

These instructions describe the repair of the Frame Front Plates.

Read these instructions thoroughly before beginning the procedure.

 **CAUTION**

Use all applicable safety precautions while working on, around, or under any machinery.

REVISION LOG

- A - April 2018

MODELS AFFECTED

- 6036, 6042
(SN 0160083775 thru 0160083925
including 0160083362, 0160083772, 0160083773
excluding 0160083908 thru 0160083910, 0160083915
thru 0160083919, 0160083921)

REQUIRED TOOLS

- Hand-held Power Grinder
- Standard Welder Tools
- Electric Welding Equipment
- AWS 70 Grade, Low Hydrogen Rod or Wire
- Standard Mechanic Tools
- Paint

REQUIRED PERSONNEL

- Qualified Equipment Mechanic
- Certified Welder

PROHIBITED OPTIONS/ITEMS

- None

REQUIRED OPTIONS/ITEMS

- None

Note: Parts referenced on or removed from machine are indicated alphabetically (A, B, C... AA, AB, AC, etc.).

GENERAL REPAIR GUIDELINES

1. This repair procedure provides repair information for specific discrepancy. It is responsibility of the entity performing the repair to determine if the discrepancy can be corrected by this procedure.
2. Reference the service and specification manuals and illustrated parts manual for safe and proper disassembly/assembly procedure.

WELD REPAIR GUIDELINES

1. All welding being performed on JLG equipment must be in strict accordance with the appropriate market standards for the material being welded. Below are the applicable welding standards for North America, Europe and Australia.

Steel:

- ANSI/AWS D1.1
- EN ISO 1011-1
- AS/NZS 1554.1

Aluminum:

- ANSI/AWS D1.2
- EN ISO 1011-4
- AS/NZS 1665

2. Disconnect the battery of the machine being repaired prior to welding.
3. Ground only to the component being welded. Do Not ground to any adjacent component or allow pins, wear pads, wire ropes, bearings, gears, seals, valves, electrical wiring, or hoses to be between the grounding position and the area to be welded.

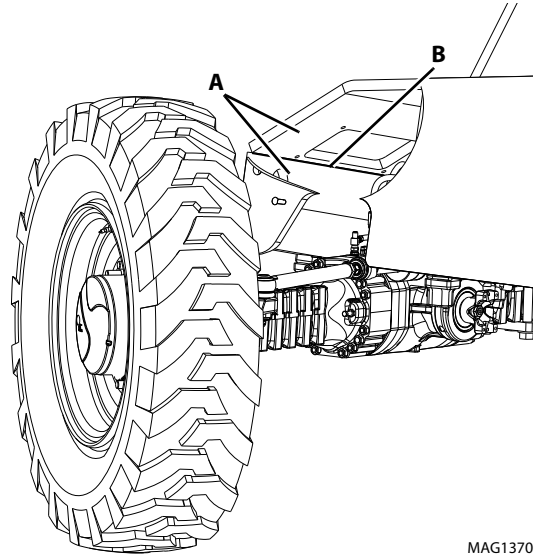
NOTICE

Failure to comply with the above weld repair guidelines may result in component damage.

MACHINE PREPARATION

1. Park machine on a firm level surface, level machine, fully retract boom and level boom.
2. Turn the front wheels to the right and tilt machine to the right.
3. Place the transmission control lever in (N) NEUTRAL, engage the park brake and shut the engine OFF.
4. Place a Do Not Operate Tag on both the ignition key switch and steering wheel.
5. Open the engine rear and side doors. Allow the system fluids to cool.
6. Properly disconnect the battery. Refer to appropriate service manual for detailed battery(s) disconnect/connect instructions.

PRELIMINARY PROCEDURE



MAG1370

1. Inspect the underside of the front plates (A), to verify if there is a weld present at joint (B). If weld is present, no further action is required. If weld is not present, proceed with below steps.
2. Remove components as required to facilitate repair. Refer to the appropriate Service Manual, for detailed procedure.

