Dip Method

NOTE: *This method works best with Face Seal o-rings, but will work for all o-ring fitting types.*

The following is needed to correctly oil the o-ring in this manner:

- A small leak proof container
- Sponge cut to fit inside the container
- A small amount of hydraulic oil to saturate the sponge

1. Place the sponge inside the container and add hydraulic oil to the sponge until it is fully saturated.
2. Dip the fitting into the sponge using firm pressure. Upon lifting the fitting, a small droplet will form and drip from the bottom of the fitting. This should signify an even coating of oil on the fitting.

3. O-ring Boss type fittings will require more pressure in able to immerse more of the fitting into the saturated sponge. This will also cause more oil to be dispersed from the sponge.

Spray Method

This method requires a pump or trigger spray bottle.

1. Fill the spray bottle with hydraulic oil.
2. Hold the fitting over a suitable catch can.
3. Spray the entire o-ring surface with a medium coat of oil.

Brush-on Method

This method requires a sealed bottle brush.

1. Fill the bottle with hydraulic oil.
2. Using slight pressure to the body of the spray bottle, invert the bottle so the brush end is in the downward position.
3. Brush hydraulic oil on the entire o-ring, applying an even coat of oil.

5.2 HYDRAULIC CONNECTION ASSEMBLY AND TORQUE SPECIFICATION

Tapered Thread Types

NPTF = national tapered fuel (Dry Seal) per SAE J476/J512

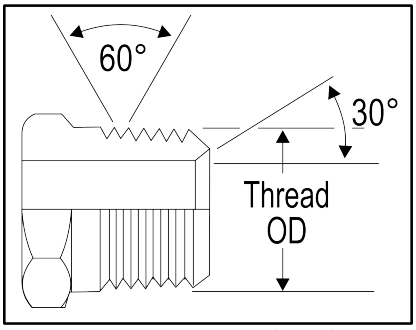


Figure 5-1. NPTF thread

BSPT = British standard pipe tapered per ISO7-1

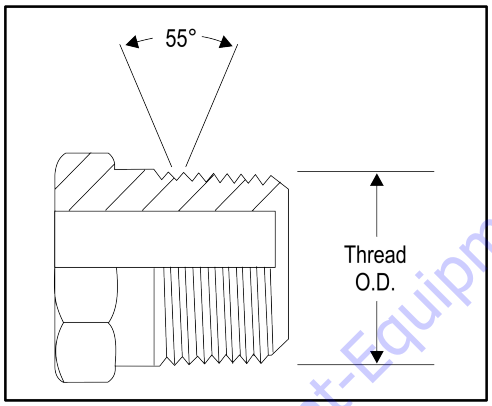


Figure 5-2. BSPT thread

Straight Thread Types, Tube and Hose Connections

JIC = 37° flare per SAE J514

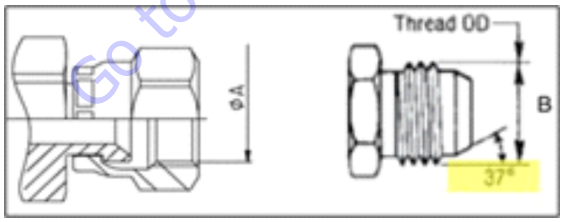


Figure 5-3. JIC Thread

SAE = 45° flare per SAE J512

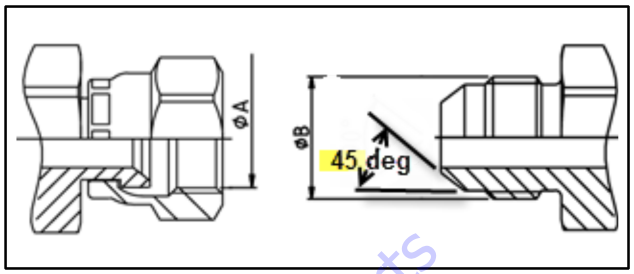


Figure 5-4. SAE Thread

ORFS = o-ring face seal per SAE J1453

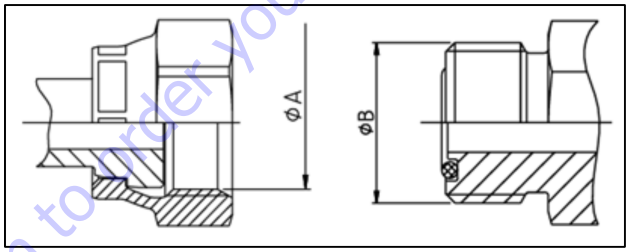


Figure 5-5. ORFS Thread

MBTL = metric flareless

bite type fitting, pressure rating L

(medium) per ISO 8434, DIN 2353

MBTS = metric flareless bite type fitting, pressure rating S

(high) per ISO 8434, DIN 2353

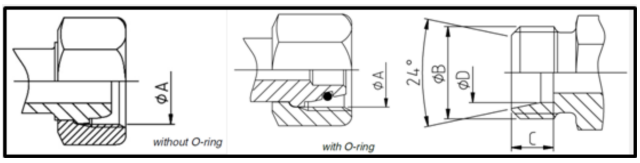


Figure 5-6. MTBL-MBTS Thread

BH = bulkhead connection – JIC, ORFS, MBTL, or MBTS types

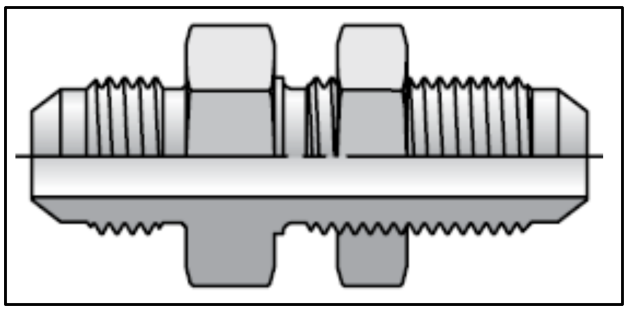
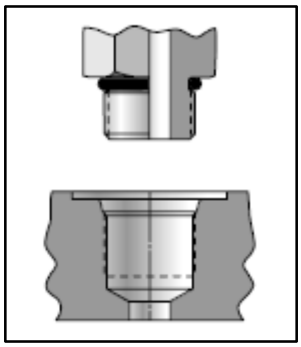


Figure 5-7. Bulkhead Thread

Straight Thread Types, Port Connections

ORB = o-ring boss per SAE J1926, ISO 11926

MPP = metric pipe parallel o-ring boss per SAE J2244, ISO 6149, DIN 3852



MFF = metric flat face port per ISO 9974-1

BSPP = British standard parallel pipe per ISO 1179-1, DIN 3852-2

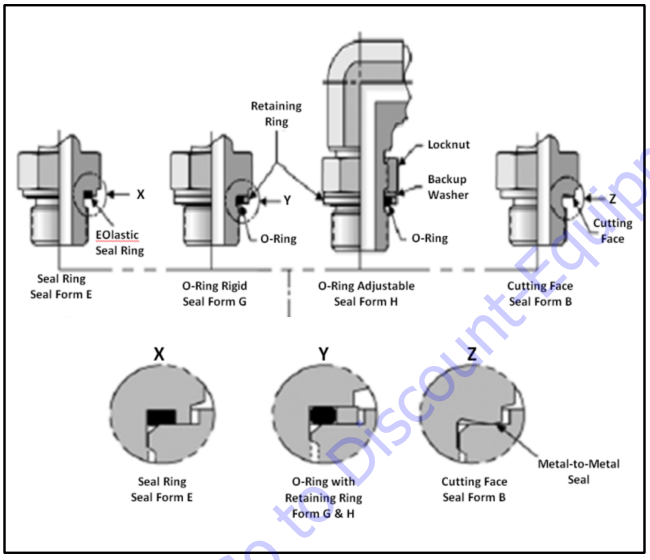


Figure 5-8. MFF-BSPP Thread

Flange Connection Types

FL61 = code 61 flange per SAE J518, ISO 6162

FL62 = code 62 flange per SAE J518, ISO 6162

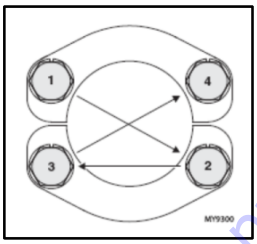


Figure 5-9. ORB-MPP Thread

Tightening Methods

Torque = Application of a twisting force to the applicable connection by use of a precise measurement instrument (i.e. torque wrench).

Finger Tight = The point where the connector will no longer thread onto the mating part when tightened by hand or fingers. Finger Tight is relative to user strength and will have some variance. The average torque applied by this method is 3 ft. lbs. (4 Nm). Also referred to as 'Hand Tight.'

TFFT = Turns From Finger Tight; Application of a preload to a connection by first tightening the connection by hand (fingers) and applying an additional rotation counted by a defined number of turns by use of a tool.

FFWR = Flats From Wrench Resistance; Application of a preload to a connection by tightening to the point of initial wrench resistance and turning the nut a described number of 'flats'. A 'flat' is one side of the hexagonal tube nut and equates to 1/6 of a turn. Also referred to as the 'Flats Method.'

Assembly And Torque Specifications

Prior to selecting the appropriate torque from the tables within this section, it is necessary to properly identify the connector being installed. Refer to the Figures and Tables in this section.

GENERAL TUBE TYPE FITTING ASSEMBLY INSTRUCTIONS

1. Take precautions to ensure that fittings and mating components are not damaged during storage, handling or assembly. Nicks and scratches in sealing surfaces can create a path for leaks which could lead to component contamination and/or failure.
2. When making a connection to tubing, compression or flare, inspect the tube in the area of the fitting attachment to ensure that the tube has not been damaged.
3. The assembly process is one of the leading causes for contamination in air and hydraulic systems. Contamination can prevent proper tightening of fittings and adapters from occurring.
   - **a.** Avoid using dirty or oily rags when handling fittings.
   - **b.** If fittings are disassembled, they should be cleaned and inspected for damage. Replace fittings as necessary before re-installing.
   - **c.** Sealing compounds should be applied where specified; however, care should be taken not to introduce sealant into the system.
   - **d.** Avoid applying sealant to the area of the threads where the sealant will be forced into the system. This is generally the first two threads of a fitting.
   - **e.** Sealant should only be applied to the male threads.
   - **f.** Straight thread fittings do not require sealants. O-rings or washers are provided for sealing.
   - **g.** When replacing or installing an o-ring, care is to be taken while transferring the o-ring over the threads as it may become nicked or torn. When replacing an o-ring on a fitting, the use of a thread protector is recommended.
   - **h.** When installing fittings with o-rings, lubrication shall be used to prevent scuffing or tearing of the o-ring. See o-ring Installation (Replacement) in this section.
4. Take care to identify the material of parts to apply the correct torque values.
   - **a.** Verify the material designation in the table headings.
   - **b.** If specifications are given only for steel fittings and components, the values for alternate materials shall be as follows: Aluminum and Brass- reduce steel values by 35%; Stainless Steel- Use the upper limit for steel.
5. To achieve the specified torque, the torque wrench is to be held perpendicular to the axis of rotation.

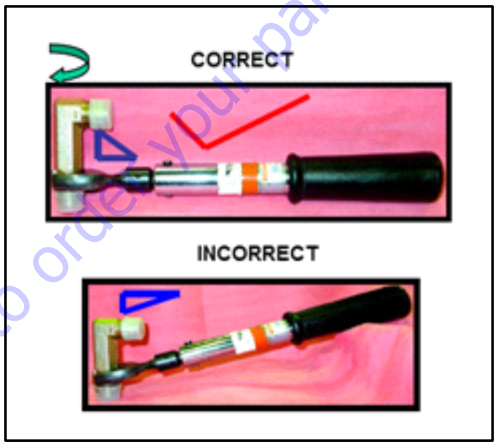


Figure 5-10. Torque Wrench Angle

6. Refer to the appropriate section in this manual for more specific instructions and procedures for each type of fitting connection.

Assembly Instructions for American Standard Pipe Thread Tapered (NPTF) Connections.

1. Inspect components to ensure male and female port threads are free of rust, splits, dirt, foreign matter, or burrs.
2. Apply a suitable thread sealant, such as high temperature high thread sealant with PTFE, to the male pipe threads if not already applied. Ensure the first 1 to 2 threads are uncovered to prevent system contamination.
3. Assemble connection hand tight.
4. Mark fittings, male and female.

⚠ CAUTION

OVER TIGHTENING MAY CAUSE DEFORMATION OF THE PIPE FITTING AND DAMAGE TO THE JOINING FITTING, FLANGE OR COMPONENT MAY OCCUR.

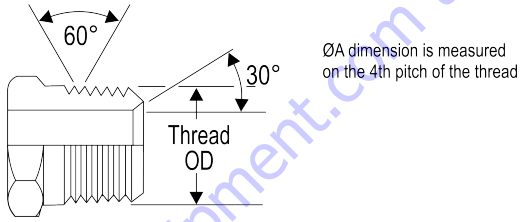
NEVER BACK OFF (LOOSEN) PIPE THREADED CONNECTORS TO ACHIEVE ALIGNMENT. MEET THE MINIMUM REQUIRED TURNS AND USE THE LAST TURN FOR ALIGNMENT.

5. Rotate male fitting the number of turns per Table 5-1, NPTF Pipe Thread. See FFWR and TFFT Methods for TFFT procedure requirements.

NOTE: *TFFT values provided in Table 5-1, NPTF Pipe Thread are applicable for the following material configurations:*

- STEEL fittings with STEEL mating components
- STEEL fittings with ALUMINUM or BRASS mating components
- ALUMINUM or BRASS fittings with STEEL mating components
- ALUMINUM or BRASS fittings with ALUMINUM or BRASS mating components.

Table 5-1. NPTF Pipe Thread



TYPE/FITTING IDENTIFICATION					Turns From Finger Tight (TFFT)**
Material	Dash Size	Thread Size (UNF)	ØA* (in)	ØA* (mm)	
STEEL, ALUMINUM, OR BRASS FITTINGS WITH STEEL, ALUMINUM, OR BRASS MATING COMPONENTS	2	1/8-27	0.40	10.24	2 to 3
	4	1/4-18	0.54	13.61	2 to 3
	6	3/8-18	0.67	17.05	2 to 3
	8	1/2-14	0.84	21.22	2 to 3
	12	3/4-14	1.05	26.56	2 to 3
	16	1-11 1/2	1.31	33.22	1.5 to 2.5
	20	1 1/4-11 1/2	1.65	41.98	1.5 to 2.5
	24	1 1/2-11 1/2	1.89	48.05	1.5 to 2.5
	32	2-11 1/2	2.37	60.09	1.5 to 2.5

*ØA thread dimension for reference only.

**See FFWR and TFFT Methods subsection for TFFT procedure requirements.

Assembly Instructions for British Standard Pipe Thread Tapered (BSPT) Connections

1. Inspect components to ensure male and female port threads are free of rust, splits, dirt, foreign matter, or burrs.
2. Apply a suitable thread sealant, such as high temperature high thread sealant with PTFE, to the male pipe threads if not already applied. Ensure the first 1 to 2 threads are uncovered to prevent system contamination.
3. Assemble connection hand tight.
4. Mark fittings, male and female.

⚠ CAUTION

OVER TIGHTENING MAY CAUSE DEFORMATION OF THE PIPE FITTING AND DAMAGE TO THE JOINING FITTING, FLANGE OR COMPONENT MAY OCCUR.

