



Diversified Metal Fabricators Service Bulletin SB 2080

Title	RW-1650GX, GRADALL XL3330-V & XL4330-V OUTER STRUCTURE REINFORCEMENT
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Purpose	Provide guidance to inspect and reinforce outer structure to prevent cracks.

Procedure:

The following figures show the structural welds requiring inspection. Inspect all the welds noting any that may have cracked. All striped patterns in the figures represent required welds.

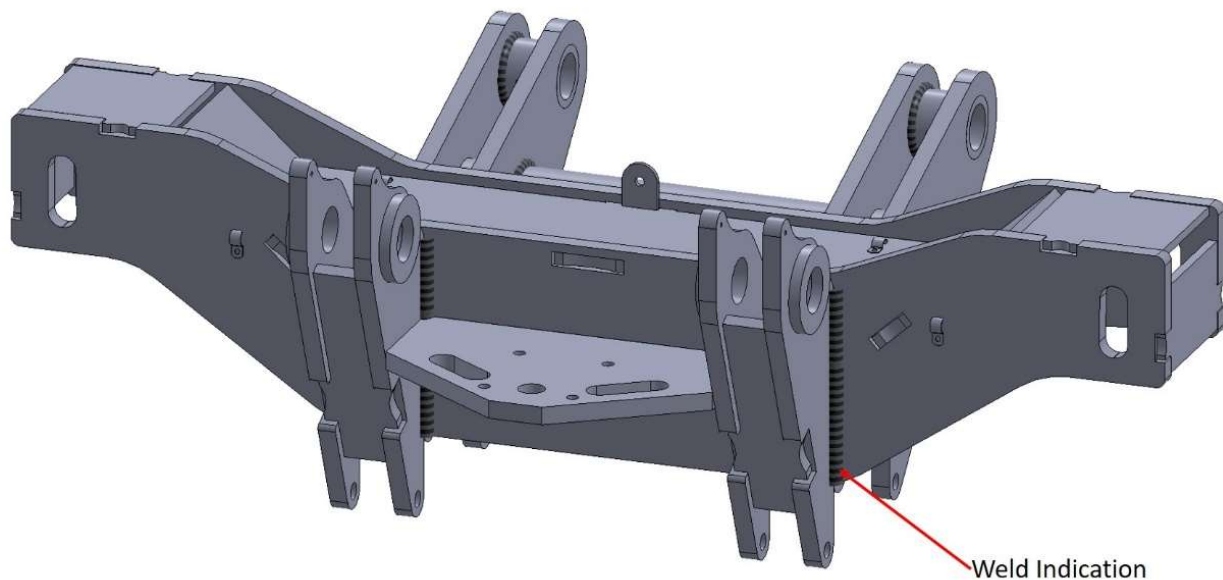


Figure 1 - Outer Structure Weldment Gradall XL-3300

Any missing, or partial welds should be welded as shown. To repair cracked welds, grind flush all of the old weld material. Ensuring all cracks have been removed before adding a new weld. The weld sizes have been called out in each figure. Some of these welds require additional passes to increase fillet size from 1/2" to 7/8". For these specific welds, the weld symbol has been highlighted and noted in Figure 2 and Figure 3.



