



**Vermeer Corporation**

Trenchless  
 Pella, IA 50219 USA

**FIELD CAMPAIGN KIT # IK003061**

**DATE:**

**05 September 2014**

*For Dealer Reference: Service Bulletin #SVC2014-589*

**Reclaimer Pivot Bolt Kit**

**CAMPAIGN  
 TYPE:**

<input checked="" type="checkbox"/> <b>Mandatory - Product Safety</b>	<input type="checkbox"/> <b>Special Consideration (Fix-as-Fail)</b>
<input type="checkbox"/> <b>Mandatory</b>	<input type="checkbox"/> <b>Special Consideration (Information Only)</b>
<input type="checkbox"/> <b>Recommended</b>	<input type="checkbox"/> <b>Free Product Safety Mailing</b>

MACHINE / ATTACHMENT MODEL(S):	Serial Numbers		Kit Version
	Included	Excluded	
R9X12T	101 – 147	146	IK01
R600HC	None	100 – 101	IK01
R400T	98, 101	99, 102 – 106	IK01

**PURPOSE:**

**POSSIBLE PARTIAL AXLE SEPARATION.** During manufacturing, the weld that provides the secondary method of securing the pivot bolts to the axle may not have been properly completed.

If the weld fails and the pivot bolts become loose, the axle may partially separate from the frame. If partial separation occurs, loss of control of the reclaimer and towing vehicle may occur. **Death or serious injury is possible.** Property or equipment damage is also possible.

This kit includes parts and instructions for inspect the weld. If inspection finds that the weld was not properly completed, new pivot bolts will be installed and the bolts secured with a new weld

## **SPECIAL TOOLS AND CONDITIONS:**

- **Welder**
- **Grinder**
- **Vermeer yellow paint**



### **WARNING!**

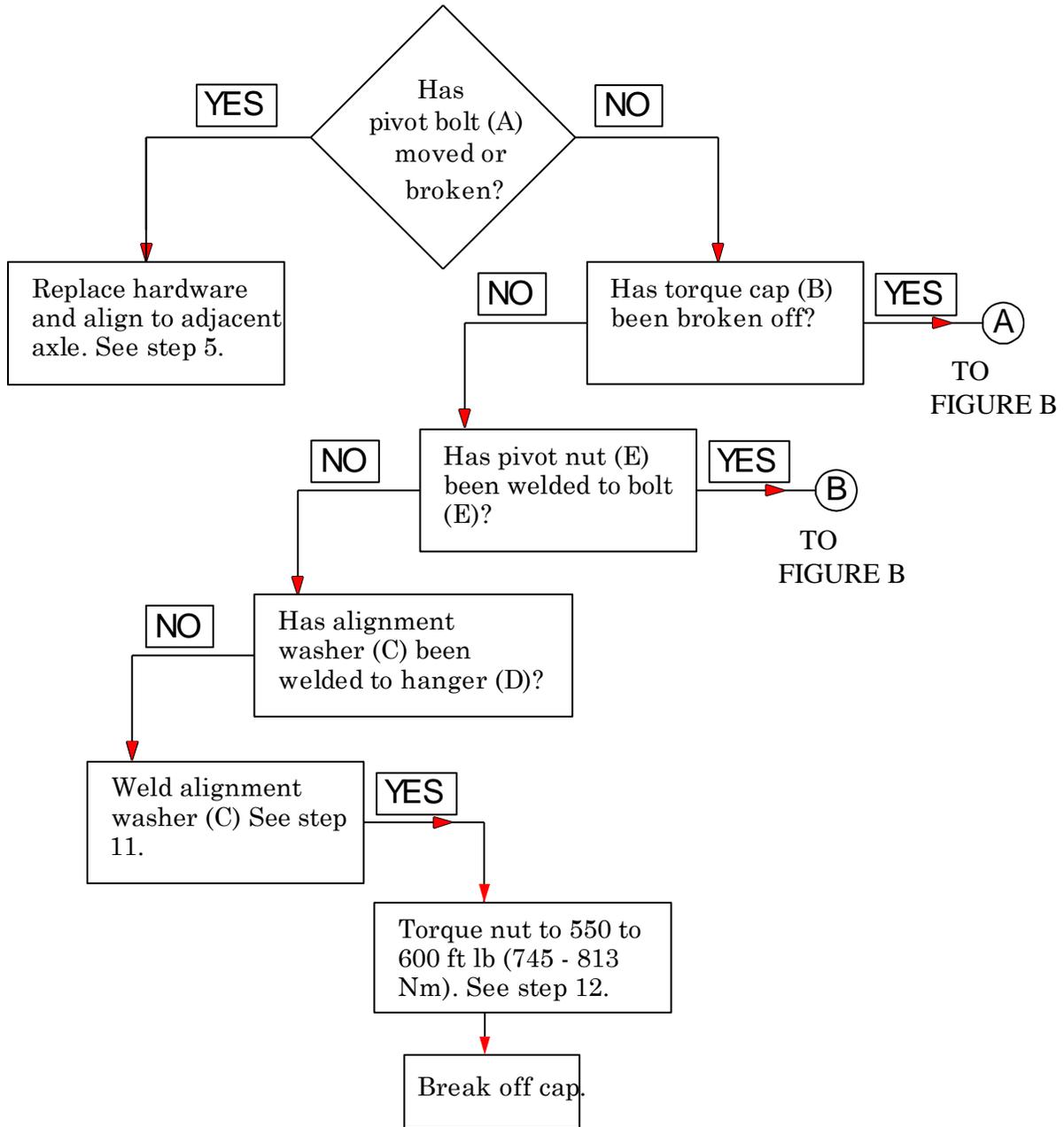
Use the following Shutdown Procedure before attempting to do any of the work described in this Kit.

1. Shut off Discharge Pump.
2. If optional Pit Pump is connected, shut off pump.
3. Shut off Desilter Pump and Desander Pump.
4. After all spoils have been discharged from shaker screens, shut off all shakers: Desander Shaker, Desilter Shaker and Primary Shakers.
5. Shut off Agitators.
6. Shut off Main Circuit Breaker.
7. Close Manual Fluid Valves if necessary.
8. Press Genset Off Button and Controller Power Switch.
9. Wait 10 seconds, then disconnect battery at switch.

## **PROCEDURE 1: IK01**

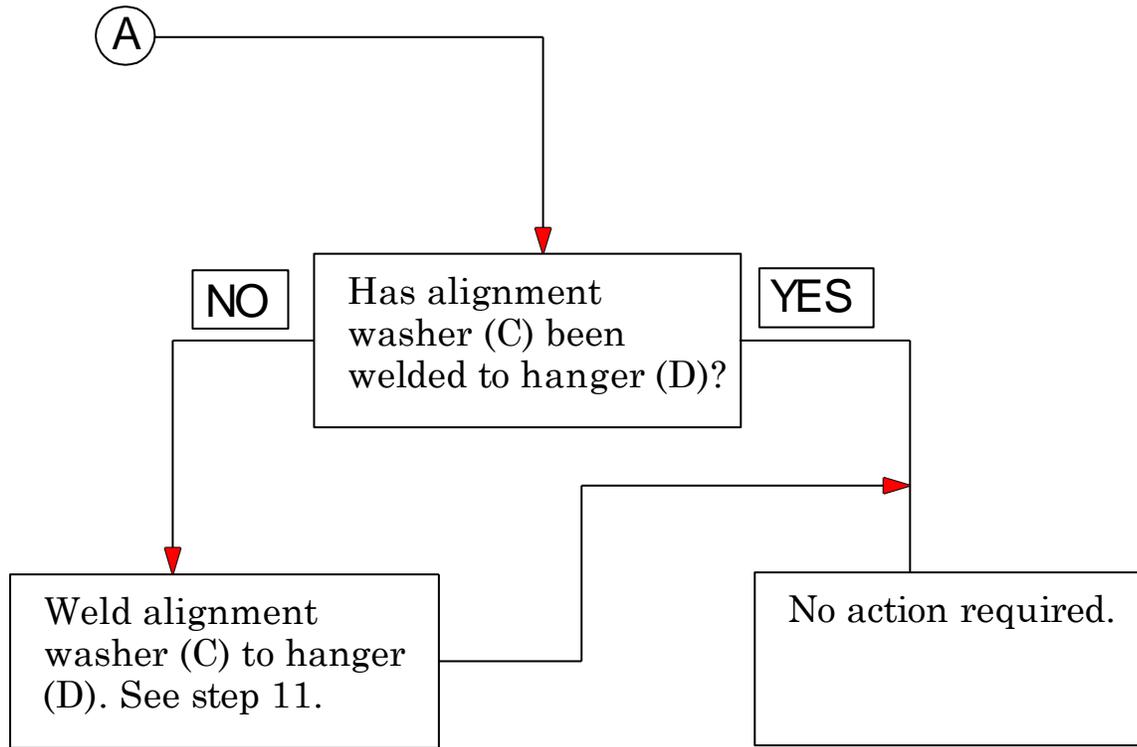
1. Position reclaimer on a level surface and disconnect it from tractor.
2. Lower machine to operating position.
3. Follow Shutdown Procedure if machine has been operating.
4. Use flow charts Figure A, and Figure B to determine the course of action to be taken. Refer to Figure C for component locations.

Figure A



FROM  
FIGURE A

**Figure B**



FROM  
FIGURE A

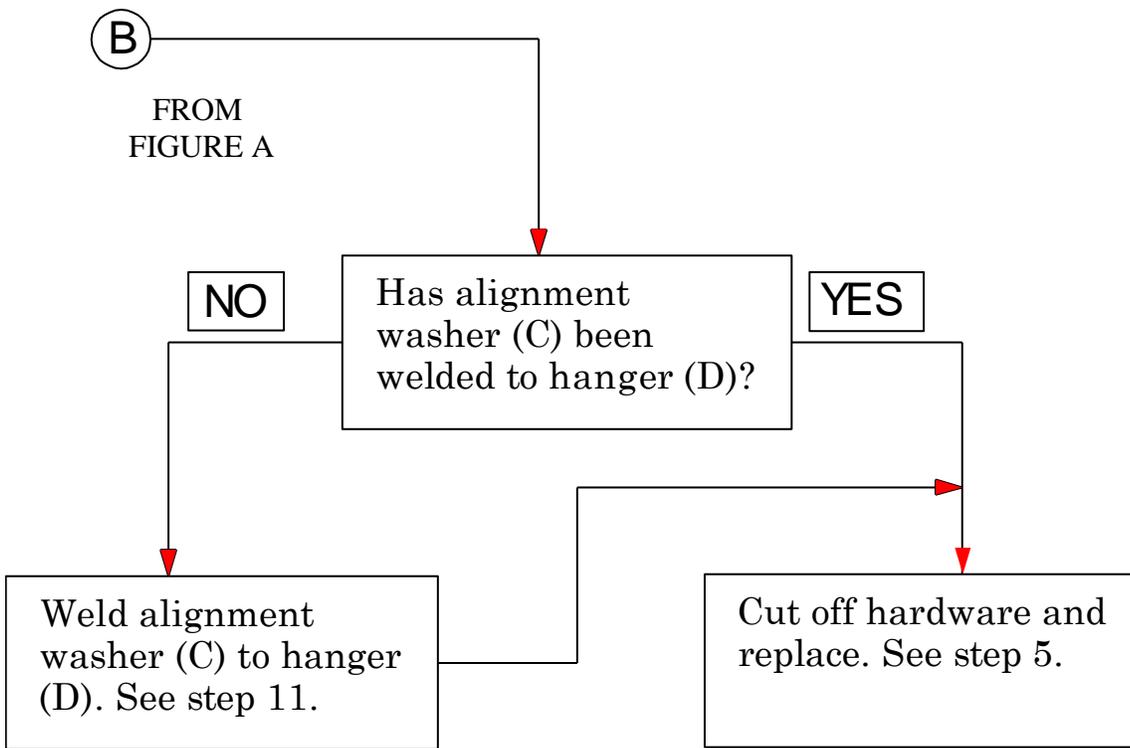