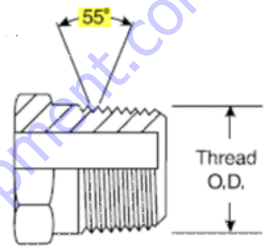
NEVER BACK OFF (LOOSEN) PIPE THREADED CONNECTORS TO ACHIEVE ALIGNMENT. MEET THE MINIMUM REQUIRED TURNS AND USE THE LAST TURN FOR ALIGNMENT.

5. Rotate male fitting the number of turns per Table 5-2, BSPT Pipe Thread. See FFWR and TFFT Methods for TFFT procedure requirements.

NOTE: *TFFT values provided in Table 5-2, BSPT Pipe Thread are applicable for the following material configurations:*

- STEEL fittings with STEEL mating components
- STEEL fittings with ALUMINUM or BRASS mating components
- ALUMINUM or BRASS fittings with STEEL mating components
- ALUMINUM or BRASS fittings with ALUMINUM or BRASS mating components.

Table 5-2. BSPT Pipe Thread



TYPE/FITTING IDENTIFICATION					Turns From Finger Tight (TFFT)**
MATERIAL	Dash Size	Thread Size (BSPT)	ØA* (in)	ØA* (mm)	
STEEL, ALUMINUM, ORBRASS FITTINGS WITH **STEEL, ALUMINUM, ORBRASS** MATING COMPONENTS	2	1/8-28	0.38	9.73	2 to 3
	4	1/4-19	0.52	13.16	2 to 3
	6	3/8-19	0.66	16.66	2 to 3
	8	1/2-14	0.83	20.96	2 to 3
	12	3/4-14	1.04	26.44	2 to 3
	16	1-11	1.31	33.25	1.5 to 2.5
	20	1 1/4-11	1.65	41.91	1.5 to 2.5
	24	1 1/2-11	1.88	47.80	1.5 to 2.5
	32	2-11	2.35	59.61	1.5 to 2.5

* ØA thread dimension for reference only.

** See Appendix B for TFFT procedure requirements.

Assembly Instructions for 37° (JIC) Flare Fittings

1. Inspect the flare for obvious visual squareness and concentricity issues with the tube OD. Ensure surface is smooth, free of rust, weld and brazing splatter, splits, dirt, foreign matter, or burrs. If necessary replace fitting or adapter.

⚠ CAUTION

DO NOT FORCE A MISALIGNED OR SHORT HOSE/TUBE INTO ALIGNMENT. IT PUTS UNDESIRABLE STRAIN ONTO THE JOINT EVENTUALLY LEADING TO LEAKAGE.

2. Align tube to fitting and start threads by hand.

⚠ CAUTION

THE TORQUE METHOD SHOULD NOT BE USED ON LUBRICATED OR OILY FITTINGS. NO LUBRICATION OR SEALANT IS REQUIRED. THE LUBRICATION WOULD CAUSE INCREASED CLAMPING FORCE AND CAUSE FITTING DAMAGE.

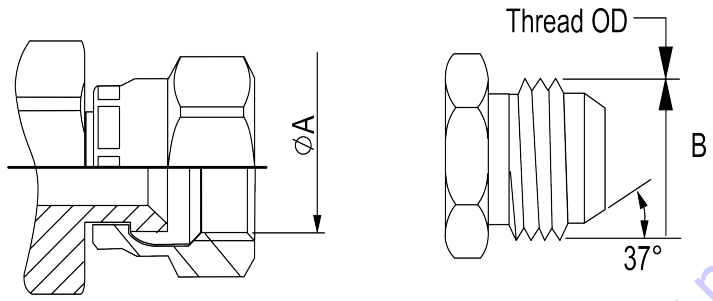
3. Torque assembly to value listed in Table 5-3, 37° Flare (JIC)Thread - Steel or Table 5-4, 37° Flare (JIC)Thread - Aluminum/Brass while using the Double Wrench Method per Double Wrench Method. Refer to FFWR and TFFT Methods for procedure requirements if using the FFWR method.

NOTE: *Torque values provided in Table Table 5-3, 37° Flare (JIC)Thread - Steel and Table 5-4, 37° Flare (JIC)Thread - Aluminum/Brass are segregated based on the material configuration of the connection.*

ALUMINUM/BRASS FITTINGS OR ALUMINUM/BRASS MATING COMPONENTS' indicate either the following material configurations:

- STEEL fittings with ALUMINUM or BRASS mating components
- ALUMINUM or BRASS fittings with STEEL mating components
- ALUMINUM or BRASS fittings with ALUMINUM or BRASS mating components.

Table 5-3. 37° Flare (JIC)Thread - Steel

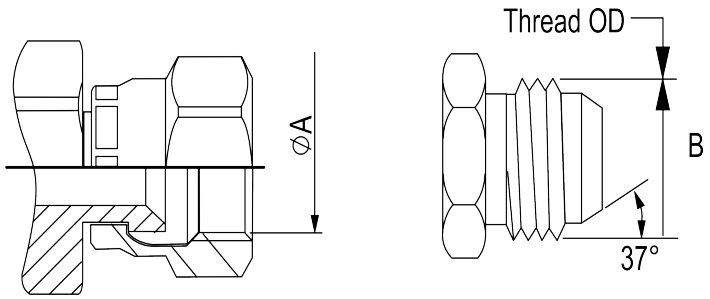


Type/Fitting Identification							Torque						Flats from Wrench Resistance (F.F.W.R)**
MATERIAL	Dash Size	Thread Size	ØA*		ØB*		[Ft-Lb]			[N-m]			
		(UNF)	(in)	(mm)	(in)	(mm)	Min	Nom	Max	Min	Nom	Max	
STEEL FITTINGS WITH STEEL MATING COMPONENTS; UN-LUBRICATED THREADS	2	5/16-24	0.28	7.00	0.31	7.75	6	7	7	8	9	10	--
	3	3/8-24	0.34	8.60	0.37	9.50	8	9	10	11	12	14	--
	4	7/16-20	0.39	10.00	0.44	11.10	13	14	14	18	19	19	1-1/2 to 1-3/4
	5	1/2-20	0.46	11.60	0.50	12.70	14	15	15	19	20	21	1 to 1-1/2
	6	9/16-18	0.51	13.00	0.56	14.30	22	23	24	30	31	33	1 to 1-1/2
	8	3/4-16	0.69	17.60	0.75	19.10	42	44	46	57	60	63	1-1/2 to 1-3/4
	10	7/8-14	0.81	20.50	0.87	22.20	60	63	66	81	85	89	1 to 1-1/2
	12	11/16-12	0.97	24.60	1.06	27.00	84	88	92	114	120	125	1 to 1-1/2
	14	13/16-12	1.11	28.30	1.19	30.10	100	105	110	136	142	149	1 to 1-1/2
	16	15/16-12	1.23	31.30	1.31	33.30	118	124	130	160	168	176	3/4 to 1
	20	15/8-12	1.54	39.20	1.63	41.30	168	176	185	228	239	251	3/4 to 1
	24	17/8-12	1.80	45.60	1.87	47.60	195	205	215	264	278	291	3/4 to 1
	32	21/2-12	2.42	61.50	2.50	63.50	265	278	292	359	377	395	3/4 to 1

* ØA and ØB thread dimensions for reference only.

** See Appendix B for FFWR procedure requirements.

Table 5-4. 37° Flare (JIC)Thread - Aluminum/Brass



TYPE/FITTING IDENTIFICATION							Torque						Flats from Wrench Resistance (F.F.W.R)**
MATERIAL	Dash Size	Thread Size	ØA*		ØB*		[Ft-Lb]			[N-m]			
		(UNF)	(in)	(mm)	(in)	(mm)	Min	Nom	Max	Min	Nom	Max	
ALUMINUM/BRASS FITTINGS OR ALUMINUM/BRASS MATING COMPONENTS; UN-LUBRICATED THREADS	2	5/16-24	0.28	7.00	0.31	7.75	4	4	5	5	6	7	--
	3	3/8-24	0.34	8.60	0.37	9.50	5	6	7	7	8	9	--
	4	7/16-20	0.39	10.00	0.44	11.10	8	9	9	11	12	13	1-1/2 to 1-3/4
	5	1/2-20	0.46	11.60	0.50	12.70	9	10	10	12	13	14	1 to 1-1/2
	6	9/16-18	0.51	13.00	0.56	14.30	14	15	16	19	20	21	1 to 1-1/2
	8	3/4-16	0.69	17.60	0.75	19.10	27	29	30	37	39	41	1-1/2 to 1-3/4
	10	7/8-14	0.81	20.50	0.87	22.20	39	41	43	53	56	58	1 to 1-1/2
	12	1 1/16-12	0.97	24.60	1.06	27.00	55	57	60	74	78	81	1 to 1-1/2
	14	1 3/16-12	1.11	28.30	1.19	30.10	65	68	72	88	93	97	1 to 1-1/2
	16	1 5/16-12	1.23	31.30	1.31	33.30	77	81	84	104	109	114	3/4 to 1
	20	1 5/8-12	1.54	39.20	1.63	41.30	109	115	120	148	155	163	3/4 to 1
	24	1 7/8-12	1.80	45.60	1.87	47.60	127	133	139	172	180	189	3/4 to 1
	32	2 1/2-12	2.42	61.50	2.50	63.50	172	181	189	234	245	257	3/4 to 1

* ØA and ØB thread dimensions for reference only.

** See FFWR and TFFT Methods for FFWR procedure requirements.

Assembly Instructions for 45° SAE Flare Fittings

1. Inspect the flare for obvious visual squareness and concentricity issues with the tube OD. Ensure surface is smooth, free of rust, weld and brazing splatter, splits, dirt, foreign matter, or burrs. If necessary replace fitting or adapter.

⚠ CAUTION

DO NOT FORCE A MISALIGNED OR SHORT HOSE/TUBE INTO ALIGNMENT. IT PUTS UNDESIRABLE STRAIN ONTO THE JOINT EVENTUALLY LEADING TO LEAKAGE.

2. Align tube to fitting.
3. Tighten fitting by hand until hand tight.

⚠ CAUTION

THE TORQUE METHOD SHOULD NOT BE USED ON LUBRICATED OR OILY FITTINGS. NO LUBRICATION OR SEALANT IS REQUIRED. THE LUBRICATION WOULD CAUSE INCREASED CLAMPING FORCE AND CAUSE FITTING DAMAGE.

Torque fitting to value listed in Table 5-5, 45° Flare (SAE) - Steel and Table 5-6, 45° Flare (SAE) - Aluminum/Brass while using the Double Wrench Method outlined in this section. Refer to FFWR and TFFT Methods for procedure requirements if using the TFFT method.

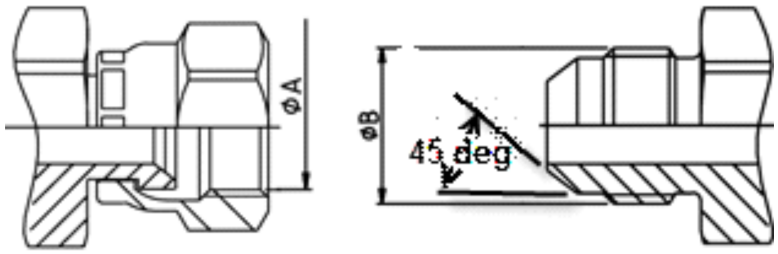
NOTE: *Torque values provided in Table 5-5, 45° Flare (SAE) - Steel and Table 5-6, 45° Flare (SAE) - Aluminum/Brass are segregated based on the material configuration of the connection.*

ALUMINUM/BRASS FITTINGS OR ALUMINUM/BRASS MATING COMPONENTS' indicate either the following material configurations:

- STEEL fittings with ALUMINUM or BRASS mating components
- ALUMINUM or BRASS fittings with STEEL mating components
- ALUMINUM or BRASS fittings with ALUMINUM or BRASS

mating components.

Table 5-5. 45° Flare (SAE) - Steel

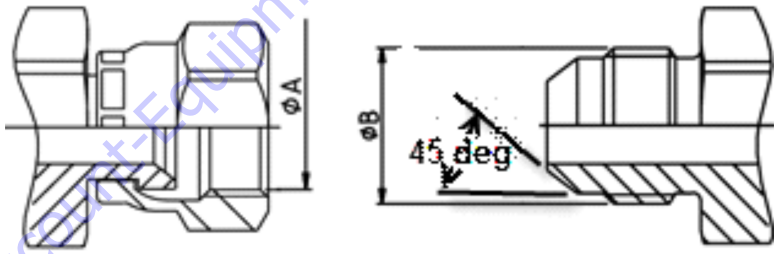


TYPE/FITTING IDENTIFICATION							Torque					
MATERIAL	Dash Size	Thread Size	ØA*		ØB*		[Ft-Lb]			[N-m]		
		(UNF)	(in)	(mm)	(in)	(mm)	Min	Nom	Max	Min	Nom	Max
STEEL FITTINGS WITH STEEL MATING COMPONENTS; UN-LUBRICATED THREADS	4	7/16-20	0.39	9.90	0.44	11.10	13	14	14	18	19	19
	6	5/8-18	0.56	14.30	0.63	15.90	22	23	24	30	31	33
	8	3/4-16	0.69	17.50	0.75	19.10	42	44	46	57	60	62
	10	7/8-14	0.81	20.60	0.87	22.20	60	63	66	81	85	89
	12	11/16-14	0.98	25.00	1.06	27.00	84	88	92	114	119	125

* ØA and ØB thread dimensions for reference only.

** See FFWR and TFFT Methodsfor FFWR procedure requirements.

Table 5-6. 45° Flare (SAE) - Aluminum/Brass



TYPE/FITTING IDENTIFICATION							Torque					
MATERIAL	Dash Size	Thread Size	ØA*		ØB*		[Ft-Lb]			[N-m]		
		(UNF)	(in)	(mm)	(in)	(mm)	Min	Nom	Max	Min	Nom	Max
ALUMINUM/BRASS FITTINGS OR ALUMINUM/BRASS MATING COMPONENTS; UN-LUBRICATED THREADS	4	7/16-20	0.39	9.90	0.44	11.10	8	9	9	11	12	12
	6	5/8-18	0.56	14.30	0.63	15.90	14	15	15	19	20	20
	8	3/4-16	0.69	17.50	0.75	19.10	27	29	30	37	39	41
	10	7/8-14	0.81	20.60	0.87	22.20	39	41	43	53	56	58
	12	11/16-14	0.98	25.00	1.06	27.00	55	58	61	75	79	83

* ØA and ØB thread dimensions for reference only.

** See FFWR and TFFT Methods for TFFT procedure requirements.

Assembly Instructions for O-ring Face Seal (ORFS) Fittings

1. Ensure proper o-ring is installed. If o-ring is missing install per O-ring Installation (Replacement).
2. Ensure surface is smooth, free of rust, weld and brazing splatter, splits, dirt, foreign matter, or burrs. If necessary replace fitting or adapter.

⚠ CAUTION

CARE TO BE TAKEN WHEN LUBRICATING O-RING. AVOID ADDING OIL TO THE THREADED CONNECTION OF THE FITTING. THE LUBRICATION WOULD CAUSE INCREASED CLAMPING FORCE AND CAUSE FITTING DAMAGE.

3. Pre-lubricate the o-ring with Hydraulic Oil.
4. Place the tube assembly against the fitting body so that the flat face comes in contact with the o-ring. Hand thread the nut onto the fitting body.
5. Torque nut to value listed in Table 5-7, O-ring Face Seal (ORFS) - Steel or Table 5-8, O-ring Face Seal (ORFS) - Aluminum/Brass while using the Double Wrench Method. Refer to FFWR and TFFT Methods for procedure requirements if using the FFWR method.

