

Vermeer MV Solutions, Inc.

Trenchless
 Piedmont, South Carolina 29673 USA

FIELD CAMPAIGN KIT #: VMV000103
For Dealer Reference: Service Bulletin #: SMV2025-007

DATE: 2025 April 15

Frame Update Kit - Heavy Units

CAMPAIGN TYPE:	Mandatory – Product Safety DEALER INSTALLATION ONLY QUALIFIED WELDER REQUIRED
CAMPAIGN CATEGORY:	Kit and Bulletin

MACHINE/ ATTACHMENT MODEL(S):	SERIAL NUMBERS:		Kit version
	Included	Excluded	
LPXDT	See attached listing on page 21 of this kit instructions for specific VIN and serial/unit numbers.	None	VMV01
LPSGT	See attached listing on page 21 of this kit instructions for specific VIN and serial/unit numbers.		
LPSDT	See attached listing on pages 22 – 27 of this kit instructions for specific VIN and serial/unit numbers.		



Purpose: TRAILER FRAME FAILURE MAY OCCUR. In certain applications, higher than expected loads increase the risk of a crack developing in the trailer frame. If a crack goes undetected the frame crack can start bending or distorting the frame. A crack in the trailer main frame could result in a loss of stability while towing. **DEATH OR SERIOUS INJURY POSSIBLE.** When towing the vacuum excavator trailer on public roadways, **death or serious injury** may result due to the loss of control of the vacuum excavator trailer and towing vehicle. A frame failure may increase the risk of a crash. Property or equipment damage may also occur.

VMV000103 has been created to provide the necessary parts and instructions to add reinforcement plates to the trailer frame. **The kit must be installed as soon as possible.**



WARNING: Use the following shutdown procedure before attempting to do any of the work described in this kit.

Stopping the machine

1. Make sure end of vacuum hose is clear of all spoils, debris, and other materials.
2. Turn *Water Pump Switch* to **off**.
3. Push *Throttle Switch* down to slow the engine to idle.
4. Idle engine five minutes to allow vacuum pump to cool down. This helps to prevent the buildup of condensation.
5. Turn *Keyswitch* to **off** to shutdown engine.
6. Pull trigger on high pressure lines to relieve line pressure.



WARNING: If pressure is not relieved, serious injury may occur when attempting to disconnect water lines. Make sure water tools are pointed in a safe direction away from people.

- Unless indicated, new parts from kit have callouts with numbers. Callouts with letters indicate existing parts or general items.



WARNING: Pressurized fluid can penetrate body tissue and result in death or serious injury. Leaks can be invisible. Keep away from any suspected leak. Relieve pressure in the hydraulic system before searching for leaks, disconnecting hoses, or performing any other work on the system. If you must pressurize the system to find a suspected leak, use an object such as a piece of wood or cardboard rather than your hands. When loosening a fitting where some residual pressure may exist, slowly loosen the fitting until oil begins to leak. Wait for leaking to stop before disconnecting the fitting. Fluid injected under the skin must be removed immediately by a surgeon familiar with this type of injury.

These instructions are for adding the reinforcement plates to the LP873 heavy trailer frames. All cutting, grinding, and welding should be done by qualified personnel. Lifting and removal of components should be done with properly rated equipment (cranes, lifting devices, etc.) During disassembly, the frame should be inspected for cracks. Any cracks that cross from the flange into the web of the I-Beam cannot be repaired and the trailer should be replaced. Cracks solely in the flange or solely in the web of the I-Beam should be repaired as described in the "Cracks" section on page 4. Any cracks in brackets should be repaired, if possible, or the part replaced if necessary.

Vermeer Corporation Welding Instructions

- **Scope:** These field welding instructions are intended for use on weld repairs and addition of stiffener plates on the LP 873 heavy trailer frame, drawing W2-LP08-T-S5.
- **Limitations:** These welding instructions are intended for use only with Vermeer Corporation supplied or approved components and as directed by Vermeer Corporation.
- **Certifications:** All welding shall be performed by a welder qualified in the position and process used to AWS D14.3/D14.3M, Specification for Welding Earthmoving, Construction, and Agriculture Equipment or one of the following: AWS D1.1, ASME Section IX, ISO 9606-1.
- **Work Area Preparation & Safety:** The company performing the welding is responsible for supplying the appropriate protective equipment, complying with the appropriate safety regulations (e.g., ANSI Z49.1), and taking appropriate measures to protect their personnel in the welding environment. Further, they are responsible for protecting sensitive equipment and components from the hazards of welding (e.g., shielding electronics, paint, plastics, etc. from the heat, light, and sparks of arc welding). Follow the battery and/or controller disconnection specifications in the machine service manual. Disassemble the machine per instructions that follow.

Cracks

Prepping the crack(s) for repair: Determine overall crack length by visual inspection and/or preferably by magnetic particle or dye penetrate. Appropriately clean area before performing test. Mark the extent of the cracks to guide cutting/gouging them out.

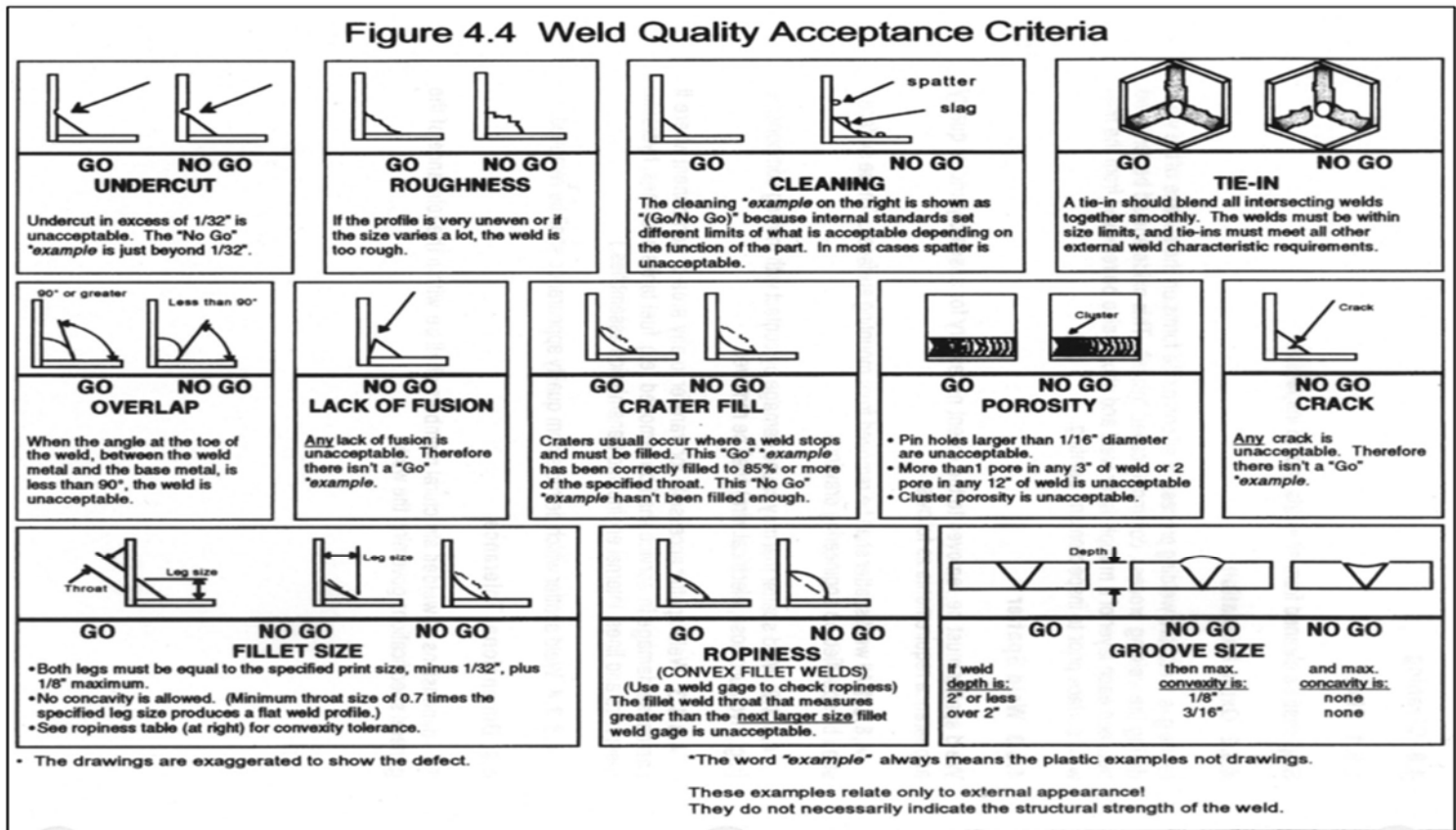
- 1) Once end of crack location is determined, drill a 1/8" diameter hole through the beam where the crack tip ends. If end location of crack is difficult to determine, then drill the hole 1/4" away from where the crack is believed to end to be safe.
- 2) Use a cut-off wheel or other appropriate tool to grind out the crack along its length. Cut out any cracked welds in the area too. Go from the origin of the crack to the OD of the hole that was drilled. Then widen root opening to 1/8" along the entire length of the crack area. The resultant should be a 1/8" wide cut in the beam that starts at the edge and goes to the drilled hole (reference figure 3) for flanges. For the web, the crack should be gouged out until no cracks are visible, which may or may not be through the entire web (reference figure 10).
- 3) Reinspect to ensure the entirety of the crack(s) has been removed. Use the same inspection process selected in step 1. If any remaining crack is found, repeat steps 1- 4.
- 4) At this time, clean all weld surfaces with a grinder. Surfaces within 1/2 inch [12 mm] of weld locations shall be free from any material that will prevent proper welding. This includes moisture, loose or thick mill scale, paint, slag, heavy rust, grease, dirt, or any other foreign material that will adversely affect the quality or strength of the weld.

Welding of crack(s): Follow the weld parameters and guidelines that are later in the document during this procedure.

- 1) Verify straightness of beam is still proper before welding.
- 2) For web cracks, weld the area that was gouged. Weld does not need to be ground flat as nothing is welded to this face. If cracks were through the beam, back gouge through the opposite side and weld the area on this face as well.
- 3) For flange cracks, start by using a run-on tab(s) (small piece of scrap metal) and tack to the inside edge of the beam frame so you can start the weld here and not the frame. This will increase the chance of a good quality edge tie-in. Use two pieces if necessary and set the same 1/8" root opening, the size of the run-on tabs is not important, only to match the 1/4" frame thickness.
- 4) Once run-on tab is tacked, weld the top side (inside) of the I-beam frame. Begin on the run-on tab and end where the hole is located.
- 5) Next, back gouge from the bottom side to sound metal using appropriate means (grind or carbon arc.) A full penetration weld is required here so be sure to verify gouge is deep enough.
- 6) Once back gouge is complete, finish the overhead weld.
- 7) When welding is complete here, cut off run-on tab and grind edges smooth. Also grind the top and bottom sides of the repaired weld face flat if the reinforcement is beyond 1/8" high or the toe angles are not optimal. (If weld looks good, you will still have to grind the top side (inside) weld because a plate sits there).
- 8) Retest finished weld by dye penetrant or magnetic particle to verify no cracks occurred during the repair process and weld repair is acceptable.

Final work:

- 1) Inspect all welds in accordance with the weld quality acceptance criteria listed on Figure 4.4. Repair any defective welds and reinspect. If defects (no go) are found, remove and repair them using one of the weld processes listed in this document.
- 2) Remove any temporary tacks that are outside weld joints.
- 3) Grind any hard notches or unacceptable weld profiles down. Pay particular attention to having a smooth leading etch on the run-out weld beads from the stiffener plates.
- 4) Reinspect general area to be sure no cracks formed during the repair process.
- 5) Paint area as required once weld has cooled.



Allowable Welding

- **Gas Metal Arc Welding [GMAW/MIG/MAG]:**

- Environment: This process shall only be used when welding can be performed in a shop environment and the weld joints can be positioned in the flat or horizontal positions. If vertical or overhead welding is required, FCAW or SMAW are recommended.
- Electrode: AWS classification ER70S-3 or ER70S-6 [ER48-S6] (e.g., Lincoln L50 or L56)
- Size: 0.045" [1.2 mm]
- Wire Feed Speed: Minimum 350 IPM [9 MPM] - Maximum 520 IPM [13 MPM] (optimum 450 IPM [11.5 MPM])
- Voltage: Minimum 26 volts - Maximum 30 volts (optimum 27.5 volts)
- Amperage: Amperage is a function of wire feed speed, but should read in the range of 250-370
- Electrode Stickout: ½ " – ¾ " [12 mm – 20 mm]
- Shielding Gas: 95% Argon - 5% Oxygen or 90% Argon - 10% CO2 at 40 cfh [1.1 cmh]
- Position: All welding should be in the flat or horizontal position. Vertical welding shall be uphill. No downhill welding is permissible.

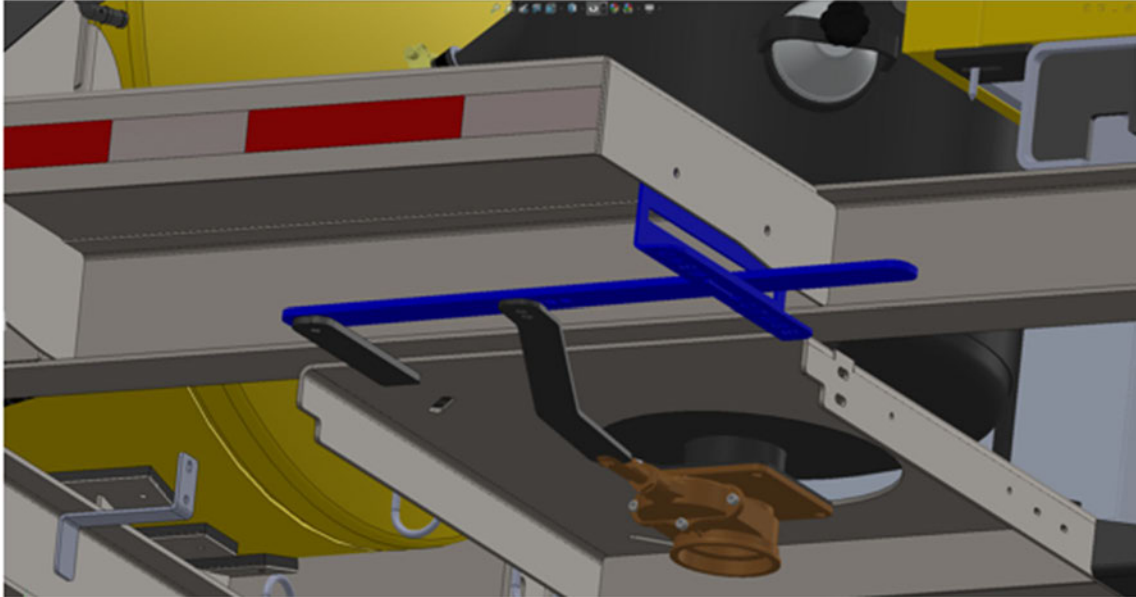
- **Flux Core Arc Welding [FCAW]:**

- Environment: This process should only be used when welding can be performed in shop environment for all welding positions. Protect the area from wind and moisture. If field welding is required, SMAW is recommended.
- Electrode: AWS classification E71T-1M [E491T-1M] (e.g., Lincoln Ultracore 71A85)
- Size: 0.052" [1.3 mm] or 1/16" [1.6mm]
- Wire Feed Speed: Minimum 200 IPM [5 MPM] - Maximum 500 IPM [13 MPM]
- Voltage: Minimum 23 volts - Maximum 30 volts
- Amperage: Amperage is a function of wire feed speed, but should read in the range of 220-370
- Electrode Stickout: ¾ " – 1 " [20 mm – 25 mm]
- Shielding Gas: See electrode manufacturer recommendation (usually 75Ar/25CO2 or 100 CO2@ 40 cfh [1.1 cmh])
- Position: Flat, horizontal, vertical, and overhead positions are permissible. Vertical welding shall be uphill. No downhill welding is permissible.

