



## ***TECHNICAL BULLETIN***

### ***ADDITIONAL WELDING ON FOOTRING OF CYLINDER***

We have had two (2) cylinders returned to the Factory due to stress failure of welds on the footing.

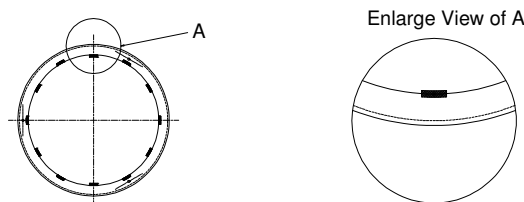
Following an investigation, it was established that the retaining cylinder straps were found to be loose which allowed the cylinder to vibrate and move within the cylinder bracket.

In both cases the cylinders came from installations on bulldozers.

### **CORRECTIVE ACTION**

1. Care must be taken when fitting the cylinder support bracket that the retaining straps are horizontal and tight.
2. At the scheduled periodic inspection it is essential that the “Check all foam agent storage cylinder brackets and vibration eliminator mounts are secure and tight”.  
(Item 1.1B Periodic Inspection)
3. Properly tightened retaining straps are the correct and approved method to Ensure such damage does not occur.

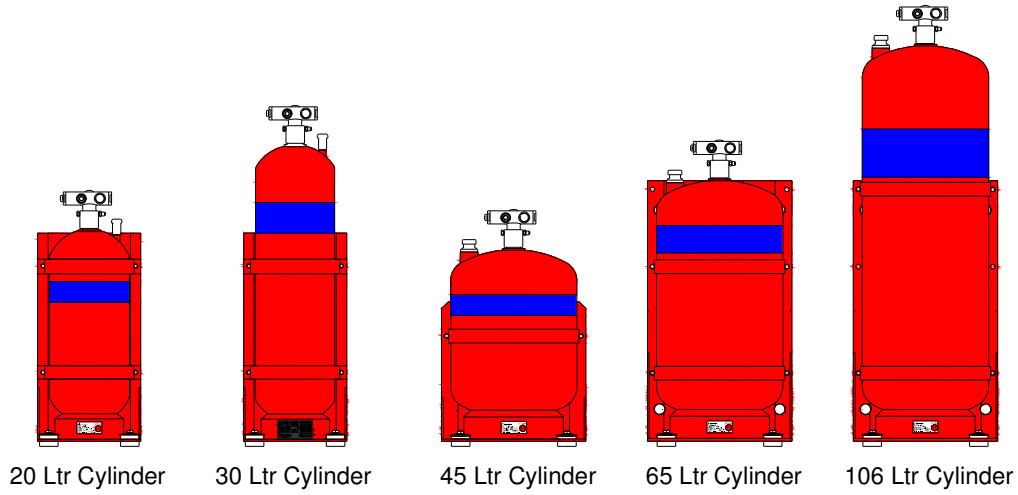
ETI in its response, starting in June 2012, has increased the welds in this area from six to twelve to further strengthen the cylinder base.



- Each base ring must be welded with a min. of 12 welds.
- Welding place is six on the internal base ring, and six on the outside of the ring Staggered

### **Welding Detail**

Welds placement has been increased from six on the internal base ring and six on the outside of the base ring staggered evenly, this action commenced June 15, 2012.



Cylinder and Bracket Assembly

Yours Sincerely



Bambang Isti Yudono  
Technical Manager & Chief Engineer