

SM KEYSHEET AND GENERAL INFORMATION

Link-Belt
C R A N E S

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ORDER NO. - L8380 MODEL - HTC-8640XL II SERIAL NO. - L8K8-6040

DISTRIBUTOR: MARDIAN EQUIPMENT CO., INC.
ENGINE:
MODEL- CUMMINS ISL9
S/N- 74071434
OPERATION- 4310785
PARTS- NONE

SALES ORDER: 026040
TRANSMISSION:
MODEL- ZF 12-AS-2535
S/N- 00586744
OPERATION- NONE

AEM: BOOK- MC-1407
VIDEO- DVD-CR

O/M BOOK- 1273080218
ADDENDUMS - NONE
TECH BULLETINS - NONE
MISCELLANEOUS - HOIST ROPE CAUTION

SM CODE DESCRIPTION
SM00 GENERAL INFORMATION

SM00-000-000.00 HOW TO USE THIS MANUAL,
SERVICE & SAFETY INFO

SM01 RUBBER TIRE LOWER

SM01-001-006.00 BOOM REST, R & I
SM01-002-012.00 FRONT AXLE, RECON
SM01-002-015.00 FRONT WHEEL & BRAKE
DRUM, R & I
SM01-003-010.00 BRAKE, RECON
SM01-003-014.00 ADJUSTING THE BRAKES
SM01-003-019.00 AUTOMATIC SLACK ADJUSTERS
SM01-004-013.00 FRONT AXLE & AIR
SUSPENSION, R & I
SM01-005-005.00 STEERING MITER BOXES, R&I
SM01-005-027.00 TROUBLESHOOTING SHEPPARD
STEERING GEARS
SM01-005-035.00 STEERING COLUMN, RECON
SM01-005-037.00 STEERING GEARS, RECON
SM01-005-048.00 STEERING COLUMN, R & I
SM01-006-040.00 STEERING GEARS, R & I
SM01-006-041.00 FRONT WHEEL ALIGNMENT &
STEER LINKAGE ADJUSTMENT
SM01-010-038.00 POWER STEERING PUMP, R&I
SM01-010-039.00 POWER STEERING PUMP WITH
PRIORITY VALVE, RECON
SM01-016-004.00 HEATER CORE & A/C EVAP
COIL, ILLUSTRATED
SM01-018-056.00 TRANSMISSION AND
CLUTCH, R & I
SM01-018-057.00 TRANSMISSION, RECON
(ZF ASTRONIC II)
SM01-019-034.00 TRANS SHIFT CONTROL, R&I
SM01-020-002.00 SUSP BRAKE PEDAL, RECON

SM CODE DESCRIPTION
SM01 RUBBER TIRE LOWER

SM01-020-008.00 SUSPENDED BRAKE PEDAL,
R & I
SM01-022-004.00 U-JOINT INSTALLATION
(HALF ROUND YOKES)
SM01-022-005.00 U-JOINT INSTALLATION
(FULL ROUND YOKES)
SM01-024-015.00 REAR AXLES, RECON
SM01-025-015.00 ANTILOCK BRAKING SYSTEM,
TROUBLESHOOTING
SM01-027-000.00 PNEUMATIC SYSTEM AIR LINE
IDENTIFICATION CODE
SM01-027-026.00 CAGING DUAL AIR BRAKE
CHAMBERS
SM01-027-028.00 FRONT AIR BRAKE CHAMBER,
RECON
SM01-027-029.00 DUAL AIR BRAKE CHAMBER,
RECON
SM01-027-062.00 AIR DRYER, R & I
SM01-027-063.00 AIR DRYER, RECON
SM01-027-091.00 FRONT AIR BRAKE CHAMBER,
R&I (W/AUTO SLACK ADJUST)
SM01-027-092.00 DUAL AIR BRAKE CHAMBER,
R & I
SM01-027-139.00 AIR SYSTEM
COMPONENTS, R & I
SM01-027-145.00 AIR SYSTEM
COMPONENTS, R & I
SM01-028-002.00 REAR WHEEL HUB & BRAKE
DRUM, R & I
SM01-029-029.00 REAR AXLES & AIR
SUSPENSION, R & I
SM01-039-003.00 HYDRAULIC SYSTEM CLEANING
SM01-039-005.00 HYD RESV FILT ASSY, RECON
SM01-039-008.00 HYD RESV FILTER, R&I

