

Service Bulletin

Maintenance of Way Equipment

Date: 05/13/2019

RRP Service Bulletin No: RRP SB344

Title: Nipper Clipper Frame Fix

Rating:

ALERT
 (Potential Problem)

INFORMATION
 (Action Is Optional)

DIRECTIVE
 (Action Is Required)

PRODUCT IMPROVEMENT
 (Enhance Product)

Product Series: Nipper Clipper [913559 & 913576]

Serial No:

NC-002-14	NC-005-15	NC-007-16	NC-021-17
NC-003-14	NC-006-15	NC-008-16	NC-022-17
NC-004-14		NC-009-16	
		NC-010-16	
		NC-011-16	
		NC-012-16	
		NC-013-16	
		NC-014-16	

Summary: Apply frame reinforcing brackets supplied with 793054 field service kit.

Action: Weld all parts called out on 800318 instruction document to the frame.

Note: Part numbers are stamped into the part to assist in assembling in the correct order.

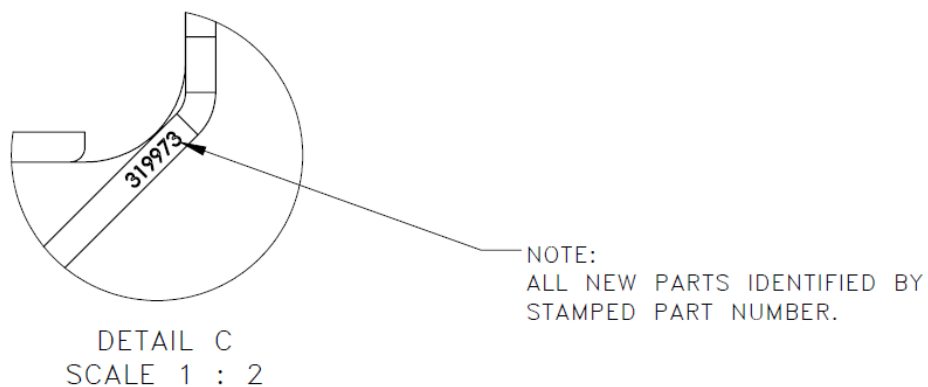
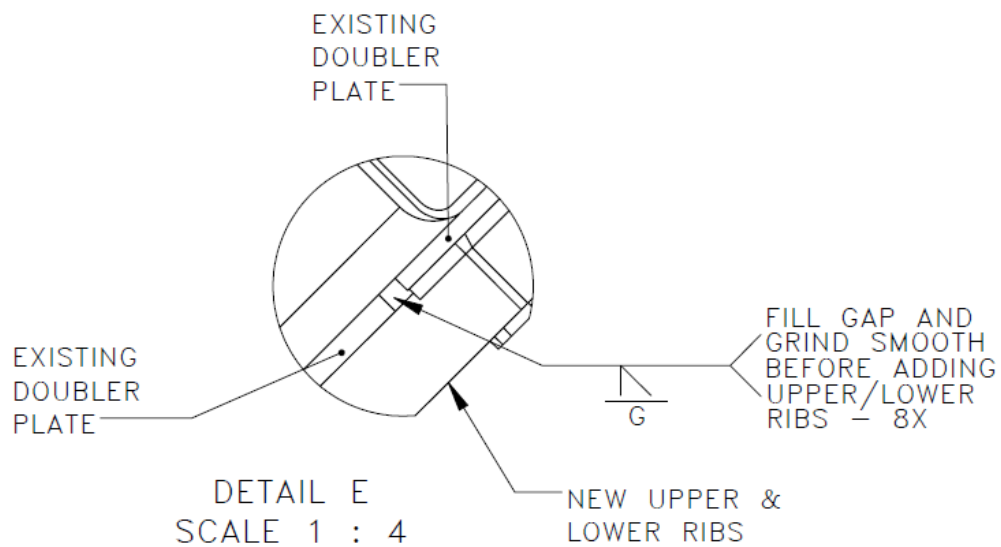
The workhead does not need to be removed when installing the parts.

