



CONFIDENTIAL PROPRIETARY INFORMATION

Reproductions of this data or the manufacturing of products from this data by anyone other than Spokane Stainless Technologies®, Inc. of Spokane Washington is strictly prohibited without written consent. The Spokane Stainless Technologies logo and HeliFueler® are registered trademarks of Spokane Stainless Technologies, Inc.

TECHNICAL MANUAL

HeliFueler 600 Gallon Defueler / Fueler Cart

Spokane Stainless Technologies Inc.

This document discloses subject matter in which Spokane Stainless Technologies, Inc. has Proprietary rights and such subject matter shall not, without the written permission of Spokane Stainless Technologies, Inc. be either (A) used, released or disclosed in whole or in part outside the government, (B) used in whole or in part by the government, for manufacture, or (C) used by a party other than the government, except for (1) emergency repair or overhaul work only, by or for the government, where the item or process concerned is not otherwise reasonably available to enable time and performance of the work, provided that release of disclosure hereof outside the government shall be made subject to a prohibition against further use, release of disclosure, or (2) release to a foreign government, or for emergency repair or overhaul work by or for such government under the conditions of (1) above. This legend shall be marked on any reproduction hereof in whole or in part.

© COPYRIGHT 2020 By SPOKANE STAINLESS TECHNOLOGIES INC.

MNUL-005

REVISION D

JUNE 2020

Section

1.0	Introduction.....	Page 3
1.1	Component Identification.....	Page 4
1.2	Specifications.....	Page 5
1.3	Hose Fitting Hookups and Usage for Select Airframes.....	Page 6
1.4	Daily Inspection Checklist.....	Page 7
1.5	Preventative Maintenance Chart.....	Page 7
2.0	Safety Guidelines.....	Page 8
2.1	General Safety Instructions.....	Page 8
2.2	Protective Clothing.....	Page 8
2.3	Static Bonding and Grounding and Other Fire Hazard Precautions.....	Page 8
2.4	Lockout / Tagout.....	Page 8
2.5	Area of Use.....	Page 8
3.0	Operation Instructions.....	Page 9
3.1	Shipment Preparation	Page 9
3.2	Controls and Indicators.....	Page 9
3.3	Defueling the Aircraft.....	Page 10
3.4	Fueling the Aircraft.....	Page 11
3.5	Taking Samples Using the Sample Ports.....	Page 12
3.6	Fuel Moisture Removal Low Point Drain/ Fuel.....	Page 12
	Filter Housings	

Section

4.0	Maintenance and Assembly.....	Page 13
4.1	Repair and Replace Instructions.....	Page 13
4.2	General Tank Instructions.....	Page 13
4.3	Manway Assembly and Maintenance.....	Page 14
4.4	Front Undercarriage Assembly.....	Page 15
4.5	Front Wheel Assembly Removal.....	Page 15
4.6	Front Hub Assembly.....	Page 15
4.7	Tow Latch Assembly.....	Page 16
4.8	Spindle Assembly.....	Page 17
4.9	Steering Arm Assembly.....	Page 17
4.10	Tie Rod Assembly.....	Page 17
4.11	Front Undercarriage Assembly Removal.....	Page 18
4.12	Rear Undercarriage Assembly.....	Page 18
4.13	Rear Wheel Assembly Removal.....	Page 18
4.14	Rear Hub/Brake Drum Assembly.....	Page 19
4.15	Mechanical Brake Assembly.....	Page 19
4.16	Parking Brake Assembly and Adjustment.....	Page 20
4.17	Brake Handle and Cable Assembly.....	Page 20
4.18	Rear Undercarriage Assembly Removal.....	Page 21
4.19	Wheel Assembly.....	Page 21
4.20	Removing the Fuel Pump.....	Page 22
4.21	Removing the Fuel Meter.....	Page 22
4.22	Removing the Filter Housings.....	Page 22
4.23	Removing the 4-Way Selection Valve.....	Page 22
4.24	Removing the Hose Reel.....	Page 22
4.25	Pump Strainer Removal and cleaning.....	Page 23
4.26	Changing Fuel Filter Elements.....	Page 24
4.27	Changing Operator Console Indicator Lights.....	Page 24
4.28	Troubleshooting the DFC.....	Page 25
5.0	Parts Breakdown.....	Page 26

Drawing No.

1.0	Overview, Component Identification.....	Page 27
2.0	Overview, Component Identification (Tank).....	Page 28
3.0	Pump Components.....	Page 29
4.0	Manway Assembly.....	Page 30
5.0	Front Undercarriage.....	Page 31
6.0	Rear Undercarriage and Axle.....	Page 32
7.0	Front Hub Assembly.....	Page 33
8.0	Rear Hub & Drum Assembly.....	Page 34
9.0	Wheel & Tire Assembly.....	Page 35

SECTION 1.0

INTRODUCTION



IMPORTANT

YOU MUST READ THIS MANUAL IN ITS ENTIRETY BEFORE OPERATING, SHIPPING OR PERFORMING MAINTENANCE PROCEDURES. FLAMMABLE AND COMBUSTIBLE VAPORS CAN CAUSE FIRE, AND/OR EXPLOSION AND CAN LEAD TO SERIOUS INJURY OR DEATH.

The instructions in this manual cover the operation and maintenance of the HeliFueller Defueler/ Fueller cart manufactured by Spokane Stainless Technologies, Inc. of Spokane Valley, Washington.

Additional features of the HeliFueller include a spill containment kit, and cabinet lighting, which makes it easier and safer to fuel up at night.

Refer to the specifications chart (Section 1.2) for more information regarding dimensions, fuel capacity and other information on the 600-gallon DFC. Refer to Section 1.4 for the Daily Inspection Checklist and Section 1.5 for The Preventive Maintenance Chart

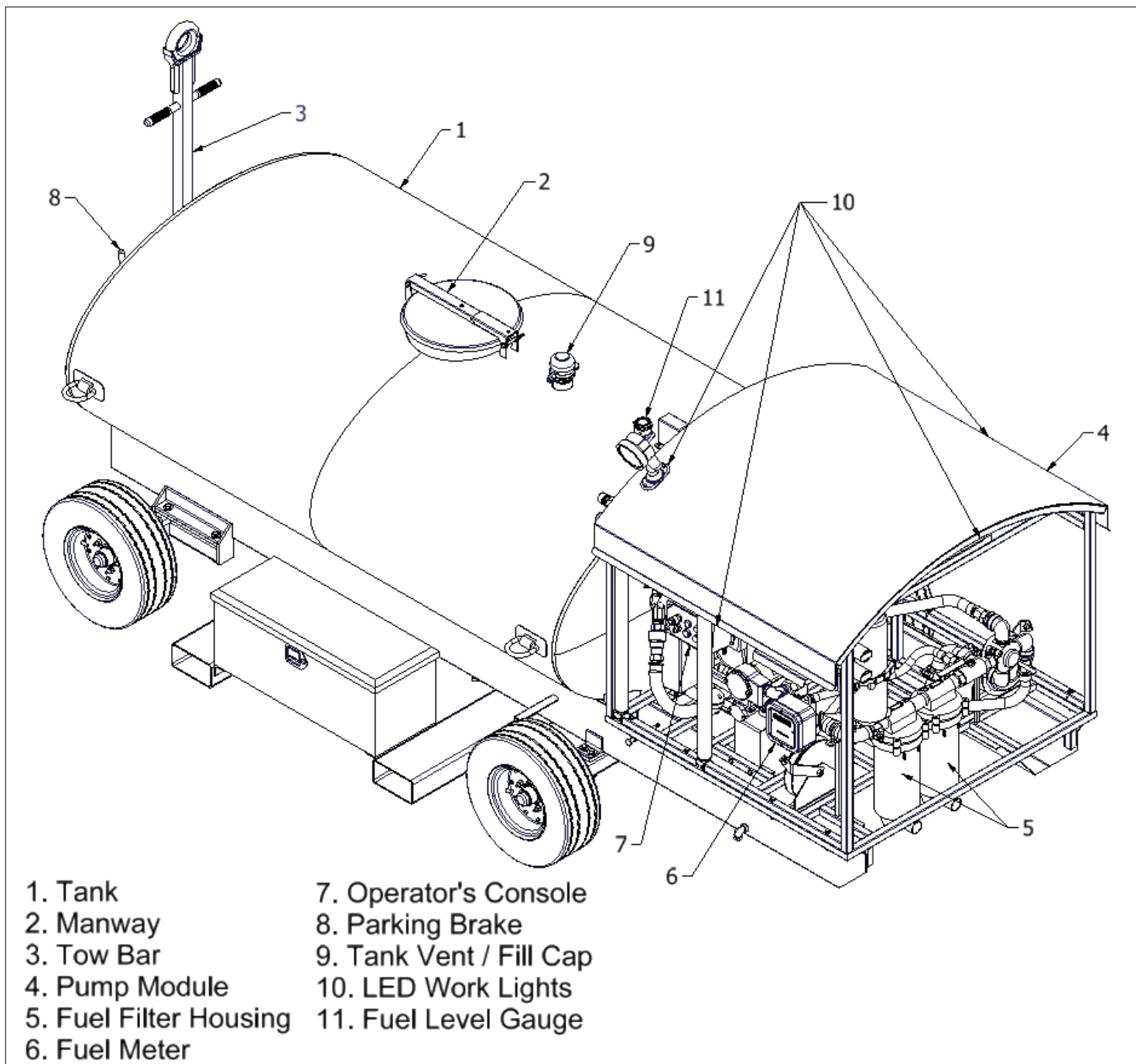
DESCRIPTION

Throughout this manual the unit will be referred to as the DFC. The HeliFueller DFC is a 600-gallon defueler / fueller cart designed to provide a portable, self-contained defueling/fueling system for refueling helicopters. The DFC is easy to use and maintain.

The DFC HeliFueller consists of an inner tank assembly and an outer tank, otherwise known as tight wrap construction. This easy to use fueller /defueler consists of a pump, fuel meter, fuel filter and a plumbing system that allows for fuel to recirculate through the system, as well as go in and out of the tank for either defueling or fueling purposes of helicopters.

When fuel is extracted, it is filtered through the plumbing system and placed back into the tank with a 50-foot fuel hose. There is a rigid and a soft extraction wand so that the user can fuel and defuel different size tanks.

Fueling and defueling is made simple with fittings that are designed for specific fueling and defueling purposes for CH-47 Chinook, AH-64 Apache and UH-60 Blackhawk helicopters. Please see section 1.3 for the hose fitting hookups for select airframes.



Section 1.1

Figure 1-1 Component Identification

1.2 Specifications for the HeliFueler 600 Gallon

Tank Volume:

Nominal Capacity 600-gallons
Max Capacity 660-gallons

Equipment Dimensions:

Length (Tow bar down) 222-inches
(Tow bar up) 162-inches
Width (Tire to tire) 77-inches
Height (Tow bar down) 70-inches
(Tow bar up) 75-inches
Weight (Empty) 2,780-pounds
(Full, at nominal capacity with fuel) 6,980-pounds
Ground Clearance (At tow bar) 6-inches
(At axle) 8-inches

Environmental Conditions:

Operating Temperature Range -25°F to 110°F
Storage Temperature Range -40°F to 150°F

Flow and Pressure:

Fueling Flow Rate (nominal) 11-GPM
Fueling Pressure <10-PSI
Fuel Extraction Flow Rate (nominal) 10-GPM
Fuel Extraction Suction (lift) 10-FEET

Electrical Characteristics:

Voltage 12VDC
On-board Batteries Dual Optima Blue tops
On-board Charging 120/230 VAC Input / 12VDC x 30-amp output
Cabinet Lighting... LED
Circuit Protection Yes, circuit breakers

Duty Cycle:

Pump (Fueling and Extraction) 30-minutes ON, 30-minutes OFF

Towing Characteristics:

Speed, Forward Direction 15-MPH
Speed, Backward Direction (hand push/pull only)
Turning Radius (Curb to curb) 372-inches

Wheels and Tires:

Tire Size 20.5 x 8.0-10
E Range Tire Pressure (Cold) (See Sidewall) 90-PSIG
Lug Nuts Torque 100 ft.-lbs.
Split Rim Nuts Torque 75 ft.-lbs.

Other Characteristics:

Double Wall Construction Yes
Tie-down Points Yes, x 4 D-rings
Fork-lift Ready Yes, 4 x 8 pockets

1.3 Hose Fitting Hookups and Usage for Select Airframes

Helicopter Type	Defuel Fittings	Fuel Fittings
UH-60 Blackhawk	25-5038 Custom Plug Fitting	Single Point (Whittaker F116) Whittaker Valve
AH-64 Apache	25-5039 Single Point (Whittaker F116)	Single Point (Whittaker F116) Whittaker Valve
CH-47 Chinook	25-5040 Threaded Swivel Connection	Single Point (Whittaker F116) Whittaker Valve



Part Number Reference

UH-60 Black Hawk Fitting Asm. - 25-5038

AH-64 Apache Whittaker Nozzle Asm. –AV.COM Part Number F116VX7D - 25-5039

CH-47 Chinook Threaded Swivel Asm. - 25-5040

Whittaker Valve - 04-1042

1.4

Daily Inspection Checklist

Part to be inspected	What to Look For				Check Off Once Inspected
Wheels	Are tires damaged?	Are there loose or missing lug nuts?			
Brakes	Inspect for proper function	Are brakes properly adjusted?			
Towbar	Are there cracks in welds?	Are there missing attachment pins?	Are there missing retaining clips?		
Tank	Are there leaks or any obvious damage?	Does Manway close properly?	Are there loose or missing components in the undercarriage mounting hardware?		
Fueling Nozzle	Are there any leaks?				
Ground Reel	Is cable end securely fastened to cable?				
Valves	Are valves functioning properly?				
Fuel Filter Housings	Are there any cracks?	Are there any leaks?			
Fuel Hose	Are there any cracks?	Are there any leaks?	Are there any rub spots?	Are fitting ends operational?	
Low-Point Drain	Is water drained from tank low-point sump?				