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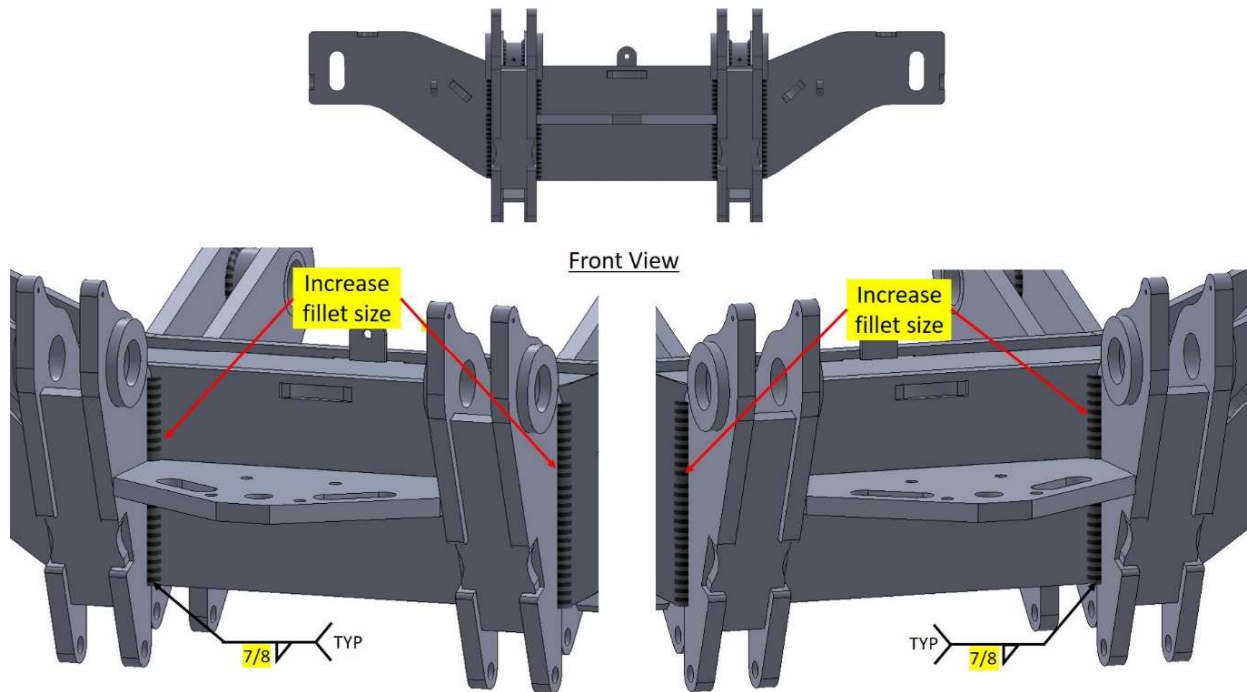


Figure 2 - Weld Inspection & Specification, Front View

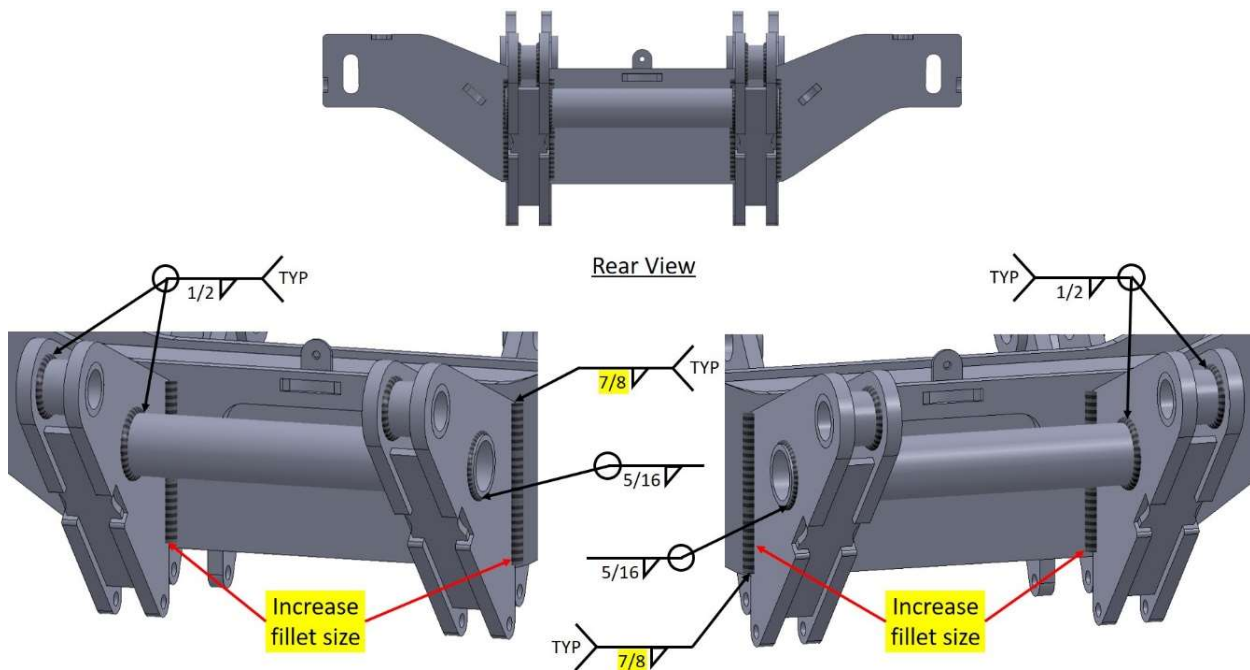


Figure 3 - Weld Inspection & Specification, Rear View

Figure 4 shows 2" long welds found between the Cylinder Mounting Plates at the front and the Frame Mounting Plates at the rear. These also need to be inspected and repaired if necessary.



