



Packaged Gas Division

Technical Service Bulletin

Orca Delivery Assist Cracks

Date: January 4, 2019

TSB-MBS-1025

Issue: Retention brackets and tank support structure weld breakage on Chart Orca™ MicroBulk delivery assist systems. Road vibration and shock loads seen in over the road vehicles are exceeding the original design.

Models Affected: All Chart Orca models with a delivery assist system (Truck or Trailer Mounted).

Description: Material fatigue in retention areas of the delivery assist tank structure develops over time, causing weld breakage and component breakage. In our continuous improvement of the products we sell, we have developed a more robust tank-to-frame retention method along with an updated frame structure design.



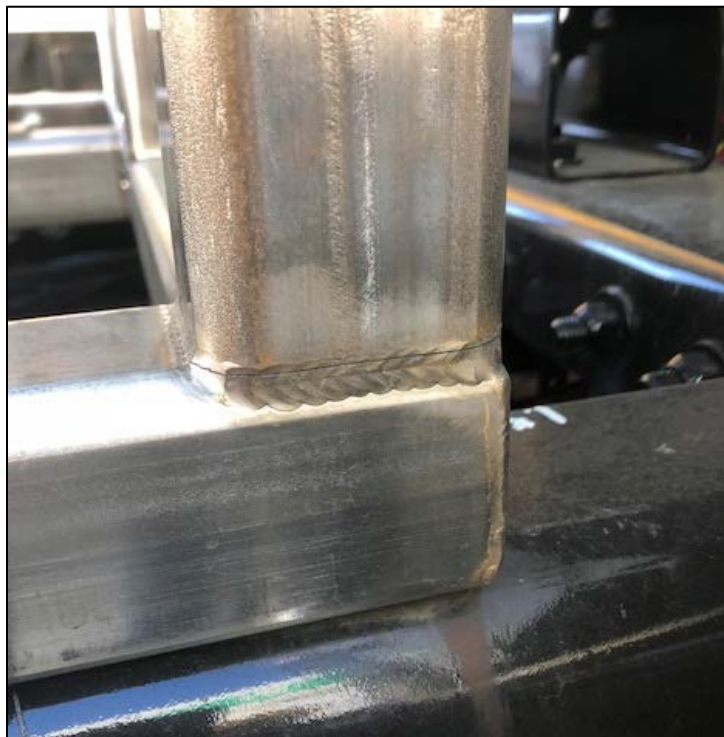
In the above image, the silver tank between the truck cab and white tank is the Delivery Assist Tank and Frame



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Tank to frame breakages



Frame weld breakages



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Action Required:

1. Review of all Orcas equipped with a delivery assist system. Review mounting hardware and check for tightness. See TSB-MBS-1018 for further details on Orca Delivery Assist Mounting Hardware technical service bulletin.
2. If mounting hardware is found to be loose, discontinue use of Orca and replace with updated hardware kit immediately. Contact Chart for hardware kit (21261149).
3. Inspect tank support areas daily for breakage on all four sides of stainless-steel frame structure in the image below.



Daily pre-trip visual inspection points



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Tank to frame breakage example



Frame weld breakages example



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4. If crack is noticed, take out of service for weld repair. Contact Chart for delivery assist frame reinforcement kit (21348715).



Installed frame reinforcement gusset and tamper indicating paste example



Installed frame reinforcement gusset example



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Dates of Implementation:

For all systems shipped between 6/1/17 to 11/1/18, reinforcement kit is strongly recommended

All systems shipped after 1/1/19 are to have the updated delivery assist frame structure and tank to frame mounting.

Chart continuously strives to meet customer expectations in a number of different areas. This technical service bulletin (TSB) is distributed to customers in order to communicate technical issues about our products that may need immediate attention. If you have concerns or questions relative to this TSB, please contact your Chart customer service representative at (800) 400-4683. Thank you for depending on Chart to provide your company with high quality products and service.