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SM01 RUBBER TIRE LOWER		SM01 RUBBER TIRE LOWER	
*****		*****	
SM01-043-001.00	SOLENOID VALVES, GENERAL RECONDITION	SM01-079-080.00	LOWER HYD COMPONENTS, R&I (SUCTION, PRESS, & RETURN)
SM01-043-004.00	4-WAY SOLENOID VALVE, RECN	SM01-081-014.00	HYDRAULIC GEAR PUMP, RECN (MULTI SECTION - STEEL)
SM01-043-045.00	OUTRIGGER DIRECTIONAL CONTROL VALVE, R & I	SM01-081-037.00	HYDRAULIC PUMP, RECON (MULTI SECTION-ALUMINUM)
SM01-043-046.00	OUTRIGGER FUNCTION CONTROL VALVE, R & I	SM01-081-040.00	HYDRAULIC PUMP, R & I (TANDUM 4-SECTION)
SM01-043-047.00	5TH O/R DIR CTRL VLV, R&I	SM01-081-041.00	HYDRAULIC PUMP, R & I (PICK & CARRY 2 SECTION)
SM01-044-023.00	5TH O/R LOCK VLV CART, R&I	SM01-081-045.00	RADIATOR FAN MOTOR, R & I
SM01-044-027.00	OUTRIGGER LOCK VALVE CARTRIDGE, R&I AND RECON	SM01-081-046.00	HYD GEAR PUMP/MOTOR, RECN (PGP/PGM620 SERIES)
SM01-045-056.00	OUTRIGGER BEAM & BEAM CYLINDER, R & I	SM01-081-051.00	HYDRAULIC PUMP, R & I (O.R./PICK & CARRY)
SM01-045-073.00	OUTRIGGER BEAM CYLINDER ASSY, RECON.		
SM01-046-034.00	JACK CYLINDER, RECON	SM03 UPPER FRAME & MACHY	
SM01-046-044.00	JACK CYLINDER, R & I	*****	
SM01-046-045.00	5TH OUTRIGGER JACK CYLINDER, R & I	SM03-001-072.00	UPPER REVOLVING FRAME AND TURNTABLE BEARING, R & I
SM01-047-038.00	PICK & CARRY MANIFOLD BLOCK, ILLUSTRATED	SM03-003-016.00	FIXED COUNTERWEIGHT, R&I
SM01-047-048.00	P&C MANIFOLD BLOCK, ILLUS	SM03-010-025.00	CTWT REMOVAL CYL, RECON
SM01-048-037.00	ROTATING JOINT, R & I	SM03-010-037.00	COUNTERWEIGHT REMOVAL CYLINDER, R & I
SM01-048-038.00	ROTATING JOINT, RECON (6-WAY)	SM03-010-077.00	COUNTERWEIGHT REMOVAL CONTROL VALVE, R & I
SM01-066-000.00	ELECTRICAL SYSTEM WIRE IDENTIFICATION CODE		
SM01-066-035.00	BATTERY, R & I	SM04 VERTICAL SHAFTS	
SM01-069-009.00	TIRES & RIMS, R & I	*****	
SM01-069-016.00	TIRE & RIM, INSPECTION & MAINTENANCE	SM04-010-032.00	SWING REDUCTION UNIT AND BRAKE, R & I
SM01-071-004.00	REPAIR OF COMPONENTS MADE OF FIBROUS COMPOSITE MATL	SM04-010-033.00	SWING REDUCTION UNIT W/BRAKE, RECON
SM01-071-024.00	ENGINE HOUSING, R & I		
SM01-073-002.00	ELECTRONIC GAUGES, TROUBLESHOOTING	SM05 HORIZONTAL SHAFTS	
SM01-075-065.00	STARTER, R & I	*****	
SM01-075-088.00	ENGINE COOLING PACKAGE, R & I	SM05-006-019.00	WINCH, RECON (BRADEN PD12C & PD15B)
SM01-076-042.00	COLLECTOR RING, R & I	SM05-006-020.00	WINCH TROUBLESHOOTING (BRADEN PD12C & PD15B)
SM01-076-101.00	COLLECTOR RING ASSY, RECN	SM05-006-039.00	WINCH ASSEMBLY, R & I
SM01-077-023.00	ALTERNATOR, R & I	SM05-018-004.00	WINCH ROLLER, R & I AND RECONDITION
SM01-079-057.00	LOWER HYD COMPONENTS, R&I (SUCTION, PRESS,& RETURN)		

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SM CODE	DESCRIPTION	SM CODE	DESCRIPTION
SM06 UPPER ENGINE		SM07 UPPER HYDRAULICS & AIR	
*****		*****	
SM06-008-009.00	THROTTLE TREADLE, R & I	SM07-008-117.00	SINGLE AXIS CONTROLLER
SM06-008-010.00	THROTTLE TREADLE, RECON (WILLIAMS CONTROLS, INC.)		VALVE, R & I
SM06-025-022.00	HEATER CORE & A/C EVAP COIL, ILLUSTRATED	SM07-008-118.00	SWING BRK PEDAL VLV, RECN
SM06-025-023.00	UPPER CAB A/C EVAP COIL & HEATER CORE, R & I	SM07-008-122.00	WINCH CNTRBAL VLV, RECON
SM06-025-026.00	DIESEL COOLANT HEATER, TROUBLESHOOTING & RECON	SM07-008-127.00	WINCH CONTROL VALVE, RECN
SM06-025-029.00	DIESEL COOLANT HEATER, R & I	SM07-008-129.00	HYD CONTROL VALVES, RECON
SM06-047-000.00	ELECTRICAL SYSTEM WIRE IDENTIFICATION CODE	SM07-008-131.00	PILOT OIL SUPPLY VALVE, RECON
SM07 UPPER HYDRAULICS & AIR		SM07-008-158.00	TELESCOPE/SWING CONTROL VALVE, R & I
*****		SM07-008-159.00	BOOM HOIST CONTROL VALVE, R & I
SM07-000-000.00	HYDRAULIC SCHEMATIC DIAGRAM SYMBOL LEGEND	SM07-008-160.00	WINCH COUNTERBALANCE VALVE, R & I
SM07-001-027.00	PILOT CONTROL ACCUMULATOR, R & I	SM07-018-001.00	HYDRAULIC TUBE FITTINGS
SM07-002-032.00	RELIEF VALVE, RECON	SM09 TUBULAR BOOM	
SM07-003-006.00	SOLENOID VALVES, RECON (GENERAL PROCEDURE)	*****	
SM07-004-042.00	UPPER HYDRAULIC COMP, R&I (UPPER FRAME)	SM09-001-002.00	REPAIRING DAMAGED TUBULAR BOOMS, FLYS, & JIBS
SM07-004-048.00	UPPER HYDRAULIC COMP, R&I (TWO WINCH PLUMBING)	SM17 HYDRAULIC BOOM	
SM07-004-079.00	UPPER HYD COMPONENTS, R&I (CAB FLOOR)	*****	
SM07-006-034.00	SWING MOTOR, RECON	SM17-001-036.00	HYDRAULIC BOOM INSPECTION
SM07-006-095.00	WINCH MOTOR, RECON (LINDE)	SM17-001-054.00	FOUR SECTION BOOM, R & I (35.5-110' FULL POWER)
SM07-006-099.00	SWING MOTOR, R & I	SM17-001-055.00	FOUR SECTION BOOM, RECON (35.5-110' FULL POWER)
SM07-006-114.00	WINCH MOTOR, R & I	SM17-002-022.00	BOOM TELE CYL, RECON.
SM07-008-032.00	CONTROL VALVE, RECON (MODEL V20)	SM17-002-026.00	BOOM TELESCOPE CYLINDER, TROUBLESHOOTING
SM07-008-108.00	SINGLE AXIS CONTROLLER VALVE, RECON	SM17-002-027.00	BOOM TELESCOPE COUNTERBALANCE VALVE, R&I
SM07-008-111.00	WINCH CONTROL VALVE, R&I	SM17-003-013.00	BOOM HOIST CYLINDER, RECN
SM07-008-113.00	BOOM TELESCOPE FOOT CONTROL VALVE, R & I	SM17-003-034.00	BOOM HOIST CYLINDER, R&I
SM07-008-114.00	HYD FOOT CTRL VALVE, RECN	SM17-003-035.00	BOOM HOIST COUNTERBALANCE VALVE, R & I
SM07-008-115.00	SWING BRAKE PEDAL VALVE, R & I	SM17-009-006.00	FOUR SHEAVE HEAD MACHINERY, RECON
		SM18 SPECIAL ATTACHMENTS	