Procedure 1:

Prepare the Unit for Installation Process

- Thoroughly clean the unit. Use the wash wand, soap, and water. This will help reduce contaminants in the welds and make it easier to paint.
- Remove the Baghouse Drain Handle and the Bracket that the handle rides in. Store the parts until re-assembly.



Remove the Boom

- Disconnect the Hydraulic lines, Plunger Wash lines and Electrical lines. Cap the hydraulic lines to prevent intrusion.



Hydraulic Lines

Electric Lines

- Remove the Bolts on the Slew Drive to disconnect from the Tank.
- Lift the boom off the unit and store until re-assembly.

Disconnect the Tank

- Unhook Hydraulic lines to the lift cylinders – Cap lines to prevent intrusion.



Hydraulic Lines

- Remove the pins from the bottom of the tank lift cylinders.



Lifting Cylinder Pins

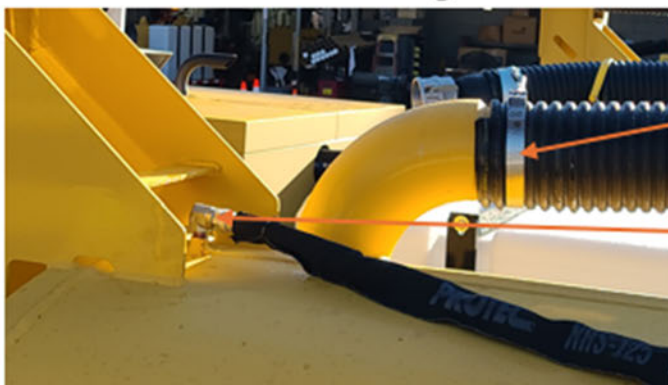
- Unhook the hydraulic lines running up to the Door Unlock Cylinder and Door Open cylinder.



Hydraulic Lines



- Unhook any light bar electrical wires. Drape all hoses and lines out of the way.
- Remove the Debris Hose and unhook the tank washout hose from the Top of the tank. Verify nothing is attached to the tank.



Debris Hose

Washout Hose

- Remove the bolts holding the rear bearings in the Frame Towers.



4 Bolts
each side

Lift the tank

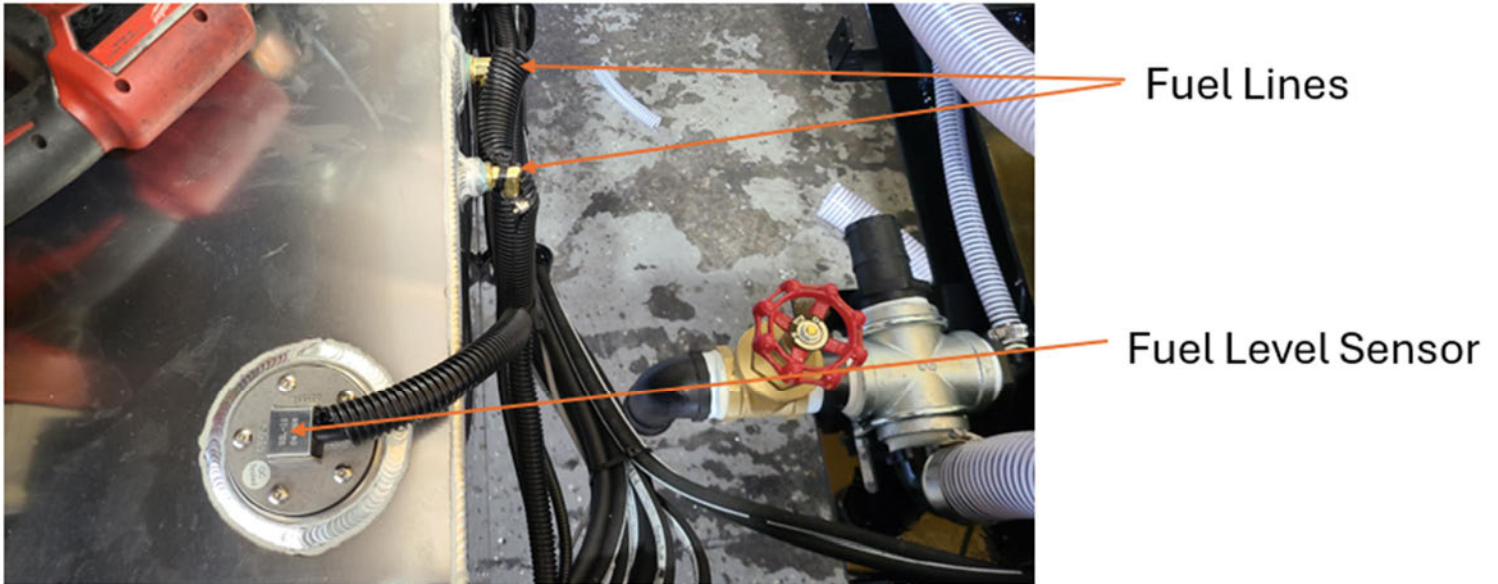
- Verify nothing is attached to the tank from the trailer.
- Using a crane or other suitable lifting device, lift the debris tank off the trailer.



- Store until re-assembly.

Remove the Fuel Tank

- Drain the fuel tank.
- Disconnect the hoses and electrical lines running to the fuel tank. Cap the lines to prevent intrusion.



- Unbolt the fuel tank from the bottom.
- Slide the tank to the rear and lift off the unit.



- Store the tank until re-assembly.

Remove Water Tank Cross Over Lines

- Remove the water tank cross over lines. The hoses will need to be cut to get them off the pipe nipples. Discard any hoses that are cut, there are replacement hoses included in the kit (P/N's 135020225 and 135020226).
- Remove the two $\frac{3}{4}$ " lines from the antifreeze valve. These hoses may need to be cut. Discard any cut hoses. There are replacement hoses in the kit (P/N's 135020223 and 135020224).

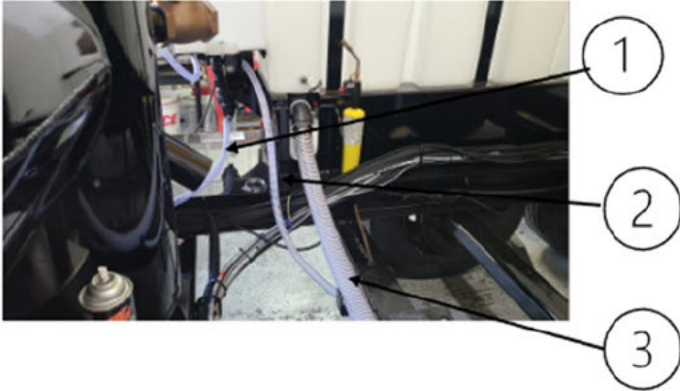


Figure 9

Prepare the Trailer for Cutting and Welding

- Tie the wires, hoses, and hydraulic lines up out of the way for cutting grinding and welding. Use weld blankets and bent metal shields where necessary.

Rear Trailer Gussets and Plates

- Cut the rear gussets off the trailer. Use a torch and/or grinder.
- Cut the plate off the I-Beam.



Rear Trailer Gussets and Plates

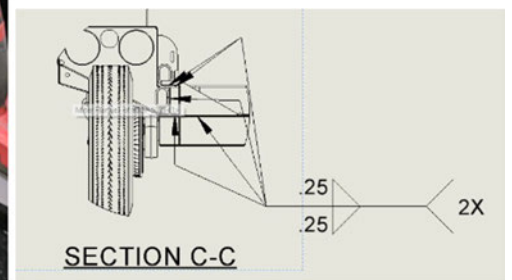
- Grind the welds back to parent material in the I-Beams.



- Weld the new gusset (P/N 135019627) in place between the cross member I-Beam and side rail I-Beam.



Figure 1



- Weld the gusset plate (P/N 135008253) onto the I-Beam.
- Weld the smaller gusset plate (P/N 135008258) onto the I-Beam.

