
Attention Service Manager/ Parts Department

Bulletin Level: 3* **Specific Warranty Coverage:** Parts: Covered Labor: 0.5 hrs Travel: 3 hrs

Subject: Vac Shoe Bracket Pin Weld Fracture

Models Affected:

- Adphibian (all models)
- AquaPLUS (all models)
- AX651 (all models)

Parts List Form Number(s) Affected: 56042476

ECO# : NA

Informational Bulletin: NA

Issue: Pin separates from vac shoe bracket weldment.

Cause: Variation in welding process resulted in undersized weld and poor penetration between shoe bracket and pin.

Corrective Action: Field:

On machines with S/N's prior to those noted below remove shoe bracket weldment 56317063 from shoe ass'y 56317041 & replace as shown in Fig's 3-6.

Factory:

Improved weld process implemented effective with SN 2050515 on AquaPLUS and S/N 2050506 on Adphibian.

Fig 1- Weld joint failure on vac shoe bracket weldment 56317063

Shoe bracket weldment with undersized weld and inadequate weld penetration between pin and shoe bracket



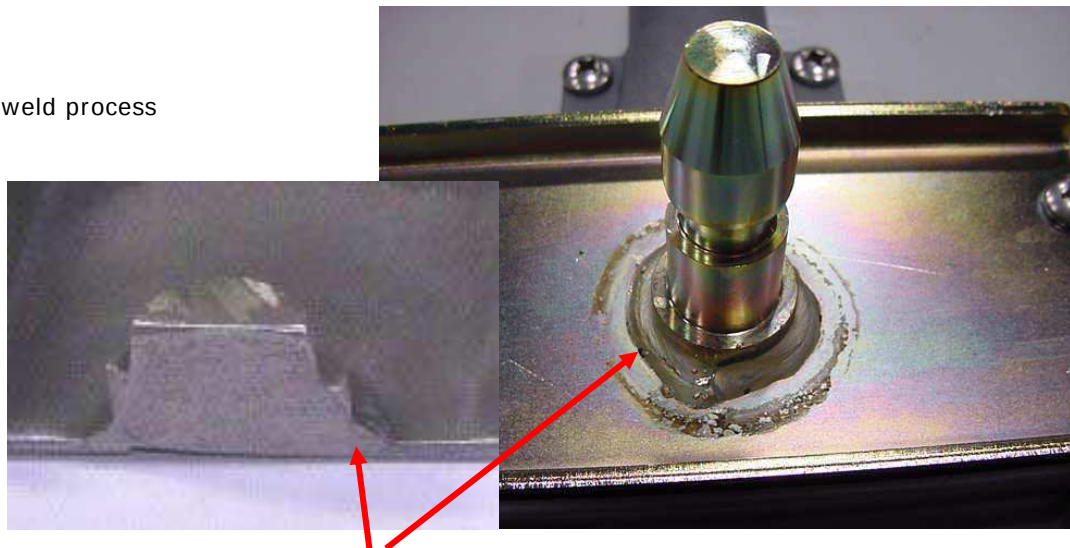
* **Technical Service Bulletins Levels:**

Level 1: These Bulletins contain general information and are without specific warranty coverage.

Level 2: These Bulletins describe continuous quality improvements that are made to products. Specific warranty coverage may apply and if so is noted in the Bulletin.

Level 3: These Bulletins describe a quality problem that has been determined to require a mandatory update to the product. Specific warranty coverage is as noted in Bulletin.

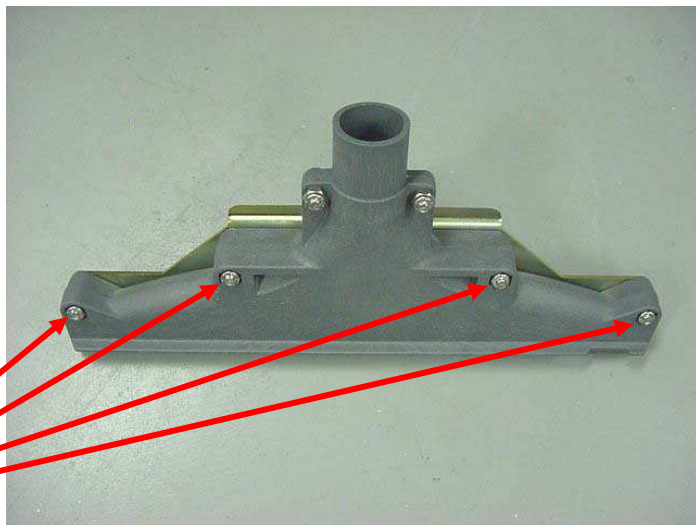
Fig 2- Correct weld process



Weld w/correct fillet size and penetration.

Fig 3- Vac shoe assembly 56317041

Remove 4 screws and nuts used to secure vac shoe bracket to shoe housing



Remove vac shoe bracket 56317063.

Fig 4-



Fig 5-

56002905 ¼-20 x 1.5
screws used in inner
positions

56002958 ¼-20 x 1.25
screws used in outer
positions

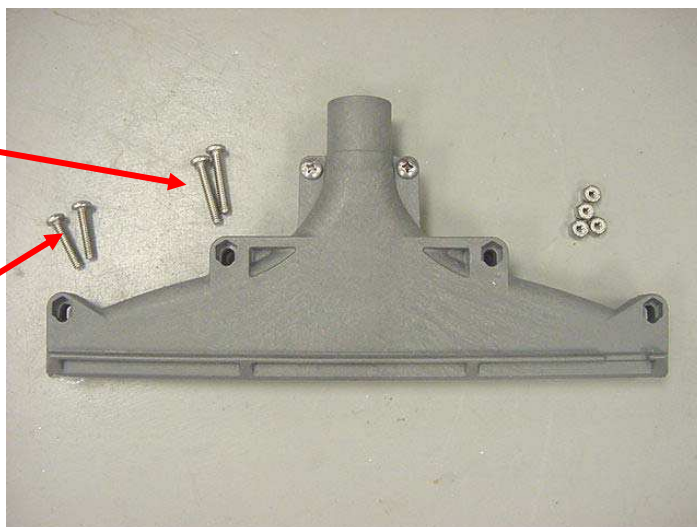


Fig 6- Install new vac shoe bracket,
reinstall mounting hardware and
torque to 67 in-lbs.