		SM18-000-001.00	CAPSCREW TORQUES
		SM18-000-002.00	BEARING, GEAR, SHAFT, & HOUSING INSPECTION

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SM CODE	DESCRIPTION	SM CODE	DESCRIPTION
SM18	SPECIAL ATTACHMENTS		

SM18-000-003.00	CRANE SYSTEM SCHEMATICS		
SM18-007-030.00	REELING DRUM, R & I		
SM18-007-038.00	REELING DRUM, TRBL & RECN (HIRSCHMANN)		
SM18-018-001.00	AIR CONDITIONING SERVICE PRECAUTIONS		
SM18-018-004.00	A/C COMPRESSOR, RECON.		
SM18-018-013.00	A/C COMPRESSOR, R & I (UPPER)		
SM18-018-014.00	A/C HYDRAULIC DRIVE MOTOR, R & I (UPPER)		
SM18-018-015.00	A/C HYDRAULIC DRIVE MOTOR, RECON (UPPER)		

How To Use This Manual, General Service Instructions, And Safety Procedures

The following information is provided to help guide the user of this manual. An explanation of how this manual is organized, as well as general information and safety considerations which should be understood when performing any service or maintenance procedure, is given. This information is general in nature and should supplement any of the specific procedures in this manual along with a constant awareness of safety and common sense.

How To Use This Manual

This Service Manual is a collection of written procedures which are used to service and maintain a specific crane model. The index, which is called a "Keysheet", is used to organize the procedures within this manual and serve as a Table Of Contents as well. Each procedure, in this manual, is written so that it can stand alone and typically covers only one procedure. Procedures are given a numerical designation, or "SM Code" Number, (Example: SM01—005—034.00) which is unique to that procedure and that procedure only. The following is a listing of the general area definitions which are designated by the first digits in the SM Code Number sequence:

General Area Descriptions

- SM01 — Rubber Tire Lower
- SM02 — Crawler Lower
- SM03 — Upper Revolving Frame & Machinery
- SM04 — Vertical Shafts
- SM05 — Horizontal Shafts
- SM06 — Upper Engine
- SM07 — Hydraulic Power Supply
- SM08 — Angle Boom
- SM09 — Tubular Boom
- SM10 — Tagline Winder
- SM11 — Fairleader
- SM12 — Shovel Attachment
- SM13 — Trench Hoe, Logger & Scraper Attachment & Prop Handler
- SM14 — Cab & House Assembly
- SM15 — Rotascope Attachment (Discontinued)
- SM16 — Wire Rope Requirements
- SM17 — Hydraulic Boom And Attachments
- SM18 — Special Attachments
- SM19 — Diesel Pile Hammer (Discontinued)
- SM20 — Tower, Climbing Assembly, Traveling Base & Gantry (Discontinued)
- SM21 — Log Skidder (Discontinued)
- SM22 — Hydraulic Hammer (Discontinued)

The procedures in this manual are collated by SM Code Number sequence. Use the Keysheet in the front of this manual, the general area descriptions shown previously, and the SM Code title shown on the

Keysheet to find the specific procedure required to service the crane.

Throughout this manual, reference is made to the left, right, front, and rear, pertaining to directions and locations. These reference directions are relative to the operator, sitting in the operator's seat, with the upper directly over the front of the carrier, unless otherwise stated. (Crawler mounted cranes: upper over the front of the crane with travel motors to the rear.)

Danger, warning, and caution captions as well as special notes are used throughout this manual and on the crane to emphasize important and critical instructions. **If any instruction, caution, warning, or danger labels, decals, or plates become lost, damaged, or unreadable, they must be replaced.** Information contained on such labels, decals, and plates is important and failure to follow the information they contain could result in an accident. Replacement labels, decals, and plates can be ordered through a Link-Belt Distributor. For the purpose of this manual, danger, warning, and caution captions and notes are defined as follows:



DANGER

An operating procedure, practice, etc. which, if not correctly followed, may result in severe personal injury, dismemberment, or loss of life.



WARNING

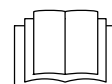
An operating procedure, practice, etc. which, if not correctly followed, may result in personal injury.

CAUTION

An operating procedure, practice, etc. which, if not correctly followed, may result in damage to, or destruction of, equipment or property.

NOTES

Note: An operating procedure step, condition, etc. which is essential in order for the process to be completed properly.



This symbol may appear in manuals or on a label on the crane to alert personnel that additional instructions are included in the crane Operator's Manual.



Figure 1
Keep hands and tools clear of moving parts.

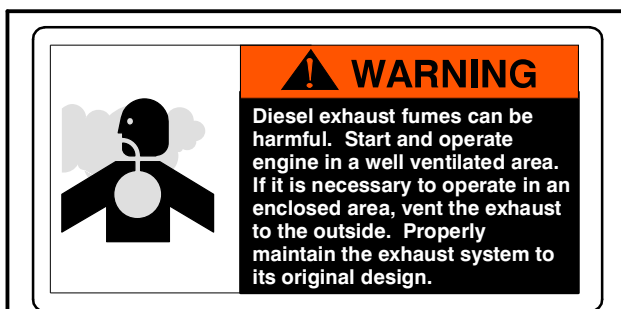
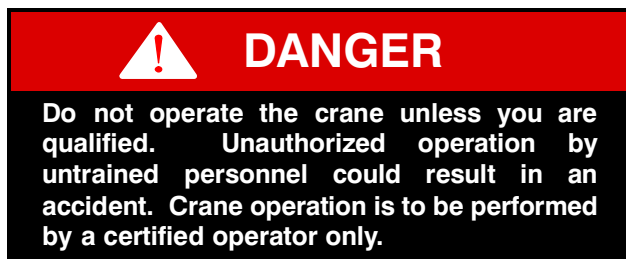


Figure 2
Diesel Exhaust Fumes.

