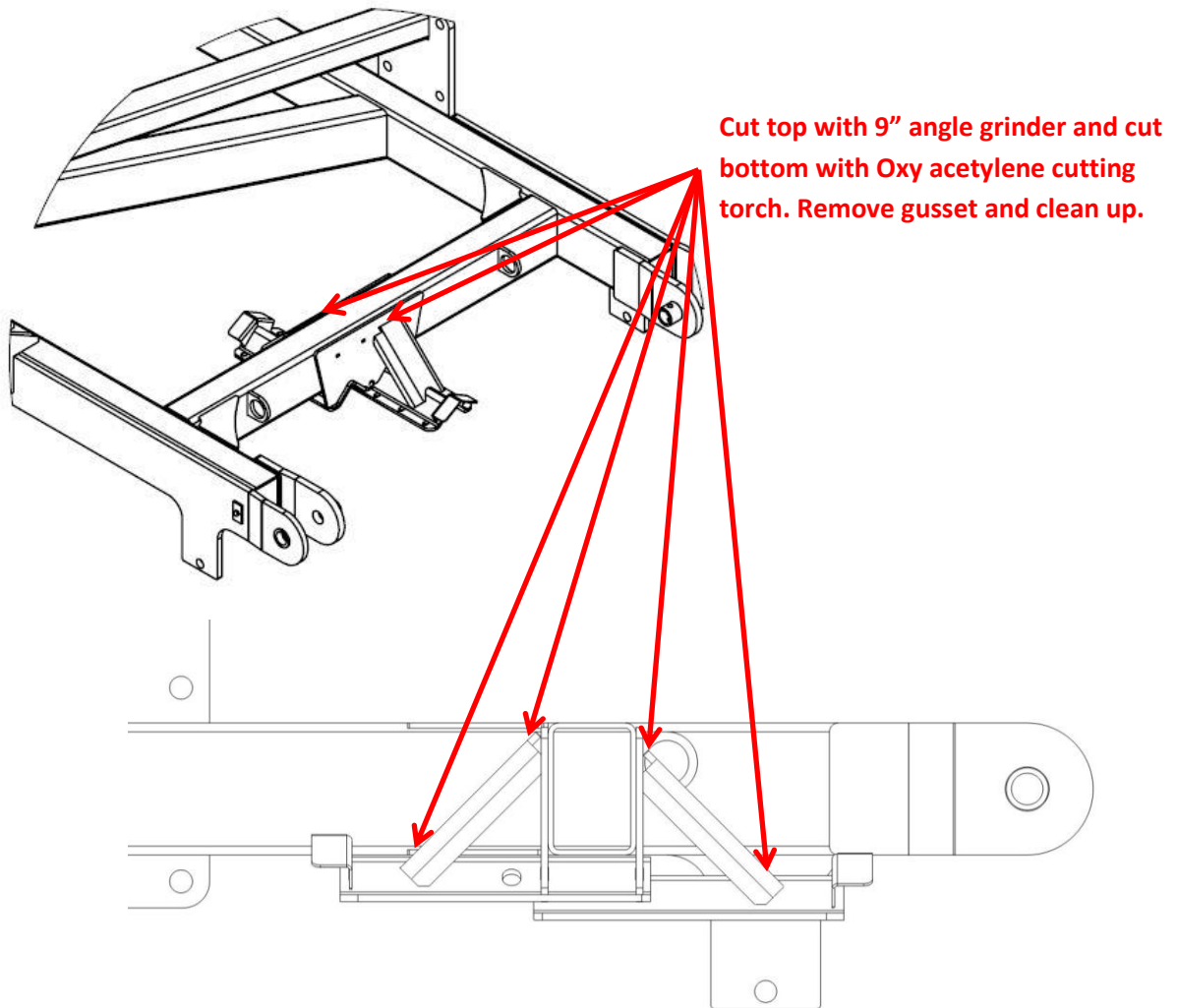


30'/40'/45' Axle Mount Gusseting Page 1 of 7

This technical bulletin describes the procedure to fix/replace the axle mount on either single axle or dual axle housings. This update applies to machines which have suffered in service failures and have damaged axle housings as a result.

Step 1

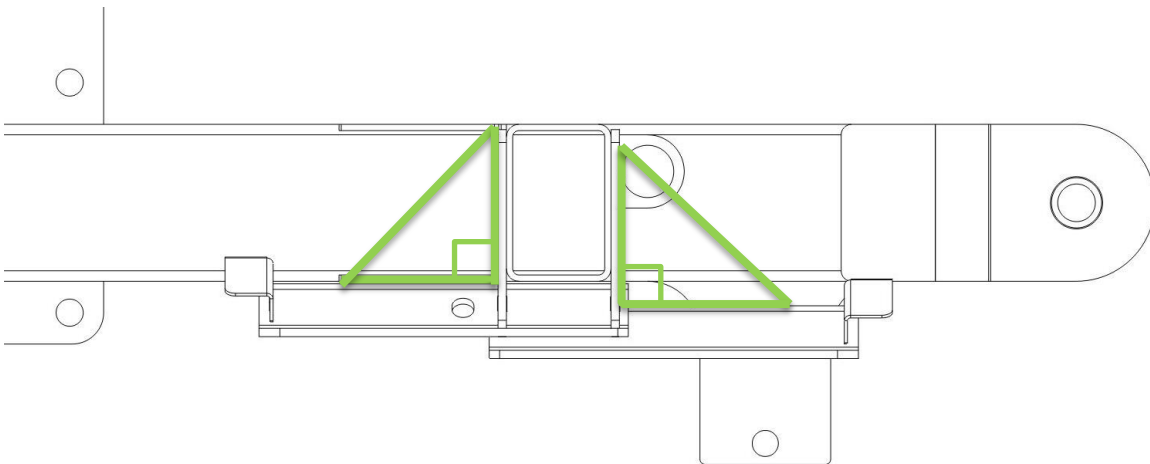
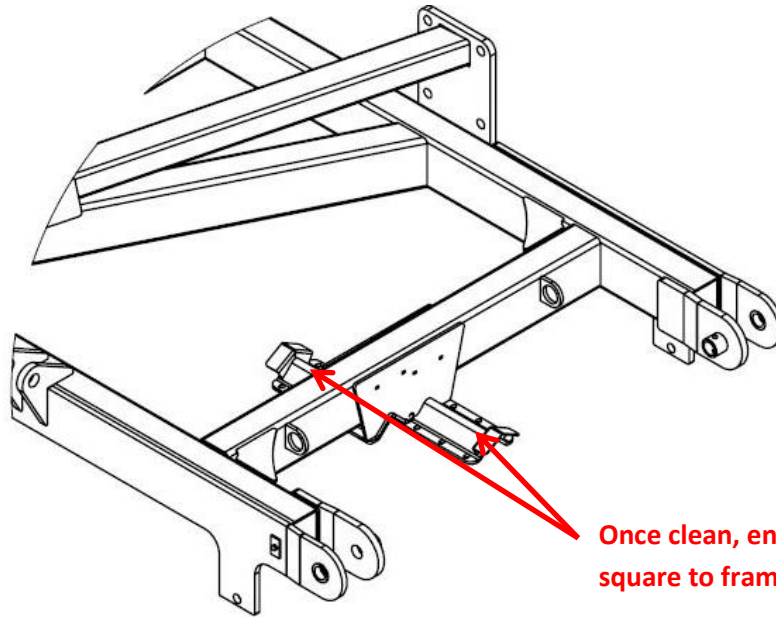
Cut off all gussets that are supporting axle housing.



