

**Mixer lower ladder  
rung clearance repair**

**Date:** March 2, 2021  
**Bulletin Name:** MXR-TSIB-033  
**Models:** Bridgemaster V and Standard Mixer  
**Model Year:** 2016-2021

**Purpose:**

McNeilus Truck and Manufacturing offers these instructions to restore lower ladder rung clearance.

**Notice:**

- This bulletin should be read and understood in its entirety before performing this procedure.
- All procedures outlined in the bulletin must be performed by skilled service personnel. Refer to the product service manual for descriptions of maintenance procedures.

**SAFETY NOTICE**

**Perform your company's Lockout/Tagout procedure. If your company does not have a Lockout/Tagout procedure, follow OSHA 1910.147 and 1910.146 Confined Space as appropriate.**

**SAFETY NOTICE**

**Use appropriate Personal Protective Equipment (PPE) as required by your company.**



**(888) 686-7278**

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## **Tools and Equipment Required:**

Customer to supply:

- Angle grinder
- Welder
- 3/4" wrench
- 5/16 Allen wrench
- Bar clamps
- 10 gauge shim

## **Parts Required:**

Customer to supply steel but can order hardware from McNeilus StreetSmartParts.com:

Item	Part Number	Description	Qty.
1	N/A	10 GA grade 50 steel cut to 1.50" X 0.5"	2
2	0120201	NUT, FLG, LKDT .50-13 GG CW	2
3	1164981	SCR, FLG, HEX .50-13 X 1.75 G8 ZY	2
4	0120020	SCR, SHD, SOC .50 X 1.00 A574 BO	4
5	0120200	NUT, FLG, LKDT .38-16 GG CW	4

1. Perform your company's Lockout/Tagout (LOTO) procedure. If your company does not have a Lockout/Tagout procedure, follow OSHA 1910.147 and 1910.146 Confined Space as appropriate. Apply wheel chocks, enable the parking brake.
2. Unbolt and remove the upper and lower ladder weldment from the mixer.

**NOTE:** Be aware that when unbolting the weldment, the lower ladder platform might swing down (Figure 1).

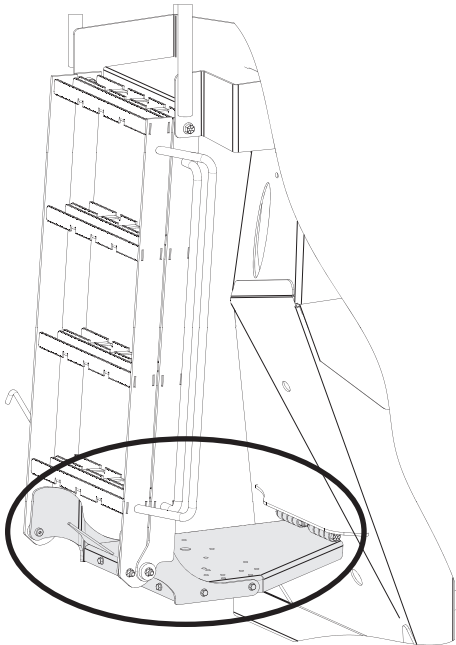


Figure 1

3. If the upper and lower ladder were removed separately, reassemble, and lay on a flat surface and use the bar clamps to clamp the upper ladder down.

4. Prop the lower ladder up using a 6.25" tall block so it makes an 8 degree angle with the flat surface (Figure 2).

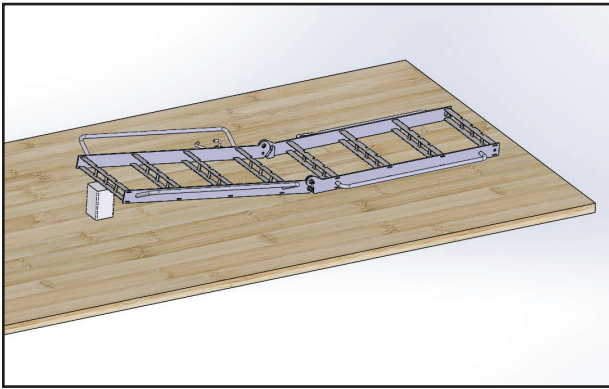


Figure 2

5. Using a 10 gauge shim pushed firmly against the ladder stop block, mark a straight line on both sides of the lower ladder (Figure 3). **NOTE:** If the 10 gauge shim is not thick enough to be able to mark a line on the lower ladder, the thickness of the shim should be increased to 3/16". If the 3/16" is not thick enough to mark the lower ladder as described, then the lower ladder will need to be replaced.

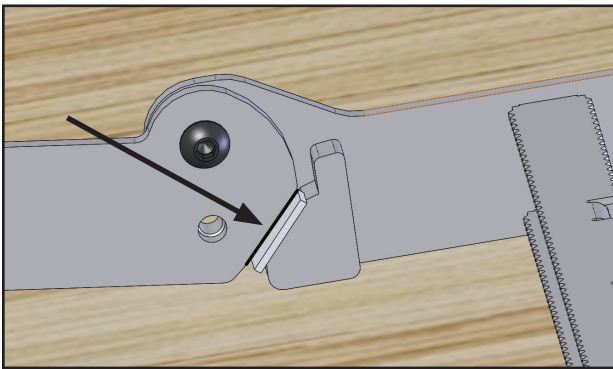


Figure 3

6. Using an angle grinder or equivalent, grind the surface of the lower ladder flush to the line marked in Step 5 on both sides (Figure 4).

