



Installation Instructions

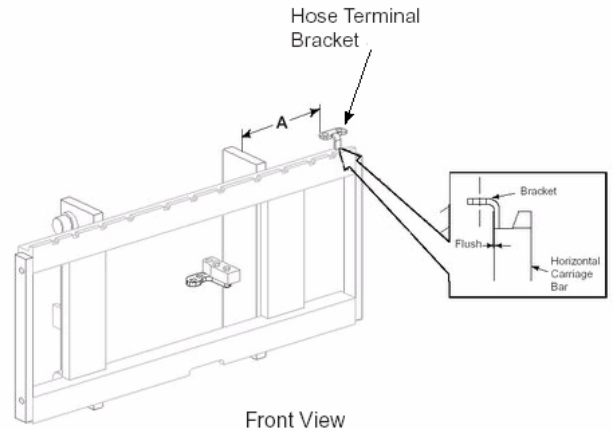
E-Series Mast Hose Adaption Kits for Internal Hose Reeving

This sheet describes the installation of Hose Adaption Kits to provide a high termination for Lift Tek E & EV-Series Masts. The Kits are for Hi-Vis bars and contain the necessary hoses, tubing, brackets and fittings to connect between the mast internal reeving and the upper bar.

①

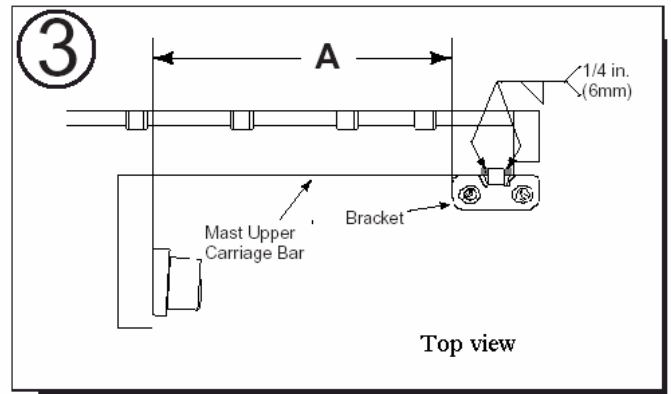
The illustrations on this page show where to weld the upper hose terminal mounting brackets. The following pages show hose and fitting location, and part numbers for the contents of each kit. Reusable fittings are provided on the hoses to enable hoses to be cut to an exact length.

- ① Clean all surfaces to be welded. Remove any paint, oil, grease or other contaminants.
- ② Position the bracket(s) on the back side (driver's view) of the mast upper carriage bar using the dimensions shown. Clamp the bracket(s) in place.



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

- ③ Weld the brackets to the mast carriage using the following weld procedures:
 - Protect hoses and adjacent areas from weld splatter.
 - Preheat weld areas to 70° F (21° C).
 - **WELD METHOD A – GMAW (Gas Metal Arc Welding).** Attach ground wire to carriage. Weld using AWS ER70S-6 0.045" - 0.052" diameter wire with 80% argon and 10% CO₂ shielding gas at 35 - 45 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. Remove weld splatter and inspect the welds.
 - **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. Remove all slag and weld splatter and inspect the welds.



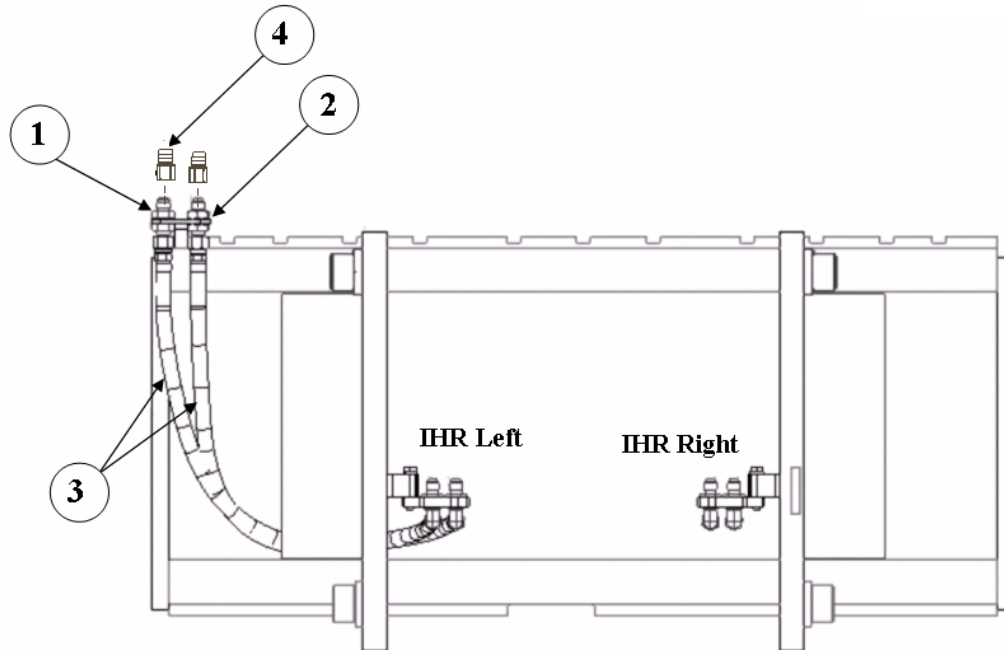
Mast Model	Dimension A
E Series MS	6.56" (166.6mm)

For Technical Support . . . or to Order Parts

Call: 1-888-946-3330 OR Write: Lift Technologies, Inc., 7040 South Highway 11, Westminster, S.C. 29693

Part No. 255933 r0

E Series MS



		E & EV - Series MS		DESCRIPTION
		Installation Type		
		Single IHR	Double IHR	
REF	QTY	PART NO.	PART NO.	
		255831	255832	Hose Adaption Kit, No. 6 hose.
1	2	2375	-	Fitting, 6-6
	4	-	2375	Fitting, 6-6
2	2	250050	250050	Bracket
3	2	2161	-	Hose, 6
3	4	-	2161	Hose, 6
4	2	611337	-	Fitting, 6-8
	4	-	611337	Fitting, 6-8

Reference: S-15985

Note: Hose and Kit part numbers for Cushion Class III Carriages shown, for options see S-15985.

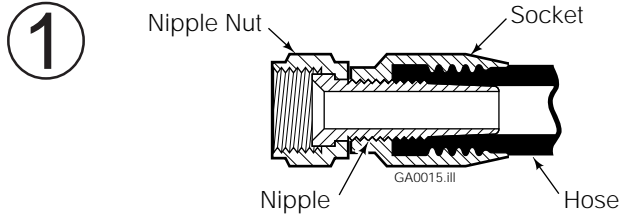
Reusable Hose Fittings

Kit hoses are equipped with reusable fittings to enable hoses to be modified to the exact length required for installation.

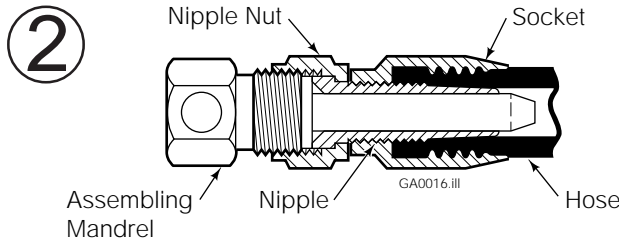
IMPORTANT: Do not shorten hoses to the point where they will be stretched or kinked when installed. When routing hoses, make sure they will not be pinched, rubbed, twisted, or otherwise damaged throughout their full range of movement. Use hose clamps to secure hoses if required.

Fitting Removal

To shorten a hose, remove either end-fitting using the following procedures:

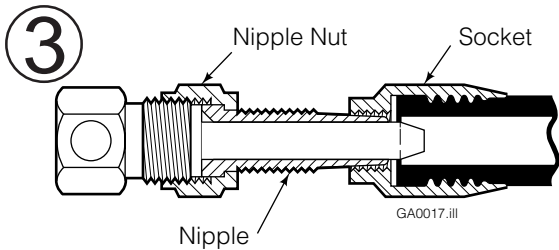


Clamp the fitting socket in a vise.

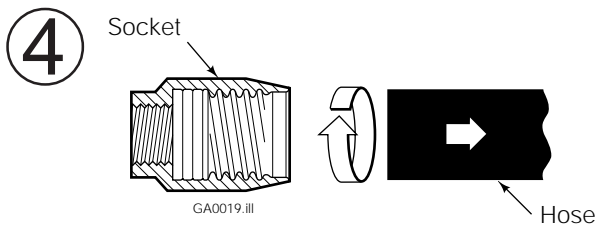


Lubricate an assembling mandrel* with hydraulic fluid. Slide the mandrel into the nipple and engage the nipple nut threads. Using two wrenches, screw the mandrel into the nipple nut.

