



Service Bulletin

Bulletin Number: **SB-18-299 Revision B**
 Release Date: **September 28, 2018**
 Subject: **Inspection and Potential Replacement of Hydraulic Oil Tank Mounting Brackets**
 Distribution: **Affected Heil Dealers, Customer Service, Field Service**

NOTE: READ THIS BULLETIN IN ITS ENTIRETY BEFORE BEGINNING ANY REPAIR WORK.

Revision B of this Service Bulletin has an adjusted Product Affected table. The procedures in this Service Bulletin have not changed since Revision A.

This Service Bulletin addresses a mandatory inspection for cracks on Hydraulic Oil Tank Mounting Brackets on Heil Front End Loader (FEL), Automated Side Loader (ASL), and Rear End Loader (REL) units identified in the Products Affected section below. If one or both angle brackets fail, the hydraulic oil tank could become unstable, potentially coming loose from the frame rail.

The corrective action is to inspect for cracks on the two Hydraulic Oil Tank Mounting Brackets and replace both brackets if cracks are found on either of them. **Do not try to repair a cracked bracket.**

1. PLANNING INFORMATION

A. Products Affected

This Service Bulletin applies to the following units.

Unit Name	Invoice Date Range	Body Serial Number Range
Half/Pack®	06/05/2014 - 11/15/2016	HPE4956072 - HPE5008948 HPS4956294 - HPS5008956
Half/Pack® (featuring Odyssey™ Controls)	06/09/2014 - 11/15/2016	HPE4956387 - HPE5008925 HPS4956404 - HPS5008731
DuraPack® Python®	06/05/2014 - 11/15/2016	7D7305029 - 7D7305824 7E7304799 - 7E7305847 7S7304907 - 7S7305827
DuraPack® 7000	06/11/2014 - 10/31/2016	7D7304966 - 7D7305581 7E7304924 - 7E7305823 7S7304946 - 7S7305620
Rapid Rail®	06/11/2014 - 11/11/2016	RR8105244 - RR8321445
CP Python®	06/20/2014 - 11/19/2015	RR8321421 - RR8321447
Liberty®	01/29/2016 - 11/15/2016	RR8321438 - RR8321460
MultiPack®	07/25/2014 - 10/26/2016	MPF9101152 - MPF9101216
MultiTask SL®	06/25/2014 - 09/30/2014	DFD2001330 - DFD2001345
Formula® 4000	06/11/2014 - 10/31/2016	4F1020669 - 4F1020760
DuraPack® 5000	06/09/2014 - 11/15/2016	FP5021525 - FP5023387
PowerTrak® Commercial	06/09/2014 - 11/15/2016	FP5802373 - FP5822506
PowerTrak® Commercial PLUS	09/22/2014 - 06/29/2016	FP5822390 - FP5822521
PT 1000™	06/05/2014 - 11/11/2016	4F1302409 - 4F1312656
PT 4000™	08/29/2014 - 04/28/2016	4F1302436 - 4F1302708
DuraPack® 4060	07/30/2014 - 09/15/2016	FP5412005 - FP5412196





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Heil Environmental Service Bulletin procedures are intended for use by professional technicians, NOT a “do-it-yourselfer.” They are written to inform experienced technicians of conditions that may occur on some units, or to provide information that could assist in the proper servicing of a unit. Properly trained technicians have **access to and are familiar with the applicable Heil Operator’s Manual and Heil Parts & Service Manual** and have the equipment, tools, safety training, and know-how to do a job properly and safely. If a condition is described, DO NOT assume that the Bulletin instructions apply to your unit, or that your unit will have that condition. See your Heil Dealer to determine whether your unit may benefit from the information in this Service Bulletin.

B. Compliance

Each Dealer must perform these tasks as outlined in this Service Bulletin for each unit identified above in the Products Affected section no later than **March 28, 2019**. The tasks outlined in this Service Bulletin must be performed by a qualified technician.

C. Manpower

The labor effort required to accomplish the tasks in this Service Bulletin is shown in **Table 1**.

Table 1. Manpower

Task	Man Hours Required
Inspect Both Hydraulic Oil Tank Brackets for Cracks	0.5 hour
Replace Both Hydraulic Oil Tank Brackets (Only if Cracks are Found on Inspection)	1 hour

D. Tools, Materials, and Parts Needed

The tools and parts necessary to perform the rework are outlined in **Table 2**.

