

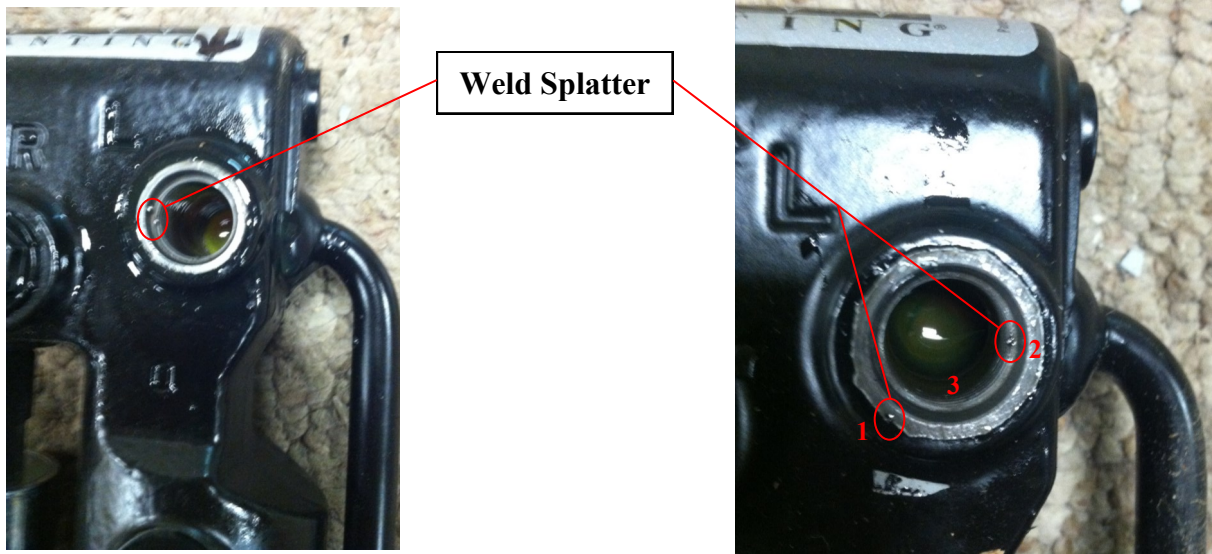
Service Bulletin: Weld Splatter on and around threads of Hydraulic Cylinder connections

January 27, 2014



Problem: Weld berries or splatter found on and around the threads of the hydraulic cylinder (729600).

Details: We have identified a fault in our manufacturing process that failed to safeguard the threads on the 729600 Hydraulic Cylinder. This allowed weld splatter to collect in and around the threads of the hydraulic connections. It is most prevalent on the Lift Circuit connections, however can be present on any of the three connections.



Solution:

For un-installed cylinders, thoroughly inspect threads prior to installing hydraulic connectors; if weld splatter is present: DO NOT INSTALL; complete RMA process for complete replacement of cylinder.

For currently installed cylinders, we are NOT recommending removal or inspection processes. Recommendation is to complete all health checks and monitor cylinder performance closely. If weld splatter was present during installation, failure would present in one of two ways:

1. Leaking at the hydraulic connection: If the splatter was on the face of the cylinder or in the O-Ring seat; locations **1** or **2** (see image above right), the weld splatter could damage the O-Ring or restrict the connector from seating properly to the cylinder.
2. Cylinder failure: If the splatter was in down into the threads; location **3** (see image above right), installing the hydraulic connection would dislodge the weld splatter introducing it as debris into the system. Outcome from this instance can range from nothing (flows through system harmlessly until capture by filter) to blockage/damage of the control valve or other internal component failures.