

PRODUCT SUPPORT BULLETIN **No.0203**

PRODUCT: Mobile Carriers

May 25, 1998

SUBJECT: New Holland Axles

EQUIPMENT AFFECTED: Axle Models D61/D64

CLASSIFICATION: Mandatory Safety
Mandatory Repair
Optional Repair
Fix-as-fail
Information

SITUATION: There are recent concerns in the way our D61, D64, D45 and D65 drive axles have been mounted on vehicle frames.

SOLUTION: Typical mounting of a D61, D64, D45 and D65 axle consists of using bolts to clamp the top of the trumpet housing surface to a vehicle frame. Due to standard casting and machining tolerances, a measurable out of plane condition often exists between the right and left trumpet housings. Shims should be used on the top surfaces of the trumpet housings so that the maximum gap to be drawn down at assembly is 1mm. If shims are not used during assembly, excessive preload stress and trumpet fracture can occur. The recommended procedure for installing the shims is as follows:

1. Install axle mounting bolts on one side of the vehicle. Tighten bolts in an alternate pattern to one-half of the recommended torque (one half of the recommended torque is 70 to 85 ft.lbs.).
2. Measure the gap on the front or back side of the opposite trumpet housing. If the gap is 1-3mm, install shims on one trumpet housing to reduce the gap to a maximum of 1mm. If gap is 4-7mm, install shims on front side of one trumpet housing and rear side of other trumpet housing to reduce the gap to a maximum of 1mm.
3. Install shims selected above and torque bolts in alternate pattern to half of the recommended torque.
4. Tighten all bolts to recommended torque of 140 to 170 ft.lbs.