

# Hydra Bed Modification History



DRAWING NO. 10-0904 F

10/29/2013

| Date                | Serial Number                        | Subject                   | Description of Change   |
|---------------------|--------------------------------------|---------------------------|---|
| After first 12 beds |                                      | Control Valve             | Switched from Gresen SP Series to Brand TS Series valve   |
| Early 1985          |                                      | Bed Design                | Switched to new style beds. Arms are along side of bed instead of in pockets on top of bed.   |
| 1986                |                                      | Control Valve             | Switched from Brand TS Series valve to Gresen V-15 Series valve.  |
| March 1989          |                                      | Hydraulic Pump            | Switched from Muncie (red colored) pump to Tyrone (black or unpainted) pump.  |
| June 1989           | 89162                                | Headache Rack             | Added gussets where the perimeter tubing of the headache rack attaches to the bed floor.  |
| Early 1990          |                                      | Hydraulic Cylinders       | Switched from Cessna cylinders to Energy cylinders. (See page 10 of dealer manual for serial numbers.)  |
| February 1992       | 92152                                | Spinner Shaft             | Switched from 1" to 1-1/8" bushings in the arms and spinner shafts.   |
| March 1992          | 92198                                | Hydraulic Cylinders       | Switched from 8" stroke arm cylinders to 6" stroke cylinders.   |
| March 1992          | 92199                                | Control Valve             | Switched from mono-block Gresen V-15 Series to the sectional Brand Valve.   |
| 1993                | <a href="#">93602-93613</a>          | Triple C production start | Triple C "TC" started production along with McClain "Mc"  |
| August 1998         |                                      | Bed Design                | Developed the new "150 Series" beds and named the existing bed design the "100 Series".   |
| August 1998         | 98101-98147 (Mc)<br>98500-98636 (TC) | Bed Design                | Redesigned Hydra Bed as follows:  |
|                     |                                      | Linkage Plates            | Switched from 1/2" plate to 5/8" plate.   |
|                     |                                      | Linkage Bar               | Switched from 1" thick to 1-1/4" thick.   |
|                     |                                      | Main Cyl base lug         | Switched from 1" thick to 1-1/4" thick.   |
|                     |                                      | Arm plates                | Redesigned to eliminate arm stop bolts.   |
|                     |                                      | Main Hinge Plate          | Switched from two piece, fabricated plate and bushing to a one piece, flame cut and drilled, 1-1/2" thick steel side plate.                     |
|                     |                                      | Headache Rack             | Switched from 2x2 square tube to 3x2 rectangle tube.  |
|                     |                                      | Clearance Lights          | Added amber clearance lights on front corners in headache rack and red clearance lights on the ends of tail light housings.                     |
|                     |                                      | Tail Light Housing        | Switched from 6x2 rectangle tube to 7x3 rectangle tube and added 4" in length to accommodate clearance lights.                                  |
|                     |                                      | Quick Couplers            | Switched from collar style quick couplers to push-to-connect style quick couplers.  |
|                     |                                      |                           | Designed a bracket to mount the quick couplers, trailer plug and license plate. The bracket now equips all Hydra Beds for 3-spool valve option. |
|                     |                                      | Arms                      | Redesigned arm tails to allow more clearance in arm sockets.  |
|                     |                                      | 5th Wheel Ball            | Added safety chain attachments in 5th wheel well.   |
| September 1998      | 98101-98151 (Mc)<br>98500-98644 (TC) | Arm Bolts                 | Switched from hex head bolt to special round head, square neck bolt with special thread length.   |
| November 1998       | 98715                                | Reservoir                 | Redesigned reservoir to have a full length baffle to eliminate hydraulic fluid from splashing out of filler neck.                               |
| June 1999           | 99613                                | Arms                      | Switched from 2-7/8" long pin to 3-3/8" long pin for the cylinder rod end connecting pin on the 150 Series beds.                                |