Service Safety And Set Up Guidelines

The following is a list of safety and set up considerations which may apply to any service or maintenance procedure. Review the entire list and understand the type of things you must consider to perform a safe service procedure and then apply these guidelines to each specific service or maintenance procedure.



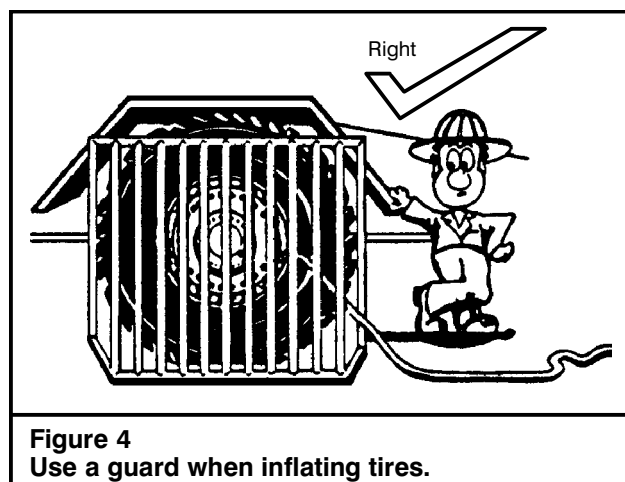
Service Safety

1. Read and understand the service or maintenance procedure to be performed before beginning work. By reading the procedure ahead of time, you can be sure to have the replacement parts and tools on hand that are required to complete the job.
2. Wear protective gear to prevent injury; hard hat, safety glasses, gloves, steel toed shoes, etc.



Figure 3
Pinch Point Label

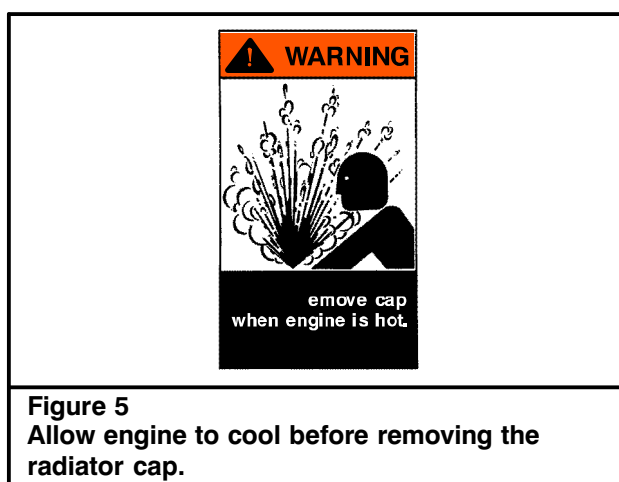
3. First aid supplies and a fire extinguisher should be on the job site to assist in an unexpected situation. The location of these items should be known to all as well as access to a telephone for emergencies.
4. Work in a clean, dry, firm, level area whenever possible. Choosing the correct work site can make a big difference on how well the job goes.
5. Use caution around flammable materials. Be aware of all the materials in the work area which are a threat. Also make others aware of volatile materials; post signs if necessary.
6. Release all trapped pressure in air and hydraulic circuits before disconnecting any line or component. Shutdown the crane, exhaust all pressure from the crane's air reservoir(s) and work the hydraulic control levers back and forth before servicing the crane.
7. Do not disconnect any hydraulic line from a crane which has its attachment in the air. Trapped pressure may be all that is suspending it. Disconnecting a line could release the trapped pressure, causing the attachment to fall. Lower the attachment to the ground or on to its rest before servicing the crane.
8. Do not work on a crane which is in motion. Fans, belts, gear trains, etc. can catch an unexpected person and quickly dismember them.
9. Do not climb on the attachment or other hard to reach areas. If the steps and/or ladders which are installed on the crane do not provide adequate access to the area of the crane which needs servicing, use a step ladder or other approved device.
10. Pinch points exist between the upper and lower frames. Death or dismemberment may result from personnel caught in these points. Learn where these pinch points are and stay clear of the rotating upper frame.



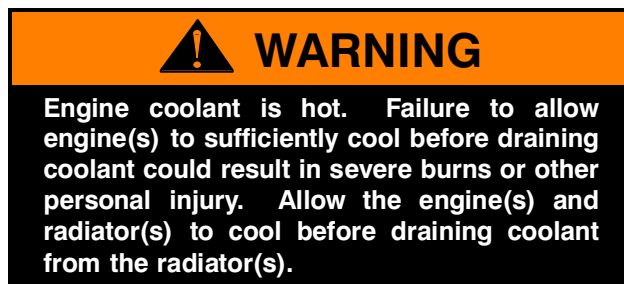
11. If working in a confined area, be sure to provide adequate ventilation when running the engine(s), using toxic solvents, welding, or any other operation which contaminates the fresh air supply.
12. Post a sign in the operator's cab to alert others that the crane is under service. Starting the crane while it is being serviced could severely injure someone. Crane damage could also occur if systems are operated prematurely. Imagine starting the engine(s) before the oil is replaced.
13. Secure access panels, doors, and machinery hoods when in the open position to ensure they do not fall or slam shut due to wind or accidental disruption.
14. Crane parts may be heavy. Always use an appropriate lifting device to support work. Do not attempt to lift an object without knowing its weight. Get help if necessary.
15. Always use a safety rim cage when inflating or deflating tires. Worn or misassembled parts can "explode" from the assembly causing serious injury. Use a safety rim cage, clip on air chuck, and stand aside when inflating or deflating tires.

