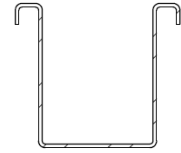


## FIELD BULLETIN

December 5, 2022

Please copy and distribute to all personnel as required.

**Equipment:** Dover-Turnbull Canada counterweight (CWT) frames for High-speed Elevators manufactured between 1977 and 1983 with a “U” type crosshead (top beam) section. CWT Frame Part #360442



“U” Type Crosshead  
(top beam)

**Service Requirement:**

Inspect and apply retrofit if required.

**Problem:** We recently found that some Dover-Turnbull Canada counterweight frames have developed cracks on the uprights (stiles) near the top weld with the crosshead. This is due to high stresses developed in the cracked region because of asymmetrical welds between the crosshead and the upright.

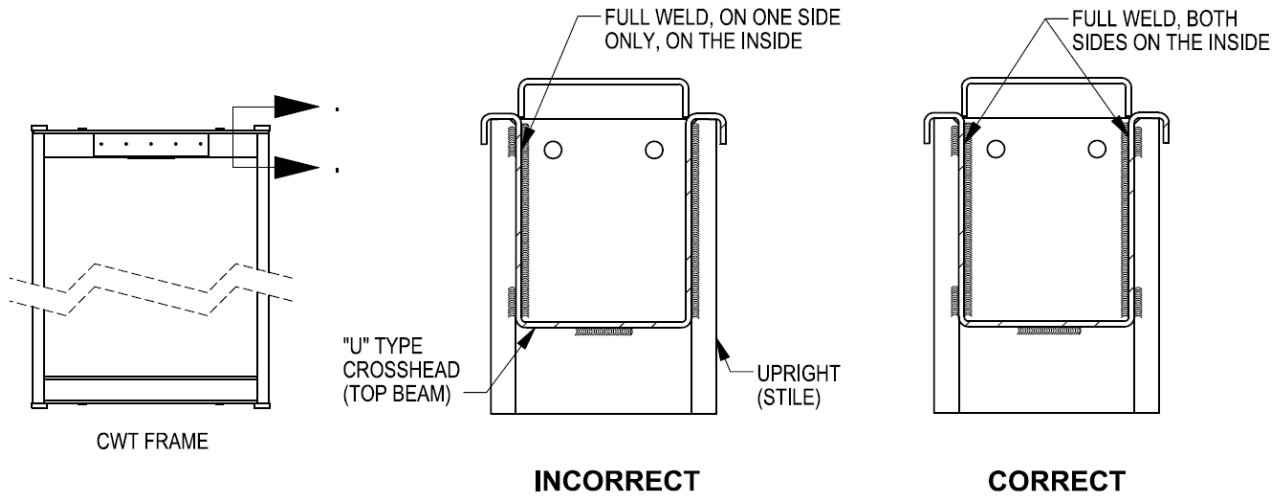


When welded properly, the crosshead is welded to the upright by a full weld on each side on the inside of the crosshead web, and two intermittent (1in long) on the outside. The improperly welded crosshead will have only one side the crosshead web welded on the inside.

Note: Failure to comply with this bulletin may affect future warranty claims.

All work described in this Bulletin must be performed in accordance with provisions described in the TK Elevator Corporation Safety Manual. All work must conform to the Local and National Code provisions in effect in your area. This Bulletin is for Internal Use Only.

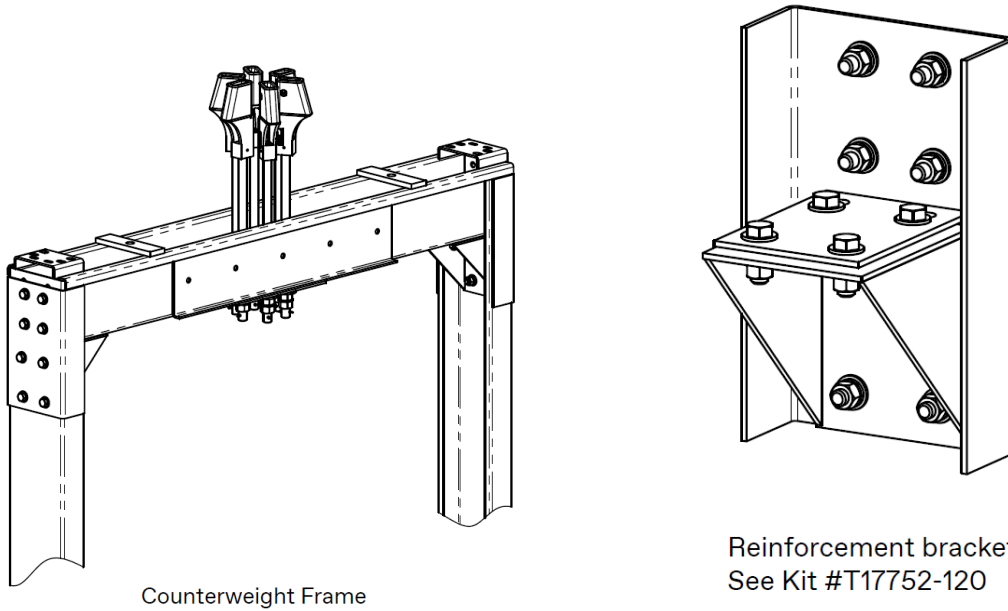
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If the crosshead is welded incorrectly, it needs to be reinforced to prevent high stresses.

