

National Association of Lift Makers

NALM

33/34 Devonshire Street London W1N 1RF

Director D M Fazakerley

telephone: 0171-935 3013

fax: 0171-935 3321

To: All Members
cc: The Quality and Technical Committee (3040)

13 September 1996

Dear Sir,

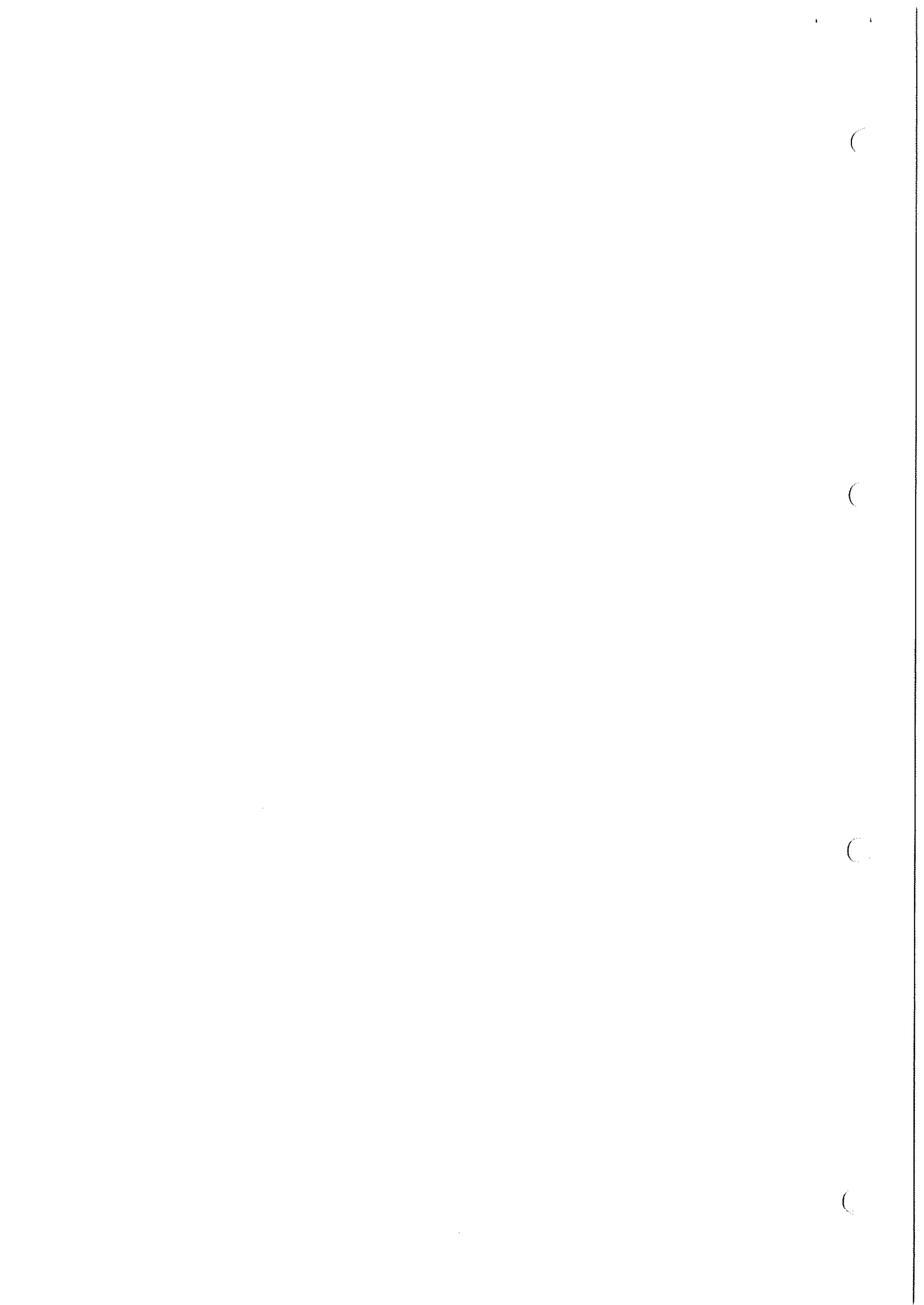
**Stannah Model GL 229/228 - Requirement for Modification
Fitting of Halfen Bolts - Stannah Straight Stairlifts**

Please find enclosed two safety information sheets in respect of stairlifts referenced as above and be guided accordingly should you be involved with this type of equipment.

