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.

March 31, 2021

Dear Altec Owner,

Altec Industries, Inc. has developed a product improvement which relates to certain HD35A pressure diggers built from 2005 through 2020.

Refer to SIL 795 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 795, 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.
Midwest Operations
St. Joseph, MO

SIL 795

Service Information Letter

March 31, 2021

Units Affected: HD35A pressure diggers built from 2005 through 2020 (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)

Stationary Frame Inspection

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 cracks occurring in the stationary frame tubes above the chassis frame rails. Investigation has shown this to be caused by improper orientation of the spacer blocks welded to the bottom of the stationary frame tubes.

Altec requires the stationary frame on each unit to be inspected no later than the next preventive maintenance interval. Use the Inspection Procedure on page 2. If the spacer blocks are oriented incorrectly, the unit must be repaired no later than 30 days after the inspection using the Repair Procedure beginning on page 3.

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 repair for free at an Altec facility. 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 requires the repair to be performed by a qualified welder proficient in 3G uphill progression welding and 4G overhead welding. Altec will allow up to $9 for the labor to perform this inspection and up to $711 for the labor to perform this repair. 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 at the owner's location. An Altec Mobile Service technician is not able to perform this repair.

Altec Use Only	
Inspection labor	0.1 hr
Repair labor	7.9 hr
Account #	010.0390.43151.503.0000.000
Travel	Not included
NHTSA code	98
Prime fail P/N	n/a
Doc ref	n/a

Altec Use Only			
Description	**Part Number**	**Qty**	**Warranty**
⅜" x 6" x 12" steel repair plate	991287546	4	Yes
½" x 6" x 12" steel repair plate	991287563	4	Yes

Inspection Procedure

A tape measure or small ruler is required for this procedure. 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. Turn off the engine and remove the key from the ignition.

2. Find the middle spacer block that is welded to the bottom of the stationary frame tube on the street side of the unit near the rear axle (refer to Figure 1).

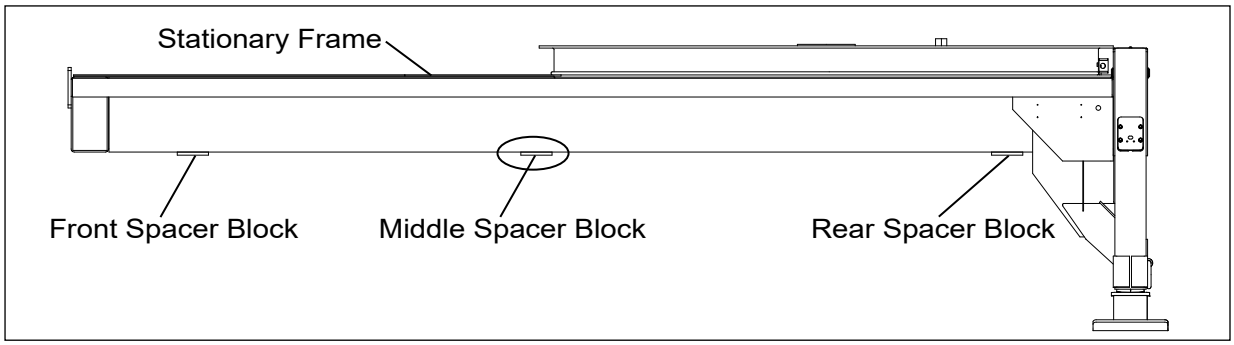

Figure 1 – Spacer Block Location

3. Measure the length of the middle spacer block on the street side from the front edge to the rear edge (refer to Figure 2). Repeat for the middle spacer block on the curb side.
   - Street side length _____
   - Curb side length _____

4. Review the measurements.
   - If the measurement is 3” or 5” for both blocks, the blocks are oriented correctly and no repair is required. Return the unit to service. Complete the Evaluation Sheet at the end of the SIL.
   - If the measurement is 4” for one or both blocks, the block(s) are oriented incorrectly. Proceed to the Repair Procedure.