1.5

Preventative Maintenance Chart

Item	Interval	Action
Manway Seal	Monthly	Inspect for tears, cracks and compression damage. Refer to Section 4.3 for maintenance instructions.
Brakes	Quarterly	Check for proper adjustment and make any adjustments using sections 4.15, 4.16 and 4.17.
12 Volt batteries	6 Months	Check battery cell fluid level. If the batteries need to be serviced, remove the battery box before servicing the batteries.
Tank Weldment	Yearly	Inspect both inner and outer tank welds for cracks. Remove plug from outer tank test fitting and inspect for fuel evidence.
Wheel Bearings	Yearly	Inspect for damage and replace components when needed. Pack wheel bearings with grease. Use sections 4.8 and 4.17 For maintenance.

SECTION 2.0

SAFETY GUIDELINES

Within this manual are guidelines and safety recommendations for use of the DFC. It is the responsibility of the end user to completely read this manual and comply with all local, state and federal laws and **regulations applicable for defueling and fueling aircraft**. Spokane Industries Inc. is not responsible for industry specific information on safety management, employment safety, health standards, safety codes, etc. Contact your local safety manager or industrial safety representative. It is the responsibility of the end user to ensure persons operating this equipment:

- **Are trained, authorized and permitted to use the equipment.**
- **Have physical and the mental ability to operate this equipment safely.**
- **Are aware of the potential hazards associated with this equipment, i.e static electricity, electrical shock, fuel spills and pinch points.**

2.1 General Safety Instructions

This manual describes physical and chemical processes which may cause injury or death to personnel, or damage to equipment if not properly followed. This safety summary includes general safety precautions that must be understood and applied during operation and maintenance to ensure safety and protection of equipment.

2.2 Protective Clothing

When fuels are being handled, approved equipment such as gloves, eye protection, face shields, etc. shall be used.

2.3 Static Bonding and Grounding and Other Fire Hazard Precautions

Improper static bonding and grounding can lead to a fire, and as with any other equipment dealing with fuel, there is always a risk of fire if all safety precautions are not followed or the equipment is not used correctly. Make sure to read and understand all instructions before operating this equipment.

2.4 Lockout / Tagout

Personnel shall be aware of the hazards associated with unguarded machinery parts, capacitors, gaseous and wet pipe systems, spring loaded devices, etc. Lockout / Tagout the energy source prior to performing maintenance, adjustment or other procedures that would bypass safety guards, barriers, or otherwise expose personnel to hazardous energy sources. Any equipment, machine or process that could unexpectedly energize, start-up or release energy will be equipped with a means to lockout / tagout the energy sources.

2.5 Area of Use

This equipment has been designed to operate outdoors only. Flammable and/or combustible vapors in ignitable quantities could be produced under certain circumstances. Additionally, local protocols must be consulted to determine if fuel draining equipment can be used in the location being considered.

SECTION 3.0

OPERATION INSTRUCTIONS

3.1 Shipment Preparation

⚠ WARNING

Flammable and combustible vapors must be removed from tank before shipping to prevent a fire and/or explosion. If this step is not taken, serious injury or death could occur

Before transporting the DFC by truck or cargo aircraft, make sure to drain the tank of all liquid products by opening the drain valve. Remove all flammable and/or combustible vapors from the tank using an approved ventilation method. Secure any loose items and check to make sure the manway assembly is securely attached.

Loading the DFC for Truck Shipment

⚠ CAUTION

Inserting fork extensions into fork pockets should be the only means of lifting the DFC for shipment. Damage to the

equipment will occur if the equipment is lifted from any other location.

Forklift with fork extensions will be required to load the DFC on a truck. Set the parking brake. Approach the unit from the front only. Once the DFC is loaded on the truck, secure to the truck bed using attachment points on tank weldment.

Loading the DFC for Air Shipment

⚠ CAUTION

Do not back equipment by any means other than hand pushing/pulling, or it will cause damage to the equipment.

After placing the DFC in the aircraft, lock tow bar upright, make sure the parking brake is set and that the manway assembly and storage boxes are latched.

3.2

Controls and Indicators

Description	Functions
Battery Switch	Main power disconnect
E-Stop Switch	Emergency shut down switch
Fuel Filter petcocks (several)	Maintains the two fuel filters
Fuel Meter	Gauge that shows fuel level during defueling and fueling operations
Operator Console	Turns Defuel / Fuel pumps both ON and OFF
Parking Brake Handle	Sets Parking Brake
Liquid Level Gauge	Located on the top centerline of the tank, this shows how much fuel is in the tank.
Sample Port Valves	There are two of these. One is located on the left side of the fuel meter and the other valve is located on the right side of the recirc valve. These are used to take fuel samples from the tank.
LED Worklights	Located on top of the HeliFueler and underneath the top hood, these are used to light the working area.

3.3 Defueling the Aircraft

▲WARNING

Never operate the DFC in a closed area or in an area with little or no ventilation.

All fuels are flammable, do not allow sources of ignition within 50 feet of the DFC.

Make sure there is enough room in the tank to store the fuel being removed from the aircraft.

- a. Set brakes by moving the handle so it points upward.
 - b. Chock tires if chocks are available.
 - c. Attach static bonding/grounding cables by locating reel with clamp end, and pulling cable outward until desired length has been taken out.
 - d. Allow cable to retract until it stops. Attach at ramp to an approved bonding/grounding site.
 - e. Uncoil 50-foot Hose assembly from hose reel.
 - f. Attach the DEFUEL adapter.
 - g. Position the Selection Valve to the DEFUEL position."
 - h. Ensure that the recirc valve is properly positioned.
 - i. Turn on the Battery Switch. The "POWER ON" indicator lamp will light up.
 - j. Make sure E-stop switches are in the non-stopped condition by twisting them counterclockwise and allowing them to spring outward.
 - k. Start the fuel pump by pushing the "Pump ON" button.
 - l. Monitor fuel meter to remove desired quantity of fuel.
 - m. If too much fuel is received into the tank, the Fuel Limit switch will activate and cut power to the system. Defueling operation must cease. Pump will turn off and pump run light will not illuminate
 - n. Disconnect the suction side of the pump
 - o. Turn the valving to go into fueling mode.
 - p. Find an appropriate receptacle, and connect the HeliFueller into the receptacle.
 - q. On the side of the electrical box, turn the reset switch. This will allow you to bypass the level switch.
 - r. On the control panel, hold down the pump button for several seconds
 - s. The pump will activate again and defueling can continue.
 - t. Turn off re-set switch.
 - u. Turn off fuel pump by depressing the "PUMP OFF".
 - v. Retract the fuel hose from aircraft
 - w. Turn off main battery switch.
 - x. Recoil hose and store.
- Normal safety procedures must be followed during this process.
 - Filling of the tanks should be done through the fuel fill service port.
 - Filling personnel must check fuel gauge when conducting this operation.
 - Filling personnel must also have the man-way open for visual inspecting during this operation.

NOTE: Repeat steps I through L if defueling any other fuel cells on the aircraft

3.4 Fueling the Aircraft

⚠ WARNING

Never operate the DFC in an enclosed area. Proper ventilation must be maintained at all times. All fuels are flammable, do not allow sources of ignition within 50 feet of the DFC.

Do not attempt to charge batteries while using the DFC 12 Volt electric fuel pump, damage to charger will occur.

- a. Set brakes by moving Brake lever upright.
- b. Chock tires if chocks are available.
- c. Locate reel with clamp end, and pull cable outward until desired length has been taken out. Allow cable to retract until it stops. Attach at ramp to an approved bonding /grounding location.
- d. Position the selection valve to the FUEL Position.
- e. Uncoil and fully extend hose.
- f. Remove Nozzle from stowed position and attach to hose end.
- g. Start the fuel pump by depressing the "PUMP ON" button.
- h. On electrical box turn main power switch ON by turning clockwise
- i. Ensure battery charge indicator indicates enough charge for operation.
- j. Open aircraft fuel tank and insert nozzle.
- k. Fill tank to desired capacity.
- l. Remove nozzle, close fuel tank and turn off pump.
- m. Turn main power switch OFF at electrical box.
- n. Remove nozzle and stow in nozzle holder.
- o. Retract fuel hose by pulling on retracted hose and allow the hose reel to start retrieving hose, control the rate of retraction by providing a small amount of resistance against the hose reel.

⚠ CAUTION

Improper grounding may result in an ignition source.

NOTE: Periodically monitor differential pressure gauges during fueling operations. This allows real time reading of filter contamination level. Red scale begins at 15 PSI differential pressure.

3.5 Taking Samples Using the Sample Ports

There are two ports used solely for taking for taking fuel samples. The sample port located on the right side of the fuel meter and the sample port located on the left side of the recirc valve.

- a. Make sure parking brake is set
- b. Attach bonding/grounding cables
- c. To take fuel before filtering, unscrew the cap to the sample port located on the right side of the fuel meter (1).
- d. After filtering fuel samples can be taken by unscrewing cap to the fuel sample port located on the left side of the recirc valve.

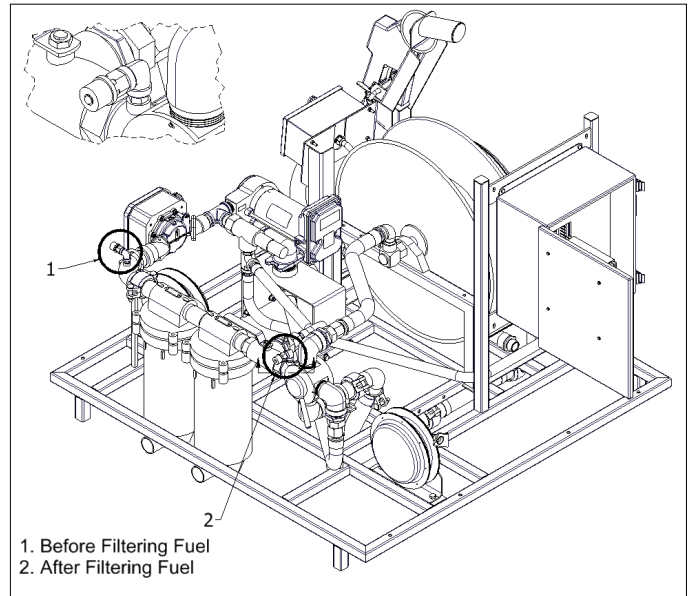


Figure 3-1 Sample Ports

3.6 Fuel Moisture Removal Low Point Drain/ Fuel Filter Housings.

The low point drain is located at the rear of the tank assembly.

- a. Make sure that the parking brake is set.
- b. Attach bonding/grounding reels.
- c. Use the fuel pump to empty tank contents into a safe container.
- d. Open low point sump valve and allow remainder of fuel to drain.
- e. Open petcock drain on filter to drain fuel from filter housing.
- f. Remove pipe plugs to drain fuel from plumbing system.

SECTION 4.0

MAINTENANCE, ASSEMBLY AND REPAIR

The DFC should always be inspected prior to use to make sure it is in working order.

4.1 Repair and Replace Instructions

Remember to set the parking brake while performing maintenance procedures. Approved jack stands and wheel chocks must also be used. Serious injury or death may occur from rolling or falling equipment.

The following procedures are used for the disassembly and reassembly for equipment components.

4.2 General Tank Instructions

⚠WARNING

Make sure that the tank is free of fuel and flammable and/or combustible vapors before performing any maintenance operation involving the tank. Serious injury or death could occur.

This procedure covers all components attached to the tank by means of threaded pipe connections and describes how to properly apply pipe joint sealing compounds. Pipe joint sealing compounds should be approved for fuel service.

- a. Remove parts that need to be repaired or replaced.
- b. Remove old pipe sealing compound from component (s) by wire brush or approved solvent. If solvent is used, allow parts to dry before moving on to step c.
- c. Inspect threads, and replace any damaged parts.
- d. Apply an even coat of pipe joint sealing compound across and all around the first four threads. The coat thickness should fill the thread “valleys”, and no more.
- e. Tighten until hand-tight. Do not cross thread components.
- f. Tighten parts until the connection does not have leaks.

4.3 Manway Assembly and Maintenance

The manway assembly is located on the top of the tank. The manway assembly has one adjustment point. Use Figure 4-1 for the following maintenance steps.

Manway Disassembly/Reassembly

- a. Open handle (2).
- b. Open Manway Assembly.
- c. Remove nut (7).
- d. Remove gasket retainer (5), gasket (4), and lid (3).
- e. Remove bolt (6) and nut (10) to remove cross-arm (1).
- f. Repair / replace components
- g. Reassemble in reverse order, leaving nut (7) only partially threaded onto cross arm (1).

Manway Adjustment

- a. Open handle (2).
- b. Open Manway Assembly.
- c. Rotate nut (11) to adjust lid position. Turn clockwise to move lid closer to the tank. Turn counter clockwise to move the lid away from the tank.
- d. Tighten nut (7) until snug.