Yours faithfully,



D M Fazakerley
Director





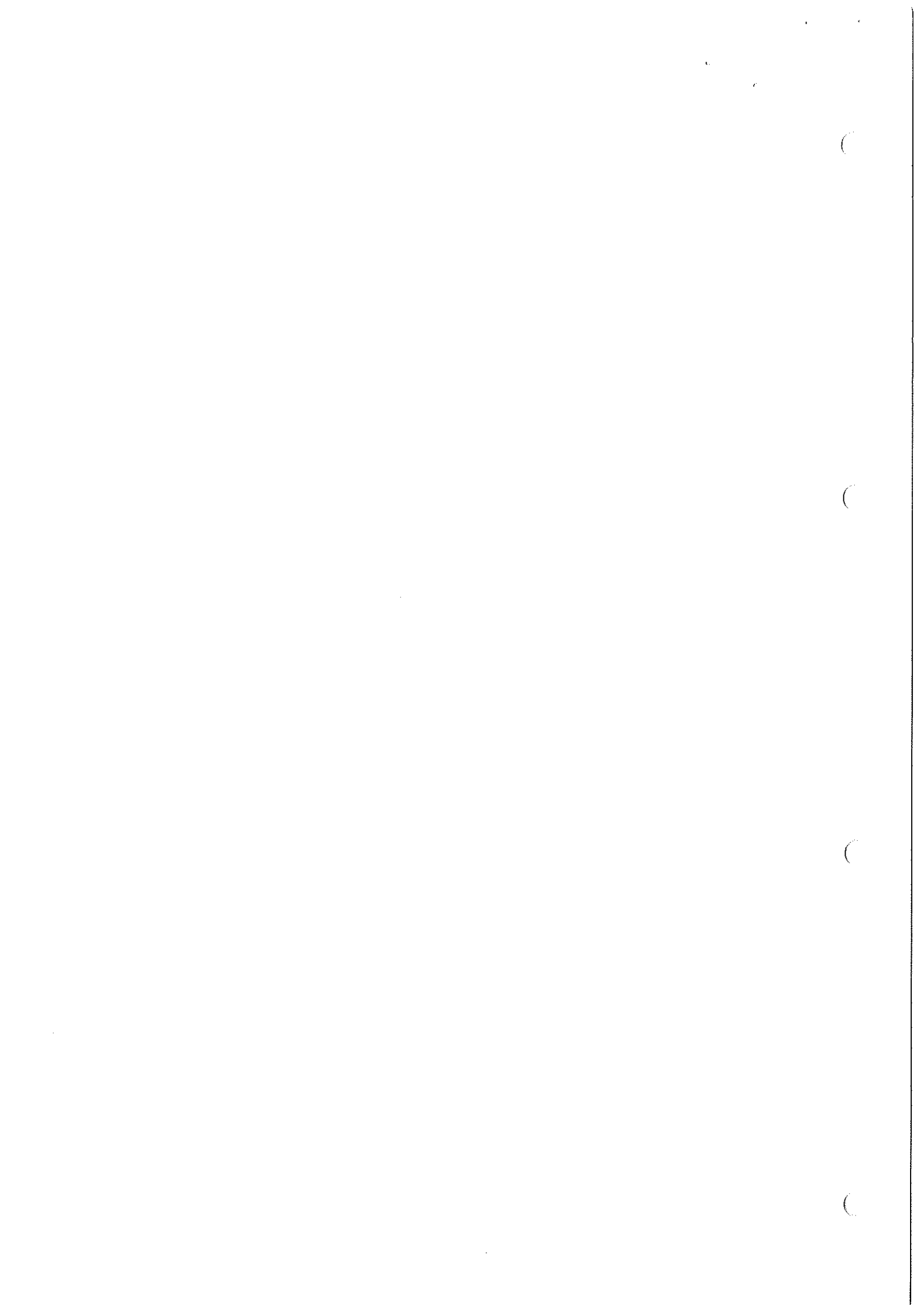
Stannah Stairlifts Limited, Watt Close, East Portway, Andover, Hampshire SP10 3SD, England
Telephone: Andover (01264) 332244 Fax: (01264) 333334

FITTING OF HALFEN BOLTS - STANNAH STRAIGHT STAIRLIFTS

It has been brought to our attention that an incident affecting the safety of a stairlift occurred due to the incorrect fitting of the halfen bolts.

