



S0012 Bandy Leg Housing Change to Standard Stabiliser Housing

S0012	Version 1	Structural	23-08-04
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The following procedure may be used to convert bandy leg housings back to standard stabiliser housings.

The following parts are required:

Part number:	Part Description:	Quantity:
S6-18066	Cap End Stabiliser Housing MK6	1 required

The procedure for changing the stabiliser housing is laid out on the following pages:

Step 1:

Remove detachable backing plate from Bandy leg housing.
Remove weld around cover pressing as shown in drawing. Once the weld around the cover pressing is removed, remove the cover pressing. Do not damage the side plates and top plate of the stabiliser housing. If there is gouging to the side plates or the top plates this will have to be welded up and then ground flush with the plates surface.

WELDING NOTES:
Parent Material: ASTM A514
Filler Material: CMK56 or Equivalent
Gas: Argonshield Universal
Wire: Solid Wire 12mm
AWS A5.18/ASME SFAS.18ER 785-6

	3 - 12mm	12 - 19mm	19 - 25mm
PREHEAT	50 - 75°C	75 - 100°C	100 - 120°C
MAXIMUM INTERPASS	150°C	180°C	200°C

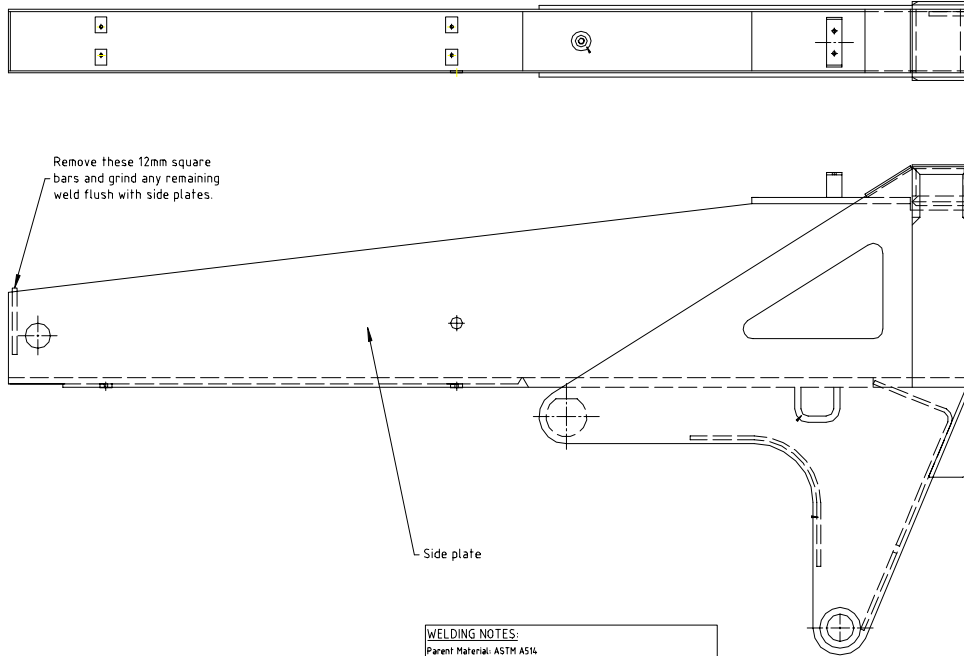
Title: Stabiliser housing Mk6 Bandy		Part: B
Notes:		Filename: S6-33151.dwg
STEELBRO New Zealand Ltd 1-31 Trellers Rd, Christchurch New Zealand		Drawn: aidsuc Date: 18/12/2013 Mass: kg A2

A	23/08/2013	First Issue	aiduc
B		Modification	



Step 2:

Remove weld around the 12mm square bar, holding the detachable backing plate on, and remove 12mm square bar. Grind any remaining weld flush with the side plates of the stabiliser housing. If there is gouging to the side plates this will have to be welded up and then ground flush with the plates surface.