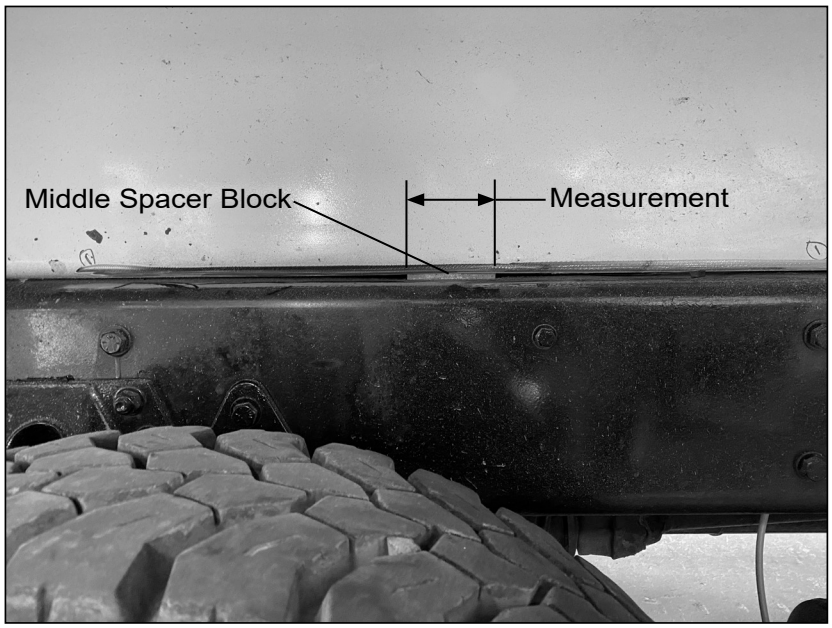

Figure 2 – Spacer Block Measurement

Repair Procedure

Normal mechanic's hand tools plus a drill, ¼" drill bit, grinder, sander, and electric welder are required for the installation of this kit. Required materials are four 6" x 12" steel plates with a thickness of either ⅜" or ½" as determined in step 9 of the procedure, weld-through primer, and white finish paint. Read and understand all steps of the instructions before beginning the procedure. All welds must be applied by a qualified welder proficient in 3G uphill progression welding and 4G overhead welding using 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)

1. Position the unit on a level surface. Apply the parking brake and chock the wheels. Turn off the engine and remove the key from the ignition.

2. The Repair Procedure is written assuming the repair is required on both sides of the stationary frame. If a 4" middle spacer block measurement was found on only one side of the stationary frame in step 3 of the Inspection Procedure, then only that side requires the repair.

3. Remove the paint from the bottom corners of the tube in an area 12" ahead of and 12" behind the middle stationary block on both sides of both stationary frame tubes (refer to Figure 3).

4. Inspect for any cracks near the spacer block on both sides of both tubes.
   - If any cracks are visible, proceed to step 5.
   - If no cracks are visible, proceed to step 9.

5. Drill a ¼" hole at the end of each crack.

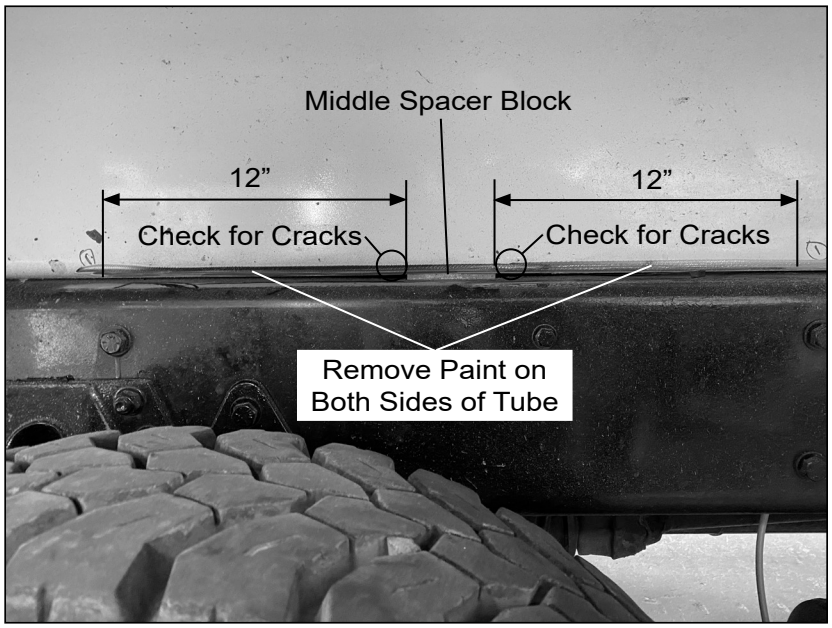

Figure 3 – Removing Paint and Checking for Cracks

6. Vee-grind a groove 1/8" deep x 1/4" wide along each crack.

7. Use a sander to remove the paint about 1/2" beyond each side of the grooves.

8. Weld the grooves and the holes slightly above full, and sand the welds flush.

9. Measure the gap between the bottom of the stationary frame tube and the top of the chassis frame rail on both sides of the spacer block.
   - If the gap is ⅜" or less, use ⅜" thick steel for the repair plates in step 10.
   - If the gap is greater than ⅜", use ½" thick steel for the repair plates in step 10.

