



Dolly Counterweight Box Inspection and Repair April 2017



Counterweight Box Inspection





Counterweight Box Inspection

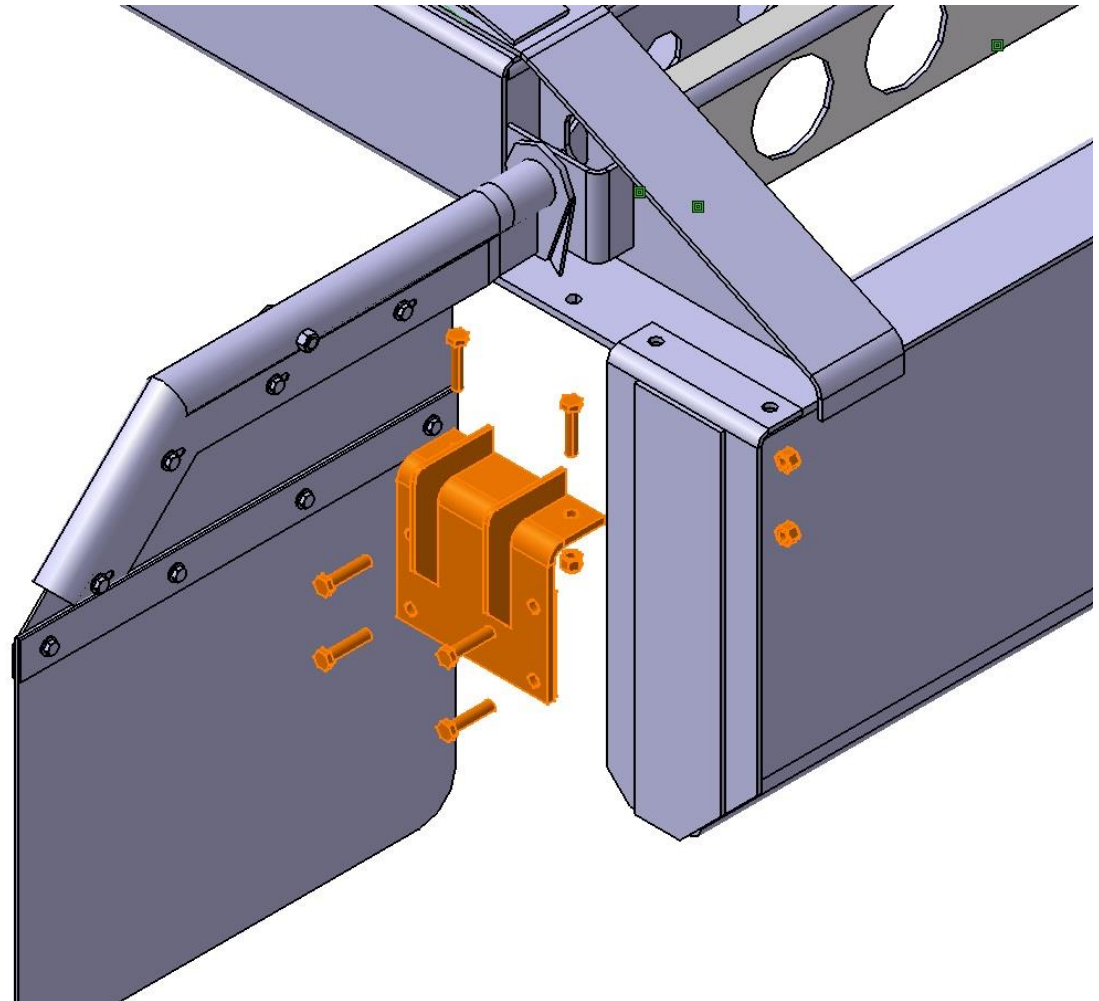
- Locate cracks on counterweight assembly
- Stop-drill using ¼” drill bit to mitigate crack propagation
- Clean weld area free of zinc and debris
- Weld cracks and grind smooth
- Clean soot and spatter from re-welded areas
- Prime newly welded area with GDPGQ1431





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- Clamp subassembly 38300007 in place by lining up 2 top holes
- Use 38300007 as template to drill 4 holes on vertical face of existing counterweight box
- Fasten all 6 fasteners and torque to 70 ft•Lb