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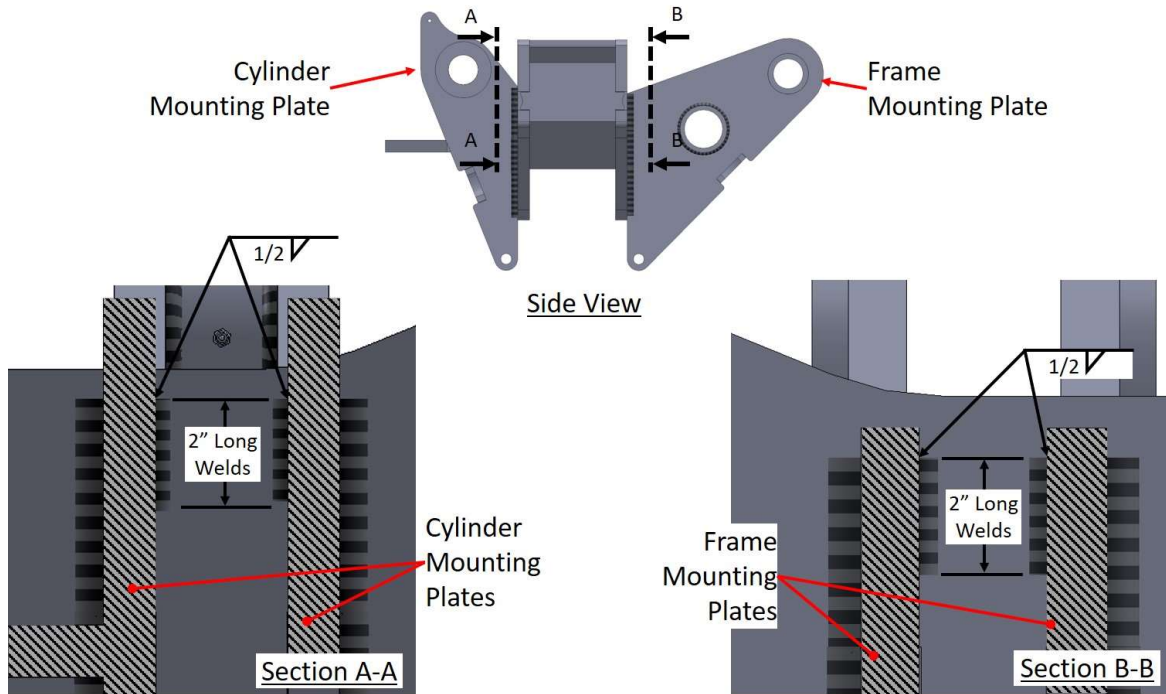


Figure 4 - Weld Inspection Inner Welds

For additional strength, contact DMF for Gusset Kit P/N 835223. These parts, which have been shown in green, include two gussets and a cross support for both the front and rear railgear. All are welded to the backside of the weldments. Use a 3/4" fillet on both sides as shown, see Figure 5 and Figure 6.