Crane Set Up And Disassembly

1. Properly park the crane as described in the Operator's Manual. Park the crane in an area which provides the most comfortable working conditions. However, do not park the crane where it will be an obstruction or an intrusion to traffic, coworkers, or to the public. Keep in mind that a major service procedure, or a repair part which requires a long lead time, could have the crane disabled for an extended period of time.
2. Keep in mind the mess which is sometimes caused by a crane under repair. Oil or other fluid leaks should be contained or prevented. Consider your responsibility of maintaining a safe clean work area and a healthy environment for all.



3. If the crane is equipped with outriggers, it may be safer as well as an advantage to raise and level the crane on outriggers to provide easier access to areas underneath. Do not work under a crane that is improperly supported.
4. Shutdown the engine(s) per the instructions given in the Operator's Manual.
5. Post a sign in the operator's cab to alert others that the crane is being serviced.
6. Engines, transmissions, hydraulic systems, etc. generate extreme heat during operation. Temperatures can reach levels which may cause serious burns. Allow the crane to cool before attempting to service it.



7. Pressure is generated inside the engine's cooling system due to the heat transfer process from the engine(s) to the radiator(s). Do not attempt to open or drain the radiator(s) until it/they has/have had sufficient time to cool. Disconnecting hoses before the engine(s) and radiator(s) has/have cooled is even more dangerous. Wait until the engine(s) and radiator(s) have cooled and then drain the radiator(s) before disconnecting any hoses. Properly store or dispose of used coolant.

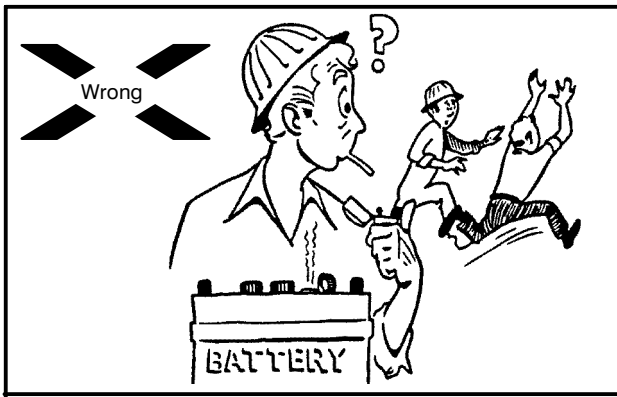


Figure 6
Do not use an open flame near the battery.

WARNING

Solvents and cleaning solutions can be hazardous. Serious personal injury may result from misuse of these products. Read and follow all the manufacturer's recommendations concerning solvents and cleaning solutions.

8. Thoroughly clean the area of the crane which is to be serviced. Dirt or other contamination could enter the hydraulic, air, lubricating system, etc. and cause immediate and/or long term problems. Cleaning the service area not only prevents contamination problems but it also makes working on the crane easier and sometimes problems are more recognizable.
9. Before beginning any removal or disassembly procedure, take a moment to observe critical features of the assembly which may greatly simplify the installation or assembly process. Label electrical, hydraulic, air, or other connections. Index mark pump, motor, and valve sections. Lightly spray paint or count the threads of adjustment screws. Simple steps such as these can minimize the effort needed to put the crane back in service.

WARNING

Hydraulic oil is under pressure and may be hot. A sudden release of hot oil could cause severe burns and/or other serious injury. Shutdown the engine(s) and exhaust all trapped hydraulic pressure from the system before removing any line or component.

10. Hydraulic systems, while operating, are under high pressure. Even after the crane is shutdown these pressures can remain trapped in the hydraulic lines and system components. Some hydraulic systems utilize an air pressurized reservoir which maintains pressure on the system after the crane is shutdown. It is critical that all residual pressure, which is trapped in the system, be neutralized before disconnecting any line or hydraulic component. Use the following techniques to exhaust trapped hydraulic pressure from the system:

- a. Lower the attachment to the boom rest, onto blocking, or onto the ground and shutdown the engine(s).
- b. Open the drain valves on the air system reservoir(s), if equipped, to bleed the air system pressure.
- c. Relieve any residual or precharge pressure by pushing the button on the pressure relief valve, on the hydraulic reservoir, if equipped. Otherwise, loosen the filler cap 1/4 turn.
- d. Turn the ignition switch to the **ON POSITION**, but **DO NOT START THE ENGINE**.
- e. Operate the steering control(s) back and forth repeatedly until steering becomes hard. (On cranes equipped with emergency steering system, it will take several rotations of steering wheel before steering becomes hard.)
- f. Work the crane control levers and outrigger switches, if equipped, back and forth several times.
- g. Turn ignition switch to the **OFF POSITION**.
- h. When pressure is fully relieved, close the drain valves on the air system reservoir(s), if equipped.

WARNING

Air lines may contain high pressure. Opening lines and fittings before relieving air pressure may result in serious injury. Shutdown the engine(s) and drain the air system reservoir(s) before opening any line or fitting.

11. Air system circuits, like hydraulic circuits, contain high pressures also. Although the threat of a hot working fluid does not exist, highly pressurized lines and components can possibly "fly off" if lines are disconnected before the system pressure is relieved. Open the drain valve on the air system reservoir(s) to exhaust system pressure before working on the crane.



WARNING

Use care not to cause sparks at the battery terminals while disconnecting or connecting the battery. Battery gasses are volatile and could be ignited by a spark or flame causing the battery to explode. Keep the area around the battery well ventilated and disconnect the negative side of the battery first, with the ignition switch “OFF”, to minimize hazard.

Battery posts, terminals, and related accessories contain lead and lead compounds. Eating or smoking with lead residue on hands may cause lead poisoning. Wash hands after handling lead products.

