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By Recall Mangement Division at 7:18 am, Jul 08, 2014

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Via Email: RMD.ODI@dot.gov

To: Defects and Recall Information Analysis Division
Associate Administrator for Safety Assurance
National Highway Traffic Safety Administration
1200 New Jersey Ave. SE
Washington DC 20590

PART 573 Defect and Noncompliance Report

Report Date: July 7, 2014

On or about July 1, 2014, Vermeer Manufacturing Company, d/b/a Vermeer Corporation, determined that there is a defect which relates to motor vehicle safety with respect to certain motor vehicles listed below, and is furnishing notification to the National Highway Traffic Safety Administration in accordance with 49 CFR Part 573 Defect and Noncompliance Reports.

Fabricating Manufacturer:

Vermeer Manufacturing Company, d/b/a Vermeer Corporation
1210 Vermeer Road East
Pella, IA 50219

Telephone: 641-628-3141 **Fax:** 641-621-7739

Contact Name and Title: Lois Slings
Product Liability Risk Manager

Name and Title of Person Who Prepared Report: Darin Dux
Product Safety Engineer

Signed:  **Date:** _____
Darin Dux

7- JULY - 2014



PART 573 Defect and Noncompliance Report

Report Date: 07/07/2014

I. Identify the Vehicle Models Involved in the Recall

Manufacturer's Identification Code: IK00-3061

Vehicle Identification:

Make:	Vermeer	Model Years Involved:	2013 – 2014	
Units Involved (Estimated)				
Model	Production Dates		VIN Range	
	Beginning	Ending	Beginning	
R9X12T	11/28/2012	3/21/2014	1VRB533B0D1000122	1VRB533B3E1000147
R400T	8/27/2013	6/16/2014	1VRA533U0D1000098	1VRA533U4E1000106
R600HC	10/28/2013	4/25/2014	1VRT53398E1000100	1VRT5339XE1000101
Vehicle Type:	Trailer – Triple axle drilling fluid reclaimer			

Description which characterizes/distinguishes the recalled vehicles from this model vehicles not included in the recall: The VIN range includes 37 units. All units except R400T serial number 103 are included in the recall.

Identify the approximate percentage of the production of all the recalled models manufactured by your company between the inclusive dates of manufacture provided above, that the recalled model population represents. For example, if the recall involved Widgets equipped with certain items of equipment from January 1, 1996 through April 1, 1997, then what was the percentage of the recalled Widgets of all Widgets manufactured during that time period. 97%

II. Identify the Recall Population

Total Number of Vehicles Recalled Potentially containing the defect or noncompliance:

Model	Year	Number of Vehicles Potentially Involved
R9x12T	2013	13
R9x12T	2014	13
R400T	2013	3
R400T	2014	6
R600HC	2014	2

Total Number Potentially Affected by the Recall:

37

Approximate percentage of Total Number of Vehicles Estimated to actually contain the defect or noncompliance:

97%

Identify and describe how the recall population was determined, in particular how the recalled models were selected and the basis for the beginning and final dates of manufacture of the recalled vehicles: The specified units were identified from manufacturing and design records maintained by Vermeer Manufacturing Company as all having the same suspension system design.

III. Describe the Defect or Noncompliance

Describe the defect or noncompliance. The description should address the nature and physical location of the defect or noncompliance. Illustrations should be provided as appropriate.

Describe the cause(s) of the defect or noncompliance condition.

Manufacturing documents did not provide sufficient information for manufacturing personnel to accurately weld suspension pivot bolts after torqueing. Bolts were properly torqued during manufacturing assembly. Welds are placed as a secondary means of securing bolt. See attached drawing marked as Exhibit A showing area of three pivot bolts per side of reclaimer.

Describe the consequence(s) of the defect or noncompliance condition.

Pivot bolts could loosen, resulting in partial axle separation from the reclaimer. Complete separation of axle from reclaimer main frame is unlikely due to attachment of other suspension component to reclaimer mainframe. See attached product brochures marked as Exhibit B.

