

Dokument-Nr./ <i>Doc. ID.:</i> KD15003	Ersteller/ <i>Author:</i> SJ/IG	Unternehmen / <i>Company</i> Doppelmayr Seilbahnen GmbH, Wolfurt	Datum/ <i>Date:</i> 17.03.2015	Seite/ <i>Page</i> 1 / 4	
Ersatz für/ <i>Supersedes:</i> KD11009	Ersetzt durch/ <i>Replaced by:</i> -	Type: CLD, MGD, CGD	Baugruppe/ <i>Assembly group:</i> Grips		
Abgeleitet von / <i>Based on:</i>					
Classification Code:	X	OS	O	IS	I

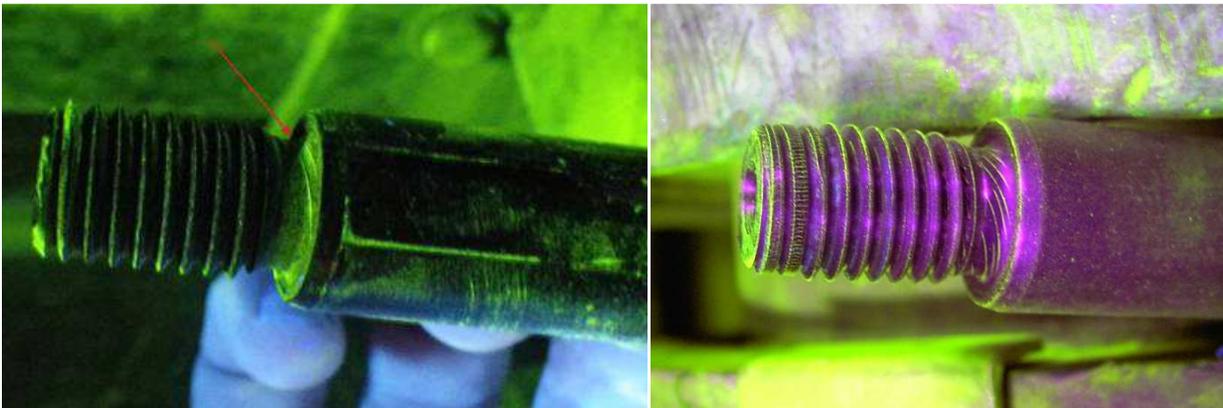
Please attach this Bulletin to the operation and service manual of the installation(s) concerned.

Revision of Bulletin KD11009:

Item 1 on page 2 has been added (facilitation: no reworking required for indications according to item 1)

Detachable Grips Type A – Spring Guide Slide Rods

In the course of the recurrent non-destructive testing, there were indications found on the spring guide slide rods in the area of the undercut and the thread (see photos).

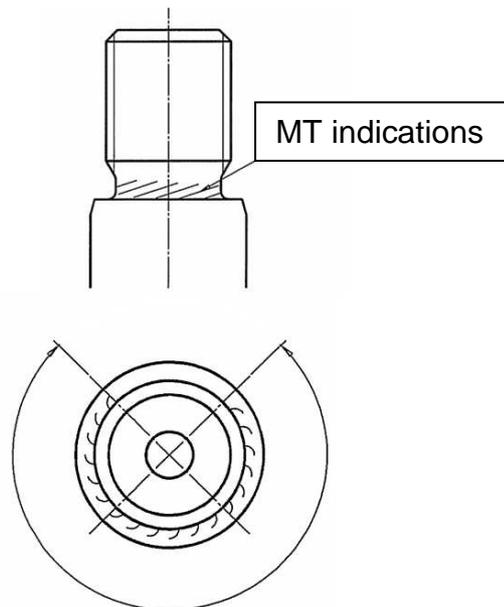


- So far examined indications showed different numbers and lengths.
- In most cases, several smaller indications were distributed along $\frac{1}{4}$ to $\frac{3}{4}$ of the circumference.
- The indications were ground in the area of the undercut until no indications remained. The maximum grinding depth to achieve this was 0.2 mm, which means that all indications were located in the nitrocarburized layer of the material.
- A spring guide slide rod with indications was then subject to rigid fatigue testing performed with double load and approximately 10 times the load cycles that occur on an average installation in 30 years. Upon completion of this extreme test, no indications of fatigue were found

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If rusty indications are found during the routine maintenance works or if indications are found in this area during the regular NDT/MT testing (see photo below), proceed as follows:

1. MT indications in the area of the undercut thread are permissible under the following conditions:
 - The indications are relatively short and are located at an angle of approx 30-45° to the axis of the component.
 - The indications are distributed along a maximum of ¾ of the circumference.
 - There is no continuous indication that is approximately perpendicular to the axis of the component.



