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AFFECTED MODEL: AllVac AVR-B-18 Manufactured March 1, 2018, through July 31, 2021

SUBJECT: Exhaust Silencer Service Kit Instructions

RELEASE DATE: March 2023

RECALL NUMBER: 23V-020

SERVICE PROCEDURE FOR RECALL 23V-020

Required Parts:

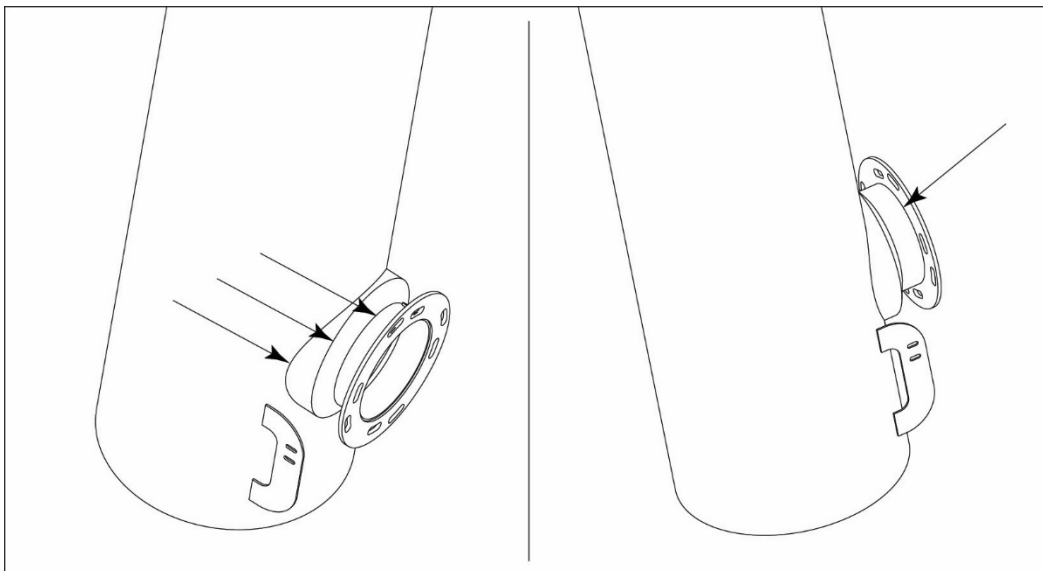
2497000002 Silencer Field Service Kit (includes the following components):

- 2410400021 – Silencer Mount Plate (qty. 2)
- 2410430001 – Silencer Mount Bracket (qty. 2)
- 88201068 – Hex Hd Capscrew, 1/2-13x1-3/4, GR5 (qty. 4)
- 88521208 – Locknut, 1/2-13 (qty. 4)
- 90027471 – Flat Washer, 1/2 (qty. 8)
- Drawings – 2460400001K & 2130430002K

**NOTE: Warranty claim/reimbursement information can be found on the last page of this document.*

1. Inspect kit 2497000002 to ensure all components are present.
2. Disconnect chassis battery.

Prior to the installation of the Service Kit, inspect the entire length of each weld seam identified below for cracks:



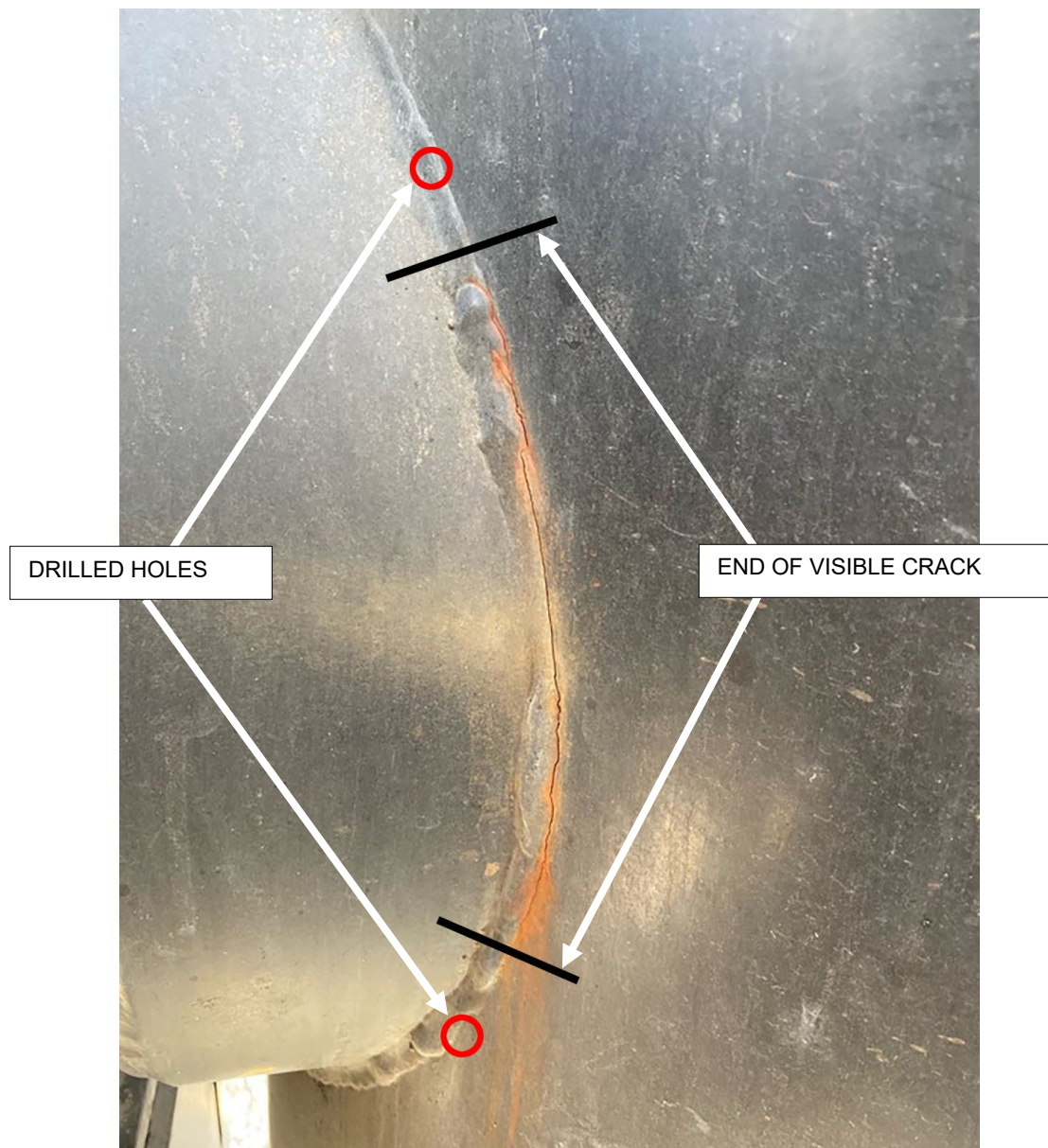
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All cracks must be repaired prior to installation of service kit. If no cracks are found, proceed to step 3. If cracks are found, repair using the method described below:

- Drill 1/8 to 3/16 hole two inches past visible crack
- Grind a groove through the crack from hole to hole
- Weld from hole to hole, ensuring both holes are filled. Recommend MIG welding using .035 weld wire.

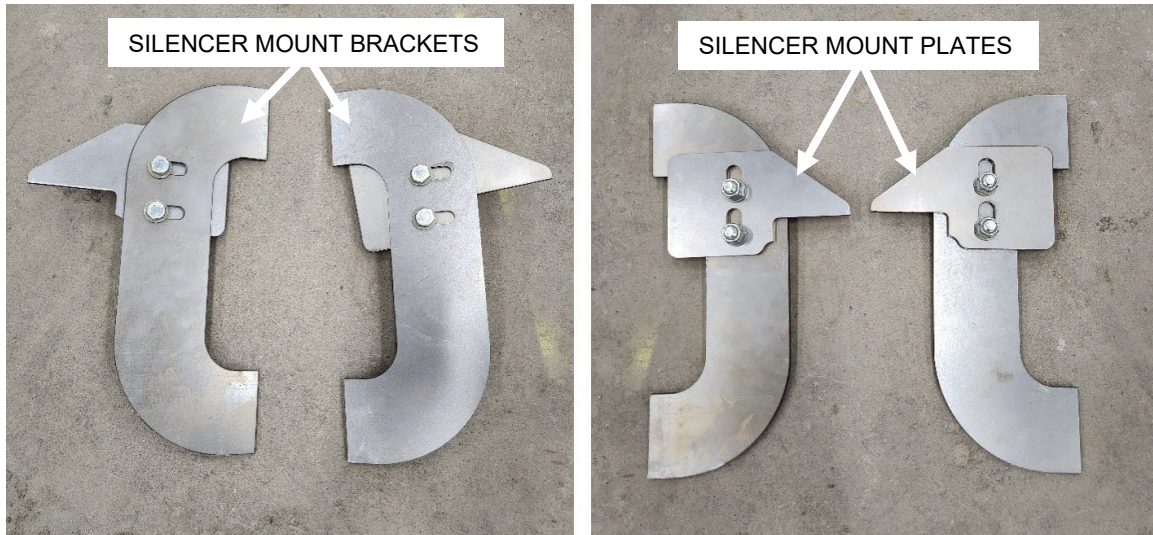
With crack(s) repaired, proceed to step 3.



