



BULLETIN

Subject: Counterbalance Tube Weld Campaign
Date: 9/21/2017 **Rev.-Date:** FR **No.:** B17005
Re.: Welded Repair **Type:** Safety
Priority: Immediate
Units Affected: See attached VIN listing.

Background:

We have found that it is likely that the “Huck” fasteners connecting the lower Counterbalance Tube to the Counterbalance assembly will loosen over time. This procedure was developed to restore structural integrity, and provide longevity to this connection.

Material Requirements:

| Description | Part Number | Qty/UM |
|---|-------------|--------|
| Spray or Brushable Cold Galvanize Coating | N/A | N/A |

Tool Requirements:

- Mig or Stick Welder
- Putty Knife
- Die Grinder / Grinding Wheels
- Drill
- Wire Wheel



CAUTION

- Wear appropriate personal protective equipment [PPE] like gloves, safety glasses and hard hat for example, when carrying out the following procedure.
- Should welding or cutting be needed, do so in a well ventilated area and wear appropriate head/face/eye protection, welding gloves and clothing.
- Refer to adhesive and chemical manufacturer’s MSDS for safe use and handling instructions if applicable.
- Follow your company’s safety procedures in addition to these recommendations.
- Follow industry standards for installation and tightening of all fasteners where torque values are not called out.

Procedure:

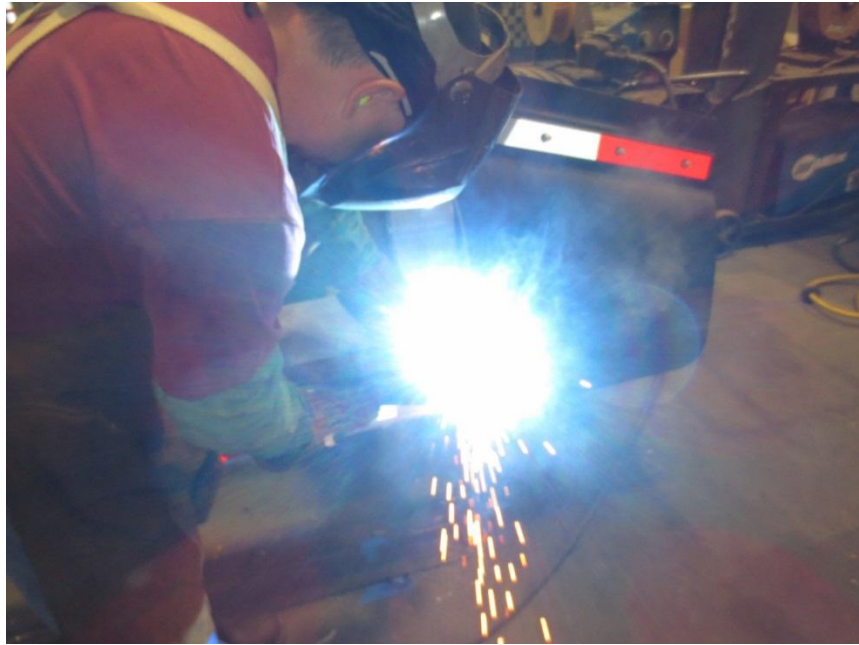
Step 1: Remove caulking from all areas to be welded.



