



J. H. FLETCHER & CO. Box 2187 – Huntington, WV 25722-2187 – 304/525-7811 – FAX 304/525-4025

IMPORTANT MACHINE UPDATE NOTICE

INFORMATION BULLETIN NO. 121

TO: OWNERS OF FLETCHER HDDR/CHDDR WITH RIB ACCESS BOOMS

FROM: J.H. FLETCHER & CO.
RISK MANAGEMENT DEPARTMENT

DATE: JULY 2013

SUBJECT: IMPROVEMENTS TO THE MAST SWING FRAME

J.H. Fletcher & Co. (“Fletcher”) has identified isolated cases of cracking problems in the mast swing frame after an extended time of use. These cracks were found near the intersection of the vertical plate and the stiffener plate on the edge and under the cover plate of the mast swing frame (see Attachment 1). Over time, the boom could develop cracks in this mast swing frame and the cracks may affect machine use, or possibly lead to an injury. As of this bulletin date, Fletcher has received no reports of an injury relating to the observed swing mast frame cracks. These cracks may represent stress failure and this Important Safety Bulletin is issued.

This occurrence has only been identified on Fletcher HDDR/CHDDR bolters with rib access booms. **If you have identified swing mast frame cracks on any machine, notify Fletcher immediately.** Because Fletcher has only received information that HDDR/CHDDR bolters with rib access booms are affected, **this notification does not apply to booms that are not rib access designs.** Please refer to the serial number list provided in this bulletin for HDDR/CHDDR bolters.

In order to reduce the potential for injury and to prevent machine down time for repairs, Fletcher has developed an upgrade kit, part no. 534624(see Attachment 2). Fletcher recommends that you immediately inspect your machine(s) for these cracks. For customers who have purchased a new bolter that has not been delivered, or have a machine at Fletcher for modernization as of the date of this bulletin, Fletcher has

already made these changes to those machines.

For customers who currently have Fletcher bolters in the field which are equipped with these mast swing frame assemblies, Fletcher is offering and will provide this upgrade kit **at no charge**. This kit includes easy installation guidelines.

Fletcher recommends owners inspect each mast swing frame on all affected machines immediately. If cracks are present the machine must be repaired immediately. All other affected machines do require to be upgraded as soon as practically possible, and should not wait for cracks to appear.

After installing the upgrade, it is recommended that regular inspections be conducted of the mast swing frame to ensure no cracks develop (see Attachment 3). This should be an ongoing part of pre-shift and pre-operational inspections. You should place a copy of Attachment 3 in each operator's manual to ensure this becomes part of the operators' pre-operational checklist.

Domestic Customers: Please contact our service department and provide the serial number and machine model to order your kit(s).

International Customers: Contact our Fletcher authorized distributor in your country.

If you previously owned a Fletcher machine and have sold it, we ask that you notify Fletcher's Risk Management Department regarding the identity of the new owners by calling (304) 525-7811, ext. 240; or by email at dcooper@jhletcher.com. This information will enable Fletcher to notify the current owner about this, and other, new machine enhancements and afford them an opportunity to improve the performance of their equipment and the safety of their employees.

If you have any questions concerning this bulletin, or on the technical application of these components to your machine, please contact your Fletcher sales/service representative.

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PUBLICATION OF LESS THAN THIS COMPLETE DOCUMENT COULD BE MISLEADING TO THE READER

