



May 30, 2007

Safety Notice – Second Mailing

Reference: Recall Code 06V-065 (see attached letter and instructions)

To:

In April of 2006 The Charles Machine Works, Inc., manufacturer of Ditch Witch trailers notified you (see attached letter) that we had found that a nonconformity which relates to motor vehicle safety exists in your Ditch Witch model T18S trailer, Vehicle Identification Number (VIN) .

Our records do not indicate that you have had your trailer repaired. Please follow the instructions in the enclosed letter.

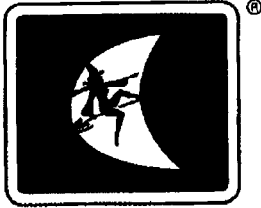
Even if you have repaired your trailer, please contact your local Ditch Witch dealership or The Charles Machine Works, Inc., Attention – Product Support, Trenchless Group, P.O. Box 66, Perry, OK 73077, or telephone (800)654-6481.

Regards,
The Charles Machine Works, Inc.

Richard Lambert, CSP, P.E.
Product Safety Coordinator



THE CHARLES MACHINE WORKS, INC.
P.O. BOX 66 • 1959 WEST FIR AVENUE • PERRY, OKLAHOMA 73077
T. (580) 336-4402 • F. (580) 336-3458 • www.ditchwitch.com



Safety Notice

Recall Code 06V-065

This notice is being sent to you in accordance with the requirements of the National Traffic and Motor Vehicle Safety Act.

To: Owners of Vacuum Systems with Ditch Witch Model T18S Trailers

The Charles Machine Works, Inc., manufacturer of Ditch Witch trailers has decided that certain Ditch Witch model T18S trailers fail to conform to Federal Motor Vehicle Safety Standard No. 223, "Rear Impact Guards."

Description of Non-conformity – The vacuum system extends too far back over the end of the trailer.

Potential Hazard – Occupants of a vehicle that collides with the rear of the trailer may be killed or seriously injured.

What You Should Do – Contact a Ditch Witch dealership to have a rear impact guard installed, the filter canister moved, and have additional reflective tape installed free of charge.

If you are a lessor of Ditch Witch model T18S trailers with vacuum systems, Federal law requires that any vehicle lessor receiving this recall notice must forward a copy of this notice to the lessee within ten days.

What The Charles Machine Works, Inc. Will Do – This work will be performed free of charge by your nearest Ditch Witch dealership. Estimated repair time is ½ day per trailer.

If You Have Incurred Trailer Repair Expenses Before You Received This Letter - The Charles Machine Works, Inc. will reimburse you if you have costs associated with the installation of a DOT rear impact guard, installation of reflective tape, or moving the filter canister and you have not been reimbursed for those costs. The amount includes parts, limited to The Charles Machine Works, Inc.'s list retail price, plus the labor at local rates, taxes, or disposal of wastes. Claims must be submitted to the Ditch Witch dealership or to The Charles Machine Works, Inc., Attention - Product Support, Trenchless Group, P.O. Box 66, Perry, OK 73077.

Reimbursement will be by check or cash from The Charles Machine Works, Inc. This plan is available to the public upon request. The Charles Machine Works, Inc. will act upon any claim within 60 days of its receipt. Disputes over the denial in whole or in part of a claim for reimbursement shall be resolved between you and The Charles Machine Works, Inc.

You may submit a complaint to the Administrator, National Highway Traffic Safety Administration, 400 Seventh Street, S.W., Washington, D.C. 20590 or call the toll free Vehicle Safety Hotline at 1-888-327-4236 (TTY: 1-800-424-9153); or go to <http://www.safercar.gov>, if you believe that The Charles Machine Works, Inc. or your Ditch Witch dealership has failed or is unable to remedy the defect or noncompliance without charge and within a reasonable time.

