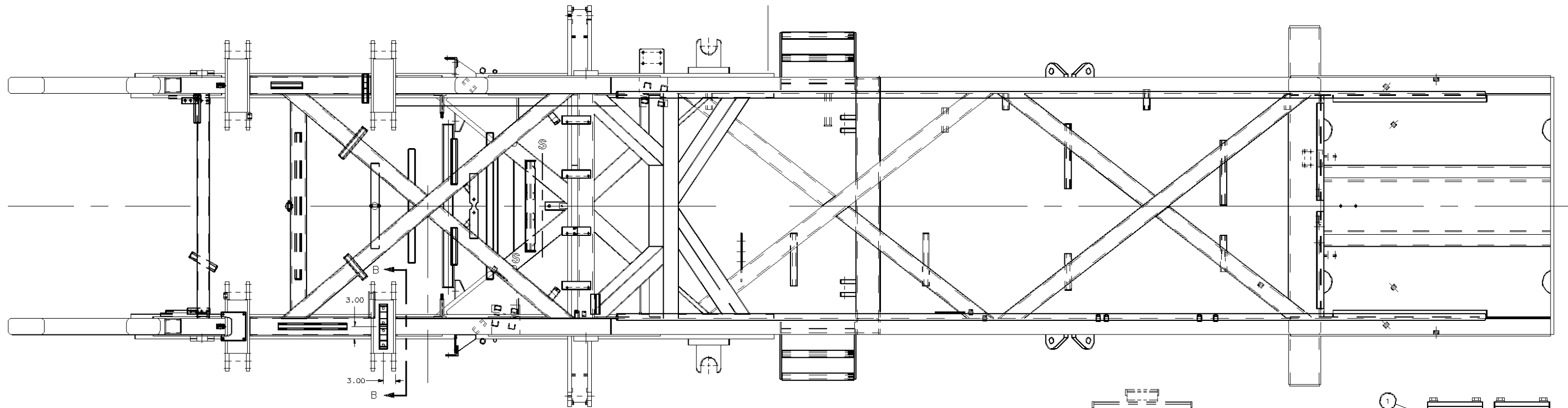
ITEM	PART NO	DESCRIPTION	QTY
1	2013179	STAUFF CLAMP - HV DUTY WELD-ON (1.38 ID) .....	5
2	91052-036M	RECT TUBE 4.00 X 2.00 X 11.00 LG .....	1
3	91052-036M	RECT TUBE 4.00 X 2.00 X 6.00 LG .....	1
4	91052-036M	RECT TUBE 4.00 X 2.00 X 4.00 LG .....	2
5	2013219-DWG	HARD COPY OF DRAWING / BILL OF MATERIAL .....	1

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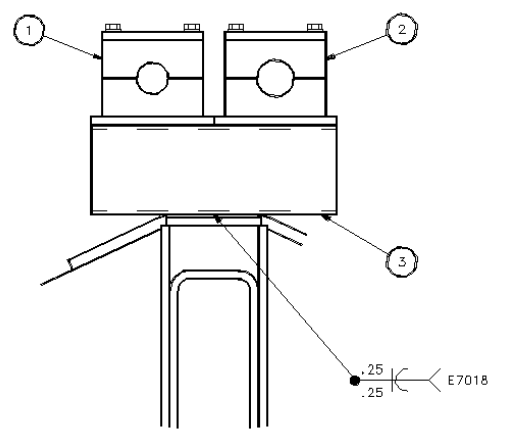
415 North Main Street  
 Fairmont, MN  
 56031-1837  
 Tel: (507) 235-3361  
 Fax: (507) 235-7370

2401 Edmund Road, Box 20  
 Cayce-West Columbia, SC  
 29171-0020  
 Tel: (803) 822-9160  
 Fax: (803) 822-7471

200 South Jackson Road  
 Ludington, MI  
 49431  
 Tel: (231) 843-3431  
 Fax: (231) 843-1644



VIEW B-B  
(REMOVAL OF ANCHOR CHANNELS)  
SCALE: .38=1"



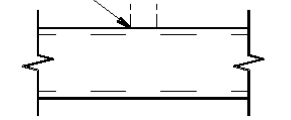
VIEW B-B  
(REF. #1, #2, & #3 INSTALLATION DETAIL)  
SCALE: .38=1"

**NOTE :**

THIS CONVERSION APPLIES TO 6700S MACHINES WITH SERIAL NUMBERS:  
153311, 153400-153403, 153412-153415, 153420, 153426-153429, 153445-153451,  
153457-153471, 153475-153496, 153500-153505, AND 153509

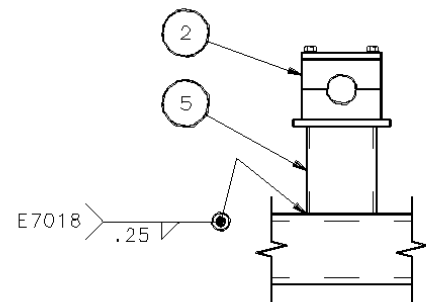
CHANGES				REVISION		DATE		BY	
1	210203089	RSC	RELEASE	21AUG03	21AUG03	CONV -	WORKHEAD RETURN HOSE CLAMP KIT	HTT	HTT
2			REWORK	17SEP03	17SEP03				
						1011243.A		Horse Track Technologies	
								Horse Track Technologies	
								Ludington, MI	
								2013181	
								1 of 3	

CUT ANCHOR CHANNEL FROM FRAME WELDMENT.



