



**WISDOM
INDUSTRIES, Ltd.**

SAFETY BULLETIN

DATE: FEBRUARY 7, 2006

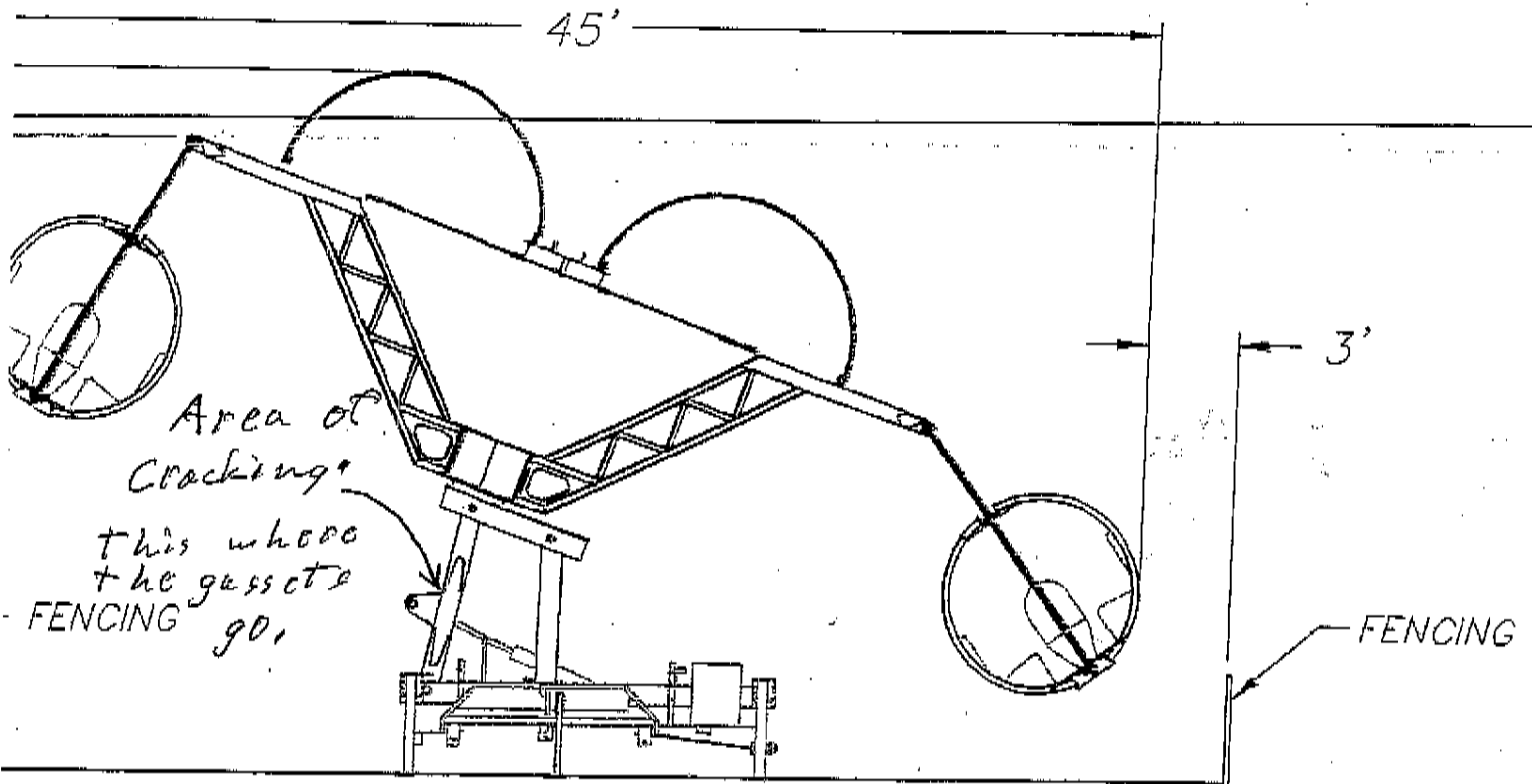
RIDE: TORNADO

SUBJECT: LIFT ARM REINFORCEMENT

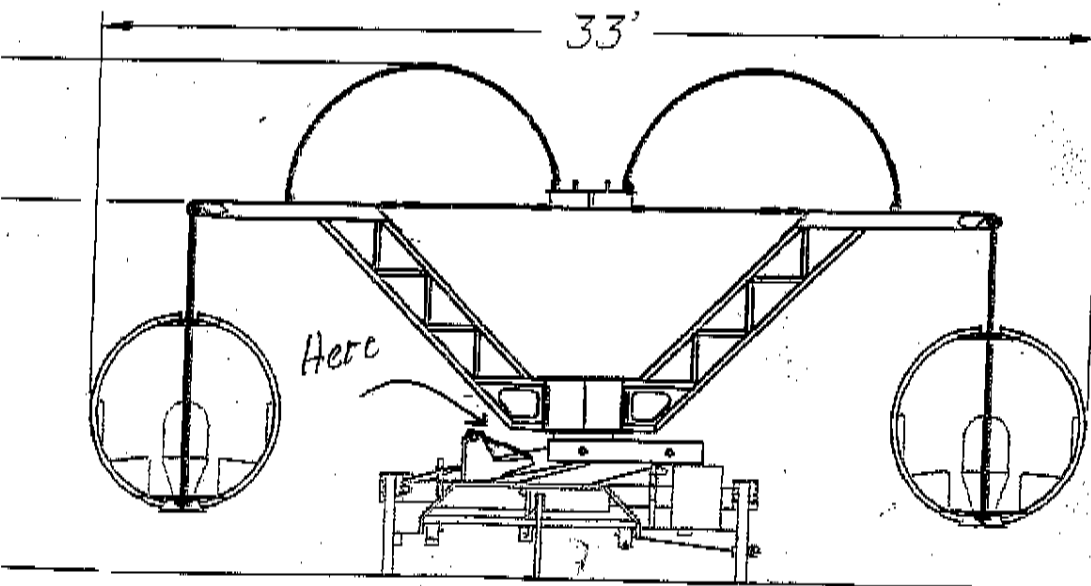
**COMPLIANCE DATE: 1 MONTH WITH DAILY
INSPECTION UNTIL INSTALLED.**

- 1. Install 4 reinforcing gussets on the Tornado lift arm.**
- 2. Clean area where plates are to be installed.**
- 3. Inspect arm for cracks.**
- 4. "V" any cracks.**
- 5. Weld cracks with 7018 low hydrogen rod.**
- 6. Weld reinforcing gussets to side plates.**
- 7. Inspect welds for cracks.**
- 8. Prime and paint new metal.**

**If you have any questions, contact Wisdom Industries,
Ltd. at 970-522-7515.**



EXTENDED POSITION



LOADING POSITION

SIDE VIEW

5/16 INCH PLATE

4 PLATES

PLACE ON SIDE CLOSEST TO CENTER

BEVEL EDGE OF GUSSET AND EDGE OF EXISTING PLATE
REMOVE PAINT FROM AREA TO BE WELDED.