30'/40'/45' Axle Mount Gusseting Page 2 of 7

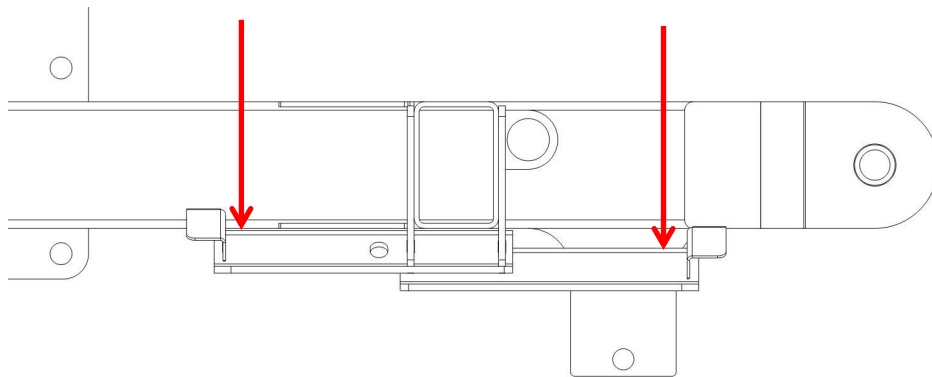
Step 2

Check to see that existing mount is still level with the frame. Place square onto axle flange to check alignment with supporting beam. If square skip to step 4.

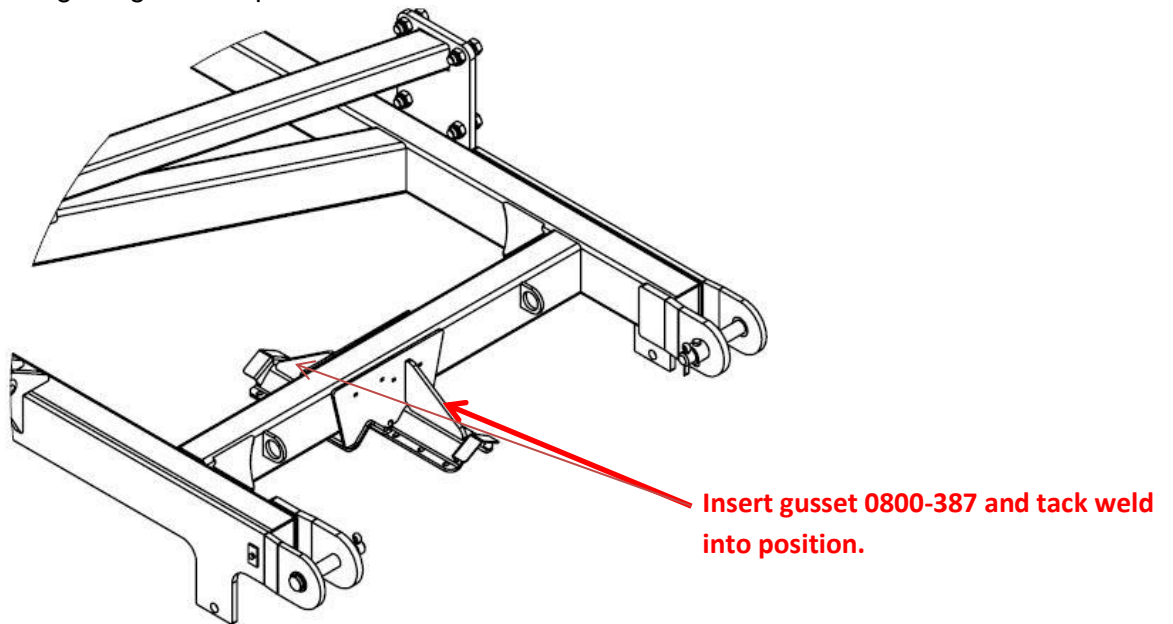


30'/40'/45' Axle Mount Gusseting Page 3 of 7

Step 3
Bend axle mount to a square position as seen in step 2.