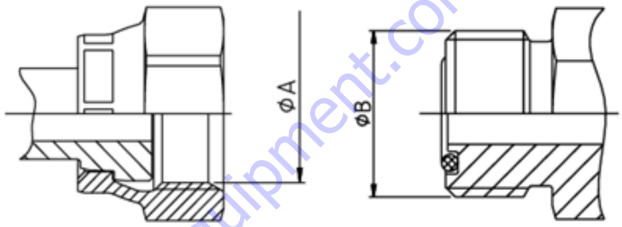
NOTE: *Torque values provided in Table 5-7, O-ring Face Seal (ORFS) - Steel and Table 5-8, O-ring Face Seal (ORFS) - Aluminum/Brass are segregated based on the material configuration of the connection.*

ALUMINUM/BRASS FITTINGS OR ALUMINUM/BRASS MATING COMPONENTS' indicate either the following material configurations:

- STEEL fittings with ALUMINUM or BRASS mating components
- ALUMINUM or BRASS fittings with STEEL mating components
- ALUMINUM or BRASS fittings with ALUMINUM or

BRASS mating components

Table 5-7. O-ring Face Seal (ORFS) - Steel

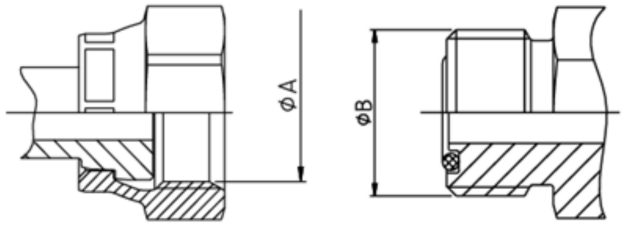


TYPE/FITTING IDENTIFICATION							Torque						Flats from Wrench Resistance (F.F.W.R)**	
MATERIAL	Dash Size	Thread Size	ØA*		ØB*		[Ft-Lb]			[N-m]			Tube Nuts	Swivel & Hose Ends
		(UNF)	(in)	(mm)	(in)	(mm)	Min	Nom	Max	Min	Nom	Max		
STEEL FITTINGS WITH STEEL MATING COMPONENTS; UN-LUBRICATED THREADS	4	9/16-18	0.51	13.00	0.56	14.20	18	19	20	25	26	27	1/4 to 1/2	1/2 to 3/4
	6	11/16-16	0.63	15.90	0.69	17.50	30	32	33	40	43	45	1/4 to 1/2	1/2 to 3/4
	8	13/16-16	0.75	19.10	0.81	20.60	40	42	44	55	57	60	1/4 to 1/2	1/2 to 3/4
	10	1-14	0.94	23.80	1.00	25.40	60	63	66	81	85	89	1/4 to 1/2	1/2 to 3/4
	12	13/16-12	1.11	28.20	1.19	30.10	85	90	94	115	122	127	1/4 to 1/2	1/2 to 3/4
	16	17/16-12	1.34	34.15	1.44	36.50	110	116	121	149	157	164	1/4 to 1/2	1/2 to 3/4
	20	111/16-12	1.59	40.50	1.69	42.90	150	158	165	203	214	224	1/4 to 1/2	1/2 to 3/4
	24	2-12	1.92	48.80	2.00	50.80	230	242	253	312	328	343	1/4 to 1/2	1/2 to 3/4
	32	21/2-12	2.43	61.67	2.50	63.50	375	394	413	508	534	560	1/4 to 1/2	1/2 to 3/4

* ØA and ØB thread dimensions for reference only.

** See FFWR and TFFT Methods for FFWR procedure requirements.

Table 5-8. O-ring Face Seal (ORFS) - Aluminum/Brass



TYPE/FITTING IDENTIFICATION							Torque						Flats from Wrench Resistance (F.F.W.R)**	
MATERIAL	Dash Size	Thread Size	ØA*		ØB*		[Ft-Lb]			[N-m]			Tube Nuts	Swivel & Hose Ends
		(UNF)	(in)	(mm)	(in)	(mm)	Min	Nom	Max	Min	Nom	Max		
ALUMINUM/BRASS FITTINGS OR ALUMINUM/BRASS MATING COMPONENTS; UN-LUBRICATED THREADS	4	9/16-18	0.51	13.00	0.56	14.20	12	13	13	16	18	18	1/4 to 1/2	1/2 to 3/4
	6	11/16-16	0.63	15.90	0.69	17.50	20	21	22	27	28	30	1/4 to 1/2	1/2 to 3/4
	8	13/16-16	0.75	19.10	0.81	20.60	26	28	29	35	38	39	1/4 to 1/2	1/2 to 3/4
	10	1-14	0.94	23.80	1.00	25.40	39	41	43	53	56	58	1/4 to 1/2	1/2 to 3/4
	12	1 3/16-12	1.11	28.20	1.19	30.10	55	58	61	75	79	83	1/4 to 1/2	1/2 to 3/4
	16	1 7/16-12	1.34	34.15	1.44	36.50	72	76	79	98	103	107	1/4 to 1/2	1/2 to 3/4
	20	1 11/16-12	1.59	40.50	1.69	42.90	98	103	108	133	140	146	1/4 to 1/2	1/2 to 3/4
	24	2-12	1.92	48.80	2.00	50.80	12	13	13	16	18	18	1/4 to 1/2	1/2 to 3/4
	32	2 1/2-12	2.43	61.67	2.50	63.50	20	21	22	27	28	30	1/4 to 1/2	1/2 to 3/4

* ØA and ØB thread dimensions for reference only.

** See FFWR and TFFT Methods for FFWR procedure requirements.

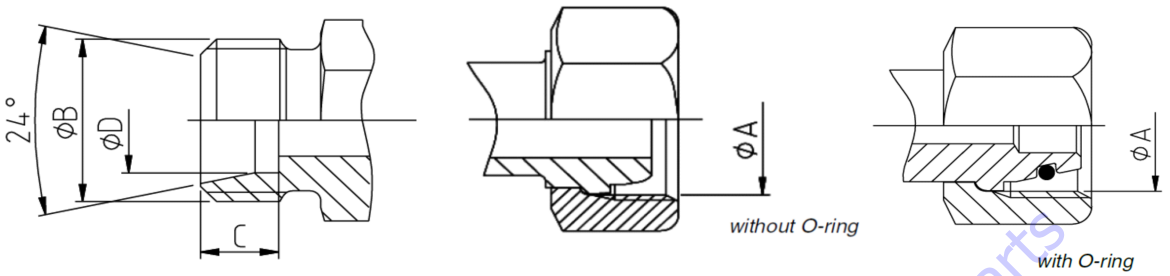
Assembly Instructions for DIN 24° Flare Bite Type Fittings (MBTL and MBTS)

⚠ CAUTION

A NON-SQUARE TUBE END CAN CAUSE IMPROPERLY SEATED FITTINGS AND LEAKAGE.

1. Inspect the components to ensure free of contamination, external damage, rust, splits, dirt, foreign matter, or burrs. Ensure tube end is visibly square. If necessary replace fitting or tube.
2. Lubricate thread and cone of fitting body or hardened pre-assembly tool, as well as the progressive ring and nut threads.
3. Slip nut and progressive ring over tube, assuring that they are in the proper orientation.
4. Push the tube end into the coupling body.
5. Slide collet into position and tighten until finger tight. Mark nut and tube in the finger-tight position. Tighten nut to the number of flats listed in Table 5-9, DIN 24°Cone (MBTL & MBTS) while using the Double Wrench Method. The tube must not turn with the nut.

Table 5-9. DIN 24°Cone (MBTL & MBTS)



TYPE/FITTING IDENTIFICATION								DIN 24° CONE FLARELESS BITE FITTING (With or Without o-ring)						
MATERIAL	TYPE	Tube O.D.	Thread M Size	ØA*	ØB*	C*	ØD*	Torque						Flats from Wrench Resistance (F.F.W.R)**
								[Ft-Lb]			[N-m]			
		(mm)	(Metric)	(mm)	(mm)	(mm)	(mm)	Min	Nom	Max	Min	Nom	Max	
STEEL FITTINGS WITH STEEL MATING COMPONENTS	DIN 24° CONE FLARELESS BITE (MBTL) FITTING	6	M12x1.5	10.50	12.00	7.00	6.20	FFWR is the recommended method of fitting assembly. Torque values are application specific due to variability in the fitting supplier, coating, lubrication, and other physical characteristics of the connection. Refer to the specific procedure in the Service Manual.						1.5 to 1.75
		8	M14x1.5	12.50	14.00	7.00	8.20							1.5 to 1.75
		10	M16x1.5	14.50	16.00	7.00	10.20							1.5 to 1.75
		12	M18x1.5	16.50	18.00	7.00	12.20							1.5 to 1.75
		15	M22x1.5	20.50	22.00	7.00	15.20							1.5 to 1.75
		18	M26x1.5	24.50	26.00	7.50	18.20							1.5 to 1.75
		22	M30x2	27.90	30.00	7.50	22.20							1.5 to 1.75
		28	M36x2	33.90	36.00	7.50	28.20							1.5 to 1.75
		35	M45x2	42.90	45.00	10.50	35.30							1.5 to 1.75
		42	M52x2	49.90	52.00	11.00	42.30							1.5 to 1.75
	TYPE	Tube O.D.	Thread M Size	ØA*	ØB*	C*	ØD*	Torque						Flats from Wrench Resistance (F.F.W.R)**
								[Ft-Lb]			[N-m]			
		(mm)	(Metric)	(mm)	(mm)	(mm)	(mm)	Min	Nom	Max	Min	Nom	Max	
	DIN 24° CONE FLARELESS BITE (MBTS) FITTING	6	M14x1.5	12.50	14.00	7.00	6.20	FFWR is the recommended method of fitting assembly. Torque values are application specific due to variability in the fitting supplier, coating, lubrication, and other physical characteristics of the connection. Refer to the specific procedure in the Service Manual.						1.5 to 1.75
		8	M16x1.5	14.50	16.00	7.00	8.20							1.5 to 1.75
		10	M18x1.5	16.50	18.00	7.50	10.20							1.5 to 1.75
		12	M20x1.5	18.50	20.00	7.50	12.20							1.5 to 1.75
		14	M22x1.5	20.50	22.00	8.00	14.20							1.5 to 1.75
		16	M24x1.5	22.50	24.00	8.50	16.20							1.5 to 1.75
		20	M30x2	27.90	30.00	10.50	20.20							1.5 to 1.75
		25	M36x2	33.90	36.00	12.00	25.20							1.5 to 1.75
		30	M42x2	39.90	42.00	13.50	30.20							1.5 to 1.75
		38	M52x2	49.90	52.00	16.00	38.30							1.5 to 1.75

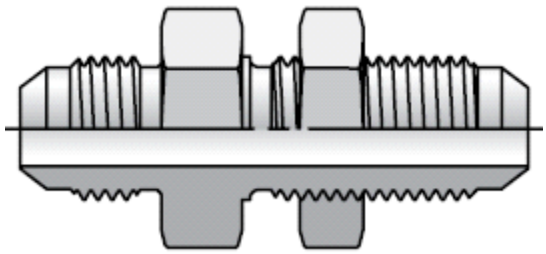
*ØA, ØB, C, & ØD thread dimensions for reference only.

**See Appendix B for FFWR procedure requirements.

Assembly Instructions for Bulkhead (BH) Fittings

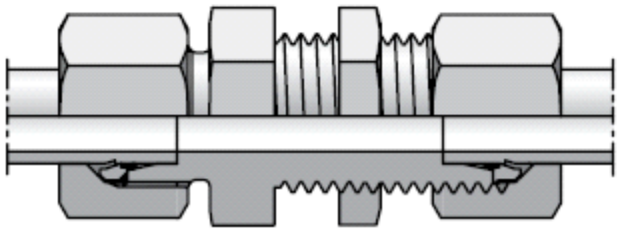
1. Ensure threads and surface are free of rust, weld and brazing splatter, splits, burrs or other foreign material. If necessary replace fitting or adapter.
2. Remove the locknut from the bulkhead assembly.
3. Insert the bulkhead side of the fitting into the panel or bulkhead bracket opening.
4. Hand thread the locknut onto the bulkhead end of the fitting body.
5. Torque nut onto fitting per Table 5-10 and Table 5-11 while using the Double Wrench Method.

Table 5-10. Bulkhead Fittings (BH) - INCH



TYPE/FITTING IDENTIFICATION				FASTENING JAM NUT for Bulkhead Connectors					
MATERIAL	TYPE	Dash Size	Thread Size	Torque					
				[Ft-Lb]			[N-m]		
			(UNF)	Min	Nom	Max	Min	Nom	Max
STEEL FITTINGS	O-RING FACE SEAL (ORFS) BULKHEAD FITTING	4	9/16-18	15	16	17	20	22	23
		6	11/16-16	25	27	28	34	37	38
		8	13/16-16	55	58	61	75	79	83
		10	1-14	85	90	94	115	122	127
		12	1 3/16-12	135	142	149	183	193	202
		14	1 5/16-12	170	179	187	230	243	254
		16	1 7/16-12	200	210	220	271	285	298
		20	1 11/16-12	245	258	270	332	350	366
		24	2-12	270	284	297	366	385	403
	TYPE	Dash Size	Thread Size	Torque					
				[Ft-Lb]			[N-m]		
			(UNF)	Min	Nom	Max	Min	Nom	Max
	37° FLARE (JIC) BULKHEAD FITTING	3	3/8-24	8	9	9	11	12	12
		4	7/16-20	13	14	14	18	19	19
		5	1/2-20	20	21	22	27	28	30
		6	9/16-18	25	27	28	34	37	38
		8	3/4-16	50	53	55	68	72	75
		10	7/8-14	85	90	94	115	122	127
		12	1 1/16-12	135	142	149	183	193	202
		14	1 3/16-12	170	179	187	230	243	254
		16	1 5/16-12	200	210	220	271	285	298
		20	1 5/8-12	245	258	270	332	350	366
		24	1 7/8-12	270	284	297	366	385	403
		32	2 1/2-12	310	326	341	420	442	462

Table 5-11. Bulkhead Fittings (BH) - METRIC



TYPE/FITTING IDENTIFICATION				FASTENING JAM NUT for Bulkhead Connectors					
MATERIAL	TYPE	Connecting Tube O.D.	Thread M Size	Torque					
				[Ft-Lb]			[N-m]		
		(mm)	(metric)	Min	Nom	Max	Min	Nom	Max
STEEL FITTINGS	DIN 24° CONE FLARELESS BITE (MBTL) BULKHEAD FITTING	6	M12x1.5	14	15	16	19	20	22
		8	M14x1.5	17	18	19	23	24	26
		10	M16x1.5	22	23	24	30	31	33
		12	M18x1.5	35	37	39	47	50	53
		15	M22x1.5	44	47	50	60	64	68
		18	M26x1.5	70	75	80	95	102	108
		22	M30x2	115	120	125	156	163	169
		28	M36x2	150	157	164	203	213	222
		35	M45x2	155	162	169	210	220	229
		42	M52x2	220	230	240	298	312	325
	DIN 24° CONE FLARELESS BITE (MBTS) BULKHEAD FITTING	Connecting Tube O.D.	Thread M Size	Torque					
				[Ft-Lb]			[N-m]		
		(mm)	(metric)	Min	Nom	Max	Min	Nom	Max
		6	M14x1.5	17	15	16	23	20	22
		8	M16x1.5	22	18	19	30	24	26
		10	M18x1.5	35	23	24	47	31	33
		12	M20x1.5	40	35	37	54	47	50
		14	M22x1.5	44	47	50	60	64	68
		16	M24x1.5	70	75	80	95	102	108
		20	M30x2	115	120	125	156	163	169
		25	M36x2	150	157	164	203	213	222
		30	M42x2	155	162	169	210	220	229
		38	M52x2	220	230	240	298	312	325

Assembly Instructions for O-ring Boss (ORB) Fittings

1. Inspect components to ensure that male and female port threads are free of rust, splits, dirt, foreign matter, or burrs.
2. Ensure proper o-ring is installed. If o-ring is missing install per O-ring Installation (Replacement).

