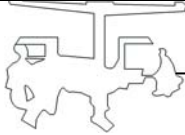


NOTICE: OUTDATED TEXT
DO NOT RELY UPON THIS TEXT. THIS TEXT IS
FOR INFORMATION PURPOSES ONLY. FOR
CURRENT INFORMATION, CONTACT
J.H. FLETCHER & CO.
RISK MANAGEMENT DEPT.



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

IMPORTANT SAFETY RETROFIT NOTICE

INFORMATION BULLETIN NO. 32

**TO: ALL OWNERS, OPERATORS AND REBUILDERS OF
FLETCHER DD TRACK DRILLS WITH ELEVATING BOOMS**

FROM: J.H. FLETCHER & CO.

SUBJECT: BOLTS ON BOOM SWING TURNTABLE

DATE: 1986

PROBLEM: Bolts holding the boom swing turntable to the slewing ring (or bearing) may break, allowing the boom to drop.

BACKGROUND: The boom swing turntable is made up of three layers of plates. On several machines these plates were not welded together. As a result, the bolts under the back of the boom, between the sump assembly and the turntable, are subjected to an excessive tensile load which could cause the boom to drop.

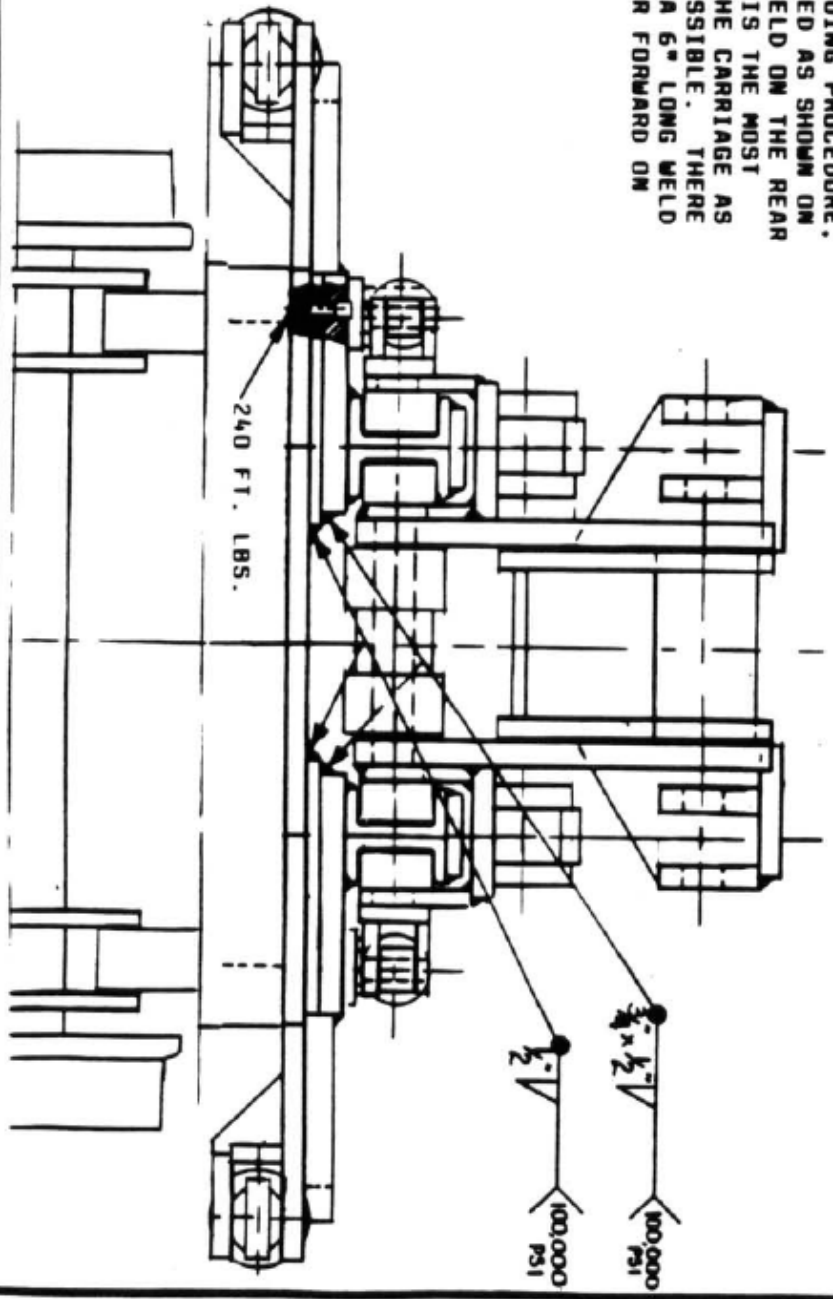
RECOMMENDED ACTION: Locate and remove from service the machine(s) identified from our records as having this potential hazard. Then perform the welding and bolt replacement and torquing as called for on the attached sheet.

IF CARRIAGE MOUNT IS NOT WELDED AS THE DRAWING BELOW NOTES THEN USE THE FOLLOWING PROCEDURE:

REPLACE ALL 5/8-11 x 4" (14) SOCKET HEAD CAP SCREWS AND TORQUE TO 240 FT. LBS. (CHECK TORQUE ON REMAINING BOLTS TO THE SAME TORQUE VALUE). AFTER COMPLETION OF BOLT EXCHANGE AND TIGHTENING PROCEDURE, WELDING IS REQUIRED AS SHOWN ON DRAWING BELOW. WELD ON THE REAR OF THE TURNABLE IS THE MOST CRITICAL. SLUMP THE CARRIAGE AS FAR FORWARD AS POSSIBLE. THERE MUST BE AT LEAST A 6" LONG WELD PASS FROM THE REAR FORWARD ON ALL FOUR JOINTS.