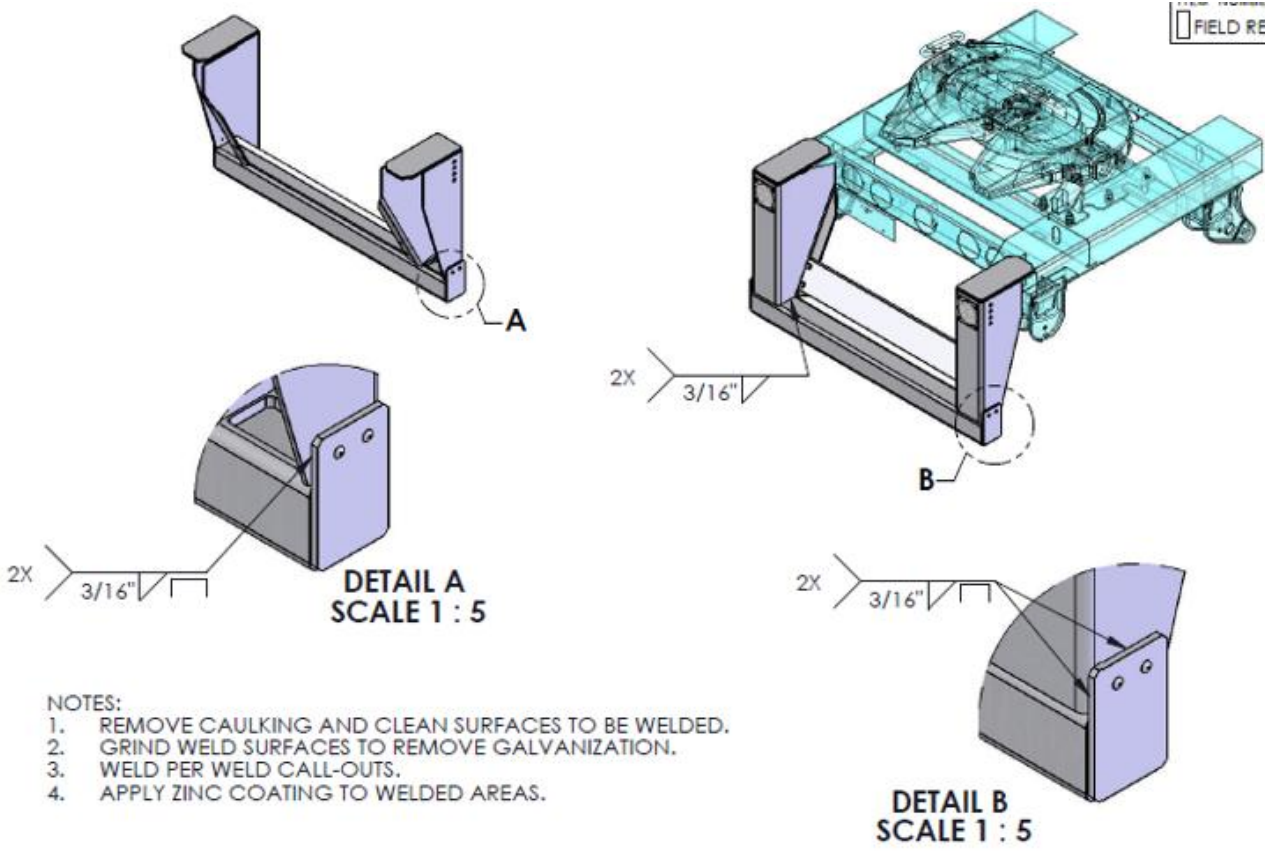
Step 2: Using a Die Grinder remove the galvanizing from the area to be welded.



Step 3: Add all needed welds per the attached print directly below.



