

Bulletin 01/2013

Subject: Caterpillar MD6420 Mast Pivot Connection Bolts
May be Incorrect Grade

Affected Product: Caterpillar MD6420 (SK75i, SKS, SKS-W) Drills.

Risks identified: Possible Failure of the Mast Pivot Connection.

Problem Overview:

Caterpillar has identified an error in the Caterpillar parts system. This error has resulted in the supply of SAE Grade 5 bolts in place of the correct SAE Grade 8 bolts for part numbers 0038107, 38107 and 1232607. These bolts are specified for the Mast Pivot Connection Joint on Caterpillar MD 6420 (SK75i, SKS, SKS-W) Drills. If the incorrect part is fitted, the mast pivot joint may fail.

Affected Part Numbers:

Description	Legacy Part no	Replacement Part no
Hex, 1½"x7½", UNC, Gr 8	38107	1232607
Hex, 1½"x7½", UNC, Gr 8	0038107	1232607

Corrective Actions Implemented by Hastings Deering:

1. The incorrectly identified bolts have been removed from stock; and
2. The Hastings Deering parts system cross reference between parts numbers has been corrected to ensure Grade 8 bolts are supplied for the mast pivot connection joint.

What to Do:

Hastings Deering requests customers with MD 6420 (SK75i, SKS, SKS-W) model drills undertake the following immediate actions:

- Inspect machine mast pivot connection area for the correct Grade 8 mast pivot cap bolts. Refer to figure 1 for identification of bolts. **If the bolts are incorrect, immediately stop the machine and replace them with the correct Grade 8 bolts**
- Check recently supplied 0038107, 38107 and the replacement part number 1232607 bolts that have not been installed. Ensure they are the correct Grade 8 bolts before you install them
- Return any incorrectly supplied 003107, 38107 or 1232607 bolts, to Hastings Deering, for replacement with the correct Grade 8 bolts.

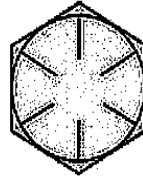
Inspection Procedure:

Inspect the mast pivot connection area to ensure that Grade 8 bolts have been installed at all positions. (Ref: Figures 1, 2 & 3 Below)

Grade 5 and Grade 8 bolts can be identified by the number of radial lines stamped on the top of the bolt head by the manufacturer. Grade 5 bolts have three lines 120 degrees apart. Grade 8 bolts have six lines 60 degrees apart. Refer figure 1 below for typical examples



Grade 5 Fastener



Grade 8 Fastener

Figure 1 – Grade 5 and Grade 8 bolt markings

Mast pivot connection joint:

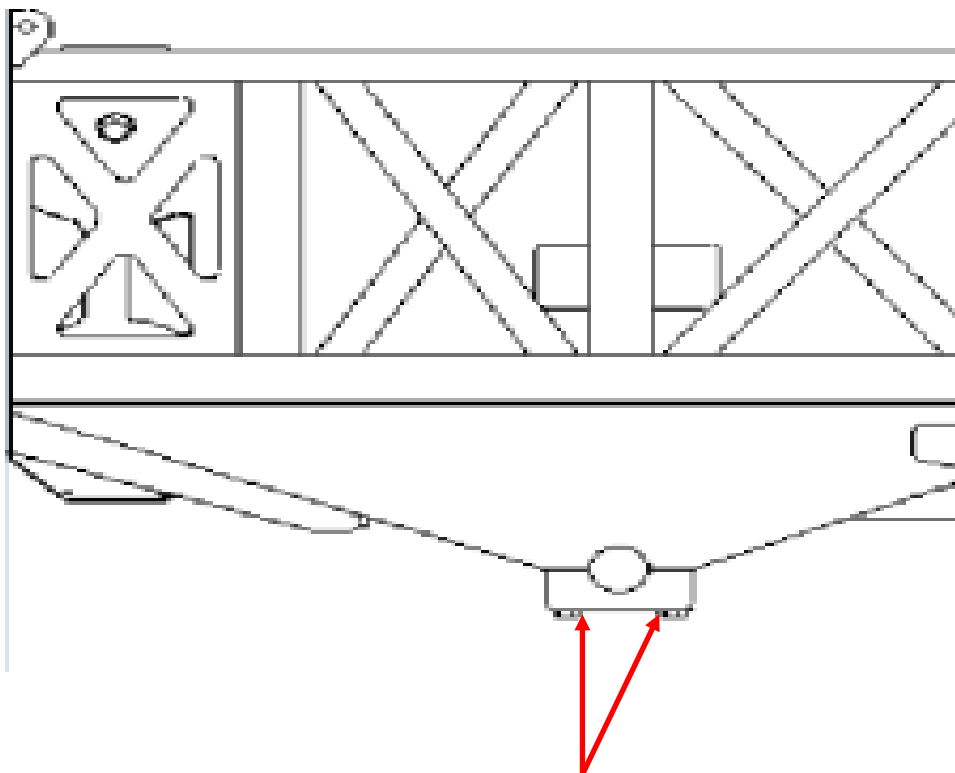


Figure 2 Bolt location

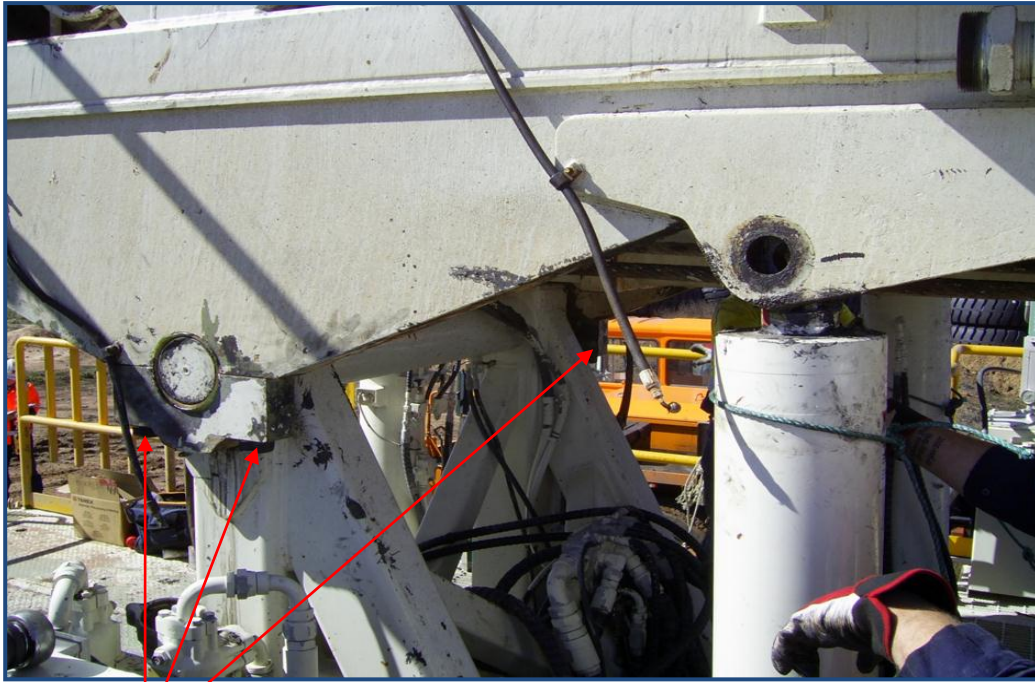


Figure 3 Mast Pivot connection joint bolt location

Do Not Operate the Machine if this connection has Grade 5 bolts or if the findings reveal a mix of Grade 5 and Grade 8 bolts in the mast pivot connection joint.

Machines should be tagged 'out of service' in accordance with site procedures and not be returned to service until all incorrect bolts have been replaced with the correct part and torqued to specification

Do not operate the machine until any defects identified in this inspection task have been corrected.

Contact Details:

If the inspection identifies incorrectly supplied bolts, please contact your Product Support Advisor at our Excavation and Underground Support Group.

This bulletin is to inform you of the recommendations of the supplier in respect of issues dealt with in the bulletin and should not be used as specific advice in respect of any particular events. Advice from a qualified repairer should be sought in respect of any particular events and Hastings Deering (Australia) Ltd accepts no responsibility for any loss or damage occasioned by a party using this general bulletin.