Rear Impact Guard**Ditch
Witch**

Publication Number: ID0158469

Publication Date: March 2006

INSTALLATION INSTRUCTIONS

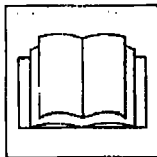
Rear Impact Guard**T18S Trailer**

Kit Number: 190-1098

Estimated Installation Time: 3.5 hours

Before You Start

Read instructions thoroughly. Check to see if all parts in bill of materials are in kit. If parts are missing or do not match bill of materials, contact Trenchless Product Support.



⚠ WARNING Incorrect procedures could result in death, injury, or property damage.
Use equipment correctly.

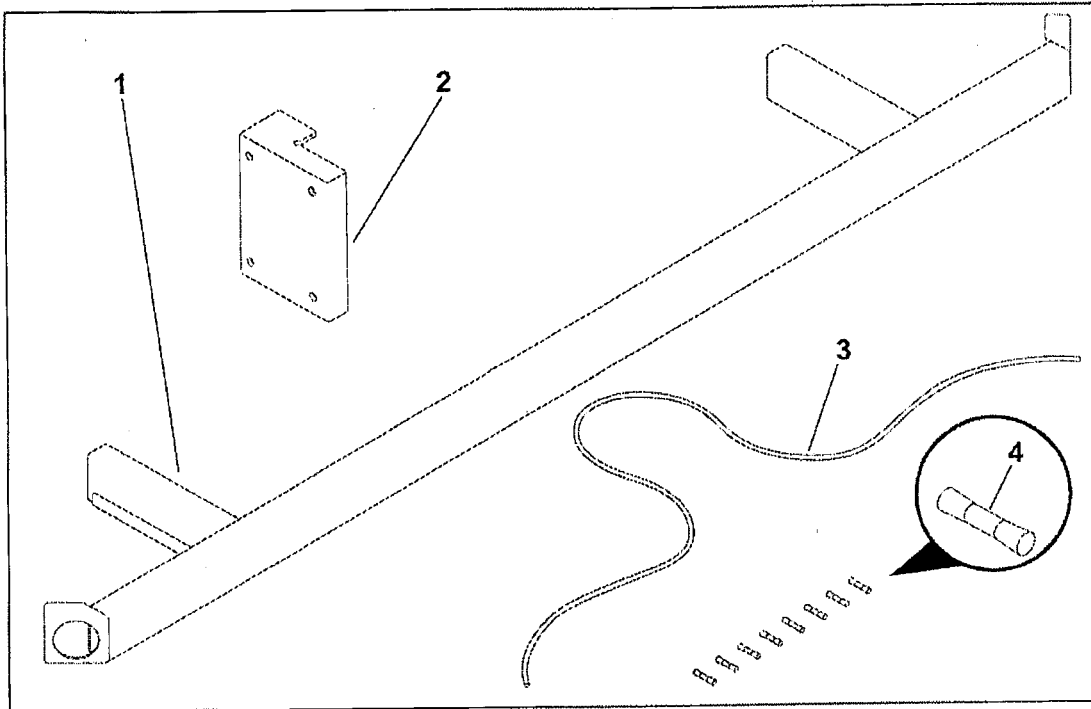
NOTICES:

- Empty tank.
- Park on level area.
- Turn off engine and remove key from ignition.
- Block the wheels.
- Use hoists and other load-bearing devices designed to hold weight of equipment.

Purpose of Kit

This kit contains the parts and instructions necessary to install a rear impact guard and relocate the filter canister on the T18S trailer.

Overview



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Ref.	P/N	Description	Qty.	Ref.	P/N	Description	Qty.
1	205-1013	rear impact guard	1	4	215-1090	butt connector (16-14 ga) w/heat shrink	8
2	300-2427	filter mount bracket	1	n/a	274-352	hi-vis stripe	3
3	215-1088	wire (16 ga 2 wire primary)	60"				

