

S0026 Repair SB330 Load Transfers

S0026	Version 1	Structural	30-03-06
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Repair SB330 Load Transfer:

The following is a procedure for repairing the Load Transfers when damaged.

Inspection of the Load Transfer blocks:

The Load Transfer blocks should be measured as per the detail below:

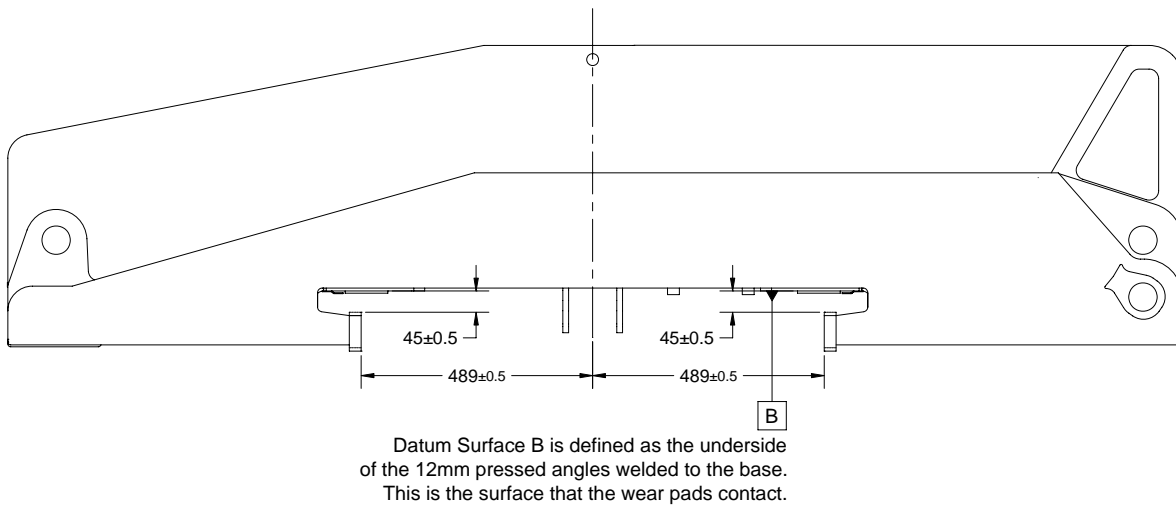


Figure 1: End view of base showing transfer block positions.

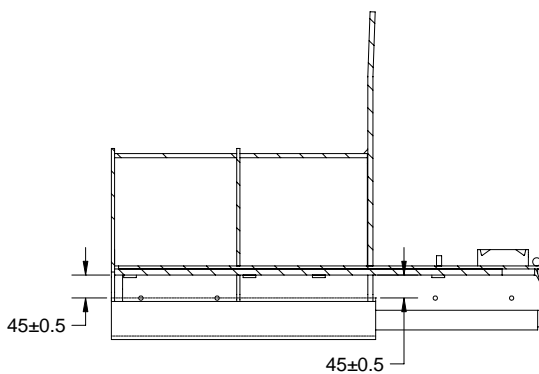


Figure 2: Sectional view of base showing side view of transfer block.

If the Load Transfer Blocks are substantially damaged then these will require replacement. The part number for the replacement block is S3-26031.

1. Cut-off the damaged load transfer block by removing the minimum possible amount of material from the three crane base web plates. These must be cleaned up and prepared as per weld specification WP-25697.
2. Position the replacement load transfer block(s) as per the dimensions above and weld as per specification WP-25697.
3. If too much material is removed from any of the crane base web plates then an 8mm doubler of 690 MPa steel will need to be fitted to the web in order to ensure adequate material strength is maintained.

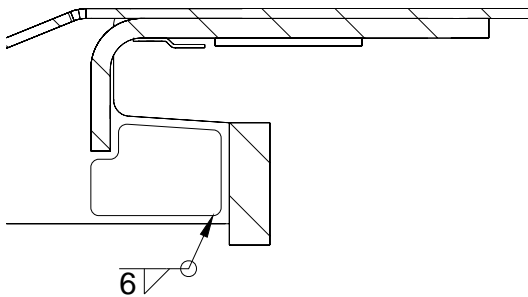


Figure 3: Sectional view of transfer block showing doubler on base web.