

Technical Bulletin

- Place a copy of this bulletin in the front of each Blueprints Manual.
- Redline drawings as needed and include a TB reference note.
- Document TB implementation schedule request and completion:

Date Scheduled _____ Date Completed _____

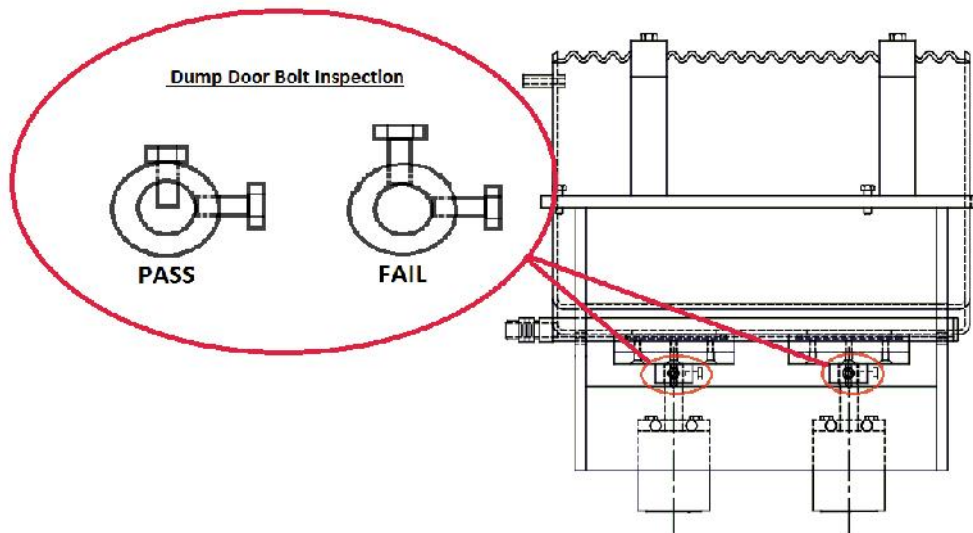
Completed by (name) _____

TB Number: 091
Date Issued: June 11, 2013
Expiration Date: none

Subject/Key Words:	Quick dump door may separate from dump piston – inspect and correct			
Classification:	<input checked="" type="checkbox"/> Informational	<input type="checkbox"/> Mandatory	<input type="checkbox"/> Safety Alert	<input checked="" type="checkbox"/> Preventive Maintenance Impact
	<input type="checkbox"/> Warranty Impact	<input type="checkbox"/> Purchase Parts	<input type="checkbox"/> No Charge For Parts expires ___/___/____. Reference this TB# when ordering NC parts.	
Application:	Gama modules: End-Effector Wash-Dry, and QDR cold and hot/warm/cold			
Parts/Documents:	TNK2B0012 PISTON TANK 1.5"EXT 2"BORE 1.5" STROKE O-RING 2-018 PISTON KALREZ			
Attachments:	none			

Issue: QDR or EEWD tanks do not fill and/or drain when the dump piston is activated. The Dump piston shaft is missing the set screw blind hole. The set screws may eventually work loose causing the disk (dump door) to remain stuck to the bottom of the tank (does not drain) or become separated from the shaft (will not fill).

Inspection:



If your inspection passes – no further solution required
If your inspection fails – proceeded to Solution below

Solution 1: Determine if securing bolts are simply misaligned to piston

- Open dump doors
- Loosen both bolts using a 7/16 HH driver
- Lift dump door by hand off the piston shaft
- Inspect shaft for a ¼ inch side hole
- IF the side hole is present – align one of the bolts to the hole and secure
- Flush with collar then loosely hand tighten second bolt
- Close dump door and snug second bolt

Solution 2: Solution 1 reveals the piston shaft to be missing the ¼ inch side hole

- Open dump doors and remove “Failed” dump door from piston shaft
- Note/mark position of piston to mounting plate
- Remove four HH bolts securing piston to the mounting plate
- Note/mark top and bottom air lines to the piston for correct re-assembly
- Remove piston and drill a ¼ inch blind hole per diagram below and de-burr
- Reverse disassembly process to assemble and test

Supply-chain correction has been made to ensure future units are shipped with dump door securing hole in side shaft per design

Diagram:

