

Installation Instructions

D-Series High-Visibility™ Mast Tube Adaption Kits for Internal Hose Reeving

This sheet describes the installation of Tube Adaption Kits to provide a high termination for Lift Tek D-Series High-Visibility™ Masts. The kits provide the necessary tubing, brackets and fittings to connect between the mast internal reeving and the upper carriage bar.

The illustrations on this page show where to weld the upper tube terminal mounting brackets. The following pages show tubing and fitting location, and part numbers for the contents of each kit.

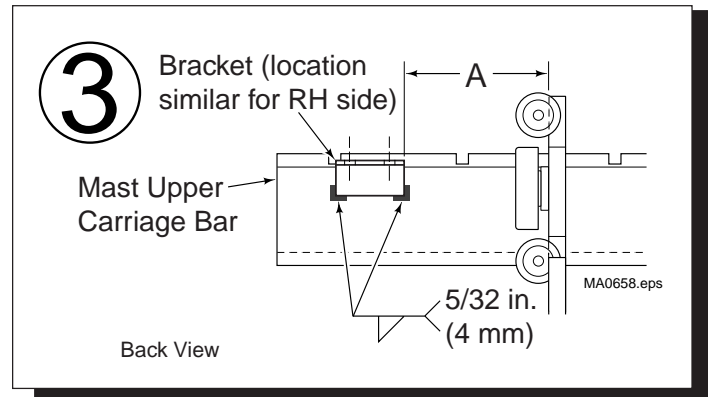
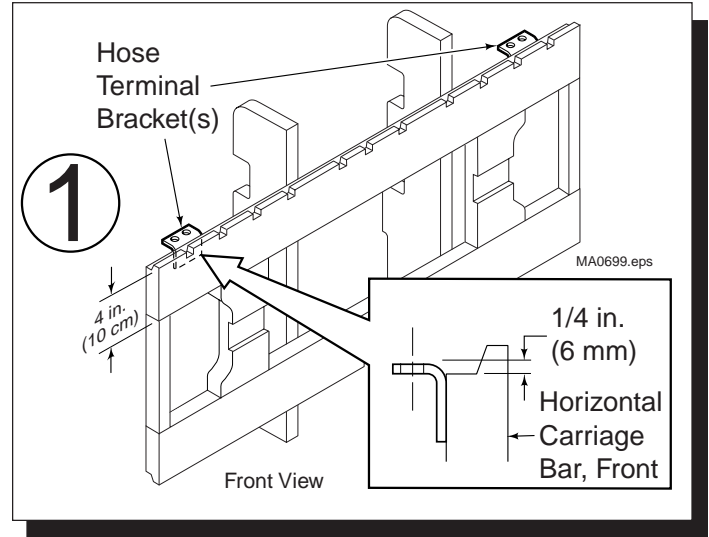
NOTE: It is recommended that the tubing be installed to the reeving fittings first, to determine proper bracket location.

- 1 Clean all surfaces to be welded. Remove any paint, oil, grease or other contaminants.
- 2 Install the tubing to the internal hose reeving fittings on the mast. Position the bracket(s) on the back side (driver's view) of the upper carriage bar (see reference dimension A), and clamp in place.



WARNING: Lift Technologies recommends that a qualified welder experienced in this type of work be used for best quality.

- 3 Weld the bracket(s) to the upper carriage bar using the following weld procedures:
 - Protect tubing, hydraulic hoses and adjacent areas from weld splatter.
 - Preheat weld areas to 70° F (21° C).
 - WELD METHOD A – FCAW (Flux-Cored Arc Weld). Attach ground wire to carriage. Weld using AWS E70T-1 1/16 in. (1.6 mm) or 5/64 in. (2 mm) diameter wire with 100% CO² shielding gas at 35–50 CFH. Set welding amps per manufacturer's recommendations. Apply weld holding a close arc. Do not oscillate or use a wash bead pattern. Let welds normal air-cool.
 - WELD METHOD B – SMAW (Stick Welding). Attach ground wire to carriage. Weld using E-7018 low hydrogen 1/8 in. (3.2 mm) or 5/32 in. (4 mm) diameter electrodes. Set welding amps per manufacturer's recommendations. **Do not use electrodes exposed to moisture without first re-drying them at 200° F (75° C) for 2 hours.** Apply weld holding a close arc. Do not oscillate or use a wash bead pattern. Let welds normal air-cool.
- 4 Remove all slag and weld splatter and inspect the welds.



