

Service Bulletin : X Series Motor
Mount Weld

Reference: SBV 11.08

Date of Issue: 19th October 2011**Affected Machines: Snorkel / Upright X26N, X26, X32****Serial Numbers:**
X26N 51172 to 51200
X26 53251
X32 53250**MANDATORY MACHINE INSPECTION AND WELD REPAIR TO BE CARRIED OUT
IMMEDIATELY**

Purpose: A problem has been identified which affects a number of Snorkel / Upright X Series electric scissor lifts.

A quantity of left and right hand drive wheel motor mounting fabrications have been manufactured by our supplier with a structural weld fillet missing. The main steering spindle (Kingpin) must be welded to the top of the motor mount plate and this weld fillet has been omitted as shown below.

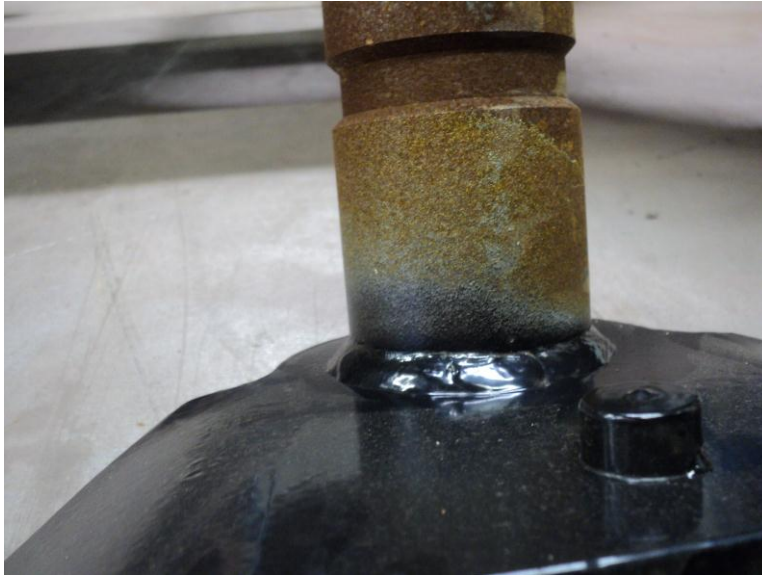


Action: It is mandatory that the X Series machines identified in the serial range above must be inspected upon receipt of this bulletin to confirm whether the weld fillet indicated is missing.

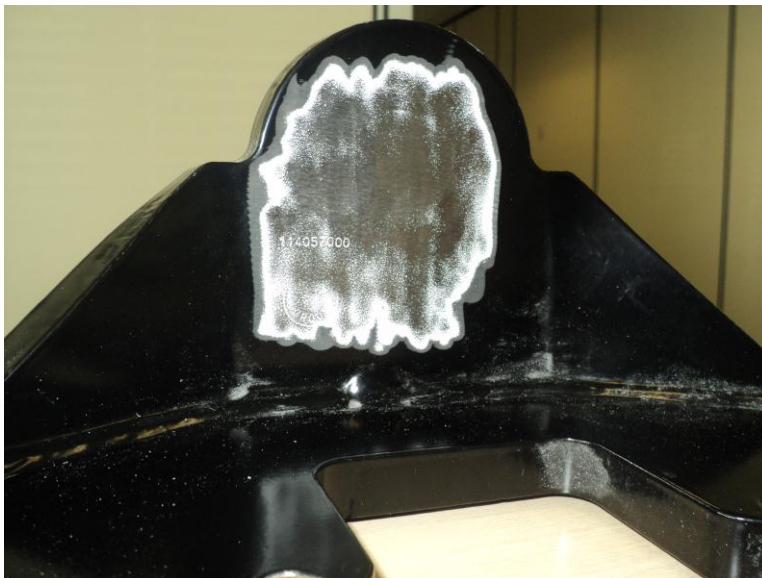
If this is the case then the machines must be removed from service immediately and not returned to service until a weld repair has been carried out.

Procedure: The field repair involves the following actions:

1. Place the machine on a firm, flat, level surface with the battery disconnected in the off position
2. Raise the front of the machine to a suitable height (approx. 200mm) to enable the motor mount fabrications to be removed and adequately support the machine for the duration of the activity
3. Remove both of the front drive wheels and disconnect the steering linkages from the motor mount plates
4. Remove the drive motors and support them to minimise stress on the hose connections
5. Whilst adequately supporting the motor mount remove the retaining bolt to allow the steering spindle /motor mount plate to disengage from the chassis steering bosses.
6. Use a needle hammer and/or a sander to remove the paint along the joint between the steering pivot and the motor mount plate. Only sand enough to prepare the area to be welded
7. The weld repair should only be carried out by a competent certified weld operator
8. Using either MIG or MMA stick weld equipment apply a continuous hot root weld bead around the steering pivot to motor mount plate interface. The weld bead should be a consistent (6 mm) thick bead all the way around the steering pivot, capping off with a 6mm fillet weld, as shown below



9. Also remove the paint from the reverse side of the motor mount plate to inspect the area where the through spigot of the steering pivot is welded to the reverse side of the plate as shown below. If there is cracking of the spigot to plate interface then this area should be ground and re-welded leaving a bead of weld above the surface of the plate



10. After the weld has cooled repaint the repaired area
11. Allow the paint to dry and then lubricate and replace the steering spindles using the existing hardware and reconnect the steering linkages.

12.Refit the drive motors and wheels

13.Safely lower the machine and test operate the machine before returning it to service.

Technical support: If required, technical support and advice is available by contacting the Snorkel Product Support or Quality Depts. for assistance.

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