



TECHNICAL SERVICE BULLETIN

INSPECTION AND REWORK INSTRUCTIONS

DOC NUMBER	D714483
DATE	Thursday, April 05, 2018
REVISION	002
SUBJECT	DM400 Suspension Hanger to Cross-member Weld Connection Cracking
APPLIES TO	DM400 Suspension
CONDITION	Potential DM400 suspension frame hanger to cross-member cracking
PURPOSE	To provide INSPECTION and REPAIR instructions to be completed during next scheduled maintenance
LABOR ALLOCATION	1.5 Hours
LABOR RATE	\$75.00 PER HOUR
TOOLS REQUIRED	1. Welding power source with the capability of performing Gas Metal Arc Welding (GMAW), or Shielded Metal Arc Welding (SMAW). 2. Chipping hammer and wire brush if SMAW is used. 3. Angle grinder with abrasive wheel to clean weld surface. 4. Spray paint/primer.
SERVICE PARTS	K714484 containing four (4) 714409-01 Gusset Plates
WARRANTY NOTICE	<i>For warranty repair coverage claims please e-mail the following information to Jerry McReynolds at jmcreynolds@reycogranning.com :</i> • <i>Trailer VIN number and suspension serial number</i> • <i>Trailer In service date</i> • <i>Details of facility that performed the inspection and repairs</i> <i>The above information is required for warranty payment.</i>

Note: This document is for trained professional technicians, who have been trained in the use of industrial standards, and have the tools to perform this service safely and correctly.

GENERAL INSTRUCTIONS

Please thoroughly review entire work procedure before starting work. If there are questions and/or concerns with steps defined in this procedure, contact:

Jerry McReynolds

Field Service Warranty Manager

Cell : (417) 366-1954

Office : (417) 466 1056

E-mail : jmcreeynolds@reycogranning.com

IMPORTANT SAFETY NOTICE



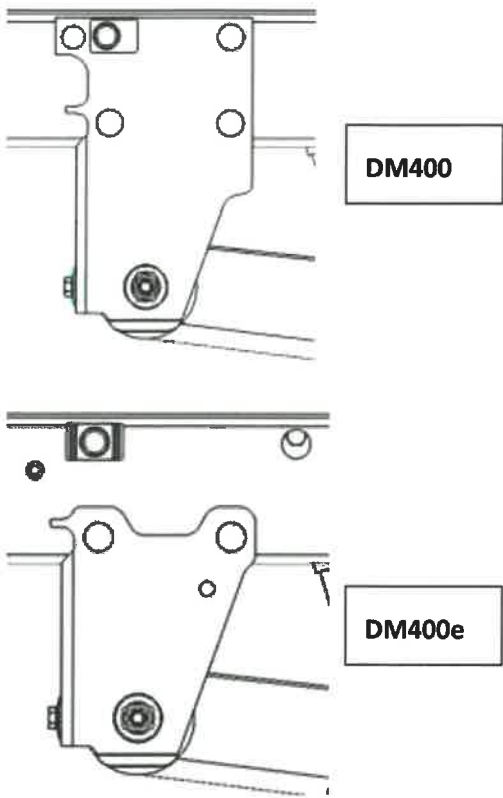
All applicable industry safety standards shall be followed when performing the work identified in this procedure.

Failure to safely support the vehicle and follow the procedures in this bulletin can lead to material damage and/or personal injury.

Note: When welding, do not ground to lug studs, this could damage the wheel bearings due to internal arcing.

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Step	Instruction	Illustration
1	Verify that the unit is equipped with the DM400 suspension, and not the DM400e. This is easily identified by the examining the outside of the hangers. NOTE: This service bulletin is only applicable to the DM400 suspension.	
2	Inspect for cracking along bottom welds of cross-member to hanger joint on the in-board sides of the four hanger brackets, as shown in picture to the right.	