Mast Model		Ref. Dimension A*
30D/35D/40D-	MS (31 in. carriage)	8.5 in. (217.3 mm)
	MS	11.5 in. (292.5 mm)
	MD (31 in. carriage)	8.5 in. (216.3 mm)
	MD	11.5 in. (292.5 mm)
	MT (31 in. carriage)	10.4 in. (263.4 mm)
	MT	13.4 in. (339.6 mm)
50D/55D-	MS, MD	10.3 in. (260.8 mm)
	MT	12.3 in. (311.9 mm)
80/100/110	MT	10.9 in. (276.5 mm)

* For 37 in. (94 cm) or wider carriages unless noted.

For Technical Support . . . or to Order Parts

Call: 1-888-946-3330

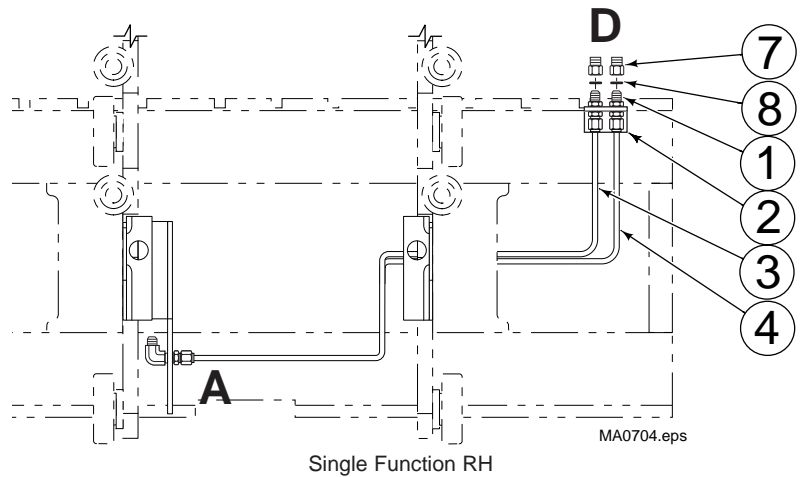
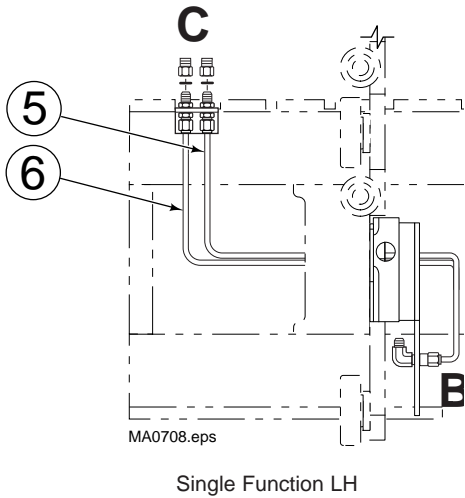
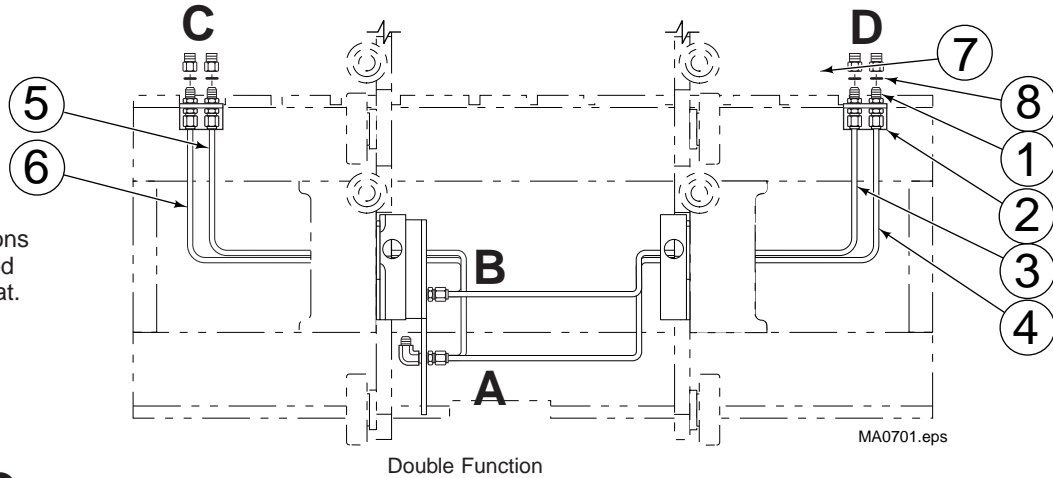
OR

Write: Lift Technologies, South Highway 11, Westminster, S.C. 29693



30D/35D/40D/50D-MS MASTS

NOTE: All illustrations are shown as viewed from the driver's seat.