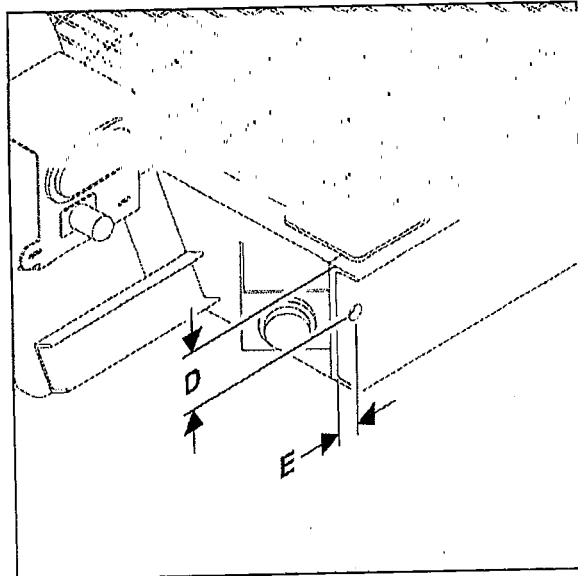
Rear Impact Guard

Install Rear Impact Guard

Drill Hole for Light Extension

1. Ensure that trailer light harness is disconnected from pulling vehicle.
2. Use the dimensions shown to drill a 1" (25 mm) hole into end of trailer.

Ref.	Measurement
D	4" (102 mm)
E	1.5" (35 mm)



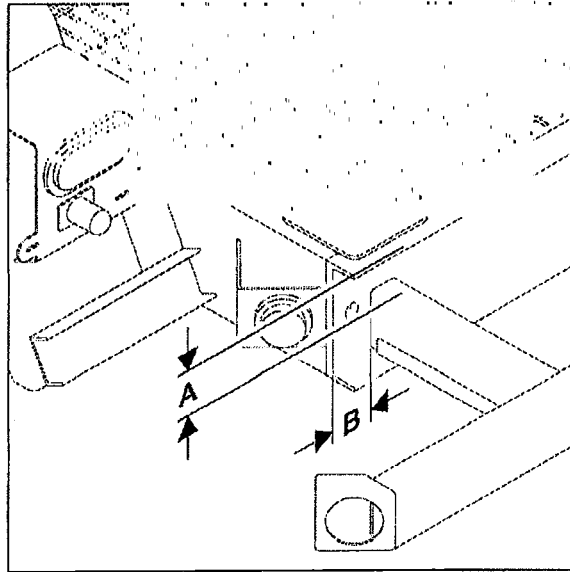
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Position Guard

1. Mark trailer in the general position where guard will be installed.

Ref.	Measurement
A	3 3/8" (86 mm)
B	3" (76 mm)

2. To prepare trailer for welding, use an abrasive disc or abrasive cleaner to remove paint.
3. Use blocks and shims to make a level surface for fitting up the guard according to the measurements in step 1.
4. Check that guard is level with trailer both from left to right and from fore to aft.



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NOTICE: Welding can damage electronics.

- Disconnect battery at battery disconnect switch before welding to prevent damage to battery. Do not turn off battery disconnect switch with engine running or alternator and other electronic devices may be damaged.
 - Connect welder ground clamp close to welding point and make sure no electronic components are in the ground path.
 - Always disconnect the ECU ground connection from the frame, harness connections to the ECU, and other electronic components prior to welding on machine or attachments.
5. Tack weld guard into place. Re-check position of guard. Re-check level.

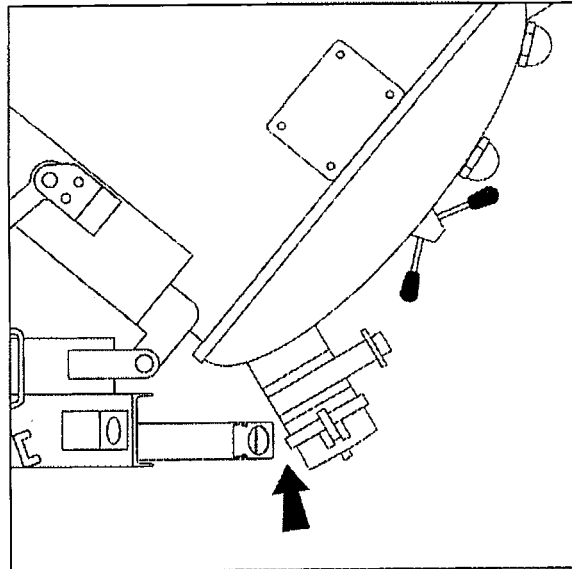
Rear Impact Guard

Test

1. Ensure that tank is empty. Turn battery disconnect switch to the on position and start unit.
2. Fully tilt tank.

NOTICE: Do not unlatch door with tank tilted up.