10. Obtain or fabricate four 6” wide x 12” long repair plates from ASTM A36 or higher grade steel having the thickness determined in step 9 (refer to Figure 4). If desired, call 1-877-GO ALTEC (1-877-462-5832) to obtain the plates from Altec using the applicable part number below.
    - ⅜” x 6” x 12” plate, part number 991287546
    - ½” x 6” x 12” plate, part number 991287563

Figure 4 – Repair Plates

11. Paint the repair plates on all sides with weld-through primer and allow them to dry.

12. Insert the repair plates between the stationary frame tube and the chassis frame rail, located directly in front of and behind the middle spacer blocks on both sides of the unit with the 12” sides parallel to the side of the chassis frame (refer to Figure 5). If necessary, drive the plates into place using a hammer or mallet. In addition, a pry bar can be used between the stationary frame tube and chassis frame rail to create more room to insert the plates (refer to Figure 6).

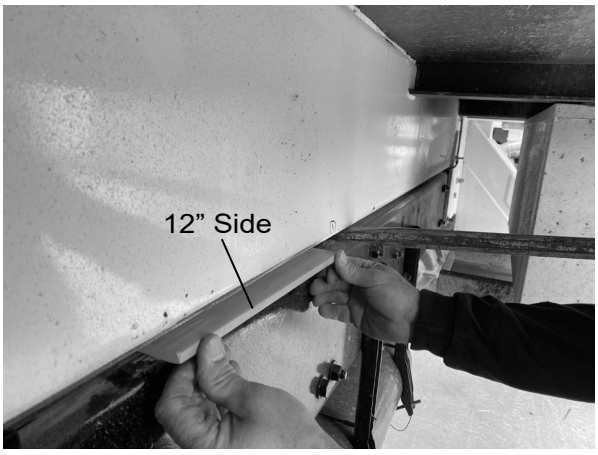

Figure 5 – Installing Repair Plate

Figure 6 – Using Pry Bar

13. Protect the tires and chassis components from weld spatter. Weld the repair plates to the stationary frame tubes on both sides of both tubes using 2” long ¼” flare-bevel stitch welds with 3” spacing (refer to Figure 7).

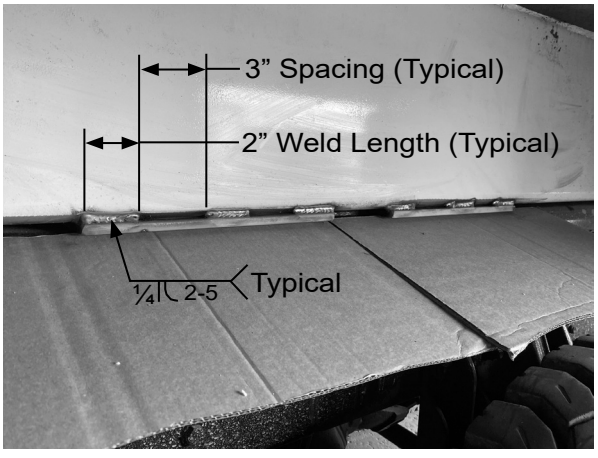

Figure 7 – Welding Repair Plates

Figure 8 – Painting Repaired Areas

14. Paint the repaired areas with white finish paint (refer to Figure 8).

15. Return the unit to service. Complete the Evaluation Sheet at the end of the SIL.

SIL 795 Stationary Frame Inspection Sheet

Complete this form and return to Altec to document inspection completion.

Choose one of these options.

- Online through the customer portal – Altec Connect*
  Sign in or Register for an account at www.altec.com/altec-connect/
  1. Select Equipment
  2. Select Altec Product Notices
  3. Select Report a Completed APN
- Scan and Email to product.safety@altec.com
- FAX to 1-877-659-9929

To login to your existing Altec Connect account, scan here with your smart phone!

*Customer performed warranty can be submitted online for reimbursement through Altec Connect.

Model	Altec Unit Serial Number	Date Inspected

Company Name: _____ Phone _____

Service Company Name: _____ Phone: _____

Company Contact: _____

Company Street Address: _____

City _____ State: _____ ZIP Code: _____

Signature: _____

Submission of this form does not order parts or schedule service from Altec.

If the customer or the customer's warranty provider performs the repair, a warranty claim must be submitted to be reimbursed for the cost of the parts and/or labor through Altec Connect.

For more information or to schedule the work to be done by an Altec Service technician, call:
1-877-GO ALTEC (1-877-462-5832)

Make copies of this form for additional units if needed.