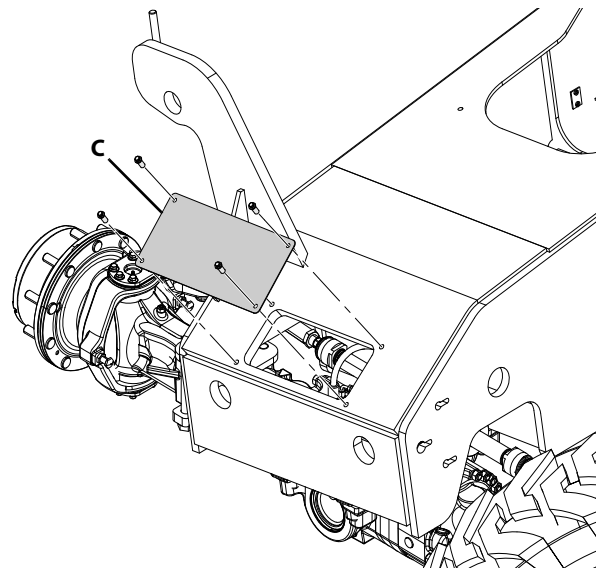
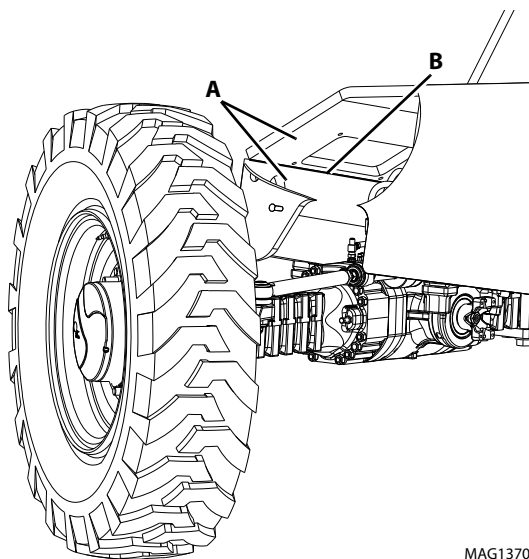


Figure 1. Front Panel

3. Remove and retain hardware and front panel (C) from frame.
4. Protect all hoses, wires, and hydraulic cylinder rods before preparing or welding in the axle mount area.

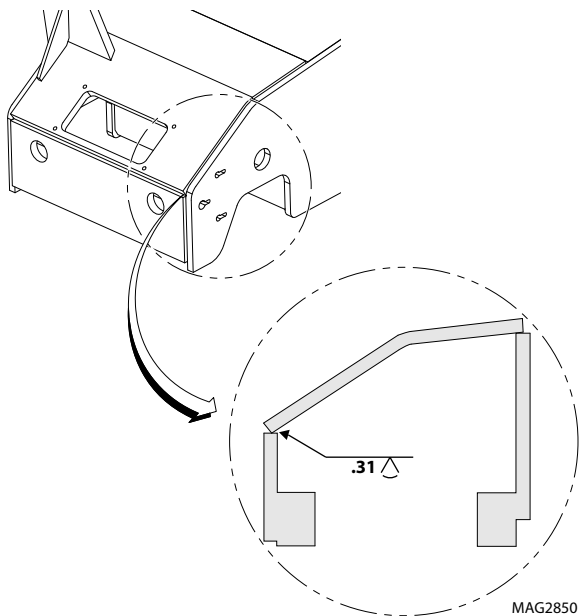
FRAME FRONT PLATES WELD PROCEDURE



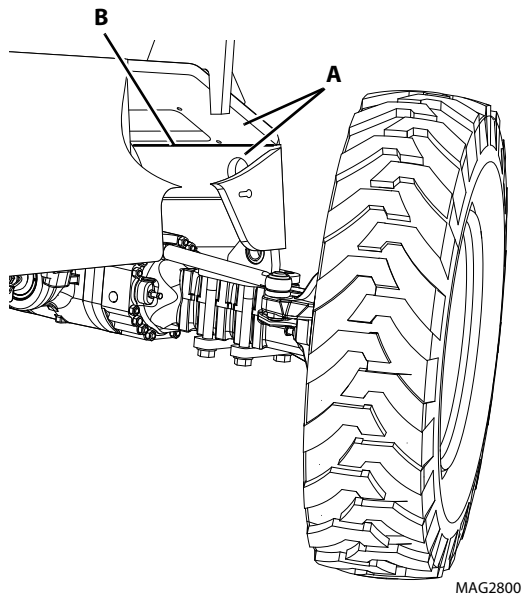
1. Thoroughly clean the front plates (A) (i.e., dirt, grease, rust, paint, etc.), in area to be welded.

NOTICE

Do Not damage the parent metal during this procedure.



2. Weld the left half of joint (B) per the weld details above.



3. Properly connect the battery. Refer to appropriate service manual for detailed battery(s) disconnect/connect instructions.
4. Turn the front wheels to the left and tilt machine to the left.
5. Properly disconnect the battery. Refer to appropriate service manual for detailed battery(s) disconnect/connect instructions.
6. Repeat step 1 and weld right half of joint (B).
7. Ensure that joint (B) welded completely.
8. Inspect the welds by using dye-penetrant or other acceptable weld inspection methods to ensure that there are no cracks or deformities. If any cracks or deformities exist, grind to remove affected area(s) and repeat the weld and inspection process.
9. Mask the surfaces or parts which are unaffected before paint.
10. Clean, prime and paint the affected areas.
11. Remove all protective coverings from hoses, wires, and cylinder rods.
12. Install the previously removed components to the machine. Refer to the appropriate Service Manual, for detailed procedure.
13. Reinstall front panel (C) on frame with previously removed hardware. Refer Figure 1.
14. Properly connect the battery. Refer to appropriate service manual for detailed battery(s) disconnect/connect instructions.
15. Close and secure the side and rear engine doors.
16. Remove Do Not Operate Tag from both the ignition key switch and steering wheel.
17. Return machine to service.

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