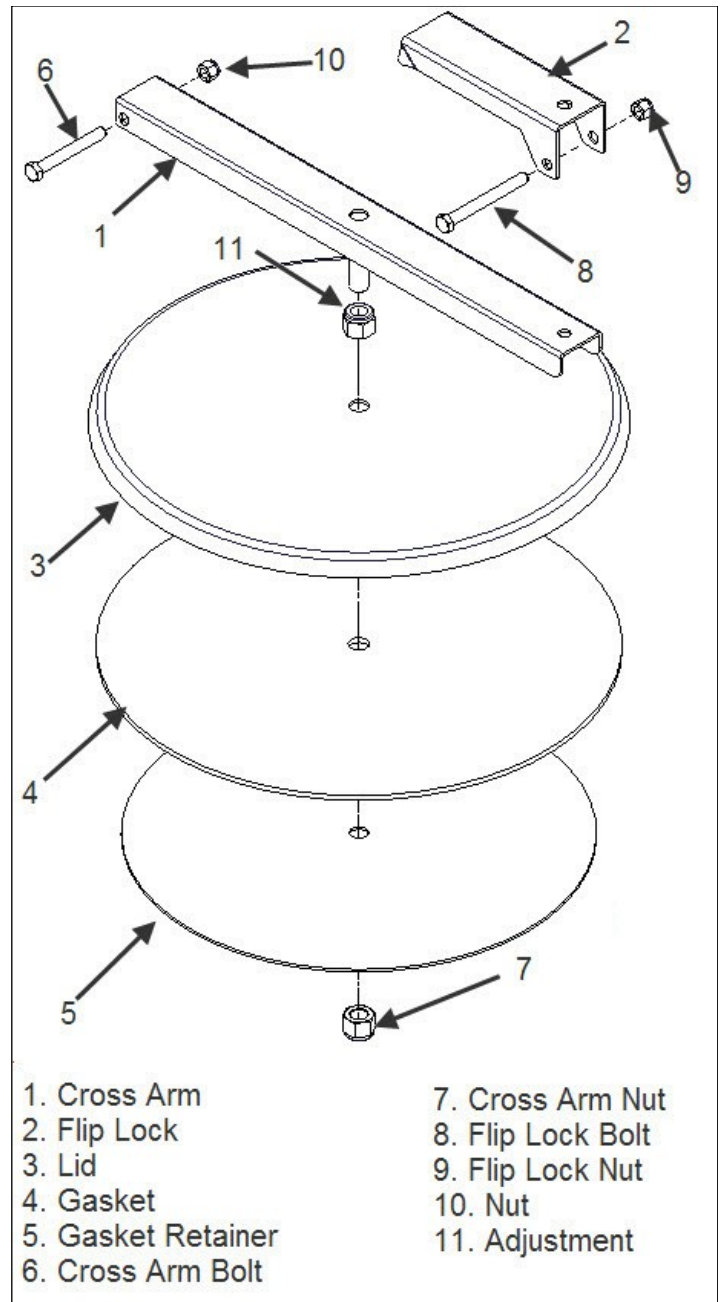


Figure 4-1 Manway Assembly

4.4 Front Undercarriage Assembly

The Front Undercarriage assembly consists of a wheel assembly, a hub assembly a spindle assembly a tow latch assembly, a steering arm assembly and an adjustable tie rod assembly.

4.5 Front Wheel Assembly Removal

To remove the wheel assembly, the equipment must have the front end raised and placed on approved jack stands.

- Loosen lug nuts on wheel assembly requiring maintenance one turn while equipment is still on the ground.
- Raise equipment with suitable maintenance jack (see Figure 4-2, arrow A for jack placement) high enough to remove wheel assembly.
- Place approved jack stands under front axle (see Figure 4-2, arrow B for stand placement).
- Remove lug nuts of wheel assembly needing maintenance, and remove.

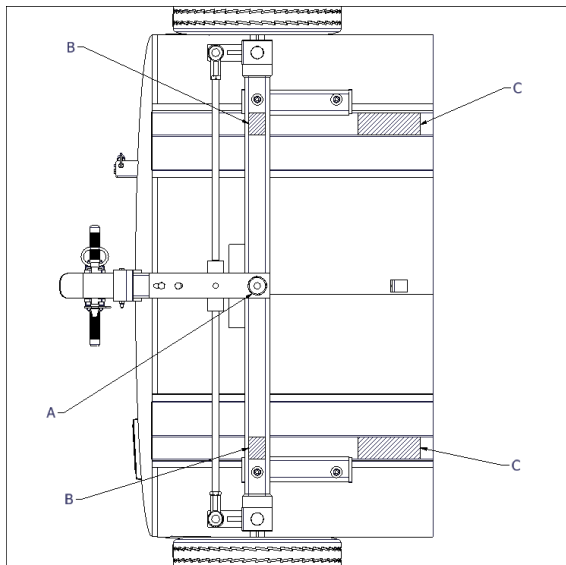


Figure 4-2 Lift Points

4.6 Front Hub Assembly

To remove the front hub assembly, follow these maintenance steps:

- Remove dust cap (1) by lightly taping with a rubber hammer.
- Remove cotter pin (2), castle nut (3), and washer (4).
- Grasp front hub (7) and pull outward firmly. Ensure that bearing (5) doesn't fall from hub and strike the ground.
- Remove bearing (5), seal (10), and bearing (9) from the front hub (7). Using a suitable H-frame press, remove bearing races (6) and (8).
- Replace components and grease bearings before reassembly.
- When reassembling, Castle nut (3) should be tightened until the hub assembly rotates past free.

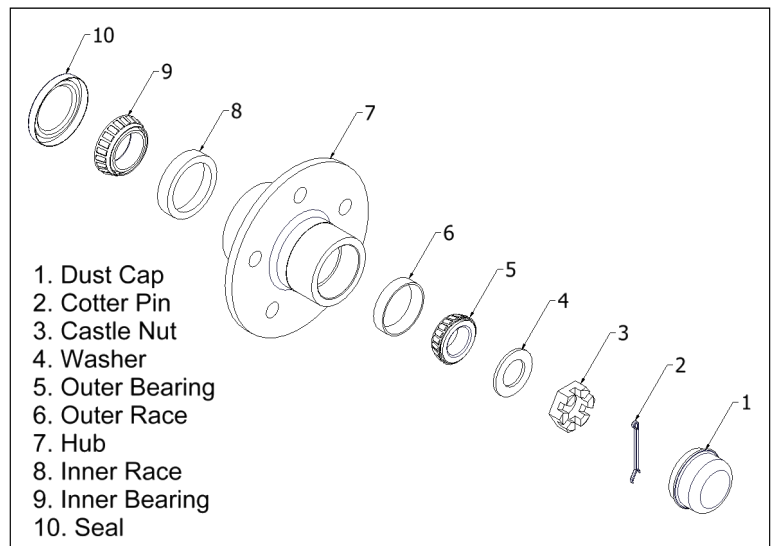


Figure 4-3 Front Hub Assembly

4.7 Tow Latch Assembly

The tow latch assembly is used to secure the tow bar in the upright position. see Figure (4-4).

- a. Remove tow bar (1) by placing the tow bar in upright, latched position. Pull the hitch pin clip (2). While holding onto towbar, place foot on toe latch assembly (See reference arrow A) and depress.
- b. Pull hitch pin (3) from steering arm assembly and place tow bar to the side.

(The remaining steps are illustrated in Figure 4-5) .

- c. Remove bolt (7) and nut (10).
- d. Rotate toe latch plate (9) downward to free from assembly.
- e. Detach spring (8) from toe latch plate (9) and spring anchor (24).

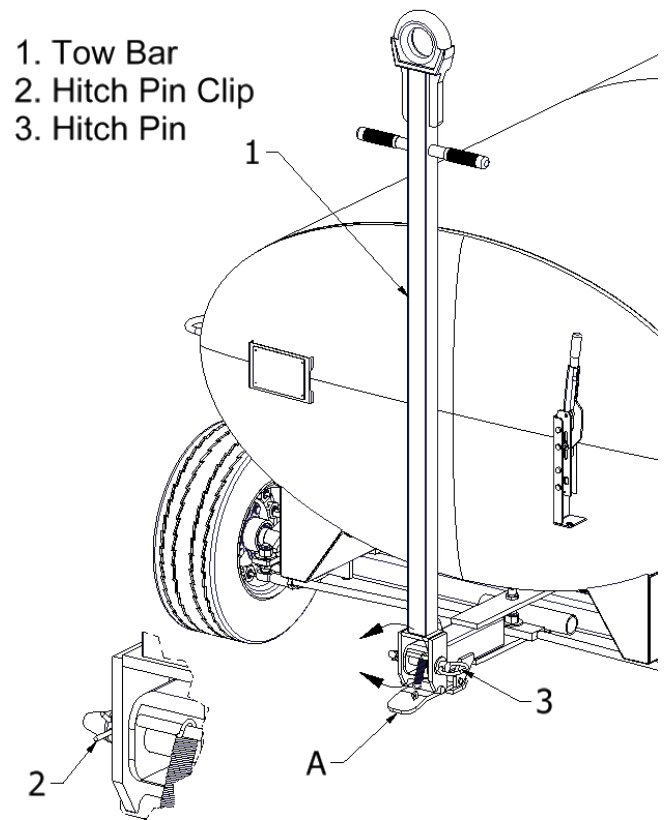


Figure 4-4 Tow Bar Removal

⚠ CAUTION

Removing hitch pin from steering arm assembly will free tow bar. Prevent tow bar from falling by holding it firmly until free. Set aside.

4.11 Front Undercarriage Removal

To remove the entire Front Undercarriage assembly, the equipment must have the front end raised. See Figure 4-2 for lift points.

- Raise equipment with suitable maintenance jack (see Figure 4-2 arrow A for jack placement) to allow four inches of space between the wheels and ground.
- Place cribbing under tank skids (see Figure 4-2, reference arrows C) to safely support the equipment.
- Lower onto cribbing. Leave jack in place.
- Raise jack to apply slight pressure on assembly. (**Tow bar must be in upright position.**)
- Remove bolts (2) and nuts (3), (see Figure 4-6).
- Carefully lower jack and assembly until wheels are on the ground and front axle tube clears tank mounts.
- Pull Front Undercarriage forward. Note location of rubber mounting pads (5).

⚠ WARNING

Use suitable lifting and support equipment when performing these steps. Serious injury or death could occur from rolling or falling equipment.

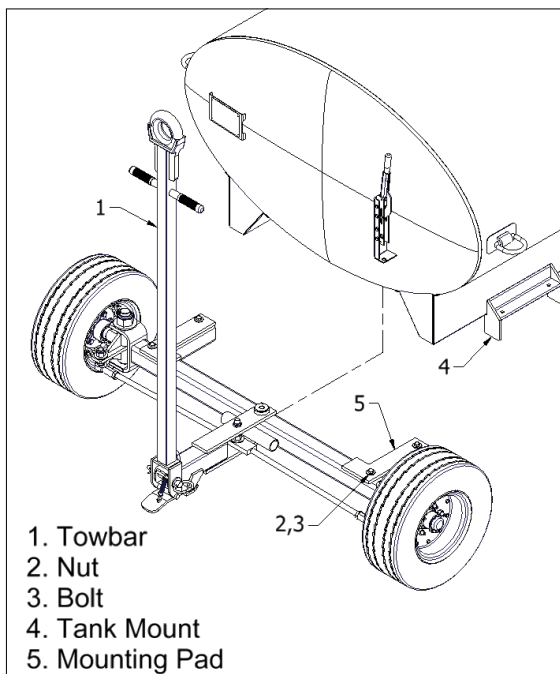


Figure 4-6 Front Undercarriage Removal

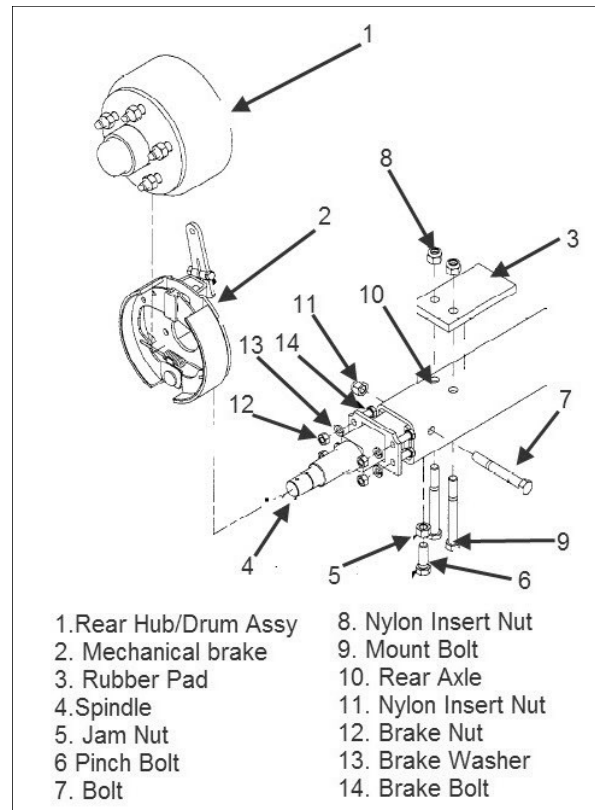


Figure 4-7 Rear Undercarriage Removal

4.12 Rear Undercarriage Assembly

See Figure 4-7 for the following maintenance steps. The rear undercarriage assembly consists of: a wheel assembly, a hub and brake drum assembly (1), a mechanical parking brake assembly (2), a rear spindle (4), and the axle (10).

4.13 Rear Wheel Assembly Removal

To remove wheel assembly, the equipment must have the back end raised and placed on approved jack stands. Points A and B are similar on both the rear and front axles. (See Figure 4-2)

- Raise equipment with suitable maintenance jack high enough to remove wheel assembly. (See Figure 4-2, arrow A for jack placement) .
- Place approved jack stands under rear axle (see Figure 4-2, arrow B for stand placement).
- Remove lug nuts of wheel assembly needing maintenance.

4.14 Rear Hub / Brake Drum Assembly

To remove the rear hub and brake drum assembly, follow the maintenance steps for the rear wheel assembly removal before beginning the next steps. Figure 4-8 illustrates the process for the rear hub/ brake drum assembly.

