




HYDRA BED MODIFICATION HISTORY

Revised September 8, 2021

CLASSIC	DATE	SERIAL #	SUBJECT	DESCRIPTION OF CHANGES
	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	93602-93613	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) 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	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.
			5th Wheel Ball	Added safety chain attachments in 5th wheel well.
	September 1998	98101-98151 (Mc) 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.
	August 1999	99101-99135 (Mc) 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) 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) 100401-100598 (TC)	Main Hinge	Switched to Nitrotec Bar material, coated bar stock.
	April 2001	101101-101117 (Mc) 101401-101564 (TC)	Arm Bolt	Added grease zerk to arm bolt bushing to enable greasing of arm pivot point (100 Series only).
				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.

CLASSIC	May 2001	101101-101121 (Mc) 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) 101401-101610 (TC)	Gooseneck Hitch	Moved ball rearward 1" to gain more clearance between ball and front tube.
	June 2001	101101-101622 (Mc) 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) 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) 102301-102464 (TC)	Gooseneck Hitch	Added gussets to the stiffener bar and flange of channel iron at the cylinder lug location.
	August 2002	102101-102114 (Mc) 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) 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) 103301-103474 (TC)	Lift Cylinder	Switched from Energy lift cylinder to Green Mfg cylinder.
	August 2003	103101-103110 (Mc) 103301-103488 (TC)	Linkage Bar	Added hardened tension bushings to linkage bar.
	September 2003	103113 (Mc) • 103509, 510, 516, 518 (TC)	Lights	Added 2nd tail light and identification lights. Redesigned QC bracket.
	September 2003	103113 (Mc) • 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.
	2004	104301-104972	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
			10" channel	additional hole was placed in 10" channel and all HBxx5 balls are placed in the rear hole
			HBxx5	rear assemblies have 45° corners.
	July 2011		Rear asm. Block	Rear assemble block FI 1-1/4x1-1/4 L 2-1/2 was welded incorrectly. Arms to ground distance was compromised.
	February 2012	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	Rear asm. Block	Corrected block location to original location " see DWG # 10-1407 C for details
	February 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
30 SERIES	August 2013	313101	Bed Design - 30 Series	Redesigned Hydra Bed as follows:
			Stop/Turn/Tail Lights	LED standard; additional set mounted in headache rack
			Backup Lights	LED standard
			License Lights	LED standard
			Side Marker Lights	LED standard
			Headache Rack	Louvres replaced expanded metal rear window protection
			Arms	All models now constructed of 3-1/2 x 3-1/2 x 5/16" square tubing
			Rear Assembly Cover	New bolt-in design replaces welded in tread plate
			Flares	Welded flares standard on any 3X50 model instead of bolted
			Oil Reservoir	Bolt-in instead of welded
			Husco 5000 Series Valve O-rings	O-rings now Glass Filled Nylon
	March 2014	314293	Tension Bar	Added tension bar to rear assembly
	June 2014	314387-314399	Arm Cylinders	Switched from Energy to Carlson
	June 2014	314400-314753	Main Lift Cylinders	Switched from Energy to Carlson
	June 2014		A mount pumps	Replaced PU-P16 45C 9D6 with PU-P16 65C 9D6
	June 2014	314412	Rear Assembly block	Replaced FP-LP-BLOCK-100 for ST-FI-1x1-1/4 L2-1/2
	August 2014	314515	Headache Rack	Changed tubing to 4x2x3/16 from 11ga.
	October 2014	314754-314933	Cylinders	Switched from Carlson to Energy

30 SERIES	December 2014	314934-315524	Cylinders	Switched from Energy to Carlson
	May 2015	315525-315725	Cylinders	Switched from Carlson to Energy
	July 2015	315726	Cylinders	Switched from Energy to Carlson
	July 2016	3160292	Rear Assembly Cover Plate	Changed from bolt on cover to 3/8" welded plate
	July 2016	3160292	Receiver Hitch	Receiver Hitch became standard on all beds
	July 2016	3160292	Paint	Went to a 2 part urethane paint and primer
	July 2016	3160292	Tag Bracket + Drop Hitch Filler Sheet	Revised tag bracket and added drop hitch filler sheet
	August 2016	3160326	Bearing Pin	Changed pin from heat treated to chrome plated
	August 2016	3160371	Linkage Bar	Powder coated gray linkage bar
	August 2016	3160371	Linkage Bar Bushings	Changed from tension bushing to a DU Bushing
	October 2016	3160619	Valve Actuator Cable Hole Location	Changed valve actuator cable hole location in LT frame rail
	November 2016	3160625	Valve Plate	Changed valve plate to accommodate manual override option
	November 2016	3160625	Manual Override Rod Hole	Added hole in side rail for optional manual override control rod
	December 2016	3160702	Manual Override Pump Switch Hole	Added hole in side rail for manual override pump switch
	6/1/2017	3170297	Arm Cylinders	Switched from Carlson arm cylinders to Energy
	6/20/2017	3170330	Lift Cylinders	Switched from Carlson main lift cylinders to Energy
	6/22/2017	317343-317366	Oil reservoir	Suction and return ports were switch around
		317368-317381		
		317386-317389		
	7/18/2017	3170380	Valve plate	Change valve plate to old style to use bolt-on manual override
 2017 Rebrand	8/14/2017	3170422	Reservoir Fill Cap	Change to screw on Reservoir fill cap MI-BREATHER-17HB
	8/14/2017	3170382	Decals & Mudflaps	New Decals and Mudflaps - 2017 Rebrand
	12/19/2017	3170696	Oil reservoir	Change oil reservoir to 4" rectangular tube
	11/16/2018	3180633	Hinge Pin	Change from Nitro pins to Tricom coated pins
	2/11/2020	3200100	Valve mount bolts	Change to longer bolts to accommodate HydraSTX mount plate
	12/30/2020	3210001	Servo Bar Handle	Change Valve Bar Handle to accommodate HydraSTX
	September 2021	3210723	Main Lift Cylinder	Switched from Energy to Bailey ML Only