
Attention Service Manager/Parts Department

Bulletin Level: 2*

Specific Warranty Coverage: Standard Warranty Coverage

Subject: Availability of the field repair kit, p/n 56380497, for 24 VDC transaxle, p/n 56315062

Models Affected: Adphibian (all), AquaPLUS (all), AX 651, BA 625, BA 725, BA 725C, BA 825, Convertamatic (all)

Parts List Form Number(s) Affected: 56042451, 56042476, 56042497, 56042504

ECO#: A-04254, A-04268

Issue: Looseness felt between the drive wheels and machine chassis; premature failure of transaxle wire leads resulting in E03 code.

Cause: Movement of the transaxle within the chassis weldment can result in contact between the transaxle motor wires and the tank which can abrade and shear the wires (Figure 1), causing an open circuit to the drive motor and subsequent 03 error code. Transaxle movement can also cause accelerated wear or damage to the neoprene mounting sleeve (Figure 2).

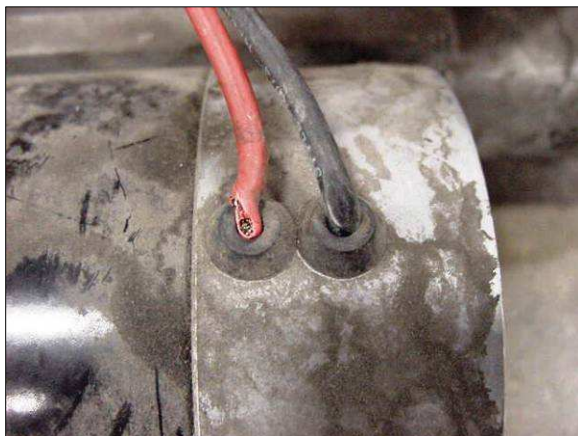


Figure 1 - Abraded and Sheared Motor Wires



Figure 2 - Damaged Neoprene Mounting Sleeve

Corrective Action: Factory:

- Machines with serial numbers 2059972 through 2059980, 2060547, and all machines built beginning with serial number 2062812 have the new Transaxle Angle Shim and Transaxle Plate installed on the transaxle to prevent rotation within the weldment.
- On Convertamatics beginning with serial number 2063622, and AquaPLUS or Adphibian machines beginning with serial number 1000000478, the transaxle mounting weldment on the chassis was modified to improve fit and eliminate the Transaxle Angle Shim.

* **Technical Service Bulletin Levels:**

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

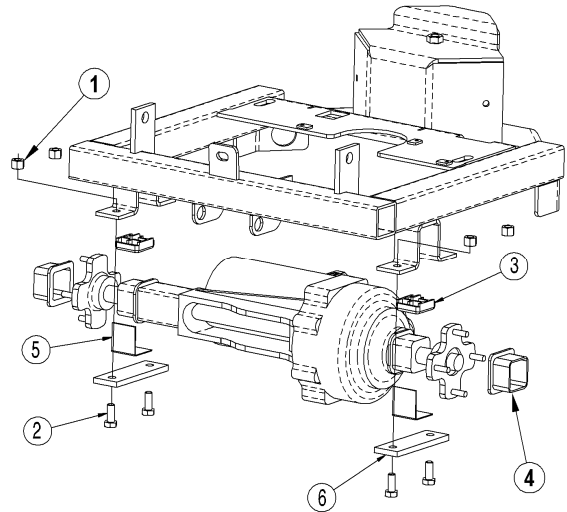
Level 2: These Bulletins describe continuous quality improvements that are made to products. Specific warranty coverage may apply and if so is noted in the Bulletin.

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.

Corrective Action: Field: When making a routine service or maintenance call, examine the motor wiring, Neoprene Mounting Sleeve, transaxle and hubs for any signs of wear or damage. If a Neoprene Mounting Sleeve appears to be worn, install the Transaxle Kit, p/n 56380497, to replace any worn parts and prevent future transaxle rotation within the weldment. If a hub appears worn or damaged, you can purchase the new hub replacement kit, p/n 56380503, which will allow you to replace the hub without having to purchase the entire transaxle assembly.

Contents of the Transaxle Kit - 56380497

#	Qty.	Part Number	Description
	1	56040998	Instruction Sheet
1	4	56003405	Hex Nut, Nyloc® SS, M8-1.25
2	4	56003435	Hex Screw, SS M8-1.25 X 20mm
3	2	56315258	Shim
4	2	56315379	Neoprene Mounting Sleeve
5	2	56380496	Transaxle Angle Shim
6	2	56380499	Transaxle Plate



To Install the Transaxle Kit:

Follow the procedures in the Instruction Sheet, part number 56040998, included with the Transaxle Kit.

To Replace the Transaxle Motor:

If the transaxle motor and/or motor wires are damaged but the transaxle itself is undamaged, you can replace the transaxle motor (p/n 56315377) before reinstalling the transaxle and the new parts in the Transaxle Kit.

1. **See Figure 3.** Remove the two **Socket Head Screws** (3/16" hex wrench) holding the **Motor** to the **Transaxle**, lift the rear of the **Motor** slightly so it clears the machined cutout in the **Transaxle**, then remove the **Motor** from the **Transaxle**.
2. Remove the **Coupler** and flat steel **Key** from the old **Motor** and install them onto the shaft on the new **Motor**.
3. Align the **Coupler** and **Key** on the new **Motor** shaft with the mating coupler in the **Transaxle**, align the threaded holes in the **Motor** with the two **Socket Head Screws**, then slide the new **Motor** into position.
4. Reinstall and tighten the two **Socket Head Screws**.

