

TO:
ATTN:
SUBJECT: De-Air Port Retrofit and Air Removal Procedure

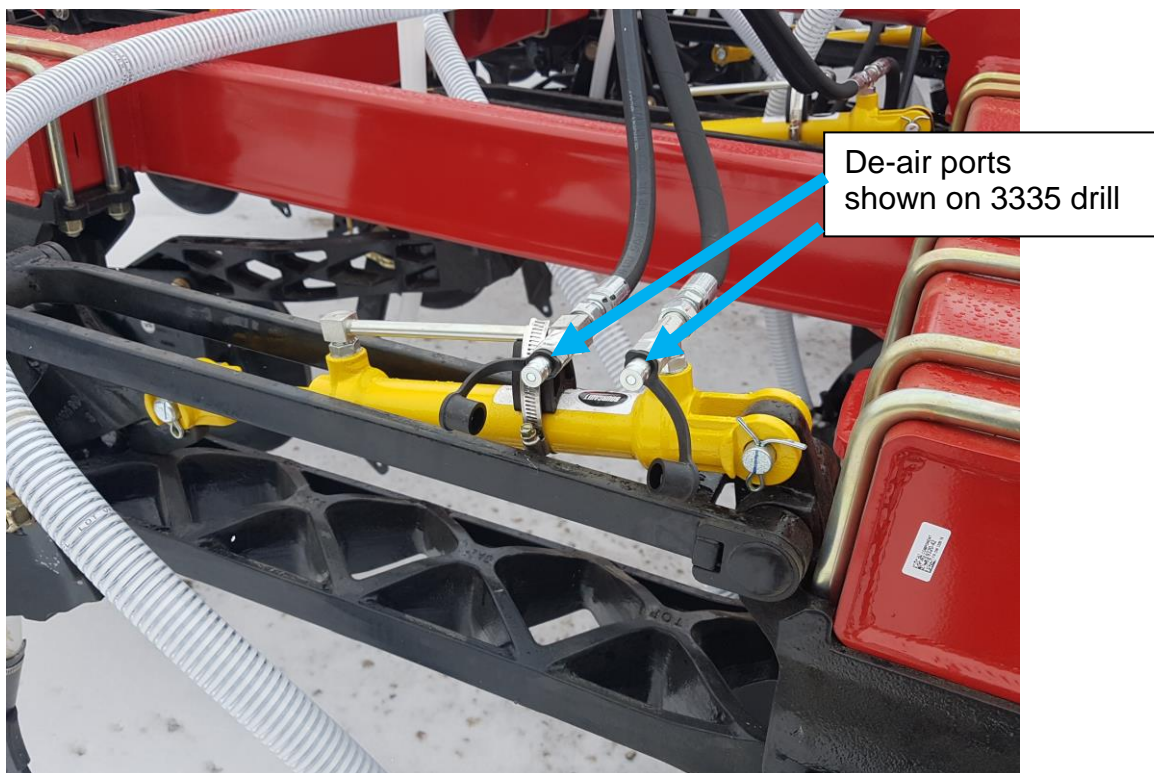
Information Bulletin: Effective Serial Number Range: 3310, 3320, 3420, 3710 and 3720 built prior to Sept 2019

BACKGROUND:

In the fall of 2019 a system to remove air from the opener and MRB circuits was added to 3320 and 3720 drills. During the initial factory assembly of these machines this air removal system is used to remove air from the circuit. Due to the nature of these circuits the air is not easily removed during normal operation.

When these circuits are opened up to replace/repair hydraulic hoses or cylinders air will be introduced and without the de-air ports and use of the bypass hose air removal will be difficult/messy. Circuits with excess amounts of trapped air will encounter performance issues. Circuits with excess air typically encounter rapid opener drop where the openers will not remain in the raised position while transporting the drill.

Newer drills equipped with the de-air ports from the factory and older drills retrofitted to have them added will benefit from removing excess air from the opener and MRB circuits – especially after removing or replacing hydraulic hoses or cylinders.