FIELD REPAIR

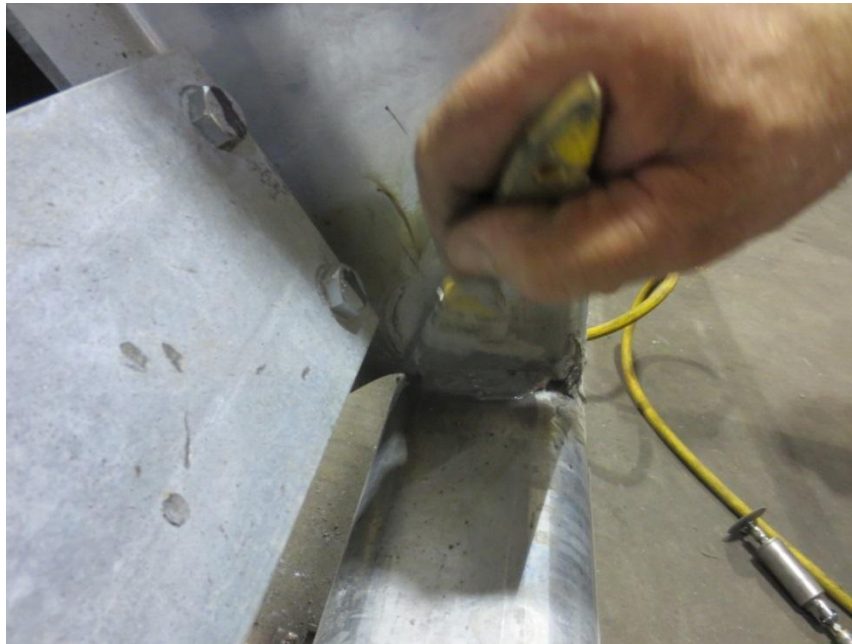


- NOTES:**
1. REMOVE CAULKING AND CLEAN SURFACES TO BE WELDED.
 2. GRIND WELD SURFACES TO REMOVE GALVANIZATION.
 3. WELD PER WELD CALL-OUTS.
 4. APPLY ZINC COATING TO WELDED AREAS.

Step 4: Using a Wire Wheel and a Drill clean all welded areas to prepare for the coating process.



Step 5: Using a cold galvanizing compound coat all newly welded areas.



The welded areas should be coated using a Rustoleum Cold Galvanizing Compound or equivalent as pictured above. This can be purchased as a spray or a brushable coating. Brushable is preferred but not required for this repair.

Completed Unit:



Notes:

- Campaign repairs should be completed as quickly as possible.
- Any questions in regards to the campaign should be directed to the Wabash Warranty Dept. @ 765-771-5404.
- If needed replacement parts can also be obtained by contacting the Wabash Warranty Dept.
- Standard Repair Time for this repair is .75 hours per unit.
- Please see the provided vin# listings for units requiring this campaign.

Attachment 1

| Location Significance | Fillet | Plug or Slot | Spot or Projection | Stud | Seam | Back or Backing | Surfacing | Flange Corner | Flange Edge |
|--|----------|--------------|--------------------|----------|----------|------------------------|-------------|------------------------|-------------|
| Arrow Side | | | | | | Groove weld symbol | | | |
| Other Side | | | | Not used | | Groove weld symbol | Not used | | |
| Both Sides | | Not used | Not used | Not used | Not used | Not used | Not used | Not used | Not used |
| No Arrow Side or Other Side Significance | Not used | Not used | | Not used | | Not used | Not used | Not used | Not used |
| Location Significance | Groove | | | | | | | Scarf for Brazed Joint | |
| | Square | V | Bevel | U | J | Flare-V | Flare-Bevel | | |
| Arrow Side | | | | | | | | | |
| Other Side | | | | | | | | | |
| Both Sides | | | | | | | | | |
| No Arrow Side or Other Side Significance | | Not used | Not used | Not used | Not used | Not used | Not used | Not used | Not used |

| Supplementary Symbols | | | | | | | |
|-----------------------|------------|-----------|-------------------|----------------|---------|--------|---------|
| Weld-All Around | Field Weld | Melt-Thru | Consumable Insert | Backing Spacer | Contour | | |
| | | | | | Flush | Convex | Concave |
| | | | | | | | |

| Basic Joints Identification of Arrow Side and Other Side of Joint | |
|--|---|
| Butt Joint Arrow side of joint Arrow of welding symbol Other side of joint | Corner Joint Arrow side of joint Arrow of welding symbol Other side of joint |
| T-Joint Arrow of welding symbol Arrow side of joint Other side of joint | Lap Joint Other side member of joint Arrow of welding symbol Arrow side member of joint |

| Location of Elements of a Welding Symbol |
|--|
| |

| Edge Joint | Process Abbreviations |
|---|--|
| Arrow side of joint Arrow of welding symbol Joint | Where process abbreviations are to be included in the tail of the welding symbol, reference is made to Table 1, Designation of Welding and Allied Processes by Letters, of AWS A2.4-86. AMERICAN WELDING SOCIETY, INC. 550 N. W. LeJeune Rd., Miami, Florida 33126 |

(American Welding Society)