



Issuing Entity:
Dartron Industries, Inc
P. O. Box 13114
Salem, Oregon 97309
Phone: 503-362-2341
Fax: 503-362-2536

www.dartronrides.com

Bulletin # 936
Release Date: 11-13-1996
Effective Date: 11-13-1996
Supercedes: None
Completion Date: _____
 Page 1 of 4

PRODUCT IMPROVEMENT BULLETIN

Ride Manufacturer: Dartron Industries, Inc.	Affected Production Dates: All
Ride Name: 28' Slide	Affected Serial #'s All before 602091-5A
Model #	

Abstract of Issue: Super Slide 28" Lift Bar Reinforcement and Installation of Cross-Port Relief Valve.

Reason for release: If pins are not removed and an attempt is made to lift the center section with the hydraulic cylinders the lift bars may become bent or distorted. This can also happen while lowering the center section. To avoid this possibility Dartron recommends that the lift bars be reinforced and that cross-port relief valves be installed.

Action to be taken: The two lift bars that lift the center section of the slide can be reinforced so they become much more difficult to bend. Once they are reinforced Dartron recommends the installation of cross-port relief valves. When pressure in the lift cylinders reaches a pre-set level the relief ports open and pressure is returned to the fluid reservoir.

Detail of issue:

Parts required: See attached drawings.

Directions:

- > Reinforce the two lift bars in accordance with drawing # 2751 attached.
- > Install cross port relief valve in accordance with drawing # 2751 attached and the following instructions:
 - Valve location:** See attached sketch a. An exact location is not required. Just make sure hose attachments and valve adjustment is accessible. This is typical for both the middle section and upper section hydraulic cylinders.
 1. Drill and tap holes 5/16"-8 at desired location of valve.
 2. Mount valve using 5/16"-8 x 2 lg. grade 5 bolts with lock washers.
 - Valve Plumbing:** Remove inlet and outlet hydraulic hoses from flow dividers and attached to cross-port relief valve. Using the supplied hoses, connect cross-port relief valve to inlet and outlet flow dividers.

Dartron

Issuing Entity:
Dartron Industries, Inc

P. O. Box 13114
Salem, Oregon 97309
Phone: 503-362-2341
Fax: 503-362-2536

www.dartronrides.com

Bulletin # 936

Release Date: 11-13-1996

Effective Date: 11-13-1996

Supersedes: None

Completion Date:

Page 2 of 4

PRODUCT IMPROVEMENT BULLETIN

Ride Manufacturer: Dartron Industries, Inc.	Affected Production Dates: All
Ride Name: 28' Slide	Affected Serial #'s All before 602091-5A
Model #	

Pressure Adjustment: To adjust the pressure turn the adjusting screw all the way out until it by passes, (the slide frame won't move). Then turn it back until the frame will move without acting sluggish. Each pair of cylinders should be adjusted at the extreme ends of their stroke. This will provide the minimum pressure required to move the frame adequately.

Pressure Settings:

Middle frame cylinder

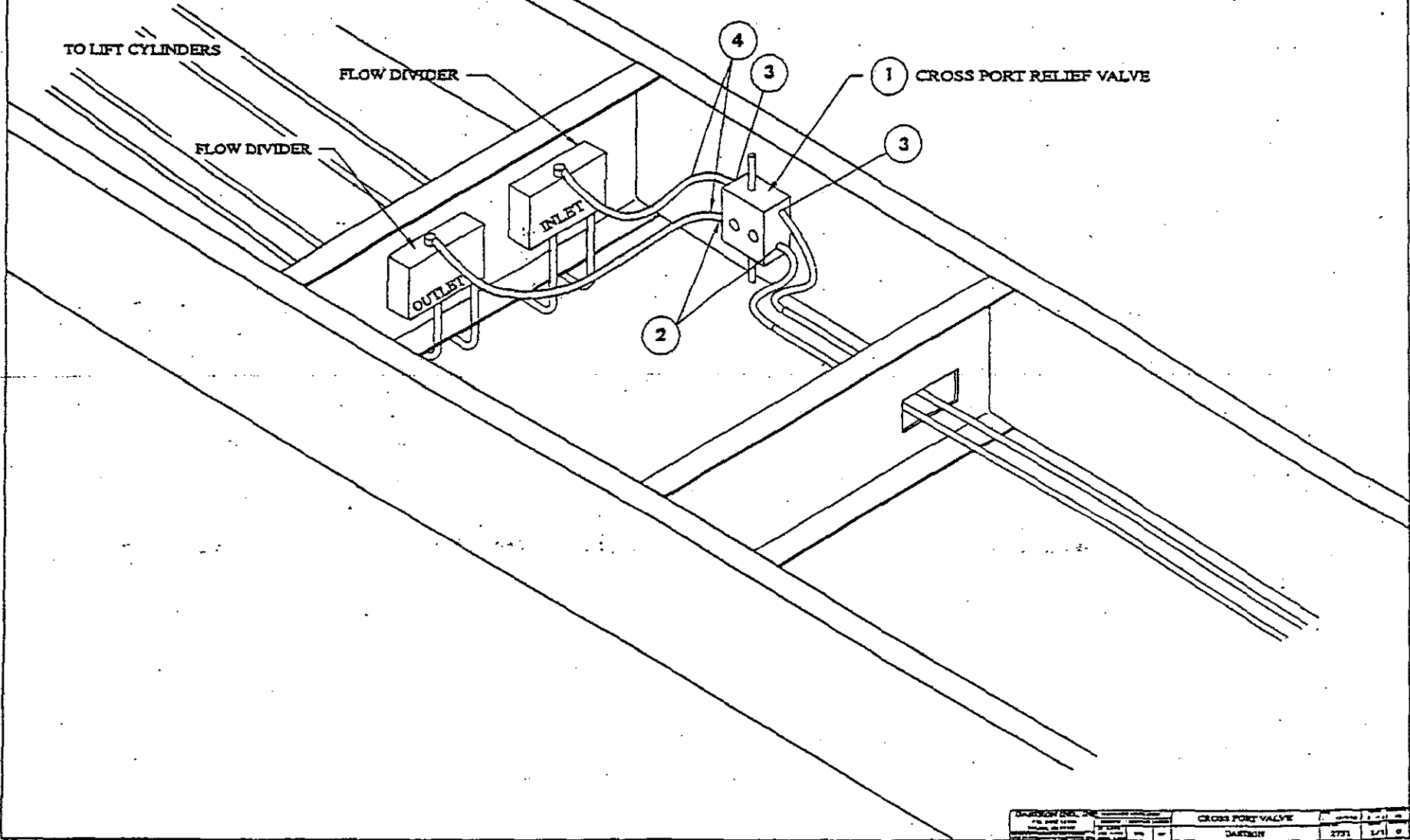
- > Lifting pressure-800 lbs.
- > Down pressure-700 lbs.

Upper frame cylinder

- > Lifting pressure-1200 lbs.
- > Down pressure- 800 lbs.

*MIDDLE SECTION VALVING SHOWN

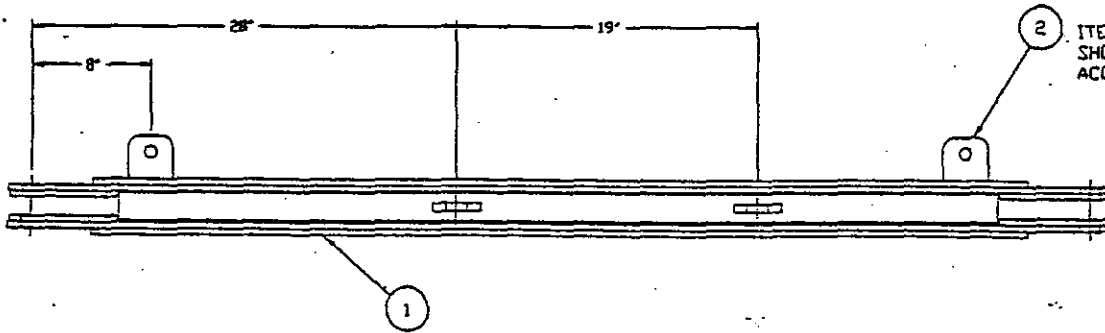
1	CROSS PORT RELIEF VALVE
2	STANDARD 4 PORT VALVE X 1/2" O-RING
3	90 FITTING - 1/2" O-RING
4	HOSE FITTING X 1/2" X 1/4" L.O.
5	SHOCK STRAP - 1/2" X 1/4" L.O. GRADUATED
6	LOCKWASHER 3/16"



DARTSON		CROSS PORT VALVE	
DATE	REV	DATE	REV

NOTE LOCATE ITEM 2
FOR LEFT & RIGHT LIFT BAR
(LEFT LIFT BAR SHOWN)