Identify any warning which can (a) precede or (b) occur.

- (a) Loose or missing pivot bolts observed during routine maintenance as instructed in unit's operator's and maintenance manual.

If the defect or noncompliance is in a component or assembly purchased from a supplier, identify the supplier by corporate name and address.

Not applicable.

Identify the name and title of the chief executive officer or knowledgeable representative of the supplier.

Not applicable.

IV. Provide the Chronology in Determining the Defect/Noncompliance

If the recall is for a defect, complete item 6, otherwise item 7.

With respect to a defect, furnish a chronological summary (including dates) of all the principle events that were the basis for the determination of the defect. The summary should include, but not be limited to, the number of reports, accidents, injuries, fatalities, and warranty claims.

16 JUNE 2014 Initial report from field: A Vermeer dealership in Pennsylvania reported a potential issue in the field on R9X12T serial number 132 regarding the area where the suspension pivot bolt attaches to the machine frame. The dealer's information was received from a retail customer who was doing a routine inspection according to Vermeer operator's and maintenance manual instruction of the machine on the customer's yard. No failure of

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suspension occurred.

18 JUNE 2014 Vermeer initiated an investigation into the reported issue, including inspecting existing units in factory and dealer inventory with the same suspension configuration.

01 JULY 2014 Vermeer completed its investigation and concluded that welds are missing on units in field.

07 JULY 2014 No reports of accidents or injuries have been reported.

With respect to a noncompliance, identify and provide the test results or other data (in chronological order and including dates) on which the noncompliance was determined.

Furnish a description of the manufacturer's remedy for the defect or noncompliance. Clearly describe the differences between the recall condition and the remedy.

Add secondary means of securing the suspension pivot bolt by adding weld to each bolt area.

Clearly describe the distinguishing characteristics of the remedy component/assembly versus the recalled component/assembly.

Field repair kit is currently under development.

Identify and describe how and when the recall condition was corrected in production. If the production remedy was identical to the recall remedy in the field, so state. If the product was discontinued, so state.

Manufacturing personnel have been advised of the issue and instructions have been provided to weld each suspension pivot bolt after it has been properly torqued. Manufacturing documents are being updated and further training is in the process of being provided.

VI. Identify the Recall Schedule

Furnish a schedule or agenda (with specific dates) for notification to other manufacturers, dealers/retailers, and purchasers. Please, identify any foreseeable problems with implementing the recall.

TBD: Complete development of field inspection and modification kit, including field kit repair instructions.

TBD: Factory will publish Service Bulletin and Kit Instructions to dealers introducing field modification kit via company-to-dealer website.

TBD: Factory will provide listing of affected units in their area to dealers via email.

TBD: Factory will notify owners of mandatory field modifications via certified/registered US mail.

VII. Furnish Recall Communications

Furnish a final copy of all notices, bulletins, and other communications that relate directly to the defect or noncompliance and which are sent to more than one manufacturer, distributor, or purchaser. This includes all communications (including both original and follow-up) concerning this recall from the time your company determines the defect or noncompliance condition on, not just the initial notification. A DRAFT copy of the notification documents should be submitted to this office by Fax (202-366-7882) for review prior to mailing.

Exhibit B

RECLAIMER

R9x12T



Vermeer[®]



Specifications

GENERAL WEIGHTS AND DIMENSIONS

Curb weight: 63,900 lb (28,984.6 kg)
Length: 53' (16.2 m)
Width: 8.5' (2.6 m)
Height: 13.4' (4.1 m)

FRAME

Type: Fifth wheel trailer
Suspension: Triple axle with air-ride
Axles: 10-bolt hub-piloted ABS ready
Certifications: DOT lighting and braking

FEATURES

Agitator system: 3 – 4.4 hp (3.3 kW)
stainless steel bladed motors
Air compressor: 150 psi (10.3 bar) max
Ancillary electrical system: 120 VAC or 240 VAC
Working lights: 3 – 42W 12V LED

