SERVICE BULLETIN NZ SB130

To: Snorkel Service Dealers

Attention: Service Manager

Units affected: SRT2670 & SR2770, built before August 2005

MANDATORY INSPECTION & UPGRADE

This Bulletin is to inform you of an Inspection and field modification that is required on all SRT2670 & SR2770 machines built before August 2005.
Insepct all of the centre pivot bosses on the scissor arms for evidence of cracking.

During Insection the following points should be noted -

1. **Check the scissor arm for bending. The usual cause of bending is lowering a load in excess of the SWL and stopping before the scissor is fully lowered.**
2. **Check the arms for obstructions, bent cylinder and crushed hoses/cables.**
3. **Check the Platform slider bar under the deck for damage/obstructions.**
4. **Check the Chassis sliders for damage/obstructions and or worn slide pads.**
5. **If the cracks in the arm carry on into the outer edge of the arm, the arm MUST be replaced.**

Where cracks are found around the centre boss of an SRT Scissor arm the machine should be removed from service and the following weld repair procedure carried out.

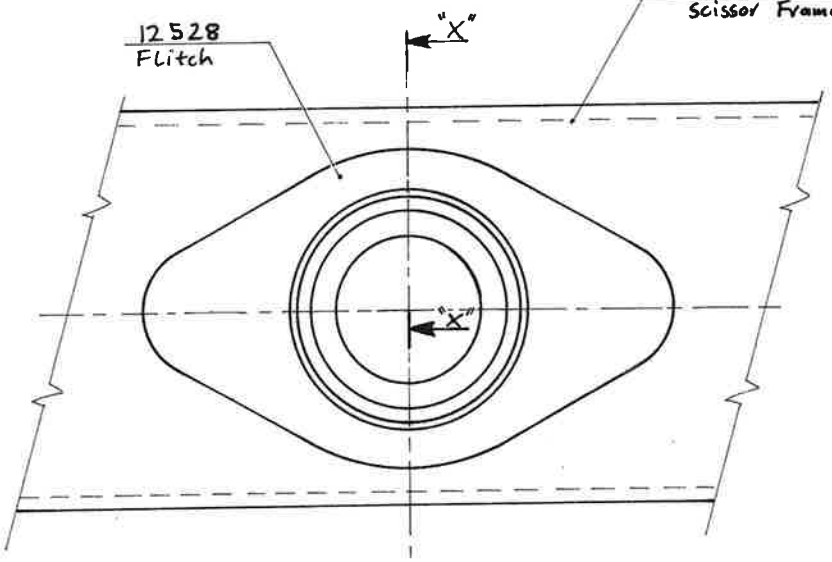
Procedure:

Remove the arm from the stack .
Grind out any cracks around the boss in a "V" groove.
Weld the groove [refer to attached drawing for weld spec].
If the Cracks appear in Scissor stage 2 or 3 [from the bottom] add the flitch plate as per the attached drawings/procedure.

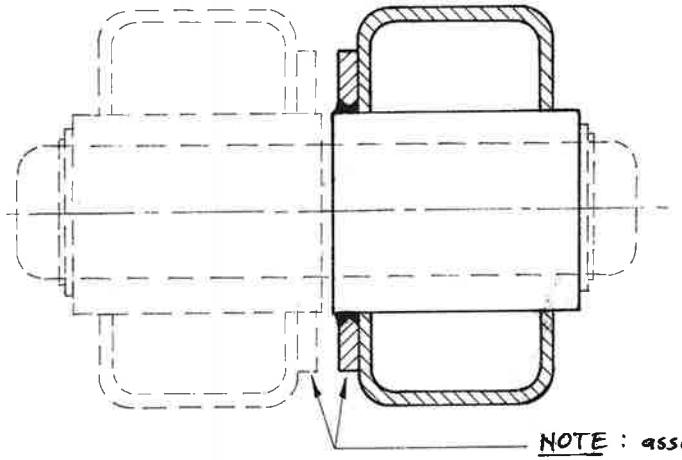
IMPORTANT
Only add the Flitch plate to Scissor Stage 2 & 3, [there is a total of 8 Flitch plates per machine].
Use a Ticketed [qualified] Welder to carry out the repairs.
Ensure that all of the Scissor arms are inspected thoroughly for any evidence of cracking.