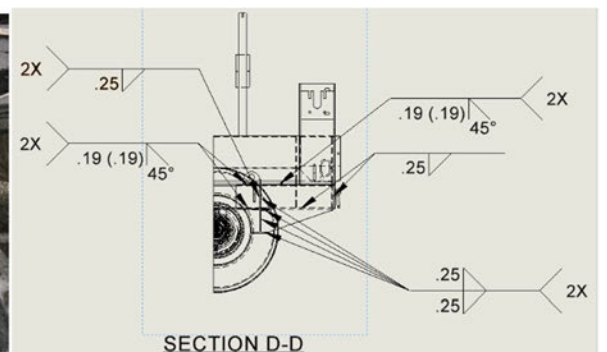
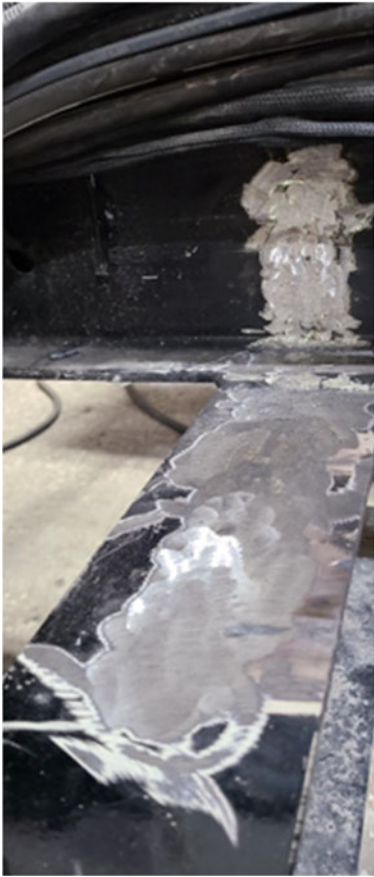


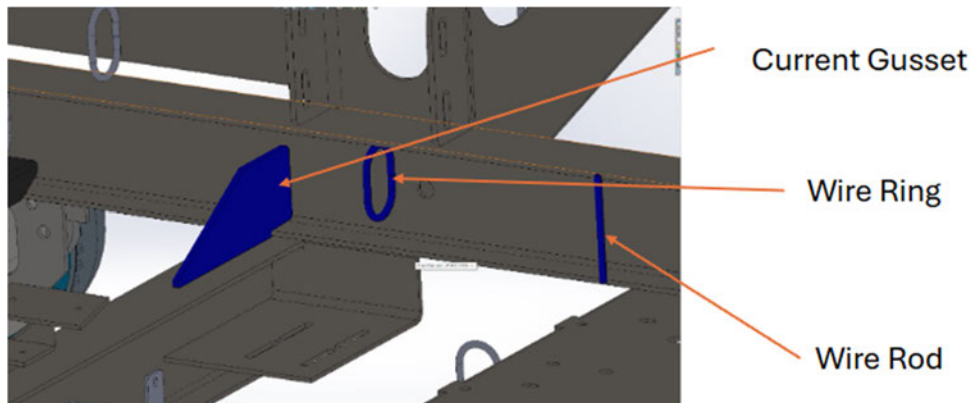
Figure 2

Mid Trailer Frame Gussets

- Cut the front gussets from the trailer. Grind the welds back to the parent material.



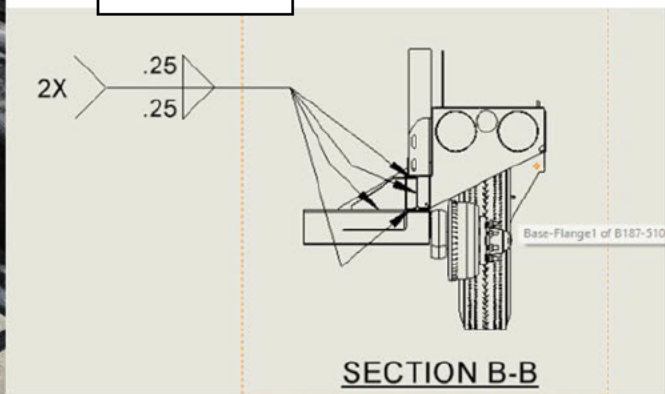
- Remove the wire ring or angle bracket near the fender reinforcement bracket. Disconnect the side marker lights and pull the wire out.
- It may be necessary to cut the wire rod or tube that holds the hydraulic lines where the belly pan meets the I-Beam on the left of the trailer.



- Weld the front gusset (P/N 135019659) onto the trailer (it welds at a slight angle).



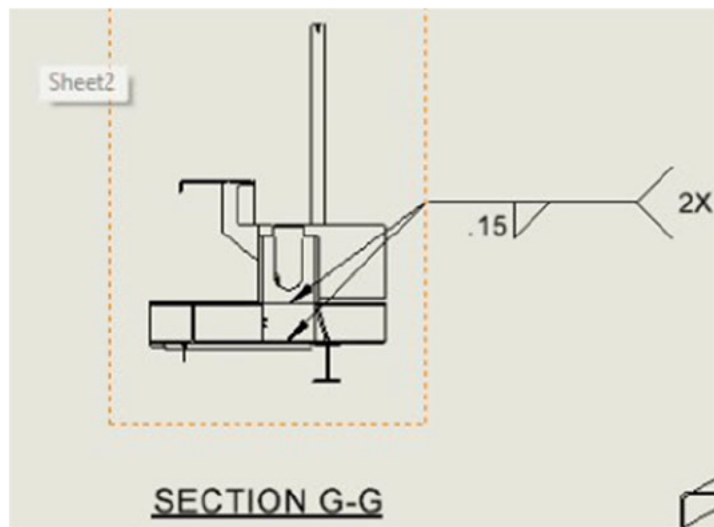
Figure 3



- Weld the I-Beam reinforcement (P/N 135019965) in front of the gusset. Be sure the two holes are towards the front of the unit.



Figure 4

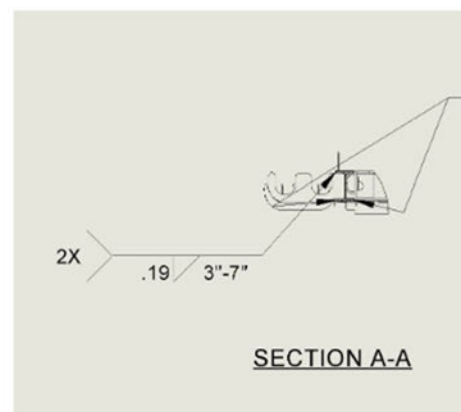
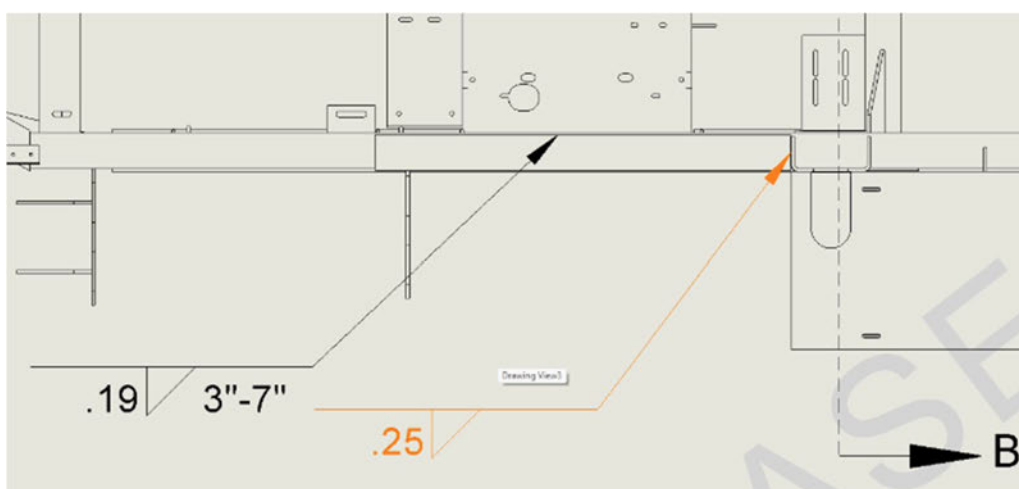