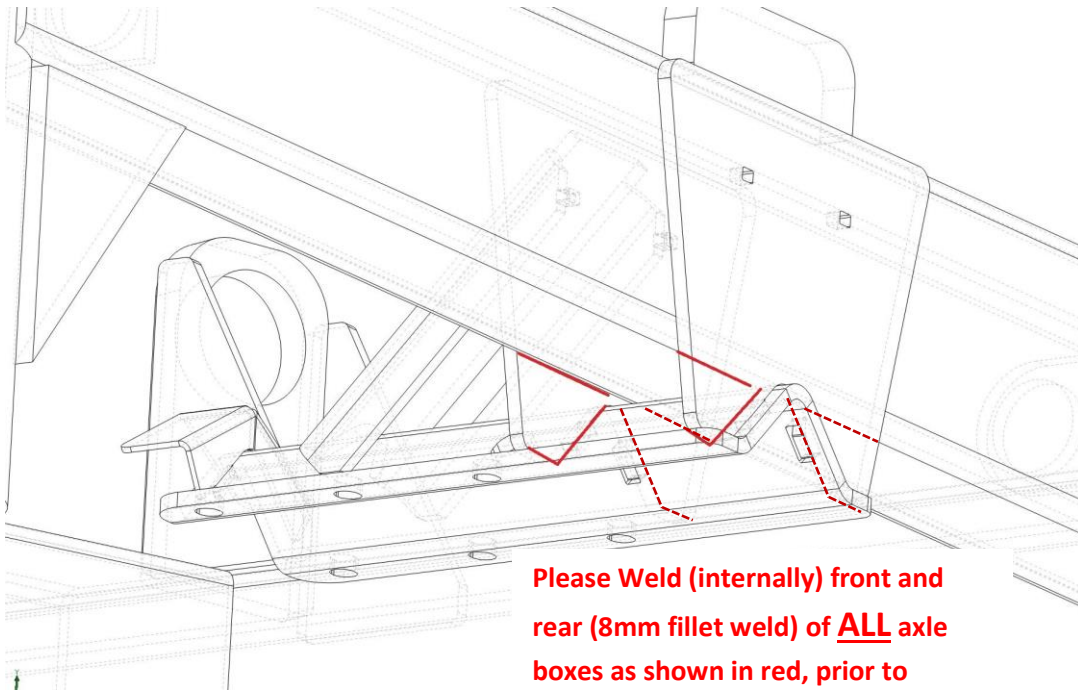


Step 4
Tack weld triangular gusset in position.



30'/40'/45' Axle Mount Gusseting Page 4 of 7

Step 5
Fully weld inside joints of all axle boxes as shown below.

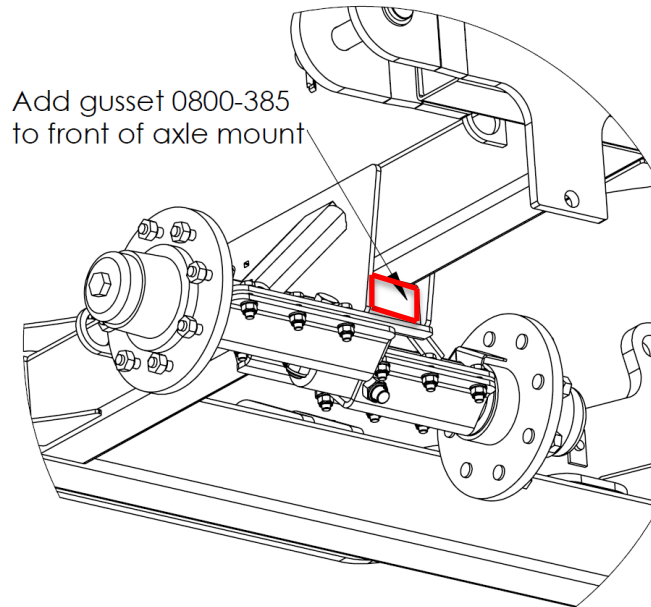


Please Weld (internally) front and rear (8mm fillet weld) of ALL axle boxes as shown in red, prior to capping with the gussets in the following steps

30'/40'/45' Axle Mount Gusseting Page 5 of 7

Step 6

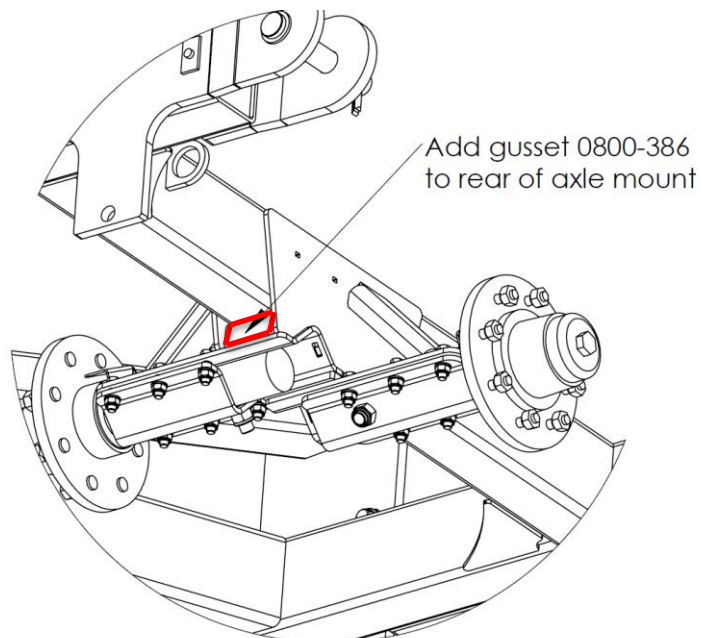
Add gusset plate 0800-385 (see Appendix 1 for drawing) to the front side of each axle mount as shown below



Please Weld front and rear (8mm fillet weld) of ALL axle boxes as shown in red.

