



Failure Mode.

Report received. Leaking from front of Drifter. 3233Hrs

On disassembly found the front percussion seals distorted and worn which would have been the reason for removal.

The Drifter is in good condition for the hours completed however a number of wear parts require replacement.

HOUSING LIFE EXPECTANCY

Percussion Housing - No work required this service.

Gear Box Housing - No work required this service.

Spacer Assembly - No work required this service.

Flushing Housing - No work required this service.

Complete HL 1560 Rebuild Kit items include

All Seals, O-rings

Hydraulic Fitting Kits, Fasteners Kits, Bearing Kits, Diaphragms, Valves and Rubber Caps.

All Machining required highlighted in GREEN

All Parts for recommended replacement highlighted in RED

All Parts highlighted in Blue Not with Machine NWM

INSPECTION AREA		COMMENTS
Flushing Housing	(303 730 88)	Serviceable Reuse
Front Cover Assembly	(154 035 58)	Swapped from BO45031
Bushing	(550 063 74)	Swapped from BO45031 (new on that rebuild)
Seal Housing	(550 063 73)	Machining Required (Repair Oring seat Ph. 2)
Connection Flange	(154 148 78)	Serviceable Reuse
Shank Bushing	(550 358 24)	Machining Required (Skim Ph. 3)
Coupling Piece	(550 347 96)	Replace (Ph. 4)
Rotation Bushing	(550 350 50)	Replace (Ph. 5)
Rotation Bushing Assembly	(550 348 41)	Serviceable Reuse
Drill Sleeve	(550 352 26)	Machining Required (Skim Ph. 6)
Tie Rod (4)	(550 379 11)	Serviceable Reuse
Nut (8)	(151 679 38)	Serviceable Reuse
Pin	(154 020 08)	Machining Required (Polish)
Idler Wheel Assembly	(150 620 38)	Serviceable Reuse.
Slide Ring (2)	(150 609 68)	Serviceable Reuse
Distributor	(153 603 28)	Replace (Ph. 7)
Rear Cylinder	(550 373 97)	Machining Required (Polishing Ph. 8)
Hydraulic Motor OMT 500	(154 044 38)	Serviceable Reuse, some wear evident (Ph. 9)
Housing	(303 737 78)	Machining Required (Skim Ph. 10)
Lock Nut	(514 015 60)	Serviceable Reuse
Lock Washer	(514 411 60)	Replace, Standard Servicing (included in Rebuild Kit)
Circlip	(800 957 69)	Serviceable Reuse
Cover	(154 023 98)	Serviceable Reuse
Rotation Shaft	(302 827 88)	Machining Required (Polishing)
Thrust	(150 613 08)	Serviceable Reuse
Impact Piston	(302 947 28)	Machining Required (Polish, skim 11, 12)
Body Cylinder	(550 365 35)	Serviceable Reuse
Spacer Assy	(550 358 96)	Serviceable Reuse
Ring	(550 351 52)	Machining Required (Polishing)
Spring Pin	(801 849 99)	Serviceable Reuse
Bushing	(550 350 52)	Replace (Ph. 13)
Bushing	(550 350 51)	Replace (Ph. 14)
Low Pressure Accumulator Assy (2)	(154 046 98)	Serviceable Reuse
High Pressure Accumulator Assy (2)	(154 045 68)	Serviceable Reuse
Stabiliser Piston	(550 354 19)	Machining Required (Polish)
Bushing	(550 350 49)	Replace (Ph. 15)
Stabiliser Piston	(550 348 12)	Machining Required (Polish)



HL1560 Rock Drill Failure Analysis Report

Job No - Q16465

Serial No - BO 45 104

Requires Machining

Recommended Replacement

Hours Achieved - 3233

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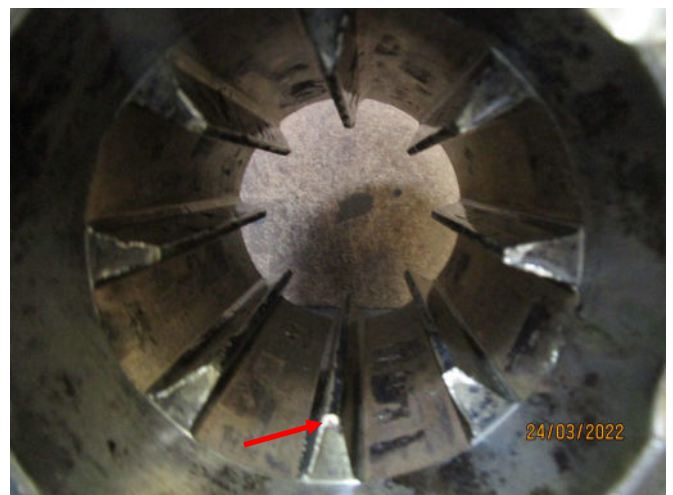
Ph. 1 - Front percussion seals - Cause of failure out.