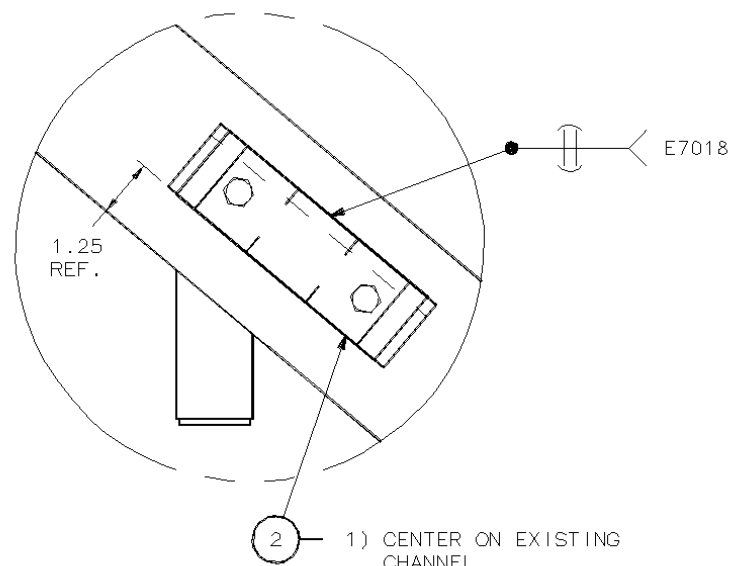
VIEW E-E

(REMOVAL OF ANCHOR CHANNEL)



VIEW E-E

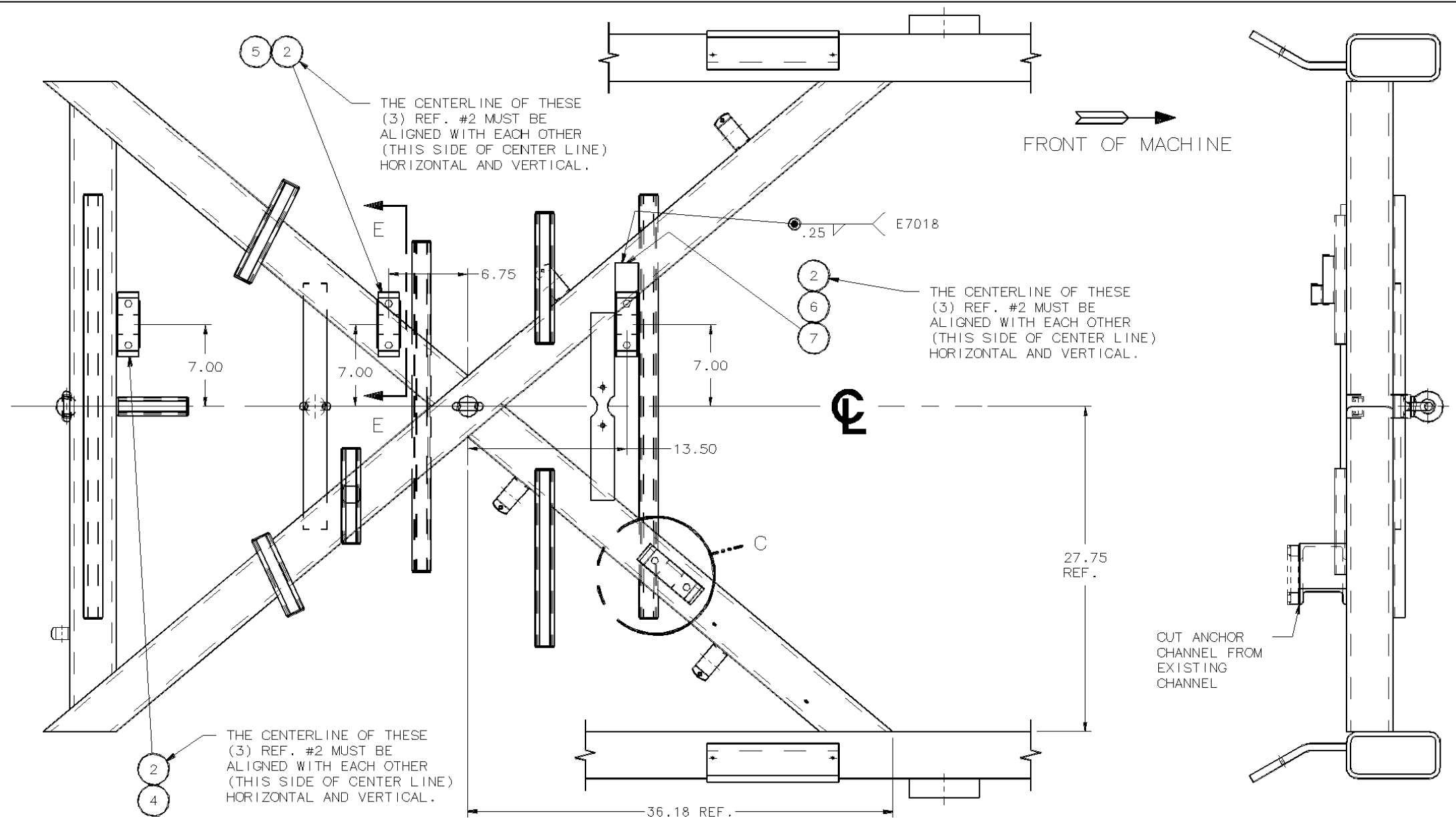
(REF. #2 AND #5 INSTALLATION)



