

TRUCK, MEDIUM, MC2, UNIMOG - ALL TYPES

FITTING OF 12.5 TON SAFETY CHAIN MOUNTS

MODIFICATION INSTRUCTION

This instruction is authorised for use by command of the Chief of Army. It provides direction, mandatory controls and procedures for the operation, maintenance and support of equipment. Personnel are to carry out any action required by this instruction in accordance with EMEI General A 001.

INTRODUCTION

1. This instruction details the removal of the trailer safety chain mounts fitted under the authority of EMEI Vehicle G 617-27 and the installation of safety chain mounts rated at 12.5 ton.
2. **Associated Publications.** Reference may be necessary to the latest issue of the following documents:
 - a. [EMEI Vehicle G 617-27](#);
 - b. Technical Regulation of Army Materiel Manual (TRAMM) (available from DTR-A website <http://intranet.defence.gov.au/armyweb/Sites/DTRA>); and
 - c. Defence Supply Chain Manual (DSCM), Volume 4, Section 3 – Supply Management Processes, Stores Accounting General (DSCM website <http://dknl009.car.defence.gov.au/dscm/index.htm>); and
3. **Authority.** ECO MHB 039/06 is the authority to carry out this modification.

GENERAL

4. **Modification Application.** This modification is to be applied to all stocks on issue or in service storage.
5. **Items Affected.** This modification alters the rear cross member of the vehicle.
6. **Priority – Group 2.** All applicable equipment is to be modified:
 - a. when next in a workshop for Light, Medium or Heavy Grade Repair; or
 - b. prior to issue from depot or pool stock.

NOTE

Where modification would delay priority issues of depot or pool stock, equipment may be issued unmodified, providing the equipment record book is endorsed appropriately.

7. **Action Required.** Actions detailed in this instruction are to be performed technical maintenance organisations authorised to carry out Light, Medium or Heavy Grade Repairs, utilising Technicians ECN 229 or civilian equivalent.

NOTE

On receipt of this instruction, enter all relevant information other than date completed, in the modifications section of the GM 120 – Record Book for Service Equipment.

8. **Estimated Workhours.** For initial planning purposes only, it is estimated that this modification will take 2 workhours to perform.
9. **Stores Required.** The stores required are listed in Table 1. All stores are to be demanded through normal supply channels.
10. **Items to be Removed.** The items to be removed are listed in Table 2. All stores removed are to be processed in accordance with DSCM, Volume 4, Section 3 – Supply Management Processes, Stores Accounting General.

DETAIL

11. Fitting of Safety Chain Mounts to Vehicles not modified in accordance with EMEI Vehicle G 617-27. The procedure is as follows:

- a. Position the left hand mount as shown in Figures 1 and 2. Figure 3 shows the completed modification.

