



Altec Industries, Inc.
Midwest Division
St. Joseph, Missouri

MAB 650

MANDATORY ACTION BULLETIN

Date: February 23, 2017

Units Affected: DLB Digger Derricks built from April 2016 through December 2016
(See attached list)

Rotation Bearing Fastener Inspection

This Mandatory Action Bulletin requires immediate action.

This Mandatory Action Bulletin requires inspection of the rotation bearing fasteners on both the inner and outer races on the affected units.

Issue:

Altec discovered a broken rotation bearing fastener while performing a check during the final assembly process. Further investigation found other fasteners broken due to stress corrosion cracking. All of the broken fasteners came from the same supplier. Failure of multiple fasteners on a single bearing race can cause uncontrolled movement of the turntable and boom. **Death or serious injury can result from uncontrolled movement.**

Customer Action:

- Inspect the rotation bearing fasteners as soon as this MAB is received to see if the fastener head is marked with 6013 (refer to Figure 1) before the unit is operated again. If none of the fasteners are marked with 6013, no further action on the MAB is needed and the unit can be returned to service.
- If there are fasteners marked with 6013, perform a torque test on the fasteners in the race where the affected fastener was found using the Annual Torque Inspection Procedure in the Maintenance Manual.
- If any of the fasteners are broken or break during the torque inspection:
 - Remove the unit from service.
 - Replace all of the fasteners on the race where the affected fastener was located before the unit is returned to service. Rotation fasteners replacement kits are listed on Page 2 and can be ordered by calling 1-877-GO ALTEC (1-877-462-5832).



Figure 1 — Head Marking

MAB 650

Inner Race Cap Screw Kit	990361450
Outer Race Cap Screw Kit	990361458

- If no broken fasteners are found in the inspection
 - Replace all the fasteners in the race where the affected fastener was found within the next 30 days.
 - Perform a daily visual inspection of the rotation bearing fasteners until the fasteners are replaced if none were broken.
- Complete the inspection form at the end of this MAB and return it to Altec.

This repair is covered under the Altec Warranty Policy and can be performed by Altec, the customer, or the customer's warranty provider. Altec will allow up to \$630 for an inspection and the labor to perform this repair. A warranty claim must be submitted to be reimbursed for the cost of the parts and/or labor.

Call 1-877-GO ALTEC (1-877-462-5832) to schedule the work to be done by an Altec service technician. Customers are responsible for the travel costs of an Altec Mobile Service technician if the technician performs the inspection or repair at the owner's location.

MAB 650 Inspection Sheet

Complete this form and FAX to: 1-877-659-9929

or scan and email to product.safety@altec.com

Model	Serial Number	Date Inspected	Head Marking	Broken Cap Screws	
				Yes	No

Make additional copies of this form, as needed, for additional units. Contact Technical Support at 1-877-GO ALTEC (1-877-462-5832), prompt 4, for further repair information.

Company Name: _____ Phone _____

Service Company Name: _____ Phone: _____

Company Contact: _____

Company Street Address: _____

State: _____ ZIP Code: _____

Signature: _____