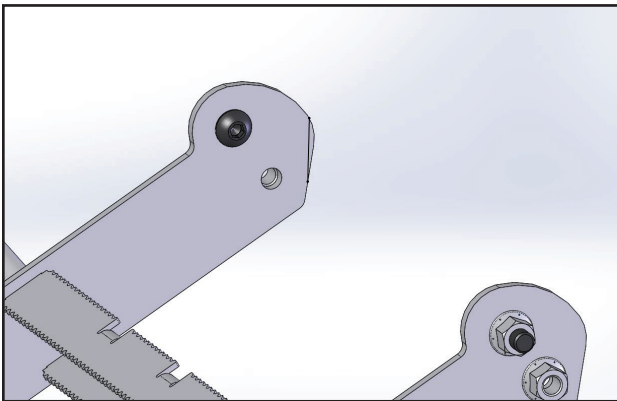


Figure 4

7. Cut a piece of 10 gauge grade 50 material to 1.50" by 0.5". **NOTE for Step 7 and Step 8:** If the shim used in Step 5 is increased to 3/16", then the material must be increased to a 3/16" thick piece.
8. Weld the piece of 10 gauge from Step 7 to the ladder stop as shown in Figure 5 and Figure 6. Repeat on other side of lower ladder.

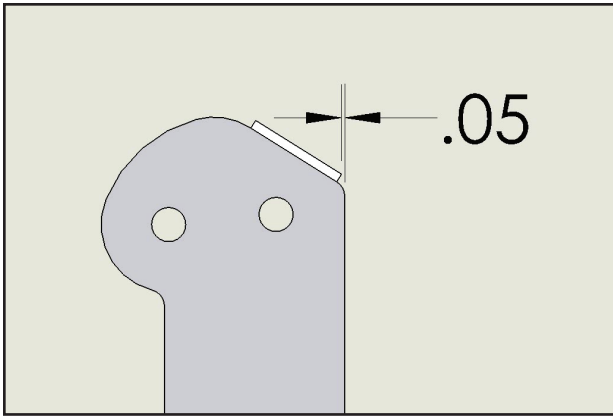


Figure 5

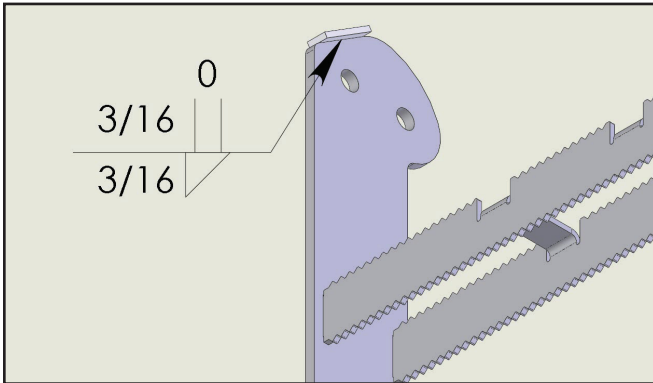


Figure 6

9. Reinstall the upper and lower ladders on to the mixer using new hardware (see Figure 7).
10. Using a torque wrench to torque nuts in the locations shown (both sides) in Figure 7 to 75 ft.-lbs., and then back off (1/2) turn.

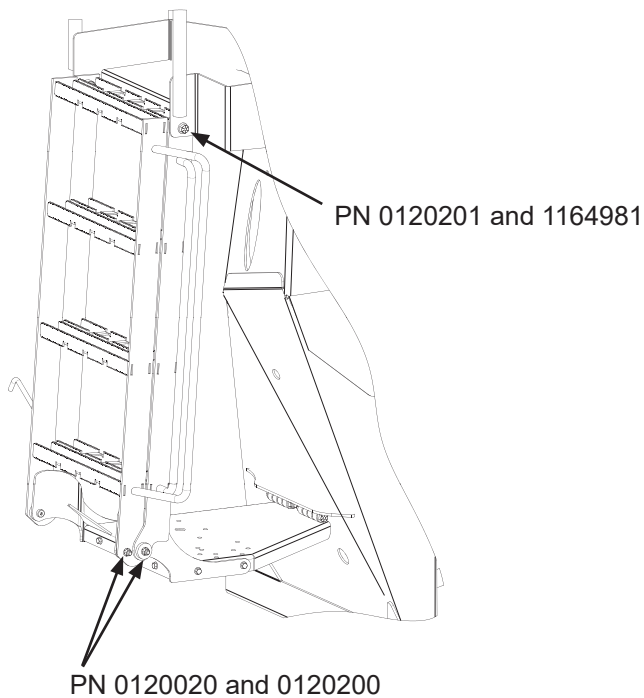


Figure 7

11. Remove your company's Lockout/Tagout procedure. If your company does not have a Lockout/Tagout procedure, follow OSHA 1910.147 and 1910.146 Confined Space as appropriate. Remove wheel chocks, Disengage the parking brake.