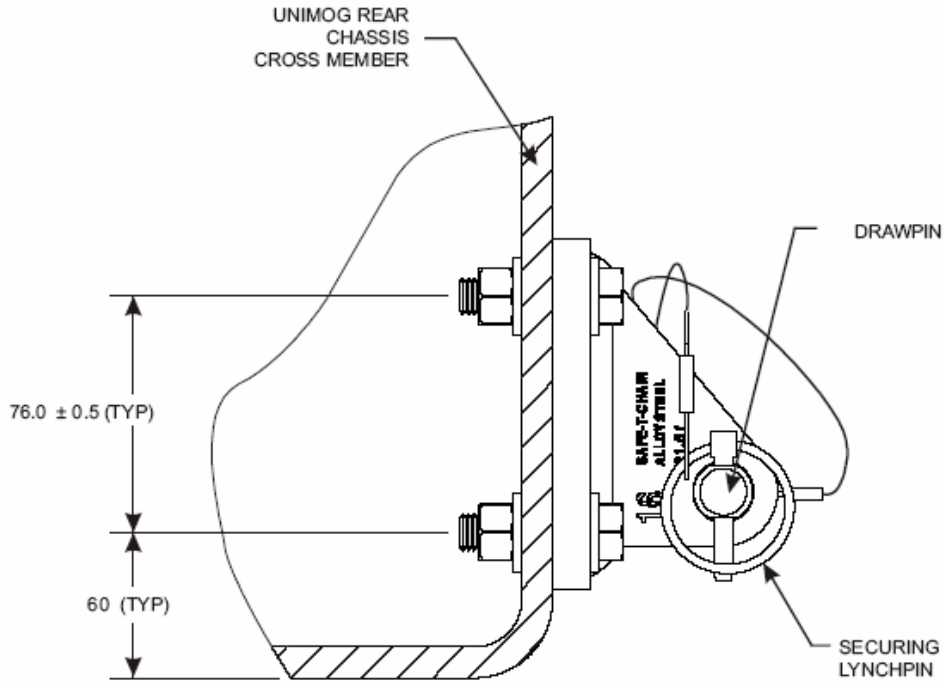


Figure 1 Vertical Position Of The Mounts

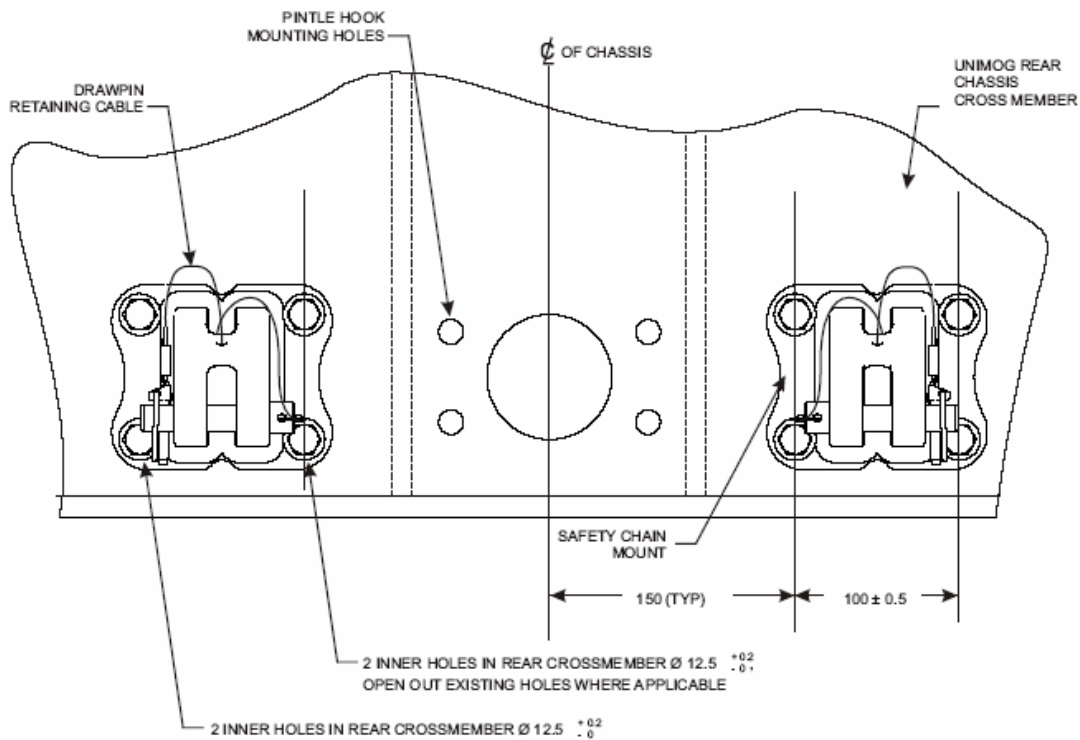


Figure 2 Horizontal Position of the Mounts

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Figure 3 Completed Modification

- b. Mark the position of the right-hand lower mounting hole.
- c. Remove the mount.
- d. Centre punch the marked position.
- e. Drill a 4 mm pilot hole.
- f. Drill out the pilot hole to 12 mm.
- g. Loosely secure the mount with a bolt and plain nut supplied with the kit.

