

1.1 GENERAL GUIDELINES

- This repair procedure provides repair information for a specific discrepancy. It is the responsibility of the entity performing the repairs to determine if the discrepancy can be corrected by this procedure. This repair is only for the replacement of the rear axle weldment.
- After inspection, if only weld cracks and NO plate deflection is found, refer to instructions 31212011.
- After inspection, if weld cracks AND plate deflection is found, complete the Rear Axle Block Weldment Replacement Instructions.

NOTICE

Reference the Service Manual for safe and proper disassembly/assembly procedures.

1.2 WELD REPAIR GUIDELINES

- All welding must be in accordance with ANSI/AWS D1.1 Standard.
- Disconnect the battery of the machine being repaired prior to welding.
- 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.

1.3 TOOLS & EQUIPMENT REQUIRED

1. Stands and lifting equipment capable of lifting/supporting the affected components
2. Hand-held power grinder
3. Air carbon-arc equipment
4. Electric welding equipment
5. AWS 70 grade, low hydrogen rod or wire
6. Standard welder tools
7. Standard mechanic tools
8. Paint

1.4 PERSONNEL REQUIRED

1. Qualified **JLG** Equipment Mechanic
2. Certified Welder

1.5 PARTS LIST

| P/N | Qty | Description |
|----------|-----|--------------------------|
| 91476013 | 1 | Rear Axle Weldment Block |


1.6 REAR AXLE BLOCK WELDMENT REPLACEMENT

1. Remove any attachment from the machine.
2. Park the machine on a firm, level surface with the machine level, retract and level the boom. Place the transmission control lever in the (N) NEUTRAL position and engage the parking brake. Shut the engine OFF.
3. Place a Do Not Operate Tag on both the ignition key switch and the steering wheel, stating that the machine should not be operated.
4. Open the engine cover. Allow system fluids to cool.
5. Properly disconnect the battery.
6. Properly support the frame to alleviate pressure or stress at the affected repair area.
7. Remove components as required to facilitate repair. Refer to the machine Service Manual for proper disassembly procedures.

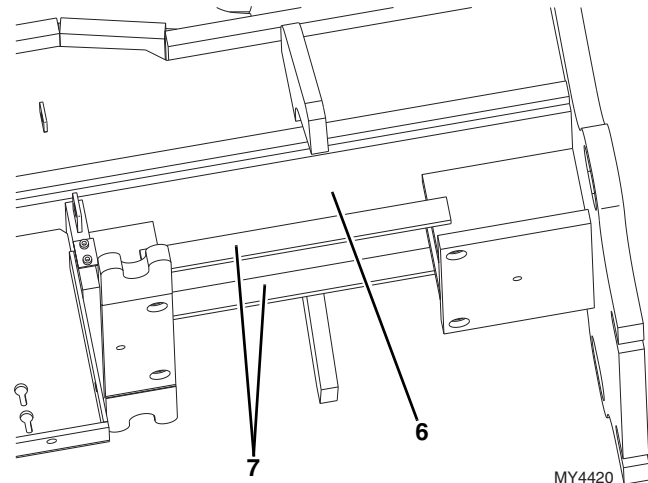
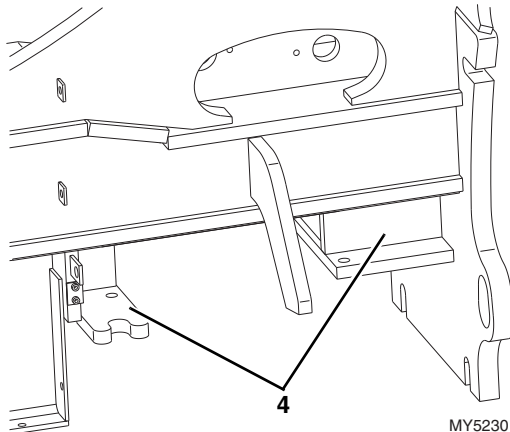
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8. Protect any hoses, wires and hydraulic cylinder rods before preparing or welding in the axle mount area.

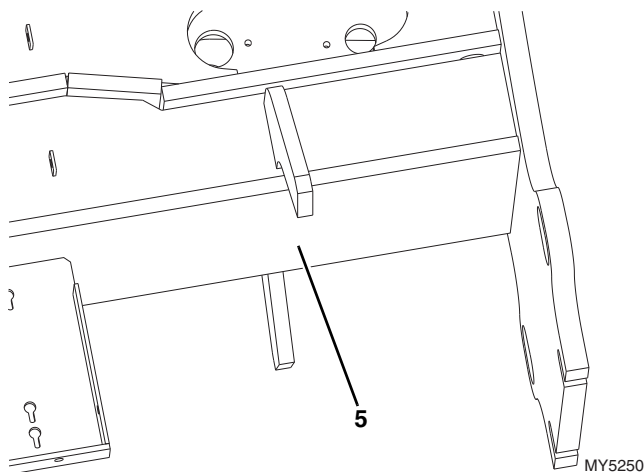


9. Use air carbon-arc equipment or a portable power grinder to remove the damaged rear axle mount weldments (4) from the frame weldment.

NOTICE

Do not damage the parent metal during this procedure.

10. Inspect the affected areas for cracks. If any discrepancies are evident, notify a certified welder for further evaluation.



11. Prepare the repair area (5) for the installation of the new rear axle weldment.

12. Locate the Axle Weldment (6) P/N 91476013 using 1.6.1 "Rear Axle Weldment Welding Locations" on page 3. Tack weld into position.

