



Service Bulletin

Bulletin Number: **SB-18-302**
Release Date: **October 12, 2018**
Subject: **Rear Mounting Pin Weldment Replacement**
Distribution: **Affected Heil Dealers, Customer Service, Field Service**

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

Also see SB-18-300 for the original notification of this issue. SB-18-302 adds certain Rear End Loaders to the Products Affected section below and adds repair instructions for both the Front End Loader/Automated Side Loader **4-Hole Pin Mount Kit (372-8847)** and the Rear End Loader **3-Hole Pin Mount Kit (372-8848)**. The only difference between the kits is the Spacer Plate hole configuration.

URGENT NOTICE:

Heil has identified the potential for a weld defect on certain Heil Front End Loaders, Automated Side Loaders and Rear End Loaders manufactured from June 1, 2018 to September 30, 2018.

The potential defect relates to improper welding of the Rear Mounting Pin Weldments, Heil P/N 211-5256. For Service Hoist or Service Lift equipped Front End Loaders, these two pins (one on each side of the frame rail) hinge the body structure during Service Hoist or Service Lift raising and lowering operations. Utilizing the Service Hoist or Service Lift may cause the raised body to become unstable.

Accordingly, this Service Bulletin serves as a mandatory directive from Heil to cease utilization of the Service Lift and Service Hoist to raise the body until inspection and/or repairs have been completed.

The corrective action is to replace the two Rear Mounting Pin Weldments.

1. PLANNING INFORMATION

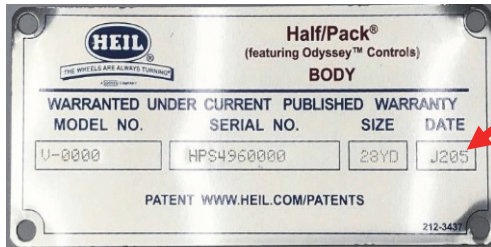
A. Products Affected

If your Body Serial Number falls within the Range identified below, you should also check your Body Serial Plate for the Date Range. See the next page for Date Range identification.

Unit Name	Beginning Body Serial #	Ending Body Serial #
Half/Pack® and Odyssey™	HP[E or S] 4960524 HP[E or S] 5010734	HP[E or S] 4961701 HP[E or S] 5011697
DuraPack® Python®	7[E or S] 7306350	7[E or S] 7306570
DuraPack® Rapid Rail®	DR[E or S] 7001133	DR[E or S] 7001150
MultiPack®	MPF9101255	MPF9101263
PT 1000™	4F1302967	4F1303072
Formula® 4000	4F1020779	4F1020781
DuraPack® 5000	FP5023795	FP5024365
PowerTrak® Commercial	FP5802659	FP5802720
PowerTrak® Commercial PLUS	FP5822657	FP5822681
DuraPack® 4060	FP5412328	FP5412421

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.

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If the Unit's Serial Number falls into the range set forth in the table on the previous page and the Date Range falls between **J121 through J274**, your unit is a Potentially Impacted Unit.

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 **January 12, 2019**. The tasks outlined in this Service Bulletin must be performed by a qualified technician.

C. Manpower

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

Table 1. Manpower

Task	Man Hours Required
Replace Both Rear Mounting Pin Weldments	2.5 hours

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	
Pneumatic or Electric Driver	Commercially available	
Torque Wrench	Commercially available	
5 lb Sledge Hammer	Commercially available	
Grinder/Sander	Commercially available	
Oxyacetylene Torch	Commercially available	Cutting pin, if necessary

Table 3. Parts

New Part Number	Description	Quantity Per Unit	Old Part Number	Special Instructions
372-8847	Installation, Rear Mounting Pin Weldment Repair, 4-Hole Mount	2	N/A	Use for Front Loaders (FELs) and Automated Side Loaders (ASLs)
311-6612	Weldment, Pin Mounting	1		Included in the 372-8847 kit
311-6613	Plate, Spacer (4-Hole)	1		Included in the 372-8847 kit
FSP111340	HHCS 5/8-18 UNF X 3" LG. GR8 Plated	4		Included in the 372-8847 kit
FSP351300	Nut, 5/8" UNF GR8, Plated	4		Included in the 372-8847 kit
FSP521300	Washer, Flat, 5/8" SAE, Plated	8		Included in the 372-8847 kit

