



June 29, 2009

Dear Cottrell owner:

You will find enclosed Service Bulletin #SB007 for the installation of reinforcement gussets on the rear of the tractor frame for certain Cottrell 3-Car Headramps.

Our records indicate that you are the current owner of the Cottrell 3-Car Headramp(s) that is affected by Service Bulletin #SB007. The Vehicle Identification Number(s) of your affected tractor(s) are indicated on the attached cover sheet. Please read Service Bulletin #SB007 and have the tractor frame modified as soon as possible according to the instructions provided.

If you no longer own the tractor(s) identified on the enclosed cover sheet, please indicate new owner in the "sold to" section of the cover sheet and return to us at the address below:

Cottrell, Inc.
2125 Candler Rd.
Gainesville, GA 30507
Attn: Technical Publications

The Cottrell Service Center (800-827-0132), Authorized Cottrell Dealers, or any Authorized Cottrell Warranty Repair Facilities may perform the modification. You can access a list of these facilities at www.cottrelltrailers.com under "Service Centers".

Parts required to perform Service Bulletin #SB007 are available through Cottrell Parts Supply (800-827-0132) or from any Authorized Cottrell Dealer.

Cottrell will reimburse a maximum of 3 ½ hours labor at a maximum of \$75.00 per hour, plus a \$25 paint allowance. Requests for reimbursement can be submitted with receipt to the above address or handled directly through the repair facility under normal procedure. This service bulletin shall remain open for 1 calendar year.

Should you have any questions concerning this bulletin, please contact Cottrell or your Authorized Cottrell Dealer.

Sincerely,

Kris Ransom
Warranty Coordinator
Cottrell, Inc.
800-827-0132 ext 301



June 29, 2009

Service Bulletin #SB007

Subject: 3-Car Headramp Tractor Frame Reinforcement

Models Affected: Certain Cottrell 3-Car headramps manufactured prior to November 5, 2008

Cottrell has determined that premature stress cracks may arise in the tractor frame on frames having model 3-Car Headramps. New gussets have been designed to prevent such premature cracking in these areas. Inspect the rear of the tractor frame and if cracks are present then call Cottrell, Inc. immediately for further instructions. If no cracks are present then follow instructions below.

Owners must install these four (4) gussets per the drawing enclosed as soon as possible.

Instructions for installing the two (2) gussets (part #117694), and two (2) gussets (part #117695) on tractor frames with 3-Car headramps, making up kit #117693.

General Notes:

1. Welds must conform to ANSI/AWS D1.1 standards using MIG or stick electrode.
2. For stick: welding electrode must conform to AWS E7018 minimum standards.
For MIG: welding wire must conform to AWS ER70s-3 minimum standards.
3. Welded area must be free of moisture, scale, dirt, paint, and grease. Prep surface area as necessary.

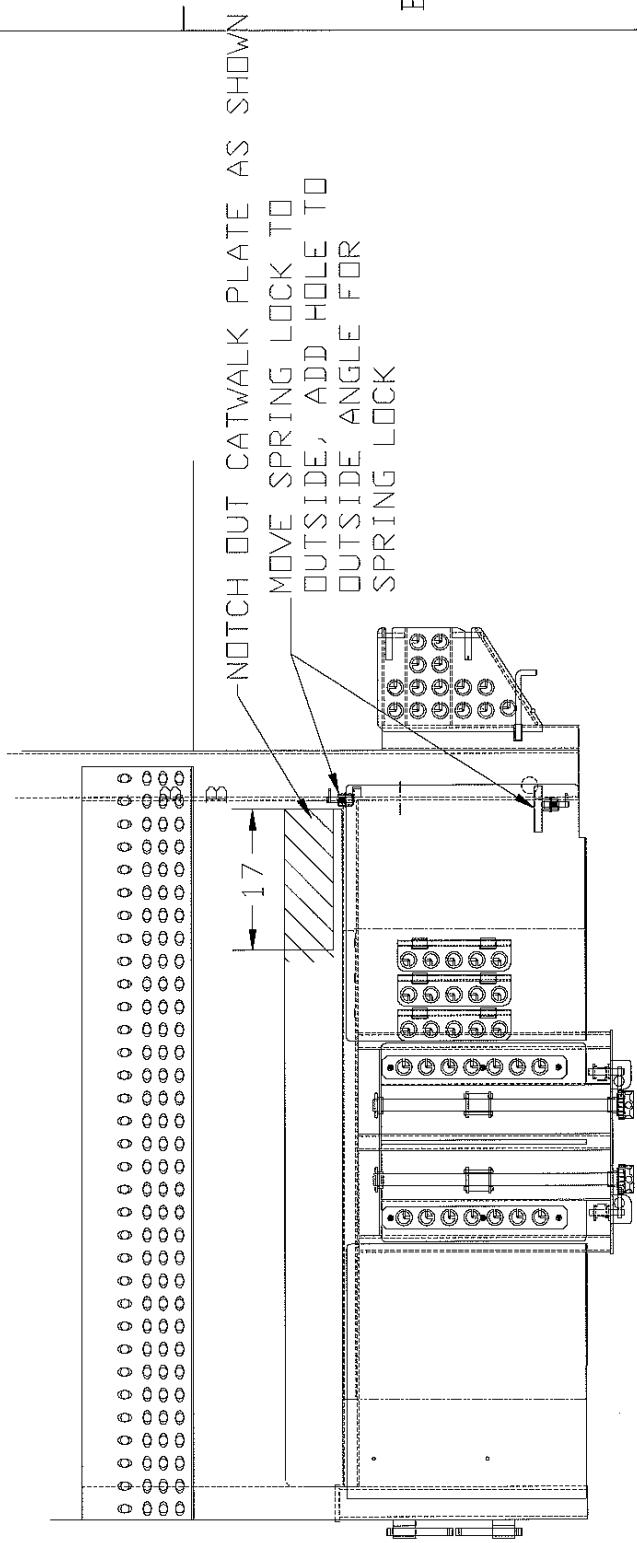
Installation Notes:

1. Shield all air, electrical and hydraulic lines in area of repair from weld spatter and sparks.
2. Notch out catwalk plate as shown in drawing #117693, page 1.
3. Relocate rear spring lock to outside, add hole to outside angle for spring lock, and weld spring lock into new location, as seen in drawing #117693, page 1.
4. Install plate #1 (#117694), per drawing 117693 page 2, welding in-board side to the tractor frame, and out-board side to the headramp crossmember and stinger assembly crossmember, being sure to leave a gap at the end of each weld.
5. Install plate #2 (#117695), per drawing 117693 page 2, welding out-board side to newly installed plate #1 and in-board side to headramp crossmember and stinger assembly crossmember, being sure to leave a gap at the end of each weld.
6. Touch up as required with primer and paint.


4 3 2 1

ECC NUMBER	ZONE	REV	REVISION-DESCRIPTION	DATE	BY	CHECKED
ECC						

C B C B



NOTCH OUT CATWALK PLATE AS SHOWN
 MOVE SPRING LOCK TO OUTSIDE, ADD HOLE TO OUTSIDE ANGLE FOR SPRING LOCK

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	DEGREES: 22?		ORIG DATE: —		PRIG. BY: —		MAKE FROM —		PART YIELD —		
	FRACTIONS: 11/16		CHK BY: —		PRIG. DATE: —		FINISH —		WEIGHT —		
	DECIMALS: .X ? .060 .XX ? .030 .XXX ? .010		CHK DATE: —		TITLE		FRAME RAIL REINFORCEMENT		PART NO. 117693		
				3		2		1		SHEET 1 OF 2	

