

TF Structural cracks in main boom levelling boss procedure

Doc. No. 245642-09

Date 10/02/17

Rev No.:	Date:	Author:	Description:
	10/2/17	A Danks	Original issue

Applicable Vehicles: All TF16M & TF17M

Issue Date: 10 February, 2017

Overview: This procedure outlines the actions required to repair a crack in the basket levelling cylinder mount in the main boom.

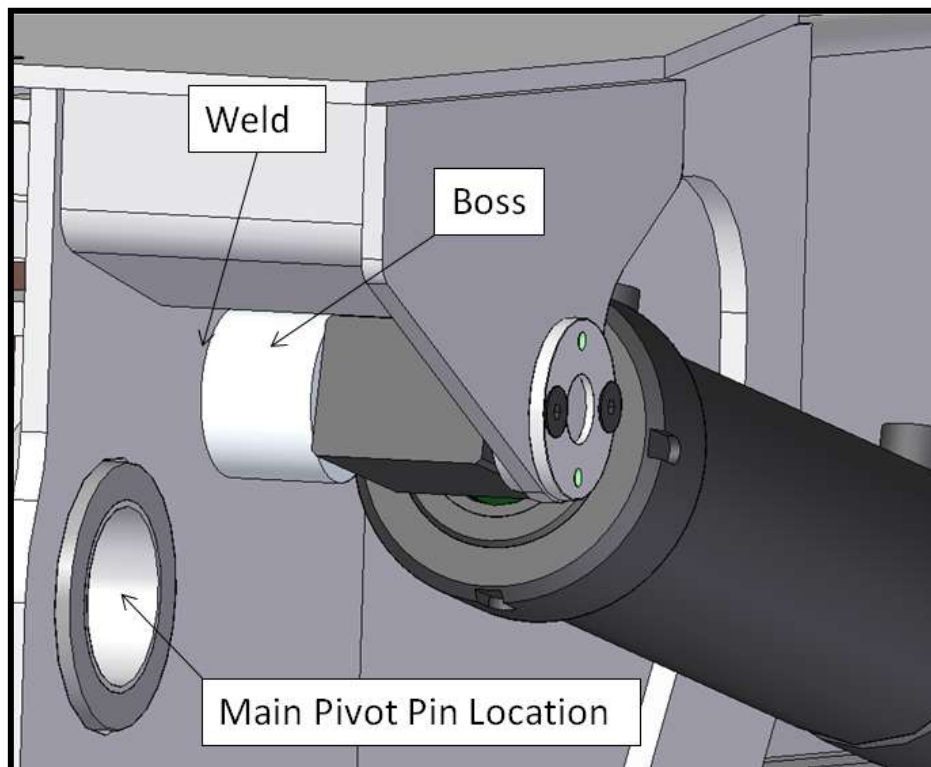
Ensure all of this work is carried out in a safe working environment. All work is to be carried out by a competent tradesperson.

Reference Document AS1554.1 section 5.8



INSPECTION PROCEDURE:

- Remove top cover.
- Visually inspect the boss for evidence of cracking between the boss and side plate. This can be indicated by rust in the crack.
- If cracking is evident, repair in accordance with the following repair procedure.
- If there is no evidence of cracking, monitor this area during the three month inspections.



REPAIR PROCEDURE:

Refer to the procedure below.

Overview: This procedure outlines the actions required to repair cracks on the main boom levelling cylinder, pivot boss connection.

Ensure all of this work is carried out in a safe working environment. All work is to be carried out by a competent tradesperson.

Equipment Required:

Safety glasses and relevant PPE,
Grinder and relevant welding equipment,
Paint for coating.

PROCEDURE:

Follow the proceeding instructions for directions for repairing the affected area:

1. A qualified welder needs to do the repair.
2. Prepare by cleaning and gouging with a thin die grinder to clean out the crack and grind no more than 0.5mm of the parent material.
3. Using S-6 type wire (ER70S-6 or similar) and suitable gas GMAW machine;
4. (MIG) weld re-instate the **6mm fillet weld**.
5. Consider the weld prep for an F1 joint specification (fillet weld with equal leg length and no root gap) as per AS1554.1 Table E3.
6. Ensure that even heat is distributed through the boss and plate to allow sufficient penetration.
7. Visually inspect the weld for a smooth profile, check that it is free of defects (i.e. undercut).
8. Touch up the uncoated steel with paint.

TEST

When the basket is in the stowed position and the main boom is on the boom rest, level the basket by following the basket levelling procedure that can be found on the turret. After the levelling procedure has been completed test the MEWP by raising the boom to full height and return to the rest checking that the basket remains level within 5°. After this test has been completed successfully the unit is ready to go back into service.

CUSTOMER ACTION REQUIRED:

MEWP owners must circulate this bulletin to all of their maintenance personnel.