WELDING NOTES:

Parent Material: ASTM A514
Filler Material: CMK56 or Equivalent
Gas: Argonshield Universal
Wire: Solid Wire 12mm
AWS A5.18/ASME SFA5.18ER 71S-6

	3 - 12mm	12 - 19mm	19 - 25mm
PREHEAT	50 - 75°C	75 - 100°C	100 - 120°C
MAXIMUM INTERPASS	150°C	180°C	200°C

Date	Stabiliser housing Mk6 Bandy	Part	Rev
Notes	Filename	S6-33151	A
Drawn	aldruc	18/12/2003	
Mass	kg		
	A2		

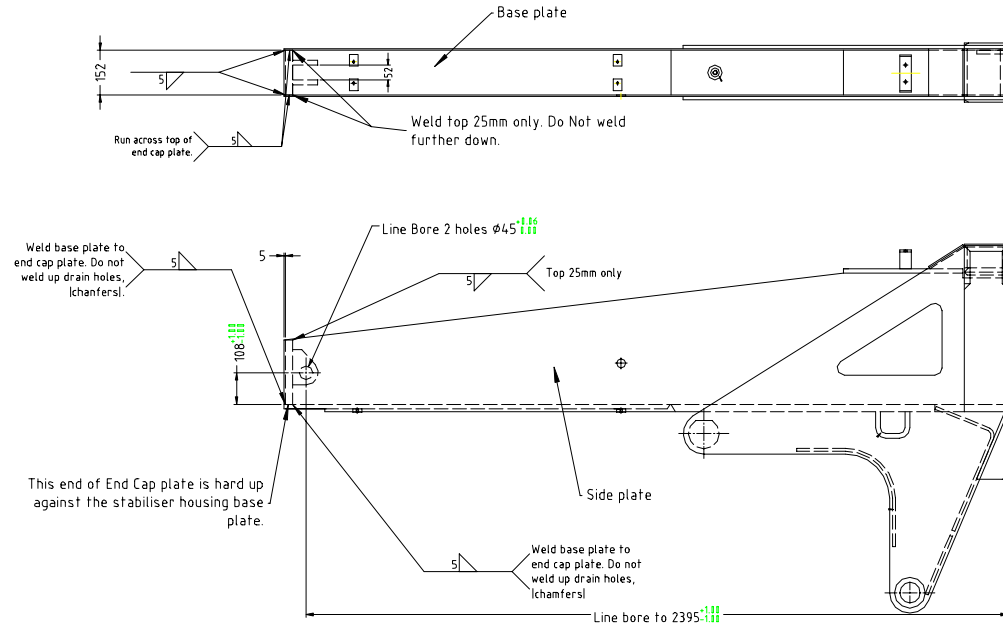
A	25/01/2014	First Issue	aldruc
B	Date	Modification	Name



Step 3:

Insert End cap for the stabiliser housing (part No. S6-18066, supplied). Check width of Stabiliser housing. Weld in according to dimensions and welding instructions shown in the drawing below. Once the end cap has been welded into position, line bore hole to given dimensions. Ensure that the 52mm gap between the lugs on end cap is not changed during line boring.

WELDING NOTES:			
Parent Material: ASTM A514			
Filler Material: OM556 or Equivalent			
Gas: Argonshield Universal			
Wire: Solid Wire 12mm			
AWS AS.18/ASME SFA5.18ER 718-6			
	3 - 12mm	12 - 19mm	19 - 25mm
PREHEAT	50 - 75°C	75 - 100°C	100 - 120°C
MAXIMUM INTERPASS	150°C	180°C	200°C



A	23/06/2014	First issue	ajdsuc
#	Date	Modification	Name

1	S6-18066	Cap End Stabiliser Housing Mk6	1.00	EA	
Rev	Part No	Description	Qty	Unit	Notes
		Stabiliser housing Mk6 Bandy			
Notes		Filename		S6-33151.dwg	
Drawn		ajdsuc	18/12/2013	Mass	kg
					A2