

Installation Instructions

Lift-Tek Mast Upright Thrust Plugs

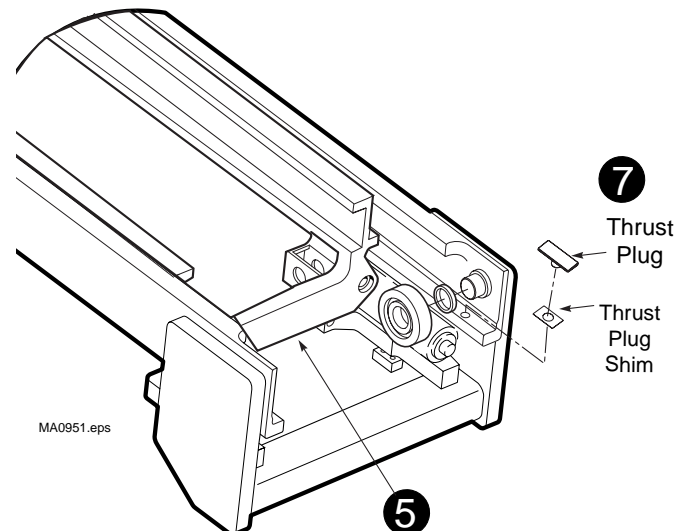
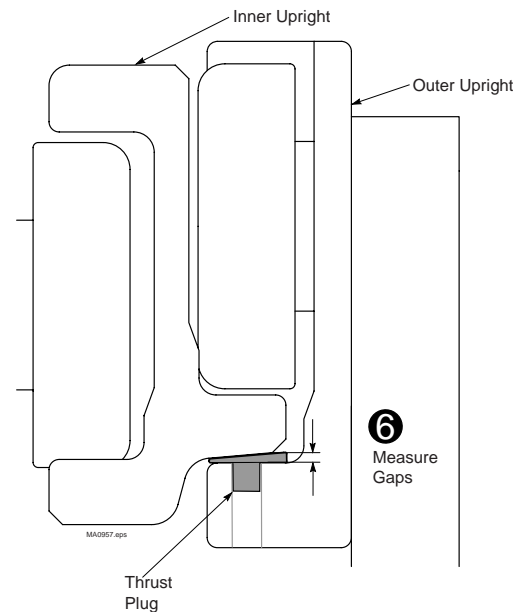
This sheet provides instructions to install upright thrust plugs to the Lift-Tek Mast.

Limited Free Lift 2-Stage Masts

1. Remove the mast assembly from the truck as described in service manual.
2. **Masts with Internal Hose Reeving** – Disconnect the hoses at the middle crossmember. Plug the hose ends.
3. Remove the main lift cylinders from the mast as described in the service manual.
4. Turn the mast over and slide the carriage to the middle of the mast.
5. Attach an overhead hoist to the center of the inner upright top crossmember. Lift until the inner upright contacts the load rollers.
6. Measure the gaps (both sides) between the mast uprights near the thrust plug locations. Push the inner upright toward the bottom of the mast to expose the thrust plugs.
7. Install new thrust plugs.
 - For upright gaps up to 1/8 in. (3 mm) use the thin thrust plugs.
 - For upright gaps over 1/8 in. (3 mm) use the thick thrust plugs. Grind the face of the thrust plugs to the needed thickness.
8. Reassemble and adjust the mast as described in the service manual.

Full Free Lift 2-Stage Masts

1. Remove the mast assembly from the truck as described in service manual.
2. **Masts with Internal Hose Reeving** – Disconnect the hoses at the middle crossmember. Plug the hose ends. Remove the lower clamp from the front hose guide bracket located next to the free lift cylinder.
3. Remove the main lift cylinders and supply tube from the mast as described in the service manual.



Part No. 202426-R3

Lift Technologies, Inc.

For Technical Assistance and to Order Parts . . .

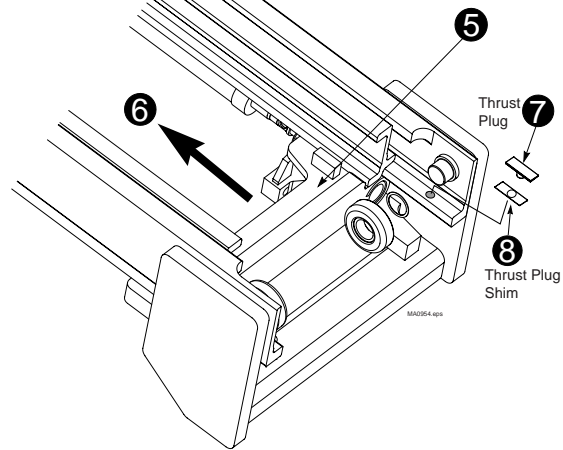
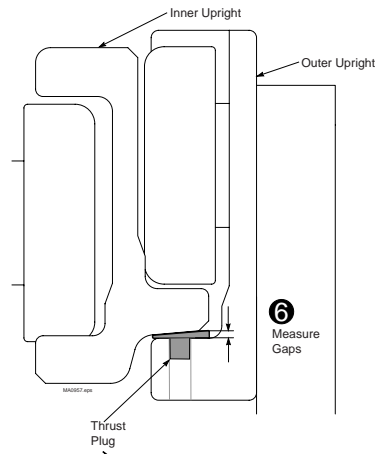
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LIFT-TEK
ELECAR MASTS
Lift Technologies 

4. Turn the mast over and slide the carriage to the middle of the mast.
5. Attach an overhead hoist to the center of the inner upright top crossmember. Lift until the inner upright contacts the load rollers.
6. Measure the gaps (both sides) between the mast uprights near the thrust plug locations. Push the inner upright toward the bottom of the mast to expose the thrust plugs.
7. Install new thrust plugs.
 - For upright gaps up to 1/8 in. (3 mm) use the thin thrust plugs.
 - For upright gaps over 1/8 in. (3 mm) use the thick thrust plugs. Grind the face of the thrust plugs to the needed thickness.
8. Reassemble and adjust the mast as described in the service manual. Install the internal hose reeving lower clamp to the front hose guide bracket located next to the free lift cylinder.



Full Free Lift 3-Stage Masts

1. Remove the mast assembly from the truck as described in service manual.
2. **Masts with Internal Hose Reeving** – Disconnect the hoses at the middle crossmember. Plug the hose ends. Disconnect the bracket from the middle crossmember to allow free movement of the uprights.
3. Disconnect the valve bracket from the middle crossmember and remove the main lift cylinders from the mast as described in the service manual.
4. Turn the mast over and slide the carriage to the middle of the mast.
5. Attach an overhead hoist to the center of the inner upright top crossmember. Lift until the inner upright contacts the load rollers. Measure the gaps (both sides) between the mast uprights near the thrust plug locations.
6. Attach the hoist to the center of the intermediate upright top crossmember. Lift until the intermediate upright contacts the load rollers. Measure the gaps (both sides) between the mast uprights near the thrust plug locations.
7. Roll the inner and intermediate uprights toward the bottom of the mast to expose the thrust plugs.
8. Install new thrust plugs.
 - For upright gaps up to 1/8 in. (3 mm) use the thin thrust plugs.
 - For upright gaps over 1/8 in. (3 mm) use the thick thrust plugs. Grind the face of the thrust plugs to the needed thickness.
9. Reassemble and adjust the mast as described in the service manual.