- Remove dust cap (1) by lightly tapping with a rubber hammer.
- Remove cotter pin (2), castle nut (3) and washer (4).
- Grasp front hub (7) and drum (8) and pull outward firmly. Ensure that bearing (5) doesn't fall from hub and strike the ground.
- Remove bearing (5), seal (11), and bearing (10) from the rear hub (7).
- Using a suitable H-frame press, remove bearing races (6) and (9).
- Remove drum (8) by pressing out wheel studs (12) in suitable H-frame press.
- Replace components and grease bearings before reassembly.
- Reassemble in reverse order. Castle nut (3) should be tightened until the hub assembly rotates barely past free.

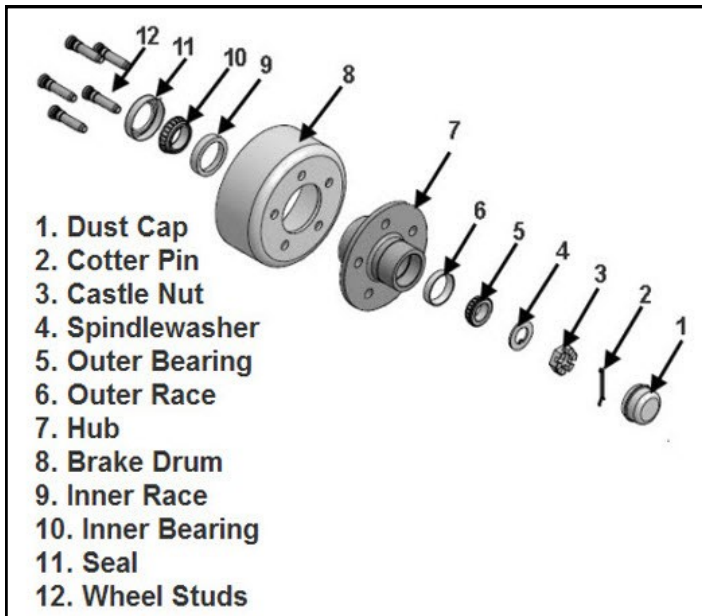


Figure 4-8 Rear Hub and Brake Drum

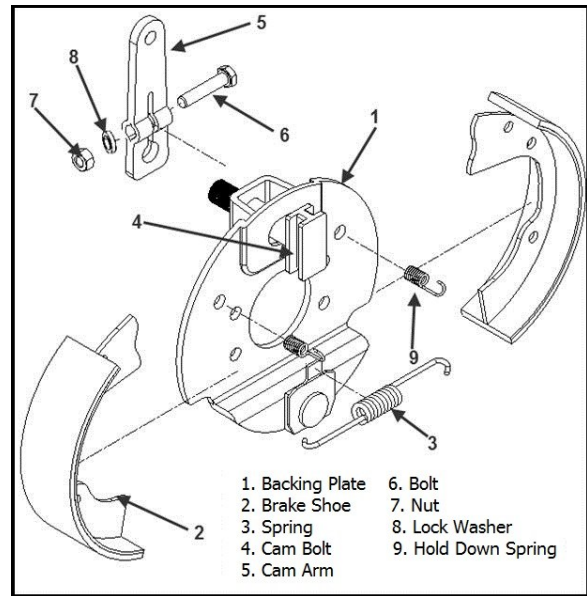


Figure 4-9 Mechanical Brake

4.15 Mechanical Brake Assembly

The assembly can be disassembled while attached to the rear spindle or removed from the unit. See Figure 4-9.

- Remove Rear Wheel Assembly as described in section 4.13.
- Remove Rear Hub and Brake Drum Assembly as described in section 4.14.
- Remove brake cable end from arm (5) as described in section Section 4.17, step (a).
- Remove nuts (12), washers (13), and bolts (14) shown in Figure 4-9
- Remove Mechanical Brake Assembly and place on flat surface.
- Remove spring (3).
- Release brake shoes (2) by removing springs (9) from the backing plate (1).
- Remove nut (7), lock washer (8), and bolt (6) to release arm (5).
- Remove brake cam (4) by pulling directly outward.

NOTE: Steps (d) and (e) are needed only if Mechanical Brake Assembly is to be removed from the axle.

4.16 Parking Brake Assembly and Adjustment

The parking brake assembly consists of a brake handle and cable assembly and a mechanical brake assembly. The parking brake can be adjusted at three different locations.

An in-field adjustment can be made at the brake handle by turning the handle cap clockwise to tighten brakes and counterclockwise to loosen the brakes (see reference arrow D in Figure 4-10.) This adjustment must be made with the brake handle in the off position. Maintenance level adjustments can be made at reference arrow E and reference arrow F of Figure 4-10 (each side).

4.17 Brake Handle and Cable Assembly

The brake handle and cable assembly only need to be disassembled to the point that the repair is needed. These instructions start at the wheel assembly and progress toward the brake handle. (1)

- a. Remove cotter pin (13) and clevis pin (14) to release clevis (12).
- b. Unthread clevis (12) from cable
- c. Remove nut (15) and remove cable housing (10) from bracket.
- d. Remove nut at opposite end of cable and disassemble cable linkage parts (6), (7), (8), and (9).
- e. Repeat steps (a) through (d) for opposite side.
- f. Remove nut (4) to release cable equalizer (5).
- g. Repeat step c. for cable housing leading to brake handle.
- h. Remove nut at other end of cable and release cable by disassembling cable linkage from brake handle (1).
- i. Remove bolts (2) and nuts (3) to free brake handle (1).

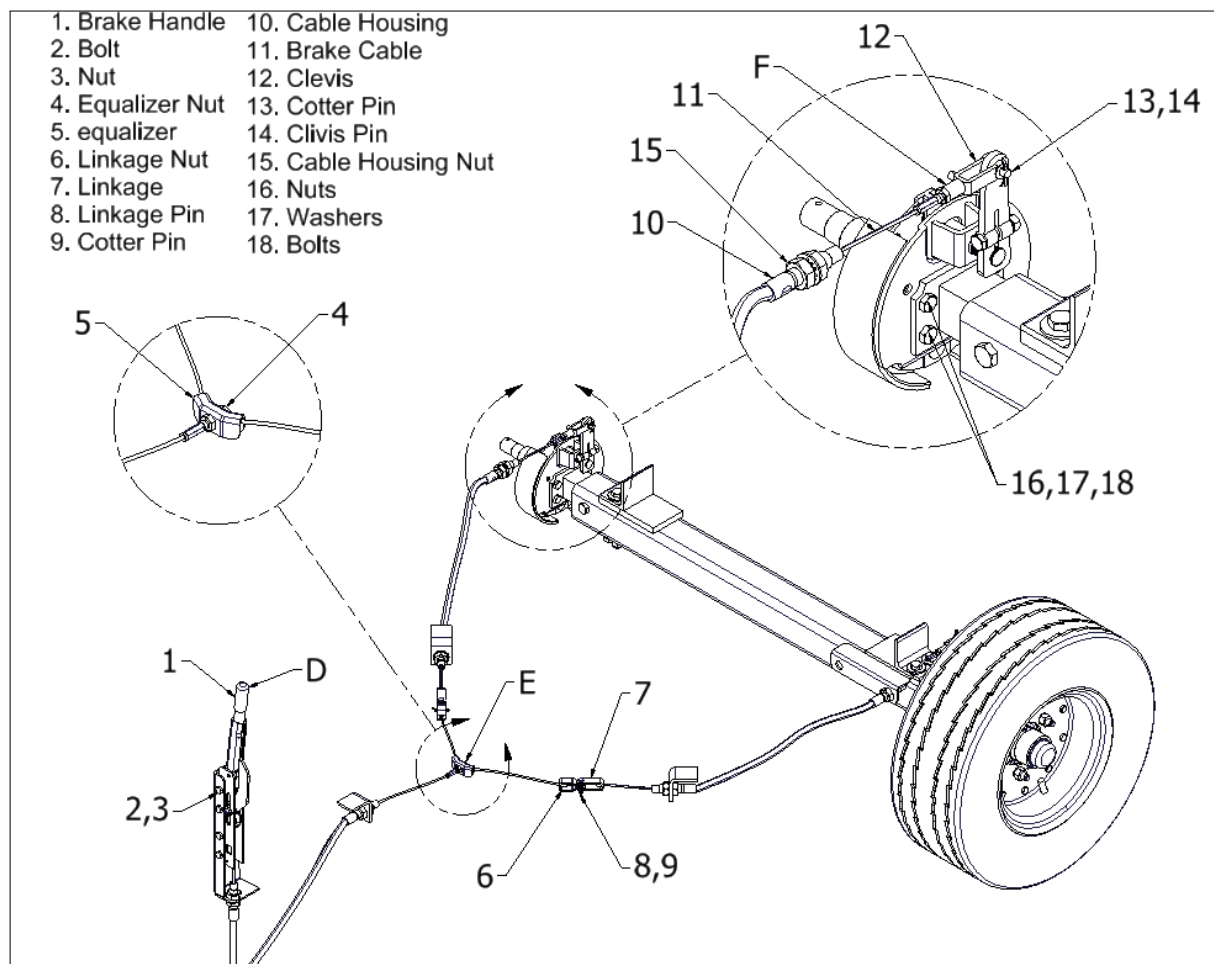


Figure 4-10 Brake and Cable Assembly

4.18 Rear Undercarriage Assembly

To remove the entire Rear Undercarriage assembly, the equipment must have the back end raised. See Sections 4.12, and 4.13 with Figure 4-11.

- Raise equipment with suitable maintenance jack (see Figure 4-11 reference arrow A for jack placement) and allow for 2-inches of space between the wheels and the ground.
- Place cribbing under tank skids to safely support the equipment. (see Figure 4-11, reference points labeled with a C).
- Lower onto cribbing. Leave jack in place.
- Disconnect parking brake cables at mechanical brake assembly in Section 4.15, step (a).
- Raise jack to apply slight pressure on assembly.
- Remove mounting nuts and bolts from both sides of axle assembly.
- Carefully lower jack and assembly until wheels are on the ground and the front axle tube clears tank mounts.

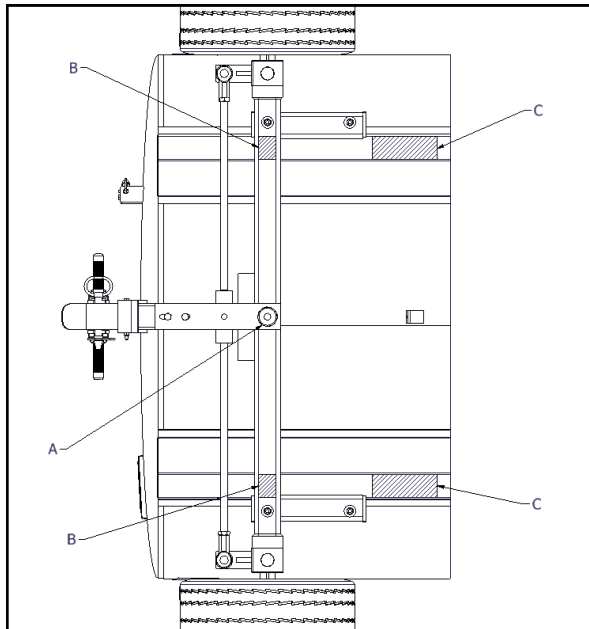


Figure 4-11 Lift Points

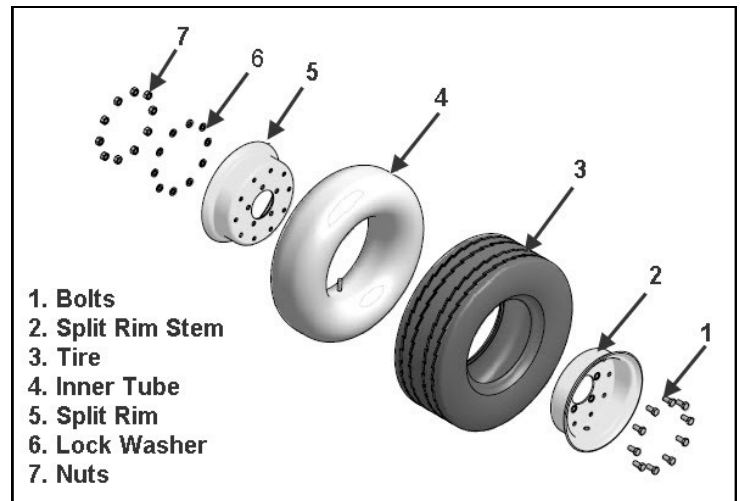


Figure 4-12 Wheel Assembly

4.19 Wheel Assembly

The Wheel assembly is a two-piece, split rim design. Use Figure 4-12 and sections 4.12 and 4.13 for the following maintenance steps.

- Remove wheel assembly as described in Section 4.5 for the side needing repair.
- Release air pressure from the inner tube by depressing stem valve or by removing the stem valve.
- Remove nuts (7), lock washers (6), and bolts (1).
- Separate split-rims (2) and (5) from tire (3).
- Remove inner tube (4) from tire (3). When reassembling, make sure that the inner tube stem is positioned through access hole in split rim.
- Torque split rim nuts (7) to 75-foot-pounds before applying air pressure to tire.
- Torque lug nuts to 100-foot-pounds.

⚠ WARNING

Disconnect all electrical connections to the unit (batteries, battery charger, tow vehicle) before performing any of the steps described here. Flammable liquids and vapors can be ignited by accidental electrical arcs. Serious injury or death could result.

Drain all flammable liquids from the tank and plumbing system before performing any of the steps described here. Flammable liquids and vapors pose a fire danger that could result in serious injury or death.