4 3 2 1

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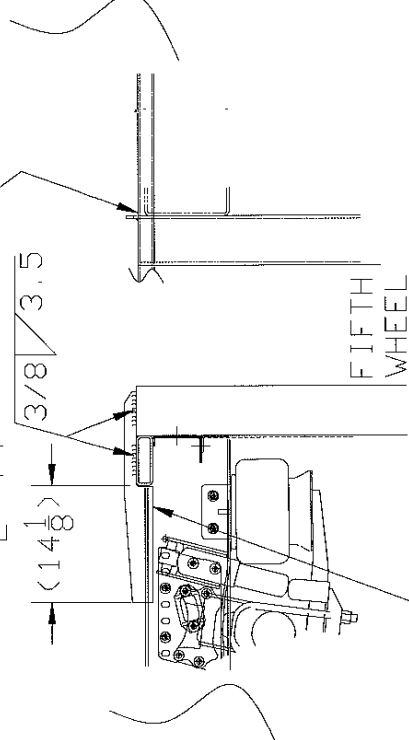
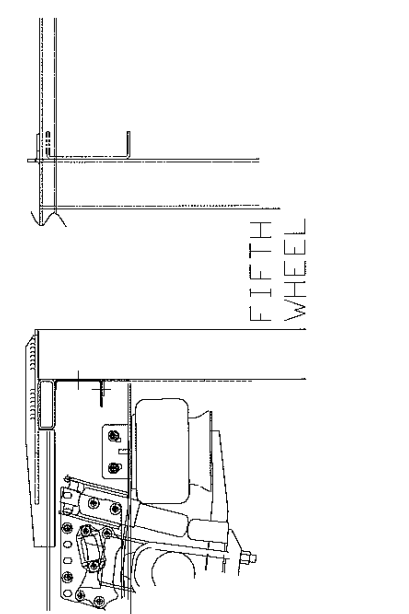
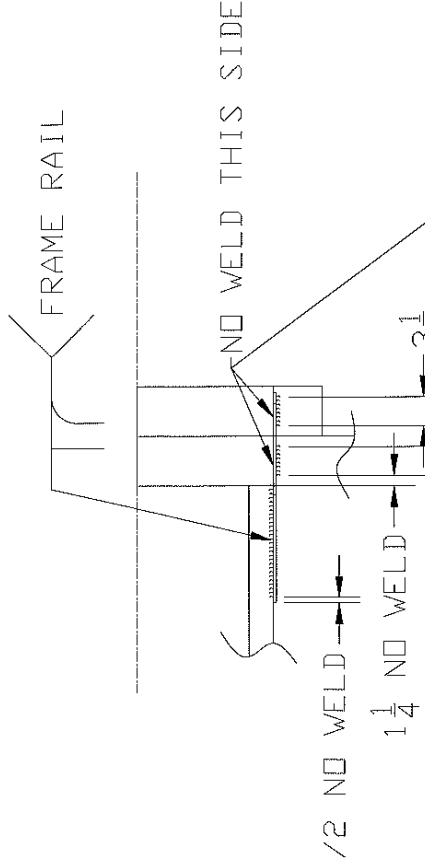
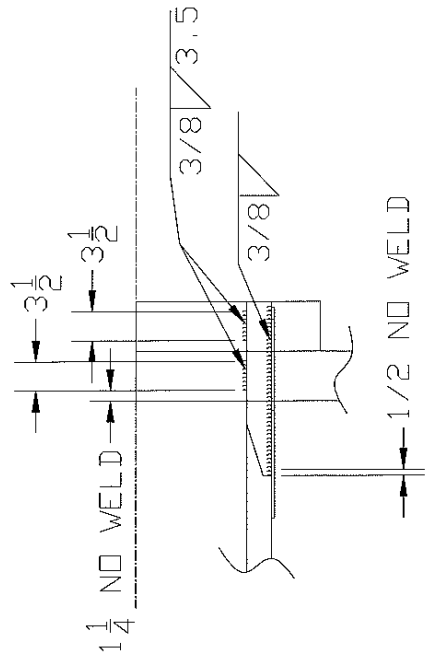
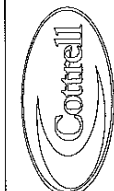