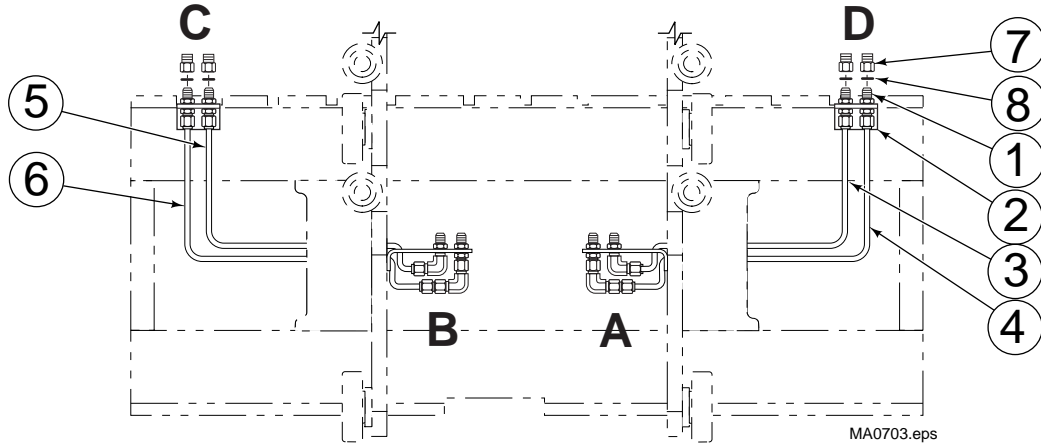


		30/35/40D-MS						50D-MS		
		31-in. Wide Carriage			37-in. & Wider Carriage			37-in. & Wider Carriage		
		A to D	B to C	A to D and B to C	A to D	B to C	A to D and B to C	A to D	A to D and B to C	
REF	QTY	PART NO.	PART NO.	PART NO.	PART NO.	PART NO.	PART NO.	PART NO.	PART NO.	DESCRIPTION
		221691	-	221693	221692	-	221694	222860	222861	Hose Adaption Kit, JIC
		221695	222652	221697	221696	222653	221698	-	-	Hose Adaption Kit, ORFS
	2	2375	2375	-	2375	2375	-	2375	-	Fitting, 6-6
1	4	-	-	2375	-	-	2375	-	2375	Fitting, 6-6
	1	685470	685470	-	685470	685470	-	685470	-	Bracket
	2	-	-	685470	-	-	685470	-	685470	Bracket
	3	221660	-	221662	221486	-	221512	222665	222839	Tube, RH JIC
	1	221679	-	221681	221685	-	221687	-	-	Tube, RH ORFS
	4	221661	-	221665	221487	-	221517	222666	222840	Tube, RH JIC
	1	221680	-	221684	221686	-	221690	-	-	Tube, RH ORFS
	5	-	-	221663	-	-	221513	-	222841	Tube, LH JIC
	1	-	222650	221682	-	221651	221688	-	-	Tube, LH ORFS
	6	-	-	221664	-	-	221514	-	222842	Tube, LH JIC
	1	-	221683	221683	-	221689	221689	-	-	Tube, LH ORFS
	2	611337	611337	-	611337	611337	-	611337	-	Ⓢ Adapter Fitting, 6-8
	7	-	-	611337	-	-	611337	-	611337	Ⓢ Adapter Fitting, 6-8
	2	2840	2840	-	2840	2840	-	2840	-	O-Ring
	8	-	-	2840	-	-	2840	-	2840	O-Ring