13. Weld the rear axle weldment into place using the recommended weld material.

14. Inspect welds using the magnetic particle or dye-penetrant inspection methods to assure there are no cracks or deformities. If any cracks or deformities exist, grind to remove affected area(s) and repeat the weld and inspection procedures.

15. Remove the weld bars (7) from the rear axle weldment.

NOTICE

Do not damage the rear axle weldment during this procedure.

16. Clean, prime and paint the affected areas.

17. Install previously removed components. Refer to the machine Service Manual for proper assembly procedures.

18. Remove all protective coverings from any hoses, wires and hydraulic cylinder rods.

19. Properly connect the battery.

20. Close and secure the engine cover.

21. Cycle the drive, steer and frame level functions a minimum of five times.

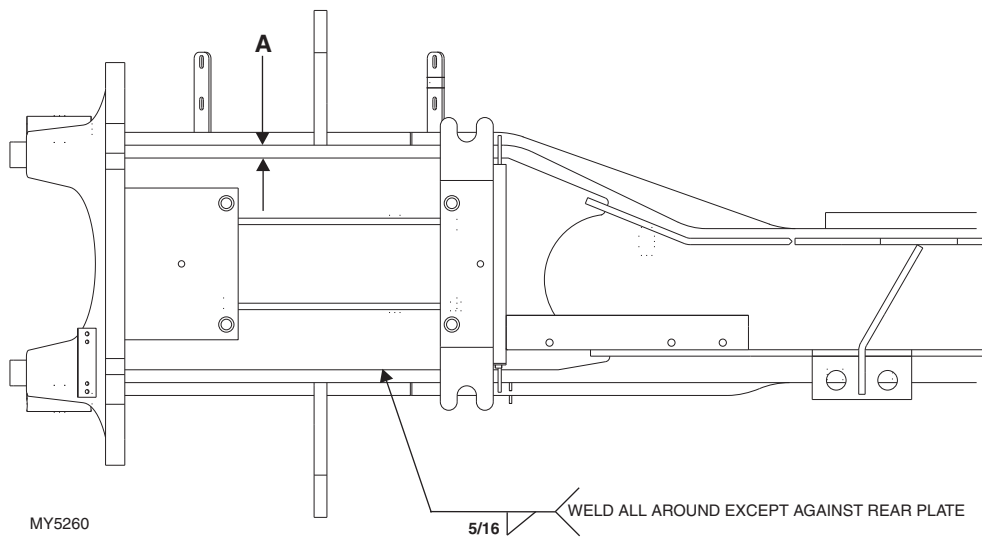
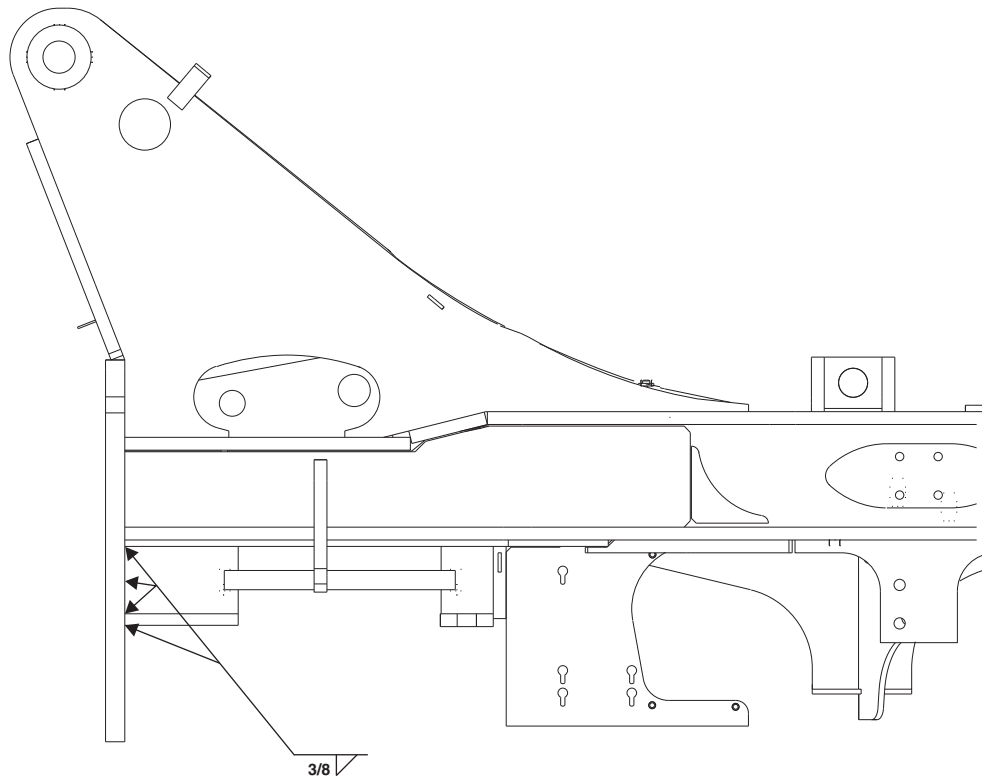
22. Verify proper clearance between the frame, rear axle, hydraulic hoses and electrical wires.

23. Install the previously removed attachment.

24. Remove the Do Not Operate Tag from the ignition key switch and the steering wheel.

25. Return machine to service.

1.6.1 Rear Axle Weldment Welding Locations



A. 1.0 in (25,4 mm)

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