4.20 Removing the Fuel Pump

- a. Remove electrical leads from pump motor. The cover plate is located in back of the pump motor and the conduit is located in front of the pump motor.
- b. Remove the two bolts connecting the fuel meter (6) to the pump-to-meter line (9).
- c. Remove the pump to meter line (9).
- d. Remove the four bolts at the bottom of the pump mounting plate.
- e. Remove the threaded hose from the pump's inlet.

4.21 Removing the Fuel Meter

- a. Remove the two bolts connecting the fuel meter (6) to the pump-to-meter line (9).
- b. Remove the four bolts connecting the fuel meter (7) to the back of the pump.

4.22 Removing the Filter Housings

- a. Remove the Victaulic fitting on the left side of the housing filter.
- b. Unthread the recirc valve (8).

4.23 Removing the 4-Way Selection Valve

- a. Remove fuel meter (6) as described in Section 4.20.
- b. Remove the valve-to pump line (2).
- c. Remove the valve-to-pump line threaded Victaulic fitting at the elbow next to the 4-way selection valve. (10)
- d. Remove the tank-to-valve line (5) Victaulic fitting at the elbow next to the selection valve.

- e. Remove the U-bolt (not shown) that secures the remaining assembly to the frame.
- f. Using a pipe wrench and a bench vise, Remove remaining components.

4.24 Removing the Hose Reel

- a. Remove all items connected to mounting bracket (12) and remove bracket.
- b. Remove valve-to-reel line. (7)
- c. Remove the quick disconnect from the fueling nozzle (14).

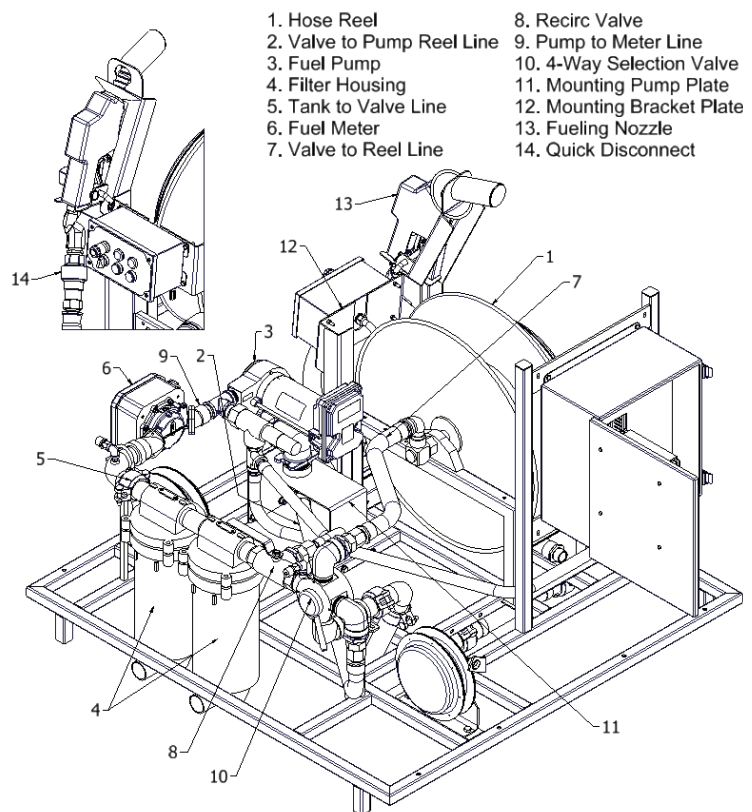


Figure 4-13 Pump Module

4.25 Pump Strainer Removal and Cleaning

This pump is designed for minimum maintenance. Motor bearings are sealed and require no lubrication. Inspect the pump and components regularly for fuel leaks and make sure the hose and power cord are in good condition. Keep the pump exterior clean to help identify leaks.

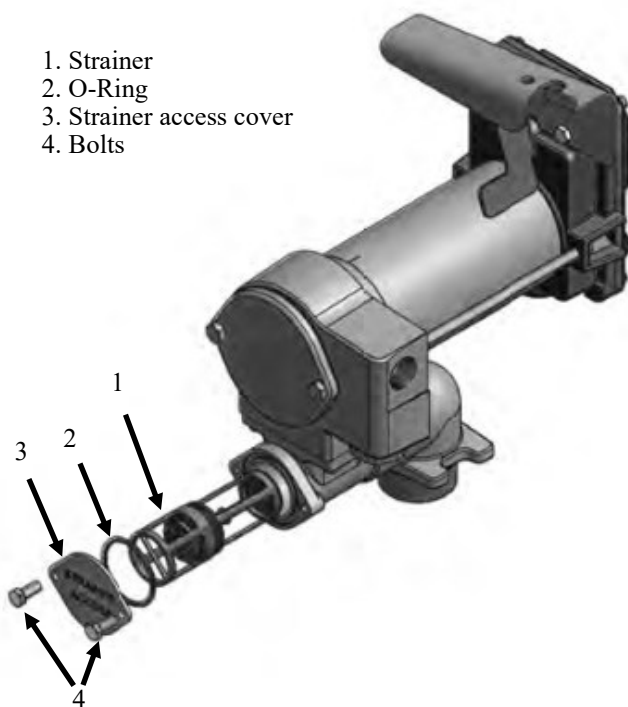
Do not use this pump for water, chemicals or herbicides. Dispensing any fluid other than those listed in this manual will damage the pump. Use of the pump with unauthorized fluids will void the warranty.

To Clean or Replace Strainer

All pump models have an inlet strainer. If flowrate is reduced, clean or replace strainer (see below)

Turn the pump off and disconnect from power. Depending on the model, remove and clean the strainer with a soft-bristled brush and solvent. If the strainer is very dirty, compressed air may be used. If damaged, replace the strainer. Replace components making sure that they are seated and fasteners are tightened securely.

1. Strainer
2. O-Ring
3. Strainer access cover
4. Bolts



**Figure 4-14. Manufacturer's Pump Strainer Removal
(Great Plains MODEL M-3025CB-AV Fuel Pump)**



Figure 4-15. Clogged Pump Strainer

4.26 Changing Fuel Filter Elements

The fuel filter elements should be replaced whenever fuel flow is restricted or at least once per year. The following steps describe how to replace the fuel filter. See Figure 4-14.

- a. Drain filter housing by opening the top and bottom petcock valves.
- b. Remove the four bolts that secure the filter canister to the filter housing.
- c. Pull downward on the filter element.
- d. Replace O-ring (not shown.)
- e. Install new filter element in reverse order.
- f. Close bottom petcock valve.
- g. Jog pump to purge air.
- h. Close top petcock valve.

4.27 Changing Operator Console Indicator Lights

The only maintenance activity for the operator console is to change out indicator lights.

- a. Identify the indicator light that needs to be removed.
- b. Rotate lens counterclockwise and remove.
- c. Remove circular diffuser disk (plastic) from housing.
- d. Remove and replace light bulb.

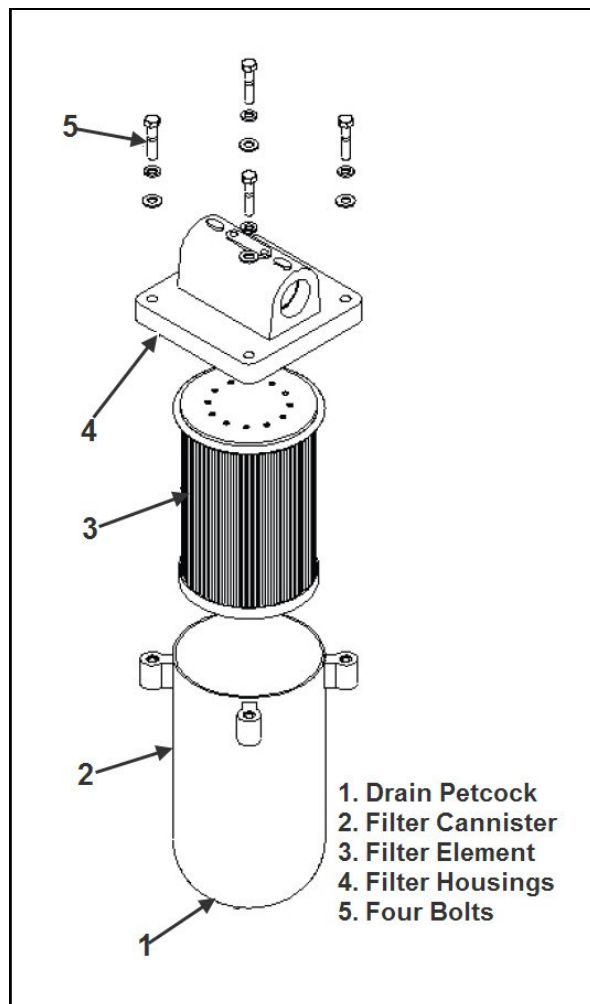


Figure 4-16 Fuel Filters

4.28

Troubleshooting the Helifueler DFC

Problem	Probable Cause	Corrective Action
Threaded Connection leaking weeping	Loose fitting, bad seal, damaged fitting	Use Section 4.2 To fix condition
Valve Leaking, weeping, or doesn't operate	Internal damage to valve's ball, stem, or seat	Replace valve using section 4.2
Manway won't seal	Manway Assembly is out of adjustment or seal is damaged	Adjust manway assembly using section 4.3
Low/ No discharge pressure at fuel nozzle	Low battery charge Fuel filter(s) restricted Tank-to-Pump valve partially open Pump strainer is blocked	Charge batteries Inspect and replace if needed Ensure valve is open (handle vertical) See section 4.25
Low/ No Defueling Capability	Low battery charge Fuel filter(s) restricted Tank-to-Pump valve partially open Pump strainer is blocked	Charge batteries Inspect and replace if needed Ensure valve is open (handle vertical) See section 4.25
12 Volt pump – weak or will not work	Low/ No battery charge Battery terminals/ cables corroded Battery Cell(s) fluid low Main Power switch in OFF position Pump has internal damage Pump has reached duty cycle Circuit breaker has tripped	Fully charge batteries Inspect & clean, replace if necessary Service cell(s) with distilled water Turn Main Power switch ON Replace pump Wait 30 minutes and retry Wait 30 minutes and retry
Fuel Meter has no indication of flow	Main pump not turned ON Main tank empty Fuel Meter internally broken	Turn ON pump Load fuel into tank Replace fuel meter
Wheels won't steer properly	Steering arm assembly is damaged or tie rod assembly is damaged or misadjusted.	Inspect and repair when needed using Sections 4.9 and 4.10.
Wheels wobble or drag while rolling	Wheel bearings are damaged or loose	Inspect and Repair if needed
Towbar won't lock in upright position	Tow latch spring, damaged or missing	Inspect and replace when necessary
Brakes don't secure unit while engaged.	Brakes are out of adjustment parking brake assembly is damaged or missing	Adjust brakes or adjust and repair using sections 4.15, 4.16 and 4.17.

SECTION 5.0

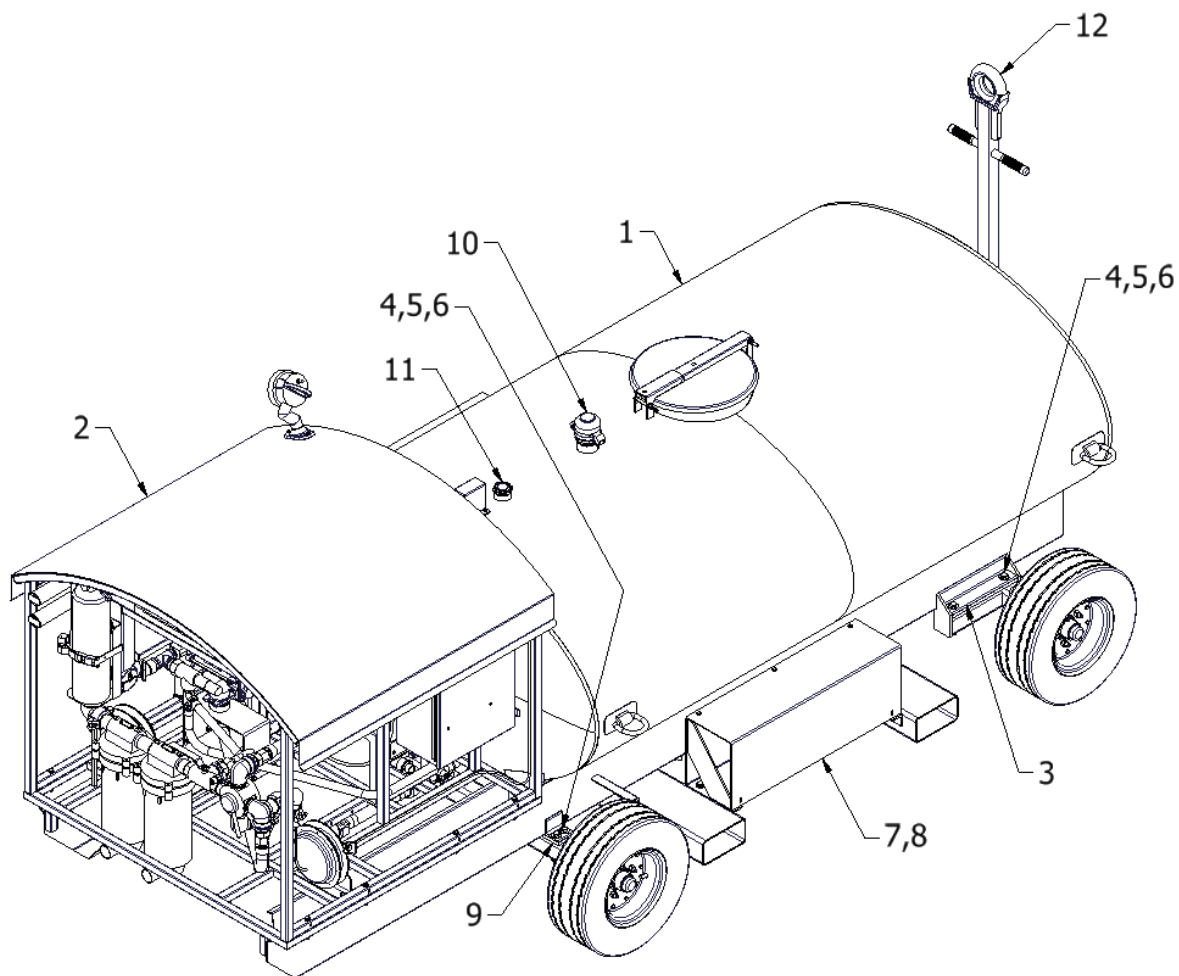
PART BREAKDOWN DRAWINGS AND PART NUMBERS

The following figures are supplied to assist in component identification and parts reordering. When reordering, ensure the complete model number and serial number are provided to the sales representative.