Table 2. Tools and Materials

Item	Part Number	Application
Personal Protective Equipment	Commercially available	Safety protection as required by employer
Wrench Set	Commercially available	
Drill	Commercially available	
Floor Jack or Hoist	Commercially available	To secure hydraulic oil tank during bracket replacement

Table 3. Parts

New Part Number	Description	Quantity Per Unit	Old Part Number	Special Instructions
311-6338	Angle Mounting Bracket	2	311-6006	New part is 2.5" x 3" HMS-STANA.10 angle instead of 1/4" HMS formed channel
FSP071124	HHCS, 1/2"-13 x 1-1/2"	6	N/A	Reuse from OEM bracket installation
FSP231100	Lock Nut, 1/2"-13, Gr. 5, Plated	6	N/A	Use NEW lock nuts (DO NOT REUSE)
FSP521100	Washer, Flat, 1/2", SAE, Plated	12	N/A	Reuse from OEM bracket installation
FSP071330	HHCS, 5/8"-11 x 2"	4	N/A	Reuse from OEM bracket installation
FSP321300	Lock Nut, 5/8"-11, Gr. 5, Plated	4	N/A	Use NEW lock nuts (DO NOT REUSE)
055-1391-007	Washer, 5/8" x 0.121 Thickness, Hardened Steel, Zinc Plated	8	N/A	Reuse from OEM bracket installation

2. PREPARE THE UNIT AND WORK AREA

Make sure that the unit is in **Lock-Out/Tag-Out mode** before performing re-work. Refer to and follow your company's Lock-Out/Tag-Out policies and procedures. At a minimum, refer to and follow the Lock-Out/Tag-Out procedure found in your Heil Service Manual. Always wear appropriate Personal Protective Equipment when repairing a unit or performing scheduled maintenance on a unit. Clear the work area around the unit of all unnecessary people and equipment.

3. CORRECTIVE ACTIONS

With the unit prepared as described in Paragraph 2 of this Service Bulletin, in **Lock-Out/Tag-Out mode**, carefully follow the steps below.

A. Inspect Hydraulic Oil Tank Mounting Brackets for Cracks

- (1) Inspect both hydraulic oil tank brackets for cracks. **NOTE:** The brackets will require periodic cleaning to ensure the inspector's visibility of any cracking is clear.
- (2) If any cracks are found, continue to Section 3.B. **NOTE:** If any bracket cracks are found, ALWAYS replace BOTH brackets.
- (3) If no cracks are found, no corrective action is required at this time.
- (4) **Hydraulic Oil Tank Mounting Bracket inspections should be added to the operator's pre- and post- trip inspection procedures.** Additionally, bracket inspections should be added to the regular Preventive Maintenance schedule to be inspected daily (every 8 hours of operation). **Replace BOTH brackets immediately if ANY cracks are found.**