Would you please brief the attached safety bulletin to all personnel who are involved in the fitting, service, and maintenance of Stannah straight stairlifts. Your help and co-operation is appreciated.

CE/OPC - 11th September 1996





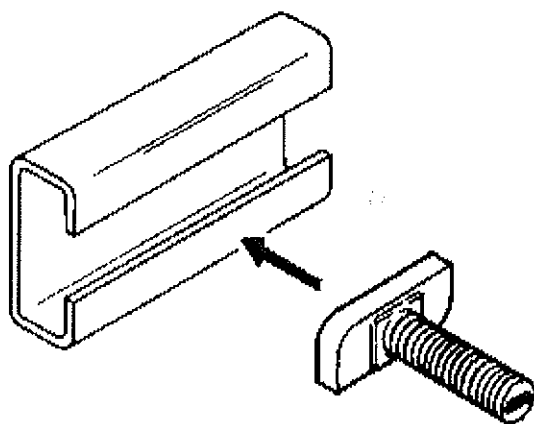
Safety Information

"HALFEN" FIXING BOLT PROCEDURE

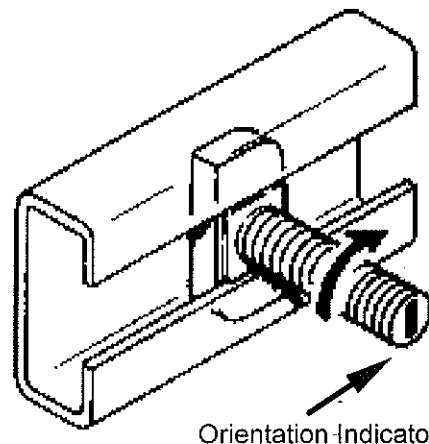
A recent safety incident on a 215 seat has highlighted the need to ensure that all "Halfen" fixing bolts are correctly fitted in order to make them fully effective.

The following diagram shows the correct orientation of the "Halfen" bolt head with respect to the "Halfen" channel.

It also shows the orientation indicator on the end of the threaded stud which **MUST ALWAYS BE AT A RIGHT ANGLE** to the "Halfen" channel before, during and after the nut is tightened.



Orientation before insertion into channel



90° rotation after insertion into channel.
Note orientation of indicator

This procedure applies to all "Halfen" fixings on all Stannah models.

Please ensure all installation and service engineers are reminded of this procedure and adhere to it.

Also acknowledge receipt of this important Safety Notice on the attached "Fax Back" Sheet. Should you have any queries, then please do not hesitate to contact Dave Harris on + 44 1264 336220.

R Paterson

RON PATERSON - Engineering Director
2 September 1996

PDN 96/3175

2
3





Stannah Stairlifts Limited, Watt Close, East Portway, Andover, Hampshire SP10 3SD, England
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STANNAH MODEL GL 229/228 - REQUIREMENT FOR MODIFICATION

Following an incident where the seat fixings came loose and the chair tilted, we have reviewed the design and concluded that all 229 and 228 units sold since introduction in 1991 need to be checked and modified.