NOTE

There is a plain nut supplied with the kit to be used to position the mount during the marking of the mounting hole locations. The Nyloc nuts are not to be used until the mounts are secured in position.

- h. Nip up the bolt.
- i. Square the mount using a level.
- j. Mark the position of the three remaining mounting holes.
- k. Remove the mount.
- l. Centre punch the marked positions.
- m. Drill three 4 mm pilot holes.
- n. Drill out the pilot holes to 12 mm.
- o. Loosely secure the mount with four Nyloc nuts, bolts, flat and spring washers supplied with the kit.

NOTE

Apply a light coat of Loctite 242 to the bolts before fitting the nuts.

- p. Nip up the bolts.
- q. Square the mount using a level.
- r. Torque the bolts to 110 N.m.
- s. Repeat the procedure for the right-hand mount.

12. Fitting of Safety Chain Mounts to Vehicles modified in accordance with EMEI Vehicle G617-7.

The procedure is as follows:

- a. Remove and discard the two safety chain mounts fitted to the vehicle.
- b. Drill out one of the two lower existing holes to 12 mm.
- c. Position the left-hand mount with the lower mounting hole over the 12 mm hole.
- d. Loosely secure the mount with a bolt and plain nut supplied with the kit.
- e. Nip up the bolt.
- f. Square the mount using a spirit level.
- g. Drill out the top right hole (the one used for the initial safety chain modification) to 12 mm.

NOTE

The existing hole can be elongated if it does not line up exactly with the mounting hole when the mount is level.

- h. Mark the position of the two remaining mounting holes.
- i. Remove the bracket.
- j. Center punch the two marked positions.
- k. Drill two 4 mm pilot holes.
- l. Drill out the pilot holes to 12 mm.
- m. Position the mount over the holes.
- n. Loosely secure the mount with four bolts, Nyloc nuts, flat and spring washers supplied with the kit.

NOTE

Apply a light coat of Loctite 242 to the bolts before fitting the nuts.

- o. Nip up the bolts.
- p. Square the mount using a spirit level.
- q. Torque the bolts to 110 N.m.
- r. Repeat the procedure for the right-hand mount.

13. Recording Action. On completion of the modification, the following action is to be taken in accordance with TRAMM, Volume 3, Section 2, Chapter 2, Annex D:

- a. Deface the number 42 on the vehicle's modification record plate.
- b. Complete the modification details in the GM 120 – Record Book for Service Equipment.
- c. Forward the modification completion details using form GM 119 – Advice of Change in Build State (TRAMM, Volume 3, Section 2, Chapter 3, Annex C) to:

ADFLM Med/Hvy B Veh,
LV SPO, DMO
Victoria Barracks, St Kilda Rd
SOUTHBANK VIC 3001

Table 1 Stores Required

Item	NSN	Mfr Part No	Designation or Description	Unit of Issue	Qty per Kit	Qty per Equip
1		YA 4353100195	Trailer Safety Chain Anchor Kit	EA		1
1.1			Pin, Anchor	EA	2	
1.2			Lynch Pin and Wire Assy	EA	2	
1.3			Bolt, Hex Hd, M12 x 40 Ig, Property Class 10.9 to AS 1110.1, Steel, Zn Plt	EA	8	
1.4			Washer, Flat, M12, Hard, Steel, Zn Plt	EA	16	
1.5			Nut, Hex Hd, Nyloc, Type P - M12 x 1.5 – 6 H, Property Class 10, Steel, Zn Plt	EA	8	
1.6			Nut, Hex Hd, Type P - M12 x 1.5 – 6 H, Property Class 10, Steel, Zn Plt	EA	1	
2			Loctite 242		A/R	

Table 2 Items to be Removed (if fitted)

Item	NSN	Mfr Part No	Designation or Description	Qty per Equip
1	2590-66-147-5907		Trailer Safety Chain Anchor Kit	1

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END

Distribution List: **VEH G 30.0 – Code 2** (Maint Level)
(Sponsor: LV SPO, Medium/Heavy B Vehicles)
(Authority: ECO MHB 039/06)