**Solution:**

Install a reinforcement bracket kit #T17752-120 at the top corners of the CWT frame.



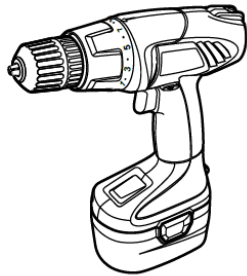
If you have questions or need assistance, please contact Parts Order Canada at 416 291 2000. Ensure that you have the original Turnbull job number.

# Installation Instructions

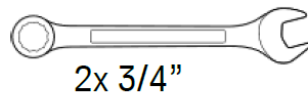
1. *Recommended Tools*
2. *Safety Precautions*
3. *Reinforcement Bracket Installation*

## 1. Recommended Tools:

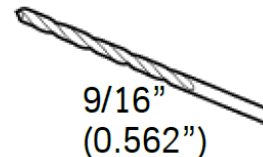
- 1.1. Hand Drill
- 1.2. Wrench, ratch, and socket for 1/2" hex bolts.
- 1.3. 9/16" Drill bit
- 1.4. Scaffold to reach top of CWT.



Mag Drill



2x 3/4"



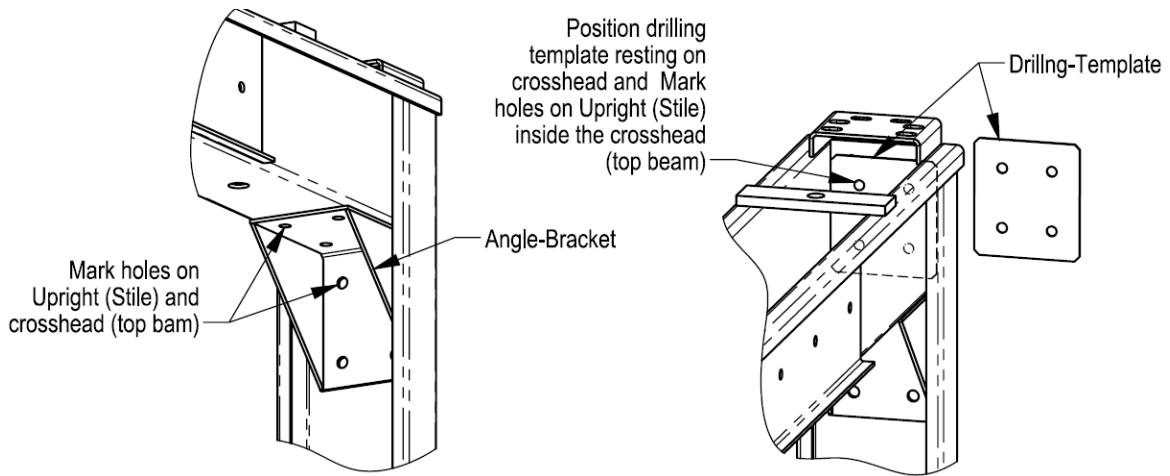
9/16"  
(0.562")

## 2. Safety Precautions

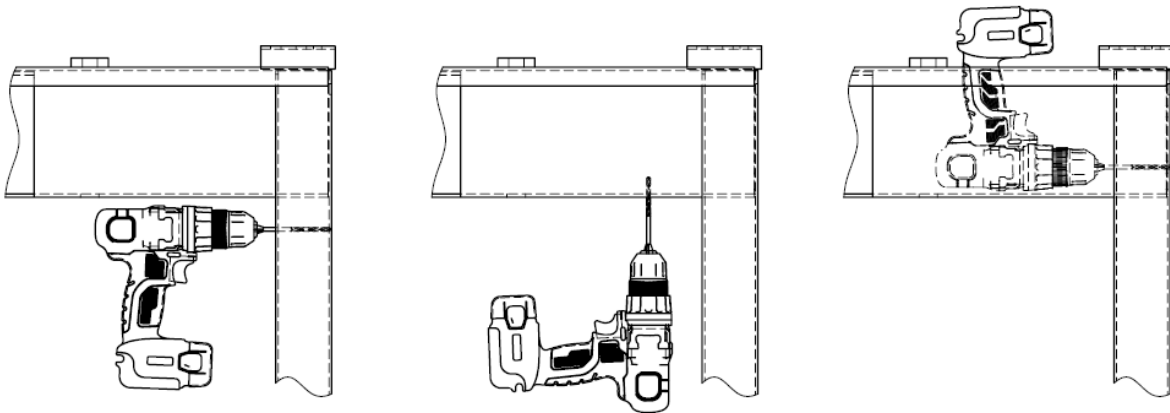
- 2.1. Follow the TKE standard safety procedures (10FPP, PPE, Barricades...).
- 2.2. Fall protection if required.
- 2.3. Work to be done in accordance with TKE safety procedures.