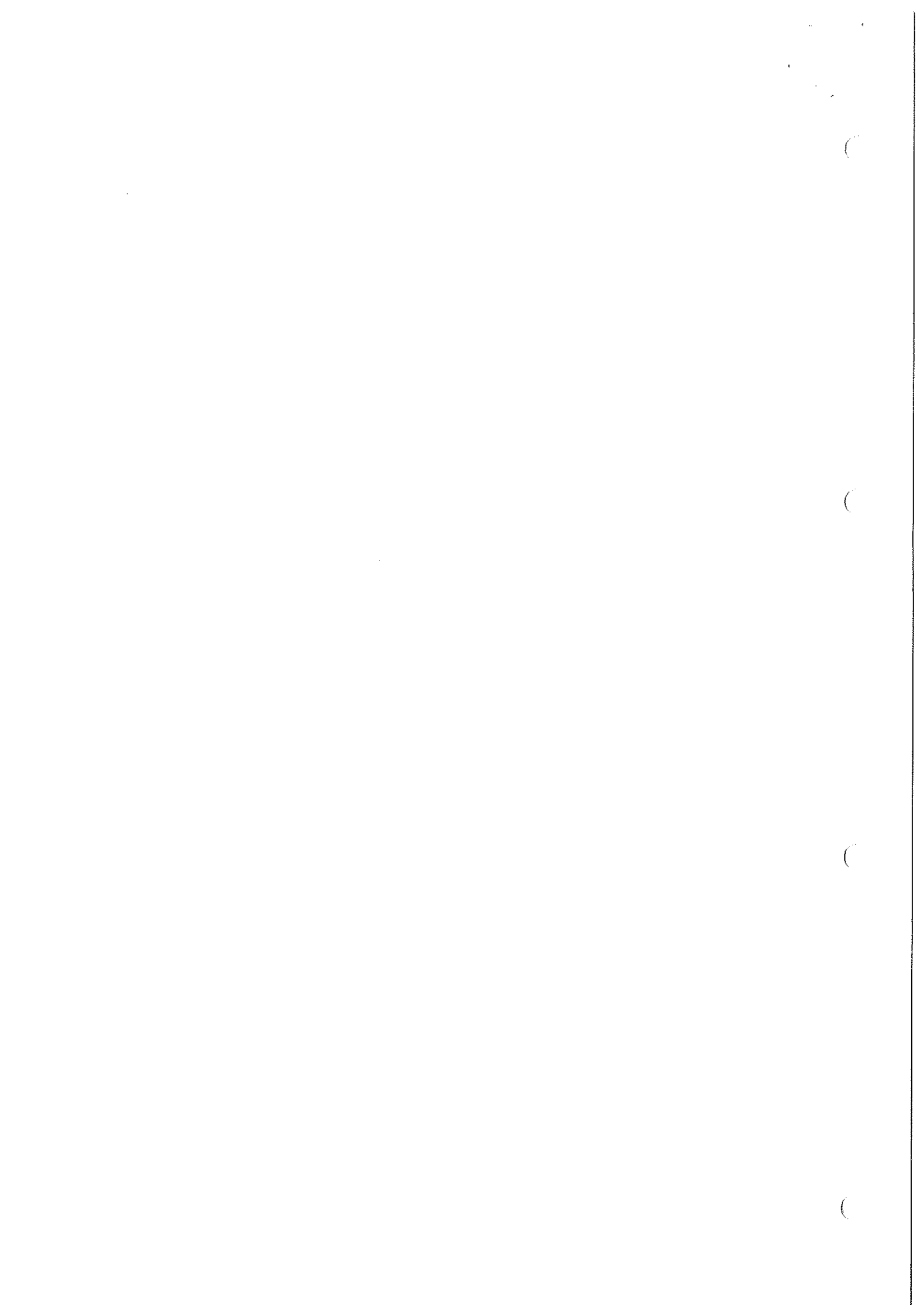
The attached procedure (Appendix 1) details the necessary work which involves replacement of the two seat fixing bolts with Tufloc bolts, the application of Loctite 243, the tightening of these bolts to 30 Nm and the fitting of a label to the carriage covers for future reference. We estimate that the time required on the premises is 10 minutes.

You may wish to carry out this work yourself - or alternatively you can inform us and we will carry it out at our cost.

Please advise Stannah Stairlifts Limited - C. Edgell, Operations Director - of the number of stairlifts you require to modify and we will send you sufficient fixings and labels.

Stannah place the highest importance on customer safety and thank you in advance for your co-operation in this matter.