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3. Loosely bolt plates and brackets together for fitment, as shown:



4. Referencing locations shown on drawings 2460400001K & 2130430002K (included in kit), mark new plate and bracket locations with a paint pen:



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5. Remove powder coat from marked locations to expose bare metal:



6. Tack weld Silencer Mount Plates to the power frame:

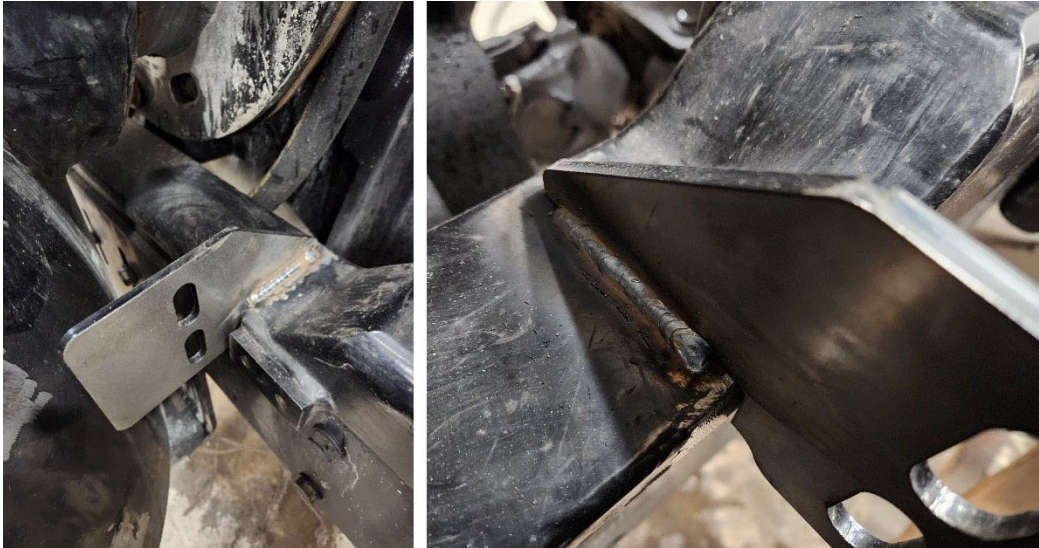


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7. Loosen hardware and separate Silencer Mount Brackets from Silencer Mount Plates.
8. Complete horizontal welds on Silencer Mount Plates, on both sides, and let cool completely:



9. Prime and paint plates so there will be a layer of paint between Silencer Mount Plates and Silencer Mount Brackets when assembled.
10. Loosely bolt Silencer Mount Brackets to the Silencer Mount Plates and align with silencer:



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11. Weld Silencer Mount Brackets to silencer and let cool completely:



12. Once Silencer Mount Brackets have cooled completely, tighten hardware and prime and paint all remaining exposed bare metal surfaces:



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Warranty Claim/Reimbursement Information:

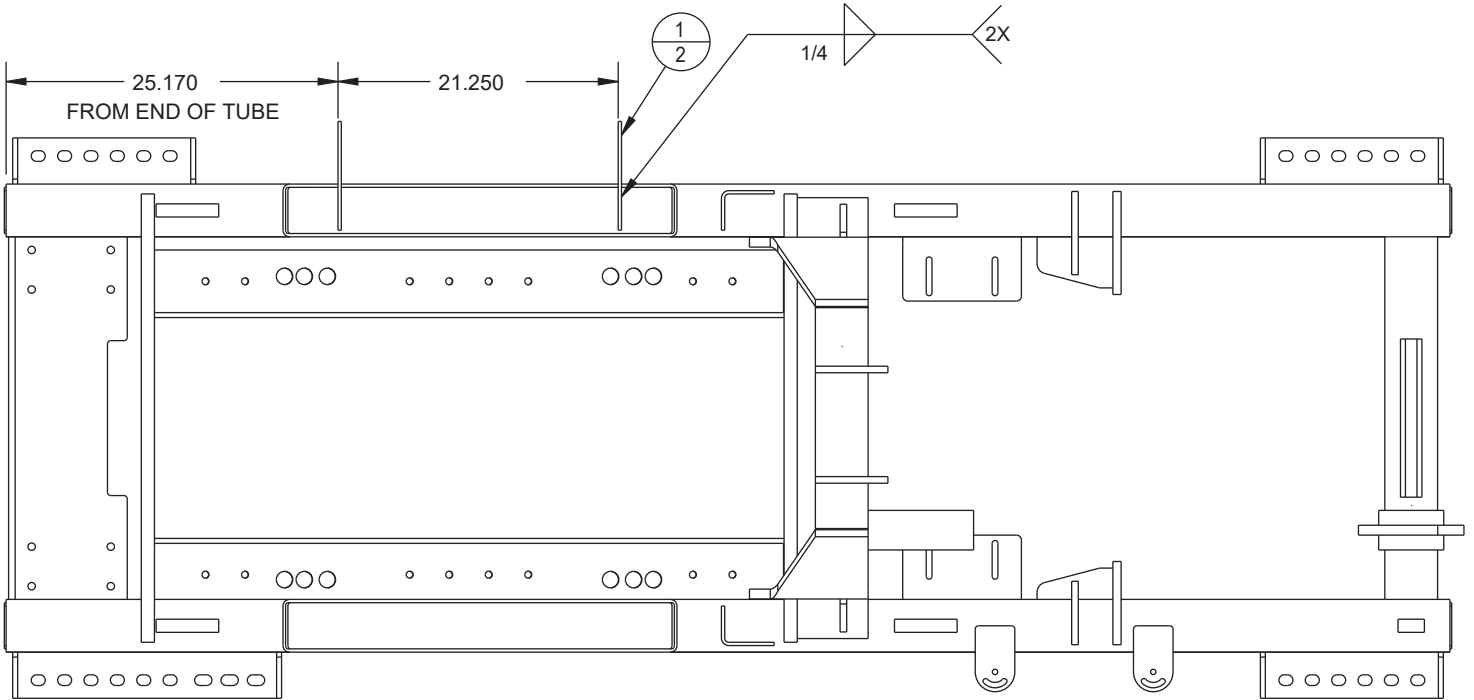
- Gradall will allow 2 hours to perform this repair and up to 3 hours travel time.
- File a warranty claim through normal warranty procedure, selecting 'Product Safety' as warranty type.
- In the Dealer Comments of the warranty claim, reference 'Recall Number 23V-020'

Contacts:

Should you have any questions or require further assistance concerning this bulletin, please contact your Gradall/Vacall Regional Service Manager, Gradall/Vacall Service Department, or Gradall/Vacall Warranty Administrator at 1-800-382-8302.