VIEW C

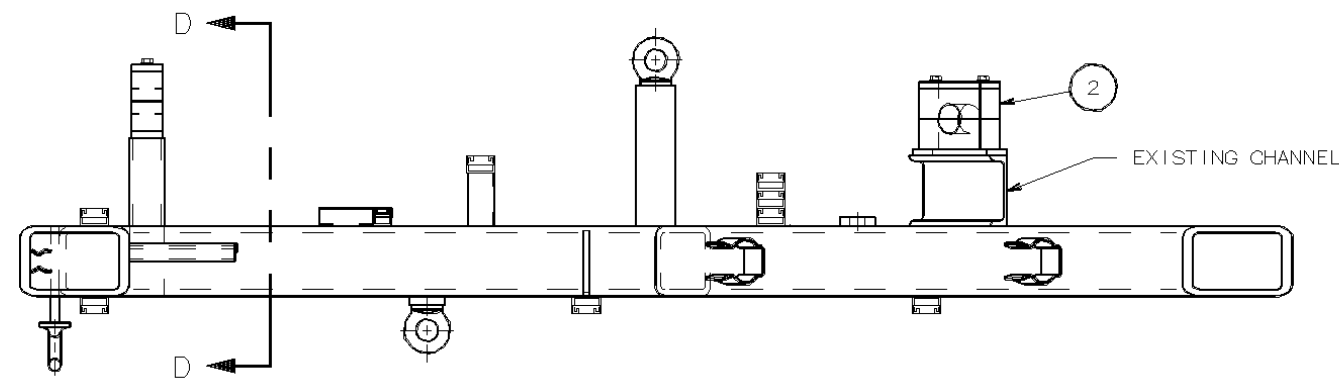
SCALE: FULL

- 1) CENTER ON EXISTING CHANNEL.
- 2) REMOVE PLASTIC MEMBERS BEFORE WELDING.



TOP VIEW OF MACHINE

VIEW A-A  
(FROM SHEET 1)



VIEW D-D

(REF. #2 AND #4 INSTALLATION)

CADAM DRAWING

CONFIDENTIAL  
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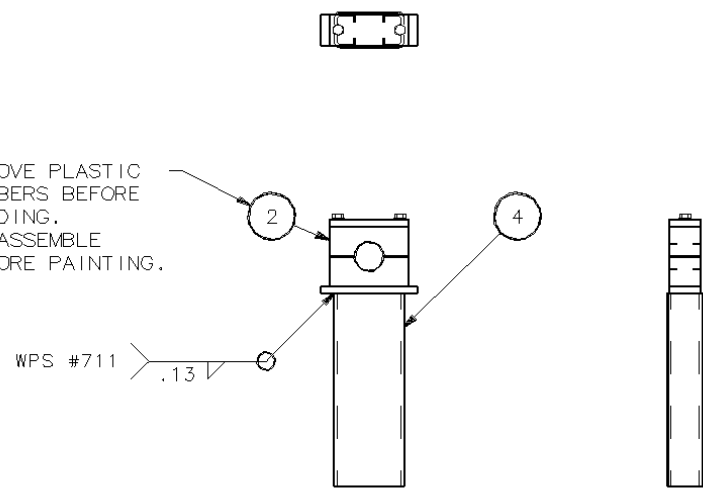
ALL DIMENSIONS ARE IN INCHES - TOLERANCE UNLESS OTHERWISE SPECIFIED		IMPLIED TOLERANCES	
OVER TO	INDICATED BY PLACE DECIMAL	OVER TO	METRIC PLUS OR MINUS
0	.03	0	.127
6	.04	150	1.0
24	.06	300	1.5