New Part Number	Description	Quantity Per Unit	Old Part Number	Special Instructions
372-8848	Installation, Rear Mounting Pin Weldment Repair, 3-Hole Mount	2	N/A	Use for Rear End Loaders (RELs)
311-6612	Weldment, Pin Mounting	1		Included in the 372-8848 kit
311-6614	Plate, Spacer (3-Hole)	1		Included in the 372-8848 kit
FSP111340	HHCS 5/8-18 UNF X 3" LG. GR8 Plated	3		Included in the 372-8848 kit
FSP351300	Nut, 5/8" UNF GR8, Plated	3		Included in the 372-8848 kit
FSP521300	Washer, Flat, 5/8" SAE, Plated	6		Included in the 372-8848 kit

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 for **each side of the unit**. Use the appropriate kit from **Table 3**. Typically, Front End Loader (FEL) and Automated Side Loader (ASL) units use 4-Hole Mount Kit (372-8847) while Rear End Loader (REL) units use 3-Hole Mount Kit (372-8848). See **Figure 1**.

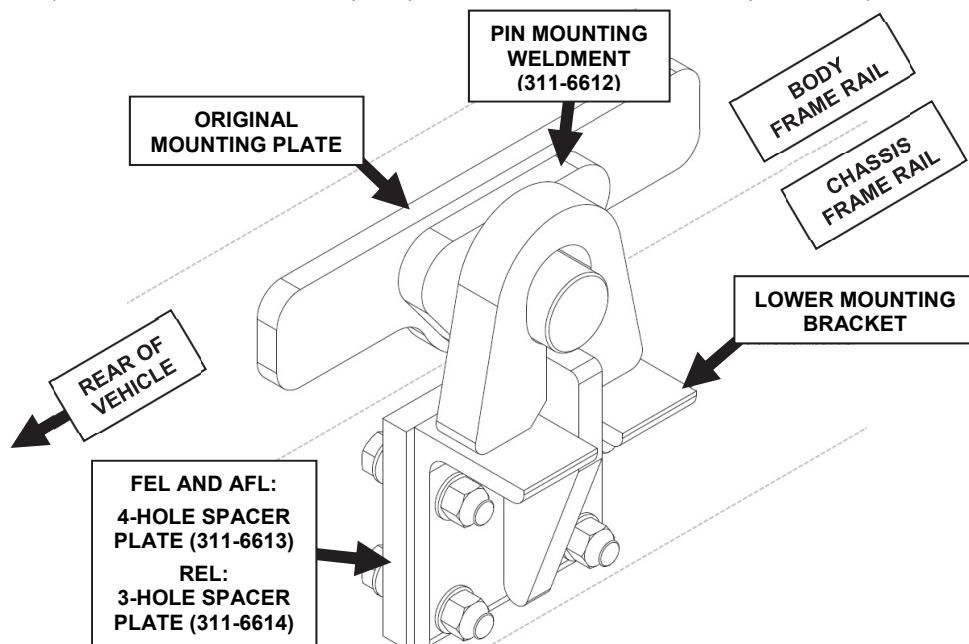


Figure 1. Rear Mounting Pin Weldment Repair Installations (372-8847 and 372-8848)

A. Replace Curb Side and Street Rear Mounting Pin Weldments

- (1) Remove the Lower Mounting Bracket that is bolted to the chassis frame rail. Save this for reuse later. Discard fasteners: the bolts, washers and nuts must be replaced.
- (2) The pin in the upper mounting weldment must be removed. Hit the pin with a 5 lb sledge hammer in an alternating horizontal direction to dislodge and remove it. Discard the pin. Then grind the surface of the original mounting plate.

NOTE: If the pin remains, cut the pin utilizing an oxyacetylene torch and grind flush with the mounting plate. Utilize protective equipment to ensure no chassis or body components are damaged during the cutting process. Make sure an A, B, C rated fire extinguisher is present during all times while using the torch. See **Figure 2**.