Top and Bottom I-Beam Reinforcements

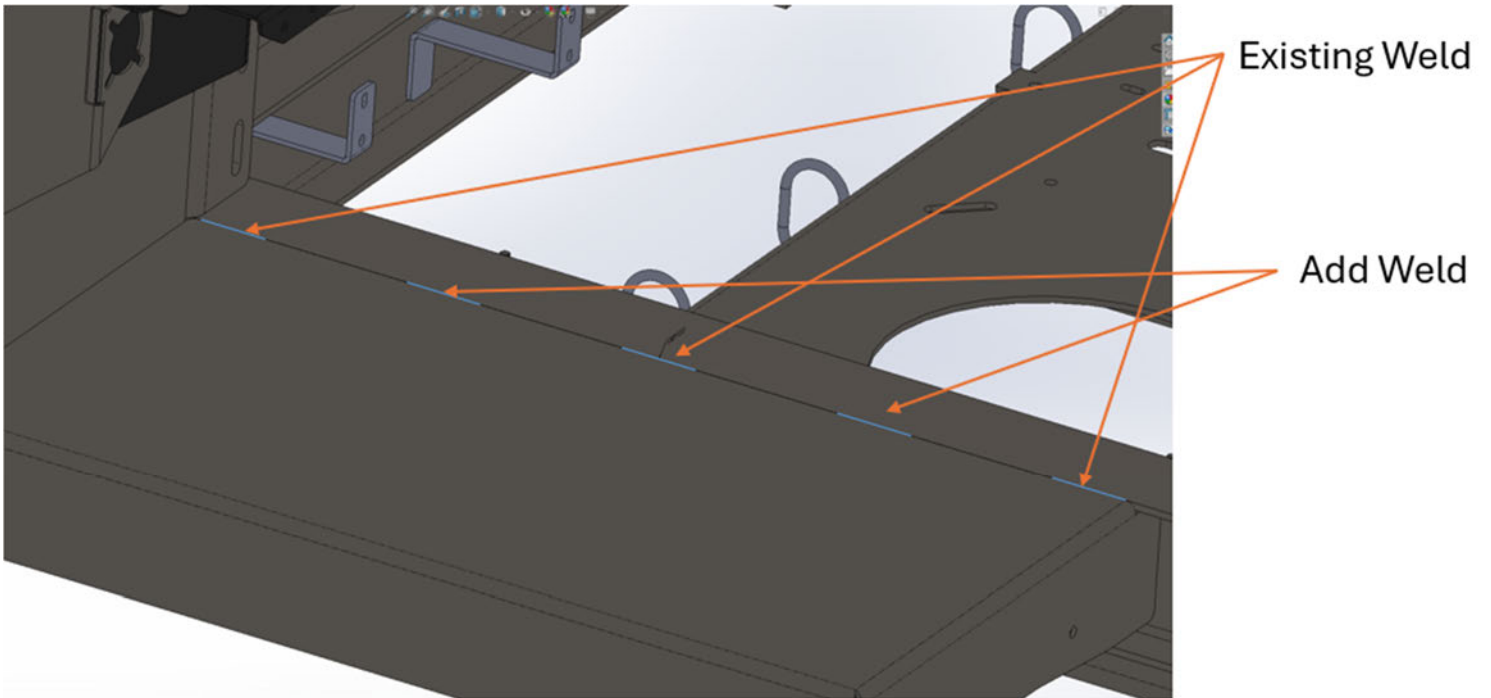
- Weld the left-hand top reinforcement (P/N 135019311) on the trailer.



Figure 5



- Add 2 more stitch welds to the platform. Grind all the welds flat.



- Weld the right-hand top reinforcement (P/N 135019311) on the trailer.

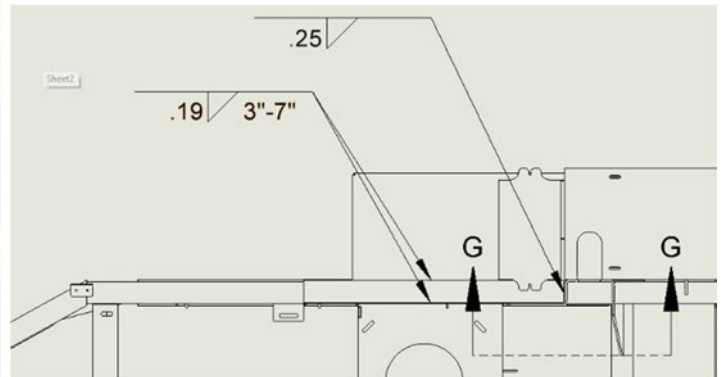
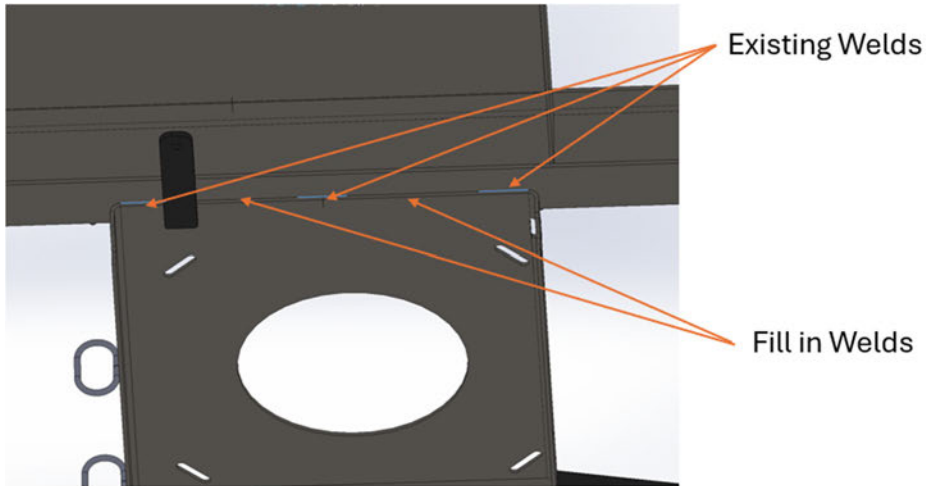
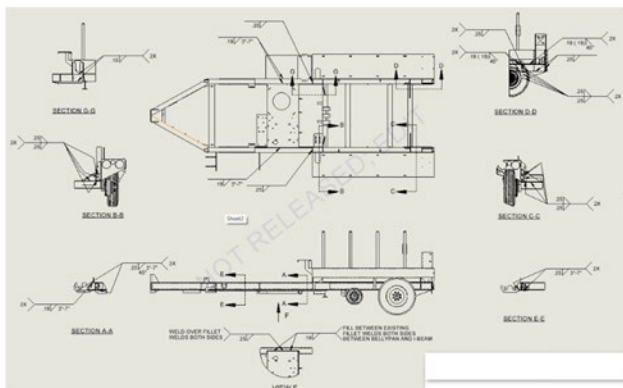
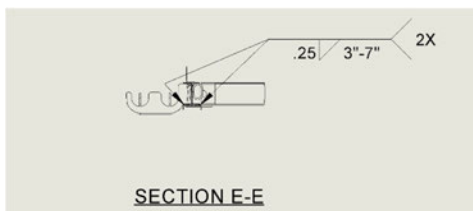


Figure 5

- Fill the stitch welds between the I-Beam and the belly pan on the bottom, both sides.

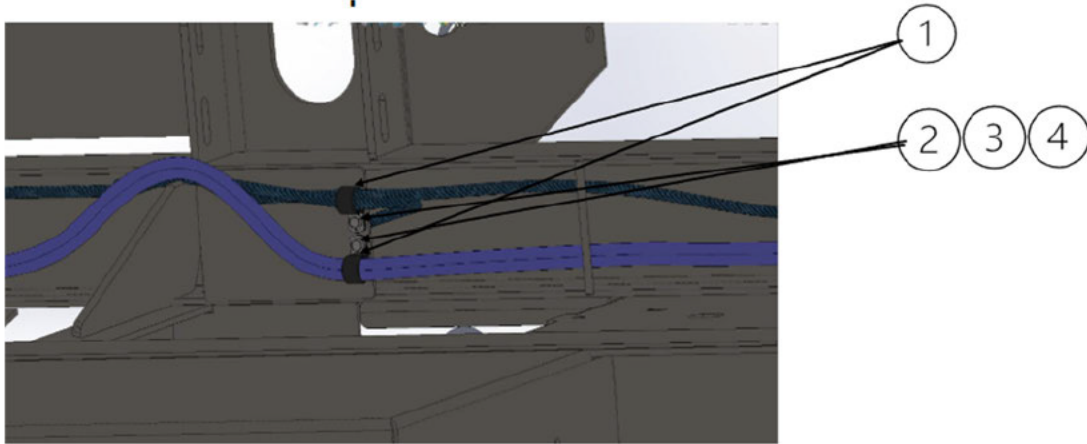


- Position the lower reinforcements (P/Ns 135019314 and 135019613) on the trailer. Mark any areas that interfere with the welds on the belly pan and cut/grind them away.
- Weld the reinforcement onto the bottom of the trailer taking care not to burn any hoses, lines, or wires.