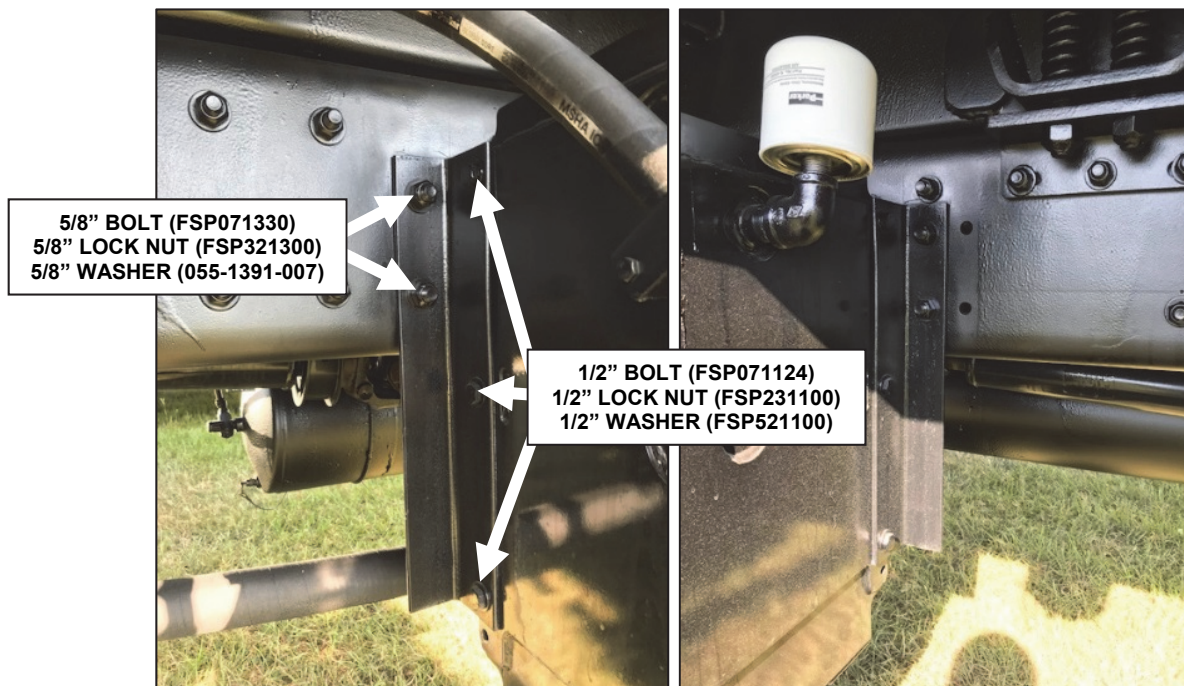


Figure 1. Hydraulic Oil Tank Mounting Bracket Locations (Each Side of the Hydraulic Oil Tank)



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B. Replace BOTH Hydraulic Oil Tank Mounting Brackets if ANY Cracks were Found

If any cracks were found on either of the two hydraulic oil tank brackets, follow the instructions below to replace **BOTH** brackets. **Do not try to repair a cracked bracket.**

WARNING

Depending on bracket configuration, it might be necessary to replace both hydraulic oil tank brackets at the same time, rather than replacing one at a time. Make sure that the hydraulic oil tank is supported and secured with a one (1) ton or greater rated floor jack or hoist.

- (1) Before removing the old hydraulic oil tank mounting brackets, support and secure the hydraulic oil tank with a one (1) ton or greater rated floor jack or hoist.
- (2) With the oil tank supported by the floor jack or hoist, on one side of the hydraulic oil tank, remove three (3) lock nuts, then three (3) bolts and six (6) washers attaching bracket to hydraulic oil tank. Keep the bolts and washers for reuse during the next steps. **Discard the lock nuts.**
- (3) Remove two (2) lock nuts from behind the frame rail, then remove two (2) bolts and four (4) washers attaching bracket to frame rail. Remove the bracket to use as a hole location template for Step (4). Keep the bolts and washers for reuse. **Discard the lock nuts.**
NOTE: The 1/2" diameter bolts, nuts and washers attach the bracket to the hydraulic oil tank flange, while the 5/8" diameter bolts, nuts and washers attach the bracket to the frame rail.
- (4) Using the old bracket as a template (bent edge to bent edge), mark the chassis mount bolt hole locations on the new Angle Mounting Bracket (311-6338), then drill 11/16" holes through the new bracket at those locations. The bracket will already be predrilled for the tank mounting bolts.
- (5) Install the new Angle Mounting Bracket to the oil tank by installing three (3) bolts (FSP071124), six (6) washers (FSP521100) and three (3) NEW lock nuts (FSP231100) to the hydraulic oil tank flange. The washers are positioned against the bolt head and against the nut. **Do not reuse any lock nuts from Step (3). Use NEW lock nuts.**
- (6) Install two (2) bolts (FSP071330), four (4) washers (055-1391-007) and two (2) NEW nuts (FSP321300) to the bracket/frame rail. The washers are positioned against the bolt head and against the nut. **Do not reuse any lock nuts from Step (3). Use NEW lock nuts.**
- (7) Repeat Steps (2) through (5) of this procedure for the other bracket.

Inspections, corrective actions, reimbursements and reporting of these actions to/from Heil, Heil Dealers, Heil Customers/End Users, and National Highway Traffic Safety Administration (NHTSA) shall comply with NHTSA regulations including Federal Motor Vehicle Safety Standards (FMVSS). **All repairs must be documented.** Heil Dealers and Service Centers must file claims electronically using Heil's online warranty system. Labor will be reimbursed at one-half (0.5) hour for Hydraulic Oil Tank Mounting Brackets inspection and, **only if needed**, one (1) hour for replacement of both Hydraulic Oil Tank Mounting Brackets. All re-work must be completed within six (6) months of the issuance of this Service Bulletin (by March 28, 2019).

If you have any questions regarding the information detailed in this Bulletin, please contact Heil Technical Service at 866.310.4345.

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