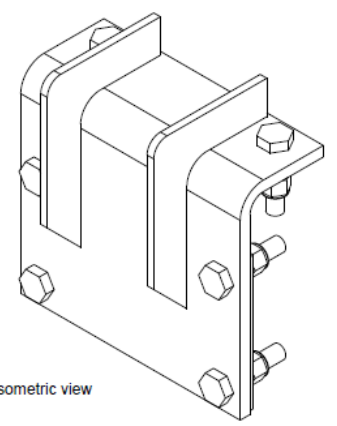


Parts List

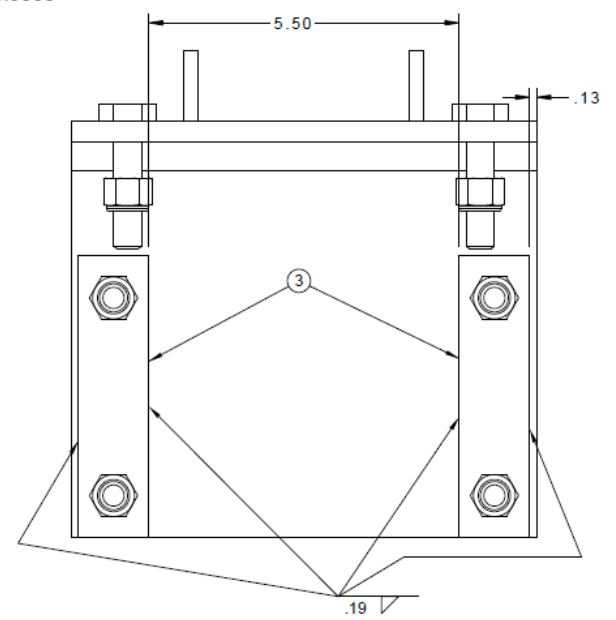
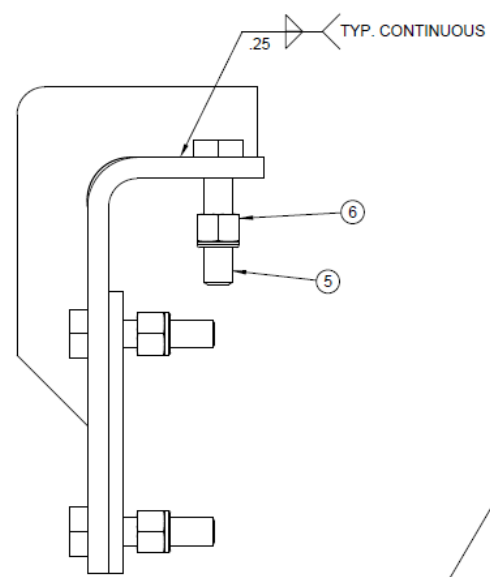
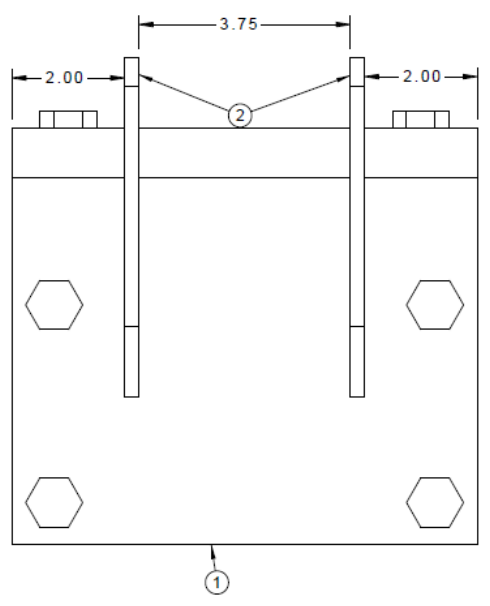
- (2) 38300007, CTRBL REINF ASY CDLY MOD DOLLY FRAME
 - (1) 40300266, ANG CTRBL CDLY REINF STL
 - (2) 40300267, REINF, DOLLY COUNTER WT BOX
 - (2) 40300268, SHM,DOLLY COUNTER WT BOX
 - (6) 42200434 , CPSCW,HH NC SS .50-13X2.25 ASTM F593C
 - (6) 42200949, NUT,LK NLN HH NC SS .50-13
- (1) ZRC Cold Galvanizing Zinc Spray



ITEM	P/N	DESCRIPTION	QTY	UOM
1	40300266	ANG,CTRBL CDLY REINF STL	1	EA
2	40300267	REINF,DOLLY COUNTER WT BOX	2	EA
3	40300268	SHM,DOLLY COUNTER WT BOX	2	EA
4	42301151	WIRE,WLDG GMAW AWS ER70S C STL	1	LB
5	42200434	CPSCW,HH NC SS .50-13X2.25	6	EA
6	42200949	NUT,LK NLN HH NC SS .50-13	6	EA



Isometric view



REV. STATEMENT: SWAP 42200548 FOR 42200434 TO USE WITH SS NUT 42200949
 CN 03/23/17

ALL DIMENSIONS ARE IN INCHES
 TOLERANCES TO BE ±0.050
 UNLESS OTHERWISE NOTED.

DWN: N Kovanda 03/23/2017
 CN 03/23/17 WEIGHT 12.012lb

SHEET: 1 OF 1
 DWG CTRBL REINF ASY, CDLY
 TITLE: MOD DOLLY FRM
 DWG NO: 38300007
 REV: A.