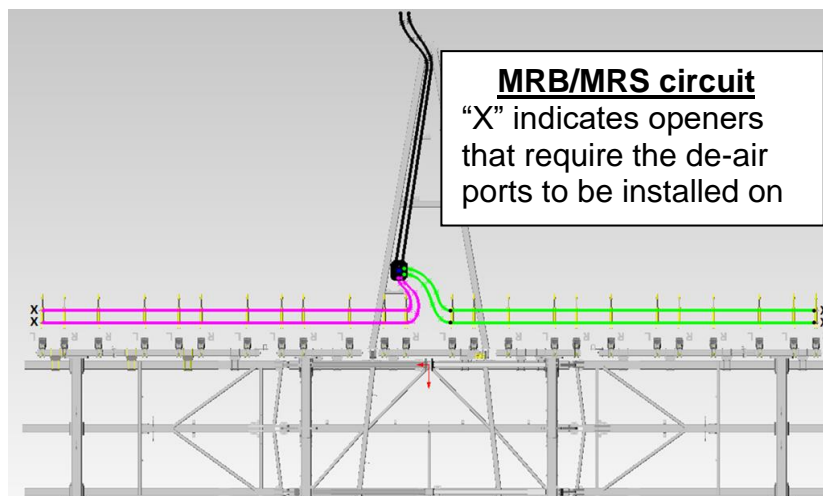
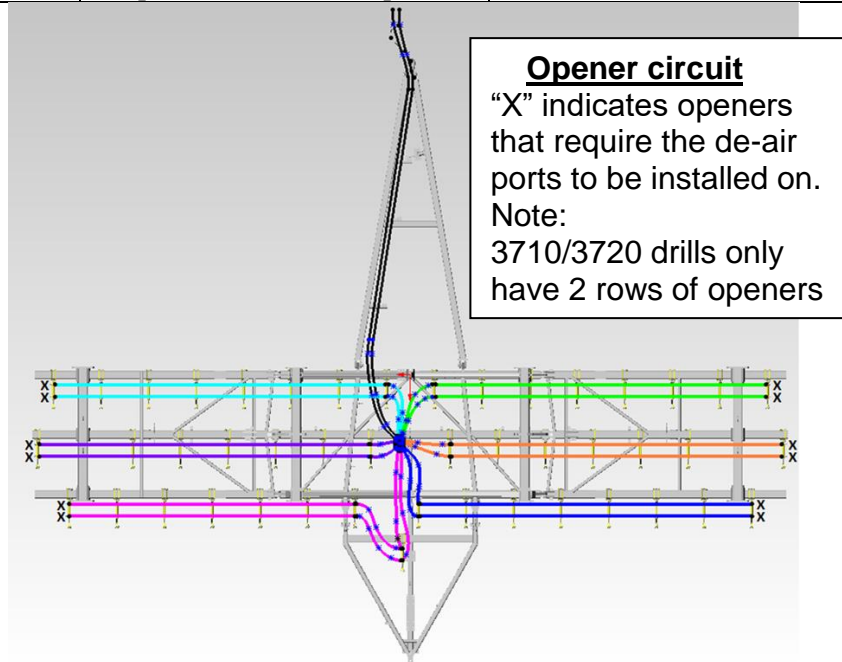
CORRECTIVE ACTION:

- Refer to the instructions in this TSB for installing this de-air system and the air removal procedure.

Part Number	Description	Dealer Cost	List Price
3345-29	TEE - 9/16MORB/MJICX9/16MJIC	\$	\$
3346-96	DE-AIR PORT - 9/16 FJIC	\$	\$
6650-18	DE-AIR HOSE	\$	\$

Call your local Bourgault dealer for pricing and availability

Part Number	Description	Qty. required for opener circuit	Qty. required for MRB/MRS circuit (if-equipped)
3345-29	Tee	3310/3320/3420 – Qty 12	4
3346-96	De-air Ports	3310/3320/3420 – Qty 12	4
3345-29	Tee	3710/3720 – Qty 8	4
3346-96	De-air Ports	3710/3720 – Qty 8	4
6650-18	By-Pass Hose	1 per machine or as required	----



Instructions

1. In each required location remove the existing elbows/unions and add the tees (3345-29) – make sure to orient the tees so the previous hose routings can be achieved – test ports will either face upwards or towards the outside of the drill.
2. Re-install the hoses and install test port fittings (3346-96) onto the tees



3. Once installation in all required locations is complete you can begin the air removal procedure.
4. It is recommended to isolate each circuit by closing all other isolation valves (located near the center of the machine) and only opening the circuit you are going to de-air.



5. Install the de-air hose onto the cylinder test ports



6. De-airing needs to be done with the openers/MRB/MRS in the lowered position
7. Engage the depth circuit and allow the oil to circulate through the bypass hose for 30 seconds to 1 minute
8. Remove de-air hose
9. Repeat procedure for the remaining circuits – starting at step 4.
10. Once all circuits have been de-aired open all the isolation valves and raise /lower the openers multiple times to ensure proper operation.