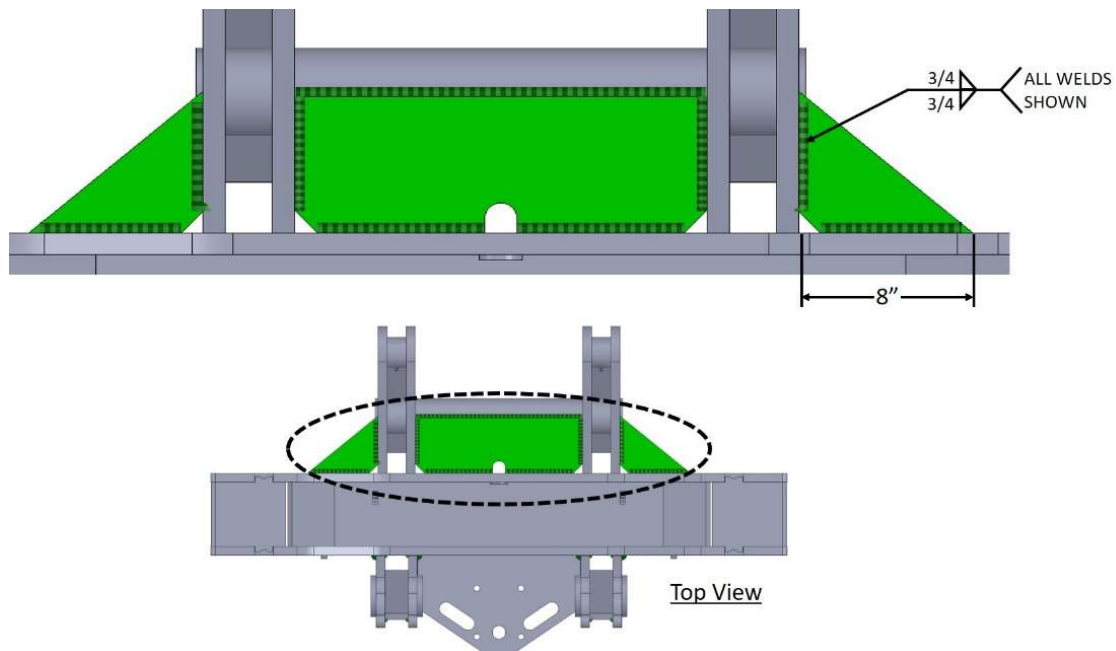


Figure 5 - Gusset Weld Specification



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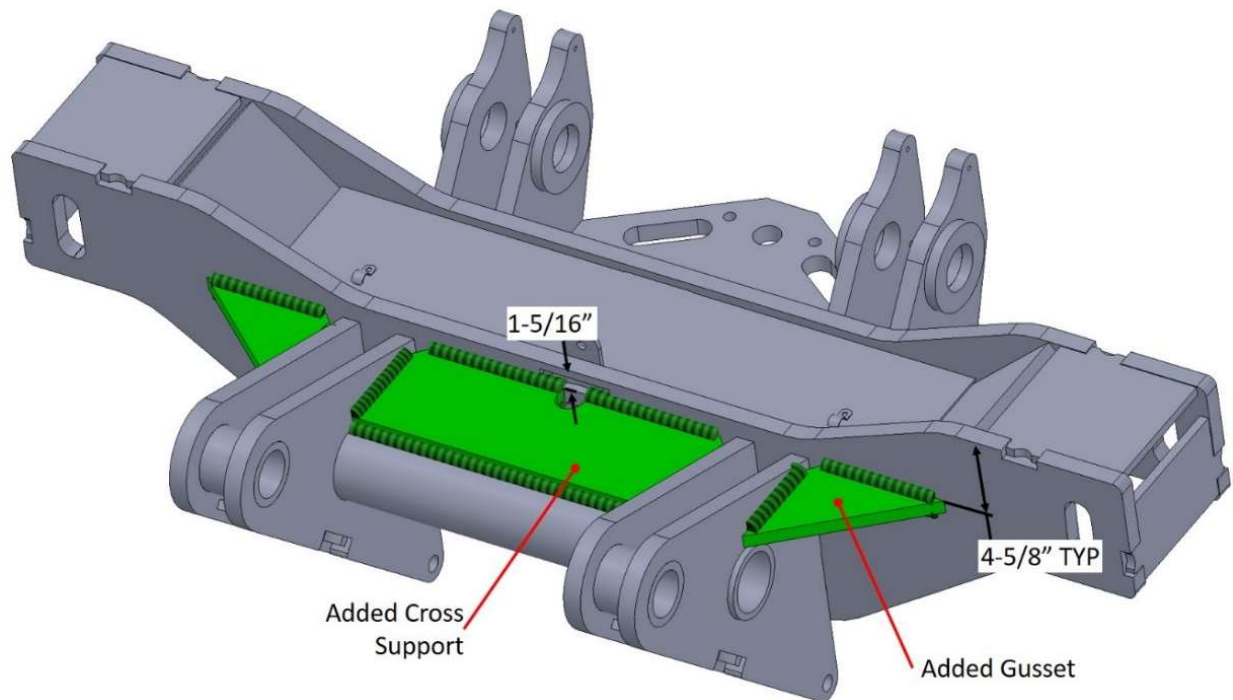


Figure 6 - Gusset Weld Placement

DMF will replace defective parts under DMF's warranty terms. DMF may require the return of affected parts to determine coverage.

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