



# Harsco Track Technologies

Harsco

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## SERVICE BULLETIN MAINTENANCE OF WAY EQUIPMENT

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**DATE:** 3-4-2002 **BULLETIN NO:** 02-008

**TITLE:** 2004590 FLOW DIVIDERS CONVERSION GROUP

**RATING:**

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

**PRODUCT SERIES / MODEL:** 6700S Tamper

**SERIAL NO:** All Models Serial # 152773 and Higher

**SUMMARY:** There have been failures of the flow dividers in the field in that the hex drive shaft that drives between the sections becomes rounded and will not regulate the flow properly. In an effort to increase product reliability and performance, a new flow divider has been sourced and will be used on all future production machines. The new flow divider has a splined shaft connecting the sections which is more efficient than the hex shaft. Older machines may be converted by installation of this Conversion Group part # 2004590.

**OPERATIONAL IMPACT:** Reduces downtime caused by the flow divider and improves performance.

**ACTION:** The installation of this Conversion Group requires:

- Disconnecting hydraulic lines and removing the existing flow dividers.
- Installing the new flow dividers and reconnecting the hydraulic lines.

**CONTACT:** If you have any questions or if we can be of any service, please contact Bill Perry or Doug Budreau at the Ludington, MI. facility, (231) 843-3431.

**SAFETY INFORMATION**

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

**CONVERSION GROUP INSTALLATION****Existing Flow Dividers Removal - See Figure 1 and Figure 2**

1. Locate the two existing flow dividers on the machine frame.
2. Disconnect all of the hydraulic lines from the adapters in the existing flow dividers and cap the lines.

*Note: Be sure to note which hydraulic lines are connected to the flow divider ports for proper re-assembly.*

3. Remove the two straight adapters from the inlet ports of the existing flow dividers. Save the straight adapters; they will be re-used.
4. Remove the two existing flow dividers from the machine frame. Discard the two existing flow dividers with the remaining adapters in the outlet ports and the mounting hardware; they will not be re-used.