PLATE 2

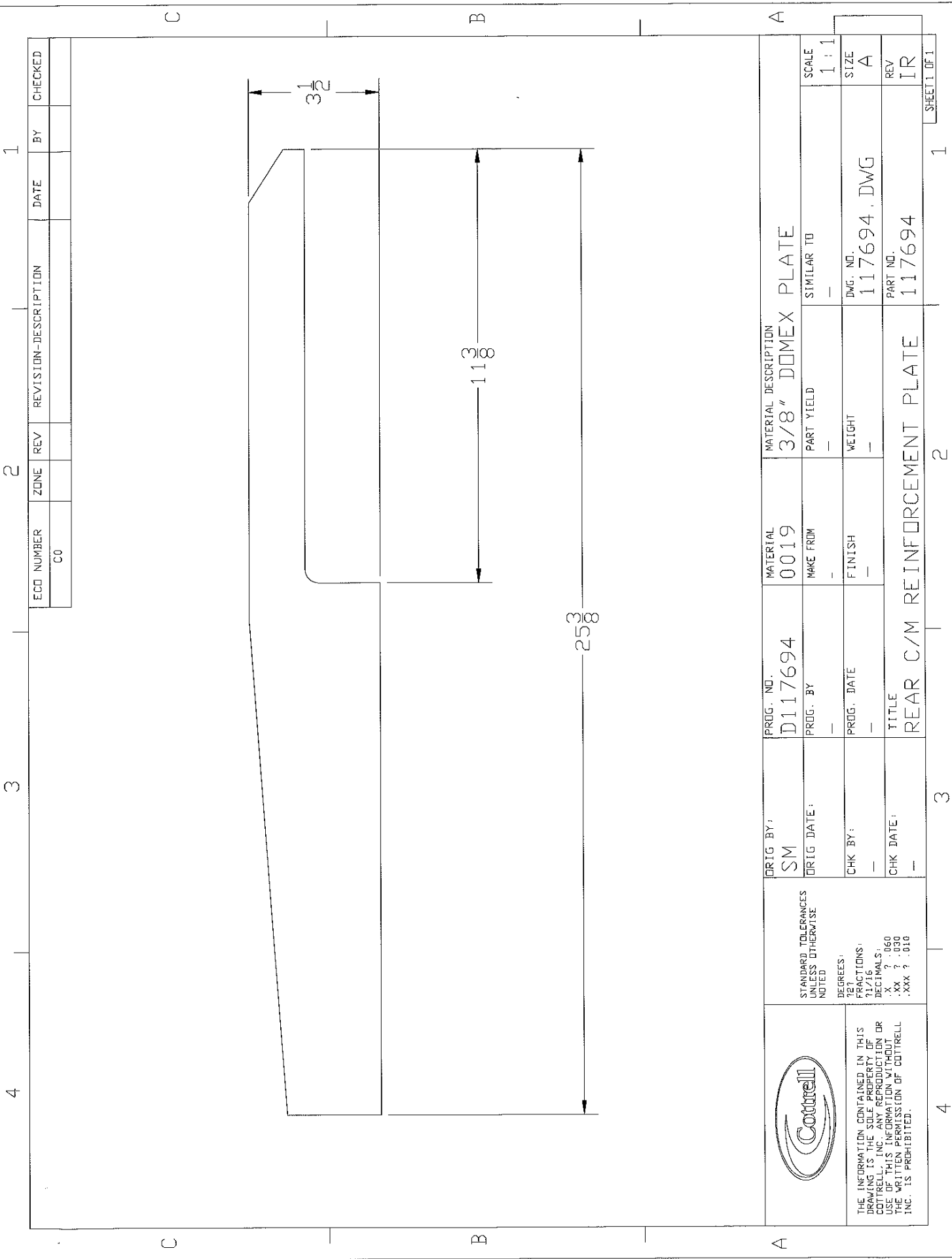
NO WELD ON BOTTOM

PLATE 1

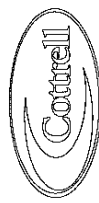


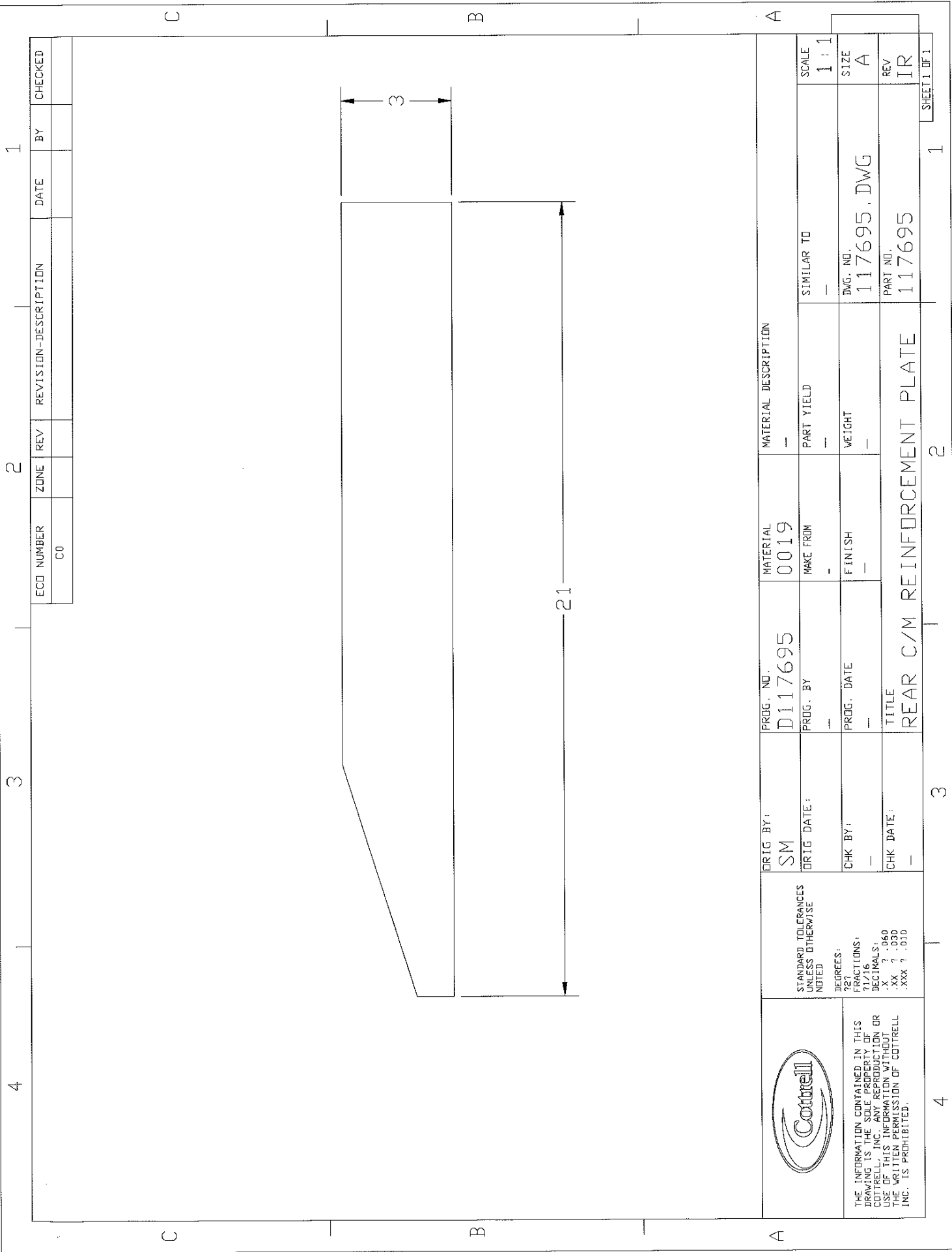
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STANDARD TOLERANCES UNLESS OTHERWISE NOTED	ORIG BY: DST	PROG. NO.	MATERIAL	MATERIAL DESCRIPTION	SIMILAR TO	SCALE 1:1
DEGREES: FRACTIONS: "1/16 DECIMALS: "X" ? .060 "XX" ? .030 "XXX" ? .010	ORIG DATE:	PROG. BY	MAKE FROM	PART YIELD	—	SIZE A
	CHK BY:	PROG. DATE	FINISH	WEIGHT	—	REV IR
	CHK DATE:	TITLE			117693	SHEET 2 OF 2
		FRAME RAIL REINFORCEMENT				1




ECD NUMBER	ZONE	REV	REVISION-DESCRIPTION	DATE	BY	CHECKED
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 <p>THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF COTTRELL, INC. ANY REPRODUCTION OR USE OF THIS INFORMATION WITHOUT THE WRITTEN PERMISSION OF COTTRELL, INC. IS PROHIBITED.