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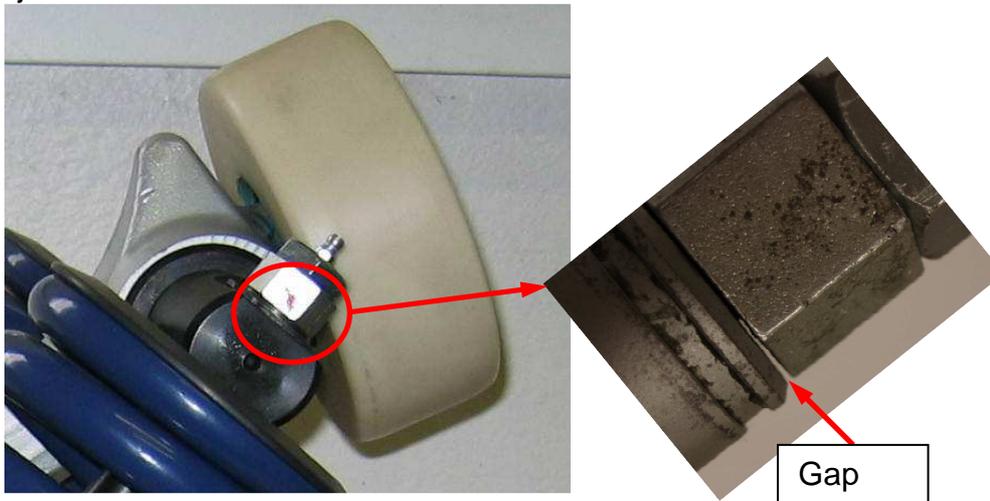
2. If the indications deviate from item 1, proceed as follows:
Using a round diamond hand file or a die grinder with a pointed metal burr remove the indications in the area of the undercut on the entire circumference on a sampling of at least 3 spring guide slide rods (see photos).



- The maximum grinding depth may be 0.3 mm.
- If the grinding removes the indications, the spring guide slide rods can be returned to service after applying an anti corrosion agent (paint).
- If the indications on the other spring guide slide rods of the inspection lot are of the same type, no further spring guide slide rods must be ground out and they also can be returned to service.
- Spring guide slide rods that have been ground to the maximum depth of 0.3 mm on the entire circumference must be permanently marked (by stamp or similar) to indicate that grinding to the maximum allowable depth has been completed and no additional grinding is allowed.
- If indications are found that are deeper than 0.3 mm, the component must be replaced and returned to Doppelmayr.

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3. Important when remounting the nuts:
 - Treat the nut and counter nut with "medium strength" threadlock (e.g. Loctite 243 or 222).
 - Mount the face-turned nut first and tighten (**without torque wrench**) until the nut contacts the spring guide slide rod. Then fit the counter nut and tighten it opposite the face-turned nut with torque, however, without applying a torque to the face-turned nut. Tightening torque **M14 = 115 Nm, M18 = 200Nm**
4. Check the hexagonal nut (M14 for type A104, M18 for type A108) at the end of the spring guide slide rod for surface evenness (see service bulletin SB-08-022) on all grips:
 - Position of grip: The grip must be closed without a rope or without a test bar in the jaws.



- Check along the entire circumference of the face turned nut for the presence of a gap (see photo above).
- If no gap is present, then no further measures are required.
- If the presence of a gap is detected, the nut must be replaced by a new one before returning the grip to service. For mounting instructions consult section 0.
- Furthermore, those spring guide slide rods whose hexagonal nuts were replaced must be tested for incipient cracks in the area of the undercut by means of NDT/MT testing in the course of the next inspection. If incipient cracks are found, proceed as described under section 2.