CHANGE	R/U	REVISION	DATE	Description
S10003661		RELEASE	21AUG07	CONV- WORKHEAD RETURN HOSE CLAMP KIT
RSC		REWORK	17SEP07	

Model	1011243.A	Machine Type	6700S
Weight		Drawn	COLE
Scale	1:1	Date	21AUG07

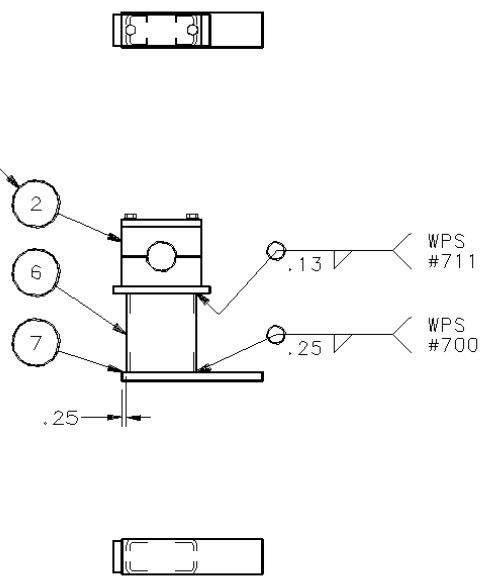
<b>HTT</b> Harsco Track Technologies	
Harsco Ludington, MI	
Part Number	2013181
Sheet	2 of 3

- 1) REMOVE PLASTIC MEMBERS BEFORE WELDING.
- 2) RE-ASSEMBLE BEFORE PAINTING.



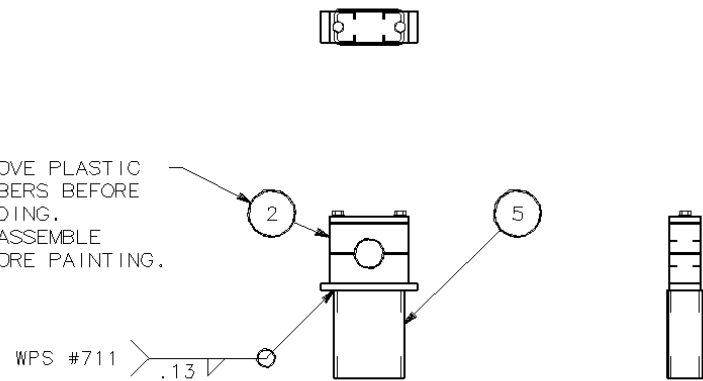
REF. #2 AND #4 SUB-ASSEMBLY

- 1) REMOVE PLASTIC MEMBERS BEFORE WELDING.
- 2) RE-ASSEMBLE BEFORE PAINTING.



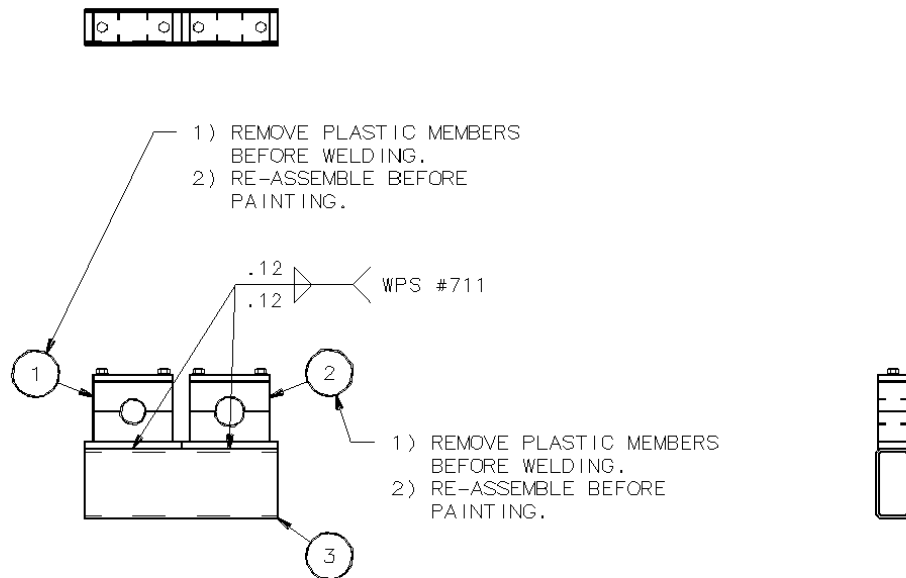
REF. #2, #6, AND #7 SUB-ASSEMBLY

- 1) REMOVE PLASTIC MEMBERS BEFORE WELDING.
- 2) RE-ASSEMBLE BEFORE PAINTING.



REF. #2 AND #5 SUB-ASSEMBLY

- 1) REMOVE PLASTIC MEMBERS BEFORE WELDING.
- 2) RE-ASSEMBLE BEFORE PAINTING.