CE/OPC - 11th September 1996



RETROFIT PROCEDURE - GL CHAIR FIXING SCREWS

These instructions are to be used in conjunction with Drawing No. 2294568

1. Unless this retro-fit is being carried out during a normal service, there is no need to remove the covers.
2. Remove one of the M8 Cap Screws that secures the chair to the carriage and discard the screw.
3. Replace with an M8x 25 long Tufloc Cap Screw (Part No. 2294566). This screw must be assembled with Loctite 243 and tightened to a torque of 30Nm (22lbf. ft), see Figs 1 & 2.
4. Repeat steps 2 & 3 for the remaining chair fixing screw.
5. Ensure that any excess Loctite is cleaned away.
6. Fit a chair fixing bolt label (Part No. 2294567) to the top of the covers as shown on Drawing No. 2294568.

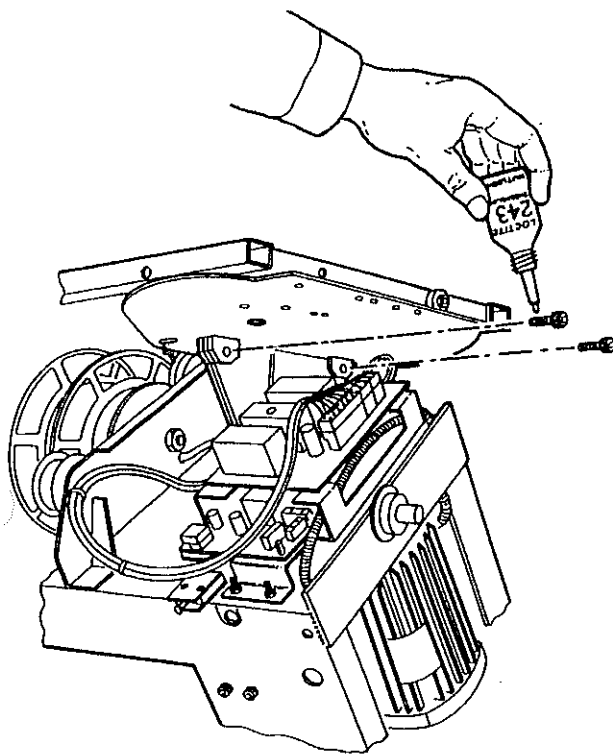


Fig 1.

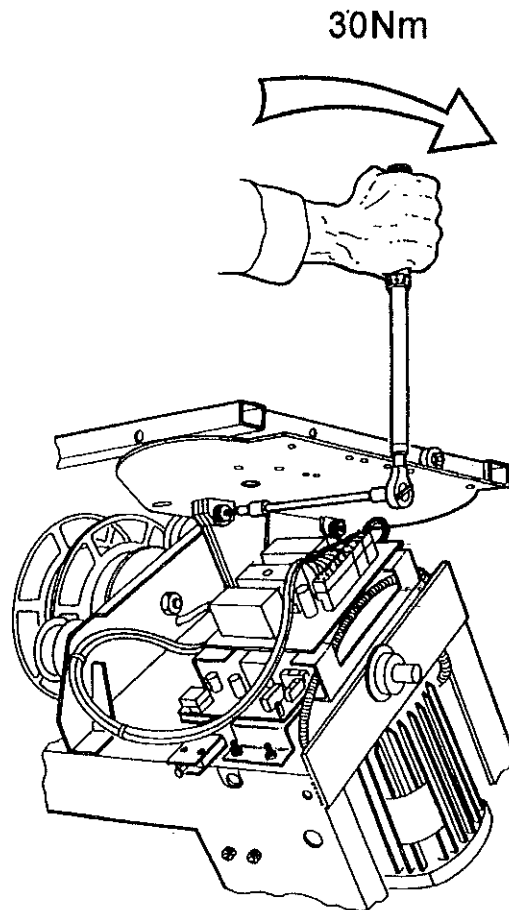


Fig 2.