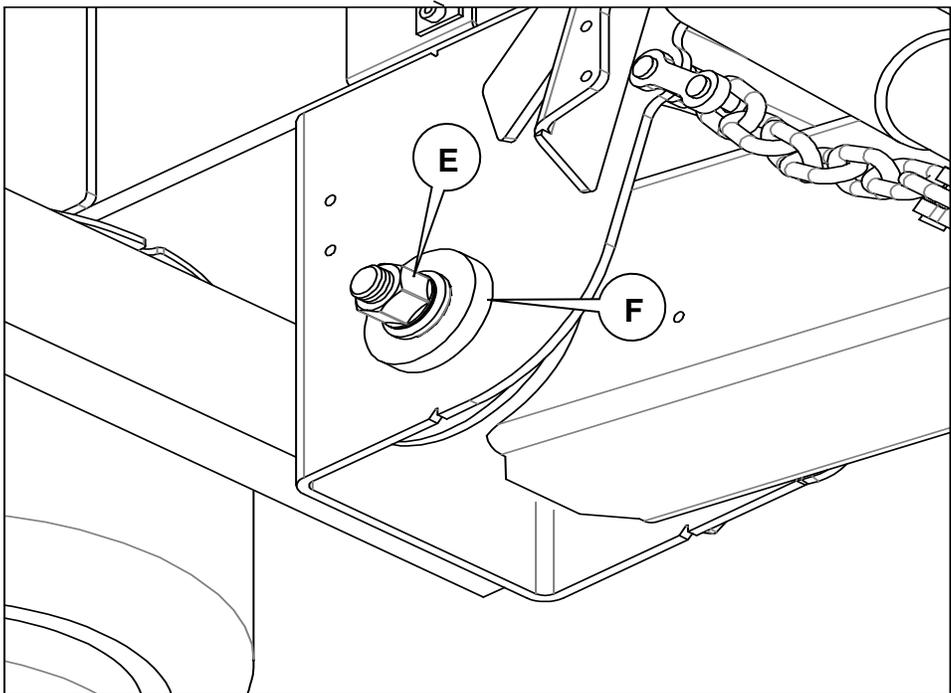
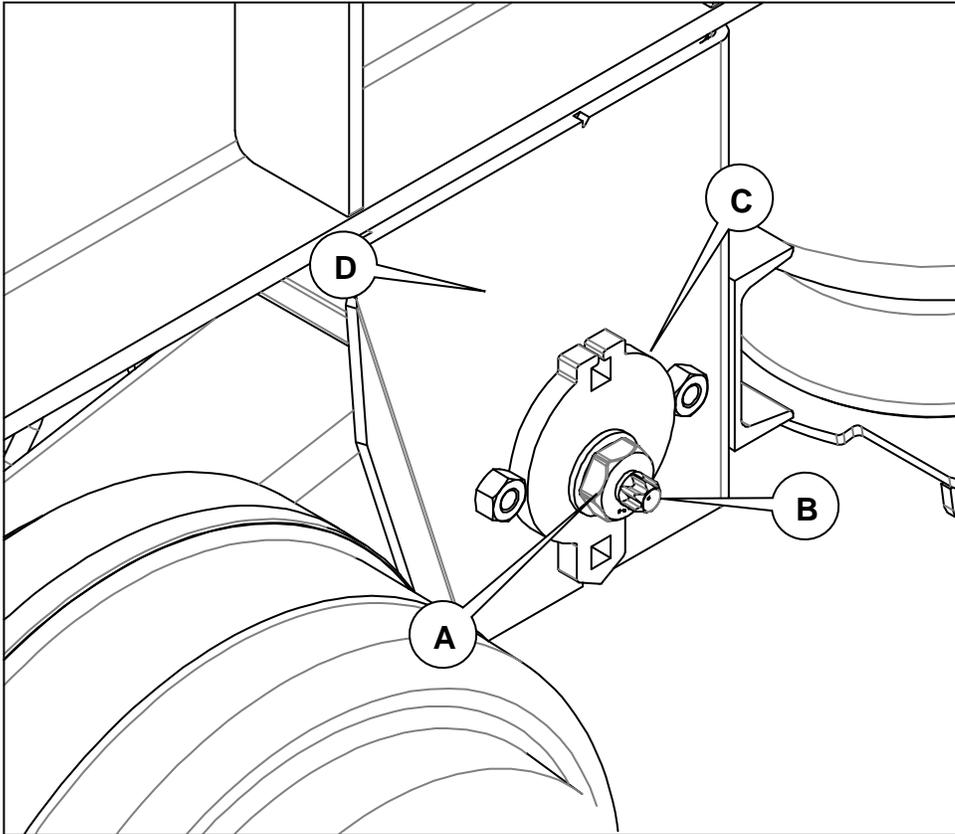
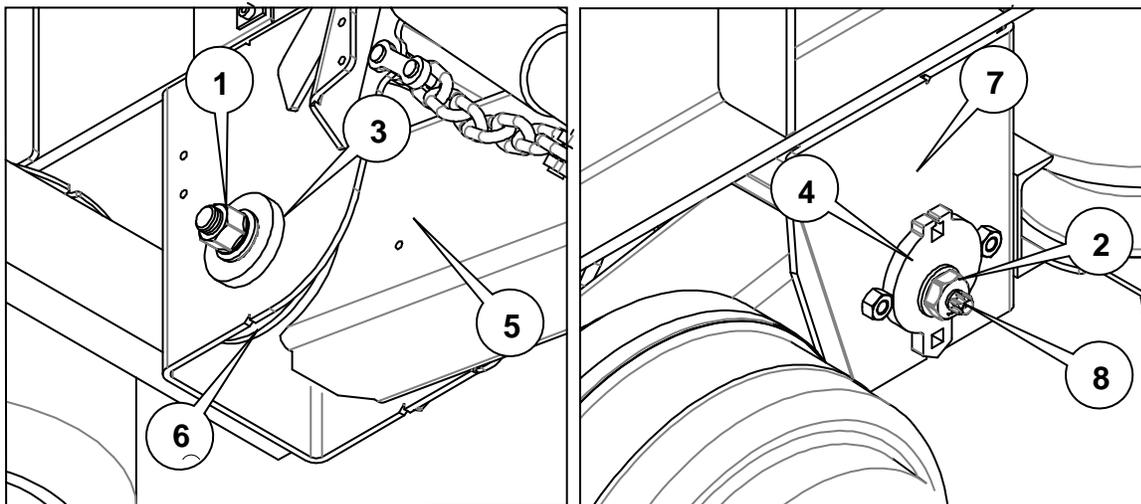