12. When working on electrical circuits, disconnect the battery to minimize shock, burn, spark, or other hazard. When disconnecting the battery, confirm that the ignition switch is in the “OFF” position. Disconnect the negative side of the battery first to minimize the potential for sparks at the battery. Battery gases which are exposed to such sparks, could cause an explosion. Likewise when connecting the battery, confirm that the ignition switch is in the “OFF” position and install the positive cable(s), first and the negative connection(s) last.
13. It is a good practice when disassembling hydraulic components to lay the parts out in the order that they were disassembled. Keeping the parts in this order during disassembly, cleaning, and inspection will aid in the assembly process.

Welding

1. When making repairs which require welding, disconnect any electronic equipment (such as rated capacity limiters and engine computers) to prevent damage to them. Use the battery disconnect switch(es), if equipped.
2. Be aware of systems adjacent to areas being welded. Residual heat from the welding process could cause damage to other components. Heat may also vaporize materials which may become toxic or volatile.
3. Remove paint from areas to be welded to prevent toxic fumes.
4. The grounding connection should be within 3 feet (1 m) of the welded parts.
5. Connect the ground to the lower, if welding on the lower, or to the upper if welding on the upper. Electrical current through the turntable bearing could cause an arc which could damage it.

6. Do not position the ground connection where seals or bearing, as in transmissions or valves, will be between it and the welded parts.
7. Remove any flammable materials from the area.
8. Use the appropriate setting on the welder for the size of the welding operation. Do not use more than 200 Volts continuously.

Cleaning And Inspection



WARNING

Solvents and cleaning solutions can be hazardous. Serious personal injury may result from misuse of these products. Read and follow all the manufacturer's recommendations concerning solvents and cleaning solutions.

1. All components should be thoroughly cleaned with an approved cleaning solvent, air dried and carefully inspected for damage, wear and corrosion.
2. All Loctite® or other sealant residue should be removed from threads of hardware and parts that are going to be reused.
3. All “soft parts”, such as seals, gaskets, back up rings, and o-rings, should be replaced.
4. Replacement of bearings and bushings is generally a good preventive maintenance measure. Even though a bearing or bushing seems to be intact and is functioning properly, its life span is limited. Replacing a simple bearing or bushing while the opportunity is at hand could save a complete component failure later.
5. In the event of severe defects, contact factory personnel for directions whether to repair or replace any major component.

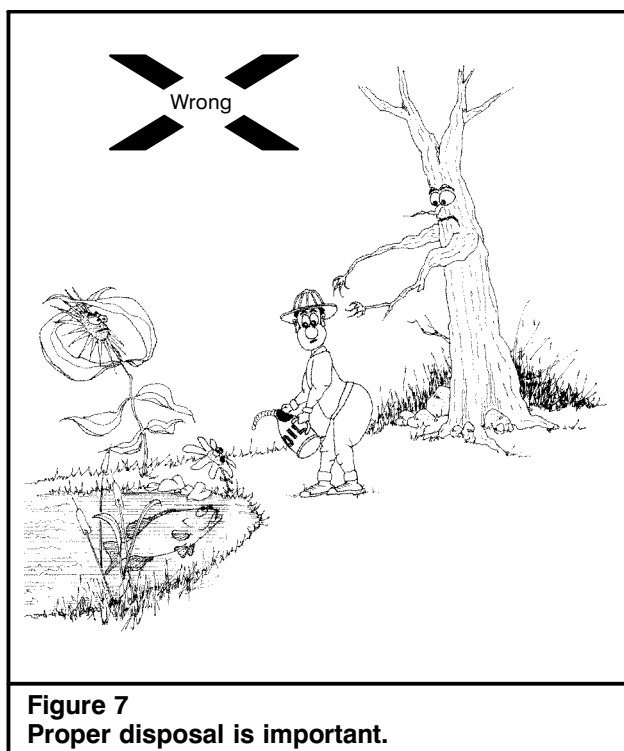
Crane Assembly

1. Loosely assemble parts to ensure all parts are in place and fasteners started before beginning torquing procedure. Always use a cross torquing sequence to ensure even and uniform installation.



WARNING

Lubricants, sealants, joint and thread locking compounds, etc. can be hazardous. Serious personal injury may result from misuse of these products. Read and follow all manufacturer's recommendations concerning these products.



2. Unless otherwise stated, torque all fasteners per the instructions given in SM Code Area 18—000.
3. When installing hydraulic hoses, lines, and fittings, use two wrenches to ensure the hoses and lines are not twisted. One wrench must be on the male fitting, the other wrench on the female fitting.
4. Unless otherwise stated, torque all hydraulic fittings per the instructions given in SM Code Area 07—018.
5. Check all fluid levels before returning the crane to service; hydraulic reservoir oil level, transmission fluid level, engine(s) oil level, etc. Add oil as required. See Operator's Manual and/or engine(s) manufacturer's manual(s) for correct type of fluids and procedures.
6. Always replace guards, grilles, and other types of protective shields. Also, be sure that any systems which were disconnected such as load indicating systems, anti-two block devices, control cables, etc. are functioning properly before returning the crane to service.
7. Start the appropriate engine and let it idle for five minutes. Inspect the connections on the hydraulic, air, transmission, etc. lines for leaks. Repair if needed.
8. Check that all hydraulic, air, and electrical functions are operating normally before returning the crane to service.
9. After crane is assembled, refer to the Operator's Manual for any periodic type of adjustments which may have been affected by the service procedure.
10. Properly dispose of any used oils, solvents, cleaners, etc.

Boom Rest, R & I

This procedure covers the removal and installation of the boom rest. If boom rest extensions are used, see SM Keysheet 01 - 001 for additional information.

Removal

1. Lower, detach, and secure load, as required.
2. Stabilize the crane for service as follows:
 - a. Park the crane out of the way on a firm and level surface.
 - b. Engage the park brake and/or properly block the tires.
 - c. Engage the swing park brake or travel swing lock, as required.
 - d. Level the crane on fully extended outriggers.
 - e. Fully retract and lower the boom over the rear of the carrier.
3. Shutdown the engine and disengage the main hydraulic pump.



WARNING

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4. Thoroughly clean area to be disassembled with an approved cleaning solvent. Allow the area to air dry.

Refer to Figure 1.

