



210 Inverness Center Parkway
Birmingham, AL 35242

Telephone: 205-991-7733
Facsimile: 205-991-9993
www.altec.com

This notice applies to your vehicle. See attached serial number list.

January 29, 2021

Dear Altec Owner,

Altec Industries, Inc. has developed a product improvement which relates to LS40/45/55 aerial devices built from 2004 through 2015.

Refer to SIL 783 for the items covered under the warranty policy. Altec will supply the necessary parts to correct this condition free of charge.

In order to determine if your unit is affected by SIL 783, compare the serial number of your unit with the list of affected units attached to the SIL. The product improvement can be performed by the customer or you may contact Altec at 1-877-GO-ALTEC (1-877-462-5832) for further assistance.

At any time, you may contact Altec at 1-877 GO ALTEC (1-877-462-5832) with your unit's serial number to determine if there are any other outstanding notices.

If you have sold or retired the unit please call Altec at 1-877-GO-ALTEC (1-877-462-5832) so the records may be changed.

We regret this inconvenience; however we are taking this action in the interest of your safety and continued satisfaction with Altec products.

Thank you for your immediate attention on this important matter.



Altec Industries, Inc.
HiLine Operations
Duluth, MN

SIL 783

Service Information Letter

January 29, 2021

Units Affected: LS40/45/55 aerial devices built from 2004 through 2015 (Verify that your unit serial number is affected by reviewing the attached list in this SIL or by accessing your fleet on connect.altec.com/login)

Leveling Cylinder Update

Altec is committed to providing our customers safe and reliable products from initial delivery throughout the useful life of the machine.

Some customers have reported structural cracking where the primary leveling cylinder mounting pin is welded to the lower boom side plate. Failure of this connection could disable the hydraulic platform leveling system. Altec has developed a kit to reduce the relief pressure of the hydraulic leveling circuit. This will prevent damage to the leveling cylinder mounting pin weld joint by reducing the weld stress. Altec has also developed a kit to repair the lower boom if the side plate has cracked.

Altec requires the following actions to be completed on the affected units by the next annual preventive maintenance interval or within one year of receipt of the SIL.

1. Call 1-877-GO ALTEC (1-877-462-5832) to order the Leveling Circuit Relief Kit, part number 991170986.
2. Inspect the primary leveling cylinder mounting pin attachment using the Inspection Procedure beginning on page 2.
3. If required by the inspection results, take the unit out of service until the leveling cylinder mounting pin attachment has been repaired.
 - If there is cracking in the weld but not the side plate, repair the unit according to the Leveling Cylinder Pin Weld Repair Procedure beginning on page 4 of the SIL.
 - If there is cracking in both the weld and the side plate, call 1-877-GO ALTEC (1-877-462-5832) to order the Leveling Cylinder Pin Repair Kit, part number 991082050. Repair the weld and install the kit according to the instructions included in the kit.
4. Install the Leveling Circuit Relief Kit according to the instructions included the kit.

Altec Use Only	
Inspection labor	0.5 hr
Repair labor	4.0 hr install relief kit 5.0 hr repair pin weld only 8.0 hr repair weld & install pin kit
Account #	010.1953.43151.000.9116.000
Travel	Not included
NHTSA code	98
Prime fail P/N	n/a
Doc ref	074900738, 074900739

Altec Use Only			
Parts Kit	Part No.	Qty	Warranty
Leveling circuit relief kit	991170986	1	Yes
Leveling cylinder pin repair kit	991082050	1	Yes

This inspection and repair are covered under the Altec Warranty Policy and can be performed by Altec, the customer, or the customer's warranty provider. Altec will perform the inspection and repair for free at an Altec facility. Altec requires the Leveling Cylinder Pin Weld Repair Procedure and the Leveling Cylinder Pin Repair Kit installation to be performed by a welder qualified to the AWS D1.1 Structural Welding Code. If the customer, or the customer's warranty provider performs the inspection and/or repair, a warranty claim must be submitted to be reimbursed for the cost of the parts and/or labor. Altec will allow up to the amounts shown below for the labor to perform this inspection and repair.

Allowable Labor Cost	Procedure
\$45	Inspection
\$360	Install Relief Kit
\$450	Repair Pin Weld Only
\$720	Repair Pin Weld and Install Pin Repair Kit

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 and/or the relief kit installation at the owner's location. An Altec Mobile Service technician is not able to perform the repairs requiring welding.

Inspection Procedure

A grinder, flashlight, and dye penetrant kit are required for the inspection. Read and understand all steps of the instructions before beginning the procedure.

1. Position the unit on a level surface. Apply the parking brake and chock the wheels.
2. Find the primary leveling cylinder mounting pin located on the street side of the lower boom (refer to Figure 1).