3. Check clearance between drain valve and impact guard as shown:
 - If valve clears guard, proceed with installation.
 - If valve does not clear guard, adjust position of guard. (Refer to measurement on page 4, step 1).
4. Return tank to horizontal position.
5. Stop unit and turn battery disconnect switch to the off position.



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Weld Guard

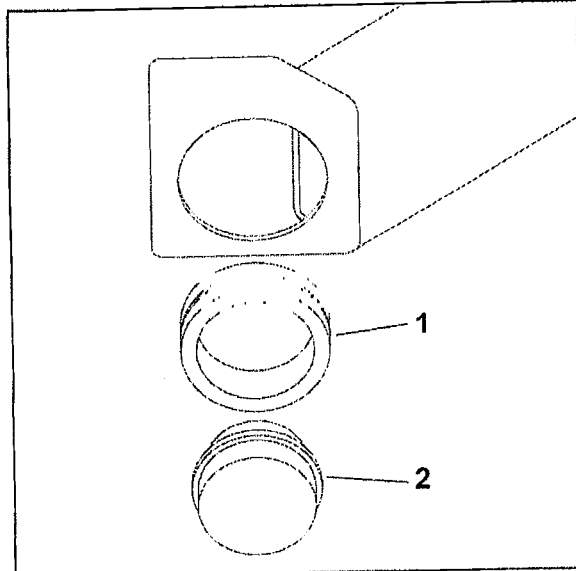
1. Use a 3/8" (10 mm) fillet weld on the top, left and right side of each mounting tube to secure guard to trailer.

NOTICE:

- Stick weld using a 7018 rod (tensile 70 KSI); or
 - MIG weld using wire equivalent to 7018, such as AWS class (ER70S-6).
2. Allow welds to cool, then inspect and repair if necessary.
 3. Clean welded area of slag and contamination. Paint to prevent rusting.

Move Marker Lights

1. Disconnect marker light from trailer harness. Remove marker (2) and large rubber grommet (1) from trailer and install on impact guard.

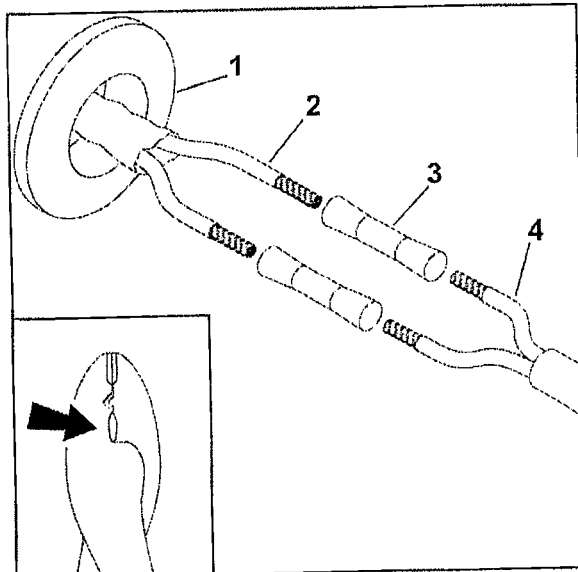


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2. Cut connector from trailer harness, leaving enough wire on the connector to splice.
3. Install grommet (1) into newly drilled hole. Thread trailer harness (2) through hole.
4. Cut extension wire (4) in half and prepare ends for splicing.

Note: Each half should measure approximately 30" (76 cm.) Use one half for each side of the trailer.

5. Use heat shrink connectors (3) to splice extension wire (4) to trailer harness (2):
 - Match wires WHT to WHT and BLK to BLK. Insert wires into connector and crimp.