TANK CAPACITIES

Maximum capacity: 8361 gal (31,649.8 L)
Number of tanks: 3
Clean/Middle tank capacity: 3128 gal (11,840.8 L)

CLEANING SYSTEM

Shaker type: Linear or orbital
Number of shakers: 4 (2 motors/shakers)
Shaker bed area – each: 26 sq ft (2.4 m²)
Number of screens per shaker: 3
Screen dimension: 25" x 49.25"
(63.5 cm x 125.1 cm)
Cleaning capacity (first cut): Up to 500 gpm/
shaker (1892.7 L/min)
Desander capacity: 1500 gpm (5678.1 L/min)
Desander quantity/size: 3 – 10" (25.4 cm) cones
Desilter capacity: 1280 gpm (4845.3 L/min)
Desilter quantity/size: 16 – 5" (12.7 cm) cones

GENERATOR SET

60 Hz Tier 3 (Stage IIIA)

Make and model: John Deere 6090HF484
Engine power: 422 hp (314.8 kW) @ 1800 rpm
Generator: 3 phase 250 kW (313 kVA)

60 Hz Tier 4i (Stage IIIB)

Make and model: John Deere 6090HFG95
Engine power: 440 hp (328.2 kW) @ 1800 rpm
Generator: 3 phase 260 kW (325 kVA)

50 Hz Stage II

Make and model: John Deere 6090HF475
Engine power: 408 hp (304.4 kW) @ 1500 rpm
Generator: 3 phase 245 kW (306 kVA)

Performance Specifications

FIRST CUT SHAKERS

Shaker decks 1, 2



DESANDER CONES (3)

Shaker deck 3



DESILTER CONES (16)