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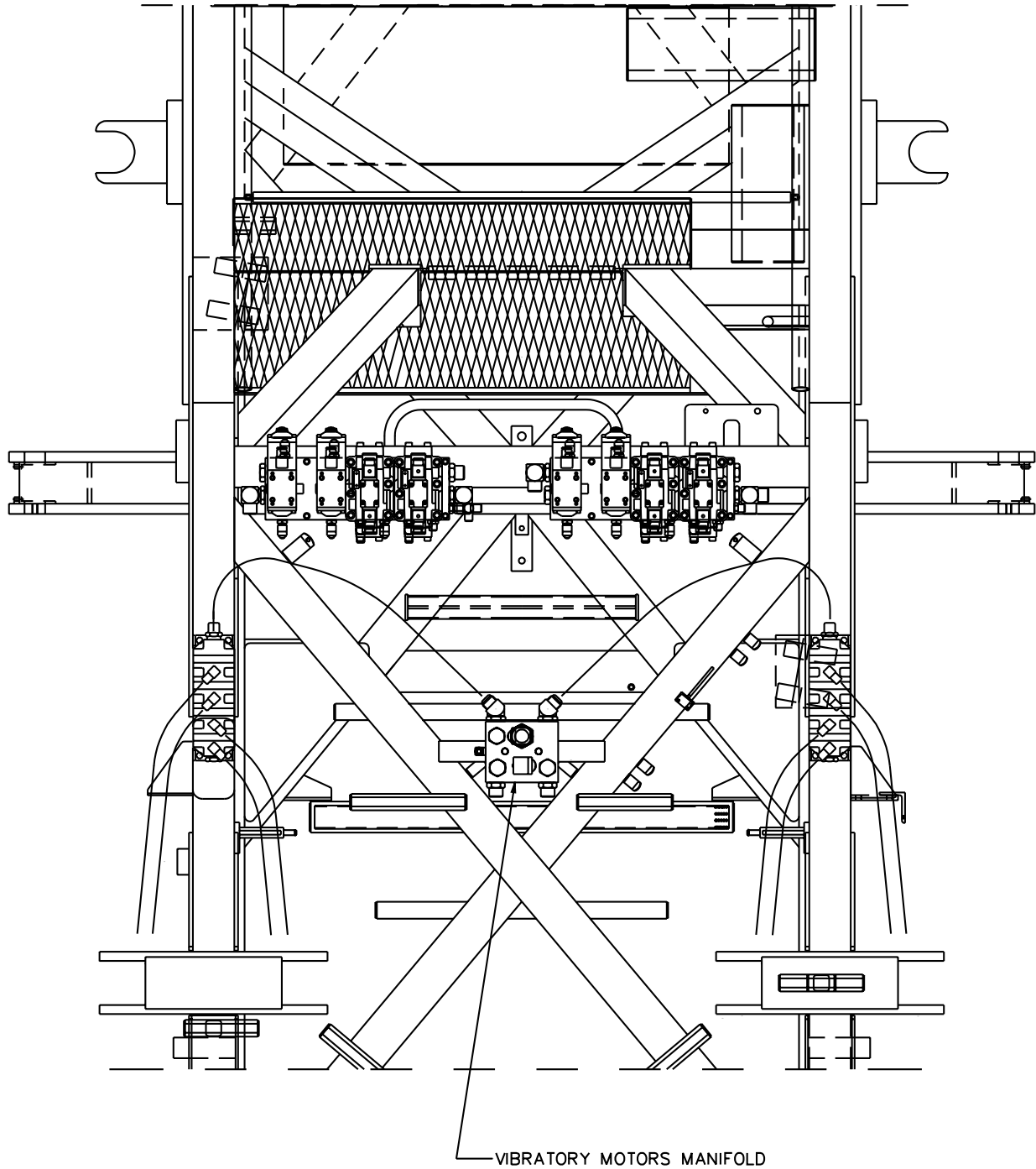
**CONVERSION GROUP INSTALLATION****New Flow Dividers Installation** - See Figure 3 and Figure 4

5. Install the two new mounting angles (2) to the existing tapping pads on the machine frame using four 3/8" x 1-1/4" cap screws (3) and 3/8" lock washers (4). Tighten all cap screws securely.
6. Install the two new flow dividers (1) to the mounting angles (2) using eight 3/8" x 5/8" cap screws (6) and 3/8" lock washers (4). Torque all cap screws to 37 ft lbs.
7. Install the original two straight adapters into the inlet ports on the bottom of the new flow dividers (1). Tighten all adapters securely.
8. Install the eight new 45° adapters (5) into the outlet ports on the top of the new flow dividers (1). Tighten all adapters securely.
9. Reconnect the hydraulic lines to the adapters in the new flow dividers. Tighten all hydraulic connections securely.
10. Start the engine.
11. Start the operation of the workhead vibrators to pressurize the workhead circuits.
12. Check the new flow dividers and all hydraulic connections for leaks.