Tools Required

Torque wrench - 3/8" drive
 Socket Extension 250mm - 3/8" drive
 6mm Ball End Hexagon Bit
 Bit Holder - 3/8" drive
 Loctite 243 Screwlock Adhesive

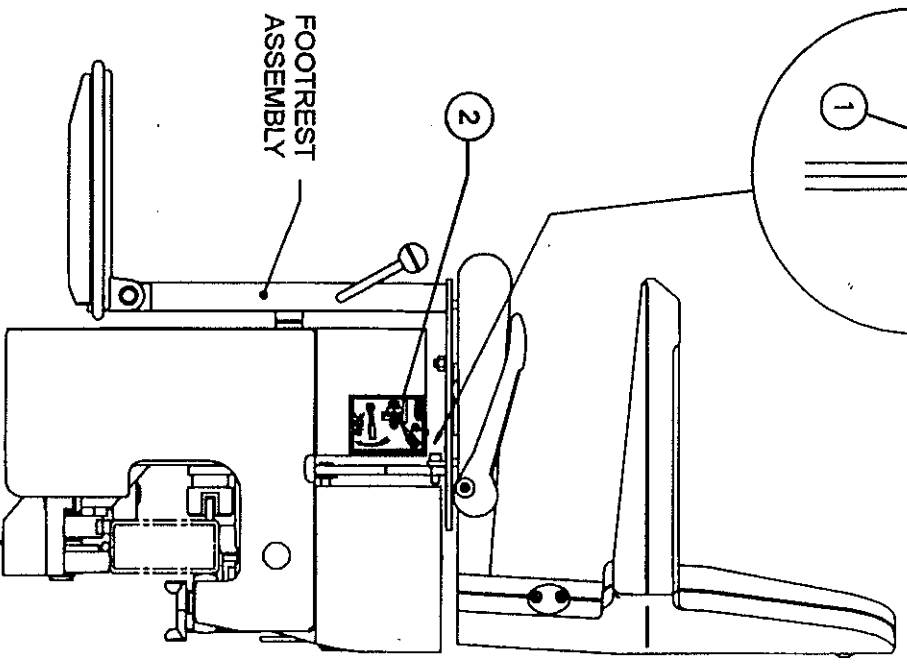
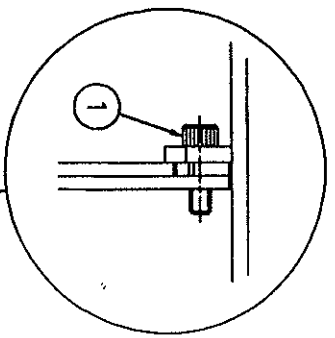
Stannah Part No.

502099
 502100
 502101
 502102
 630112

Price each £'s

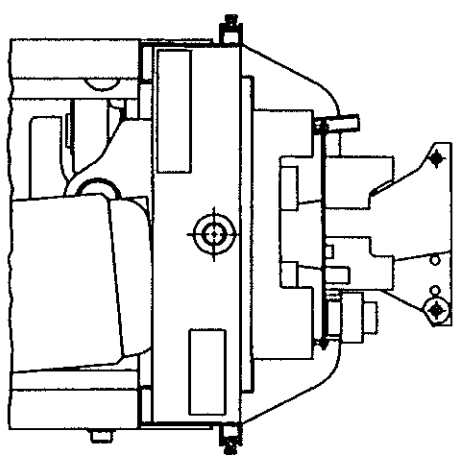
62.90
 8.55
 1.90
 3.65
 3.40

ITEM 1 TO BE ASSEMBLED WITH LOCTITE 243 & TIGHTENED TO A TORQUE OF 30Nm. (22lbf.ft)



FOOTREST ASSEMBLY

ITEM	DESCRIPTION	PART No.	NO. OFF
1	SCREW (TUFLOC) - GL CHAIR	2294566	2
2	LABEL - CHAIR FIXING BOLTS	2294567	1



DRG TITLE: GL CHAIR / CARRIAGE FIXING BOLTS - RETRO-FIT

REV C: ITEM 2 REPOSITIONED M.D.T. 14-06-96
 REV B: REDRAWN M.D.T. 03-06-96
 REV A: REDRAWN M.D.T. 22-05-96



HEAD OFFICE:
 Matt Close, East Portway, Andover
 Hampshire SP10 3SD, England
 Tel: 01264 364311 Fax: 01264 339198

DRAWN BY: MDT/sh DATE: 10-05-96
 CHECKED BY: DATE:
 DRAWING NUMBER: 2294568
 REV C