Step 7

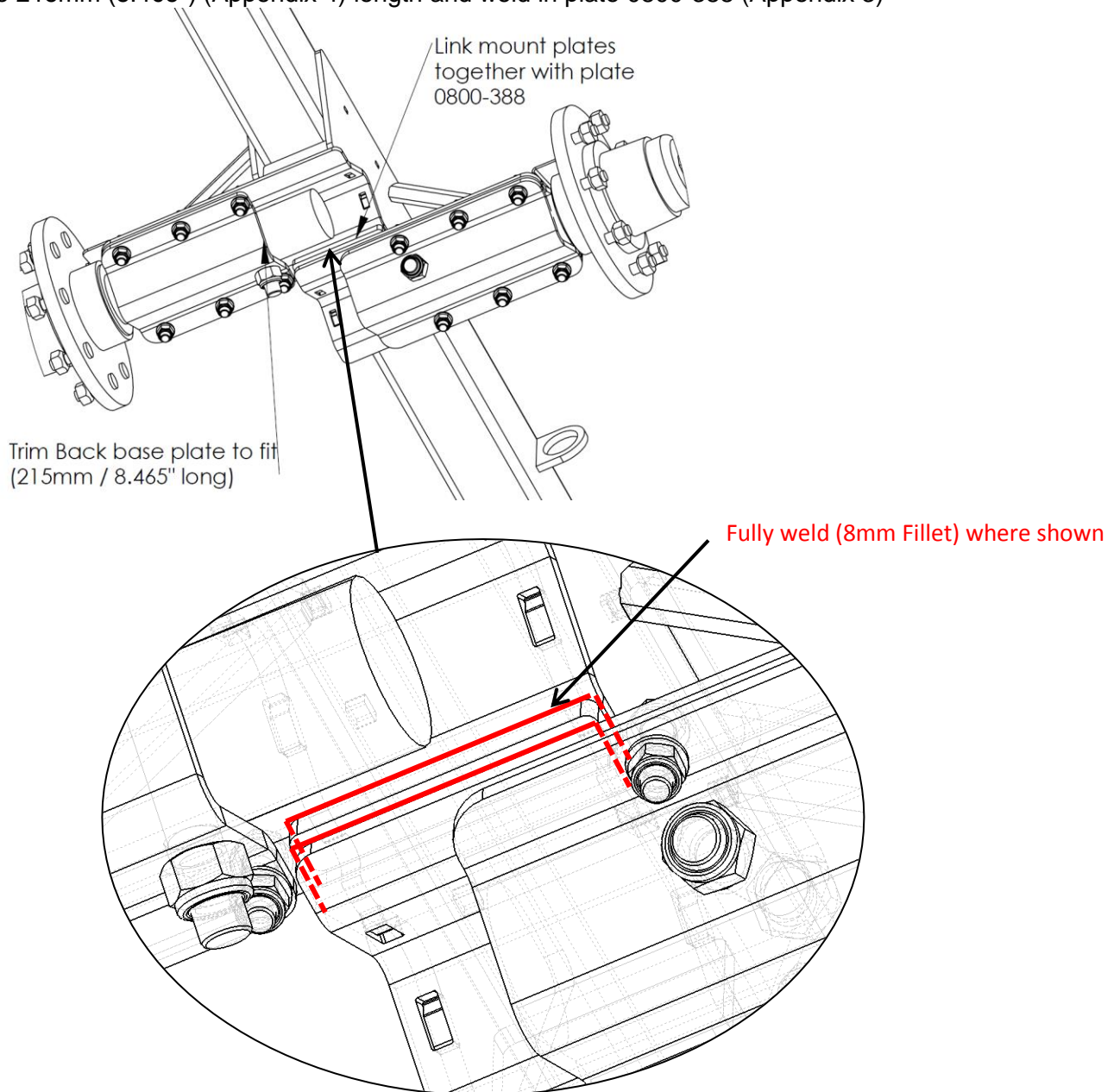
Add gusset plate 0800-386 (see Appendix 2 for drawing) to the rear side of each axle mount as shown below



30'/40'/45' Axle Mount Gusseting Page 6 of 7

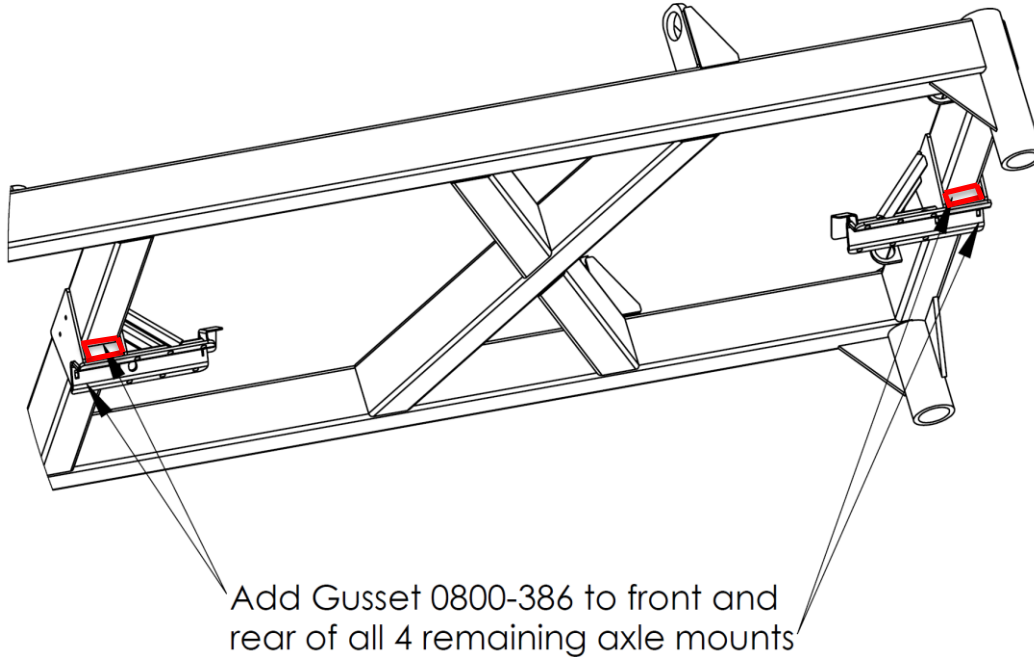
Step 8

To link the two axle mount brackets together in the centre as shown below trim back base plate to 215mm (8.465") (Appendix 4) length and weld in plate 0800-388 (Appendix 3)