Hose Constraints

- Right-side hydraulic hoses (2) previously constrained by the wire loop should be constrained by a 1" P-Clip (P/N 135012897).
- Right-side hydraulic hoses (2) previously constrained by the wire loop should be constrained by a 1" P-Clip (P/N 135012897).



- Left-side hydraulic hoses (2) previously constrained by the wire loop should be constrained by a 1" P-Clip (P/N 135012897).
- The right-side wire harnesses (2) should be constrained by another of the same P-Clip.

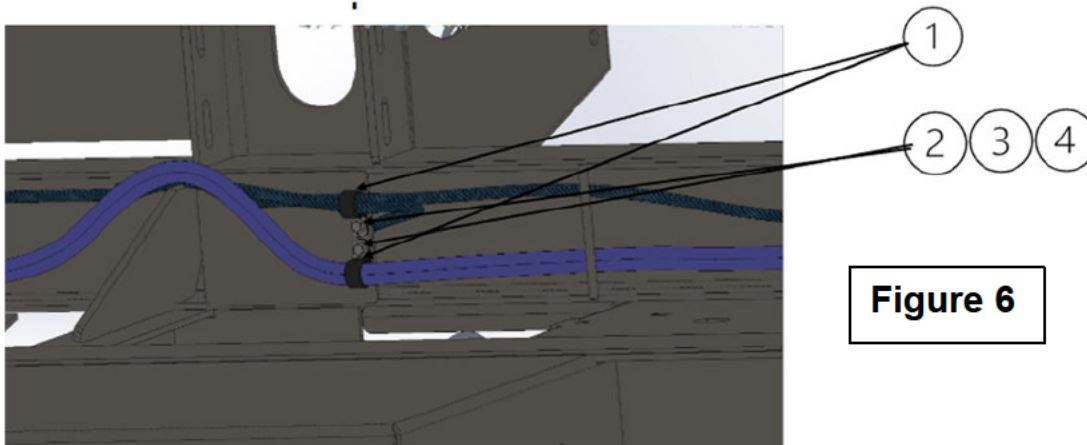
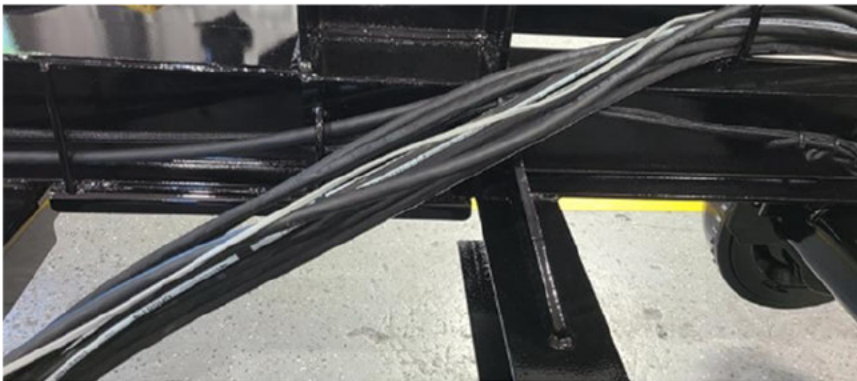


Figure 6



Paint

- Mask the various hydraulic lines, hoses, and electrical lines.
- Prime any areas of bare metal then paint it black.
- Re-Assemble the unit.

Decals

- Replace damaged/covered stickers.
- Conspicuity Tape
 - Inside the rear cross member



- Hydraulic Oil Decal
 - Left-hand rail near hydraulic pump



Figure 7

- Water Tank Drain Decal
 - Left-hand rail near drain valve



Figure 8

LPXDT AFFECTED MACHINES - VMV010103					
MODEL	VIN	SERIAL/UNIT		MODEL	SERIAL/UNIT
LPXDT		191764		LPXDT	301222
LPXDT		191765		LPXDT	301223
LPXDT		191801		LPXDT	301571
LPXDT		191802		LPXDT	304606
LPXDT		200035		LPXDT	304769
LPXDT		210054		LPXDT	304770
LPXDT		300855		LPXDT	304765
LPXDT		301221		LPXDT	304768

LPSGT AFFECTED MACHINES - VMV010103					
MODEL	VIN	SERIAL/UNIT		MODEL	SERIAL/UNIT
LPSGT		191804		LPSGT	301454A
LPSGT		210028		LPSGT	304448
LPSGT		210055		LPSGT	304458
LPSGT		300251		LPSGT	304799
LPSGT		300912		LPSGT	304931
LPSGT		300913			

LPSDT AFFECTED MACHINES - VMV010103					
MODEL	VIN	SERIAL/UNIT	MODEL	VIN	SERIAL/UNIT
LPSDT		191610	LPSDT		200287
LPSDT		191611	LPSDT		200212
LPSDT		191641	LPSDT		200206
LPSDT		191642	LPSDT		200294
LPSDT		191707	LPSDT		200489
LPSDT		191738	LPSDT		200416
LPSDT		191739	LPSDT		200347
LPSDT		191772	LPSDT		200388
LPSDT		191776	LPSDT		200391
LPSDT		191862	LPSDT		200473
LPSDT		191864	LPSDT		200325
LPSDT		200003	LPSDT		200420
LPSDT		191812	LPSDT		200421
LPSDT		191813	LPSDT		200422
LPSDT		191814	LPSDT		200452
LPSDT		200004	LPSDT		200412
LPSDT		200032	LPSDT		200482
LPSDT		200077	LPSDT		200411
LPSDT		200091	LPSDT		200419
LPSDT		200139	LPSDT		200500
LPSDT		200176	LPSDT		200501
LPSDT		200270	LPSDT		200503
LPSDT		200182	LPSDT		200414
LPSDT		200183	LPSDT		200673
LPSDT		200184	LPSDT		200592
LPSDT		200205	LPSDT		200611
LPSDT		200204	LPSDT		200612
LPSDT		200198	LPSDT		200613
LPSDT		200194	LPSDT		200619
LPSDT		200241	LPSDT		200633
LPSDT		200108	LPSDT		200634
LPSDT		200109	LPSDT		200636
LPSDT		200271	LPSDT		200614
LPSDT		200279	LPSDT		200615
LPSDT		200280	LPSDT		200616
LPSDT		200281	LPSDT		200617
LPSDT		200282	LPSDT		200561
LPSDT		200210	LPSDT		200698
LPSDT		200283	LPSDT		200709
			LPSDT		200708