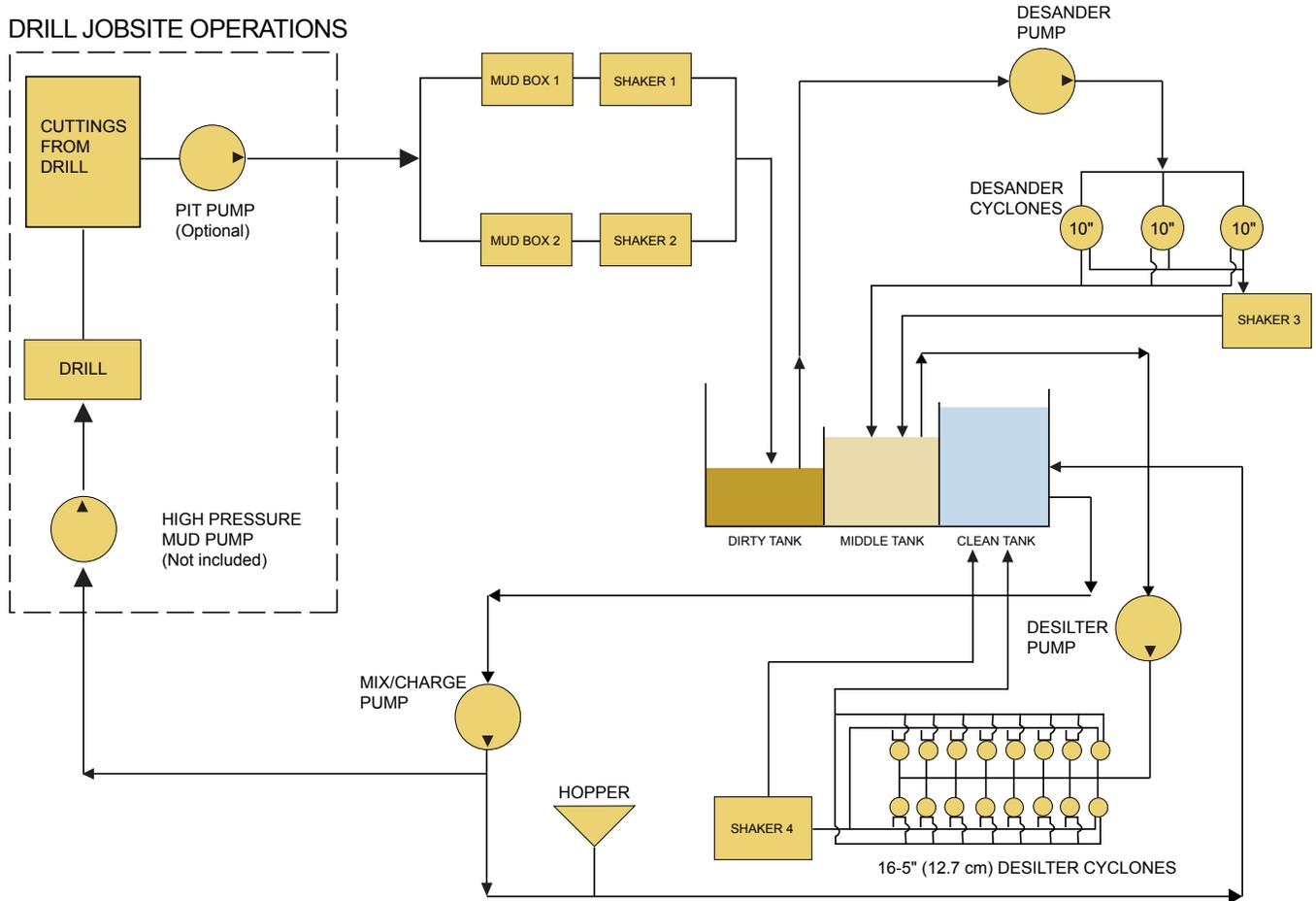
Shaker deck 4



THREE SCREENS PER SHAKER

26 sq ft (2.4 m²) per deck

Jobsite Flow Chart



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RECLAIMER

R400T



Vermeer[®]

R400T

ONBOARD PUMP



The R400T has an onboard pump built into the unit delivering the same power and performance of a stand-alone high pressure mud pump.

Onboard Pump



The onboard pump reduces the amount of support equipment needed on jobsites — minimizing hauling and trucking costs and making it easier to work in tight right-of-ways.



The pump is hydraulically driven, allowing for infinitely variable amounts of mud flow and enabling contractors to operate with precision no matter the ground conditions.



A wireless remote mud pump control allows drill operators to monitor pressure and mud flow from within the driller's cabin.



With EcoMode function, operators are able to regulate mud flow while optimizing fuel efficiency for jobsite cost savings.



Specifications

GENERAL WEIGHTS AND DIMENSIONS

Curb weight: 87,700 lb (39,780 kg)
Length: 53' (16.2 m)
Width: 8.3' (2.5 m)
Height: 13.5' (4.1 m)

FRAME

Type: Fifth wheel trailer
Suspension: Triple axle with air-ride
Axles: 10-bolt hub-piloted ABS ready
Certifications: DOT lighting and braking

FEATURES

Agitator system: 3 submersible mixers
Air compressor: Manual
Ancillary electrical system: 120 VAC
Working lights: 3 – 42W 24V LED
Sound pressure at operator's ear: 84 dBA

CLEANING SYSTEM

Shaker type: Triple screen with adjustable inclination
Number of shakers: 3
Shaker bed area – each: 25.6 sq ft (2.4 m²)
Number of screens per shaker: 3
Screen dimension: 25" x 49.3"
(63.5 cm x 125.1 cm)
Cleaning capacity (first cut): 500 gpm/
shaker (1892.7 L/min)
Desander capacity: 1000 gpm (3785.4 L/min)
Desander quantity/size: 2 – 10" (25.4 cm) cones
Desilter capacity: 800 gpm (3028.3 L/min)
Desilter quantity/size: 10 – 5" (12.7 cm) cones

TANK CAPACITIES

Max capacity: 6375 gal (24,132 L)
Number of tanks: 3
Clean/Middle tank capacity: 3500 gal (13,248.9 L)