Resolution: Continue with normal machine operation after completing this procedure

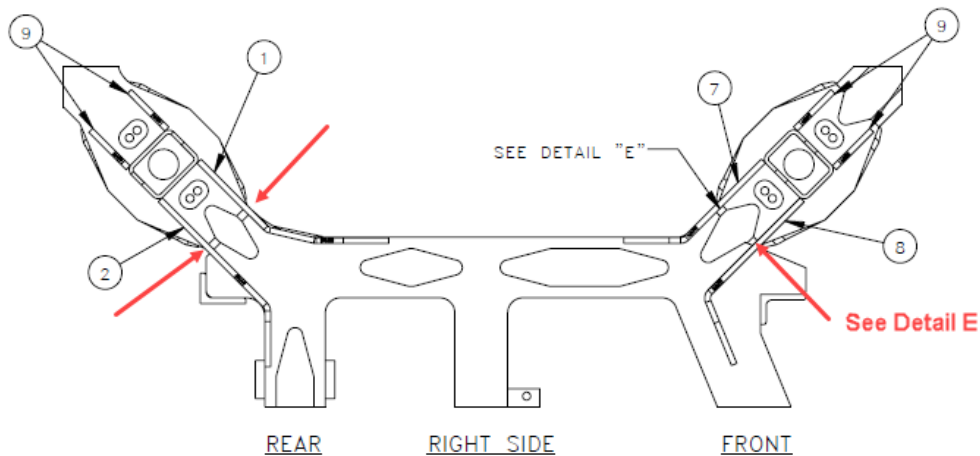
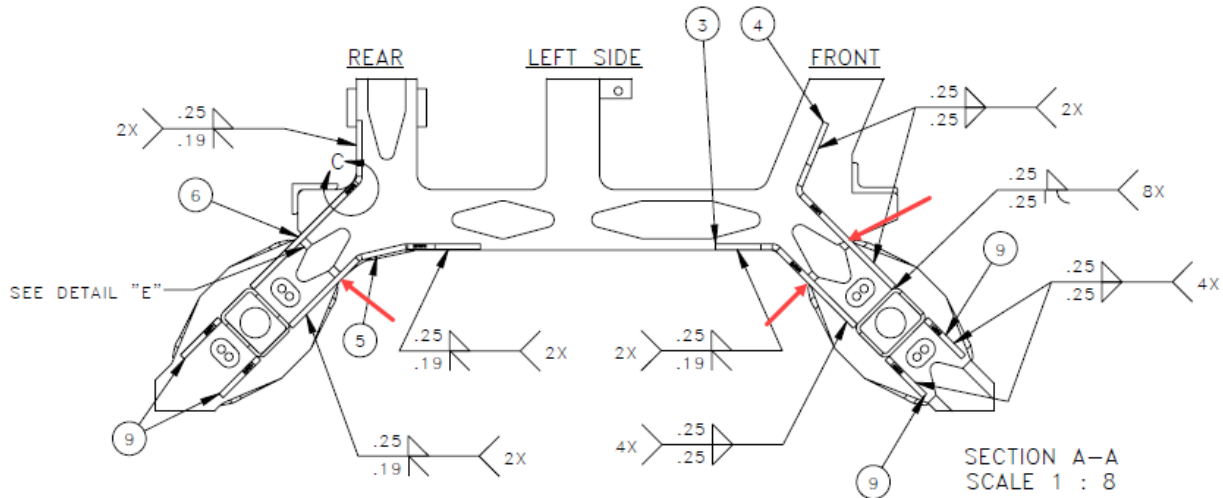
Instructions

Note: It is not necessary to remove the workhead from the machine for this modification.