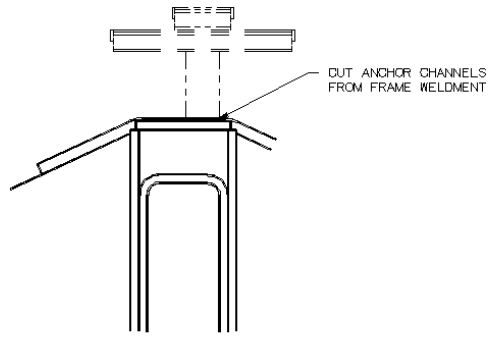
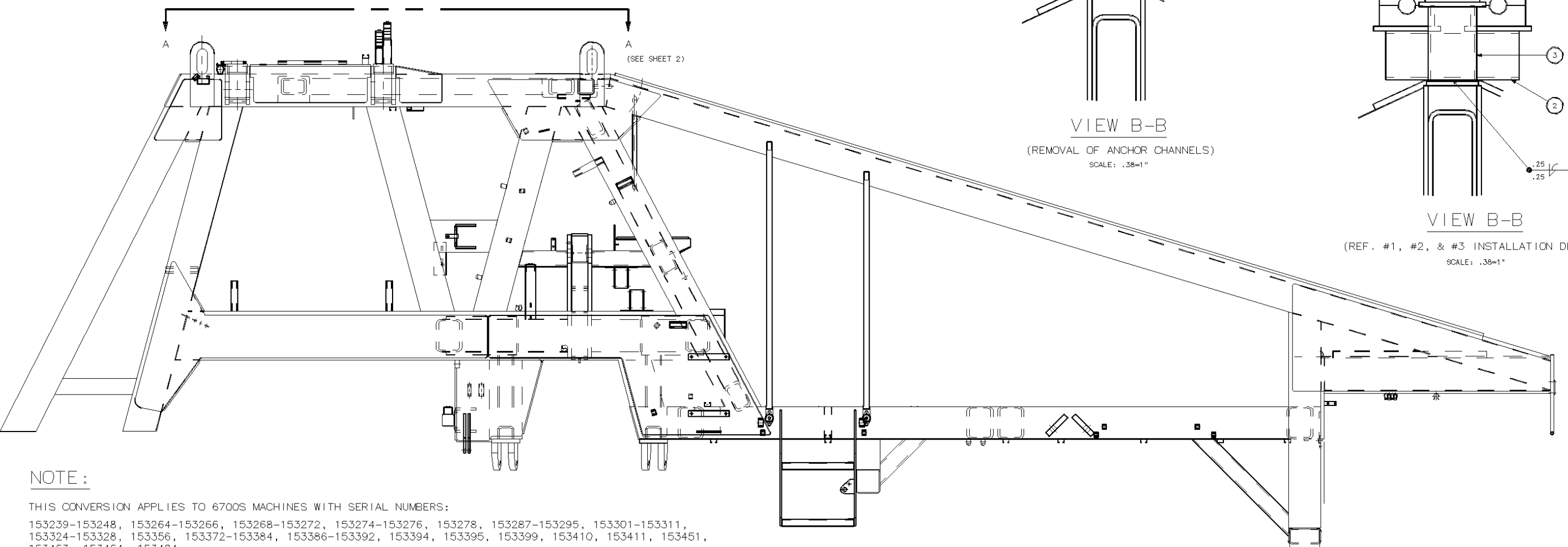
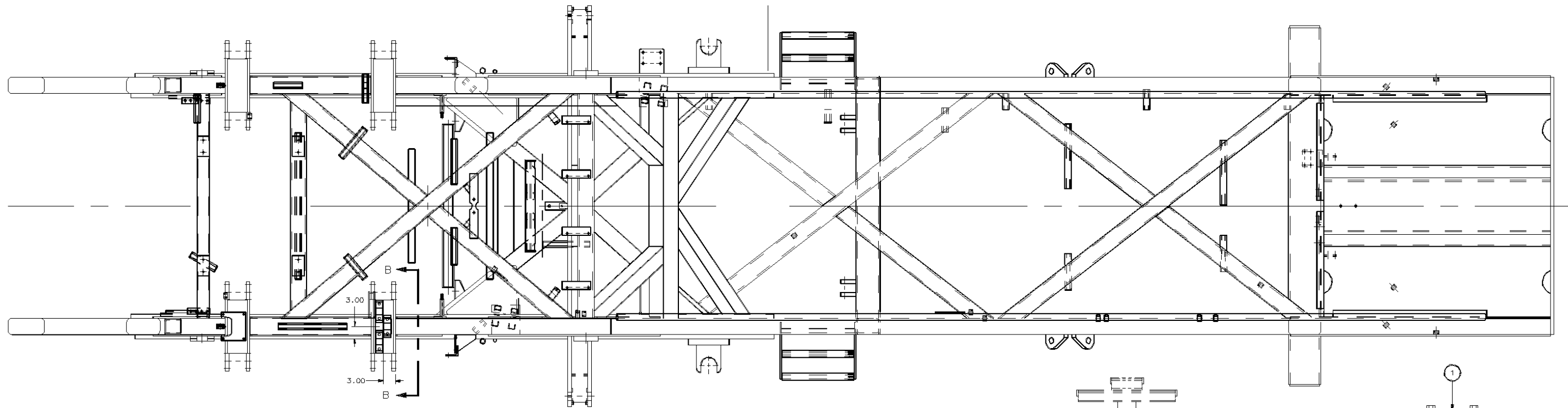


- 1) REMOVE PLASTIC MEMBERS BEFORE WELDING.
- 2) RE-ASSEMBLE BEFORE PAINTING.