CONVERSION GROUP INSTALLATION

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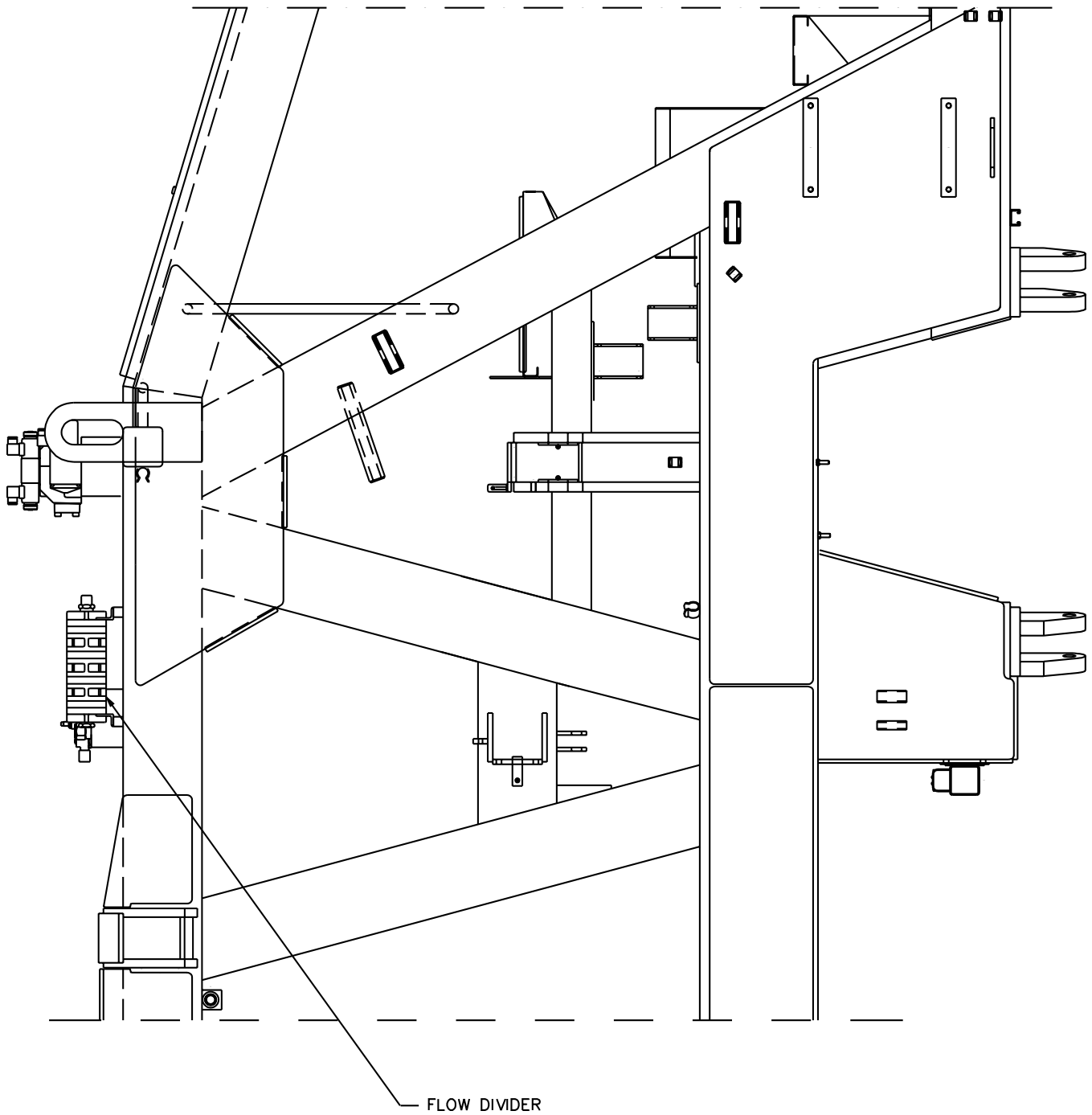
FIGURE 1  
EXISTING FLOW DIVIDERS REMOVAL