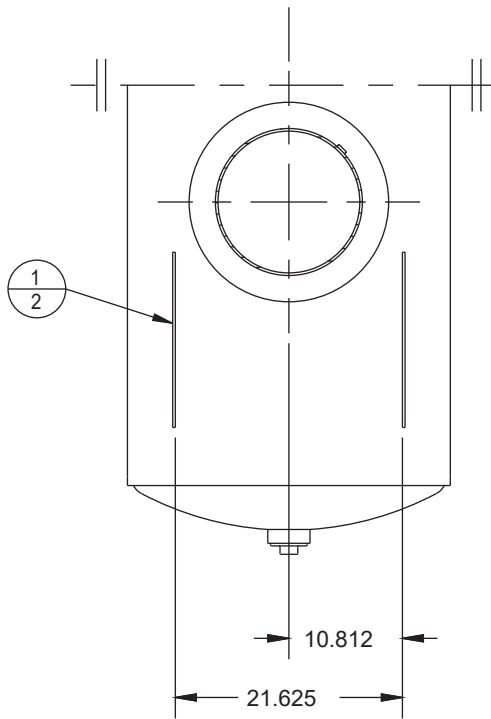
SAFETY INFORMATION

REV	ITEM	QTY	ITEM NO.	DESCRIPTION
	1	2	2410400021	SILENCER MOUNT PLATE

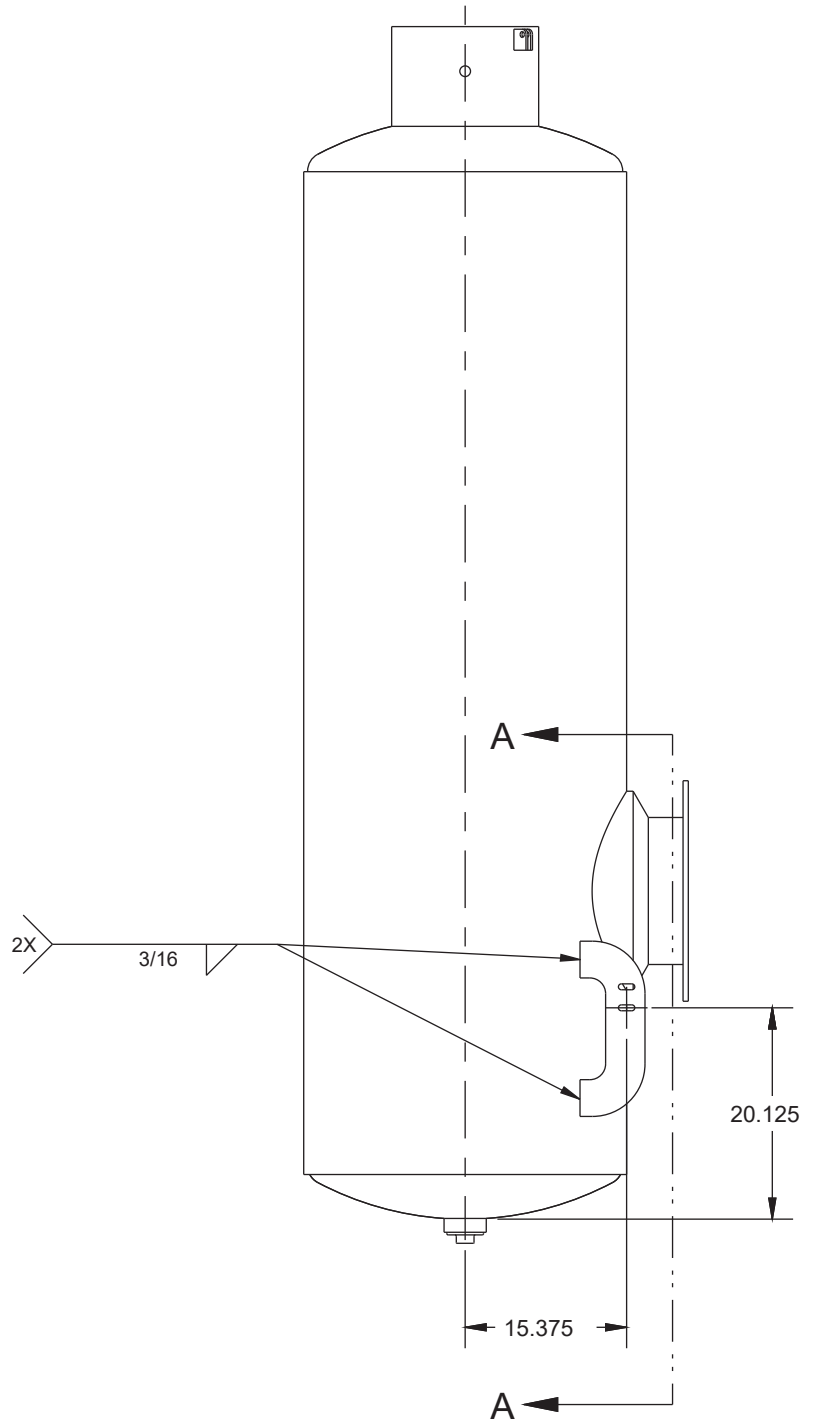


GRADALL
TITLE: SILENCER MOUNT PLATE LOCATION
DWG NO. 2460400001K

REV	ITEM	QTY	ITEM NO.	DESCRIPTION
	1	2	2410430001	SILENCER MOUNT BRACKET

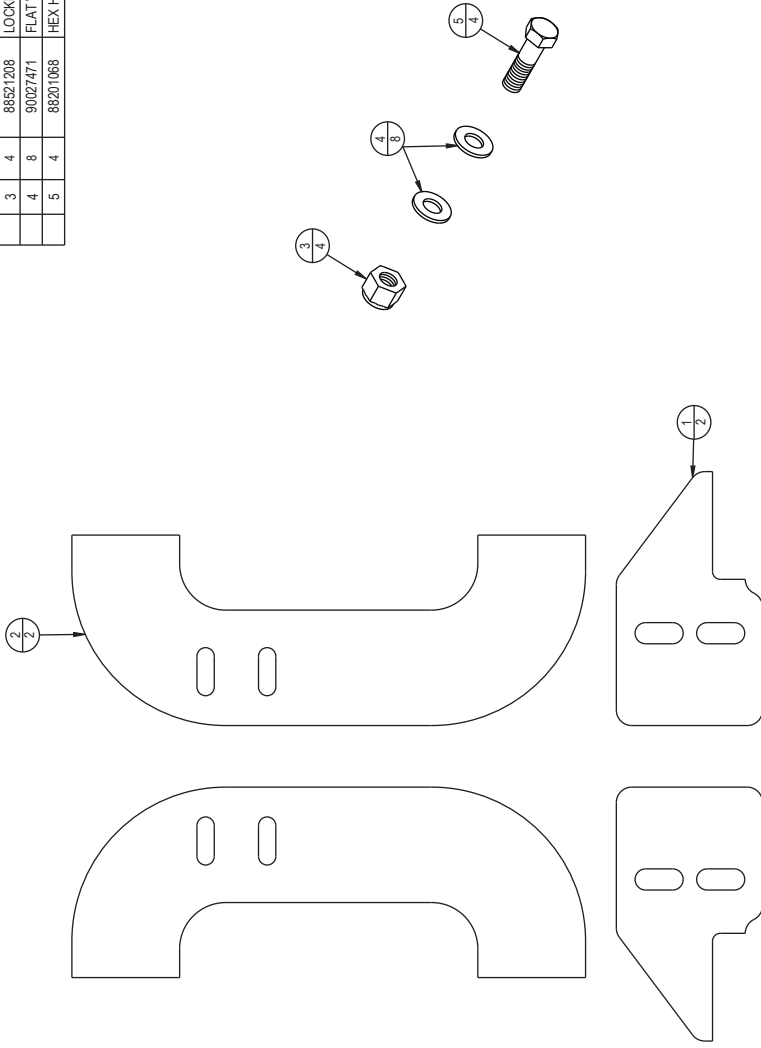


SECTION A-A



GRADALL
TITLE: SILENCER MOUNT BRACKET LOCATION
DWG NO. 2130430002K

NOTES:
 1. SEE DRAWING 2460400001K FOR PLACEMENT OF BRACKETS 2410400021 ON THE POWER FRAME.
 2. SEE DRAWING 2130430002K FOR PLACEMENT OF BRACKETS 2410430001 ON THE SILENCER.



SCALE 1/2

REV	ITEM	QTY	ITEM NO.	DESCRIPTION
1	2	2410400021	PLATE, SILENCER MOUNT	