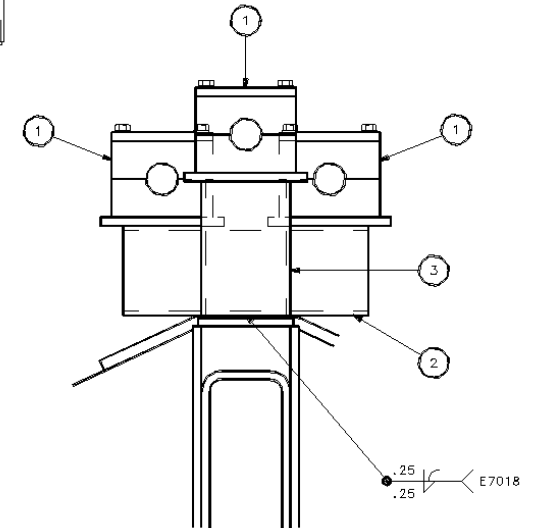
REF. #1, #2, AND #3 SUB-ASSEMBLY

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6700S	COLE	21AUG07																																																										





VIEW B-B  
(REMOVAL OF ANCHOR CHANNELS)  
SCALE: .38=1"



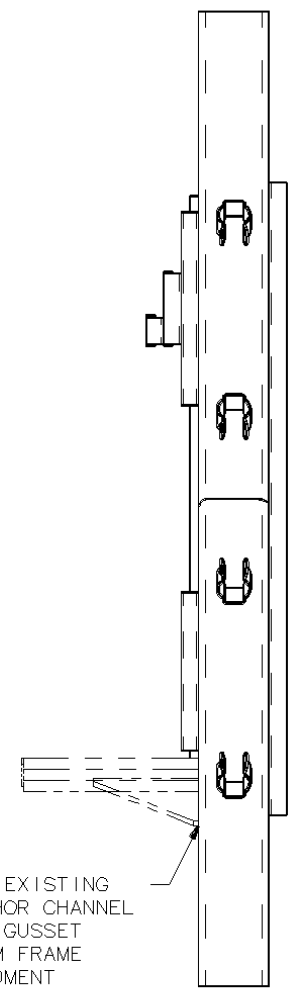
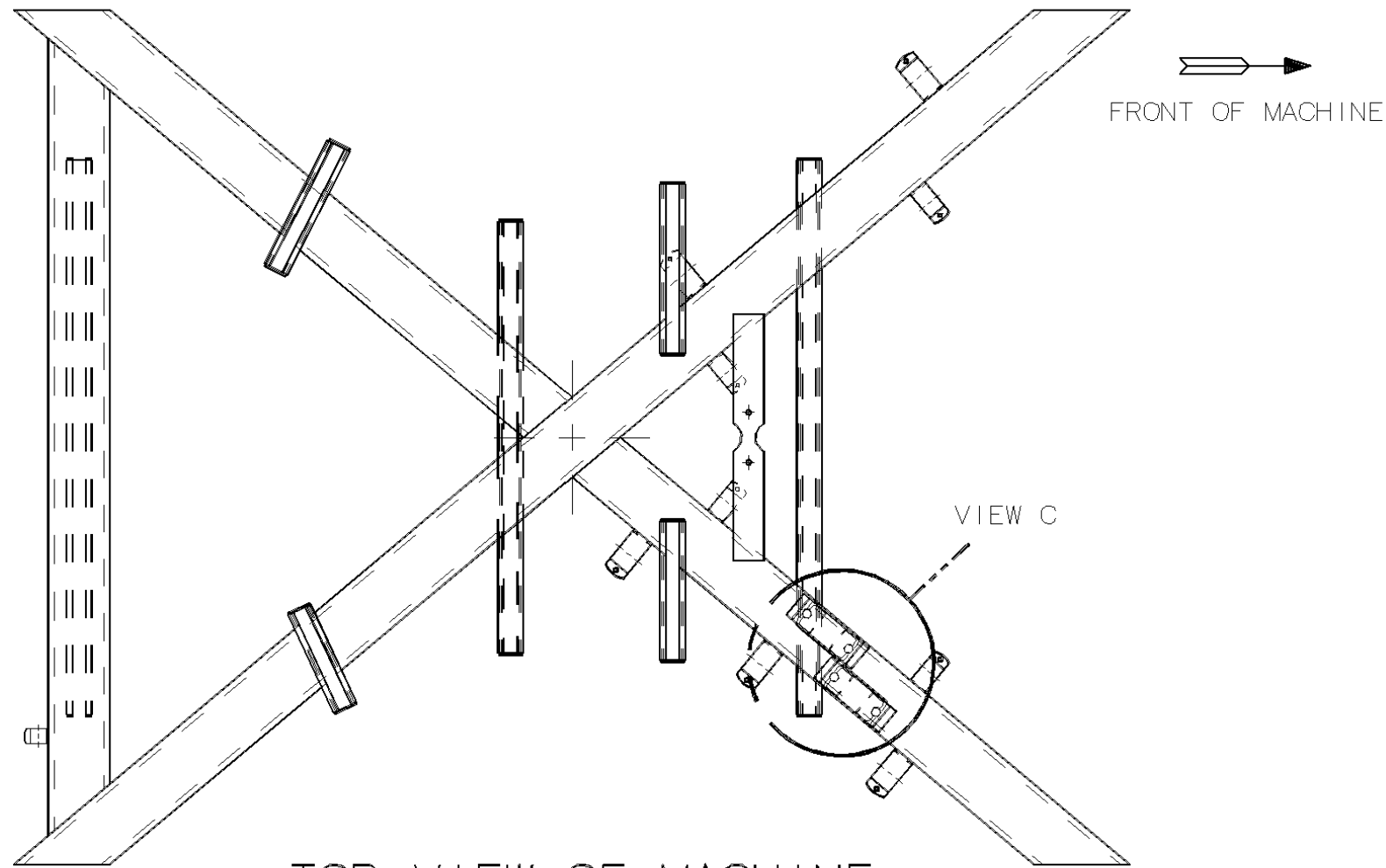
VIEW B-B  
(REF. #1, #2, & #3 INSTALLATION DETAIL)  
SCALE: .38=1"