GENERATOR SET

60 Hz Tier 4i (Stage IIIB)

Make and model: John Deere 6090HFG95
Engine power: 440 hp (323.6 kW)
Generator: 260 kW (325 kVA) prime

MUD PUMP ENGINE

Tier 4i (Stage IIIB)
Make and model: John Deere 6090HFC95
Engine power: 384 hp (282.4 kW)

Performance Specifications

FIRST CUT SHAKERS

Shaker decks 1, 2



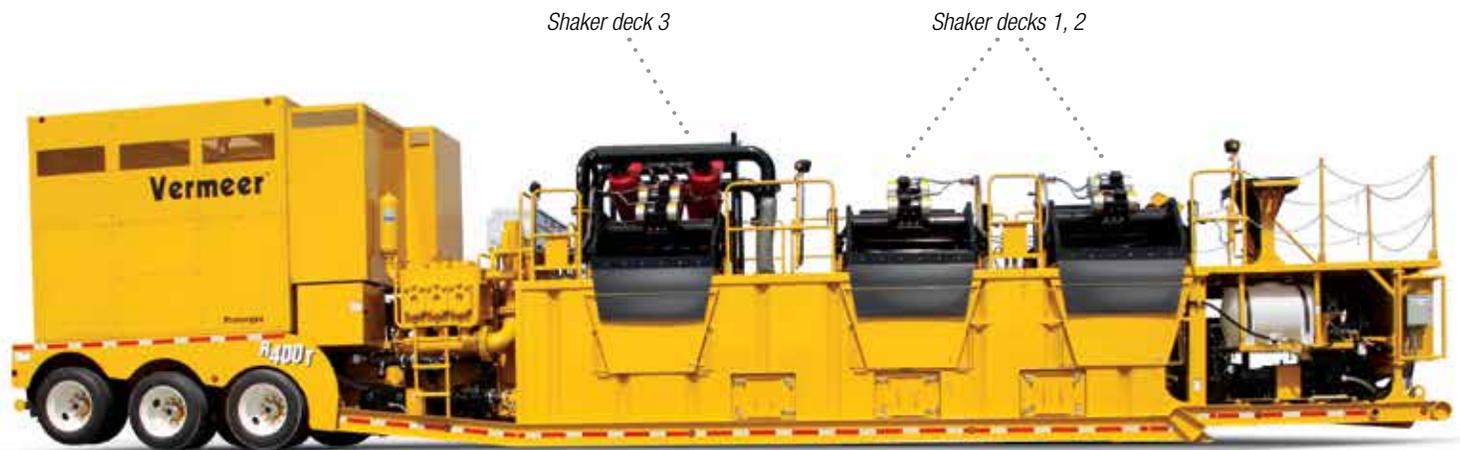
DESANDER CONES (2)

Shaker deck 3



DESILTER CONES (10)