(ROTEK BEARING)

240 FT. LBS.



| | | | |
|---------------------|---------------------------|--------------------|-----------------------------------------------------------------------------------|
| SHEET NO. 0032-A | TITLE SERVICE BULLETIN | DATE 09-17-1986 | R J. N. FLETCHER & CO. 701 WEST 7TH STREET HUNTINGTON, W. VA. |
|---------------------|---------------------------|--------------------|-----------------------------------------------------------------------------------|

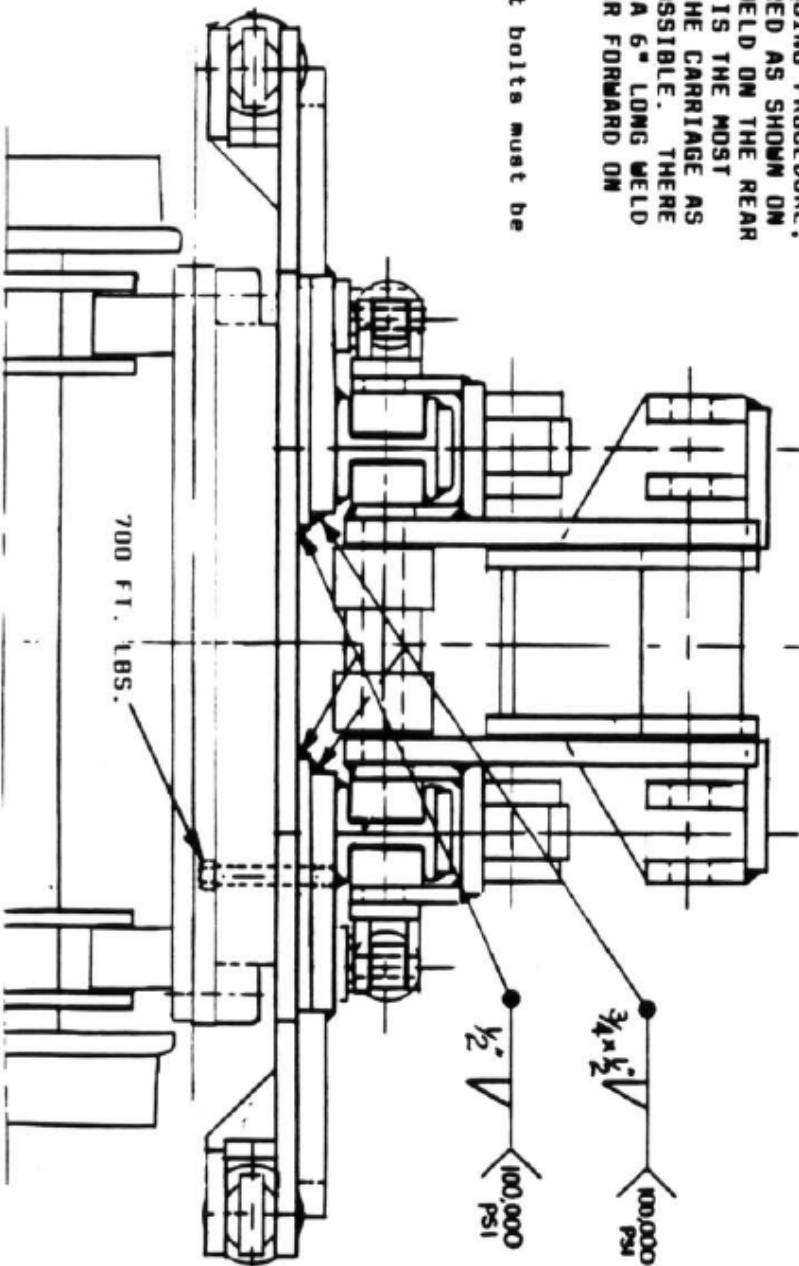
IF CARRIAGE MOUNT IS NOT WELDED AS THE DRAWING BELOW NOTES THE USE THE FOLLOWING PROCEDURE:

REPLACE ALL 7/8-9 x 5 1/2" (12) HEX HEAD CAP SCREWS AND TORQUE TO 700 FT. LBS. (CHECK TORQUE ON REMAINING BOLTS TO THE SAME TORQUE VALUE). AFTER COMPLETION OF BOLT EXCHANGE AND TORQUING PROCEDURE, WELDING IS REQUIRED AS SHOWN ON DRAWING BELOW. WELD ON THE REAR OF THE TURNABLE IS THE MOST CRITICAL. SUMP THE CARRIAGE AS FAR FORWARD AS POSSIBLE. THERE MUST BE AT LEAST A 6" LONG WELD PASS FROM THE REAR FORWARD ON ALL FOUR JOINTS.

Note: Replacement bolts must be

Grade 8

(SKF BEARING)



SHEET NO.

0032-8

TITLE

SERVICE BULLETIN

DATE

09-17-1986

R

J. N. FLETCHER & CO.

707 WEST 7TH STREET

MANASSAS, VA