**NOTE :**

THIS CONVERSION APPLIES TO 6700S MACHINES WITH SERIAL NUMBERS:  
 153239-153248, 153264-153266, 153268-153272, 153274-153276, 153278, 153287-153295, 153301-153311,  
 153324-153328, 153356, 153372-153384, 153386-153392, 153394, 153395, 153399, 153410, 153411, 153451,  
 153463, 153464, 153484

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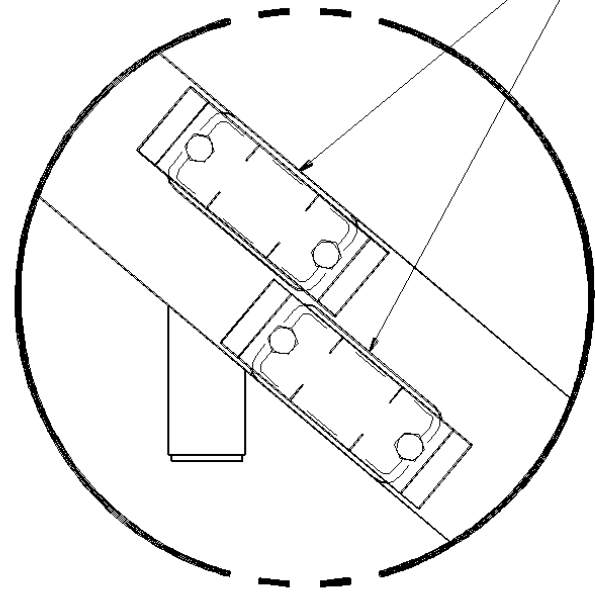




TOP VIEW OF MACHINE

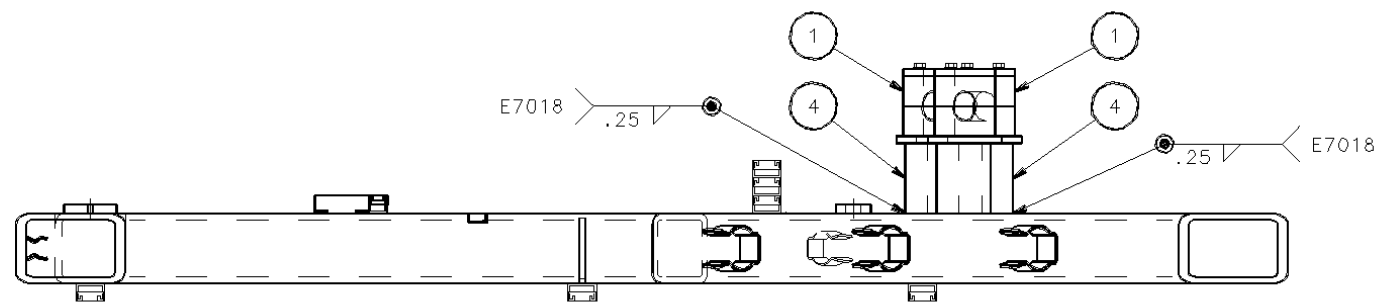
VIEW A-A  
(FROM SHEET 1)

LOCATE AT ASSEMBLY,  
TO MINIMIZE CHANGES  
TO HOSE ROUTING.



VIEW C

SCALE: .50=1"



IMPLIED TOLERANCES				CHANGE		REVISION		DATE		Description	
ALL DIMENSIONS ARE IN INCHES - TOLERANCE UNLESS OTHERWISE SPECIFIED				S10003669	R/U			23AUG07	CONV- WORKHEAD #16 RET HOSE CLAMP KIT		
OVER	TO	FRAC	DECIMAL	OVER	TO	FRAC	DECIMAL				
0	6	.03	.005	0	150	.8	.127				
6	24	.04	.008	150	500	1.0	.203				
24	-	.06	.010	-	500	1.5	.254				