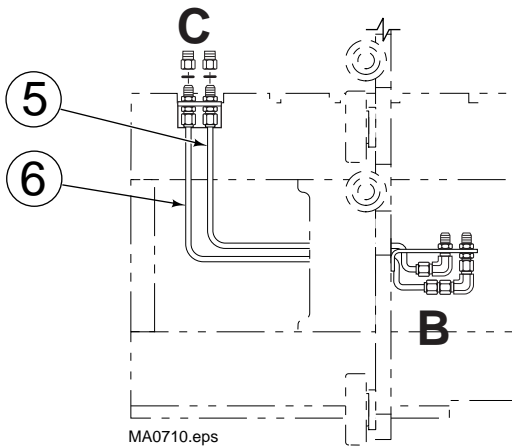
Ⓢ User Reference: S-10442, S-10470

30D/35D/40D/55D-MD MASTS

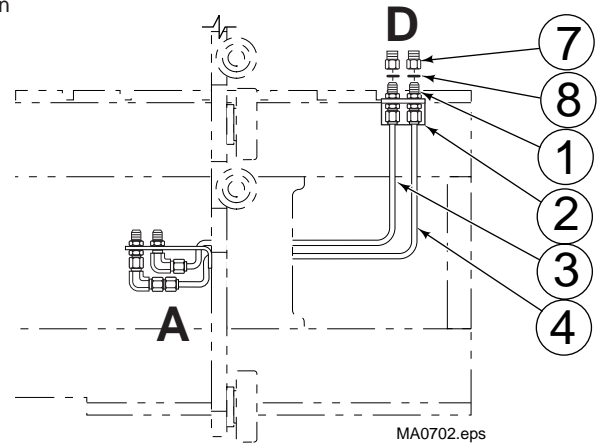
NOTE: All illustrations are shown as viewed from the driver's seat.



Double Function



Single Function LH



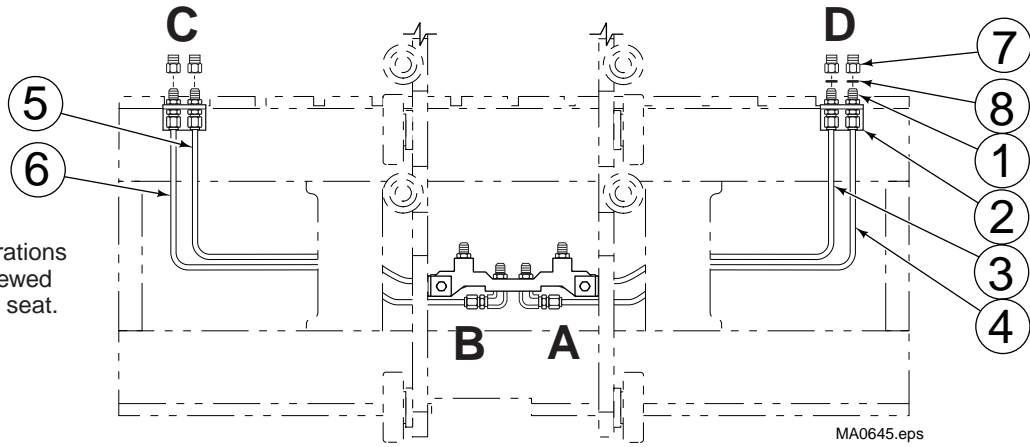
Single Function RH

		30/35/40D-MD						55D-MD			
		31-in. Wide Carriage			37-in. & Wider Carriage			37-in. & Wider Carriage			
		A to D	B to C	A to D and B to C	A to D	B to C	A to D and B to C	A to D	A to D and B to C		
REF	QTY	PART NO.	PART NO.	PART NO.	PART NO.	PART NO.	PART NO.	PART NO.	PART NO.	DESCRIPTION	
		222128	-	222129	221936	-	221937	222911	222912	Hose Adaption Kit, JIC	
		222130	222647	222131	222938	222648	221939	-	-	Hose Adaption Kit, ORFS	
1	2	2375	2375	-	2375	2375	-	2375	-	Fitting, 6-6	
	4	-	-	2375	-	-	2375	-	2375	Fitting, 6-6	
	1	685470	685470	-	685470	685470	-	685470	-	Bracket	
2	2	-	-	685470	-	-	685470	-	685470	Bracket	
3	1	222120	-	222120	221748	-	221748	222935	222935	Tube, RH JIC	
	1	222124	-	222124	221910	-	221910	-	-	Tube, RH ORFS	
4	1	222121	-	222121	221749	-	221749	222936	222936	Tube, RH JIC	
	1	222125	-	222125	221911	-	221911	-	-	Tube, RH ORFS	
5	1	-	-	222122	-	-	221908	-	222937	Tube, LH JIC	
	1	-	222126	222126	-	221912	221912	-	-	Tube, LH ORFS	
6	1	-	-	222123	-	-	221909	-	222938	Tube, LH JIC	
	1	-	222127	222127	-	221913	221913	-	-	Tube, LH ORFS	
	2	611337	611337	-	611337	611337	-	611337	-	ⓐ Adapter Fitting, 6-8	
7	4	-	-	611337	-	-	611337	-	611337	ⓐ Adapter Fitting, 6-8	
	2	2840	2840	-	2840	2840	-	2840	-	O-Ring	
8	4	-	-	2840	-	-	2840	-	2840	O-Ring	