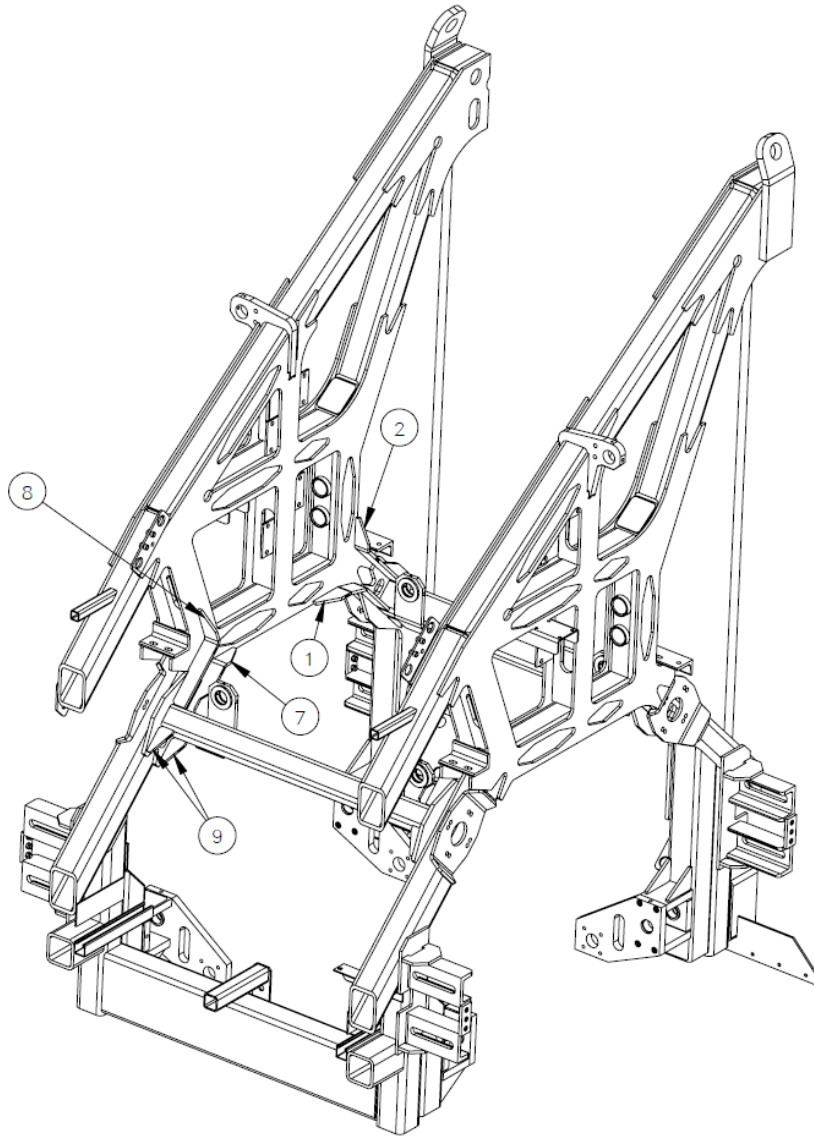
1. Inspect areas to be reinforced for cracks. If any are found, grind them out and fill with weld, then grind smooth.
2. Remove the paint from the gaps between the existing doubler plates (8 locations).
See Detail E.



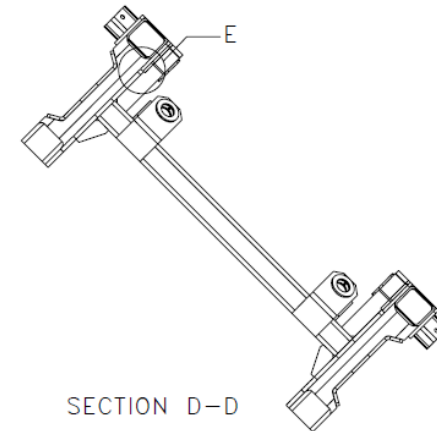
- Fill the gaps between the existing doubler plates with weld and grind smooth (8 location). **See Detail E.**