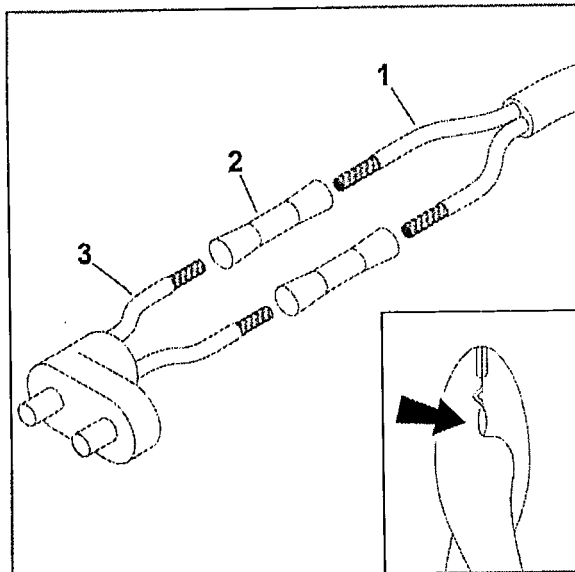
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NOTICE: To prevent damage to heat shrink tape, use smooth opening in pliers (shown) to crimp connectors.

- Apply heat to seal heat shrink connectors.

Rear Impact Guard

6. Use heat shrink connectors (2) to splice opposite end of extension wire (1) to marker connector (3).
- Match wires WHT to WHT and BLK to BLK. Insert wires into connector and crimp.
- NOTICE:** To prevent damage to heat shrink tape, use smooth opening in pliers (shown) to crimp connectors.
- Apply heat to seal heat shrink connectors.
7. Connect marker lights to harness.
8. Connect trailer harness to vehicle and test lights for proper operation.

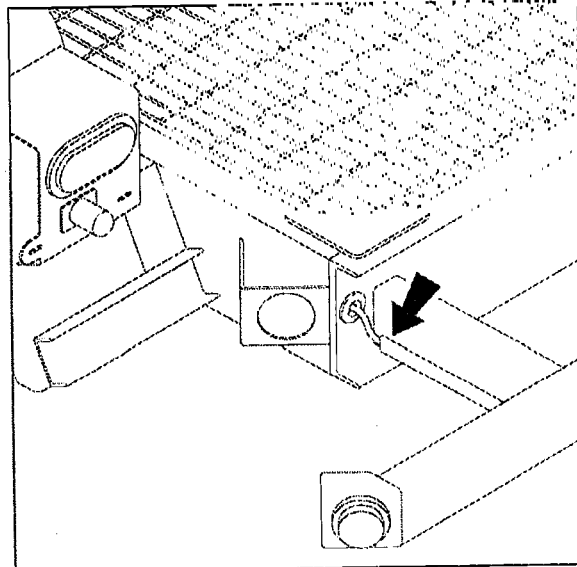


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9. Route wire through channel (shown). Use a rubber mallet to bend tracks up to protect wire.

NOTICE: Ensure that wire does not become pinched or kinked in the channel.

10. Cut original marker light holder from trailer. Grind to make smooth, then paint to prevent rusting.



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Modify Filter Canister Bracket



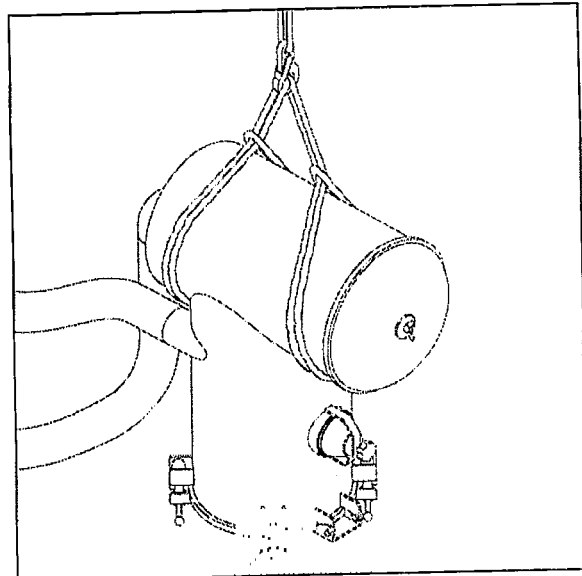
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WARNING Crushing weight could cause death or serious injury. Use proper procedures and equipment or stay away.