Figure C



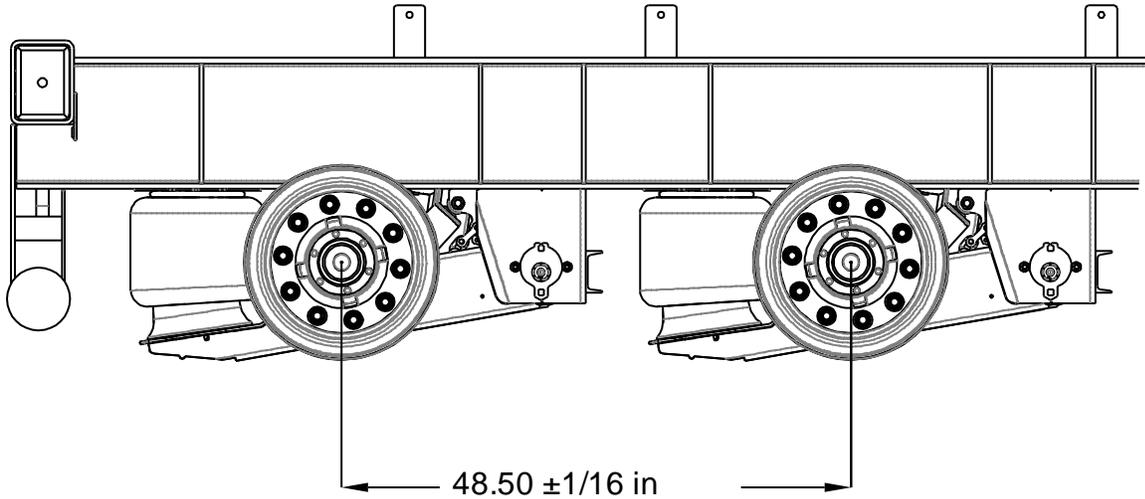
5. Remove and discard nut (1). If nut (1) has been welded to bolt, cut off bolt (2) on the nut side of the bracket and discard nut (1). Remove and discard washer (3), and bolt (2). (Note that some bolts may have a rounded head instead of a hex head). Refer to Figure 1.
6. If alignment washer (4) is welded to the pivot bracket (5), and not damaged, it can be left in place. Refer to Figure 1.
7. If alignment washer (4) has been damaged, or welds are broken, grind welds and remove washer and discard. Grind area smooth. Refer to Figure 1.
8. Install supplied alignment washer (4) if needed, supplied washer (3), and bolt (2) through trailing arm (5), plastic washers (6) and pivot bracket (7). Refer to Figure 1.
9. Install washer (3), and nut (1). Refer to Figure 1.

**Figure 1**



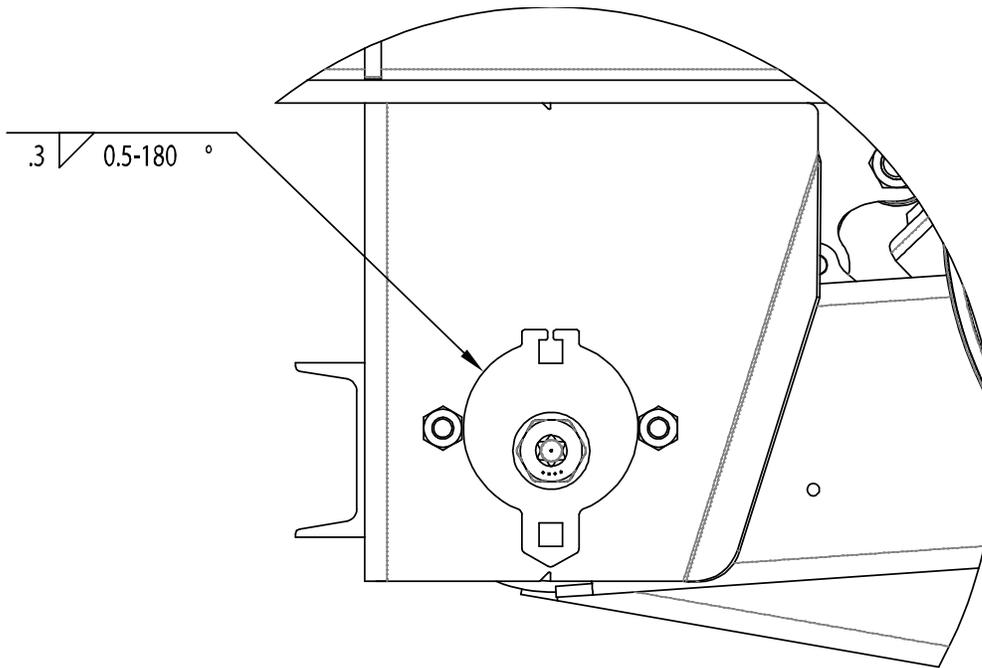
10. If alignment washer is being replaced, the axle will have to be aligned. If not, proceed to step 12. Measure the distance between the affected axle and the adjacent axle. Refer to Figure 2 for dimension. Use the square head of a ratchet or breaker bar in the hole of the alignment washer to rotate it clockwise or counter clockwise to adjust the distance between the axles. The left and right side dimension will be the same.