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3	If a crack is found and the crack <u>does not</u> extend past either end of the weld by more than 2" then proceed to step 4. If no crack is found, proceed to step 5. If the crack extends past either end of the weld by more than 2" please contact Jerry McReynolds at: jmcreynolds@reycogranning.com Office : (417) 466 1056 Cell : (417) 366-1954	
4	Remove paint and rust on the area to be welded. Remove the crack and/or defective material to provide a rust-free v-groove along the complete length of the crack. All surfaces to be welded must be clean and free of any rust, weld spatter, slag and/or paint.	
5	Strip an area of any rust and paint on front lower portion of hanger to provide a bare metal surface for attaching the welder ground as shown. Note: Do not ground to lug studs, this could damage the wheel bearings due to internal arcing.	

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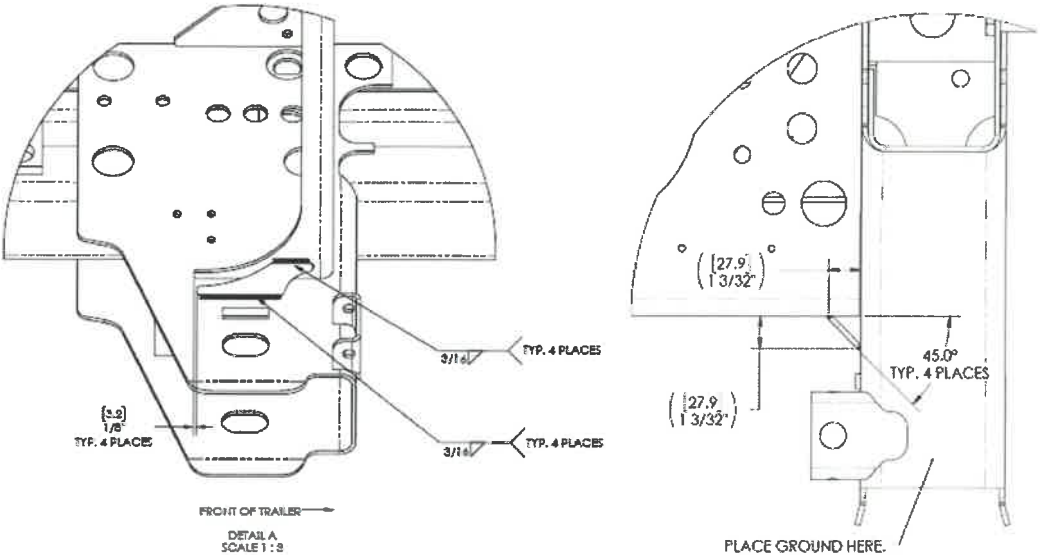
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5	Weld so that the v-groove weld is completed. Welding Procedure: • GMAW – Use ER70S-6, .035 Solid wire. Welding procedure is as follows: Welding machine settings – Voltage range (16-20), Wire Feed Speed (WFS) 150-250 inches per minute (IPM). Shielding gas mixture requirement – 75% Argon/25% CO², with 30-40 Cubic Feet per Hour (CFH). • SMAW – Use E7018, 1/8" electrode Welding machine settings – Amperage range (90-115)	
6	Position gusset plate (714409-01) at 45° to inside of hanger and cross-member and 1/8" behind the end of the cross-member, as shown in step 7 below. Tack in place ensure proper placement, then fully weld a 3/16" min. fillet weld along both mating edges. Repeat this procedure on the opposite hanger as well as the other pair of hangers. (All four hangers) Welding Procedure: • GMAW – Use ER70S-6, .035 Solid wire. Welding procedure is as follows: Welding machine settings – Voltage range (16-20), Wire Feed Speed (WFS) 150-250 inches per minute (IPM). Shielding gas mixture requirement – 75% Argon/25% CO², with 30-40 Cubic Feet per Hour (CFH). • SMAW – Use E7018, 1/8" electrode Welding machine settings – Amperage range (90-115)	

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7	 FRONT OF TRAILER DETAIL A SCALE 1 : 2
8	Remove all weld slag and spatter. Apply paint to all of the areas where paint was removed, inclusive of the ground clamp position. Ensure that the surface under the added gusset is also painted.

Reyco Granning Approvals

J. McReynolds	<i>RS</i>	Warranty and Service	04/10/2018
K. Wall	<i>K. Wall</i>	Chief Engineer	4-10-18
R. Steenekamp	<i>R. Steenekamp</i>	VP of Engineering	04/10/2018
Name	Signature	Title	Date

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