⚠ CAUTION

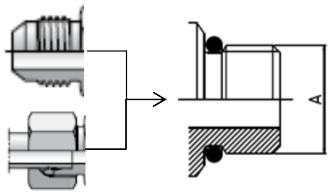
CARE TO BE TAKEN WHEN LUBRICATING O-RING. AVOID ADDING OIL TO THE THREADED CONNECTION OF THE FITTING. THE LUBRICATION WOULD CAUSE INCREASED CLAMPING FORCE AND CAUSE FITTING DAMAGE.

3. Pre-lubricate the o-ring with Hydraulic Oil.
4. For Non-Adjustable and Plugs, thread the fitting by hand until contact.
5. For Adjustable fittings, refer to Adjustable Stud End Assembly for proper assembly.
6. Torque the fitting or nut to value listed in Table 5-12 through Table 5-17 while using the Double Wrench Method.
   a. The table headings identify the straight thread o-ring port and the type on the other side of the fitting. The torque will be applied to the straight thread o-ring port.
   b. Torque values provided in Table 5-12 through Table 5-17 are segregated based on the material configuration of the connection. 'ALUMINUM/BRASS FITTINGS OR ALUMINUM/BRASS MATING COMPONENTS' indicate either the following material configurations:

- STEEL fittings with ALUMINUM or BRASS mating components
- ALUMINUM or BRASS fittings with STEEL mating components
- ALUMINUM or BRASS fittings with ALUMINUM or BRASS mating components.

7. Inspect to ensure the o-ring is not pinched and the washer is seated flat on the counterbore of the port.

Table 5-12. O-ring Boss (ORB) - Table 1 of 6



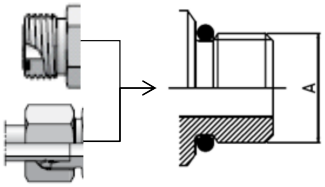
TYPE/FITTING IDENTIFICATION					HEX TYPE PLUGS & STUD ENDS with 37° (JIC) or L series DIN (MBTL) opposite end					
MATERIAL	Dash Size	Thread Size	ØA*		Torque					
		(UNF)	(in)	(mm)	Min	Nom	Max	Min	Nom	Max
STEEL FITTINGS WITH STEEL MATING COMPONENTS; UN-LUBRICATED THREADS	2	5/16-24	0.31	7.93	(85)	(90)	(94)	10	10	11
	3	3/8-24	0.37	9.52	(155)	(163)	(171)	18	18	19
	4	7/16-20	0.44	11.11	22	23	24	29	31	33
	5	1/2-20	0.50	12.70	23	25	26	32	34	35
	6	9/16-18	0.56	14.28	29	31	32	40	42	43
	8	3/4-16	0.75	19.10	52	55	57	70	75	77
	10	7/8-14	0.87	22.22	85	90	94	115	122	127
	12	1 1/16-12	1.06	27.00	135	142	149	185	193	202
	14	1 3/16-12	1.19	30.10	175	184	193	235	249	262
	16	1 5/16-12	1.31	33.30	200	210	220	270	285	298
	20	1 5/8-12	1.63	41.30	250	263	275	340	357	373
	24	1 7/8-12	1.87	47.60	305	321	336	415	435	456
	32	2 1/2-12	2.50	63.50	375	394	413	510	534	560

TYPE/FITTING IDENTIFICATION					HEX TYPE PLUGS & STUD ENDS with 37° (JIC) or L series DIN (MBTL) opposite end					
MATERIAL	Dash Size	Thread Size	ØA*		Torque					
		(UNF)	(in)	(mm)	Min	Nom	Max	Min	Nom	Max
ALUMINUM/BRASS FITTINGS OR ALUMINUM/BRASS MATING COMPONENTS; UN-LUBRICATED THREADS	2	5/16-24	0.31	7.93	(55)	(58)	(61)	6	7	7
	3	3/8-24	0.37	9.52	(101)	(106)	(111)	11	12	13
	4	7/16-20	0.44	11.11	14	15	16	19	20	22
	5	1/2-20	0.50	12.70	15	16	17	20	22	23
	6	9/16-18	0.56	14.28	19	20	21	26	27	28
	8	3/4-16	0.75	19.10	34	36	37	46	49	50
	10	7/8-14	0.87	22.22	55	58	61	75	79	83
	12	1 1/16-12	1.06	27.00	88	93	97	119	126	132
	14	1 3/16-12	1.19	30.10	114	120	126	155	163	171
	16	1 5/16-12	1.31	33.30	130	137	143	176	186	194
	20	1 5/8-12	1.63	41.30	163	171	179	221	232	243
	24	1 7/8-12	1.87	47.60	198	208	218	268	282	296
	32	2 1/2-12	2.50	63.50	244	256	268	331	347	363

* ØA Thread OD dimension for reference only.

**Removal Torque for Zero Leak Gold® Hollow Hex Plugs is significantly higher than install torque, typically 1.5-3.5X install torque.

Table 5-13. O-ring Boss (ORB) - Table 2 of 6

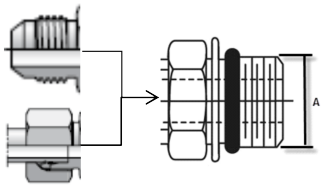


TYPE/FITTING IDENTIFICATION					STUD ENDS with (ORFS) or S series DIN (MBTS) opposite end					
MATERIAL	Dash Size	Thread Size	ØA*		Torque					
		(UNF)	(in)	(mm)	Min	Nom	Max	Min	Nom	Max
STEEL FITTINGS WITH STEEL MATING COMPONENTS; UN-LUBRICATED THREADS	2	5/16-24	0.31	7.93	--	--	--	--	--	--
	3	3/8-24	0.37	9.52	--	--	--	--	--	--
	4	7/16-20	0.44	11.11	26	27	28	35	37	38
	5	1/2-20	0.50	12.70	30	32	33	40	43	45
	6	9/16-18	0.56	14.28	35	37	39	46	50	53
	8	3/4-16	0.75	19.10	60	63	66	80	85	89
	10	7/8-14	0.87	22.22	100	105	110	135	142	149
	12	1 1/16-12	1.06	27.00	135	142	149	185	193	202
	14	1 3/16-12	1.19	30.10	175	184	193	235	249	262
	16	1 5/16-12	1.31	33.30	200	210	220	270	285	298
	20	1 5/8-12	1.63	41.30	250	263	275	340	357	373
	24	1 7/8-12	1.87	47.60	305	321	336	415	435	456
	32	2 1/2-12	2.50	63.50	375	394	413	510	534	560
TYPE/FITTING IDENTIFICATION					STUD ENDS with (ORFS) or S series DIN (MBTS) opposite end					
MATERIAL	Dash Size	Thread Size	ØA*		Torque					
		(UNF)	(in)	(mm)	Min	Nom	Max	Min	Nom	Max
ALUMINUM/BRASS FITTINGS OR ALUMINUM/BRASS MATING COMPONENTS; UN-LUBRICATED THREADS	2	5/16-24	0.31	7.93	--	--	--	--	--	--
	3	3/8-24	0.37	9.52	--	--	--	--	--	--
	4	7/16-20	0.44	11.11	17	18	18	23	24	24
	5	1/2-20	0.50	12.70	20	21	21	27	28	28
	6	9/16-18	0.56	14.28	23	24	24	31	33	33
	8	3/4-16	0.75	19.10	39	41	43	53	56	58
	10	7/8-14	0.87	22.22	65	69	72	88	94	98
	12	1 1/16-12	1.06	27.00	88	93	97	119	126	132
	14	1 3/16-12	1.19	30.10	114	120	126	155	163	171
	16	1 5/16-12	1.31	33.30	130	137	143	176	186	194
	20	1 5/8-12	1.63	41.30	163	171	179	221	232	243
	24	1 7/8-12	1.87	47.60	198	208	218	268	282	296
	32	2 1/2-12	2.50	63.50	244	256	268	331	347	363

* ØA Thread OD dimension for reference only.

**Removal Torque for Zero Leak Gold® Hollow Hex Plugs is significantly higher than install torque, typically 1.5-3.5X install torque.

Table 5-14. O-ring Boss (ORB) - Table 3 of 6

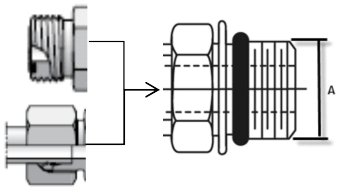


TYPE/FITTING IDENTIFICATION					ADJUSTABLE STUD END with 37° (JIC) or L series DIN (MBTL) opposite end					
MATERIAL	Dash Size	Thread Size	ØA*		Torque					
		(UNF)	(in)	(mm)	Min	Nom	Max	Min	Nom	Max
STEEL FITTINGS WITH STEEL MATING COMPONENTS; UN-LUBRICATED THREADS	2	5/16-24	0.31	7.93	(60)	(63)	(66)	7	7	7
	3	3/8-24	0.37	9.52	(100)	(105)	(110)	11	12	12
	4	7/16-20	0.44	11.11	15	16	17	20	22	23
	5	1/2-20	0.50	12.70	21	22	23	28	30	31
	6	9/16-18	0.56	14.28	29	31	32	40	42	43
	8	3/4-16	0.75	19.10	52	55	57	70	75	77
	10	7/8-14	0.87	22.22	85	90	94	115	122	127
	12	1 1/16-12	1.06	27.00	135	142	149	185	193	202
	14	1 3/16-12	1.19	30.10	175	184	193	235	249	262
	16	1 5/16-12	1.31	33.30	200	210	220	270	285	298
	20	1 5/8-12	1.63	41.30	250	263	275	340	357	373
	24	1 7/8-12	1.87	47.60	305	321	336	415	435	456
	32	2 1/2-12	2.50	63.50	375	394	413	510	534	560
TYPE/FITTING IDENTIFICATION					ADJUSTABLE STUD END with 37° (JIC) or L series DIN (MBTL) opposite end					
MATERIAL	Dash Size	Thread Size	ØA*		Torque					
		(UNF)	(in)	(mm)	Min	Nom	Max	Min	Nom	Max
ALUMINUM/BRASS FITTINGS OR ALUMINUM/BRASS MATING COMPONENTS; UN-LUBRICATED THREADS	2	5/16-24	0.31	7.93	(39)	(41)	(43)	4	5	5
	3	3/8-24	0.37	9.52	(65)	(69)	(72)	7	8	8
	4	7/16-20	0.44	11.11	10	11	11	14	15	15
	5	1/2-20	0.50	12.70	14	15	15	19	20	20
	6	9/16-18	0.56	14.28	19	20	21	26	27	28
	8	3/4-16	0.75	19.10	34	36	37	46	49	50
	10	7/8-14	0.87	22.22	55	58	61	75	79	83
	12	1 1/16-12	1.06	27.00	88	93	97	119	126	132
	14	1 3/16-12	1.19	30.10	114	120	126	155	163	171
	16	1 5/16-12	1.31	33.30	130	137	143	176	186	194
	20	1 5/8-12	1.63	41.30	163	171	179	221	232	243
	24	1 7/8-12	1.87	47.60	198	208	218	268	282	296
	32	2 1/2-12	2.50	63.50	244	256	268	331	347	363

* ØA Thread OD dimension for reference only.

**Removal Torque for Zero Leak Gold® Hollow Hex Plugs is significantly higher than install torque, typically 1.5-3.5X install torque.

Table 5-15. O-ring Boss (ORB) - Table 4 of 6



TYPE/FITTING IDENTIFICATION					ADJUSTABLE STUD END with (ORFS) or S series DIN (MBTS) opposite end					
MATERIAL	Dash Size	Thread Size	ØA*		Torque					
		(UNF)	(in)	(mm)	Min	Nom	Max	Min	Nom	Max
STEEL FITTINGS WITH STEEL MATING COMPONENTS; UN-LUBRICATED THREADS	2	5/16-24	0.31	7.93	--	--	--	--	--	--
	3	3/8-24	0.37	9.52	--	--	--	--	--	--
	4	7/16-20	0.44	11.11	15	16	17	20	22	23
	5	1/2-20	0.50	12.70	30	32	33	40	43	45
	6	9/16-18	0.56	14.28	35	37	39	46	50	53
	8	3/4-16	0.75	19.10	60	63	66	80	85	89
	10	7/8-14	0.87	22.22	100	105	110	135	142	149
	12	1 1/16-12	1.06	27.00	135	142	149	185	193	202
	14	1 3/16-12	1.19	30.10	175	184	193	235	249	262
	16	1 5/16-12	1.31	33.30	200	210	220	270	285	298
	20	1 5/8-12	1.63	41.30	250	263	275	340	357	373
	24	1 7/8-12	1.87	47.60	305	321	336	415	435	456
	32	2 1/2-12	2.50	63.50	375	394	413	510	534	560
TYPE/FITTING IDENTIFICATION					ADJUSTABLE STUD END with (ORFS) or S series DIN (MBTS) opposite end					
MATERIAL	Dash Size	Thread Size	ØA*		Torque					
		(UNF)	(in)	(mm)	Min	Nom	Max	Min	Nom	Max
ALUMINUM/BRASS FITTINGS OR ALUMINUM/BRASS MATING COMPONENTS; UN-LUBRICATED THREADS	2	5/16-24	0.31	7.93	--	--	--	--	--	--
	3	3/8-24	0.37	9.52	--	--	--	--	--	--
	4	7/16-20	0.44	11.11	10	11	11	14	15	15
	5	1/2-20	0.50	12.70	20	21	21	27	28	28
	6	9/16-18	0.56	14.28	23	24	24	31	33	33
	8	3/4-16	0.75	19.10	39	41	43	53	56	58
	10	7/8-14	0.87	22.22	65	69	72	88	94	98
	12	1 1/16-12	1.06	27.00	88	93	97	119	126	132
	14	1 3/16-12	1.19	30.10	114	120	126	155	163	171
	16	1 5/16-12	1.31	33.30	130	137	143	176	186	194
	20	1 5/8-12	1.63	41.30	163	171	179	221	232	243
	24	1 7/8-12	1.87	47.60	198	208	218	268	282	296
	32	2 1/2-12	2.50	63.50	244	256	268	331	347	363

*ØA Thread OD dimension for reference only.

**Removal Torque for Zero Leak Gold® Hollow Hex Plugs is significantly higher than install torque, typically 1.5-3.5X install torque.