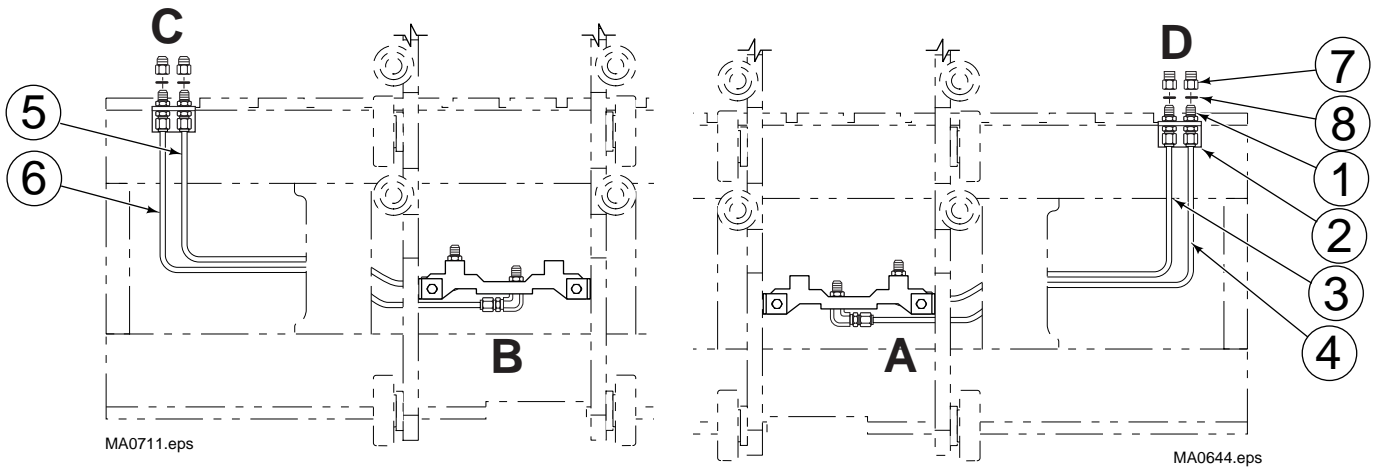
ⓐ Use Reference: S-10449, S-10471

30D/35D/40D/50D-MT MASTS

NOTE: All illustrations are shown as viewed from the driver's seat.