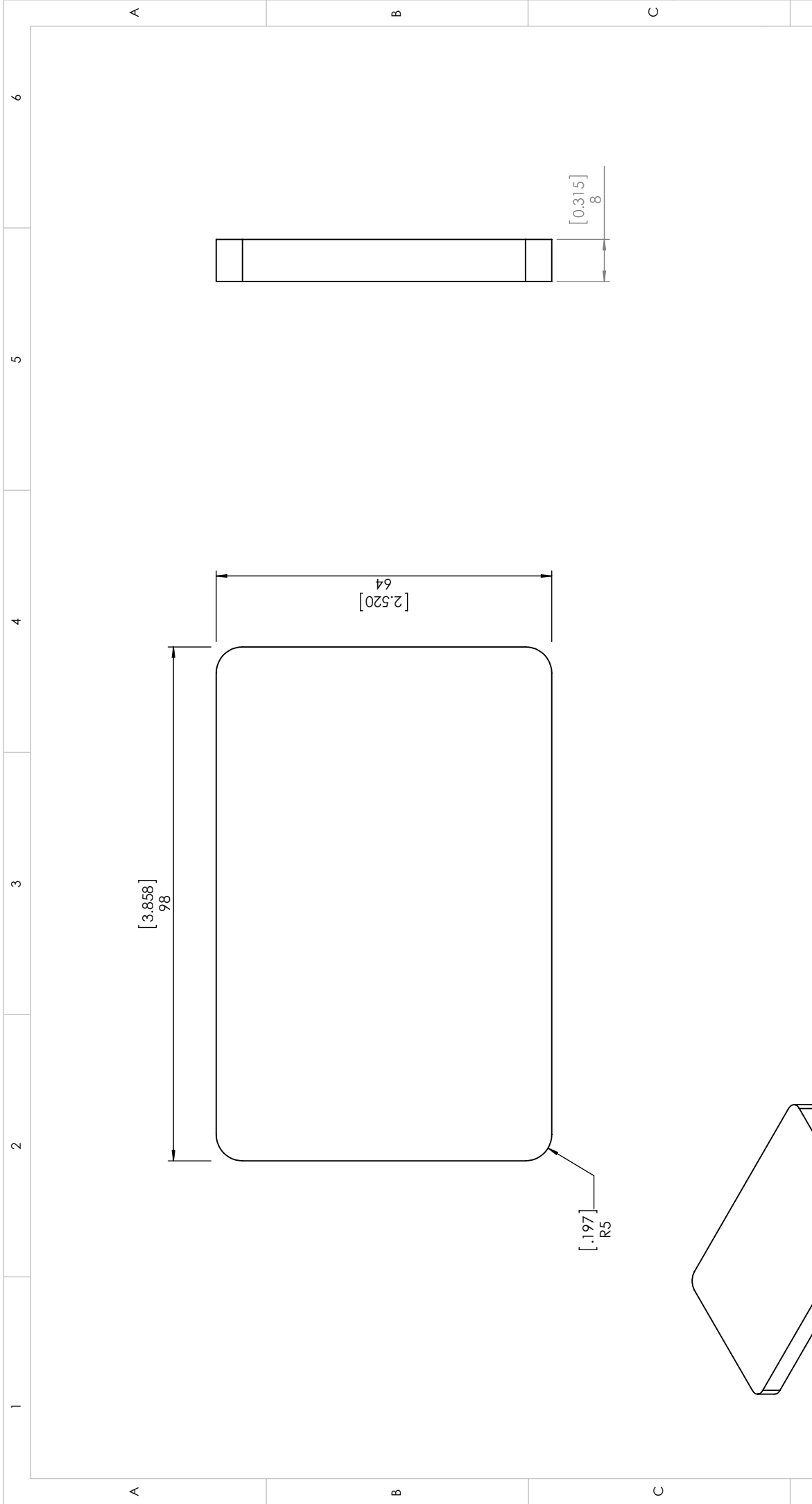
30'/40'/45' Axle Mount Gusseting Page 7 of 7

Repeat step 7 on all outer wing axle mounts at front and rear of machine as shown below.

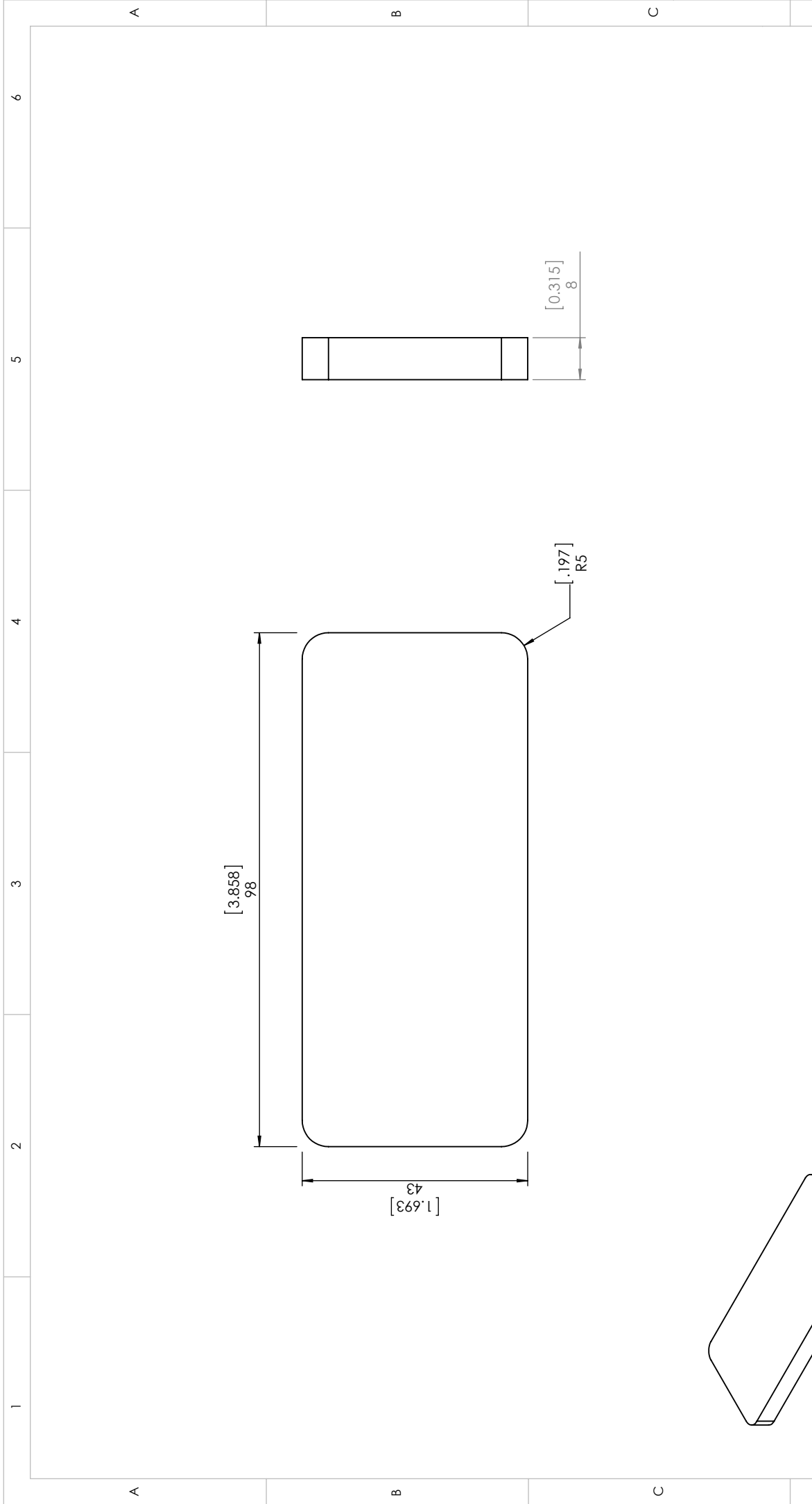


Step 8


Fully weld gussets to axle mount (8mm fillet), clean up and repaint.