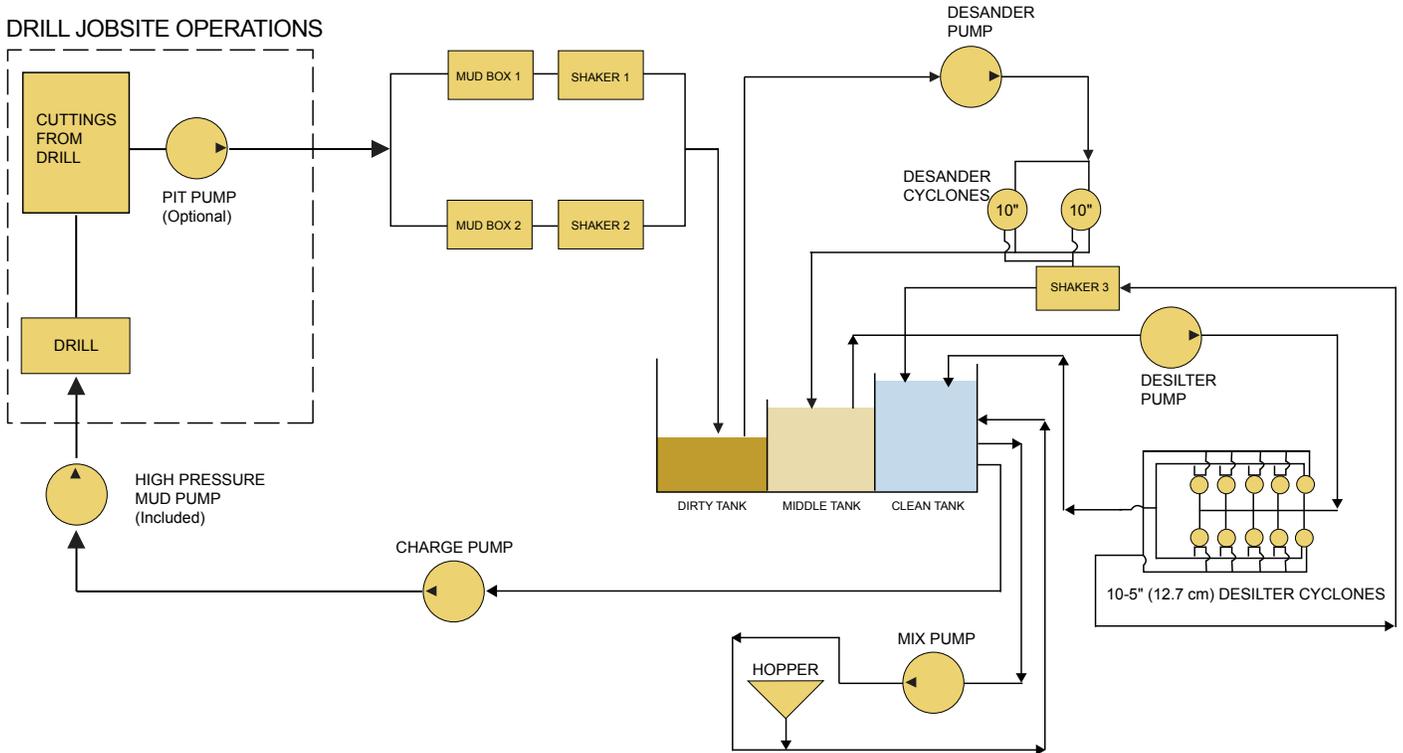
Shaker deck 3



THREE SCREENS PER SHAKER

26 sq ft (2.4 m²) per deck

Jobsite Flow Chart



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R600HC RECLAIMER



DESIGNED FOR THE OIL AND GAS INDUSTRY. The explosion-proof R600HC is designed without an onboard power source for operation. Key components are suited for use in potentially explosive atmospheres. The R600HC is designed in accordance with IECEx (International Electrotechnical Commission) guidelines making it fit to work in the oil and gas fields.



ALL HANDS ON DECK. The inlet guiding flow into mud tanks is below deck, allowing fluid to be divided into one tank, two tanks or neither tank, depending on job needs. Placement allows for greater freedom on the working deck and keeps a clear pathway for workers.



TWO POINTS OF ACCESS. The R600HC features an elevated work platform with two means of entry; this industry-exclusive feature provides workers admittance to the working deck.



CLEANING CAPACITY. Using dual first-cut shakers and a series of desander and desilter cones, the R600HC is able to support an industry-leading 600 gpm (2271.2 L) pump, which makes for a more productive fluid cleaning process, while helping to reduce the amount of wear machine components experience.



LEAVE THE LIGHT ON. LED amber colored work lights are battery powered enabled, illuminate the working deck and can be run without using a standalone generator, while attracting fewer insects.



PROTECT YOUR INVESTMENT. The R600HC design uses an optional marine grade epoxy barrier coating which helps reduce corrosion from drilling fluids and also improves durability and abrasion resistance.