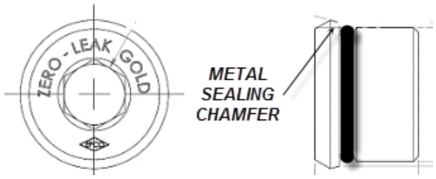
Table 5-16. O-ring Boss (ORB) - Table 5 of 6

TYPE/FITTING IDENTIFICATION					HOLLOW HEX PLUGS					
MATERIAL	Dash Size	Thread Size	ØA*		Torque					
		(UNF)	(in)	(mm)	Min	Nom	Max	Min	Nom	Max
STEEL FITTINGS WITH STEEL MATING COMPONENTS; UN-LUBRICATED THREADS	2	5/16-24	0.31	7.93	(30)	(32)	(33)	3	4	4
	3	3/8-24	0.37	9.52	(55)	(58)	(61)	6	7	7
	4	7/16-20	0.44	11.11	10	11	11	14	15	15
	5	1/2-20	0.50	12.70	14	15	16	19	20	22
	6	9/16-18	0.56	14.28	34	36	38	46	49	52
	8	3/4-16	0.75	19.10	60	63	66	80	85	89
	10	7/8-14	0.87	22.22	100	105	110	135	142	149
	12	1 1/16-12	1.06	27.00	135	142	149	185	193	202
	14	1 3/16-12	1.19	30.10	175	184	193	235	249	262
	16	1 5/16-12	1.31	33.30	200	210	220	270	285	298
	20	1 5/8-12	1.63	41.30	250	263	275	340	357	373
	24	1 7/8-12	1.87	47.60	305	321	336	415	435	456
	32	2 1/2-12	2.50	63.50	375	394	413	510	534	560
TYPE/FITTING IDENTIFICATION					HOLLOW HEX PLUGS					
MATERIAL	Dash Size	Thread Size	ØA*		Torque					
		(UNF)	(in)	(mm)	Min	Nom	Max	Min	Nom	Max
ALUMINUM/BRASS FITTINGS OR ALUMINUM/BRASS MATING COMPONENTS; UN-LUBRICATED THREADS	2	5/16-24	0.31	7.93	(20)	(21)	(21)	2	2	2
	3	3/8-24	0.37	9.52	(36)	(38)	(40)	4	4	5
	4	7/16-20	0.44	11.11	6	7	7	8	9	9
	5	1/2-20	0.50	12.70	9	10	10	12	14	14
	6	9/16-18	0.56	14.28	22	24	25	30	33	34
	8	3/4-16	0.75	19.10	39	41	43	53	56	58
	10	7/8-14	0.87	22.22	65	69	72	88	94	98
	12	1 1/16-12	1.06	27.00	88	93	97	119	126	132
	14	1 3/16-12	1.19	30.10	114	120	126	155	163	171
	16	1 5/16-12	1.31	33.30	130	137	143	176	186	194
	20	1 5/8-12	1.63	41.30	163	171	179	221	232	243
	24	1 7/8-12	1.87	47.60	198	208	218	268	282	296
	32	2 1/2-12	2.50	63.50	244	256	268	331	347	363

* ØA Thread OD dimension for reference only.

**Removal Torque for Zero Leak Gold® Hollow Hex Plugs is significantly higher than install torque, typically 1.5-3.5X install torque.

Table 5-17. O-ring Boss (ORB) - Table 6 of 6



TYPE/FITTING IDENTIFICATION					ZERO LEAK GOLD® HOLLOW HEX PLUGS					
MATERIAL	Dash Size	Thread Size	ØA*		Torque					
		(UNF)	(in)	(mm)	Min	Nom	Max	Min	Nom	Max
STEEL FITTINGS WITH STEEL MATING COMPONENTS; UN-LUBRICATED THREADS	2	5/16-24	0.31	7.93	2	3	4	3	4	5
	3	3/8-24	0.37	9.52	3	4	5	4	5	7
	4	7/16-20	0.44	11.11	7	8	9	9	11	12
	5	1/2-20	0.50	12.70	9	10	11	12	14	15
	6	9/16-18	0.56	14.28	11	12	13	15	16	18
	8	3/4-16	0.75	19.10	28	30	32	38	41	43
	10	7/8-14	0.87	22.22	46	48	50	62	65	68
	12	1 1/16-12	1.06	27.00	51	54	57	69	73	77
	14	1 3/16-12	1.19	30.10	Fitting size greater than -12 not typically specified on JLG applications. Consult specific service procedure if encountered.					
	16	1 5/16-12	1.31	33.30						
	20	1 5/8-12	1.63	41.30						
	24	1 7/8-12	1.87	47.60						
	32	2 1/2-12	2.50	63.50						

TYPE/FITTING IDENTIFICATION					ZERO LEAK GOLD® HOLLOW HEX PLUGS					
MATERIAL	Dash Size	Thread Size	ØA*		Torque					
		(UNF)	(in)	(mm)	Min	Nom	Max	Min	Nom	Max
ALUMINUM/BRASS FITTINGS OR ALUMINUM/BRASS MATING COMPONENTS; UN-LUBRICATED THREADS	2	5/16-24	0.31	7.93	2	3	4	3	4	5
	3	3/8-24	0.37	9.52	3	4	5	4	5	7
	4	7/16-20	0.44	11.11	7	8	9	9	11	12
	5	1/2-20	0.50	12.70	9	10	11	12	14	15
	6	9/16-18	0.56	14.28	11	12	13	15	16	18
	8	3/4-16	0.75	19.10	28	30	32	38	41	43
	10	7/8-14	0.87	22.22	46	48	50	62	65	68
	12	1 1/16-12	1.06	27.00	51	54	57	69	73	77
	14	1 3/16-12	1.19	30.10	Fitting size greater than -12 not typically specified on JLG applications. Consult specific service procedure if encountered.					
	16	1 5/16-12	1.31	33.30						
	20	1 5/8-12	1.63	41.30						
	24	1 7/8-12	1.87	47.60						
	32	2 1/2-12	2.50	63.50						

* ØA Thread OD dimension for reference only.

**Removal Torque for Zero Leak Gold® Hollow Hex Plugs is significantly higher than install torque, typically 1.5-3.5X install torque.

Assembly Instructions for Adjustable Port End Metric (MFF) Fittings

1. Inspect components to ensure that male and female threads and surfaces are free of rust, splits, dirt, foreign matter or burrs.
2. If o-ring is not pre-installed, install proper size, taking care not to damage it. See O-ring Installation (Replacement) for instructions.

⚠ CAUTION

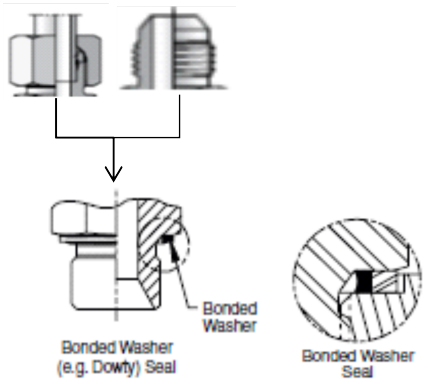
CARE TO BE TAKEN WHEN LUBRICATING O-RING. AVOID ADDING OIL TO THE THREADED CONNECTION OF THE FITTING. THE LUBRICATION WOULD CAUSE INCREASED CLAMPING FORCE AND CAUSE FITTING DAMAGE.

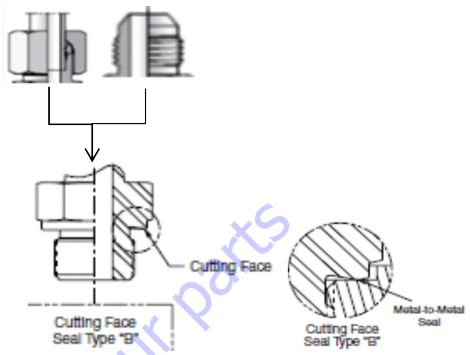
3. Pre-lubricate the o-ring with Hydraulic Oil.
4. For Non-Adjustable Fittings and Plugs, thread the fitting by hand until contact.
5. For Adjustable fittings, refer to Adjustable Stud End Assembly for proper assembly.
6. Torque the fitting or nut to value listed in Table 5-18, Table 5-19, Table 5-20, Table 5-21, Table 5-22, or Table 5-23 while using the Double Wrench Method.
   a. The table headings identify the Metric port and the type on the other side of the fitting. The torque will be applied to the Metric port.
   b. Torque values provided in Table 5-18, Table 5-19, Table 5-20, Table 5-21, Table 5-22, and Table 5-23 are segregated based on the material configuration of the connection. 'ALUMINUM/BRASS FITTINGS OR ALUMINUM/BRASS MATING COMPONENTS' indicate either the following material configurations:

- STEEL fittings with ALUMINUM or BRASS mating components
- ALUMINUM or BRASS fittings with STEEL mating components
- ALUMINUM or BRASS fittings with ALUMINUM or BRASS mating components.

7. Inspect to ensure the o-ring is not pinched and the washer is seated flat on the counterbore of the port.

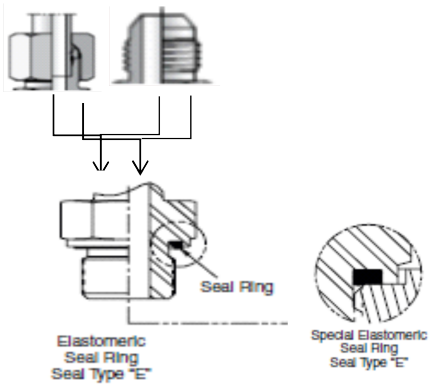
Table 5-18. Metric Flat Face Port (MFF) - L Series - Table 1 of 3

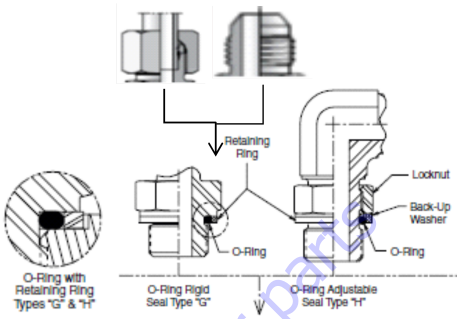




TYPE/FITTING IDENTIFICATION			FORM A (SEALING WASHER) STUD ENDS with 37° (JIC) or L series DIN (MBTL) opposite end						FORM B (CUTTING FACE) STUD ENDS with 37° (JIC) or L series DIN (MBTL) opposite end					
MATERIAL	Thread M Size	Connecting Tube O.D.	Torque						Torque					
			[Ft-Lb]			[N-m]			[Ft-Lb]			[N-m]		
	(metric)	(mm)	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max
STEEL FITTINGS WITH STEEL MATING COMPONENTS; UN-LUBRICATED THREADS	M10x1	6	7	8	8	9	11	11	13	14	14	18	19	19
	M12x1.5	8	15	16	17	20	22	23	22	23	24	30	31	33
	M14x1.5	10	26	28	29	35	38	39	33	35	36	45	47	49
	M16x1.5	12	33	35	36	45	47	49	48	51	53	65	69	72
	M18x1.5	15	41	43	45	55	58	61	59	62	65	80	84	88
	M22x1.5	18	48	51	53	65	69	72	103	108	113	140	146	153
	M27x2	22	66	70	73	90	95	99	140	147	154	190	199	209
	M33x2	28	111	117	122	150	159	165	251	264	276	340	358	374
	M42x2	35	177	186	195	240	252	264	369	388	406	500	526	550
	M48x2	42	214	225	235	290	305	319	465	489	512	630	663	694
MATERIAL	Thread M Size	Connecting Tube O.D.	Torque						Torque					
			[Ft-Lb]			[N-m]			[Ft-Lb]			[N-m]		
	(metric)	(mm)	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max
ALUMINUM/BRASS FITTINGS OR ALUMINUM/BRASS MATING COMPONENTS; UN-LUBRICATED THREADS	M10x1	6	4	5	5	5	7	7	8	9	9	11	12	12
	M12x1.5	8	10	11	11	14	15	15	14	15	16	19	20	22
	M14x1.5	10	17	18	19	23	24	26	21	22	23	28	30	31
	M16x1.5	12	21	22	23	28	30	31	31	33	34	42	45	46
	M18x1.5	15	27	28	29	37	38	39	38	40	42	52	54	57
	M22x1.5	18	31	33	34	42	45	46	67	70	73	91	95	99
	M27x2	22	43	45	47	58	61	64	91	96	100	123	130	136
	M33x2	28	72	76	79	98	103	107	163	171	179	221	232	243
	M42x2	35	115	121	127	156	164	172	240	252	264	325	342	358
	M48x2	42	139	146	153	188	198	207	302	318	332	409	431	450

Table 5-19. Metric Flat Face Port (MFF) - L Series - Table 2 of 3





TYPE/FITTING IDENTIFICATION			FORM A (SEALING WASHER) STUD ENDS with 37° (JIC) or L series DIN (MBTL) opposite end						FORM B (CUTTING FACE) STUD ENDS with 37° (JIC) or L series DIN (MBTL) opposite end					
MATERIAL	Thread M Size	Connecting Tube O.D.	Torque [Ft-Lb]			Torque [N-m]			Torque [Ft-Lb]			Torque [N-m]		
	(metric)	(mm)	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max
STEEL FITTINGS WITH STEEL MATING COMPONENTS; UN-LUBRICATED THREADS	M10x1	6	13	14	14	18	19	19	13	14	15	18	19	20
	M12x1.5	8	18	19	20	25	26	27	18	19	20	25	26	28
	M14x1.5	10	33	35	36	45	47	49	30	31	32	40	42	44
	M16x1.5	12	41	43	45	55	58	61	41	43	45	55	58	61
	M18x1.5	15	52	55	57	70	75	77	52	54	57	70	74	77
	M22x1.5	18	92	97	101	125	132	137	66	70	73	90	95	99
	M27x2	22	133	140	146	180	190	198	133	139	146	180	189	198
	M33x2	28	229	241	252	310	327	342	229	240	252	310	326	341
	M42x2	35	332	349	365	450	473	495	332	348	365	450	473	495
	M48x2	42	398	418	438	540	567	594	398	418	438	540	567	594
MATERIAL	Thread M Size	Connecting Tube O.D.	Torque [Ft-Lb]			Torque [N-m]			Torque [Ft-Lb]			Torque [N-m]		
	(metric)	(mm)	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max
ALUMINUM/BRASS FITTINGS OR ALUMINUM/BRASS MATING COMPONENTS; UN-LUBRICATED THREADS	M10x1	6	8	9	9	11	12	12	8	9	9	11	12	12
	M12x1.5	8	12	13	13	16	18	18	12	13	13	16	18	18
	M14x1.5	10	21	22	23	28	30	31	19	20	21	26	27	29
	M16x1.5	12	27	28	29	37	38	39	26	28	29	36	38	39
	M18x1.5	15	34	36	37	46	49	50	34	35	37	46	48	50
	M22x1.5	18	60	63	66	81	85	89	43	45	47	59	61	64
	M27x2	22	86	91	95	117	123	129	86	91	95	117	123	129
	M33x2	28	149	157	164	202	213	222	149	157	164	202	213	222
	M42x2	35	216	227	237	293	308	321	216	227	237	293	308	321
	M48x2	42	259	272	285	351	369	386	259	272	285	351	369	386