IF YOU HAVE ANY QUESTIONS, OR TO REQUEST PERMISSION TO REPRODUCE THIS DOCUMENT,
CONTACT THE RISK MANAGEMENT DEPARTMENT

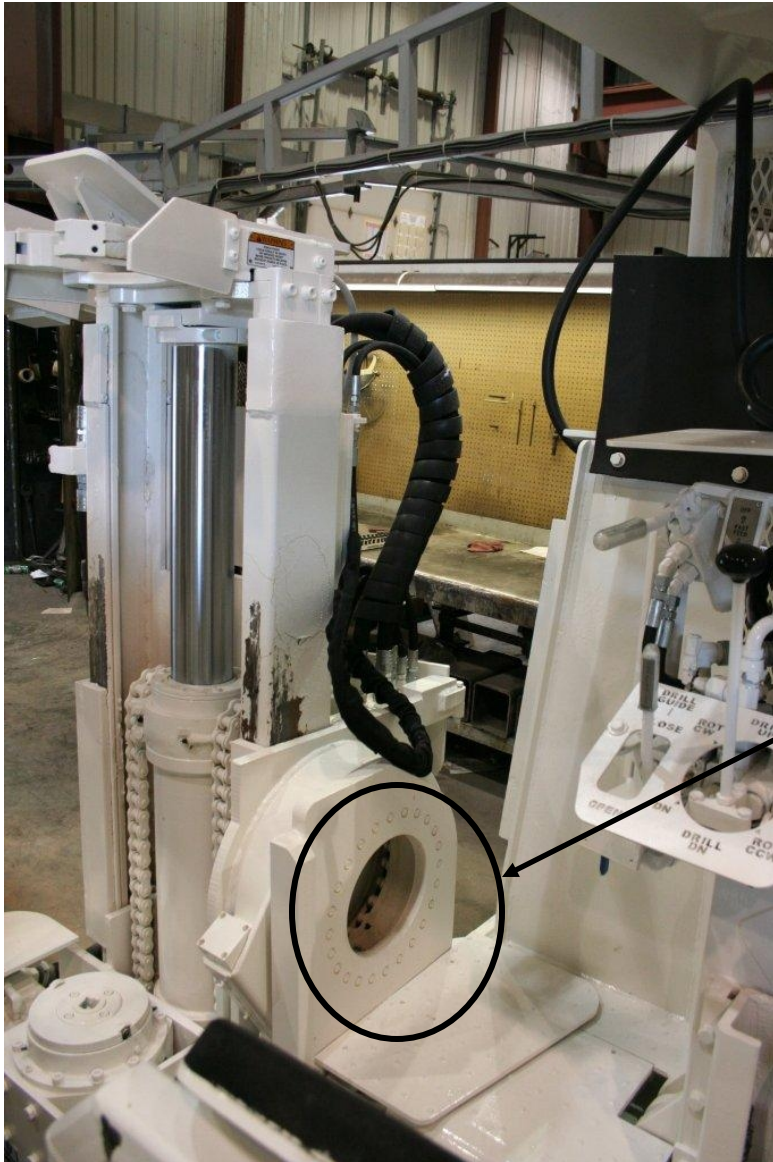
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LIST OF RIB ACCESS MACHINES AFFECTED BY IB 121