1. Use a hoist with two slings to support filter canister, as shown.

Note: Filter canister weighs 200-300 lb (91-136 kg).

2. Remove four bolts from canister bracket. Save hardware for reuse.
3. Move filter canister away from working area. (It is not necessary to disconnect any hoses or fittings.)



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Rear Impact Guard

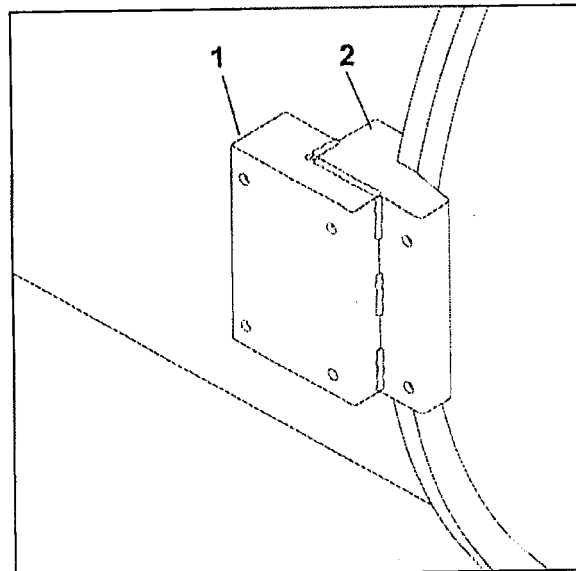
NOTICE: Welding can damage electronics.

Disconnect battery at battery disconnect switch before welding to prevent damage to battery. Do not turn off battery disconnect switch with engine running or alternator and other electronic devices may be damaged.

Connect welder ground clamp close to welding point and make sure no electronic components are in the ground path.

Always disconnect the ECU ground connection from the frame, harness connections to the ECU, and other electronic components prior to welding on machine or attachments.

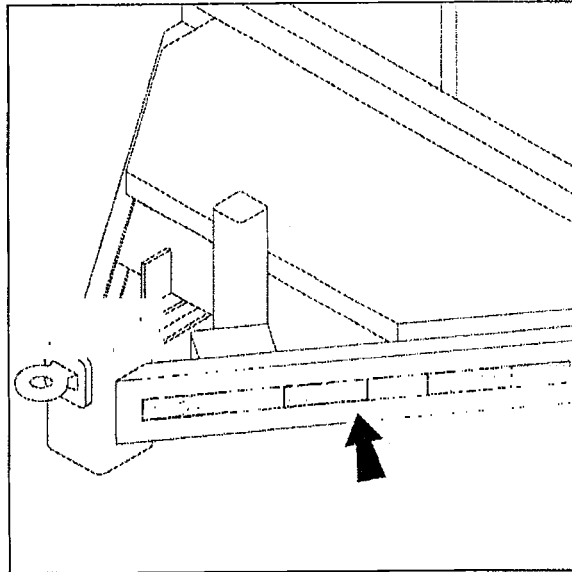
4. Mark bracket in general area where new bracket will be installed. Use an abrasive disc or abrasive cleaner to remove paint from weld area.
5. Position new bracket (1) as shown. Ensure that the top of the new bracket (1) is flush with the top of the original bracket (2). Clamp or tack weld into place.
6. Secure new bracket on top and left side with 1/4" (6 mm) fillet welds at 2" (51 mm) intervals (shown.)
7. Allow welds to cool, then inspect and repair if necessary.
8. Clean welded area of slag and contamination. Paint to prevent rusting.
9. Move filter canister into position and secure to new bracket using original hardware.