You may access customer service by contacting Spokane Stainless Technologies at 509-921-8871. (The toll free number does not work internationally). If you would like more information about Spokane Stainless Technologies you may visit the website at: www.spokanestainless.com.

DRAWING NUMBER

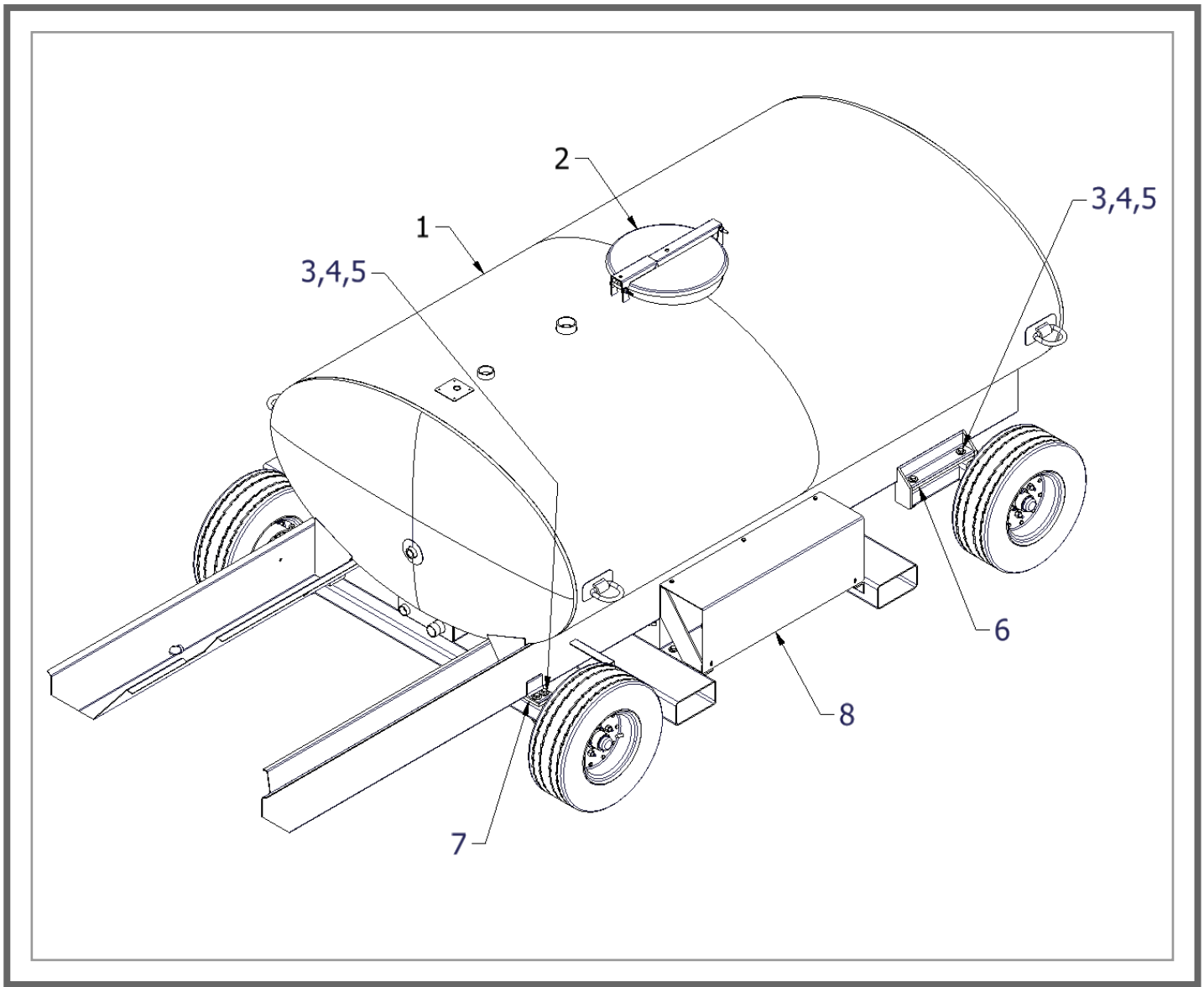
- 1.0 Overview, Component Identification**
- 2.0 Overview, Component Identification (Tank)**
- 3.0 Pump Components**
- 4.0 Manway Assembly**
- 5.0 Front Undercarriage**
- 6.0 Rear Undercarriage and Axle**
- 7.0 Front Hub Assembly**
- 8.0 Rear Hub & Drum Assembly**
- 9.0 Wheel & Tire Assembly**



DRAWING 1.0

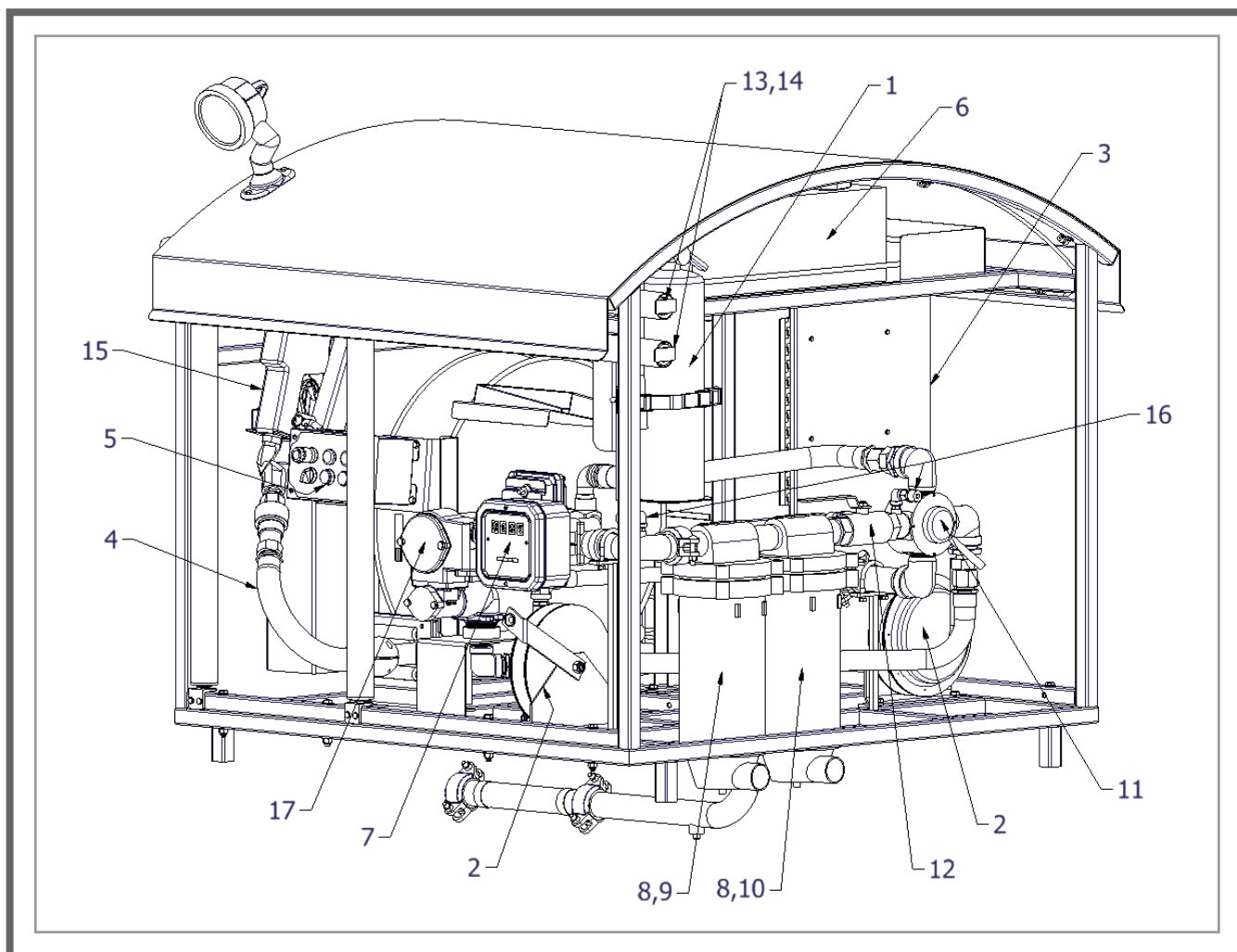
Overview Component Identification

ITEM	QTY	P.N.	DESCRIPTION	MATERIAL	WEIGHT
1	1	07-9029	Tank Weldment 600 Gallon	Various	1852 lb.
2	1	25-0003	Pump Module Assembly	Various	788 lb.
3	2	06-1023	Mounting Pad	Rubber	1 lb.
4	8	02-3025	Bolt, 1/2-IN x 4-1/2-IN LG	Stainless Steel	0 lb.
5	16	02-3125	Washer, 1/2-IN	Stainless Steel	0 lb.
6	8	02-3087	Nut, Nylon Insert, 1/2-IN-13	Stainless Steel	0 lb.
7	1	07-5510	Dual Battery Enclosure	Various	48 lb.
8	2	04-8050	Battery	Various	60 lb.
9	2	06-1012	Rear Mount Pad	Rubber	0 lb.
10	1	04-01545	Tank Vent / Fill Cap, 2-IN		0 lb.
11	1	04-8007	Liquid Level Gauge	Various	0 lb.
12	1	07-1103-1	Weldment, Tow Bar		34 lb.



DRAWING 2.0 **Overview, Component Identification (Tank)**

ITEM	QTY	P.N.	DESCRIPTION	MATERIAL	WEIGHT
1	1	07-9029	Tank Weldment 600 Gallon	Various	1852 lb.
2	1	08-10251	Cross Arm and Lid Assembly	Various	12 lb.
3	8	02-3025	Bolt, 1/2-IN x 4-1/2-IN LG	Stainless Steel	0 lb.
4	16	02-3125	Washer, 1/2-IN	Stainless Steel	0 lb.
5	8	02-3087	Nut, Nylon Insert, 1/2-IN-13	Stainless Steel	0 lb.
6	2	06-1023	Mounting Pad	Rubber	1 lb.
7	2	06-1012	Rear Mount Pad	Rubber	0 lb.
8	1	07-5510	Dual Battery Enclosure	Various	48 lb.