DO NOT SCALE DRAWING		REVISION A-0													
		TITLE: 45' Centre Frame Front Axle Gusset													
		DWG NO. 0800-385													
For Machines Built:		SCALE: 1:1													
<table border="1"> <thead> <tr> <th>Rev</th> <th>Date</th> <th>Revision Description</th> </tr> </thead> <tbody> <tr> <td>A-0</td> <td>20/05/2015</td> <td>Initial release for 45' axle gusseting</td> </tr> </tbody> </table>		Rev	Date	Revision Description	A-0	20/05/2015	Initial release for 45' axle gusseting	<table border="1"> <thead> <tr> <th>DATE</th> <th>SIGNATURE</th> <th>MATERIAL</th> </tr> </thead> <tbody> <tr> <td>20/05/2015</td> <td>Approved G Laskey</td> <td>8mm 250 Plate</td> </tr> </tbody> </table>		DATE	SIGNATURE	MATERIAL	20/05/2015	Approved G Laskey	8mm 250 Plate
Rev	Date	Revision Description													
A-0	20/05/2015	Initial release for 45' axle gusseting													
DATE	SIGNATURE	MATERIAL													
20/05/2015	Approved G Laskey	8mm 250 Plate													
<table border="1"> <thead> <tr> <th>NAME</th> <th>DATE</th> <th>WEIGHT:</th> </tr> </thead> <tbody> <tr> <td>G Laskey</td> <td>20/05/2015</td> <td>0.390 Kg</td> </tr> </tbody> </table>		NAME	DATE	WEIGHT:	G Laskey	20/05/2015	0.390 Kg	<table border="1"> <thead> <tr> <th>DRAWN</th> <th>CHKD</th> <th>APPV'D</th> </tr> </thead> <tbody> <tr> <td>G Laskey</td> <td>S Kelly</td> <td></td> </tr> </tbody> </table>		DRAWN	CHKD	APPV'D	G Laskey	S Kelly	
NAME	DATE	WEIGHT:													
G Laskey	20/05/2015	0.390 Kg													
DRAWN	CHKD	APPV'D													
G Laskey	S Kelly														
<table border="1"> <thead> <tr> <th>Rev</th> <th>Date</th> <th>Revision Description</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>2</td> <td></td> </tr> </tbody> </table>		Rev	Date	Revision Description	1	2		SHEET 1 OF 1							
Rev	Date	Revision Description													
1	2														



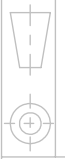
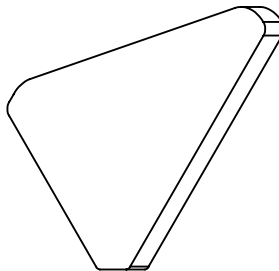
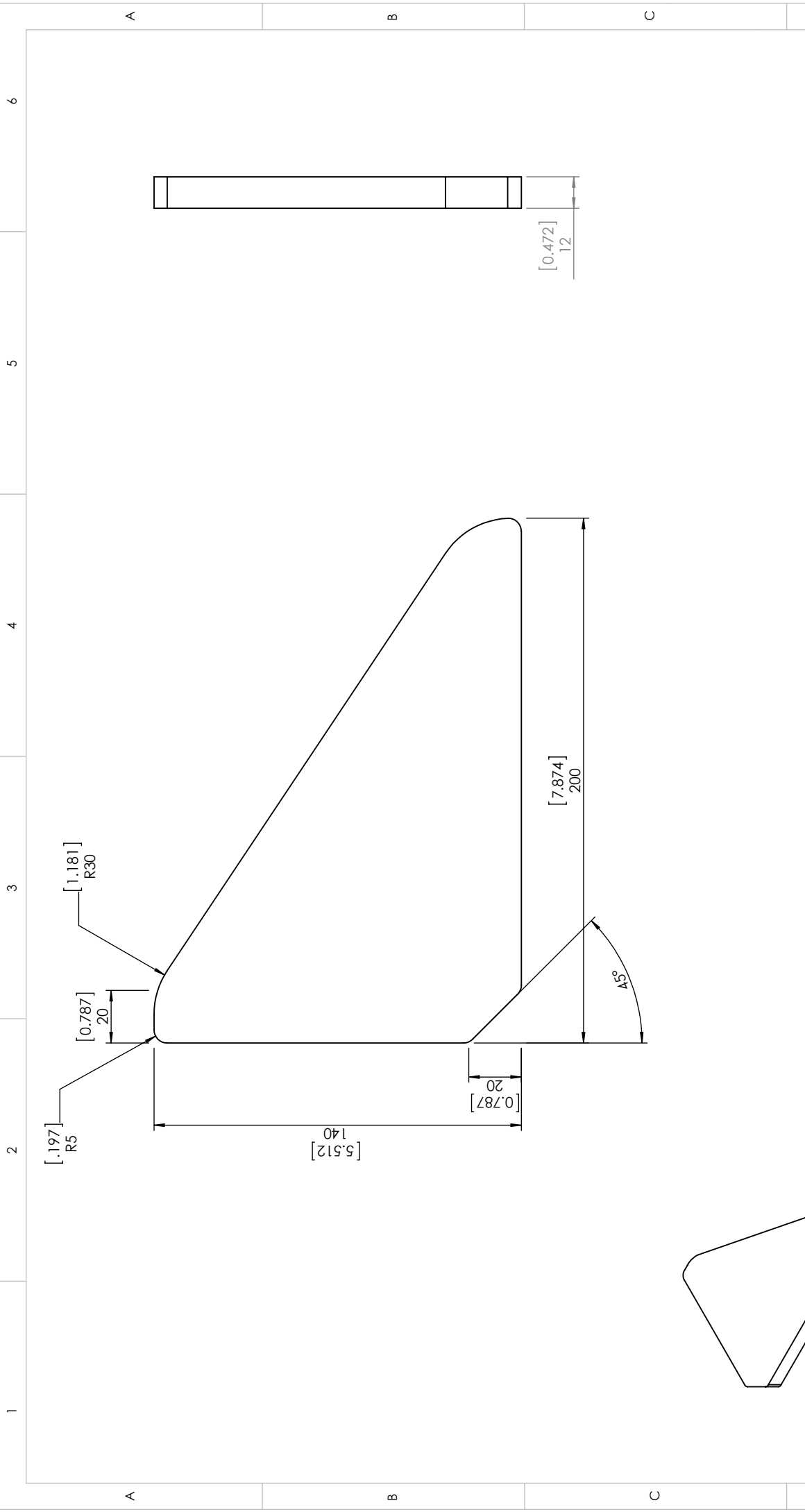
Rev	Date	Revision Description
A-0	20/05/2015	Initial release for 45' axle gusseting
1		2