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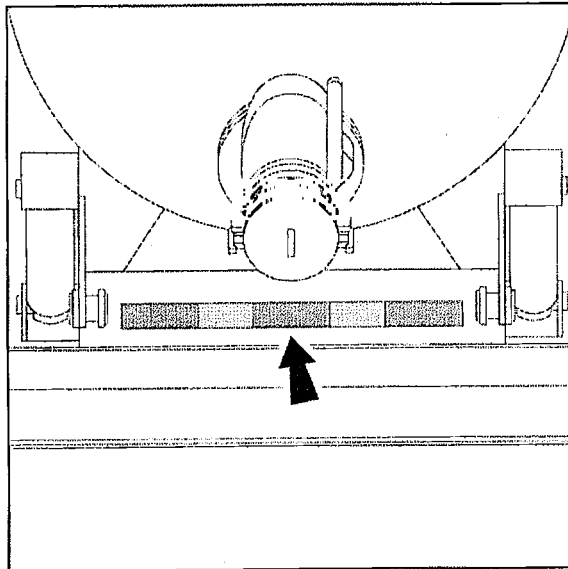
Install Reflective Tape

1. Install reflective tape on each side of trailer tongue as shown.



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2. Install reflective tape below rear of tank as shown.



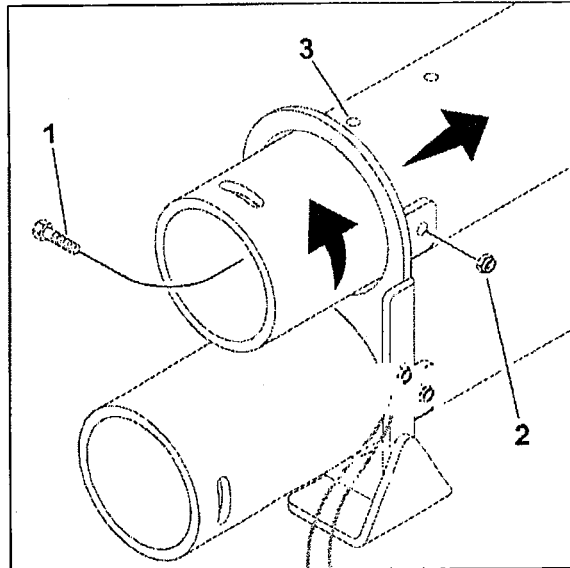
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Rear Impact Guard

Adjust Hose Storage Tube

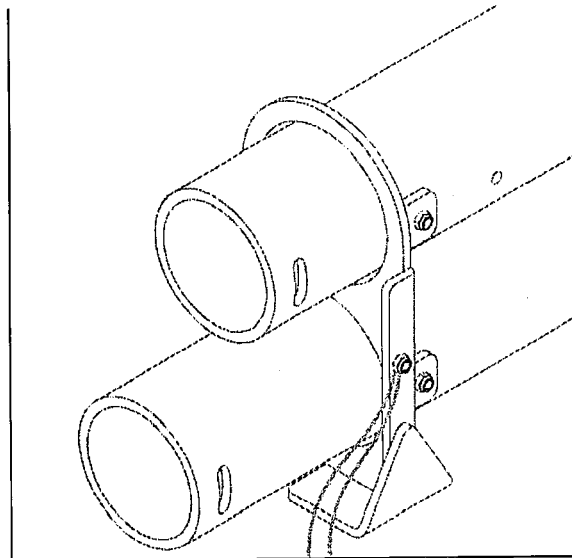
IMPORTANT: This procedure applies only to units equipped with hose storage tubes.

1. Remove hose from top storage tube.
2. Remove nut (2) and bolt (1) from tube mounting bracket.
3. Slide tube toward the front of the trailer.
4. Rotate tube until hole where bolt was installed is at the top.
5. Drill new hole (3) $\frac{7}{32}$ " (6 mm) in diameter 2.5" (64 mm) back from the first hole.



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6. Align new hole with hole in mounting bracket and install bolt and nut as shown.



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