CONVERSION GROUP INSTALLATION

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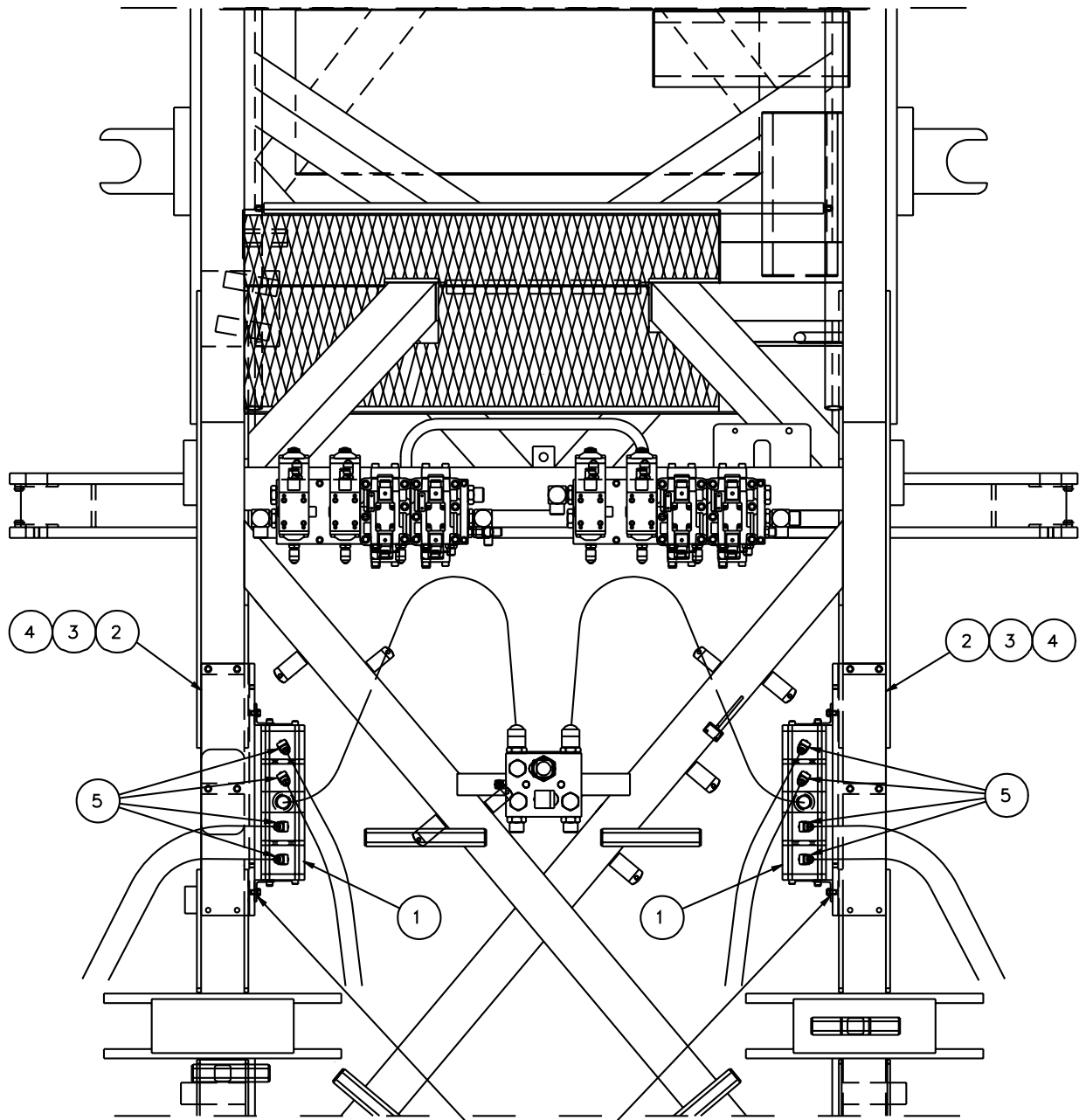
FIGURE 2  
EXISTING FLOW DIVIDERS REMOVAL



CONVERSION GROUP INSTALLATION

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FIGURE 3  
NEW FLOW DIVIDERS INSTALLATION