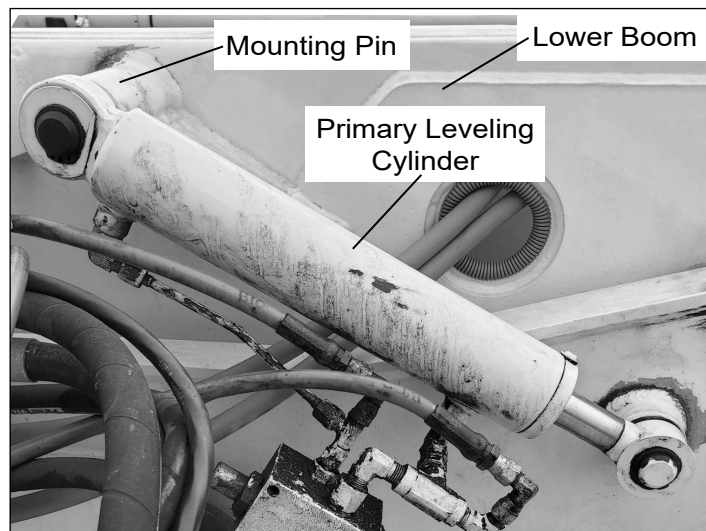


Figure 1 — Locating Leveling Cylinder Mounting Pin

3. Inspect the weld around the base of the mounting pin between the 9 o'clock and 12 o'clock positions (refer to Figure 2).

- If there is no visible cracking in the paint and no rust on the surface, proceed to step 7a.
- If there is visible cracking in the paint and/or rust on the surface, proceed to step 4.

4. Look inside the lower boom through the base end with a flashlight and examine the surface of the left side plate in the area where the mounting pin is attached to the outside.

- If there is no visible cracking in the paint and no rust on the surface, proceed to step 5.
- If there is visible cracking in the paint and/or rust on the surface, proceed to step 7b.

5. Use a grinder to remove the weld all along the cracked portion and about $\frac{1}{2}$ " beyond each end of the crack in the weld. Allow the boom to cool to the touch.

6. Use a dye penetrant kit to check for cracking in the side plate.

- If the dye penetrant shows cracking in the side plate (refer to Figure 3), use a die grinder to grind a slight groove along the length of the crack to mark it. Then proceed to step 7b.
- If the dye penetrant does not show any cracking in the side plate, proceed to step 7c.

7. Proceed with step a, b, or c based on the results of steps 3 through 6.

- If step 3 showed no visible cracking or rust on the weld, return the unit to service until the Leveling Circuit Relief Kit is received. Then install the Leveling Circuit Relief Kit
- If step 4 or step 6 showed cracking in the side plate, take the unit out of service. Order and install the Leveling Cylinder Pin Repair Kit, part number 991082050. Return the unit to service until the Leveling Circuit Relief Kit is received. Then install the Leveling Circuit Relief Kit.
- If step 3 showed evidence of cracking in the weld but steps 4 through 6 showed no cracking in the side plate, take the unit out of service. Perform the Leveling Cylinder Pin Weld Repair Procedure beginning on page 4. Return the unit to service until the Leveling Circuit Relief Kit is received. Then install the Leveling Circuit Relief Kit.

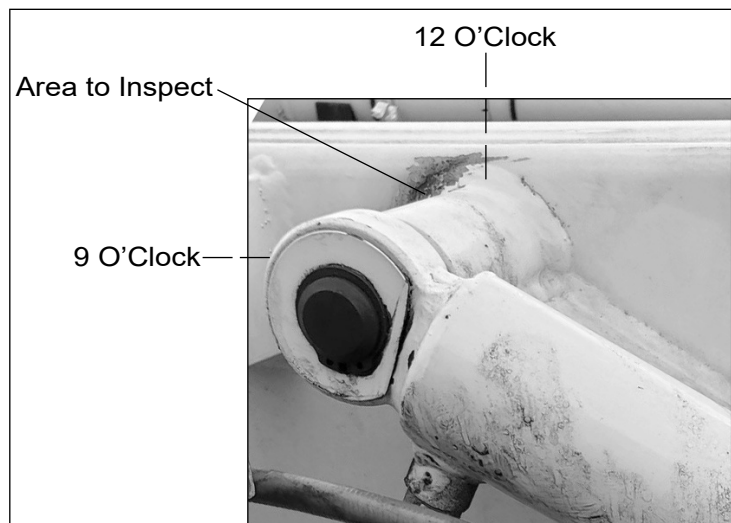


Figure 2 — Inspecting Weld

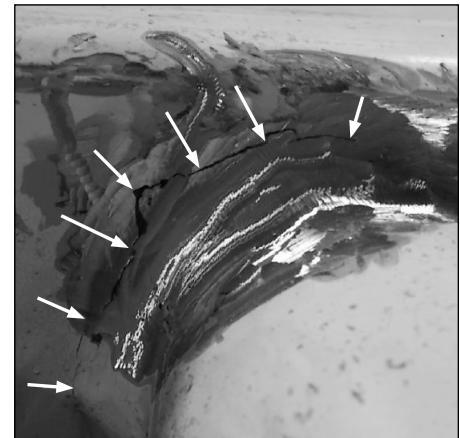


Figure 3 — Cracking in Side Plate

Leveling Cylinder Pin Weld Repair Procedure

This procedure replaces the cracked weld that was removed during the Inspection Procedure. The unit must be taken to an Altec facility, customer shop, or third party for repair by a welder qualified to AWS D1.1 Structural Welding Code. The welder must be qualified in 3G uphill progression welding and use one of the following approved methods:

- FCAW-G - gas shielded flux core wire (E71T-1M/9M)
- FCAW-S - gasless self-shielded flux core wire (E71T-11)
- SMAW - stick electrode (E7018 H4R)
- GMAW - solid core wire (ER70S-6)

Matching paint is required for application after the welding is completed. Read and understand all steps of the instructions before beginning the procedure.

1. Position the unit on a level surface. Apply the parking brake and chock the wheels.

2. Find the primary leveling cylinder mounting pin located on the street side of the lower boom (refer to Figure 4).

3. Cover the hydraulic plumbing below the cylinder with heat-resistant material such as fiberglass cloth to protect it from weld spatter.

4. Sand off the paint and any corrosion from the side plate and the pin OD about ½" beyond where the weld was removed during the Inspection Procedure.

5. Apply a ¼" fillet weld to replace the portion of weld that was removed (refer to Figure 5). Blend the weld smoothly into the original weld that was not removed.

6. After the weld has cooled, clean the repaired area and paint it to match.

7. Remove the covering over the hydraulic plumbing.

8. A structural test is required to verify structural soundness before putting the unit back into service.

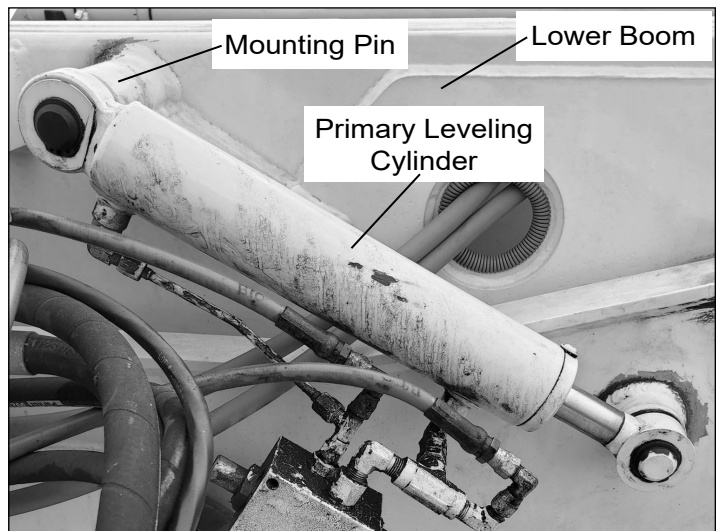
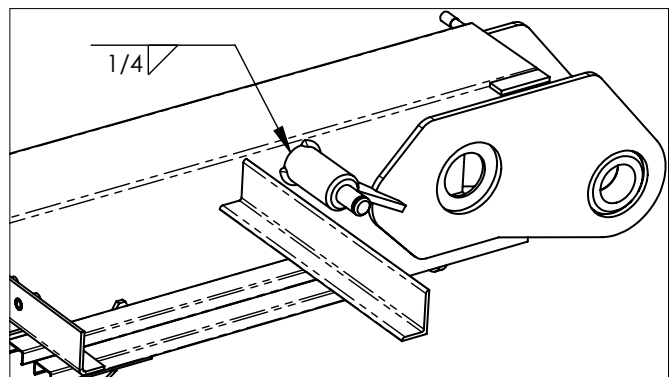


Figure 4 — Locating Leveling Cylinder Mounting Pin



**Figure 5 — Repairing Weld on Mounting Pin
(Cylinder and Plumbing not shown)**



WARNING

Death or serious injury can result if the unit becomes unstable. Maintain stability of the unit while performing a structural test by following proper procedures.

9. The area where the test is performed must be level and free from any overhead obstructions. Position the unit in the test area so the platform may be accessed by a forklift (or other lifting device) to place the test weight.
10. Apply the parking brake and chock the wheels. Engage the unit's hydraulic system.
11. For the test weight, use the platform capacity shown on the serial number placard. Do not multiply the capacity by 1.5 for this test.

If the unit is equipped with a platform liner, deduct the weight of the liner from the test weight figure.

NOTICE

Carefully load the test weight to prevent damage to the platform or liner.

12. Place the weight in the platform or place a sling around the platform to suspend the weight directly under its centerline. Use a forklift (or other lifting device) to slowly apply the weight.
13. Leave the boom fully retracted.
14. Using the lower controls, articulate the boom from horizontal to the maximum boom angle and back to horizontal a total of ten times.
15. Inspect the repaired weld and the surrounding area for any signs of damage. Make any necessary corrections.
16. Return the unit to service until the Leveling Circuit Relief Kit is received. Then install the Leveling Circuit Relief Kit.