5. Remove the locator caps (2) by removing the cap-screws, washers, and locknuts (5).
6. Remove the engine housing (1). See SM Keysheet Area 01 - 071 for the correct procedure.
7. Support the boom rest assembly with an auxiliary lifting device.

Note: The boom rest assembly weighs approximately 350 lb (159kg).

8. Remove the cotter pins (10) and pins (9) which secure the cross tube assembly (8) to the carrier frame (7).

9. Remove the boom rest assembly from the crane.
10. If further disassembly of the boom rest is required, proceed with Steps a and b as needed.
 - a. Remove the nylon pads (3) from the locator caps (2) by removing the screws (4).
 - b. Using an auxiliary lifting device, separate the pivot assembly (6) and cross tube assembly (8) by removing the cotter pins (11) and pin (12).

Note: The pivot assembly weighs approximately 180 lb (82kg) and the cross tube assembly weighs approximately 75 lb (34kg).

11. If boom rest is to be removed for an extended period of time, adequately support the boom.

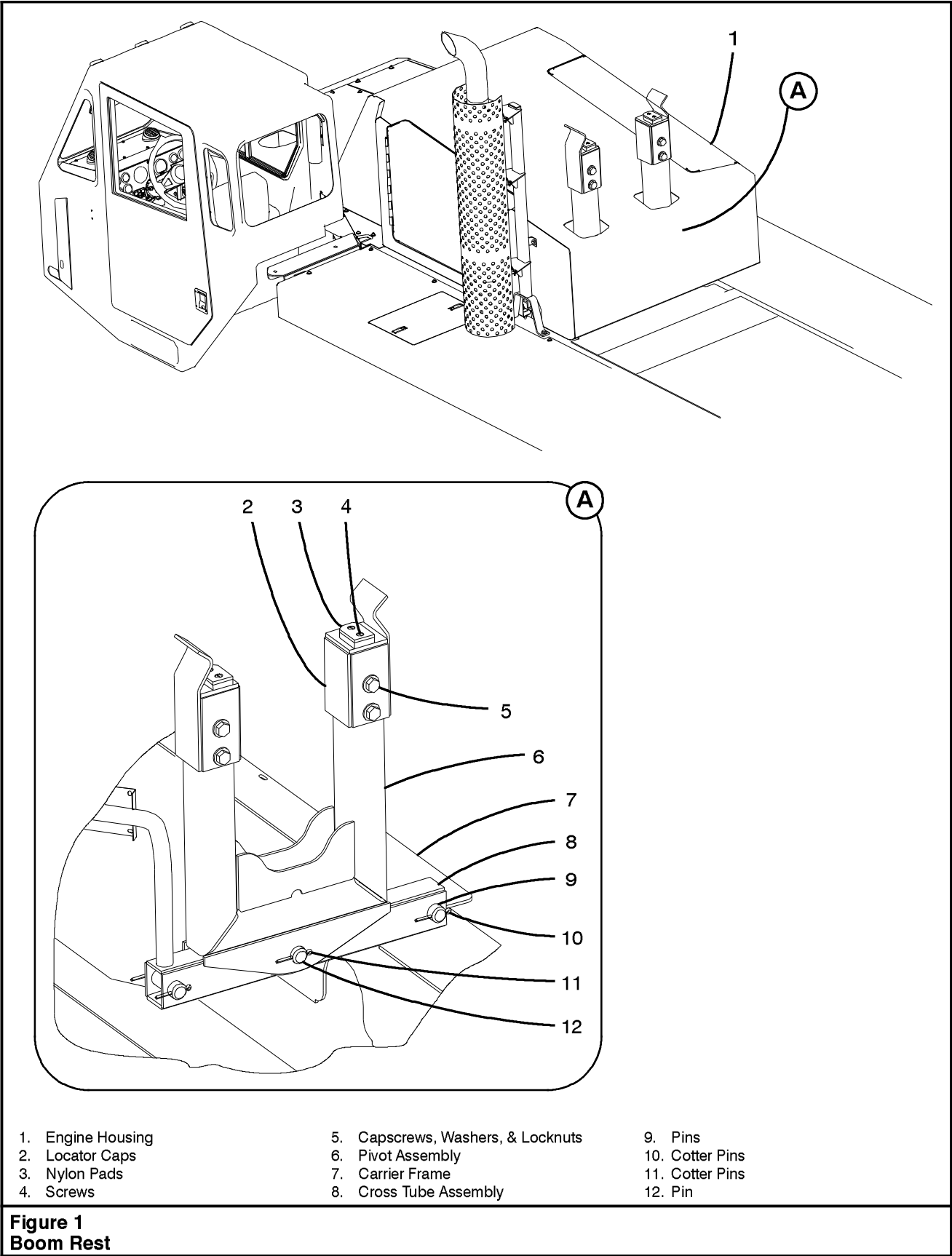
Cleaning And Inspection



WARNING

Solvents and cleaning solutions can be hazardous. Serious personal injury may result from misuse of these products. Read and follow all the manufacturer's recommendations concerning solvents and cleaning solutions.

1. All components should be thoroughly cleaned with an approved cleaning solvent, air dried, and carefully inspected.
2. All Loctite[®], Permatex[®], or other sealant residue should be removed from threads of hardware and the mounting surfaces of parts that are going to be reused. Prior to applying new thread locking compounds or sealants, clean threads and surfaces with Loctite[®] 7070 Cleaner to ensure best performance of products.
3. Thoroughly inspect all related parts for damage, wear, fatigue or stress fractures, and corrosion. Repair or replace as required.
4. In the event of severe defects, contact factory personnel for directions whether to repair or replace any major component.



Installation



WARNING

Lubricants, sealants, joint and thread locking compounds, etc. can be hazardous. Serious personal injury may result from misuse of these products. Read and follow all manufacturer's recommendations concerning these products.

Refer to Figure 1.

1. If assembly of the boom rest is required, proceed with Steps a and b as needed.

- a. Using an auxiliary lifting device, position the pivot assembly (6) to the cross tube assembly (8) and install the pin (12) and cotter pins (11). Bend cotter pins (11) only slightly.