## 3. Reinforcement Bracket Installation

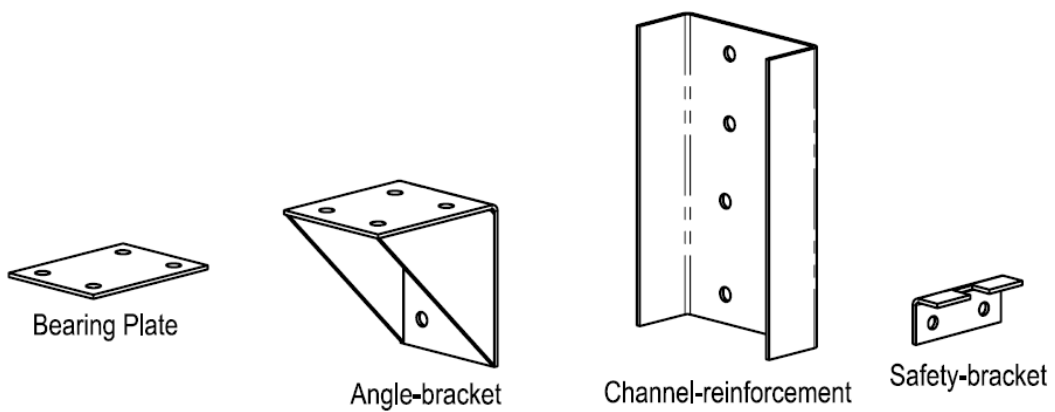
- 3.1. Without removing guiding means, use the angle-bracket as template and the drilling template provided to mark up the location of the holes to be drilled.

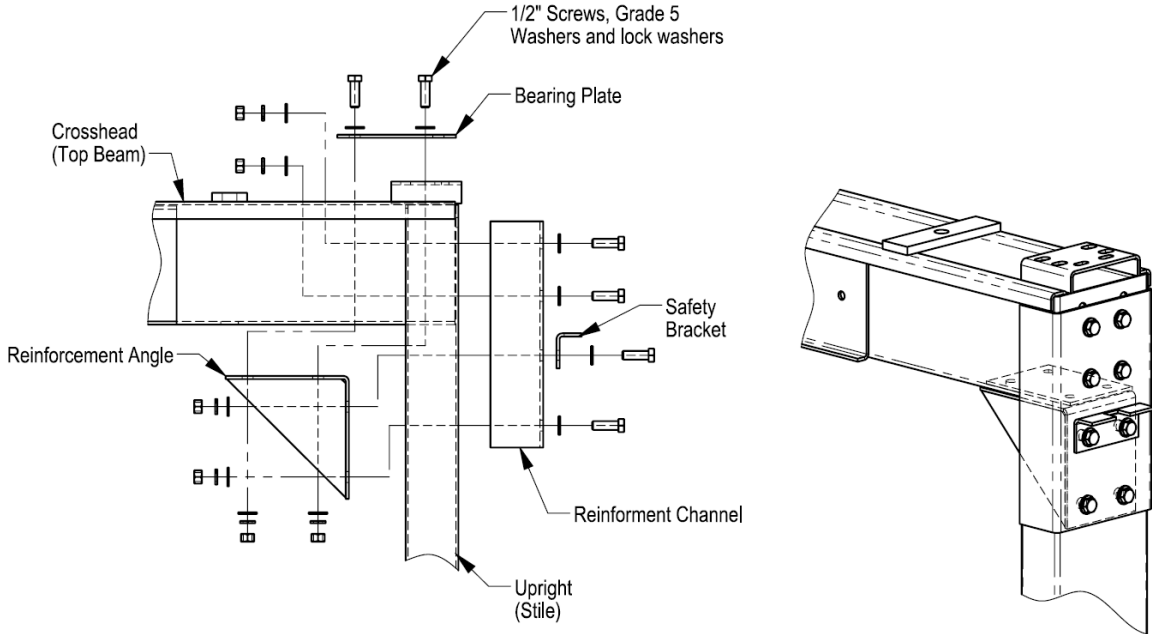


3.2. Drill 12X Ø9/16" (0.562") holes on the marked-up locations.



3.3. Install the Angle-Bracket, Channel-Reinforcement, Bearing-plate, and safety bracket as shown.





3.4. Repeat installation on the other side.

