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TO: Service Managers
AFFECTED MODEL: Sweepers equipped with Hoist Mechanism P/N 1130280006
SUBJECT: Hoist Mechanism Inspection and Weld Repair
RELEASE DATE: August 6th, 2026 **BULLETIN NUMBER:** 41200201

URGENT – ACTION REQUIRED

If you receive a copy of this bulletin, our records indicate you took delivery of one of the affected machines in need of inspection and possible repair. Please **immediately contact owners of the affected machines** and instruct them to:

- **STOP operating the sweeper(s) immediately**
- Arrange for **inspection of the hoist mechanism as soon as possible**

ISSUE DESCRIPTION

It has been identified that certain hoist mechanisms supplied by the vendor may have been **improperly stitch welded**, resulting in **excessive gaps between weld stitches**. These conditions may lead to:

- Structural weakness
- Cracked welds
- Deformation of the hoist mechanism

All affected units must be inspected and repaired as outlined below.

INSPECTION PROCEDURE

Before performing any inspection:

1. Ensure the **debris body is completely empty**
2. Raise the debris body and **secure it on approved body props**
3. Verify the machine is in a **safe and stable condition**
4. **Remove the keys and attach a “Do Not Operate” tag on the steering wheel.**

Inspect the hoist mechanism for the following:

- All weld seams for the presence of cracked welds
- Any **visible deformation or distortion**



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INSPECTION RESULTS & REQUIRED ACTIONS

If Cracks or Deformation ARE Found:

- Remove the unit from service immediately
- Contact your regional product support manager for further instructions.

If NO Cracks or Deformation Are Found:

- Perform the **Preventative Weld Repair** as outlined in this bulletin.

REPAIR PROCEDURE SUMMARY

Key requirements include:

- Follow the approved repair methods based on job-specific risk assessment
- **Disconnect batteries and controllers prior to welding**
- Ensure proper support for the debris tank or remove it entirely before repair
- Welding must be performed by an **AWS-qualified welder**
- Use approved processes and materials (SMAW, FCAW, or GMAW with specified consumables)
- Minimum weld size: **¼ inch**
- Perform **post-weld inspection per AWS D1.1 standards**

LABOR ALLOWANCE

- Estimated repair time: **4–5 hours per machine**

WARRANTY INFORMATION

- Submit a **“Machine Warranty” claim type for each unit repaired**. Include:
 - Inspection findings
 - Repair details
 - Photos (before and after repair)
- **Reference this bulletin number** on all claims (41200201)

REPORTING REQUIREMENTS

All dealers must:

- Report inspection results to their **Regional Product Support Manager**. Include:
 - Serial number(s) & Hours
 - Condition found (cracks, deformation, none)
 - Repair status

IMPORTANT SAFETY NOTICE

Failure to inspect and repair affected units may result in equipment damage. Units must **not be returned to service** until all required inspections and repairs are completed.



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PREVENTATIVE WELD REPAIR

Welding Requirements

- Welding must be done by an American Welding Society qualified welder.

Surface Preparation

- All paint, coatings, and contaminants must be completely removed from joints prior to welding to prevent weld defects and contamination.

Approved Welding Processes and Filler Materials

- **SMAW (Stick Welding):**
 - Use **E7018** electrodes.
- **FCAW (Flux-Cored Arc Welding):**
 - Use **ER70T-1** wire.
 - FCAW may be considered the preferred method depending on available equipment.
- **GMAW (MIG Welding):**
 - Use **ER70S-6** solid wire. (Gradall recommends L-59 Lincoln weld wire)
 - Minimum wire diameter: **0.035 in.**
- **Shielding Gas (GMAW)**
 - Gradall uses gas blend: **92% Argon / 8% CO₂**.
 - Minimum allowable gas mix: **90% Argon / 10% CO₂**.
- **Welding Position and Weld Size**
 - Welding shall be performed in the flat or horizontal position. If out of position welding is needed, it must be done vertical up.
 - The weld size must be a minimum of ¼ inch.
- **Post Weld Inspection**
 - All welds are to be visually inspected to AWS D1.1 structural welding code requirements.



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Methods of Repair

Two acceptable methods are available for completing this repair. The selected approach must be based on a thorough job-specific risk assessment. The safest method shall always be selected and implemented based on the specific job conditions, equipment configuration, and findings of the risk assessment. **The battery and all controllers must be safely unhooked before any welding is to be done on the machine.** Work must not proceed unless hazards are controlled and the selected setup provides safe access for welding operations.

Method 1

Debris Tank positioned on safety props with hoist mechanism unhooked from debris tank

- Secure the debris tank on safety props as shown in Section 1 of the Operator & Safety Manual (part number VA0000S4758).
- Unbolt and remove the hoist mechanism from the debris tank.
- Position the hoist mechanism in a safe configuration to provide adequate access for welding while maintaining stability on the subframe.
- Confirm all components are properly supported and cannot shift during the repair.

Method 2

Remove the Debris Tank

- Completely remove the debris tank prior to welding. Ensure the debris tank is properly supported and handled to prevent damage or injury during removal and transport.
- Proceed with welding operation only after the machine and debris tank are safely located.

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Sides and Hinge Ends of Hoist Mechanism: Place welds between existing welds to form a continuous weld. Do the same on the opposite side of the hoist mechanism.



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Top of Hoist Mechanism: Place welds between existing welds to form a continuous weld.



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The images show the hoist mechanism after welding