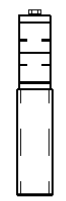
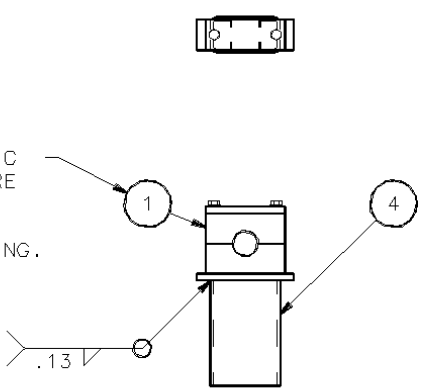
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<small>           UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS SHALL HAVE A GENERAL TOLERANCE OF .125         </small>				<small>           UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS SHALL HAVE A GENERAL TOLERANCE OF .125         </small>				<small>           UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS SHALL HAVE A GENERAL TOLERANCE OF .125         </small>			
<small>           THIRD ANGLE PROJECTION         </small>				<small>           UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS SHALL HAVE A GENERAL TOLERANCE OF .125         </small>				<small>           UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS SHALL HAVE A GENERAL TOLERANCE OF .125         </small>			

Drawing Number: 1011256,-		Machine Type: 6700S		HHT	
Model: COLE		Date Drawn: 23AUG07		Harsco Track Technologies	
Weight:		Scale: .19=1		Harsco Ludington, MI	
Part #1:		APD Base		Part Number: 2013219,-	
				Sheet: 2 of 3	

- 1) REMOVE PLASTIC MEMBERS BEFORE WELDING.
- 2) RE-ASSEMBLE BEFORE PAINTING.

WPS #711



REF. #1 AND #4 SUB-ASSEMBLY

(2) REQUIRED

SCALE: .19=1"

- 1) REMOVE PLASTIC MEMBERS BEFORE WELDING.
- 2) RE-ASSEMBLE BEFORE PAINTING.

- 1) REMOVE PLASTIC MEMBERS BEFORE WELDING.
- 2) RE-ASSEMBLE BEFORE PAINTING.

WPS #711

.13  
.13

1.00 TYP.

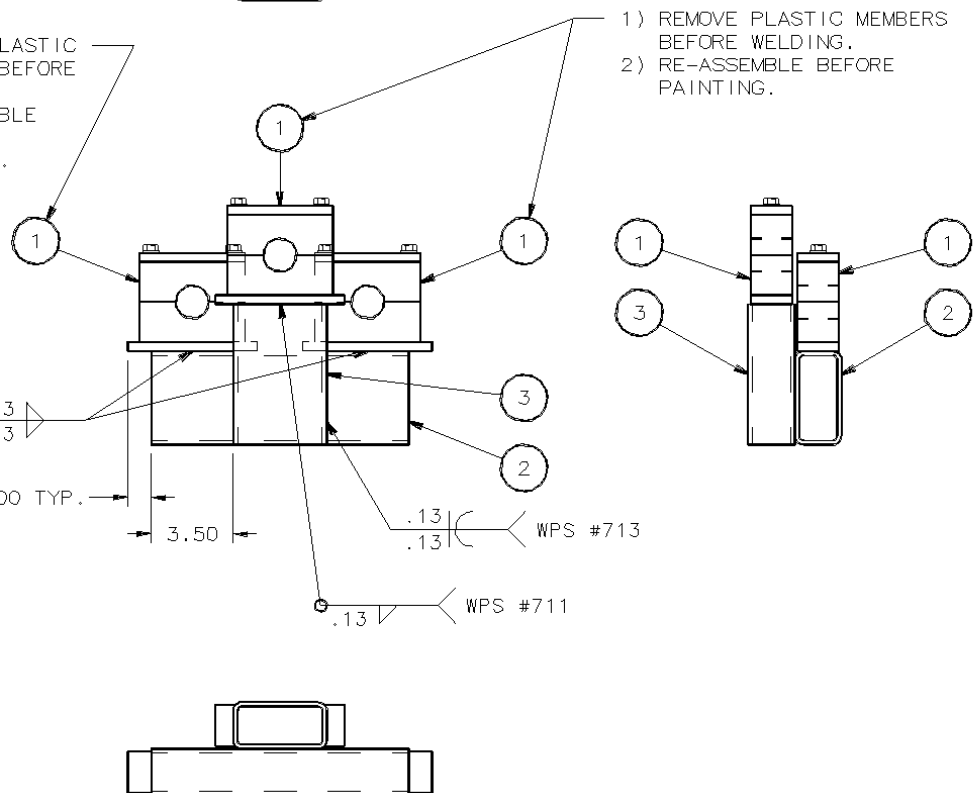
3.50

.13  
.13

WPS #713

.13

WPS #711



REF. #1, #2, AND #3 SUB-ASSEMBLY

\* SEE SEPARATE PARTS LISTS FOR SERVICE ON FOLLOWING REF #

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NOMINAL SIZE RANGE	INCH PLUS OR MINUS	METRIC PLUS OR MINUS	INCH PLUS OR MINUS	METRIC PLUS OR MINUS	UNLESS OTHERWISE SPECIFIED ALL SURFACE FINISHES SHALL BE TO UNLESS OTHERWISE SPECIFIED ALL SURFACE FINISHES SHALL BE TO																																				
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<p>CADAM DRAWING</p>				<p>THIRD ANGLE PROJECTION</p>				<p>Scale: .25=1</p>		<p>Part Number          2013219,-</p>		<p>Sheet          3 of 3</p>																													

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