Double Function



Single Function LH

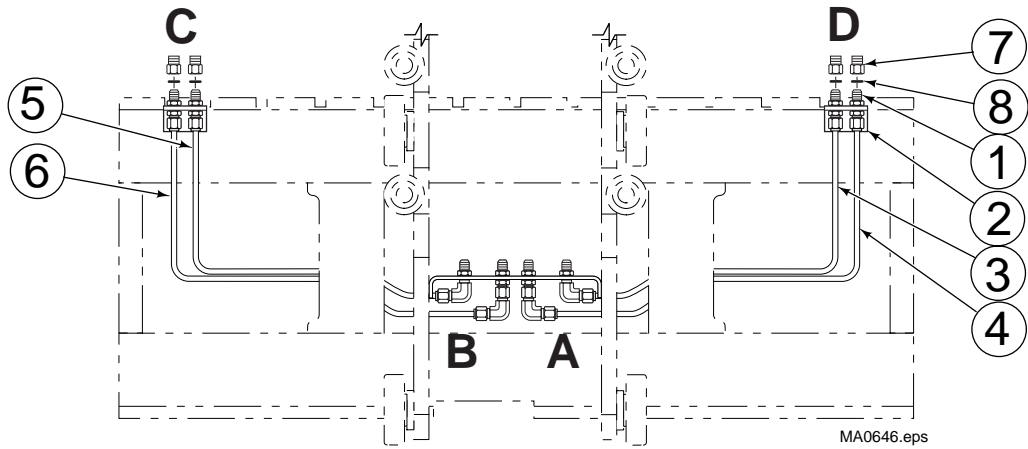
Single Function RH

		30/35/40D-MT						50D-MT			
		37-in. & Wider Carriage						37-in. & Wider Carriage			
		A to D	B to C	A to D and B to C	A to D	B to C	A to D and B to C	A to D	A to D and B to C		
REF	QTY	PART NO.	PART NO.	PART NO.	PART NO.	PART NO.	PART NO.	PART NO.	PART NO.	DESCRIPTION	
		221453	-	221454	221454	-	221544	221545	221544	Hose Adaption Kit, JIC	
		221548	222234	221630	221455	222235	221456	-	-	Hose Adaption Kit, ORFS	
	2	2375	2375	-	2375	2375	-	2375	-	Fitting, 6-6	
1	4	-	-	2375	-	-	2375	-	2375	Fitting, 6-6	
	1	685470	685470	-	685470	685470	-	685470	-	Bracket	
2	2	-	-	685470	-	-	685470	-	685470	Bracket	
3	1	221451	-	221451	221539	-	221539	221539	221539	Tube, RH JIC	
	1	221546	-	221546	221457	-	221457	-	-	Tube, RH ORFS	
4	1	221452	-	221448	221540	-	221541	221540	221541	Tube, RH JIC	
	1	221547	-	221631	221461	-	221458	-	-	Tube, RH ORFS	
5	1	-	-	221450	-	-	221542	-	221542	Tube, LH JIC	
	1	-	221632	221632	-	221459	221459	-	-	Tube, LH ORFS	
6	1	-	-	221449	-	-	221543	-	221543	Tube, LH JIC	
	1	-	222233	221633	-	222232	221460	-	-	Tube, LH ORFS	
	2	611337	611337	-	611337	611337	-	611337	-	① Adapter Fitting, 6-8	
7	4	-	-	611337	-	-	611337	-	611337	① Adapter Fitting, 6-8	
	2	2840	2840	-	2840	2840	-	2840	-	O-Ring	
8	4	-	-	2840	-	-	2840	-	2840	O-Ring	

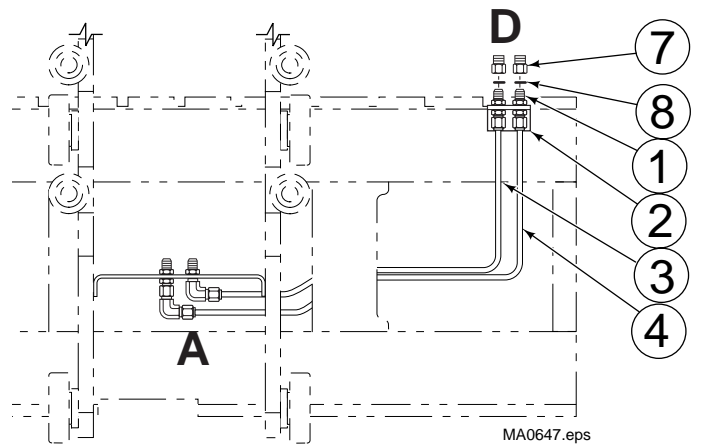
© Usec Reference: S-10441, S-10468

55D-MT MASTS

NOTE: All illustrations are shown as viewed from the driver's seat.