DOMESTIC CUSTOMERS LISTED IN BLACK

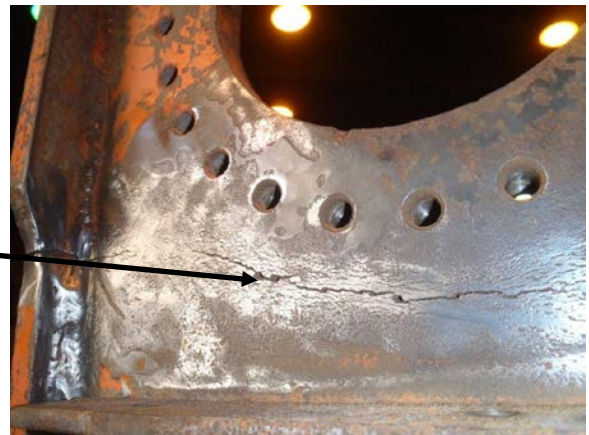
INTERNATIONAL CUSTOMERS LISTED IN RED

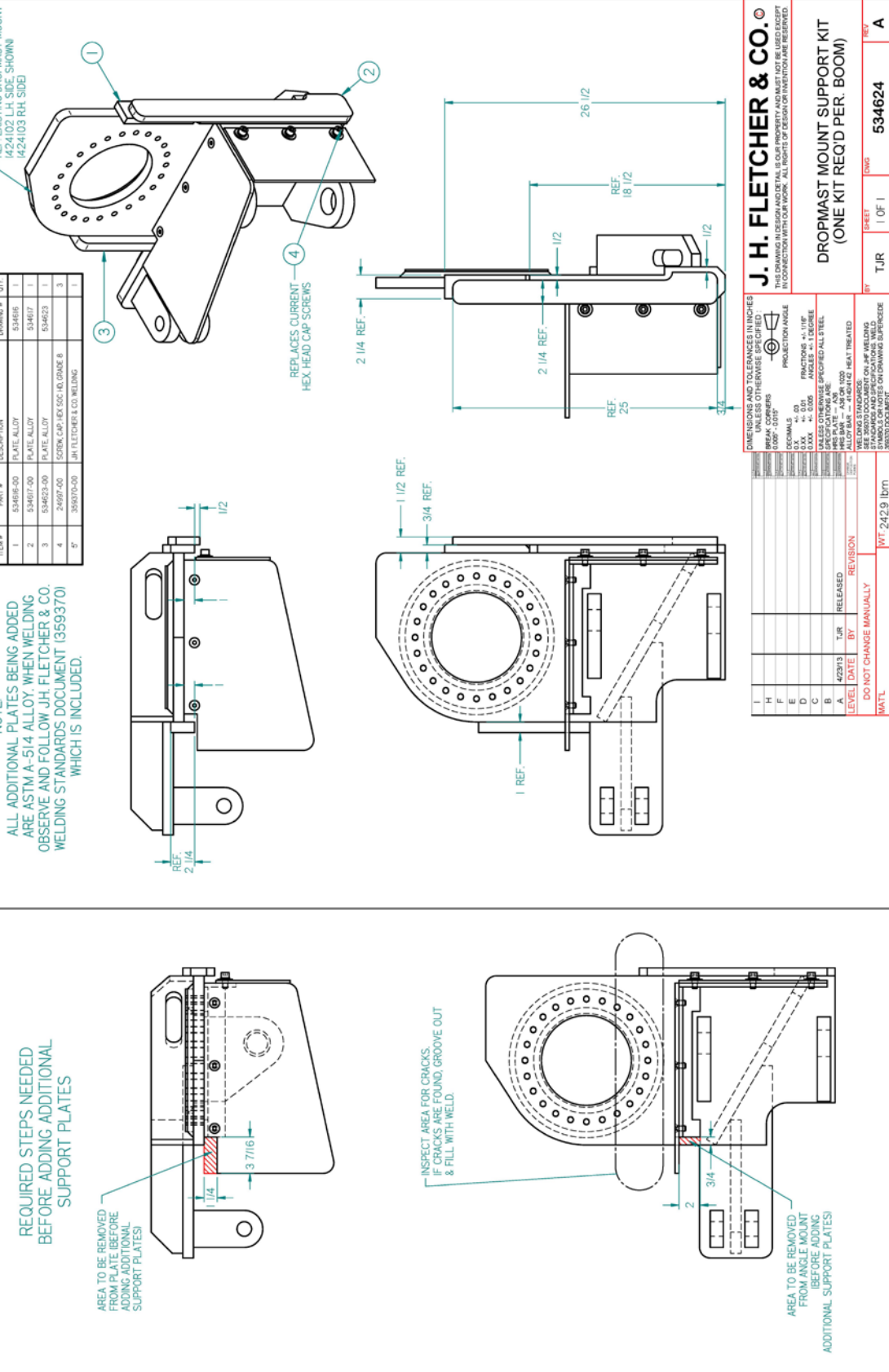
SERIAL NO.	MACHINE TYPE	SERIAL NO.	MACHINE TYPE
2008001	CHDDR	2011178	CHDDR
2009235	HDDR	2011193	CHDDR
2009236	HDDR	2011300	CHDDR
2009237	HDDR	2011352	CHDDR
2009409	HDDR	2011406	HDDR
2009428	HDDR	2011407	HDDR
2009461	HDDR	2011414	HDDR
2010067	HDDR	2011415	HDDR
2010093	CHDDR	2011416	HDDR
2010179	CHDDR	2011417	HDDR
2010180	CHDDR	2011453	HDDR
2010181	HDDR	2011475	HDDR
2010494	CHDDR	2011480	HDDR
2010495	CHDDR	2011414	HDDR
2010839	HDDR	2011489	CHDDR
2010840	HDDR	2011806	HDDR
2010878	HDDR	2012001	CHDDR
2010879	HDDR	2012051	CHDDR
2011034	CHDDR	2012052	CHDDR
2011078	CHDDR	2012067	HDDR
2011083	CHDDR	2012068	HDDR
2011084	CHDDR	2012070	HDDR
2011085	CHDDR	2012220	HDDR
2011171	CHDDR	2012224	HDDR
2011172	CHDDR	2012436	HDDR
2011173	CHDDR	2013013	CHDDR
2011174	CHDDR	2013015	HDDR
2011175	CHDDR	2013016	HDDR
2011176	CHDDR	2013019	CHDDR
2011177	CHDDR	2013406	HDDR



General location of
where cracks on the
mast swing frame
have occurred

Example of crack on
the mast swing
frame





DROPMAST AND DRILL MAST INSPECTION CHECKLIST

It is recommended that a periodic inspection be made of the dropmast and drill mast.

Although there are a variety of dropmast and drill mast designs used on Fletcher machines – this list should provide a general approach to inspecting these components:

STRUCTURE – Check for cracks, wear or any indication of metal fatigue.

FIT – There should be minimal play between the inner mast, outer mast, and dropmast. A snug sliding fit is optimal. Some mast designs have adjustment points to remove excessive play caused by wear during operation. If excessive play is detected, determine the source of the play and take corrective action to eliminate the excessive play.

BOLTS – Make sure all bolts are installed, properly tightened and of the correct grade. When replacing bolts, make sure to use the proper grade and install with recommended torque.

LUBRICATION – Make sure all grease fittings (and grease lines if used) are installed, in proper operating condition and take grease. Try to determine if the fittings are being serviced regularly.

ROLLERS AND WEAR PADS – Check rollers to make sure they are operating properly and adjusted to eliminate excessive play. Check, and if necessary, replace wear pads to eliminate excessive play. Also check the wear or rolling surface for damage, wear or metal galling.

MAST CHAINS – Mast chains should be tight. Lower the drill head all the way, if the mast chains will reach the back of the carriage plate, they are too loose and need replaced.

REGULAR MAINTENANCE AND REPAIR – Follow the directions provided in the Service Manual for your particular machine (lubrication, inspection and recommended adjustments/replacements).

FOR SPECIFIC INFORMATION ON YOUR DROPMAST AND DRILL MAST CONSULT YOUR PARTS BOOK, SERVICE MANUAL, OR CONTACT J.H. FLETCHER & CO.