Ph. 2 - Seal Housing - Weld and rebores Oring seat.



Ph. 3 - Shank Bushing - Skim.



Ph. 4 - Coupling - Worn to replacement.



Ph. 5 - Rotation Bushing - Replace.



Ph. 6 - Drill sleeve - Skim.



Ph. 7 - Distributor - Replace, deep cavitation.



Ph. 8 - Rear Cylinder - Polish, light cavitation.



Ph. 9 - Rotation Motor - Wear evident, acceptable for re-use.



Ph. 10 - Housing - Skim



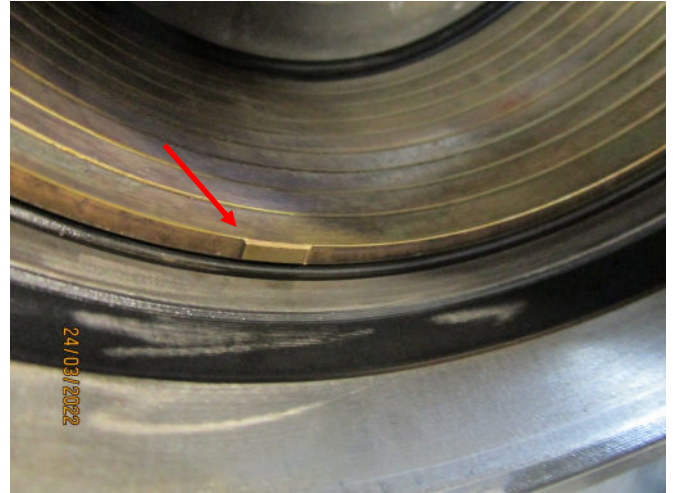
Ph. 11 - Impact Piston - Polish.



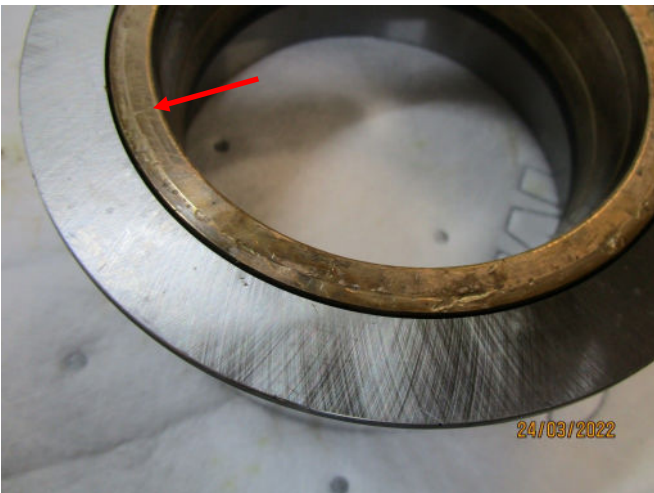
Ph. 12 - Impact Piston - Skim.



Ph. 13 - Bushing - Replace.



Ph. 14 - Bushing - Replace.



Ph. 15 - Bushing - Replace.



Ph. 16 - Bushing - Replace.



Ph. 17 - Bushing - Replace.



Ph. 18 - Bushing - Replace.

Mangelsdorf Engineering PL

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Tel 08 9093 2972
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**QUOTATION
Date**

16465
25/03/2022

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Item	Our Ref	CPN/Description	Drawing No.	Issue	Quantity	Unit Price
1	HL 1560 REBUILD KIT	HL 1560 Complete Rebuild Kit			1	2714.00
2	SAND BLAST	Sand Blasting			1	130.00
3	SUNDRY	OIL/ENVIROMENT	SUNDRY		1	182.00
4	LABOUR	LABOUR DRIFTER REBUILD	LABOUR		1	2500.00
5	MACHINING	MACHINING MACHINING DRIFTER PARTS			1	2031.00
6	550 350 50	Bearing Bushing			1	422.00
7	153 603 28	HL 1010/1500 Distributor			1	3325.00
8	550 350 52	Bush	55035052		1	511.00
9	550 350 51	Bushing	55035051		1	491.00
10	550 350 49	Bearing Bush	55035049		1	363.00

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Item	Our Ref	CPN/Description	Drawing No.	Issue	Quantity	Unit Price
11	550 350 48	Bearing Bush	55035048		1	412.00
12	150 116 58	HL 1500/1560 Front Cylinder Bush			1	512.30
13	550 521 62	Bearing			1	661.20
14	550 190 07	Flushing Head seal kit D65	55019007		1	306.20
					Total	14560.70

THE ABOVE COSTINGS REMAIN EFFECTIVE FOR THIRTY DAYS FROM THE DATE OF QUOTATION. QUOTE IS EXCLUSIVE OF GST. IF YOU HAVE ANY QUERIES, PLEASE DO NOT HESITATE TO CONTACT THE UNDERSIGNED.

Yours sincerely,