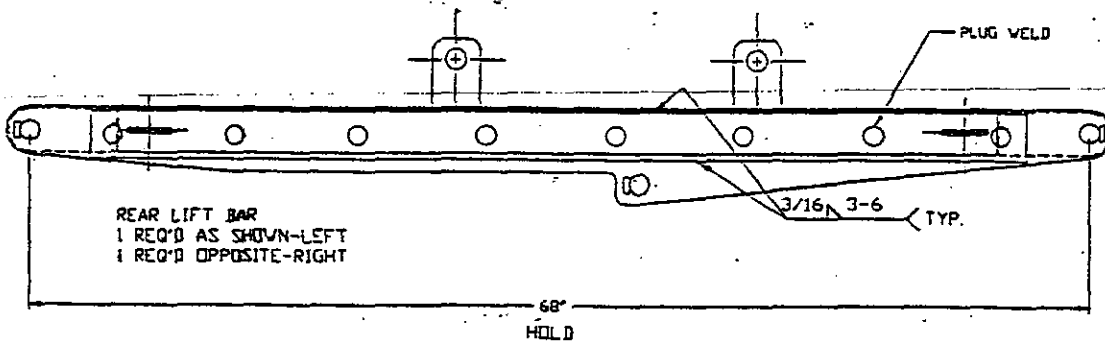
ITEM	QTY	DESCRIPTION
1	2	3/8" F.B. 3" X 60" LG.
2	4	3/8" PLATE 3" X 2 5/8" LG.



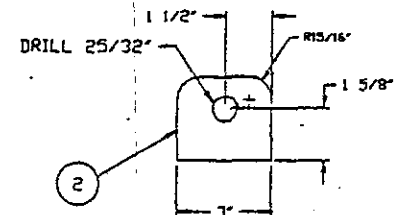
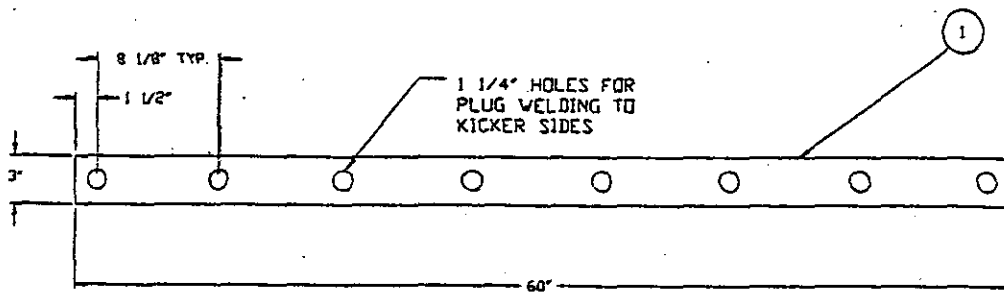
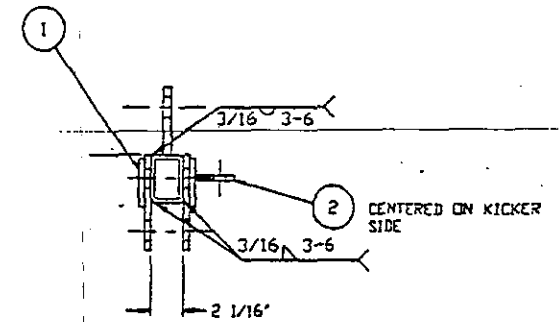
ITEM 2 HAS BEEN
SHORTENED 3/8" TO
ACCOMMODATE ITEM 1

* LIFT BAR REINFORCEMENT

- STEP 1: REMOVE ITEM 2 FROM SIDE OF LIFT BAR
- STEP 2: STRAIGHTEN LIFT BAR IF NEEDED
- STEP 3: POSITION ITEM 1 CENTERED ON BOTH SIDES OF LIFT BAR. THEN STITCH WELD AND PLUG WELD.
- STEP 4: LOCATE AND WELD ITEM 2 TO SIDE OF LIFT BAR.



REAR LIFT BAR
1 REQ'D AS SHOWN-LEFT
1 REQ'D OPPOSITE-RIGHT



DARTRON INC. P.O. BOX 1234 SALEM, OR 97309 SEE INSTRUCTIONS FOR PROPER USE P.L. or trademark of Dartron Inc.	UNLESS OTHERWISE NOTED		LIFT BARS	PART NO.	REV.	DATE
	REVISIONS	FUNCTIONS/CHANGES				
			DARTRON	2751	1/1	0