LPSDT AFFECTED MACHINES - VMV010103

MODEL	VIN	SERIAL/UNIT	MODEL	VIN	SERIAL/UNIT
LPSDT		200710	LPSDT		300163
LPSDT		200711	LPSDT		300247
LPSDT		200694	LPSDT		300490
LPSDT		210006	LPSDT		300261
LPSDT		210007	LPSDT		300297
LPSDT		210008	LPSDT		300454
LPSDT		210009	LPSDT		300461
LPSDT		210033	LPSDT		300462
LPSDT		210035	LPSDT		300463
LPSDT		210036	LPSDT		300464
LPSDT		210038	LPSDT		300482
LPSDT		210039	LPSDT		300483
LPSDT		210041	LPSDT		300488
LPSDT		210042	LPSDT		300744
LPSDT		210040	LPSDT		300484
LPSDT		210084	LPSDT		300485
LPSDT		210053	LPSDT		300486
LPSDT		210073	LPSDT		300489
LPSDT		210074	LPSDT		300492
LPSDT		210075	LPSDT		300582
LPSDT		210076	LPSDT		300593
LPSDT		210077	LPSDT		300597
LPSDT		210078	LPSDT		300598
LPSDT		210133	LPSDT		300599
LPSDT		210037	LPSDT		300602
LPSDT		210072	LPSDT		300649
LPSDT		210166	LPSDT		300651
LPSDT		210173	LPSDT		300652
LPSDT		210174	LPSDT		300653
LPSDT		210175	LPSDT		300676
LPSDT		210205	LPSDT		300677
LPSDT		300039	LPSDT		300678
LPSDT		300043	LPSDT		300679A
LPSDT		210172	LPSDT		300687
LPSDT		300132	LPSDT		300695
LPSDT		300133	LPSDT		300696
LPSDT		300134	LPSDT		300680
LPSDT		300135	LPSDT		300698
LPSDT		300149	LPSDT		300699
LPSDT		300150	LPSDT		300779

LPSDT AFFECTED MACHINES - VMV010103

MODEL	VIN	SERIAL/UNIT	MODEL	VIN	SERIAL/UNIT
LPSDT		300780	LPSDT		301442
LPSDT		300681	LPSDT		301286
LPSDT		300823	LPSDT		301447
LPSDT		300848A	LPSDT		301467
LPSDT		300857	LPSDT		301448
LPSDT		300858	LPSDT		301466
LPSDT		300859	LPSDT		301481
LPSDT		300907	LPSDT		301482
LPSDT		300908	LPSDT		301483
LPSDT		300921	LPSDT		301484
LPSDT		300922	LPSDT		301485
LPSDT		300930	LPSDT		301486
LPSDT		300697	LPSDT		301487
LPSDT		300931	LPSDT		301488
LPSDT		300932	LPSDT		301518
LPSDT		300940	LPSDT		302310
LPSDT		300969	LPSDT		301677
LPSDT		300970	LPSDT		301678
LPSDT		300971	LPSDT		301790
LPSDT		300973	LPSDT		301793
LPSDT		300999	LPSDT		301903A
LPSDT		300878A	LPSDT		301942
LPSDT		301166	LPSDT		301791
LPSDT		301170	LPSDT		301792
LPSDT		301173	LPSDT		301817A
LPSDT		301174	LPSDT		302004A
LPSDT		301175	LPSDT		302005A
LPSDT		301176	LPSDT		302006A
LPSDT		301236	LPSDT		301749A
LPSDT		301237	LPSDT		302008A
LPSDT		301244	LPSDT		302010A
LPSDT		301247	LPSDT		302002A
LPSDT		301249	LPSDT		302003B
LPSDT		301302	LPSDT		302140
LPSDT		301248	LPSDT		302143
LPSDT		301426	LPSDT		301795
LPSDT		301436	LPSDT		301829
LPSDT		301446	LPSDT		301830
LPSDT		301445	LPSDT		302096
LPSDT		301439	LPSDT		301831

LPSDT AFFECTED MACHINES - VMV010103

MODEL	VIN	SERIAL/UNIT	MODEL	VIN	SERIAL/UNIT
LPSDT		301951	LPSDT		302402
LPSDT		302007A	LPSDT		302401
LPSDT		302277A	LPSDT		302914A
LPSDT		302389	LPSDT		302400
LPSDT		302314A	LPSDT		302463
LPSDT		302076	LPSDT		302462
LPSDT		303627	LPSDT		302766
LPSDT		303628	LPSDT		302823
LPSDT		303631	LPSDT		302478
LPSDT		303629	LPSDT		302560
LPSDT		303630	LPSDT		302811C
LPSDT		303652	LPSDT		302933
LPSDT		302075	LPSDT		302764A
LPSDT		302464	LPSDT		302812A
LPSDT		303565	LPSDT		302813A
LPSDT		303567	LPSDT		303028
LPSDT		302009C	LPSDT		302924
LPSDT		303566	LPSDT		303774
LPSDT		303661	LPSDT		303636
LPSDT		302559	LPSDT		303637
LPSDT		303660	LPSDT		302824
LPSDT		302072	LPSDT		303245
LPSDT		302073	LPSDT		302385A
LPSDT		303659	LPSDT		302415A
LPSDT		303733	LPSDT		303030
LPSDT		303742	LPSDT		302964
LPSDT		302091A	LPSDT		303032
LPSDT		302820	LPSDT		303031
LPSDT		302854A	LPSDT		303039C
LPSDT		302399	LPSDT		302975
LPSDT		303741	LPSDT		303197
LPSDT		302391C	LPSDT		302974A
LPSDT		302074	LPSDT		303866
LPSDT		302855B	LPSDT		303033
LPSDT		302821	LPSDT		303118A
LPSDT		302913A	LPSDT		303144A
LPSDT		302822	LPSDT		303034
LPSDT		302810B	LPSDT		303148
LPSDT		303143A	LPSDT		303249
LPSDT		302364	LPSDT		303151

LPSDT AFFECTED MACHINES - VMV010103

MODEL	VIN	SERIAL/UNIT	MODEL	VIN	SERIAL/UNIT
LPSDT		302011B	LPSDT		303943B
LPSDT		303865	LPSDT		304098A
LPSDT		303518A	LPSDT		303864
LPSDT		303152	LPSDT		304117A
LPSDT		303029A	LPSDT		304291
LPSDT		303153	LPSDT		304293
LPSDT		303154	LPSDT		304167
LPSDT		303145A	LPSDT		303867A
LPSDT		303243	LPSDT		304177
LPSDT		303244	LPSDT		304176
LPSDT		303239	LPSDT		304179
LPSDT		303542A	LPSDT		304180
LPSDT		303772	LPSDT		304136
LPSDT		303773	LPSDT		303998A
LPSDT		303240	LPSDT		304158
LPSDT		303242	LPSDT		304160A
LPSDT		303378	LPSDT		304163B
LPSDT		304027	LPSDT		304189
LPSDT		303792A	LPSDT		304165
LPSDT		303793A	LPSDT		304225
LPSDT		304219	LPSDT		304203
LPSDT		303794A	LPSDT		304210
LPSDT		303795A	LPSDT		304208
LPSDT		303796A	LPSDT		304211
LPSDT		303797A	LPSDT		302455B
LPSDT		304013	LPSDT		304217A
LPSDT		303798A	LPSDT		304226
LPSDT		303799A	LPSDT		303634
LPSDT		304019	LPSDT		304218
LPSDT		304009	LPSDT		302456B
LPSDT		304018	LPSDT		304292
LPSDT		304039	LPSDT		304324
LPSDT		303241A	LPSDT		302457B
LPSDT		304196	LPSDT		304474
LPSDT		303885	LPSDT		304267
LPSDT		303713A	LPSDT		304475
LPSDT		303944	LPSDT		304227
LPSDT		303868	LPSDT		304290
LPSDT		303714	LPSDT		304228
LPSDT		303379A			

LPSDT AFFECTED MACHINES - VMV010103

MODEL	VIN	SERIAL/UNIT	MODEL	VIN	SERIAL/UNIT
LPSDT		304289	LPSDT		304464
LPSDT		304268	LPSDT		304465
LPSDT		304330	LPSDT		304615A
LPSDT		304331	LPSDT		304323
LPSDT		304332	LPSDT		304368
LPSDT		304295	LPSDT		304603
LPSDT		303543A	LPSDT		304688
LPSDT		304508	LPSDT		303851A
LPSDT		304322	LPSDT		304743
LPSDT		304326	LPSDT		304732
LPSDT		304297	LPSDT		304742
LPSDT		304346A	LPSDT		304759
LPSDT		304466	LPSDT		304781
LPSDT		304446	LPSDT		304774
LPSDT		304266A	LPSDT		304780
LPSDT		304345A	LPSDT		304798
LPSDT		304535	LPSDT		304873
LPSDT		304385	LPSDT		304874
LPSDT		304537	LPSDT		304763
LPSDT		304468	LPSDT		304888
LPSDT		304320	LPSDT		304764
LPSDT		304467			
LPSDT		304594A			
LPSDT		304601			
LPSDT		304463			

UNIT OWNER COPY:
Insert in parts manual
for future reference.