		For Machines Built:	
DRAWN	NAME	SIGNATURE	DATE
	G Laskey	<i>G Laskey</i>	20/05/2015
CHKD			
APPV'D	S Kelly	<i>S Kelly</i>	20/05/2015
		MATERIAL:	WEIGHT:
		8mm 250 Plate	0.262 Kg

DO NOT SCALE DRAWING	REVISION
	A-0

TITLE:	DWG NO.	SCALE:1:1
45' Centre Frame Axle Rear Gusset	0800-386	SHEET 1 OF 1

Tolerance (UNO) XX ± 0.1mm X ± 0.2mm X ± 0.5mm XX ± 1.0mm XXX ± 2.0mm X ± 0.1" X ± 0.5"	
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DO NOT SCALE DRAWING

REVISION A-0

Tolerance (UNO):
 XX ± 0.1mm
 X ± 0.2mm
 X ± 0.5mm
 XX ± 1.0mm
 XXX ± 2.0mm
 X ± 0.1mm
 X ± 0.5°

For Machines Built:

NAME	DATE	SIGNATURE	MATERIAL
G Laskey	20/05/2015	Approved G Laskey	12mm 250 Plate
S Kelly	20/05/2015	S Kelly	WEIGHT: 1.586 Kg



TITLE:
**45' Centre Frame Axle Mount
 Triangle Gusset**

DWG NO. **0800-387**
 SCALE: 1:2

REVISION **A-0**

DATE: 20/05/2015

SIGNATURE: Approved
G Laskey

NAME: G Laskey

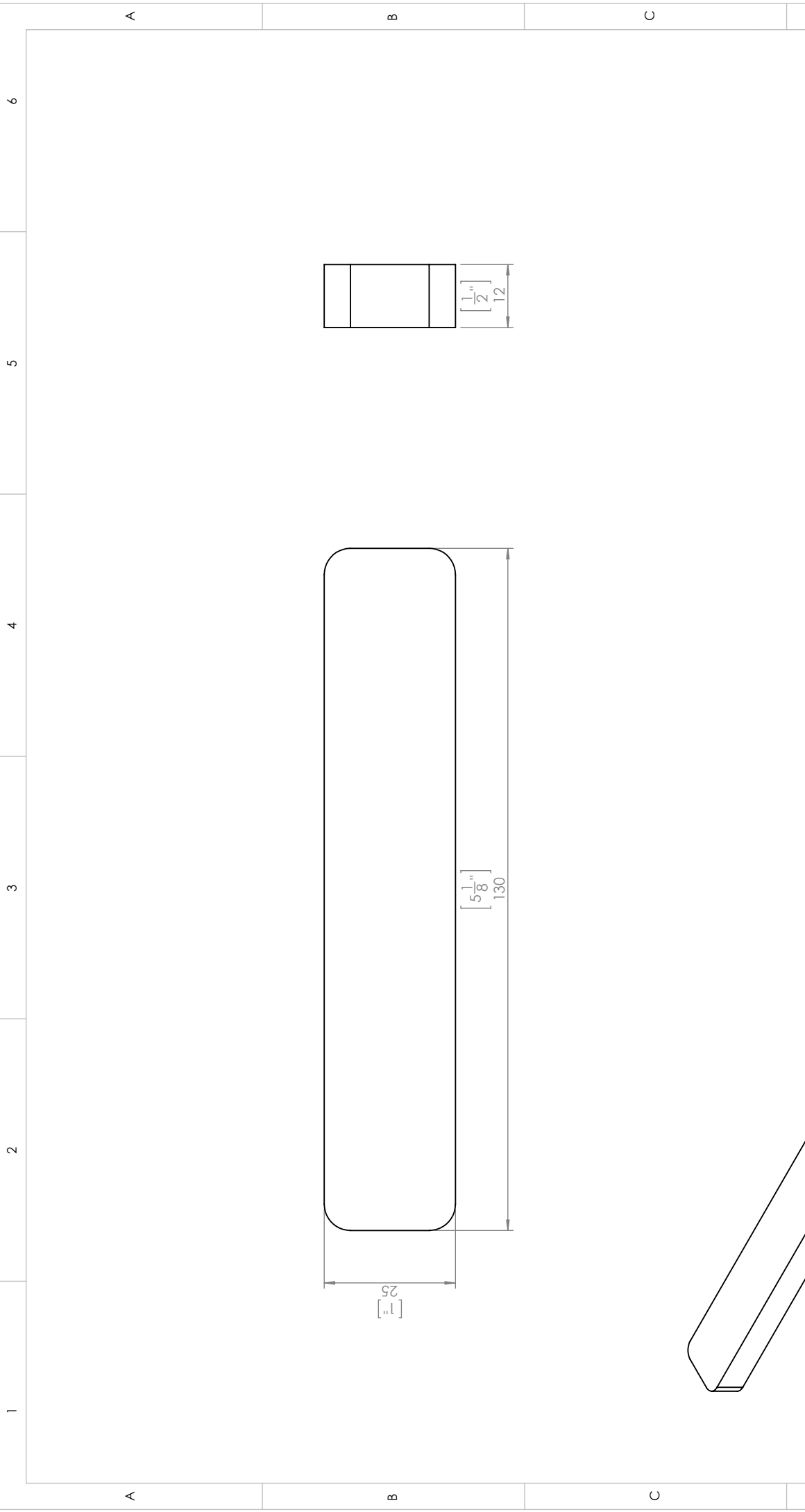
DATE: 20/05/2015












SIGNATURE: S Kelly

NAME: S Kelly

DATE: 20/05/2015

Rev	Date	Revision Description
A-0	20/05/2015	Initial release for 45' axle gusseting
1		2