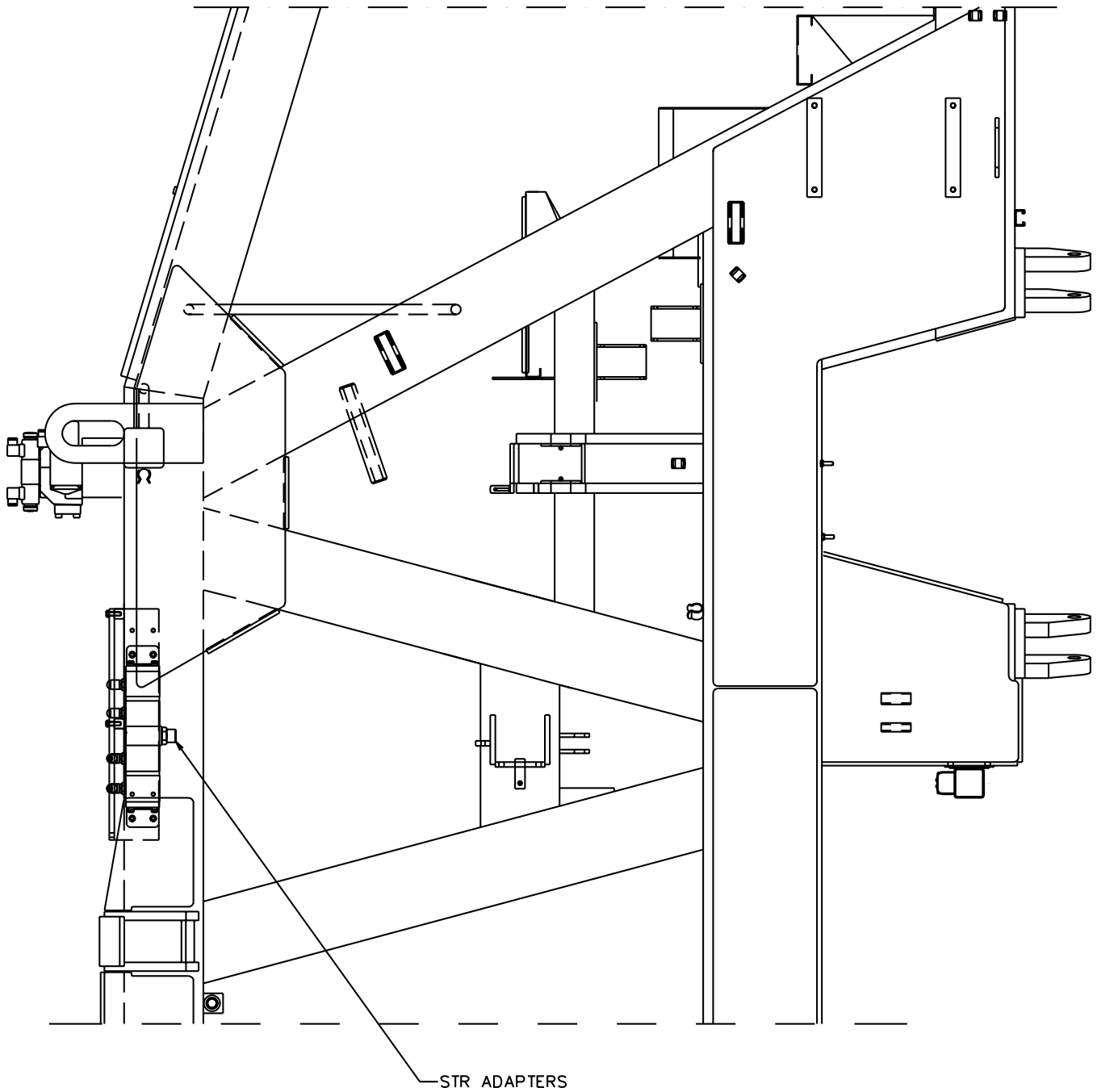


4 6 — TORQUE BOLTS ON FLOW DIVIDERS TO 37 FT LBS AFTER INSTALLING NEW ANGLE BRACKETS, BOTH SIDES.

CONVERSION GROUP INSTALLATION

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FIGURE 4  
NEW FLOW DIVIDERS INSTALLATION



**CONVERSION GROUP PARTS LIST**

ITEM	PART NO	DESCRIPTION	QTY
	2004590	FLOW DIVIDERS CONVERSION GROUP .....	1
1	2004589	Flow Divider .....	2
2	2004598	Mounting Angle .....	2
3	250010-106	Cap Screw, 3/8"-16 x 1-1/4" Hex Head .....	4
4	150988-11	Lock Washer, 3/8" .....	16
5	152390-11	Adapter, 45° .....	8
6	250010-102	Cap Screw, 3/8"-16 x 5/8" Hex Head .....	8

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