Figure 2



11. When the axle has been aligned, weld the alignment washer. Refer to Figure 3.

Figure 3



- 12.** Using the supplied E20 Torx socket, torque pivot bolt by securing the nut (1) and rotating clockwise until the cap (8) snaps off. This torques the bolt to 550–600 ft-lb (745–813 Nm). (Note that the bolts provided in the kit have a rounded head instead of a hex head). Refer to Figure 1.
- 13.** Complete and submit work completion card Ref. (1), Figure 5, after kit has been installed.
- 14.** Remove Figure 4 and 5 and provide to unit owner to place with existing Parts Manual. Delivery of these pages to the unit owner can be accomplished by attaching pages to the customer's copy of the invoice or placing the pages in the unit's manual storage box.

Figure 4

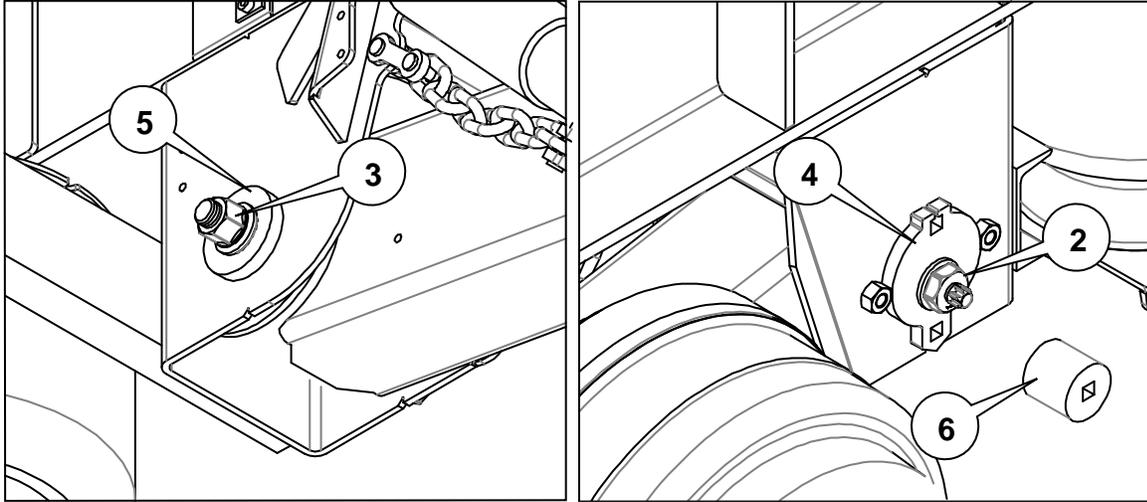
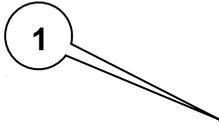


FIGURE 4 Parts List

REF. NO.	PART NO.	DESCRIPTION	IK01 QTY.
1	296443273	WASHER- 0.875" SAE	6
2	296443274	Bolt-AUDITORX HHCS 0.875"x10"	6
3	296443275	NUT-HFTL 0.875"	6
4	29644277	WASHER-ALIGNMENT ECCENTRIC	6
5	29644278	WASHER-ALIGNMENT BEARING PLATE	6
6	296443279	SOCKET-3/4 DRIVE E20 TORX IMPACT	1
Kit IK003061 includes all items in Figure 4 and 5 Parts List			

**FIGURE 5**



NO POSTAGE  
NECESSARY  
IF MAILED  
IN THE  
UNITED STATES

**BUSINESS REPLY MAIL**  
FIRST CLASS PERMIT NO. 56 PELLA, IOWA  
POSTAGE WILL BE PAID BY ADDRESSEE



**Vermeer Corporation**  
**Attn: Product Safety Dept.**  
**Box 200**  
**Pella, IA 50219-9987**



<b>FIGURE 5</b>			
<b>REF. NO.</b>	<b>PART NO.</b>	<b>DESCRIPTION</b>	<b>QTY.</b>
1	296287039	WORK COMPLETION CERTIFICATE - SAFETY KIT	1
		Kit IK003061 includes all items in Figure 4 and 5 Parts List	
		<b>(Inc. All Items In Figures 4 &amp; 5)</b>	