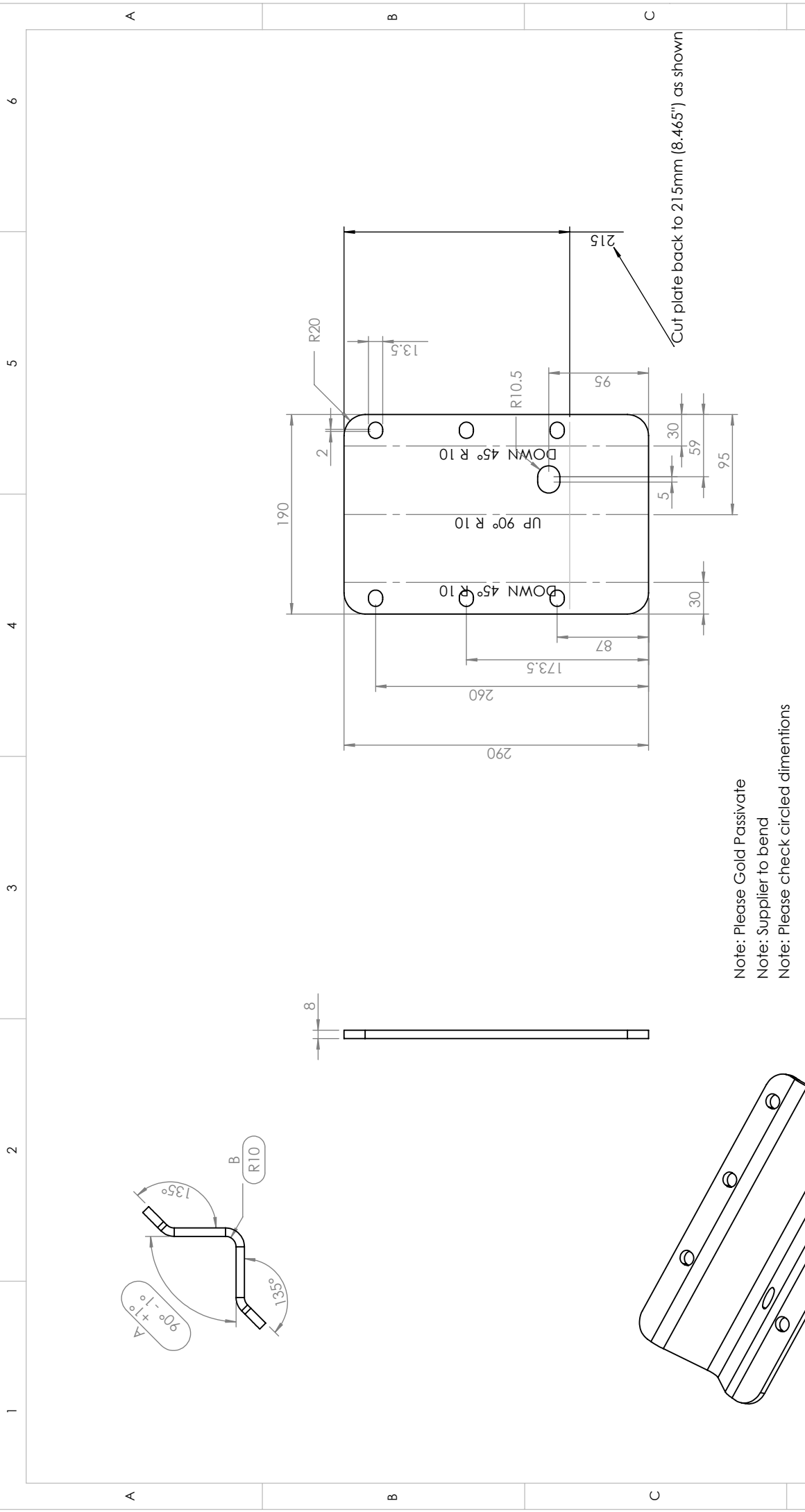


DO NOT SCALE DRAWING		REVISION		A-0	
TITLE:		45D Axle Mount Centre Gusset			
Tolerance (UNO): XX ± 0.1mm X ± 0.2mm X ± 0.5mm XX ± 1.0mm XXX ± 2.0mm XXX ± 3.0mm X* ± 0.1* X* ± 0.5*		DWG NO.		0800-388	
MATERIAL:		12mm 250 Plate			
DATE		27/05/2015			
SIGNATURE		 Approved G Laskey			
NAME		S Kelly			
DATE		27/05/2015			
SIGNATURE		 S Kelly			
NAME		G Laskey			
DATE		27/05/2015			
SIGNATURE		 G Laskey			
NAME		S Kelly			
DATE		27/05/2015			
SIGNATURE		 S Kelly			
NAME		G Laskey			
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DATE		27/05/2015			
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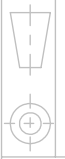


For Machines Built:

Rev	Date	Revision Description
A-0	27/05/2015	
1		
2		



Note: Please Gold Passivate
 Note: Supplier to bend
 Note: Please check circled dimensions



Tolerance (UNO)
 XX ± 0.1mm
 X ± 0.2mm
 X ± 0.5mm
 XX ± 1.0mm
 XXX ± 2.0mm
 XXX ± 3.0mm
 X* ± 0.1*
 X* ± 0.5*

DO NOT SCALE DRAWING

REVISION **A-0**

TITLE:
Axel Bolt Plate

DWG NO. **0800-352**

SCALE: 1:5

SHEET 1 OF 1



For Machines Built:

DRAWN	NAME	SIGNATURE	DATE	MATERIAL:
	O Clothier		14/07/2014	8mm 250 Grade
	L Ellery		14/07/2014	
	G Laskey		14/07/2014	

Rev	Date	Revision Description
A-0	14/07/2014	Axel box plates
1		
2		

WEIGHT: 0.313 Kg Kg