Figure 1



Figure 1 parts list

<u>REF. NO.</u>	<u>PART NO.</u>	<u>DESCRIPTION</u>	<u>IK01 QTY.</u>
1	135019627	PLATE, CROSS MEMBER GUSSET	2
		Kit includes all items in Figure 1 parts list.	

UNIT OWNER COPY:
Insert in parts manual
for future reference.

Figure 2



Figure 2 parts list

<u>REF. NO.</u>	<u>PART NO.</u>	<u>DESCRIPTION</u>	<u>IK01 QTY.</u>	<u>Remarks</u>
1	13508253	GUSSET, REAR, 6" I-BEAM	2	
2	13508258	GUSSET, REINFORCEMENT, 6" I-BEAM	2	
		Kit includes all items in Figure 2 parts list.		

UNIT OWNER COPY:
Insert in parts manual
for future reference.

Figure 3



Figure 3 parts list

REF. NO.	PART NO.	DESCRIPTION	IK01 QTY.	Remarks
1	135019569	PLATE, GUSSET FRAME	2	
		Kit includes all items in Figure 3 parts list.		

UNIT OWNER COPY:
Insert in parts manual
for future reference.

Figure 4

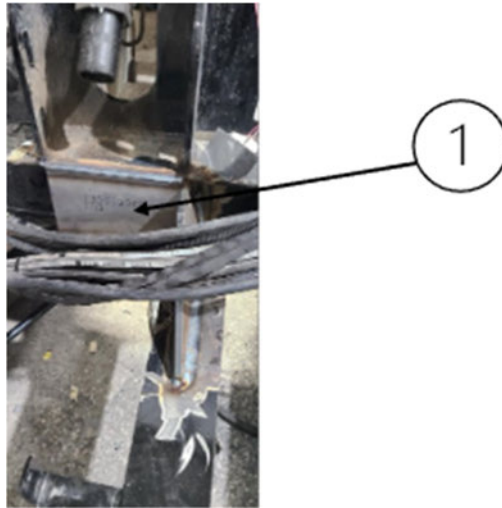


Figure 4 parts list

REF. NO.	PART NO.	DESCRIPTION	IK01 QTY.	Remarks
1	135019965	PLATE, I-BEAM REINFORCEMENT	2	
		Kit includes all items in Figure 4 parts list.		

UNIT OWNER COPY:
Insert in parts manual
for future reference.

Figure 5



Figure 5 parts list

REF. NO.	PART NO.	DESCRIPTION	VMV01 QTY.	Remarks
1	135019311	PLATE UPPER FRAME REINFORCEMENT	2	
		Kit includes all items in Figure 5 parts list.		

UNIT OWNER COPY:
Insert in parts manual
for future reference.

Figure 6

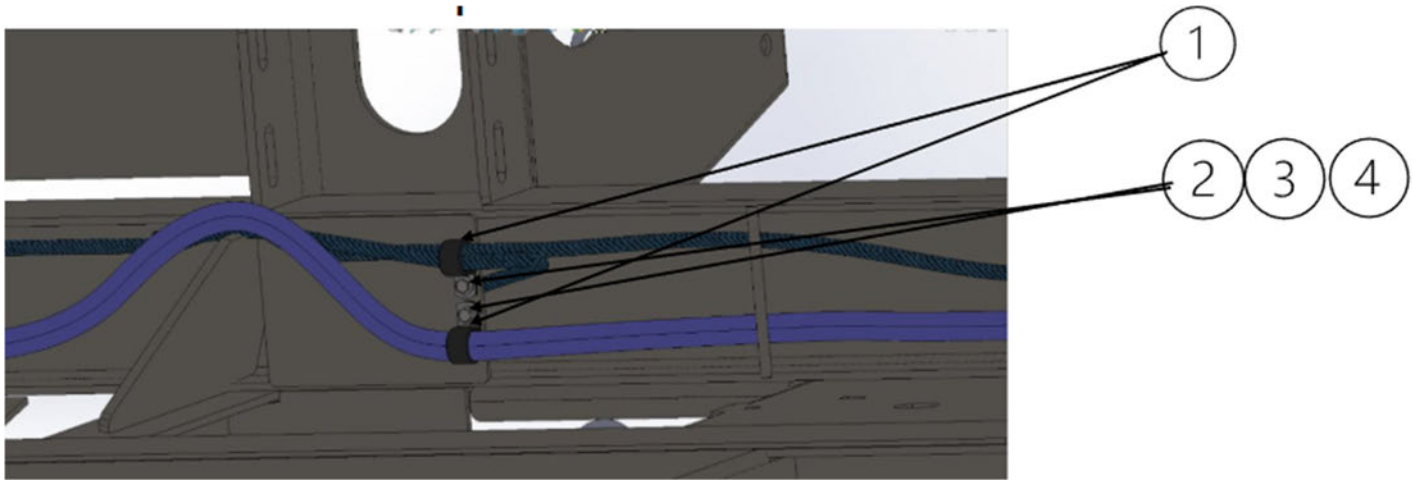


Figure 6 parts list

REF. NO.	PART NO.	DESCRIPTION	VMV01 QTY.	Remarks
1	135012897	1" DIA VNL OF HOLE	4	
2	U000080	SCEW, HC .250-20x1.25ZP G5	4	
3	U120000	NUT LOCK NY .250-20 ZP G2	4	
4	U200020	WASHER FLAT 1/4 ZP	4	
		Kit includes all items in Figure 6 parts list.		

UNIT OWNER COPY:
Insert in parts manual
for future reference.

Figure 7



Figure 7 parts list				
REF. NO.	PART NO.	DESCRIPTION	VMV01 QTY.	Remarks
1	P-3478-DEC	Decal, "HYDRAULIC FLUID ONLY"	1	
		Kit includes all items in Figure 7 parts list.		

UNIT OWNER COPY:
Insert in parts manual
for future reference.

Figure 8



Figure 8 parts list

REF. NO.	PART NO.	DESCRIPTION	VMV01 QTY.	Remarks
1	P-0763-DEC	DECAL, "WATER TANK DRAIN", BLACK AND WHITE	1	
		Kit includes all items in Figure 8 parts list.		

UNIT OWNER COPY:
Insert in parts manual
for future reference.

Figure 9

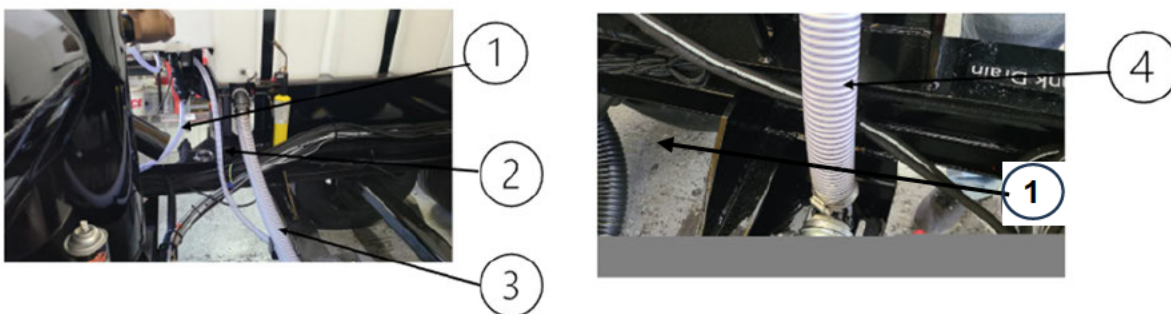


Figure 9 parts list

REF. NO.	PART NO.	DESCRIPTION	VMV01 QTY.	Remarks
1	1350020223	HOSE, 3/4" CLEAR – 78"	1	
2	1350020224	HOSE, 3/4" CLEAR – 136"	1	
3	1350020225	HOSE, 2" CLEAR – 24"	1	
4	1350020226	HOSE, 2" CLEAR – 54"	1	
		Kit includes all items in Figure 9 parts list.		