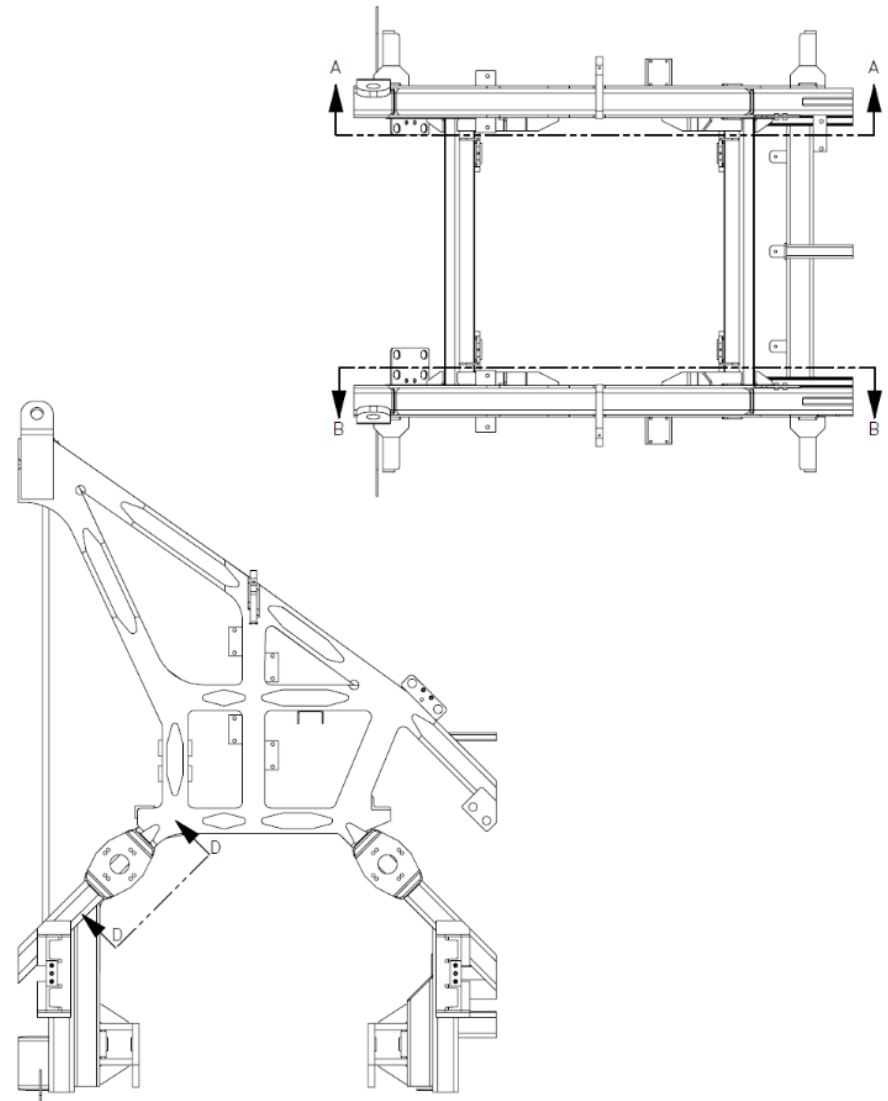
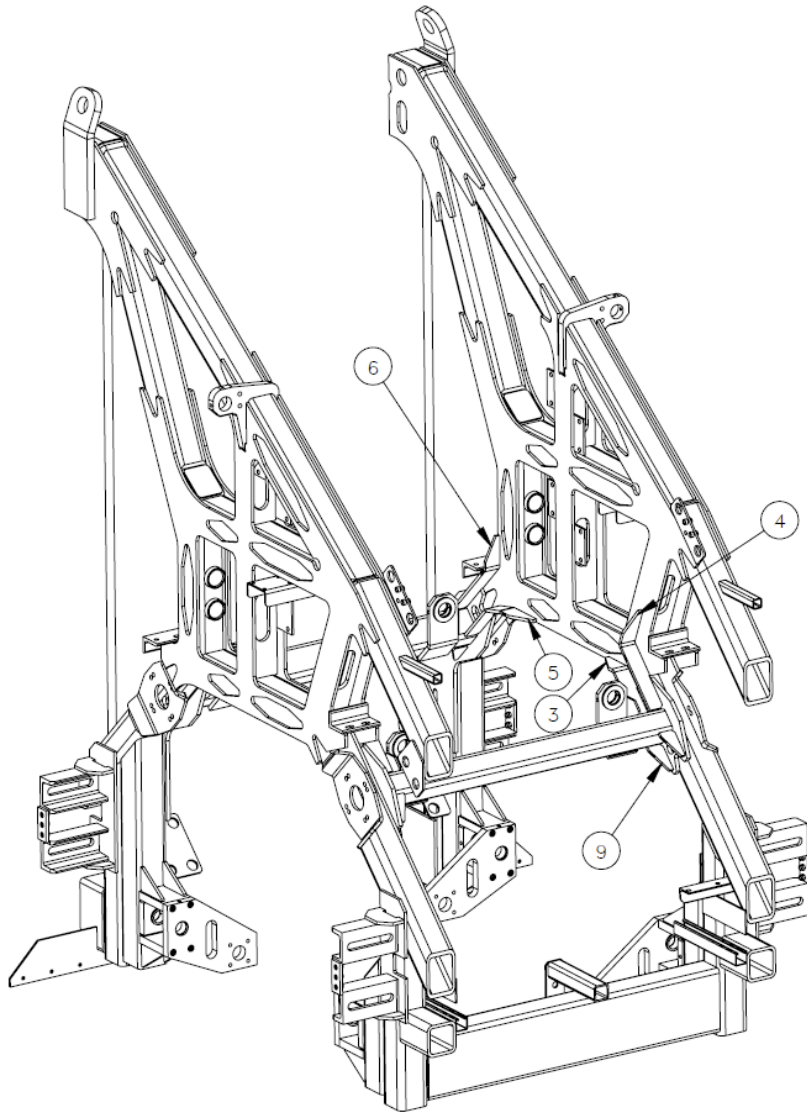