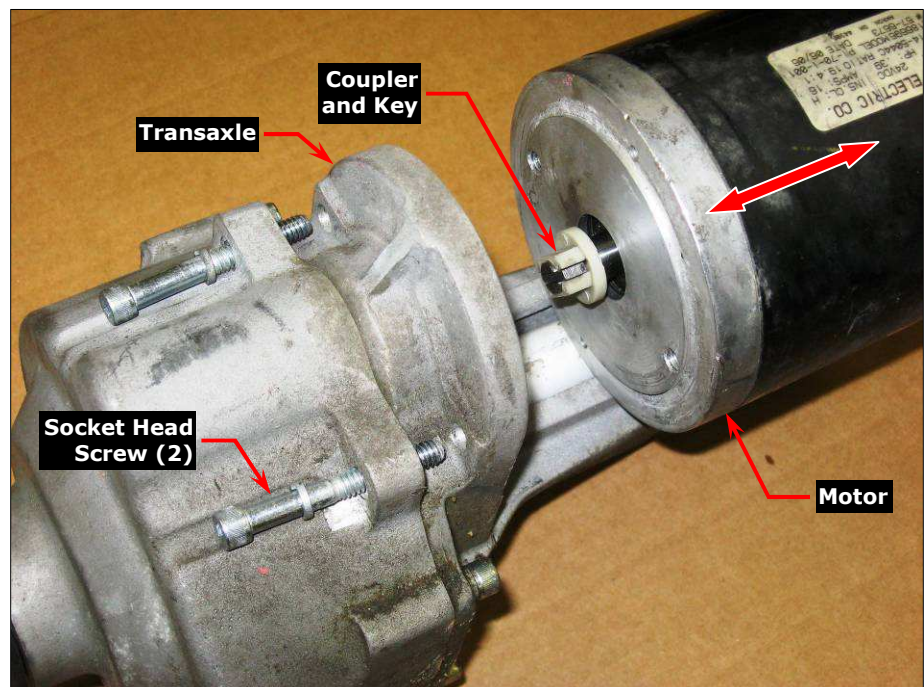


Figure 3 – Transaxle Motor Replacement

Note: If the replacement motor does not have a connector attached to the motor wires, you will need to splice the connector from the old motor to the wires on the new motor by following steps **5** through **10** below.

- 5. Refer to Figure 4.** Measure the length of the wires from the old motor to the connector and note this length.

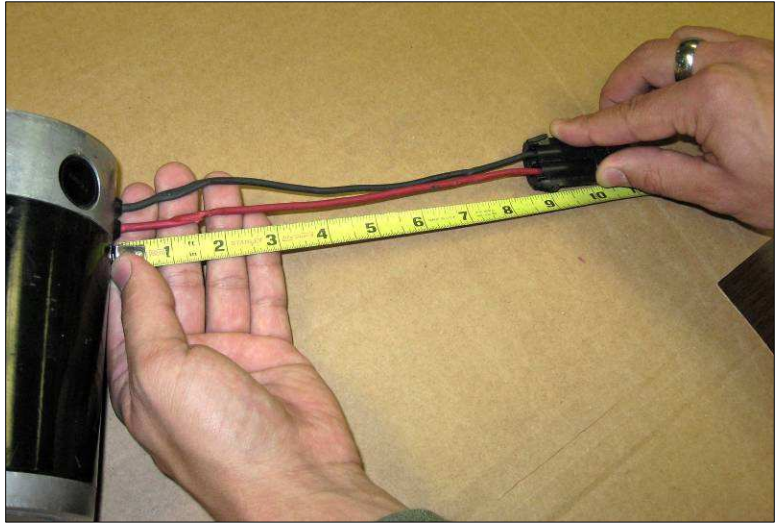


Figure 4 – Measuring the Motor Wires

- 6.** Make sure that the connector wires that you will be splicing to the new motor wires are in good condition and are not torn, crushed or abraded, then cut the wires from the old motor to the connector.
- 7.** Cut the wires on the new motor to the appropriate length so that when the motor wires are spliced to the connector wires, the total wire length between the new motor and connector will be the same as that noted in step **5** above.
- 8.** Install a length (approximately 3") of heat-shrink insulation onto the wires.
- 9. Refer to Figure 5.** Connect and solder the wires from the new motor to the wires on the old connector. Make sure to match the wire colors to maintain correct motor polarity.

Note: Use only rosin-core solder. Do not use acid-core solder.

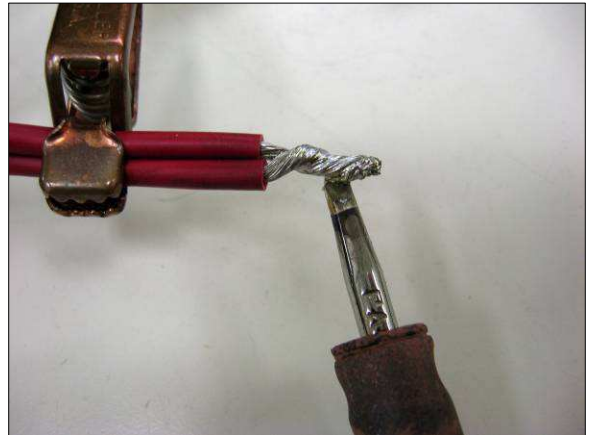


Figure 5 – Soldering Motor Wire

- 10. Refer to Figure 6.** Center the heat-shrink insulation over the wire splices, then heat the insulation to seal the splices.



Figure 6 – Heat-shrink Insulation Over Splice