

TRUCK, HEAVY, MC3 (MACK) ALL TYPES  
FUEL TANK SUPPORT BRACKETS

MODIFICATION INSTRUCTION

Issue of this instruction is authorized by CONMEA

Introduction

1. This instruction details the method of repairing and modifying the fuel tank support brackets to prevent further cracking.

Note:

1. NSN and Designation used in this instruction were current at the date of issue. If twelve months or more have expired since issue, the NSN should be checked for supersession.

General

2. Estimated Manhours to Perform. 3.0.
3. Priority. Group 2.
  - a. All equipments on issue to units are to be modified when next in workshop for major servicing/repairs.
  - b. All equipments held by supply depots should normally be modified before issue. However, where this would delay priority issue, equipments may be released unmodified provided their record books are endorsed with details of the outstanding modification.
4. Modification to be Applied to. All subject trucks.
5. Items Affected. Fuel tank support brackets.
6. Action Required. By RAEME units authorized to carry out unit, field and base repairs in accordance with WKSP A 850.

TABLE 1 - STORES REQUIRED (To be demanded through normal supply channels)

Item	NSN	Designation	Qty per Equip
1.	2510-66-083-5616	METAL BAR, FLAT 25 BY 6 MM	As required
2.	3439-66-016-2219	ELECTRODE E4113 3.2	As required
3.	3439-66-016-2220	ELECTRODE E4113 4.0	As required

7. Stores Removed. Nil.
8. Detail. To carry out the modification, proceed as follows:
  - a. Drain the fuel from the fuel tank and remove the fuel tank and support brackets.
  - b. Gouge and reweld any cracked welds ensuring that the weld continues 75 mm down the supporting rib as shown in Fig 1.
  - c. Cut the steel bar item 1 Table 1 to the dimensions shown in Fig 1.

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- d. Prepare the areas to be welded and weld using the electrodes, item 2 and 3 Table 1, as shown in Fig 1.
- e. To enable the modified bracket to be fitted to the cargo and cargo crane variants, the body mounting angle must be relieved by grinding four slots 6 mm wide and 15 mm deep where the additional strengthening ribs are located.
- f. Paint the reworked areas in accordance with WKSP B 700.
- g. Refit the fuel tank support brackets and fuel tank to the vehicle.

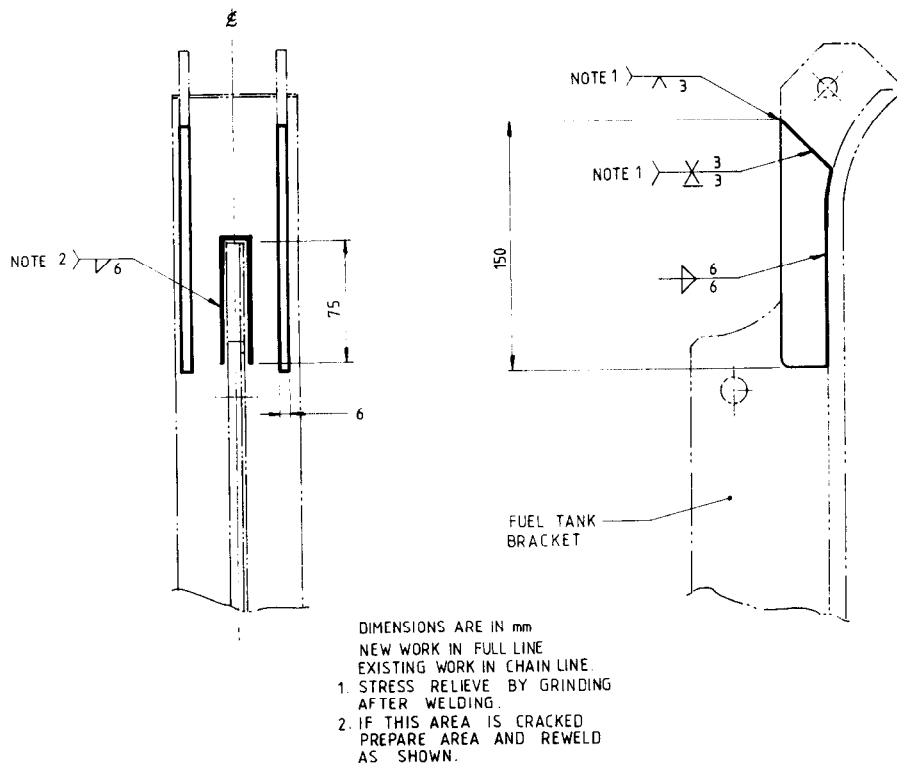


FIG 1 - REPAIR DETAIL

Modification Record Plate

9. The modification is to be recorded as follows:
  - a. Truck Cargo/Truck Cargo Winch heavy MC3 (Mack), deface the numeral 14.
  - b. Truck Cargo with Crane Heavy MC3 (Mack), deface the numeral 15.
  - c. Truck Ammunition/Gun Tractor Heavy MC3 (Mack), deface the numeral 14.
  - d. Truck Dump/Truck Dump Winch Heavy MC3 (Mack), deface the numeral 11.
  - e. Truck Tank Fuel/Truck Tank Water Heavy MC3 (Mack), deface the numeral 10.
  - f. Truck Bitumen Distributor Heavy MC4 (Mack), deface the numeral 6.
  - g. Truck Transit Mixer Heavy MC3 (Mack), deface the numeral 7.
  - h. Truck Wrecker Heavy MC3 (Mack), deface the numeral 7.

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