- Test fit the location of all parts per 793054 (**see Page 4**).
- Remove the paint from affected areas. All fabricated parts are stamped with their respective parts numbers. **See Detail C.**
- Weld all parts as shown in the appropriate views.
- Remove spatter and scale from the weld areas and prime and paint as required to prevent corrosion.



ITEM NO.	QTY.	DESCRIPTION	PART NUMBER
1	REF	RIB, RH REAR LOWER	319968
2	REF	RIB, RH REAR UPPER	319969
3	REF	RIB, LH FRONT LOWER	319970
4	REF	RIB, LH FRONT UPPER	319971
5	REF	RIB, LH REAR LOWER	319972
6	REF	RIB, LH REAR UPPER	319973
7	REF	RIB, RH FRONT LOWER	319974
8	REF	RIB, RH FRONT UPPER	319975
9	REF	RIB, LOWER TUBE	319979





Contact: If you have any questions or we can be of any service, please contact the Racine Railroad Products service department at (262)-637-9681 or custserv@racinerailroad.com.

Safety Terms



DANGER indicates a hazardous operating procedure, practice, or condition. If the hazardous situation is not avoided death or serious injury will occur.



WARNING indicates a hazardous operating procedure, practice, or condition. If the hazardous situation is not avoided death or serious injury could occur.



CAUTION indicates a potentially hazardous operating procedure, practice, or condition. If the hazardous situation is not moderate or minor injury could occur.

Note: Indicates an essential operating procedure, practice, or condition. No personal injury is possible.