



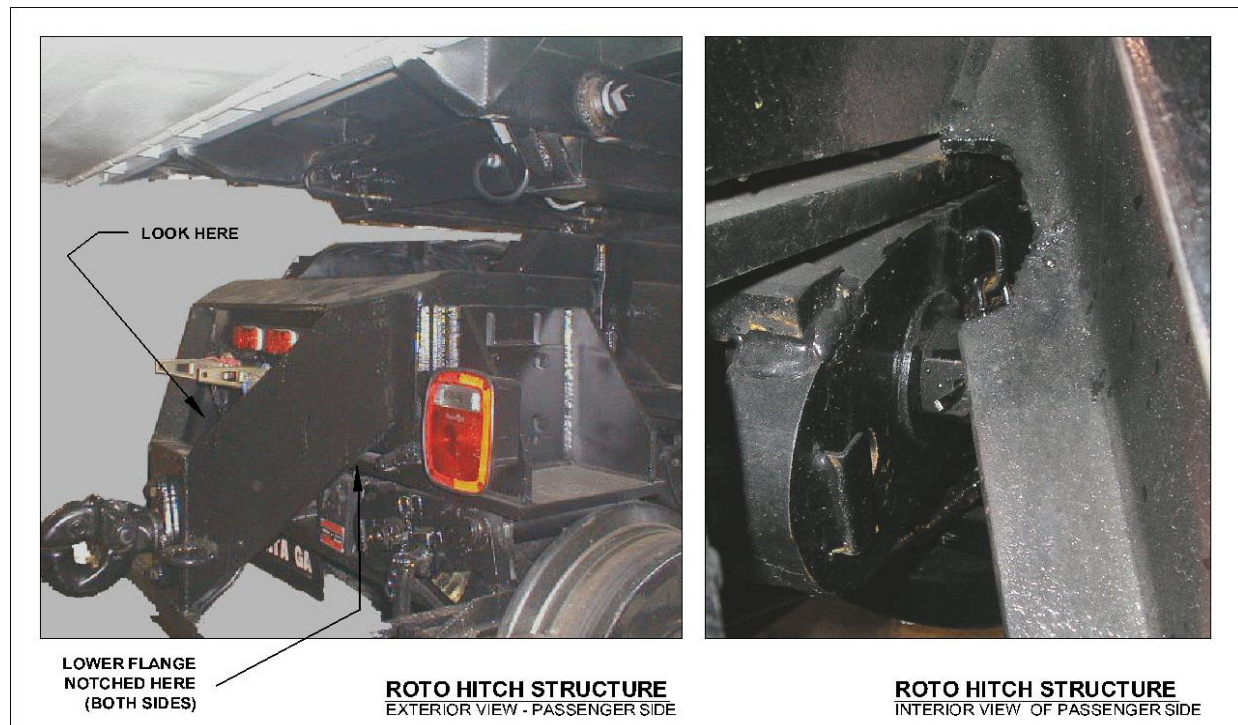
## Diversified Metal Fabricators Service Bulletin SB 2046

<b>Title</b>	Roto 180 Hitch Structure Reinforcement
<b>Document No.</b>	SB 2046
<b>Issue Date</b>	1/25/06 (WAK)
<b>Units Affected</b>	Roto-180 installed with Hitch Structure at DMF in 2005. All units should be checked and repaired as described below. Units must not tow until hitch has been inspected and repaired if necessary.
<b>Purpose</b>	To address an installation error in Pintle Hitch Structure.

### Process:

#### Identify Units with Defect

Notches were torch cut in the lower flanges of the main channel beams for clearance. These notches create a significant stress concentration and can cause a structural failure. Inspect units as shown below:

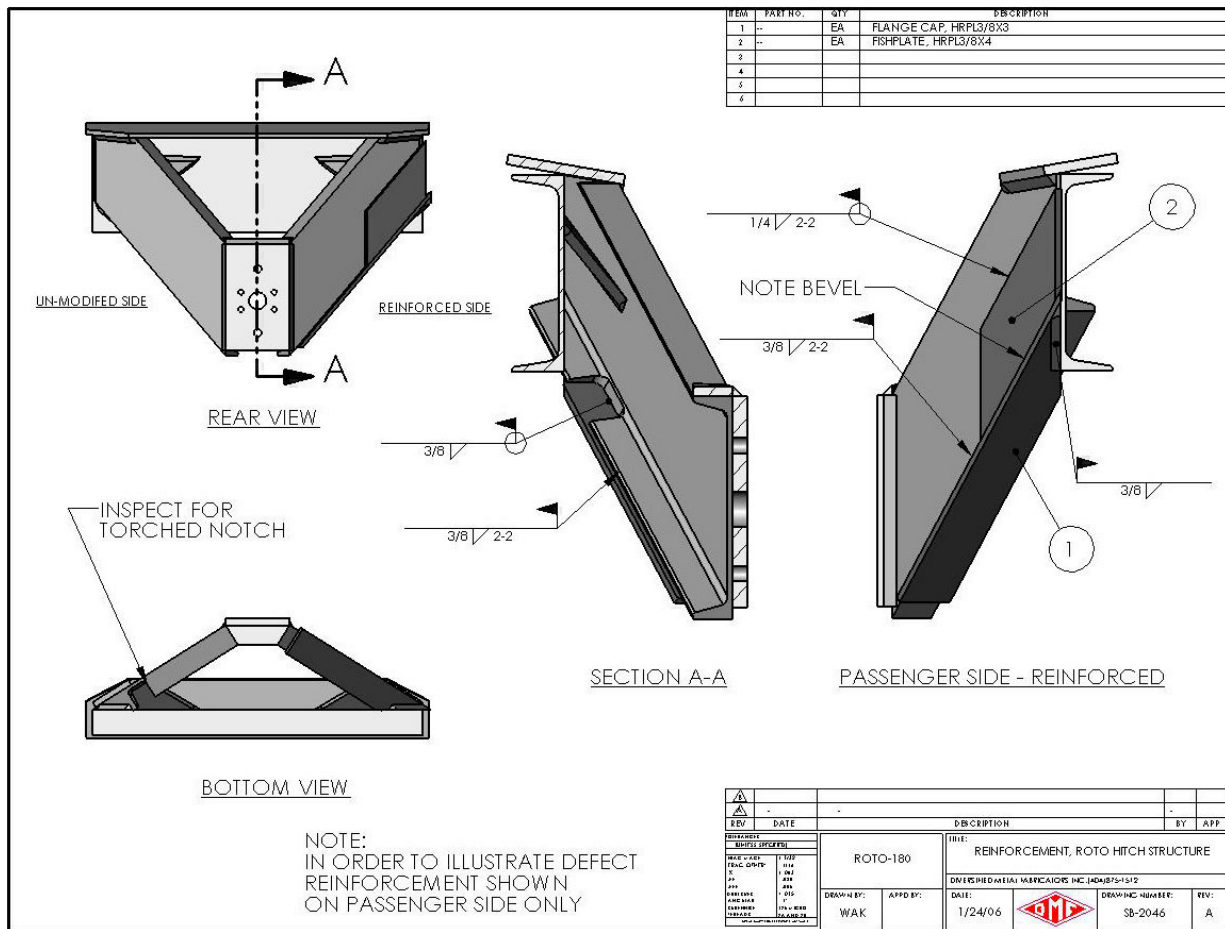




## Diversified Metal Fabricators Service Bulletin SB 2046

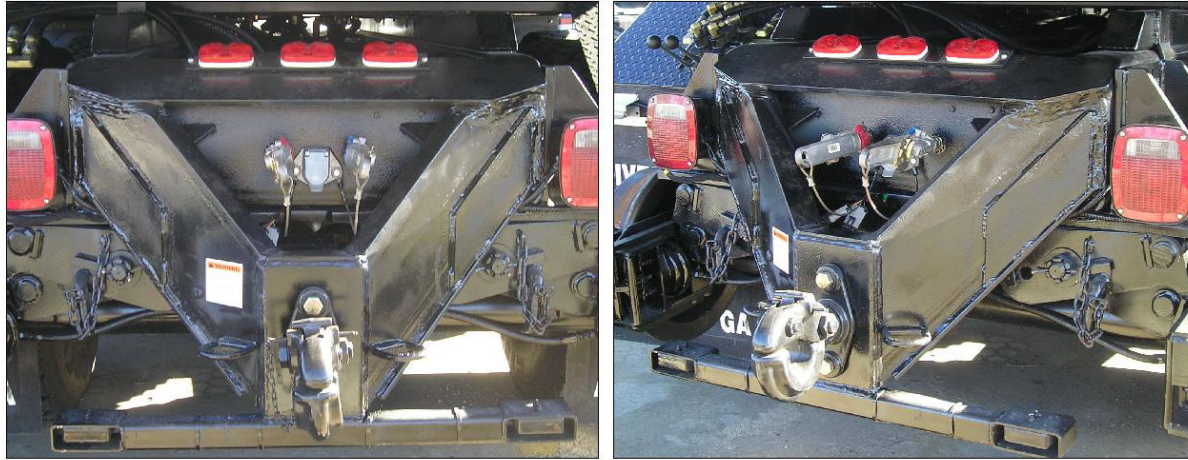
### Repair Affected Units

- Inspect area around notch, looking for cracks originating from notch area. Contact DMF if any cracks extend more than 1/2" into the web of the channel.
- Any cracks should be ground and welded.
- Surfaces to be welded should be cleaned and ground free of paint.
- Tack plates as shown, grind to fit if necessary.
- Weld as shown in attached drawing.
- DMF will supply flange reinforcement and fishplate. Note orientation of beveled edge on fishplate.
- Prime and paint to match.





## Diversified Metal Fabricators Service Bulletin SB 2046



**ROTO HITCH STRUCTURE - REPAIRED**  
EXTERIOR VIEW - PASSENGER SIDE

DMF will replace defective parts under DMF's warranty terms. DMF will not cover parts that have been subjected to gross overloading or blatant abuse. DMF may require the return of affected parts to determine coverage.

### **Diversified Metal Fabricators**

Phone: (404) 875-1512

Email: [info@dmfatlanta.com](mailto:info@dmfatlanta.com)

Web: [www.dmfatlanta.com](http://www.dmfatlanta.com)