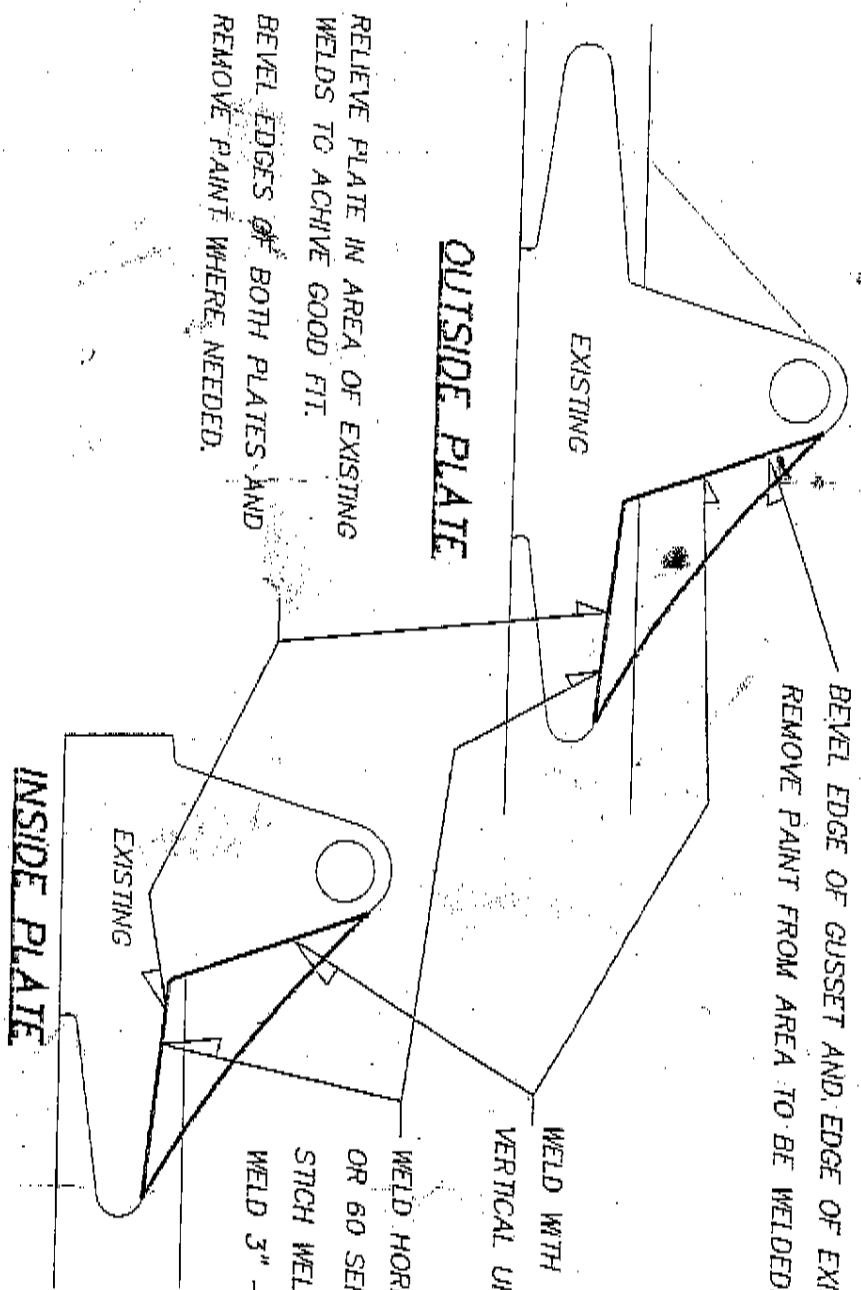
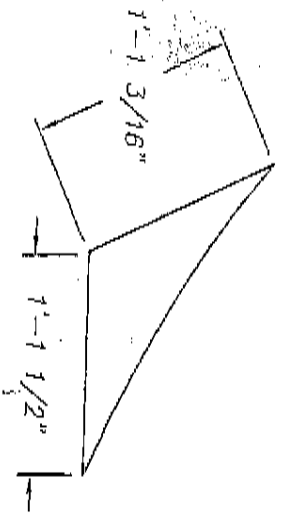
OUTSIDE PLATE

RELIEVE PLATE IN AREA OF EXISTING
WELDS TO ACHIVE GOOD FIT.
BEVEL EDGES OF BOTH PLATES AND
REMOVE PAINT WHERE NEEDED.

WELD WITH 7018 ROD OR 60 SERIES WIRE.
VERTICAL UP ; FULL PENETRATION.

WELD HORIZONTAL USING 7018 ROD
OR 60 SERIES WIRE. FULL PENETRATION.
STICH WELD BACK SIDE TO TUBE.
WELD 3" ---SKIP 3" ON WELDS TO TUBE.

INSIDE PLATE



WISDOM INDUSTRIES
Merino, CO 80741

SCALE: 1"=1'-0" APPROVED BY:

DATE: 08-28-96 DRAWN BY: MFK

DESCRIPTION: CYLR SHAFT MFG PLATE GUSSET

EQUIPMENT: TORNADO DRAWING NUMBER: BT 312

AUG 28, 1996 - 14:30:26 < F:\TORNADO\BT312.DWG >