Table 5-20. Metric Flat Face Port (MFF) - L Series - Table 3 of 3

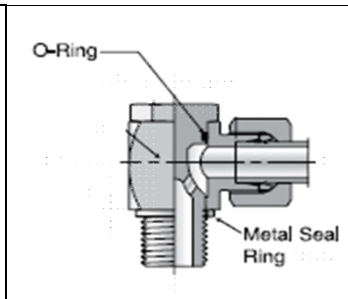
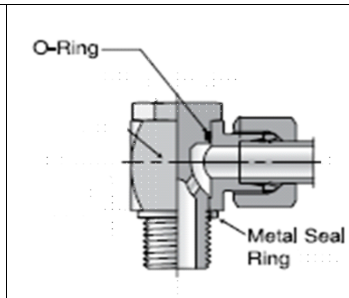
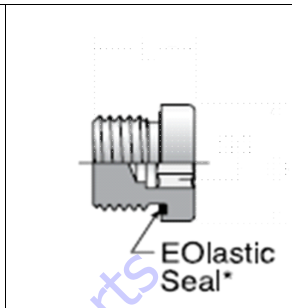
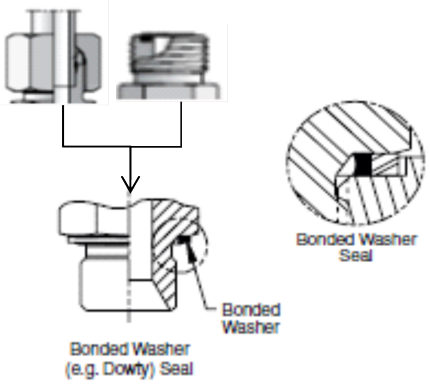
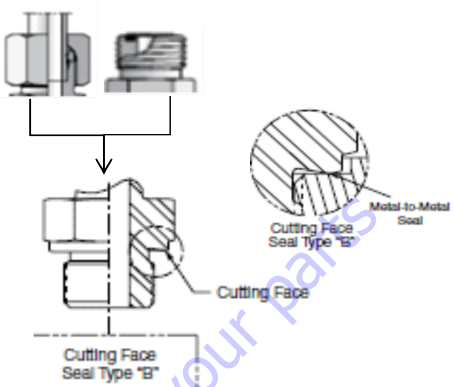
																				
TYPE/FITTING IDENTIFICATION			BANJO FITTINGS with L series DIN (MBTL) opposite end						HIGH PRESSURE BANJO FITTINGS with L series DIN (MBTL) opposite end						FORM E (EOLASTIC SEALING RING) HOLLOW HEX PLUGS								
MATERIAL	Thread M Size	Connecting Tube O.D.	Torque						Torque						Torque								
			[Ft-Lb]			[N-m]			[Ft-Lb]			[N-m]			[Ft-Lb]			[N-m]				
	(metric)	(mm)	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max		
STEEL FITTINGS WITH STEEL MATING COMPONENTS; UN-LUBRICATED THREADS	M10x1	6	13	14	14	18	19	19	13	14	14	18	19	19	9	10	10	12	14	14		
	M12x1.5	8	26	28	29	35	38	39	33	35	36	45	47	49	18	19	20	25	26	27		
	M14x1.5	10	37	39	41	50	53	56	41	43	45	55	58	61	26	28	29	35	38	39		
	M16x1.5	12	44	46	48	60	62	65	59	62	65	80	84	88	41	43	45	55	58	61		
	M18x1.5	15	59	62	65	80	84	88	74	78	81	100	106	110	48	51	53	65	69	72		
	M22x1.5	18	89	94	98	120	127	133	103	108	113	140	146	153	66	70	73	90	95	99		
	M27x2	22	96	101	106	130	137	144	236	248	260	320	336	353	100	105	110	135	142	149		
	M33x2	28	--	--	--	--	--	--	266	280	293	360	380	397	166	175	183	225	237	248		
	M42x2	35	--	--	--	--	--	--	398	418	438	540	567	594	266	280	293	360	380	397		
	M48x2	42	--	--	--	--	--	--	516	542	568	700	735	770	266	280	293	360	380	397		
MATERIAL	Thread M Size	Connecting Tube O.D.	Torque						Torque						Torque								
			[Ft-Lb]			[N-m]			[Ft-Lb]			[N-m]			[Ft-Lb]			[N-m]				
	(metric)	(mm)	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max		
ALUMINUM/BRASS FITTINGS OR ALUMINUM/BRASS MATING COMPONENTS; UN-LUBRICATED THREADS	M10x1	6	8	9	9	11	12	12	8	9	9	11	12	12	6	7	7	8	9	9		
	M12x1.5	8	17	18	19	23	24	26	21	22	23	28	30	31	12	13	13	16	18	18		
	M14x1.5	10	24	26	27	33	35	37	27	28	29	37	38	39	17	18	19	23	24	26		
	M16x1.5	12	29	30	31	39	41	42	38	40	42	52	54	57	27	28	29	37	38	39		
	M18x1.5	15	38	40	42	52	54	57	48	51	53	65	69	72	31	33	34	42	45	46		
	M22x1.5	18	58	61	64	79	83	87	67	70	73	91	95	99	43	45	47	58	61	64		
	M27x2	22	62	66	69	84	89	94	153	161	169	207	218	229	65	69	72	88	94	98		
	M33x2	28	--	--	--	--	--	--	173	182	190	235	247	258	108	114	119	146	155	161		
	M42x2	35	--	--	--	--	--	--	259	272	285	351	369	386	173	182	190	235	247	258		
	M48x2	42	--	--	--	--	--	--	335	352	369	454	477	500	173	182	190	235	247	258		

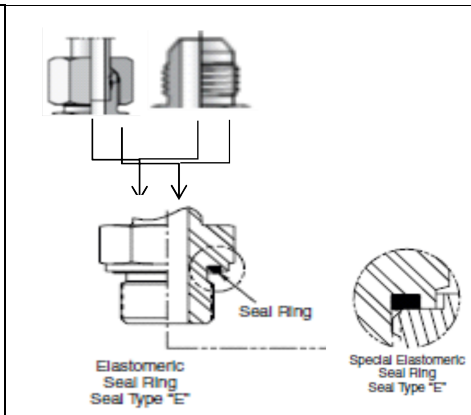
Table 5-21. Metric Flat Face Port (MFF) - S Series - Table 1 of 3

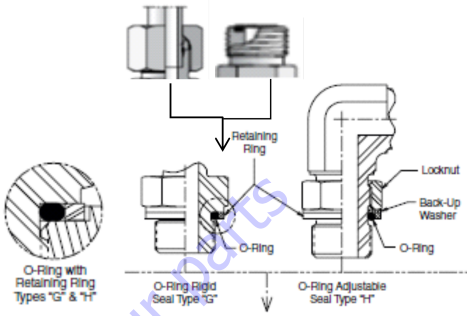




TYPE/FITTING IDENTIFICATION			FORM A (SEALING WASHER) STUD ENDS with (ORFS) or S series DIN (MBTS) opposite end						FORM B (CUTTING FACE) STUD ENDS with (ORFS) or S series DIN (MBTS) opposite end					
MATERIAL	Thread M Size	Connecting Tube O.D.	Torque						Torque					
			[Ft-Lb]			[N-m]			[Ft-Lb]			[N-m]		
	(metric)	(mm)	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max
STEEL FITTINGS WITH STEEL MATING COMPONENTS; UN-LUBRICATED THREADS	M12x1.5	6	15	16	17	20	22	23	26	28	29	35	38	39
	M14x1.5	8	26	28	29	35	38	39	41	43	45	55	58	61
	M16x1.5	10	33	35	36	45	47	49	52	55	57	70	75	77
	M18x1.5	12	41	43	45	55	58	61	81	85	89	110	115	121
	M20x1.5	14	41	43	45	55	58	61	111	117	122	150	159	165
	M22x1.5	16	48	51	53	65	69	72	125	132	138	170	179	187
	M27x2	20	66	70	73	89	95	99	199	209	219	270	283	297
	M33x2	25	111	117	122	150	159	165	302	317	332	410	430	450
	M42x2	30	177	186	195	240	252	264	398	418	438	540	567	594
	M48x2	38	214	225	235	290	305	319	516	542	568	700	735	770
MATERIAL	Thread M Size	Connecting Tube O.D.	Torque						Torque					
			[Ft-Lb]			[N-m]			[Ft-Lb]			[N-m]		
	(metric)	(mm)	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max
ALUMINUM/BRASS FITTINGS OR ALUMINUM/BRASS MATING COMPONENTS; UN-LUBRICATED THREADS	M12x1.5	6	10	11	11	14	15	15	17	18	19	23	24	26
	M14x1.5	8	17	18	19	23	24	26	27	28	29	37	38	39
	M16x1.5	10	21	22	23	28	30	31	34	36	37	46	49	50
	M18x1.5	12	27	28	29	37	38	39	53	56	58	72	76	79
	M20x1.5	14	27	28	29	37	38	39	72	76	79	98	103	107
	M22x1.5	16	31	33	34	42	45	46	81	86	90	110	117	122
	M27x2	20	43	45	47	58	61	64	129	136	142	175	184	193
	M33x2	25	72	76	79	98	103	107	196	206	216	266	279	293
	M42x2	30	115	121	127	156	164	172	259	272	285	351	369	386
	M48x2	38	139	146	153	188	198	207	335	352	369	454	477	500

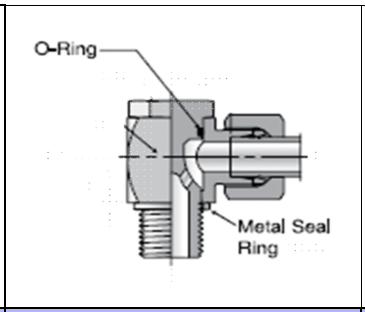
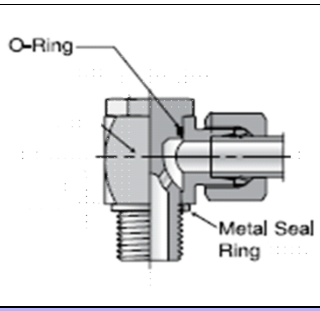
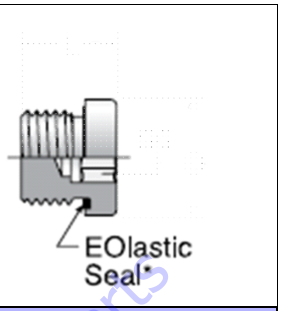
Table 5-22. Metric Flat Face Port (MFF) - S Series - Table 2 of 3





TYPE/FITTING IDENTIFICATION			FORM E (EOLASTIC SEALING RING) STUD ENDS AND HEX TYPE PLUGS with (ORFS) or S series DIN (MBTS) opposite end						FORM G/H (O-RING W/ RETAINING RING) STUD ENDS & ADJUSTABLE STUD ENDS with (ORFS) or S series DIN (MBTS) opposite end					
MATERIAL	Thread M Size	Connecting Tube O.D.	Torque						Torque					
			[Ft-Lb]			[N-m]			[Ft-Lb]			[N-m]		
	(metric)	(mm)	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max
STEEL FITTINGS WITH STEEL MATING COMPONENTS; UN-LUBRICATED THREADS	M10x1	6	26	28	29	35	38	39	26	28	29	35	38	39
	M12x1.5	8	33	35	36	45	47	49	41	43	45	55	58	61
	M14x1.5	10	52	55	57	70	75	77	52	55	57	70	75	77
	M16x1.5	12	66	70	73	90	95	99	66	70	73	90	95	99
	M18x1.5	15	92	97	101	125	132	137	92	97	101	125	132	137
	M22x1.5	18	100	105	110	135	142	149	100	105	110	135	142	149
	M27x2	22	133	140	146	180	190	198	133	140	146	180	190	198
	M33x2	28	229	241	252	310	327	342	229	241	252	310	327	342
	M42x2	35	332	349	365	450	473	495	332	349	365	450	473	495
	M48x2	42	398	418	438	540	567	594	398	418	438	540	567	594
MATERIAL	Thread M Size	Connecting Tube O.D.	Torque						Torque					
			[Ft-Lb]			[N-m]			[Ft-Lb]			[N-m]		
	(metric)	(mm)	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max
ALUMINUM/BRASS FITTINGS OR ALUMINUM/BRASS MATING COMPONENTS; UN-LUBRICATED THREADS	M10x1	6	17	18	19	23	24	26	17	18	19	23	24	26
	M12x1.5	8	21	23	23	29	31	32	27	28	29	37	38	39
	M14x1.5	10	34	36	37	46	49	50	34	36	37	46	49	50
	M16x1.5	12	43	45	47	58	61	64	43	45	47	58	61	64
	M18x1.5	15	60	63	66	81	85	89	60	63	66	81	85	89
	M22x1.5	18	65	69	72	88	94	98	65	69	72	88	94	98
	M27x2	22	86	91	95	117	123	129	86	91	95	117	123	129
	M33x2	28	149	157	164	202	213	222	149	157	164	202	213	222
	M42x2	35	216	227	237	293	308	321	216	227	237	293	308	321
	M48x2	42	259	272	285	351	369	386	259	272	285	351	369	386

Table 5-23. Metric Flat Face Port (MFF) - L Series - Table 3 of 3

																				
TYPE/FITTING IDENTIFICATION			BANJO FITTINGS with S series DIN (MBTS) opposite end						HIGH PRESSURE BANJO FITTINGS with S series DIN (MBTS) opposite end						FORM E (EOLASTIC SEALING RING) HOLLOW HEX PLUGS					
MATERIAL	Thread M Size	Connecting Tube O.D.	Torque						Torque						Torque					
			[Ft-Lb]			[N-m]			[Ft-Lb]			[N-m]			[Ft-Lb]			[N-m]		
	(metric)	(mm)	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max
STEEL FITTINGS WITH STEEL MATING COMPONENTS; UN-LUBRICATED THREADS	M10x1	6	26	28	29	35	38	39	33	35	36	45	47	49	--	--	--	--	--	--
	M12x1.5	8	37	39	41	50	53	56	41	43	45	55	58	61	--	--	--	--	--	--
	M14x1.5	10	44	46	48	60	62	65	59	62	65	80	84	88	--	--	--	--	--	--
	M16x1.5	12	59	62	65	80	84	88	74	78	81	100	106	110	--	--	--	--	--	--
	M18x1.5	15	81	85	89	110	115	121	92	97	101	125	132	137	59	62	65	80	84	88
	M22x1.5	18	89	94	98	120	127	133	100	105	110	135	142	149	--	--	--	--	--	--
	M27x2	22	100	105	110	135	142	149	236	248	260	320	336	353	--	--	--	--	--	--
	M33x2	28	--	--	--	--	--	--	266	280	293	360	380	397	--	--	--	--	--	--
	M42x2	35	--	--	--	--	--	--	398	418	438	540	567	594	--	--	--	--	--	--
	M48x2	42	--	--	--	--	--	--	516	542	568	700	735	770	--	--	--	--	--	--
MATERIAL	Thread M Size	Connecting Tube O.D.	Torque						Torque						Torque					
			[Ft-Lb]			[N-m]			[Ft-Lb]			[N-m]			[Ft-Lb]			[N-m]		
	(metric)	(mm)	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max
ALUMINUM/BRASS FITTINGS OR ALUMINUM/BRASS MATING COMPONENTS; UN-LUBRICATED THREADS	M10x1	6	17	18	19	23	24	26	21	22	23	28	30	31	--	--	--	--	--	--
	M12x1.5	8	24	26	27	33	35	37	27	28	29	37	38	39	--	--	--	--	--	--
	M14x1.5	10	29	30	31	39	41	42	38	40	42	52	54	57	--	--	--	--	--	--
	M16x1.5	12	38	40	42	52	54	57	48	51	53	65	69	72	--	--	--	--	--	--
	M18x1.5	15	53	56	58	72	76	79	60	63	66	81	85	89	38	40	42	52	54	57
	M22x1.5	18	58	61	64	79	83	87	65	69	72	88	94	98	--	--	--	--	--	--
	M27x2	22	65	69	72	88	94	98	153	161	169	207	218	229	--	--	--	--	--	--
	M33x2	28	--	--	--	--	--	--	173	182	190	235	247	258	--	--	--	--	--	--
	M42x2	35	--	--	--	--	--	--	259	272	285	351	369	386	--	--	--	--	--	--
	M48x2	42	--	--	--	--	--	--	335	352	369	454	477	500	--	--	--	--	--	--

Assembly Instructions for Metric ISO 6149 (MPP) Port Assembly Stud Ends

1. Inspect components to ensure that male and female threads and surfaces are free of rust, splits, dirt, foreign matter or burrs.
2. If o-ring is not pre-installed, install proper size, taking care not to damage it. See O-ring Installation (Replacement) for instructions.