# Hydra Bed Modification History



DRAWING NO. 10-0904 F

10/29/2013

| Date           | Serial Number                             | Subject                        | Description of Change   |
|----------------|---|--------------------------------|---|
| August 1999    | 99101-99135 (Mc)<br>99500-99XXX (TC)      | Wiring                         | Added edge protection to headache rack to protect clearance light wire, drivers' side.  |
| September 1999 |   | Reservoir                      | Added magnet to each end to collect metal particles.  |
| September 1999 | 99753                                     | Main Lift Cylinder             | Increased base end lugs to 3/4" thick material and pin length to 3-3/4" (P/N RE PN-1X375).  |
| July 2000      | 100101-100120 (Mc)<br>100401-100586 (TC)  | Roller Sleeves                 | Added machined roller sleeve to the RA100rr rollers on the main lift cylinder to protect and eliminate damage to rollers.   |
| July 2000      | 100101-100121 (Mc)<br>100401-100598 (TC)  | Main Hinge                     | Switched to Nitrotec Bar material, coated bar stock.  |
| April 2001     | 101101-101117 (Mc)<br>101401-101564 (TC)  | Arm Bolt                       | Added grease zerk to arm bolt bushing to enable greasing of arm pivot point (100 Series only).<br>Redesigned arm tail to obtain 41" grip on 150 Series and added grease zerk. |
| April 2001     | 101566 (TC)                               | Arm Bolt                       | (EXCEPTION) HB250 with old style arms. Sold to Swinford Trailer.  |
| May 2001       | 101101-101121 (Mc)<br>101401-101605 (TC)  | Gooseneck Well                 | Moved front tube 5/16" forward to gain more space in front of ball. Moved drivers side tube of main lift cylinder 5/16" to the left to gain more clearance for cylinder lug.  |
| May 2001       | 101101-1011XX (Mc)<br>101401-101610 (TC)  | Gooseneck Hitch                | Moved ball rearward 1" to gain more clearance between ball and front tube.  |
| June 2001      | 101101-101622 (Mc)<br>101401-101631 (TC)  | Main Hinge                     | Added 2nd grease zerk to main hinge bushing to provide more uniform greasing of hinge.  |
| October 2001   | 101101-101135 (Mc)<br>101401-101848 (TC)  | Underbody Toolbox Mounts       | Replaced front FI 1/4x4 with FI 1/4x5 and added slots. Added brackets to the first cross tube to hang the rear of the toolbox.  |
| December 2001  | 101914                                    | Gooseneck Door & Cylinder Door | Redesigned to eliminate hinges on top surface.  |
| April 2002     | 102101-102109 (Mc)<br>102301-102464 (TC)  | Gooseneck Hitch                | Added gussets to the stiffner bar and flange of channel iron at the cylinder lug location.  |
| August 2002    | 102101-102114 (Mc)<br>102301-102579 (TC)  | Control Valve                  | Switched from Brand sectional valve to Husco sectional valve.   |
| August 2002    | 102581 (TC)                               | Control Valve                  | HB100 sold to Hensley Trailers has old style valve  |
| July 2003      | 103101-103109 (Mc)<br>103301-103443 (TC)  | Arm Cylinders                  | Switched from Energy arm cylinders to Green Mfg cylinders   |
| July 2003      | 103445 (TC)                               | Arm Cylinders                  | HB100 has Energy arm cylinders  |
| August 2003    | 103101-103110 (Mc)<br>103301-103474 (TC)  | Lift Cylinder                  | Switched from Energy lift cylinder to Green Mfg cylinder  |
| August 2003    | 103101-103110 (Mc)<br>103301-103488 (TC)  | Linkage Bar                    | Added hardened tension bushings to linkage bar.   |
| September 2003 | 103113 (Mc)<br>103509, 510, 516, 518 (TC) | Lights                         | Added 2nd tail light and identification lights. Redesigned QC bracket.  |
| September 2003 | 103113 (Mc)<br>103509, 510, 516, 518 (TC) | Quick Couplers                 | Redesigned QC bracket for low mount QC to prevent dirt and trash build up on QC.  |
| October 2003   | 103589 (TC)                               | Tail Light Wiring              | Started using Maxi-Seal Tail Light wire harness.  |

# Hydra Bed Modification History



DRAWING NO. 10-0904 F

10/29/2013

| Date           | Serial Number                 | Subject                         | Description of Change   |
|----------------|-------------------------------|---------------------------------|---|
| 2004           | <a href="#">104301-104972</a> | McClain production ended        | McClain "Mc" ended production and Triple C "TC" began doing all production  |
| February 2004  | 104405 (TC)                   | Main Hinge Bolt                 | Switched to 3/8x2-1/2 Grade 8 bolt and different locknut.   |
| July 2006      | 106437 (TC)                   | Bearing Pin                     | Switched from 1" Dia. 4142 CR pin to 1" Dia. Heat Treated Pin to reduce wear. This now has a Rockwell C scale hardness of 30. |
| September 2006 | 106561 (TC)                   | Hydraulic Cylinders             | Switched from Green Mfg cylinder's to Energy cylinder's   |
| November 2006  | 106xxx                        | HB XX5 beds                     | Created the HB305, H355, & HB555 beds due to Dodge cab/chassis rear fuel tank location.                                       |
|                |                               | HB3xx & HB55x                   | additional 3" in overall length   |
|                |                               | <a href="#">10" channel</a>     | additional hole was placed in 10" channel and all HBxx5 balls are placed in the rear hole                                     |
|                |                               | <a href="#">HBxx5</a>           | rear assemblies have 45° corners.   |
| July 2011      |                               | <a href="#">Rear asm. Block</a> | Rear assemble block FI 1-1/4x1-1/4 L 2-1/2 was welded incorrectly. Arms to ground distance was compromised.                   |
| February-12    | 112140                        | Valve plate for Solenoid        | Added hole in FP-PL-VA750 plate for bolting solenoid to plate with FP-VA-3SPOL LEG instead of using FP-PL-VA625               |
| July 2012      | 112530                        | <a href="#">Rear asm. Block</a> | Corrected block location to orginal location " see dwg # 10-1407 C for details  |
| Feb 2013       | 113141                        | Solenoid valve remote           | Revised Kar-tech remote control wiring on solenoid valve to match pendant 10-0905 B   |
| July 2013      | 113433                        | Linkage bar                     | Added 3/8" to the overall length of the 1-1/4" Linkage Bar  |
|                |                               |                                 |   |
|                |                               |                                 |   |
|                |                               |                                 |   |