Double Function

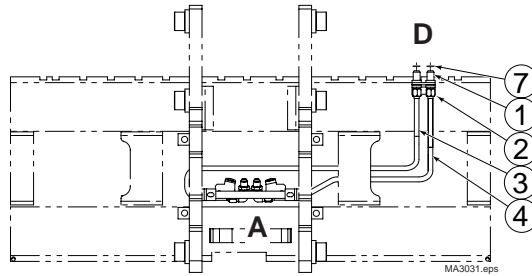


Single Function RH

55D-MT				
37-in. & Wider Carriage				
		A to D	A to D and B to C	
REF	QTY	PART NO.	PART NO.	DESCRIPTION
		221829	221830	Hose Adaption Kit, JIC
		-	-	Hose Adaption Kit, ORFC
	2	2375	-	Fitting, 6-6
1	4	-	2375	Fitting, 6-6
	1	685470	-	Bracket
2	2	-	685470	Bracket
	1	221823	221825	Tube, RH JIC
3	1	-	-	Tube, RH ORFS
	1	221824	221826	Tube, RH JIC
4	1	-	-	Tube, RH ORFS
	1	-	221827	Tube, LH JIC
5	1	-	-	Tube, LH ORFS
	1	-	221826	Tube, LH JIC
6	1	-	-	Tube, LH ORFS
7	2	611337	-	① Adapter Fitting, 6-8
	4	-	611337	① Adapter Fitting, 6-8
8	2	2840	-	O-Ring
	4	-	2840	O-Ring

① Used for Quick-Change couplers.

80/100D-MT MASTS



Single Function RH

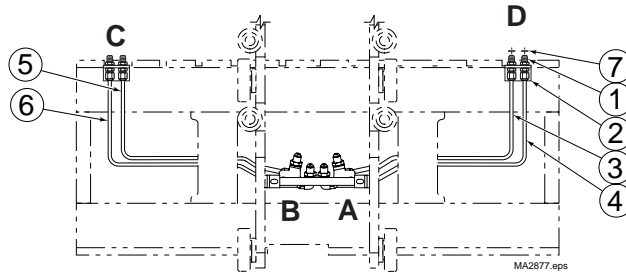
80/100D-MT

37-in. & Wider Carriage

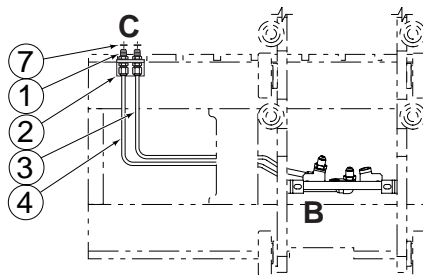
REF	QTY	A to D		DESCRIPTION
		260745		Hose Adaption Kit, JIC
1	2	2376		Fitting, 6-6
2	1	245059		Bracket
3	1	260744		Tube, RH JIC
4	1	245055		Tube, RH JIC
7	2	2841		O-Ring

Ref S-15379

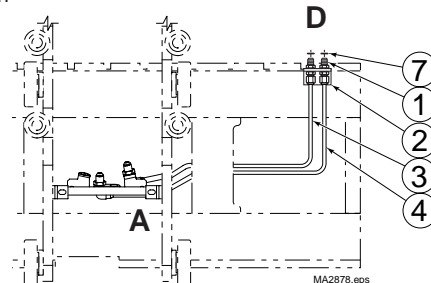
NOTE: All illustrations are shown as viewed from the driver's seat.