⚠ CAUTION

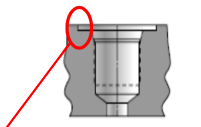
CARE TO BE TAKEN WHEN LUBRICATING O-RING. AVOID ADDING OIL TO THE THREADED CONNECTION OF THE FITTING. THE LUBRICATION WOULD CAUSE INCREASED CLAMPING FORCE AND CAUSE FITTING DAMAGE.

3. Pre-lubricate the o-ring with Hydraulic Oil.
4. For Non-Adjustable Fittings and Plugs, thread the fitting by hand until contact.
5. For Adjustable fittings, refer to Adjustable Stud End Assembly for proper assembly.
6. Torque the fitting or nut to value listed in Table 5-24 while using the Double Wrench Method.
   a. The table headings identify the Metric port and the type on the other side of the fitting. The torque will be applied to the Metric port.
   b. Torque values provided in Table 5-24 are segregated based on the material configuration of the connection. 'ALUMINUM/BRASS FITTINGS OR ALUMINUM/BRASS MATING COMPONENTS' indicate either the following material configurations:

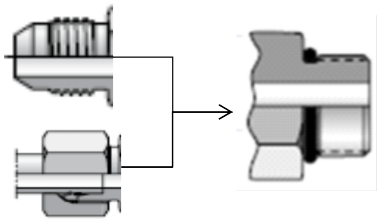
- STEEL fittings with ALUMINUM or BRASS mating components
- ALUMINUM or BRASS fittings with STEEL mating components
- ALUMINUM or BRASS fittings with ALUMINUM or BRASS mating components.

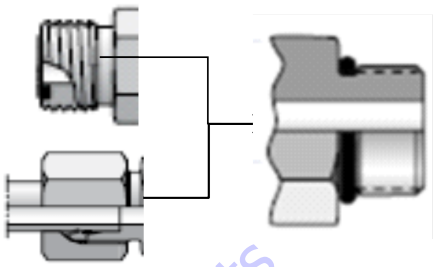
7. Inspect to ensure the o-ring is not pinched and the washer is seated flat on the counterbore of the port.

Table 5-24. Metric Pipe Parallel O-ring Boss (MPP)



Note: Metric O-ring only style (ISO 6149) requires o-ring chamfer in the port, similar to ISO 11926 (SAE ORB),**but is not interchangeable.**





TYPE/FITTING IDENTIFICATION			STUD ENDS with 37° (JIC) or L series DIN (MBTL) opposite end						STUD ENDS with (ORFS) or S series DIN (MBTS) opposite end					
MATERIAL	Thread M Size	Connecting Tube O.D.	Torque						Torque					
			[Ft-Lb]			[N-m]			[Ft-Lb]			[N-m]		
	(metric)	(mm)	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max
STEEL FITTINGS WITH STEEL MATING COMPONENTS; UN-LUBRICATED THREADS	M8x1	4	6	7	7	8	9	9	8	9	9	10	12	12
	M10x1	6	11	12	12	15	16	16	15	16	17	20	22	23
	M12x1.5	8	18	19	20	25	26	27	26	28	29	35	38	39
	M14x1.5	10	26	28	29	35	38	39	33	35	36	45	47	49
	M16x1.5	12	30	32	33	40	43	45	41	43	45	55	58	61
	M18x1.5	15	33	35	36	45	47	49	52	55	57	70	75	77
	M20x1.5	--	--	--	--	--	--	--	59	62	65	80	84	88
	M22x1.5	18	44	46	48	60	62	65	74	78	81	100	106	110
	M27x2	22	74	78	81	100	106	110	125	132	138	170	179	187
	M30x2	--	95	100	105	130	136	142	175	184	193	237	249	262
	M33x2	25	120	126	132	160	171	179	230	242	253	310	328	343
	M38x2	--	135	142	149	183	193	202	235	247	259	319	335	351
	M42x2	30	155	163	171	210	221	232	245	258	270	330	350	366
	M48x2	38	190	200	209	260	271	283	310	326	341	420	442	462
	M60x2	50	230	242	253	315	328	343	370	389	407	500	527	552
ALUMINUM/BRASS FITTINGS OR ALUMINUM/BRASS MATING COMPONENTS; UN-LUBRICATED THREADS	M8x1	4	4	5	5	5	7	7	5	6	6	7	8	8
	M10x1	6	7	8	8	9	11	11	10	11	11	14	15	15
	M12x1.5	8	12	13	13	16	18	18	17	18	19	23	24	26
	M14x1.5	10	17	18	19	23	24	26	21	22	23	28	30	31
	M16x1.5	12	20	21	21	27	28	28	27	28	29	37	38	39
	M18x1.5	15	21	22	23	28	30	31	34	36	37	46	49	50
	M20x1.5	--	--	--	--	--	--	--	30	40	42	41	54	57
	M22x1.5	18	29	30	31	39	41	42	48	51	53	65	69	72
	M27x2	22	48	51	53	65	69	72	81	86	90	110	117	122
	M30x2	--	62	65	68	84	88	92	114	120	125	155	163	169
	M33x2	25	78	82	86	106	111	117	150	157	164	203	213	222
	M38x2	--	88	93	97	119	126	132	153	161	168	207	218	228
	M42x2	30	101	106	111	137	144	150	159	168	176	216	228	239
	M48x2	38	124	130	136	168	176	184	202	212	222	274	287	301
	M60x2	50	150	157	164	203	213	222	241	253	265	327	343	359

Assembly instructions for Adjustable Port End (BSPP) Fittings

1. Inspect components to ensure that male and female threads and surfaces are free of rust, splits, dirt, foreign matter or burrs.
2. If o-ring is not pre-installed, install proper size, taking care not to damage it. See O-ring Installation (Replacement) for instructions.

⚠ CAUTION

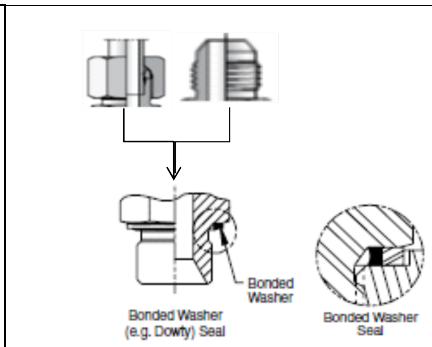
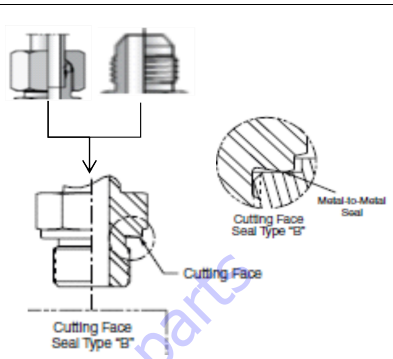
CARE TO BE TAKEN WHEN LUBRICATING O-RING. AVOID ADDING OIL TO THE THREADED CONNECTION OF THE FITTING. THE LUBRICATION WOULD CAUSE INCREASED CLAMPING FORCE AND CAUSE FITTING DAMAGE.

3. Pre-lubricate the o-ring with Hydraulic Oil.
4. For Non-Adjustable Fittings and Plugs, thread the fitting by hand until contact.
5. For Adjustable fittings, refer to Adjustable Stud End Assembly for proper assembly.
6. Torque the fitting or nut to value listed in Table 5-25, Table 5-26, Table 5-27, Table 5-28, Table 5-29, or Table 5-30 while using the Double Wrench Method.
   a. The table headings identify the BSPP port and the type on the other side of the fitting. The torque will be applied to the BSPP port.
   b. Torque values provided in Table 5-25, Table 5-26, Table 5-27, Table 5-28, Table 5-29, and Table 5-30 are segregated based on the material configuration of the connection. 'ALUMINUM/BRASS FITTINGS OR ALUMINUM/BRASS MATING COMPONENTS' indicate either the following material configurations:

- STEEL fittings with ALUMINUM or BRASS mating components
- ALUMINUM or BRASS fittings with STEEL mating components
- ALUMINUM or BRASS fittings with ALUMINUM or BRASS mating components.

7. Inspect to ensure the o-ring is not pinched and the washer is seated flat on the counterbore of the port.

Table 5-25. British Standard Parallel Pipe Port (BSPP) - L Series - Table 1 of 3

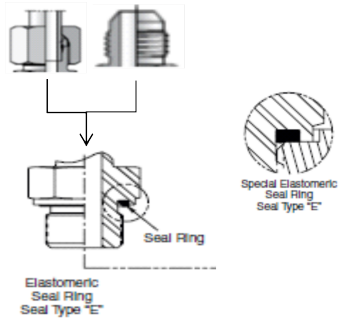
														
TYPE/FITTING IDENTIFICATION			FORM A**(SEALING WASHER) STUD ENDS with 37° (JIC) or L series DIN (MBTL) opposite end						FORM B** (CUTTING FACE) STUD ENDS with 37° (JIC) or L series DIN (MBTL) opposite end					
MATERIAL	BSPP Thread G Size	Connecting Tube O.D.	Torque						Torque					
			[Ft-Lb]			[N-m]			[Ft-Lb]			[N-m]		
	(metric)	(mm)	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max
STEEL FITTINGS WITH STEEL MATING COMPONENTS; UN-LUBRICATED THREADS	G 1/8A	6	7	8	8	9	11	11	13	14	14	18	19	19
	G 1/4A	8	26	28	29	35	38	39	26	28	29	35	38	39
	G 1/4A	10	26	28	29	35	38	39	26	28	29	35	38	39
	G 3/8A	12	33	35	36	45	47	49	52	55	57	70	75	77
	G 1/2A	15	48	51	53	65	69	72	103	108	113	140	146	153
	G 1/2A	18	48	51	53	65	69	72	74	78	81	100	106	110
	G 3/4A	22	66	70	73	90	95	99	133	140	146	180	190	198
	G 1A	28	111	117	122	150	159	165	243	255	267	330	346	362
	G 1-1/4A	35	177	186	195	240	252	264	398	418	438	540	567	594
	G 1-1/2A	42	214	225	235	290	305	319	465	489	512	630	663	694
MATERIAL	BSPP Thread G Size	Connecting Tube O.D.	Torque						Torque					
			[Ft-Lb]			[N-m]			[Ft-Lb]			[N-m]		
	(metric)	(mm)	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max
ALUMINUM/BRASS FITTINGS OR ALUMINUM/BRASS MATING COMPONENTS; UN-LUBRICATED THREADS	G 1/8A	6	4	5	5	5	7	7	8	9	9	11	12	12
	G 1/4A	8	17	18	19	23	24	26	17	18	19	23	24	26
	G 1/4A	10	17	18	19	23	24	26	17	18	19	23	24	26
	G 3/8A	12	21	22	23	28	30	31	34	36	37	46	49	50
	G 1/2A	15	31	33	34	42	45	46	67	70	73	91	95	99
	G 1/2A	18	31	33	34	42	45	46	48	51	53	65	69	72
	G 3/4A	22	42	45	47	57	61	64	86	91	95	117	123	129
	G 1A	28	72	76	79	98	103	107	158	166	174	214	225	236
	G 1-1/4A	35	115	121	127	156	164	172	259	272	285	351	369	386
	G 1-1/2A	42	139	146	153	188	198	207	302	318	333	409	431	451

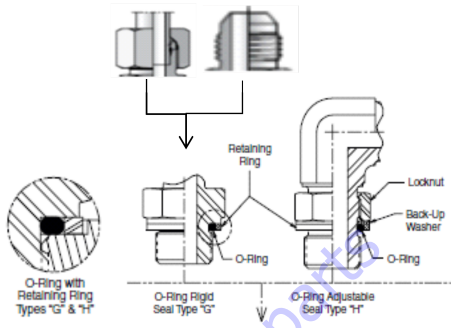
*Typical for JLG Straight Male Stud Fittings

**Non typical for JLG Straight Male Stud Fittings, reference only.

***Typical for JLG Adjustable Fittings

Table 5-26. British Standard Parallel Pipe Port (BSPP) - L Series - Table 2 of 3





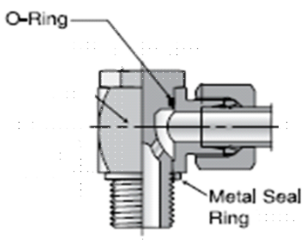
TYPE/FITTING IDENTIFICATION			FORM E* (EOLASTIC SEALING RING) STUD ENDS with 37° (JIC) or L series DIN (MBTL) opposite end						FORM G/H*** (O-RING W/ RETAINING RING) STUD ENDS & ADJUSTABLE STUD ENDS with 37° (JIC) or L series DIN (MBTL) opposite end					
MATERIAL	BSPP Thread G Size	Connecting Tube O.D.	Torque						Torque					
			[Ft-Lb]			[N-m]			[Ft-Lb]			[N-m]		
	(metric)	(mm)	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max
STEEL FITTINGS WITH STEEL MATING COMPONENTS; UN-LUBRICATED THREADS	G 1/8A	6	13	14	14	18	19	19	13	14	14	18	19	19
	G 1/4A	8	26	28	29	35	38	39	26	28	29	35	38	39
	G 1/4A	10	26	28	29	35	38	39	26	28	29	35	38	39
	G 3/8A	12	52	55	57	70	75	77	52	55	57	70	75	77
	G 1/2A	15	66	70	73	90	95	99	66	70	73	90	95	99
	G 1/2A	18	66	70	73	90	95	99	66	70	73	90	95	99
	G 3/4A	22	133	140	146	180	190	198	133	140	146	180	190	198
	G 1A	28	229	241	252	310	327	342	229	241	252	310	327	342
	G 1-1/4A	35	332	349	365	450	473	495	332	349	365	450	473	495
	G 1-1/2A	42	398	418	438	540	567	594	398	418	438	540	567	594
MATERIAL	BSPP Thread G Size	Connecting Tube O.D.	Torque						Torque					
			[Ft-Lb]			[N-m]			[Ft-Lb]			[N-m]		
	(metric)	(mm)	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max
ALUMINUM/BRASS FITTINGS OR ALUMINUM/BRASS MATING COMPONENTS; UN-LUBRICATED THREADS	G 1/8A	6	8	9	9	11	12	12	8	9	9	11	12	12
	G 1/4A	8	17	18	19	23	24	26	17	18	19	23	24	26
	G 1/4A	10	17	18	19	23	24	26	17	18	19	23	24	26
	G 3/8A	12	34	36	37	46	49	50	34	36	37	46	49	50
	G 1/2A	15	43	45	47	58	61	64	43	45	47	58	61	64
	G 1/2A	18	43	45	47	58	61	64	43	45	47	58	61	64
	G 3/4A	22	86	91	95	117	123	129	86	91	95	117	123	129
	G 1A	28	149	157	164	202	213	222	149	157	164	202	213	222
	G 1-1/4A	35	216	227	237	293	308	321	216	227	237	293	308	321
	G 1-1/2A	42	259	272	285	351	369	386	259	272	285	351	369	386

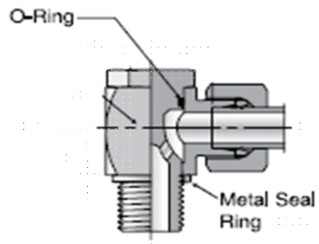
*Typical for JLG Straight Male Stud Fittings

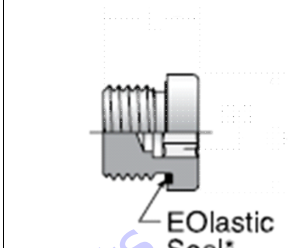
** Non typical for JLG Straight Male Stud Fittings, reference only.