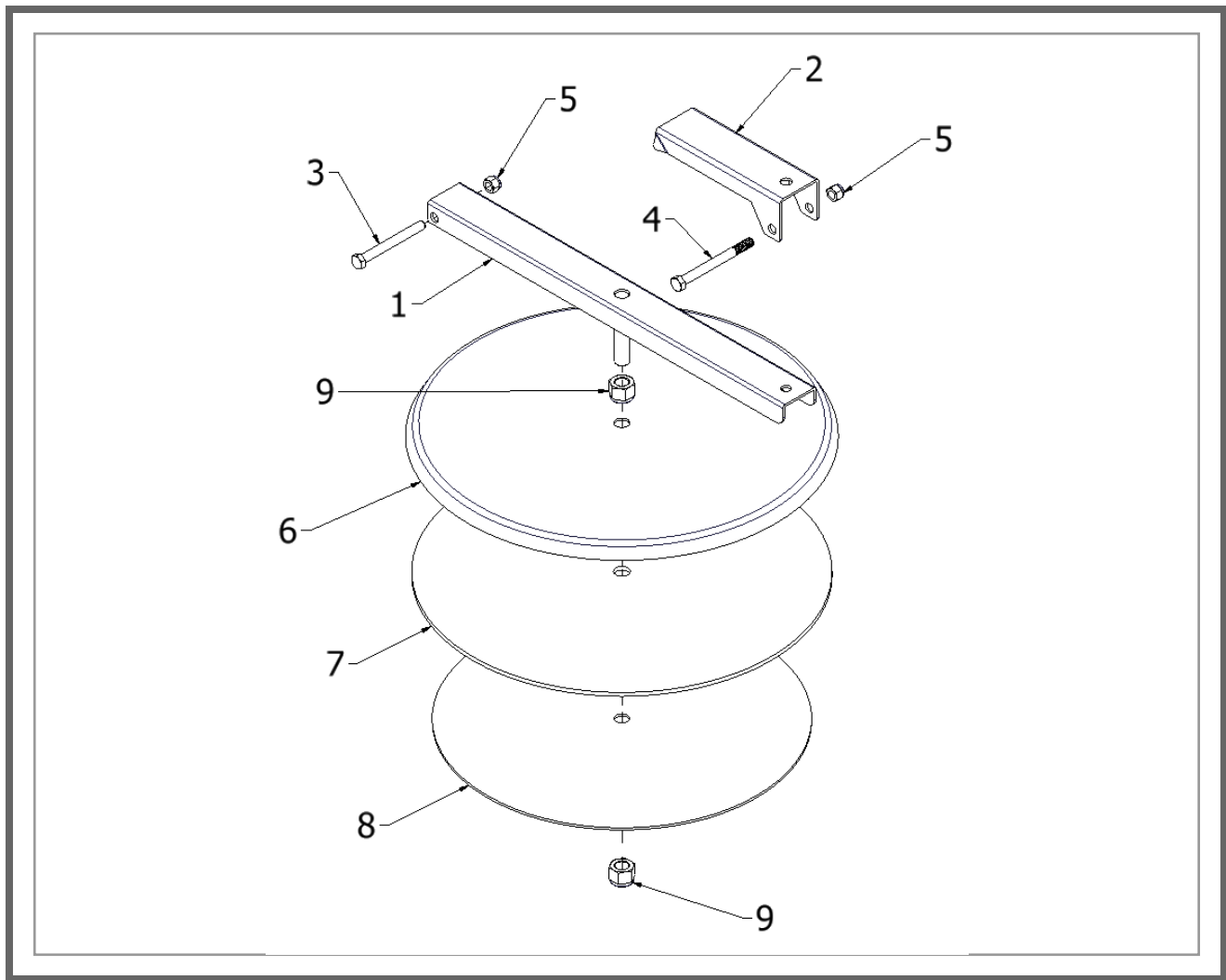


Drawing 3.0

Pump Components

-Not Illustrated

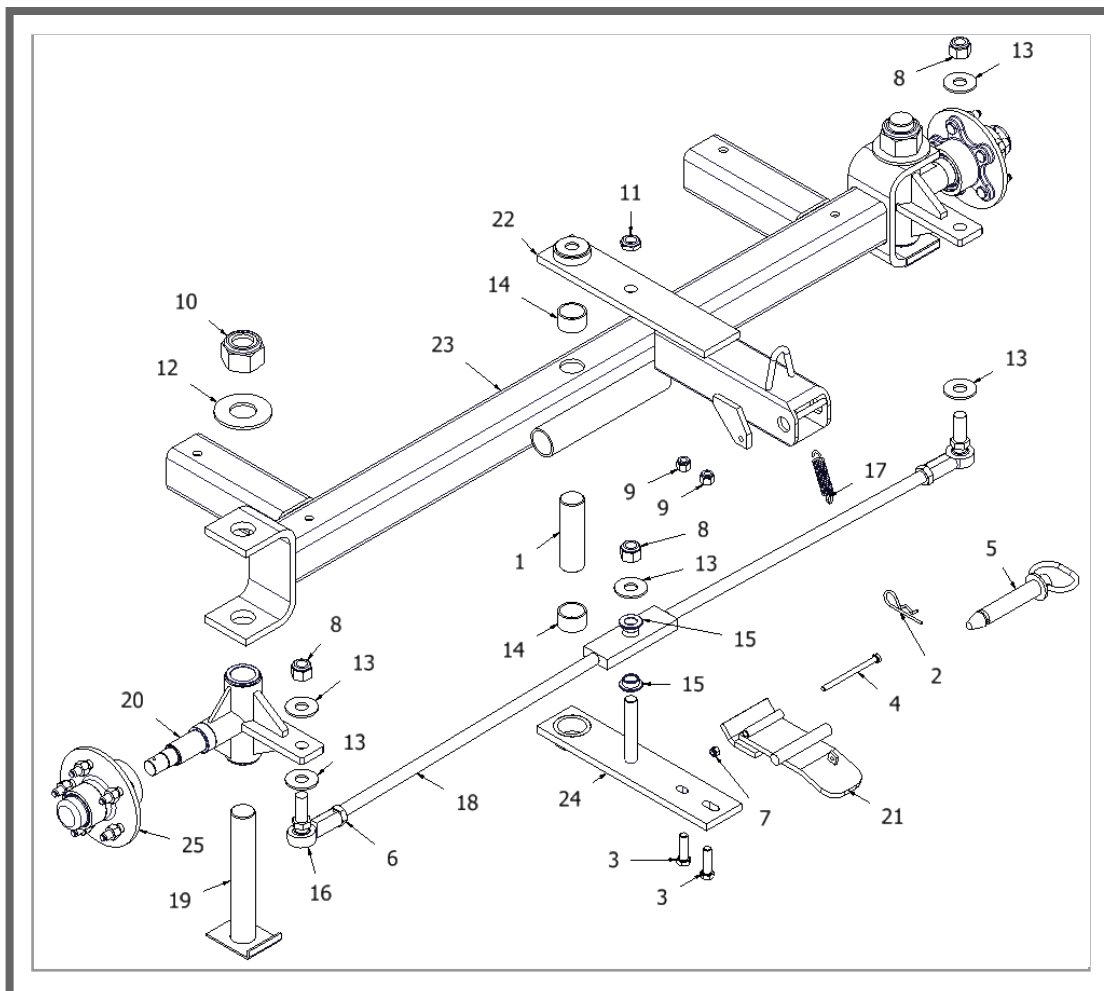
ITEM	QTY	P.N.	DESCRIPTION
1	1	04-0702	Fire Ext. 5# Purple K
2	2	04-10362	Grounding Reel, Red, Plug and Clamp
3	1	15-00162	Electrical Box Assembly
4	1	25-5019	Hose Asm., 1-IN x 50-FT
5	1	15-00110	Operator's Console
6	1	04-8025	Spill Response Kit
7	1	04-8063	Fuel Meter
8	2	04-8043	Filter Housing
9	1	04-80212	Filter Element, Facet #CC-22-7, Coalescer CRT, Fits VF-22SB
10	1	04-80213	Filter Element, Facet #FG-0-612-2, FG Monitor CRT, Fits VF-22SB
11	1	04-10310	Valve, 4-Way Lever Operated, 1- 1/2-IN. Ports
12	1	04-10350	Valve, Ball, 3-Way, 1 1/2-IN NPT
13	1	25-0003-012	Weldment, Lower Storage Tube, Suction Wand
14	1	25-0003-013	Weldment, Upper Storage Tube, Suction Wand
15	1	04-8162	Nozzle, Automatic Shut-off .83-inch, 1-IN FNPT
16	2	04-8040	Sample Port
17	1	04-8061	Pump, Fuel, 12VDC, 25GPM, 35 AMP
-18	2	04-0469	ASM, CABLE, STATIC DRAIN



Drawing 4.0

Manway Assembly

ITEM	QTY	P.N.	DESCRIPTION
1	1	07-1039S	Cross Arm
2	1	01-8222S	Flip Lock
3	1	02-3044	Hex Hd. Capscrew, NC, 3/8" by 3-1/2" LG
4	1	02-3045	Hex Hd. Capscrew, NC, 3/8" by 4" LG
5	2	02-3089	Nut, Nylon Insert, 3/8-16 (AP)
6	1	01-86001	Manway Lid, 16" Diameter w/ Thru Hole
7	1	06-25025	Manway Gasket, 16" Standard, 3/16" Thk, Buna
8	1	07-2303	Retainer Gasket
9	2	02-3091	Nut, Nylock, NF, 5/8"-18

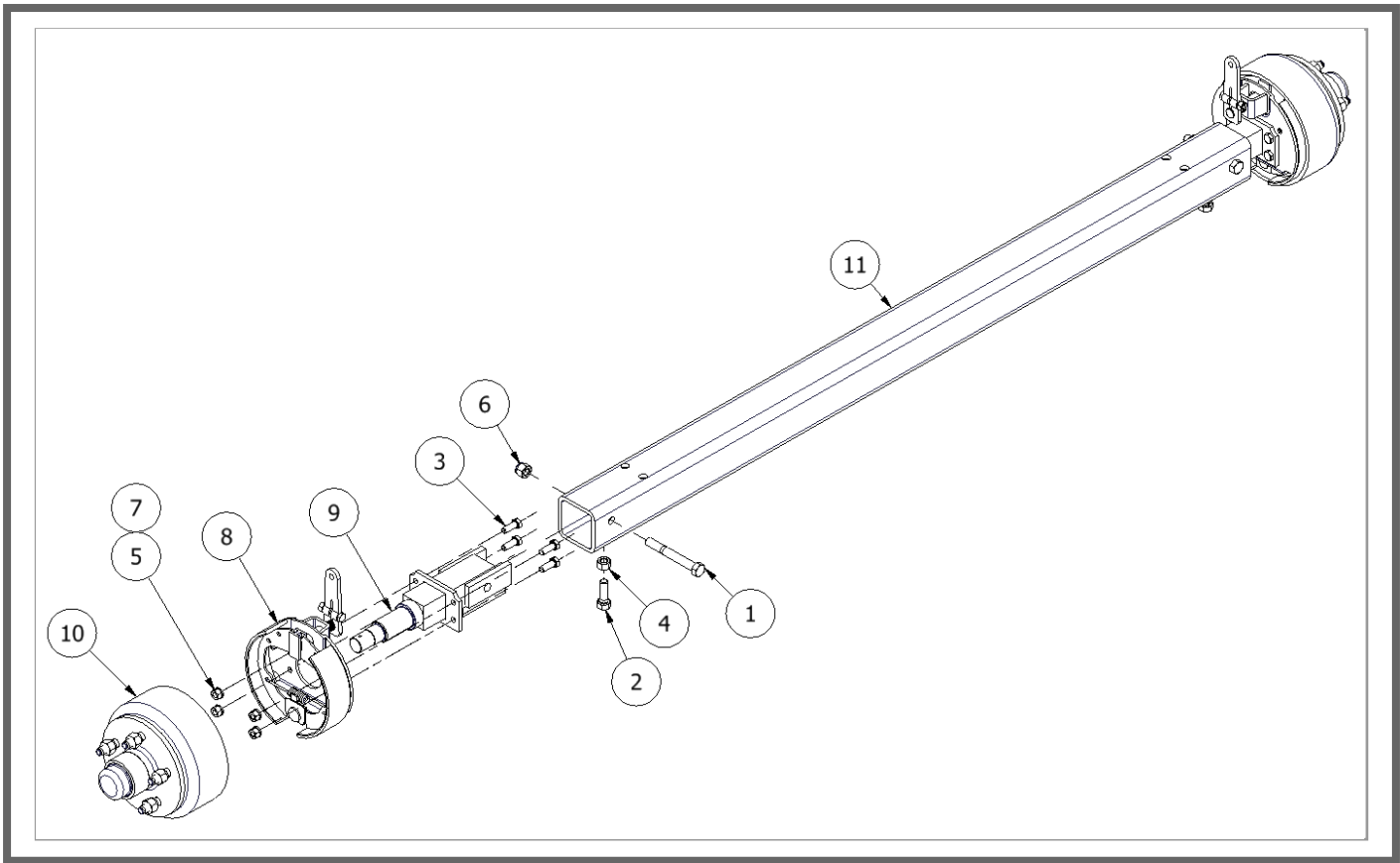


Drawing 5.0

Front Undercarriage

ITEM	QTY	P.N.	DESCRIPTION
1	1	01-8414	PIVOT PIN, FRONT AXLE
2	1	02-3016	HITCH PIN CLIP
3	2	02-3022	HEX HD CAPSCREW, NC, 1/2-IN BY 1 3/4-IN, GRD 5, PLATED
4	1	02-3055	HEX HD CAPSCREW, NC, 5/16-IN BY 4 1/2-IN LG, PLATED
5	1	02-3063	HITCH PIN, 1-IN BY 4 1/2-IN LG, PLATED
6	2	02-3081	NUT, JAM, UNF, 3/4-IN-16, PLATED
7	1	02-3082	NUT, NYLOCK, NC, 5/16-IN-18
8	3	02-3083	NUT, NYLOCK, NF, 3/4-IN-16
9	2	02-3087	NUT, NYLOCK, NC, 1/2-IN-13, FIN, PLATED
10	2	02-3093	NUT, NYLOCK, UNF, 1 1/2-IN-12, FIN
11	1	02-3094	NUT, NYLOCK, NF, 3/4-IN-16, FIN, THIN
12	2	02-3127	WASHER, FLAT, 1 1/2-IN, PLATED

ITEM	QTY	P.N.	DESCRIPTION
13	5	02-3131	WASHER, FLAT, 3/4-IN, PLATED
14	2	03-1014	BUSHING, STEERING ARM
15	2	03-1015	BUSHING, TIE ROD, PIVOT POINT
16	2	03-1016	ROD END, BALL JOINT LINKAGE
17	1	04-1054	SPRING, TOW LATCH
18	1	07-1005	TIE ROD ASSEMBLY, 400/600 GALLON
19	2	07-10105	KING PIN
20	2	07-1015	ASM., KING PIN
21	1	07-1020	TOW LATCH WMT, ALL SIZES
22	1	07-1104	STEERING ARM, UPPER, 400 & 600 GALLON
23	1	07-11071	FRONT AXLE WELDMENT, 400 & 600 GALLON
24	1	07-5002	STEERING ARM, LOWER PLATE, ALL SIZES
25	2	08-1011	FRONT HUB ASSEMBLY