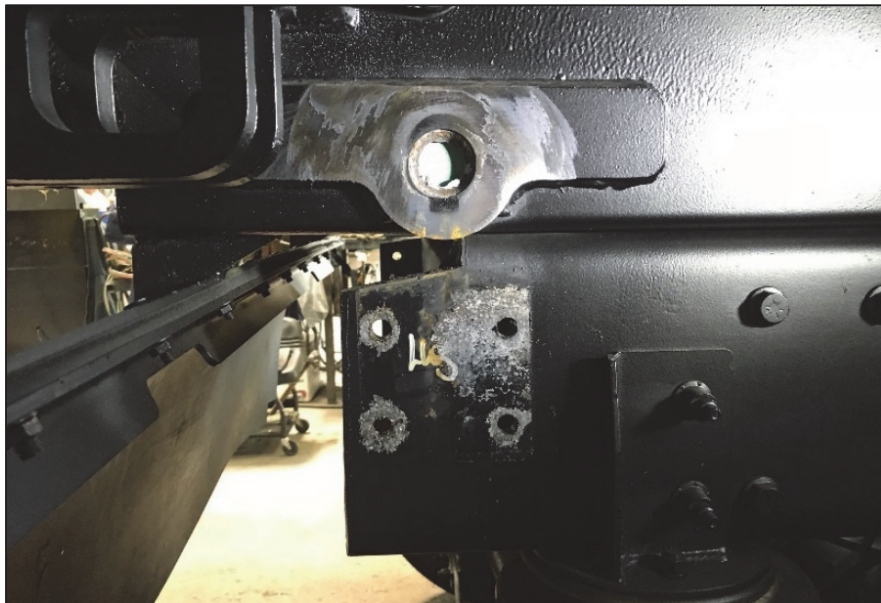


Figure 2. Lower Mounting Bracket Removed and Upper Mounting Weldment with Pin Removed

- (3) Position the 4-Hole Spacer Plate (311-6613) or 3-Hole Spacer Plate (311-6614) on chassis frame rail as shown in **Figure 3**. Use the Spacer Plate that matches the Lower Mounting Bracket hole pattern.



Figure 3. 4-Hole Spacer Plate Positioned Prior to Installing Lower Mounting Bracket

- (4) Position the Pin Mounting Weldment (311-6612) vertically in the middle of the oblong hole of the Lower Mounting Bracket, then temporarily install the bolts, washers and nuts to attach the bracket to the chassis frame rail. This position should allow about 1/4" of the original mounting plate to protrude all the way around the new pin weldment. See **Figure 4**.
- (5) Tack weld the pin weldment to the original mounting plate in the proper position. See **Figure 4**.



Figure 4. Position and Install Pin Mounting Weldment onto Lower Mounting Bracket, then Tack Weld Pin Mounting Weldment

- (6) Unbolt the lower mounting bracket from the chassis frame rail. See **Figure 5**.



Figure 5. Pin Mounting Weldment Tack Welded onto Original Mount Plate

- (7) Weld the replacement Pin Mounting Weldment (311-6612) to the original mounting plate that is welded to the body longitudinally. This should be a horizontal or uphill 1/4" fillet weld. There should be **NO DOWNHILL WELDS**.
- (8) Reinstall the lower mounting bracket to the chassis rail utilizing NEW bolts, washers and nuts from the kit and tighten to **170 FT-LB**. See **Figure 6**.
- (9) Clean all welds and exposed metal surfaces and then paint.



Figure 6. Rear Mounting Pin Weldment Installed and Painted

To obtain reimbursement from Heil for the inspection and any re-work as a result of implementing this Service Bulletin, submit one completed Request For Credit (RFC) for each unit re-worked. Heil Dealers and Service Centers must file claims electronically using Heil's online warranty system. Labor will be reimbursed at two and one-half (2.5) hours for replacement of both Rear Mounting Pin Weldments. All re-work must be completed within three (3) months of the issuance of this Service Bulletin (by January 12, 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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