* Stratoflex PN : 2701-9-18S (#6 hose), 2071-12-16S (#8 hose).



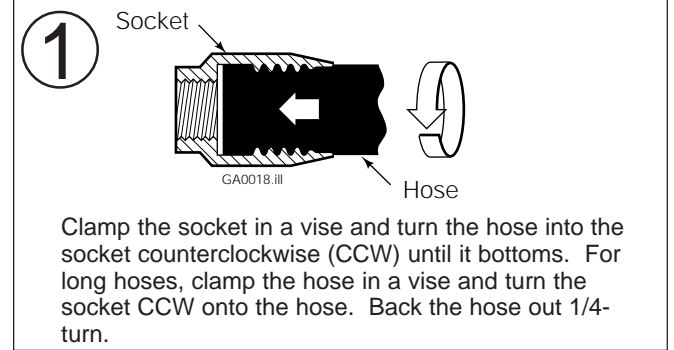
With a wrench on the nipple nut, unscrew the nipple from the hose socket.



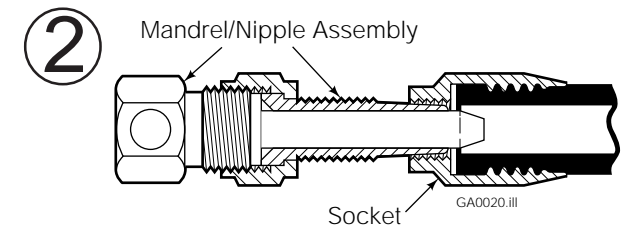
Clamp the socket in a vise and manually turn the hose clockwise (CW) to remove it from the socket. For long hoses, clamp the hose in a vise and turn the socket CW to remove it from the hose.

Hose Reassembly

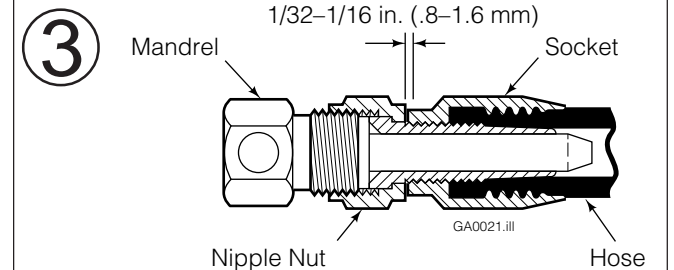
Cut the hose to the desired length using a fine-toothed hacksaw or hose cutoff machine. Make sure the hose is not cut too short for proper installation.



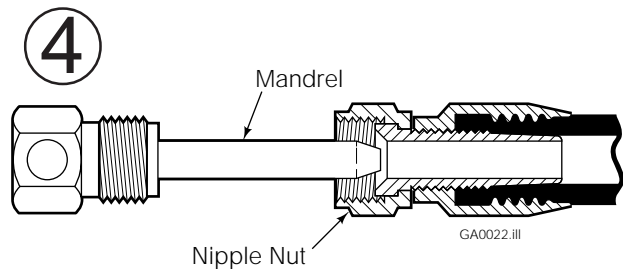
Clamp the socket in a vise and turn the hose into the socket counterclockwise (CCW) until it bottoms. For long hoses, clamp the hose in a vise and turn the socket CCW onto the hose. Back the hose out 1/4-turn.



Lubricate the mandrel/nipple assembly and the inside of the hose with hydraulic fluid. Insert the nipple into the hose, making sure it moves in and out freely.



With a wrench on the mandrel, screw the nipple into the fitting socket. Leave 1/32 to 1/16-in. (.8 to 1.6 mm) clearance between the nipple nut and socket so the nut swivels freely.



Using two wrenches, remove the mandrel from the nipple nut.

IMPORTANT: Inspect the hose for proper assembly. Sight down the fitting ID to assure that the nipple did not scarf a piece of hose material that might prevent free flow. If damage is found, remove the fitting and cut away the damaged hose. Reassemble the hose as in Steps 1 through 4. Use compressed air to clear the hose of debris.