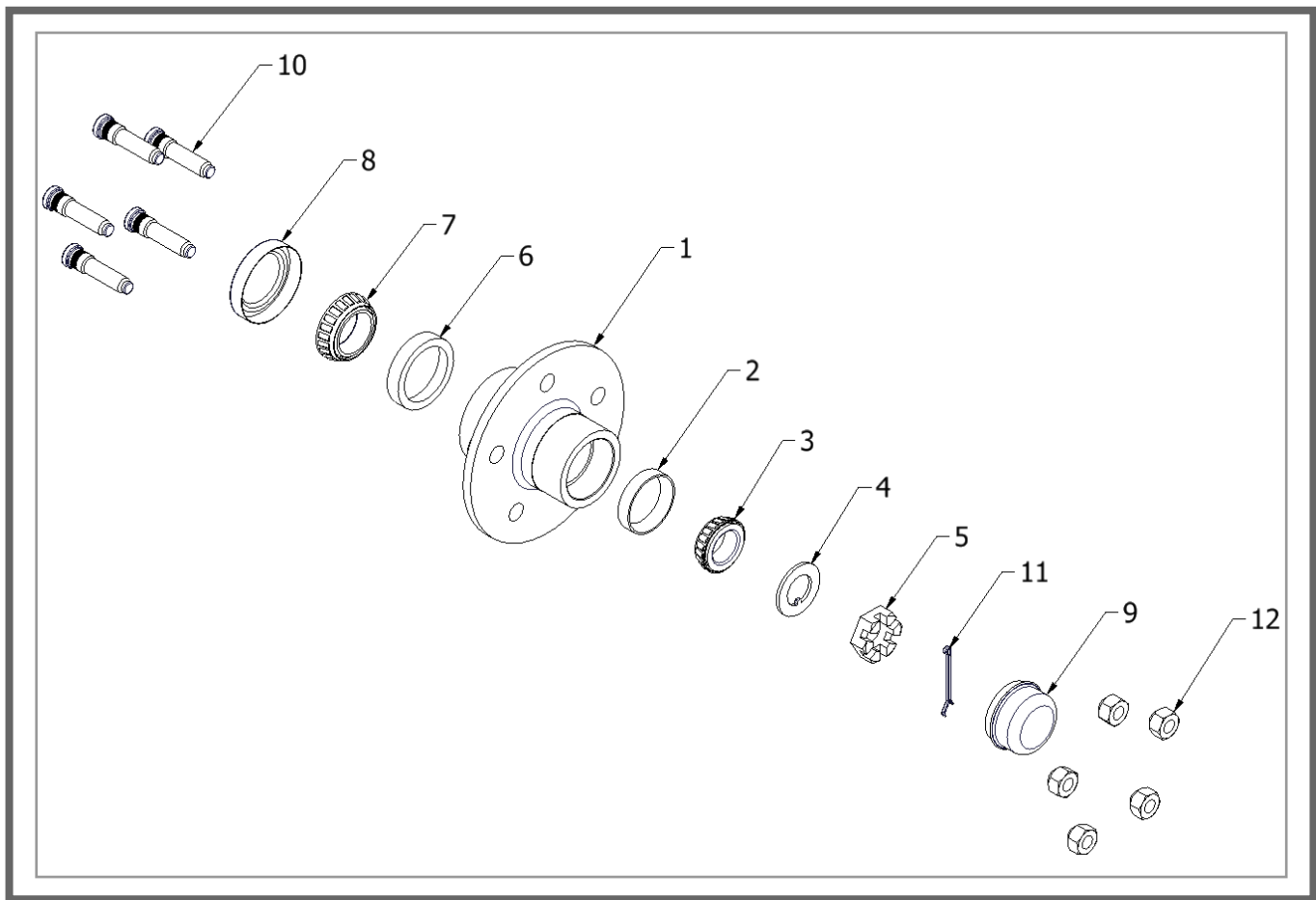


Drawing 6.0

Rear Undercarriage and Axle

ITEM	QTY	P.N.	DESCRIPTION
1	2	02-3024	HEX HD CAPSCREW, NC, 1/2-INCH BY 4-INCH, GRD 5, PLATED
2	2	02-3026	HEX HD CAPSCREW, NC, 1/2-INCH BY 1 1/2-INCH, GRD 5, PLATED
3	8	02-3050	HEX HD CAPSCREW, NC, 3/8-INCH BY 1-INCH, GRD 5, PLATED
4	2	02-3068	NUT, HEX, 1/2"-13 UNC PLATED
5	8	02-3072	NUT, HEX, NC, 3/8-IN-16, FIN., PLATED
6	2	02-3087	NUT, NYLOCK, NC, 1/2-INCH-13, FIN., PLATED
7	8	02-3143	WASHER, MEDIUM LOCK, 3/8-INCH PLATED
8	2	04-1063RBO	BRAKE ASSEMBLY
9	2	07-1010	REAR SPINDLE WELDMENT, REAR AXLE
10	2	08-10111	REAR HUB & DRUM ASSEMBLY
11	1	08-103011	REAR AXLE WELDMENT, 400 & 600 GALLON

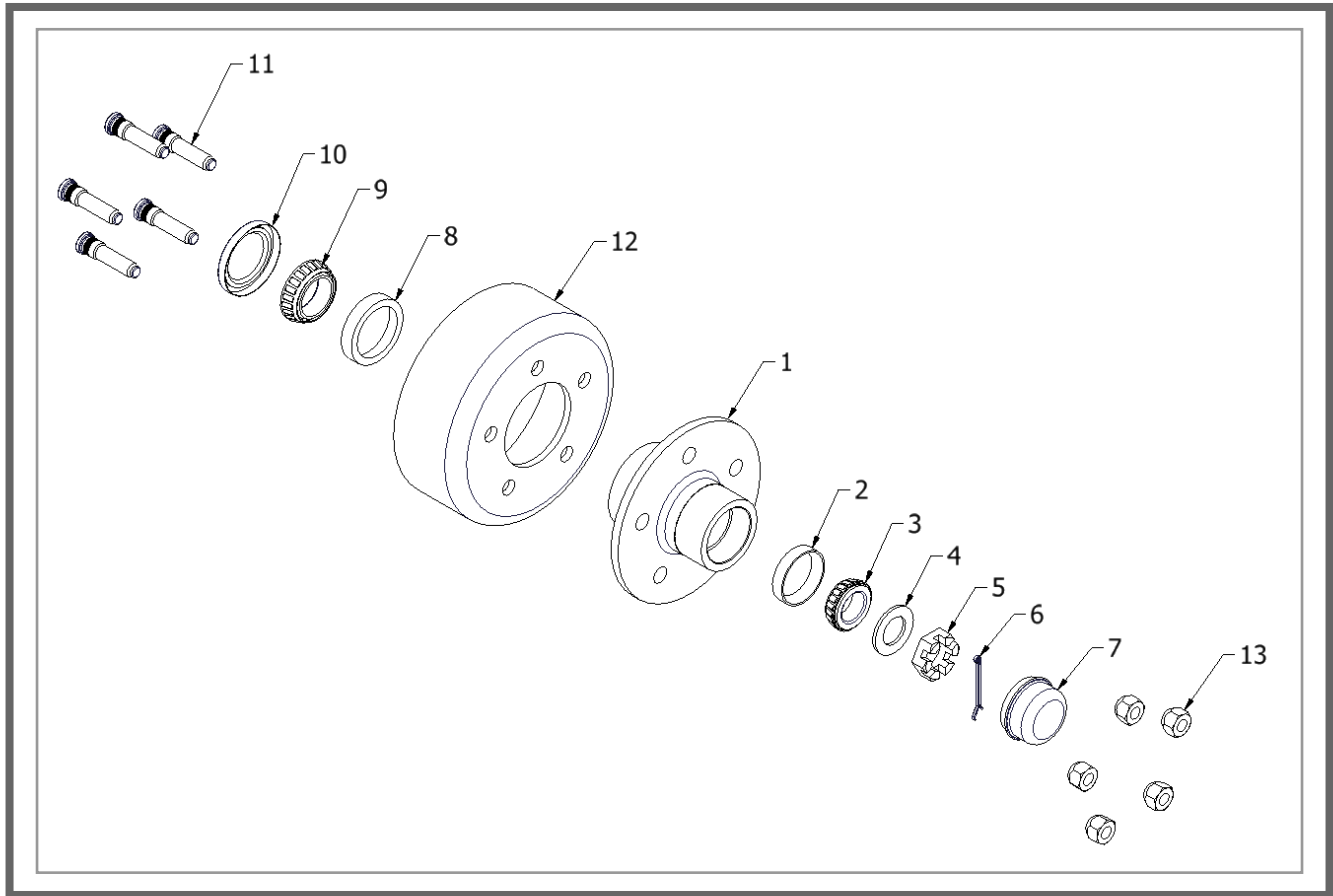
- Not Illustrated



Drawing 7.0

Front Hub Assembly

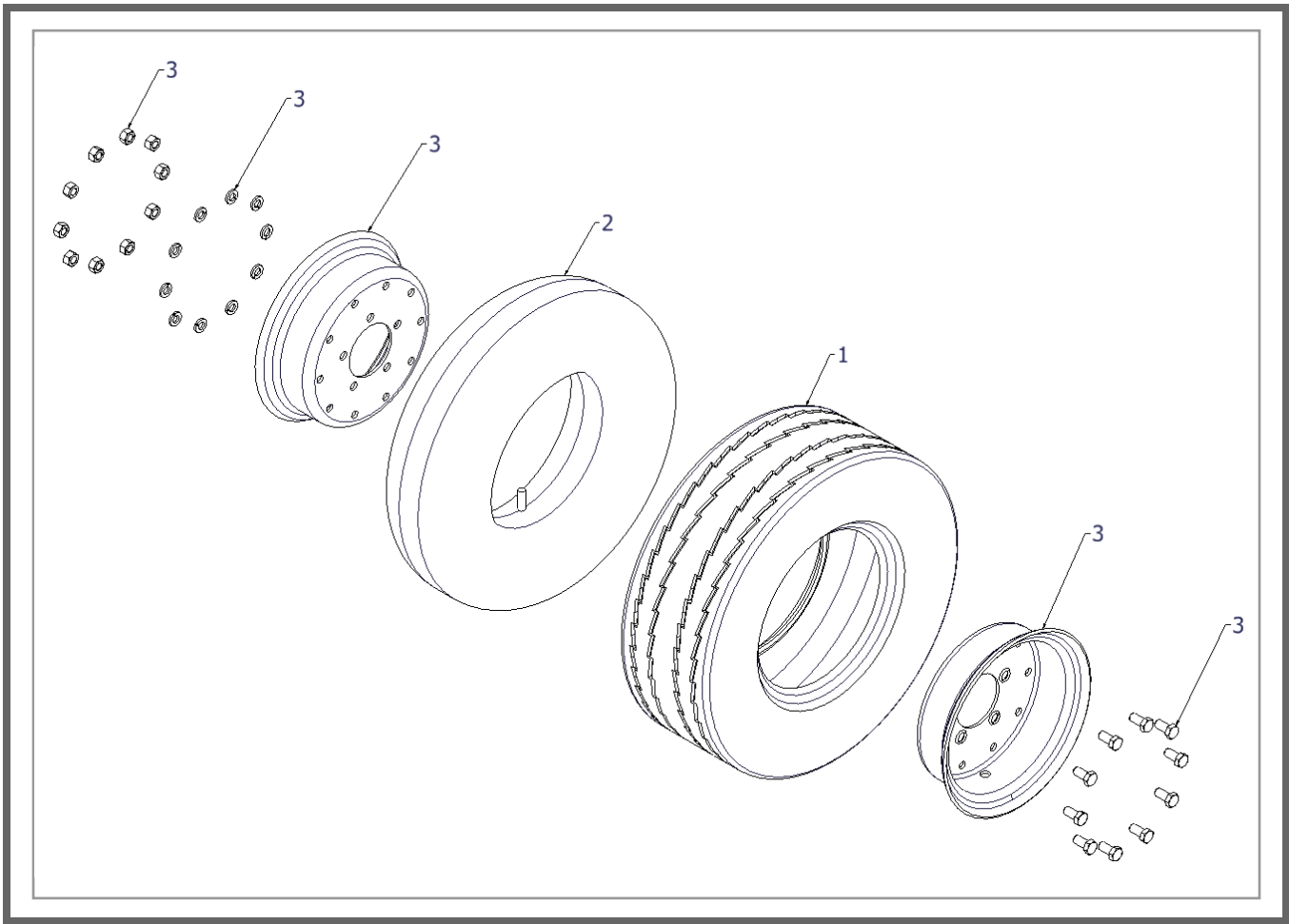
ITEM	QTY	P.N.	DESCRIPTION
1	1	04-1017	Hub, Front Axle
2	1	04-1016	Cup, Outer Bearing
3	1	04-1014	Cone, Outer Bearing
4	1	02-12055	Washer
5	1	02-1205	Nut, Castle
6	1	04-1015	Cup, Inner Bearing
7	1	04-1013	Cone, Inner bearing
8	1	04-1012	Seal bearing
9	1	04-1019	Cap, Hub
10	5	02-1017	Stud
11	1	02-1303	Pin, Cotter
12	5	02-3065	Nut, lug, 1/2"



Drawing 8.0

Rear Hub and Drum Assembly

ITEM	QTY	P.N.	DESCRIPTION
1	1	04-1017	Hub, Rear Axle
2	1	04-1016	Cup, Outer Bearing
3	1	04-1014	Cone, Outer Bearing
4	2	02-12055	Washer
5	1	02-1205	Nut, Castle
6	1	02-1303	Pin, Cotter
7	2	04-1019	Cap, Hub
8	2	04-1015	Cup, Inner Bearing
9	1	04-1013	Cone, Inner bearing
10	1	04-1012	Seal, Bearing
11	5	02-1303	Stud
12	1	08-10111	Drum, Brake
13	5	02-3065	Nut Lug



Drawing 9.0

Wheel and Tire Assembly

ITEM	QTY	P.N.	DESCRIPTION
	4	07-10201	Complete Wheel Assembly (All Numbers)
1	1	04-10221	Tire, 20.5x 8.0-10, E-Range
2	1	04-1045	Inner Tube
3	1	04-1020	Split Rim Wheel Assembly