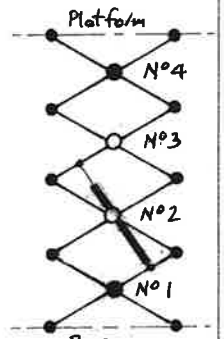
12528 sht 2/2

CH No	LET	DATE	CHANGE
05-04	A	19 Jul 05	New Release (Produn/Service upgrade)



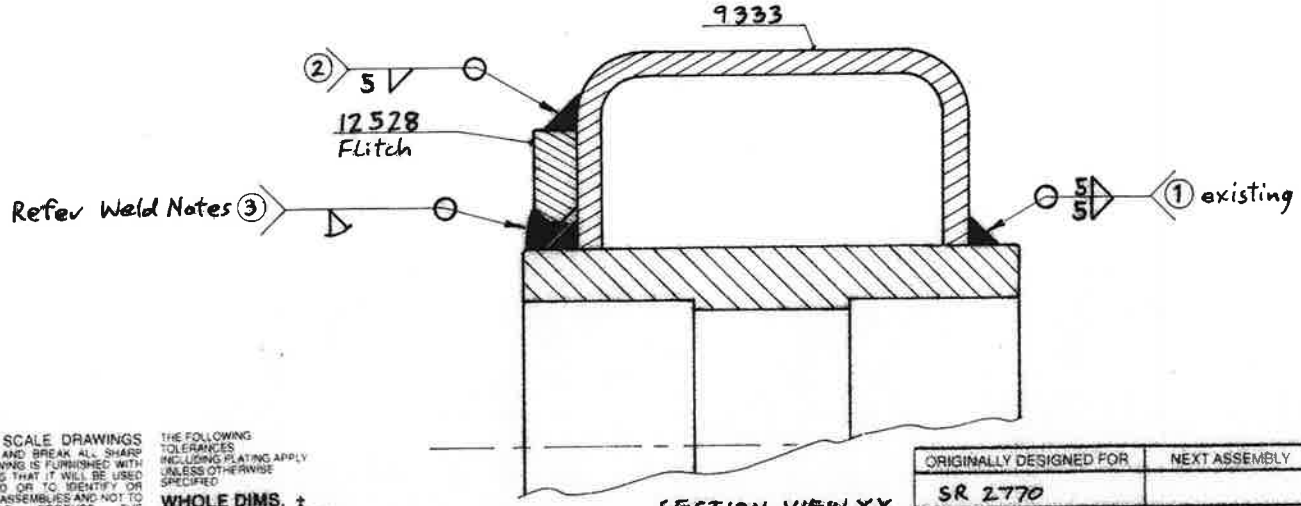
Scissor Arm 9333 Qty 4
Scissor Frames 9332 Qty 1
9465 Qty 1
} per M/C





SCISSOR SCHEMATIC

NOTE : assembled with flitch reinforced faces adjacent, at N°2 & N°3 centre pivots



SECTION VIEW XX
Scale 1:1

WELD NOTES : Fit flitch plate over boss. Grind back any high spots on existing boss weld (1), if necessary, to provide close and centralized fitup.
Tack flitch at periphery, (weld posn. (2))
Weld all round flitch hole, (weld posn. (3),) fusing to boss and existing boss weld.
Complete peripheral fillet weld 2
Check that weld (3) does not have buildup projecting beyond boss end. Grind back if neccessary

NOTE DO NOT SCALE DRAWINGS
REMOVE ALL BURS AND BREAK ALL SHARP CORNERS THIS DRAWING IS FURNISHED WITH THE UNDERSTANDING THAT IT WILL BE USED ONLY AS A RECORD OR TO IDENTIFY OR INSPECT PARTS AND ASSEMBLIES AND NOT TO MANUFACTURE OR PROCURE THE MANUFACTURE OF THE PARTS SHOWN ON THE PRINT EXCEPT FOR SNORKEL

THE FOLLOWING TOLERANCES INCLUDING PLATING APPLY UNLESS OTHERWISE SPECIFIED
WHOLE DIMS. ±
ONE DECIMAL DIMS. ±
TWO DECIMAL DIMS. ±

ALL DIMS. ARE IN mm U.O.S.

ORIGINALLY DESIGNED FOR		NEXT ASSEMBLY	
SR 2770			
DRAWN BY	DATE	CHECKED BY	DATE
[illegible]	18 Jul 05		

Snorkel

SCALE 1:2 & 1:1	FINISH Paint	
MATERIAL SPEC		STOCK SIZE
AWS E70 XX or E70S-6	+ Electrodes + MIG Wire	
PART NAME	DRAWING No	SHT / C.L
WELD & ASSEMBLY DETAIL	12528	2/2 A

MATERIAL USAGE
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