Double Function



Single Function LH



Single Function RH

80/100D-MT

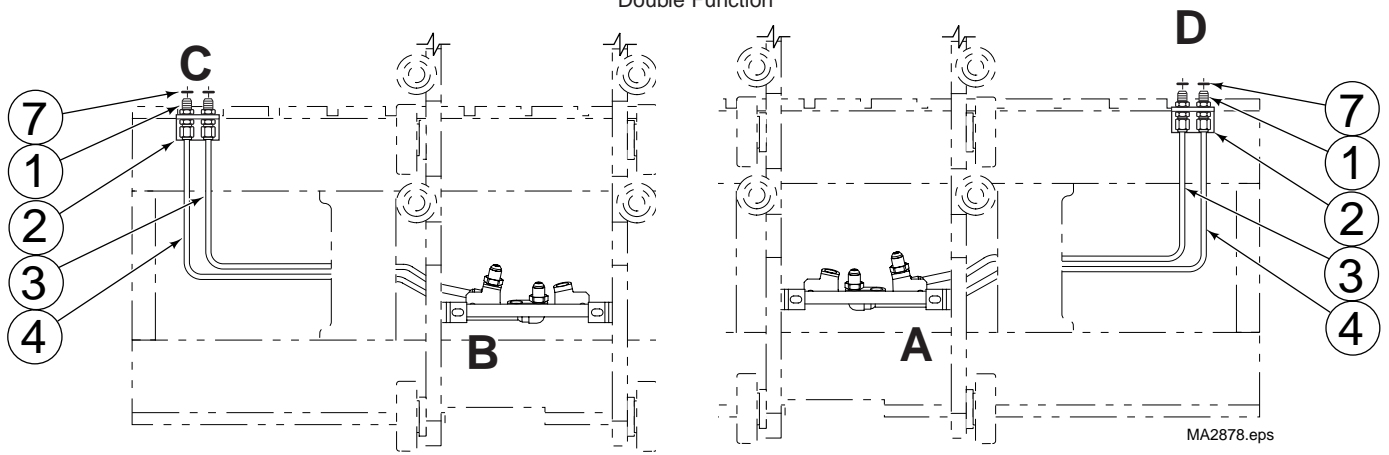
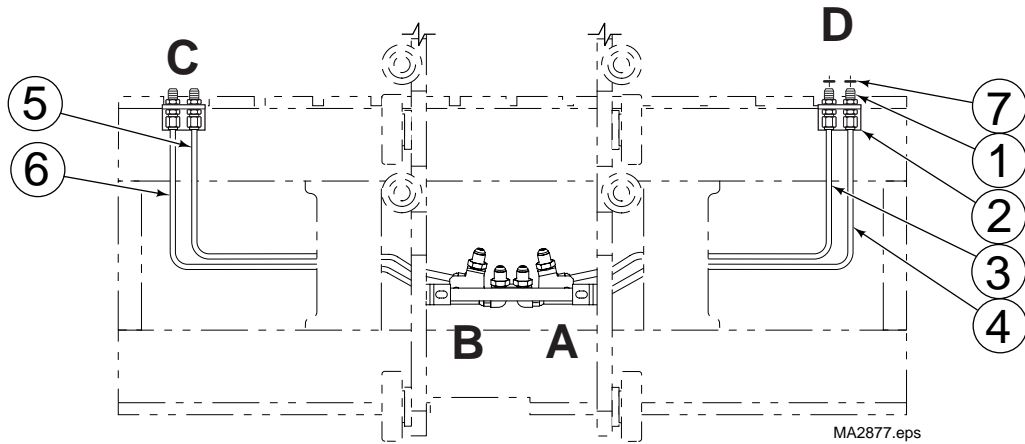
37-in. & Wider Carriage

REF	QTY	A to D and B to C			DESCRIPTION
		A to D	B to C	A to D and B to C	
		245053	245052	254054	Hose Adaption Kit, JIC
		-	-	-	Hose Adaption Kit, ORFC
1	2	2376	2376	-	Fitting, 6-6
	4	-	-	2376	Fitting, 6-6
2	1	245059	254059	-	Bracket
	2	-	-	254059	Bracket
3	1	245056	-	245056	Tube, RH JIC
	1	-	-	-	Tube, RH ORFS
4	1	245055	-	245055	Tube, RH JIC
	1	-	-	-	Tube, RH ORFS
	1	-	254056	254056	Tube, LH JIC
5	1	-	-	-	Tube, LH ORFS
	1	-	254057	254057	Tube, LH JIC
6	1	-	-	-	Tube, LH ORFS
	2	2841	2841	-	O-Ring
7	2	-	-	2841	O-Ring

Ref S-15379

110D-MT MASTS

NOTE: All illustrations are shown as viewed from the driver's seat.



110D-MT					
37-in. & Wider Carriage					
		A to D	B to C	A to D and B to C	
REF	QTY	PART NO.	PART NO.	PART NO.	DESCRIPTION
		254902	254903	254904	Hose Adaption Kit, JIC
		-	-	-	Hose Adaption Kit, ORFC
1	2	2376	2376	-	Fitting, 6-6
	4	-	-	2376	Fitting, 6-6
2	1	254059	254059	-	Bracket
	2	-	-	254059	Bracket
3	1	254096	-	254906	Tube, RH JIC
	1	-	-	-	Tube, RH ORFS
4	1	254914	-	254905	Tube, RH JIC
	1	-	-	-	Tube, RH ORFS
5	1	-	254908	254908	Tube, LH JIC
	1	-	-	-	Tube, LH ORFS
6	1	-	254915	254907	Tube, LH JIC
	1	-	-	-	Tube, LH ORFS
7	2	2841	2841	-	O-Ring
	4	-	-	2841	O-Ring

Ref S-16018