2	2	2410430001	BRACKET, SILENCER MOUNT	
3	4	88521208	LOCKNUT, 1/2-13	
4	8	90027471	FLAT WASHER, 1/2	
5	4	88201068	HEX HD CAPSCREW, 1/2-13X1-3/4, GR5	

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REV	ZONE	DATE	BY	ER NUMBER	DESCRIPTION	CHK

REVISIONS			
DRAWN BY:	DAD	CHK'D BY:	DEG
DATE:	07-04-22	ER NUMBER:	EC220242
SIMILAR TO:		NEXT ASSY:	
MTL:	SEE PARTS LIST	SIZE:	D
FINISH:		DWG NO.:	2497000002
EST. WEIGHT:	0.0 lbs	SHT:	1 of 1

SPECIFICATIONS	
1) DIMENSIONING AND TOLERANCING PER ASME Y14.5M/1994	
2) ALL WELDING TO STRUCTURAL WELD CODE - STEEL ANSI/AWS D1.1	
3) FINISH TO SURFACES TO BE PER ASME Y14.5M/1994	
4) MACHINE TOLERANCE TO BE 0.1	
5) REMOVE ALL BURRS AND SHARP EDGES	
6) ALL ANGLES \pm 125	
7) MACHINED SURFACES ∇ MAX	