



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

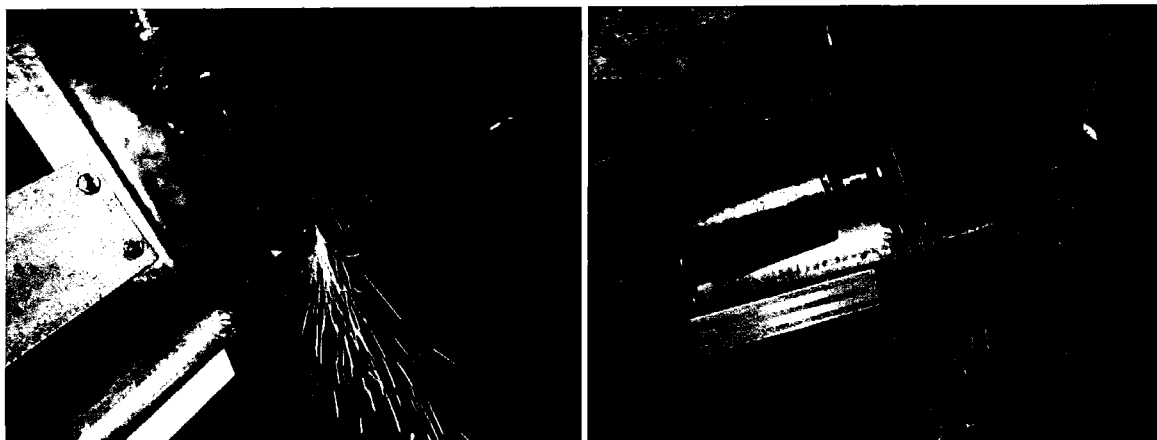
- Wear appropriate personal protective equipment [PPE] like gloves, safety glasses and hard hat for example, when carrying out the following procedure.
- Should welding or cutting be needed, do so in a well ventilated area and wear appropriate head/face/eye protection, welding gloves and clothing.
- 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:

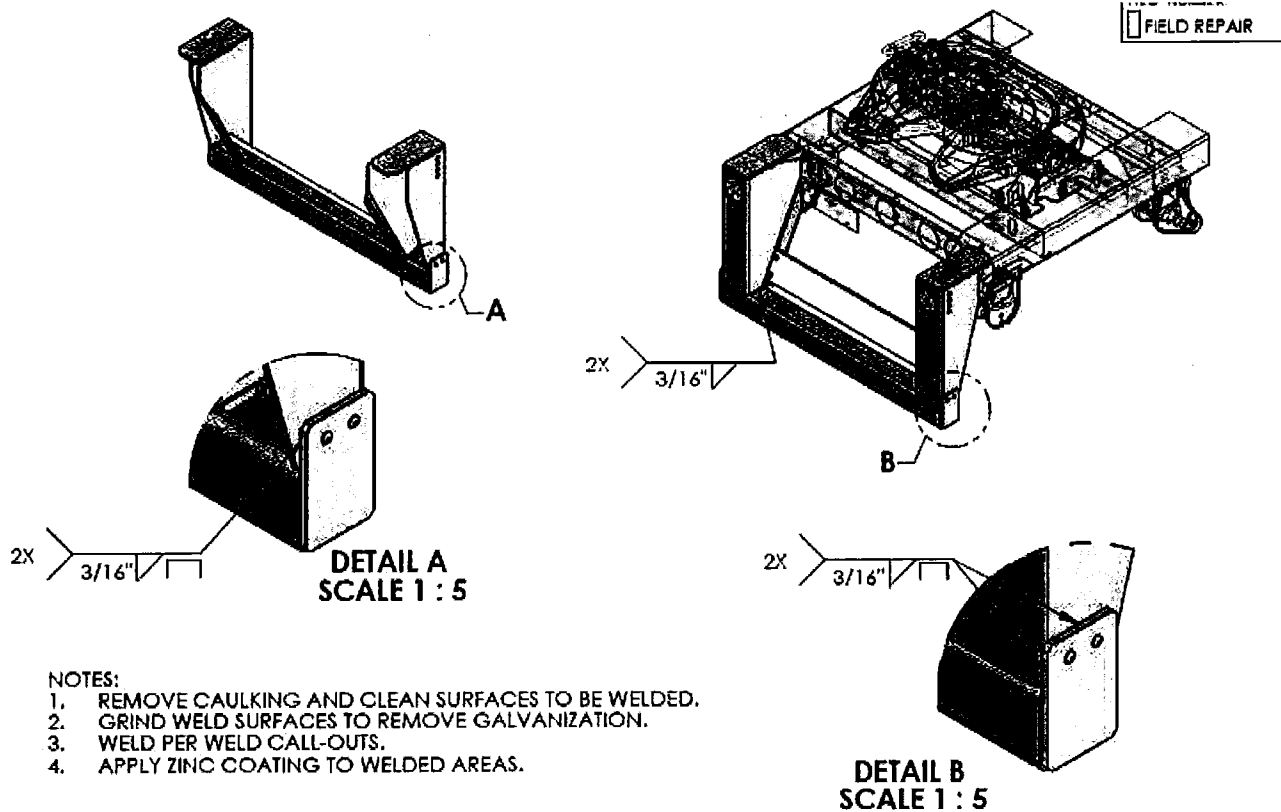
Step 1: Remove caulking from all areas to be welded.



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.



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	Filet	Plug or Slot	Spot or Projection	Stud	Seam	Back or Backing	Surfacing	Flange Corner	Flange Edge
Arrow Side									
Other Side				Not used			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	Grooves							Bevel 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

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

Identification of Arrow Side and Other Side of Joint	
Butt Joint	Corner Joint

T-Joint	Lap Joint

Edge Joint	Process Abbreviations
	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.

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