Note: The pivot assembly weighs approximately 180 lb (82kg) and the cross tube assembly weighs approximately 75 lb (34kg).

- b. Position the nylon pads (3) on the locator caps (2) and install the screws (4).

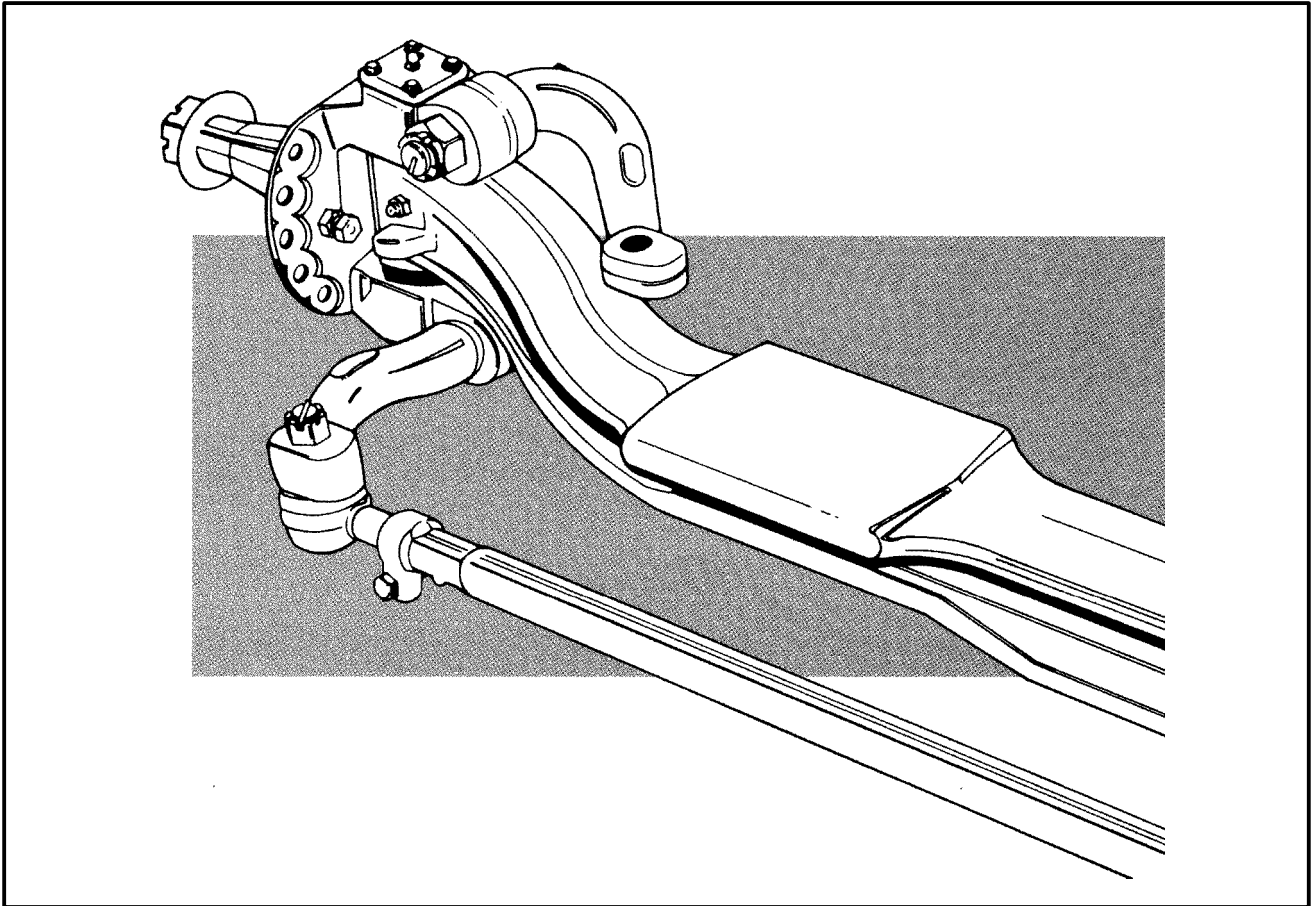
2. Using an auxiliary lifting device, align boom rest assembly to the carrier frame (7).

Note: The boom rest assembly weighs approximately 350 lb (159kg).

3. Install the pins (9) and cotter pins (10) which secure the cross tube assembly (8) to the carrier frame (7). Bend cotter pins (10) only slightly.
4. Install the engine housing (1). See SM Keysheet Area 01- 071 for the correct procedure.
5. Install the locator caps (2) on the pivot assembly (6) and secure with the capscrews, washers, and locknuts (5).
6. Complete the installation by testing the boom rest for proper alignment. The boom should rest evenly on the pads. Adjust as required.

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Service Manual



Front Steer Axle, Recondition

This procedure covers the recondition of the front steer axle. For removal and installation procedures, see SM Keysheet Area 1-4.

The following pages are taken directly from Dana® Spicer® Service Manual AXSM-0037 dated March 1992. Axle models 12F3/F4, 13F3/F5, 18F3, 20F4, 22T2/T5, and 24T2/T5 are covered by this information. Pay particular attention to Section 1 of this procedure to correctly identify the specific axle being serviced. Proper identification of the axle is crucial to obtain the correct information to follow from the charted specifications included in this procedure.

Based on the specific application of this axle, Link-Belt literature will supersede any discrepancies in operation, lubrication, maintenance, or service, implied by the axle manufacturer. Any concerns regarding such inconsistencies should be reviewed with a Link-Belt distributor.

If parts are hard to disassemble and assemble, do not use a hammer unless it has a soft face, do not force parts together, they must be free to turn and not bind.

It is a good practice when disassembling complex components to lay the parts out in the order that they were disassembled. Keeping the parts in this order during disassembly, cleaning, and inspection will aid in the assembly process.



WARNING

Solvents and cleaning solutions can be hazardous. Serious personal injury may result from misuse of these products. Read and follow all the manufacturer's recommendations concerning solvents and cleaning solutions.

Thoroughly clean the exterior surface of the axle before beginning the disassembly process.