</p>	STANDARD TOLERANCES UNLESS OTHERWISE NOTED	ORIG BY: SM	PROG. NO. D117694	MATERIAL 0019	MATERIAL DESCRIPTION 3/8" DOMEX PLATE	SCALE 1:1	
	DEGREES: 72?	ORIG DATE:	PROG. BY:	MAKE FROM:	PART YIELD:	SIMILAR TO:	
	FRACTIONS: 71/16	CHK BY:	PROG. DATE:	FINISH:	WEIGHT:	DWG. NO. 117694.DWG	SIZE A
	DECIMALS: .X ? .060 .XX ? .030 .XXX ? .010	CHK DATE:	TITLE REAR C/M REINFORCEMENT PLATE			PART NO. 117694	REV IR
			4	2		1	SHEET 1 OF 1



ECD NUMBER	ZONE	REV	REVISION-DESCRIPTION	DATE	BY	CHECKED
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	DEGREES: ?	ORIG DATE:	PROG. BY: -	MAKE FROM: -	PART YIELD: -	SIMILAR TO: -	SCALE: 1:1
	FRACTIONS: 1/16	CHK BY: -	PROG. DATE: -	FINISH: -	WEIGHT: -	DWG. NO. 117695.DWG	SIZE: A
	DECIMALS: .X ? .060 .XX ? .030 .XXX ? .010	CHK DATE: -	TITLE: REAR C/M REINFORCEMENT PLATE	PART NO. 117695		REV: IR	