***Typical for JLG Adjustable Fittings

Table 5-27. British Standard Parallel Pipe Port (BSPP) - L Series - Table 3 of 3







TYPE/FITTING IDENTIFICATION			BANJO FITTINGS with L series DIN (MBTL) opposite end						HIGH PRESSURE BANJO FITTINGS with L series DIN (MBTL) opposite end						FORM E (EOLASTIC SEALING RING) HOLLOW HEX PLUGS					
MATERIAL	BSPP Thread G Size	Connecting Tube O.D.	Torque						Torque						Torque					
			[Ft-Lb]			[N-m]			[Ft-Lb]			[N-m]			[Ft-Lb]			[N-m]		
	(metric)	(mm)	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max
STEEL FITTINGS WITH STEEL MATING COMPONENTS; UN-LUBRICATED THREADS	G1/8A	6	13	14	14	18	19	19	13	14	14	18	19	19	10	11	11	13	15	15
	G1/4A	8	30	32	33	40	43	45	33	35	36	45	47	49	22	23	24	30	31	33
	G1/4A	10	30	32	33	40	43	45	33	35	36	45	47	49	22	23	24	30	31	33
	G3/8A	12	48	51	53	65	69	72	52	55	57	70	75	77	44	46	48	60	62	65
	G1/2A	15	66	70	73	90	95	99	89	94	98	120	127	133	59	62	65	80	84	88
	G1/2A	18	66	70	73	90	95	99	89	94	98	120	127	133	59	62	65	80	84	88
	G3/4A	22	92	97	101	125	132	137	170	179	187	230	243	254	103	108	113	140	146	153
	G1A	28	--	--	--	--	--	--	236	248	260	320	336	353	148	156	163	200	212	221
	G1-1/4A	35	--	--	--	--	--	--	398	418	438	540	567	594	295	313.5	332	400	425	450
	G1-1/2A	42	--	--	--	--	--	--	516	542	568	700	735	770	332	349	365	450	473	495
MATERIAL	BSPP Thread G Size	Connecting Tube O.D.	Torque						Torque						Torque					
			[Ft-Lb]			[N-m]			[Ft-Lb]			[N-m]			[Ft-Lb]			[N-m]		
	(metric)	(mm)	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max
ALUMINUM/BRASS FITTINGS OR ALUMINUM/BRASS MATING COMPONENTS; UN-LUBRICATED THREADS	G1/8A	6	8	9	9	11	12	12	8	9	9	11	12	12	6	7	7	8	9	9
	G1/4A	8	20	21	21	27	28	28	21	22	23	28	30	31	14	15	16	19	20	22
	G1/4A	10	20	21	21	27	28	28	21	22	23	28	30	31	14	15	16	19	20	22
	G3/8A	12	31	33	34	42	45	46	34	36	37	46	49	50	29	30	31	39	41	42
	G1/2A	15	43	45	47	58	61	64	58	61	64	79	83	87	38	40	42	52	54	57
	G1/2A	18	43	45	47	58	61	64	58	61	64	79	83	87	38	40	42	52	54	57
	G3/4A	22	60	63	66	81	85	89	111	117	122	150	159	165	67	70	73	91	95	99
	G1A	28	--	--	--	--	--	--	153	161	169	207	218	229	96	101	106	130	137	144
	G1-1/4A	35	--	--	--	--	--	--	259	272	285	351	369	386	216	227	237	293	308	321
	G1-1/2A	42	--	--	--	--	--	--	335	352	369	454	477	500	216	227	237	293	308	321

* Typical for JLG Straight Male Stud Fittings

** Non typical for JLG Straight Male Stud Fittings, reference only.

*** Typical for JLG Adjustable Fittings

Table 5-28. British Standard Parallel Pipe Port (BSPP) - S Series - Table 1 of 3

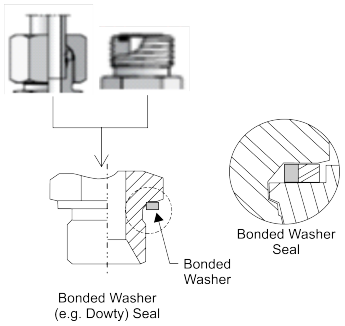
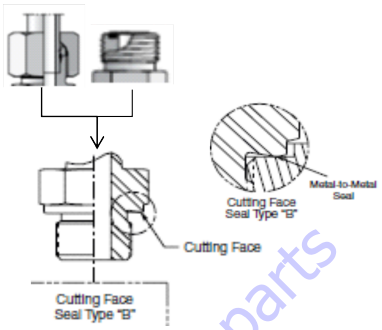
														
TYPE/FITTING IDENTIFICATION			FORM A** (SEALING WASHER) STUD ENDS with (ORFS) or S series DIN (MBTS) opposite end						FORM B** (CUTTING FACE) STUD ENDS with (ORFS) or S series DIN (MBTS) opposite end					
MATERIAL	BSPP Thread G Size	Connecting Tube O.D.	Torque						Torque					
			[Ft-Lb]			[N-m]			[Ft-Lb]			[N-m]		
	(metric)	(mm)	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max
STEEL FITTINGS WITH STEEL MATING COMPONENTS; UN-LUBRICATED THREADS	G 1/4A	6	26	28	29	35	38	39	41	43	45	55	58	61
	G 1/4A	8	26	28	29	35	38	39	41	43	45	55	58	61
	G 3/8A	10	33	35	36	45	47	49	66	70	73	90	95	99
	G 3/8A	12	33	35	36	45	47	49	66	70	73	90	95	99
	G 1/2A	14	48	51	53	65	69	72	111	117	122	150	159	165
	G 1/2A	16	48	51	53	65	69	72	96	101	106	130	137	144
	G 3/4A	20	66	70	73	90	95	99	199	209	219	270	283	297
	G 1A	25	111	117	122	150	159	165	251	264	276	340	358	374
	G 1-1/4A	30	177	186	195	240	252	264	398	418	438	540	567	594
	G 1-1/2A	38	214	225	235	290	305	319	516	542	568	700	735	770
MATERIAL	BSPP Thread G Size	Connecting Tube O.D.	Torque						Torque					
			[Ft-Lb]			[N-m]			[Ft-Lb]			[N-m]		
	(metric)	(mm)	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max
ALUMINUM/BRASS FITTINGS OR ALUMINUM/BRASS MATING COMPONENTS; UN-LUBRICATED THREADS	G 1/4A	6	17	18	19	23	24	26	27	28	29	37	38	39
	G 1/4A	8	17	18	19	23	24	26	27	28	29	37	38	39
	G 3/8A	10	21	22	23	28	30	31	43	45	47	58	61	64
	G 3/8A	12	21	22	23	28	30	31	43	45	47	58	61	64
	G 1/2A	14	31	33	34	42	45	46	72	76	79	98	103	107
	G 1/2A	16	31	33	34	42	45	46	62	66	69	84	89	94
	G 3/4A	20	43	45	47	58	61	64	129	136	142	175	184	193
	G 1A	25	72	76	79	98	103	107	163	171	179	221	232	243
	G 1-1/4A	30	115	121	127	156	164	172	259	272	285	351	369	386
	G 1-1/2A	38	139	146	153	188	198	207	335	352	369	454	477	500
*Typical for JLG Straight Male Stud Fittings														
** Non typical for JLG Straight Male Stud Fittings, reference only.														
***Typical for JLG Adjustable Fittings														

Table 5-29. British Standard Parallel Pipe Port (BSPP) - S Series - Table 2 of 3

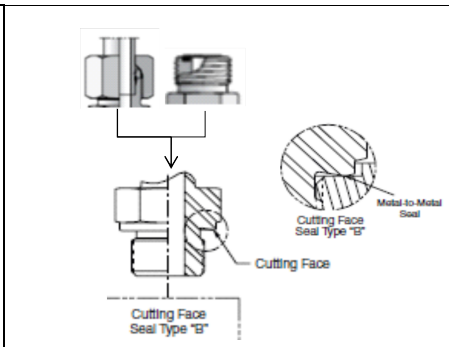
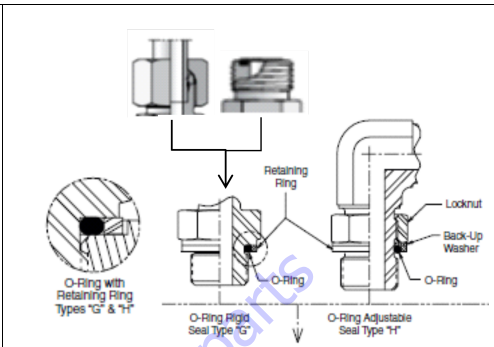
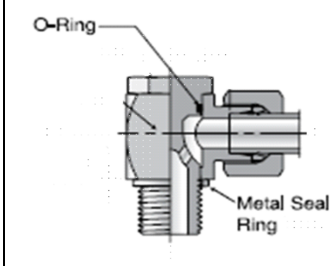
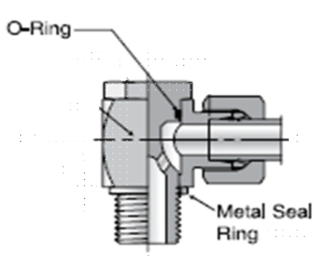
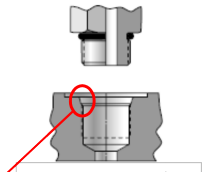
														
TYPE/FITTING IDENTIFICATION			FORM E* (EOLASTIC SEALING RING) STUD ENDS AND HEX TYPE PLUGS with (ORFS) or S series DIN (MBTS) opposite end						FORM G/H*** (O-RING W/ RETAINING RING) STUD ENDS & ADJUSTABLE STUD ENDS with (ORFS) or S series DIN (MBTS) opposite end					
MATERIAL	BSPP Thread G Size	Connecting Tube O.D.	Torque						Torque					
			[Ft-Lb]			[N-m]			[Ft-Lb]			[N-m]		
	(metric)	(mm)	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max
STEEL FITTINGS WITH STEEL MATING COMPONENTS; UN-LUBRICATED THREADS	G 1/4A	6	41	43	45	55	58	61	26	28	29	35	38	39
	G 1/4A	8	41	43	45	55	58	61	26	28	29	35	38	39
	G 3/8A	10	59	62	65	80	84	88	52	55	57	70	75	77
	G 3/8A	12	59	62	65	80	84	88	52	55	57	70	75	77
	G 1/2A	14	85	90	94	115	122	127	66	70	73	90	95	99
	G 1/2A	16	85	90	94	115	122	127	66	70	73	90	95	99
	G 3/4A	20	133	140	146	180	190	198	133	140	146	180	190	198
	G 1A	25	229	241	252	310	327	342	229	241	252	310	327	342
	G 1-1/4A	30	332	349	365	450	473	495	332	349	365	450	473	495
	G 1-1/2A	38	398	418	438	540	567	594	398	418	438	540	567	594
MATERIAL	BSPP Thread G Size	Connecting Tube O.D.	Torque						Torque					
			[Ft-Lb]			[N-m]			[Ft-Lb]			[N-m]		
	(metric)	(mm)	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max
ALUMINUM/BRASS FITTINGS OR ALUMINUM/BRASS MATING COMPONENTS; UN-LUBRICATED THREADS	G 1/4A	6	27	28	29	37	38	39	17	18	19	23	24	26
	G 1/4A	8	27	28	29	37	38	39	17	18	19	23	24	26
	G 3/8A	10	38	40	42	52	54	57	34	36	37	46	49	50
	G 3/8A	12	38	40	42	52	54	57	34	36	37	46	49	50
	G 1/2A	14	55	58	61	75	79	83	43	45	47	58	61	64
	G 1/2A	16	55	58	61	75	79	83	43	45	47	58	61	64
	G 3/4A	20	86	91	95	117	123	129	86	91	95	117	123	129
	G 1A	25	149	157	164	202	213	222	149	157	164	202	213	222
	G 1-1/4A	30	216	227	237	293	308	321	216	227	237	293	308	321
	G 1-1/2A	38	259	272	285	351	369	386	259	272	285	351	369	386
*Typical for JLG Straight Male Stud Fittings														
** Non typical for JLG Straight Male Stud Fittings, reference only.														
***Typical for JLG Adjustable Fittings														

Table 5-30. British Standard Parallel Pipe Port (BSPP) - S Series - Table 3 of 3

			 **Note:** BSPP O-ring only style (ISO 228-1) requires o-ring chamfer in the port, similar to ISO 11926 (SAE ORB), **but is not interchangeable. Not typically used on JLG machines.**
TYPE/FITTING IDENTIFICATION	BANJO FITTINGS with S series DIN (MBTS) opposite end	HIGH PRESSURE BANJO FITTINGS with S series DIN (MBTS) opposite end	JIS/BSPP O-RING ONLY

MATERIAL	BSPP Thread G Size	Connecting Tube O.D.	Torque [Ft-Lb]			Torque [N-m]			Torque [Ft-Lb]			Torque [N-m]			Torque [Ft-Lb]			Torque [N-m]		
	(metric)	(mm)	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max
STEEL FITTINGS WITH STEEL MATING COMPONENTS; UN-LUBRICATED THREADS	G 1/4A	6	30	32	33	40	43	45	33	35	36	45	47	49	Fitting type not typically specified on JLG applications. Refer to the specific procedure in this Service Manual.					
	G 1/4A	8	30	32	33	40	43	45	33	35	36	45	47	49						
	G 3/8A	10	48	51	53	65	69	72	52	55	57	70	75	77						
	G 3/8A	12	48	51	53	65	69	72	52	55	57	70	75	77						
	G 1/2A	14	66	70	73	90	95	99	89	94	98	120	127	133						
	G 1/2A	16	66	70	73	90	95	99	89	94	98	120	127	133						
	G 3/4A	20	92	97	101	125	132	137	170	179	187	230	243	254						
	G 1A	25	--	--	--	--	--	--	236	248	260	320	336	353						
	G 1-1/4A	30	--	--	--	--	--	--	398	418	438	540	567	594						
	G 1-1/2A	38	--	--	--	--	--	--	516	542	568	700	735	770						

MATERIAL	BSPP Thread G Size	Connecting Tube O.D.	Torque [Ft-Lb]			Torque [N-m]			Torque [Ft-Lb]			Torque [N-m]			Torque [Ft-Lb]			Torque [N-m]		
	(metric)	(mm)	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max
ALUMINUM/BRASS FITTINGS OR ALUMINUM/BRASS MATING COMPONENTS; UN-LUBRICATED THREADS	G 1/4A	6	20	21	21	27	28	28	22	22	23	30	30	31	Fitting type not typically specified on JLG applications. Refer to the specific procedure in this Service Manual.					
	G 1/4A	8	20	21	21	27	28	28	22	22	23	30	30	31						
	G 3/8A	10	31	33	34	42	45	46	34	36	37	46	49	50						
	G 3/8A	12	31	33	34	42	45	46	34	36	37	46	49	50						
	G 1/2A	14	43	45	47	58	61	64	58	61	64	79	83	87						
	G 1/2A	16	43	45	47	58	61	64	58	61	64	79	83	87						
	G 3/4A	20	60	63	66	81	85	89	111	117	122	150	159	165						
	G 1A	25	--	--	--	--	--	--	153	161	169	207	218	229						
	G 1-1/4A	30	--	--	--	--	--	--	259	272	285	351	369	386						
	G 1-1/2A	38	--	--	--	--	--	--	335	352	368	454	477	499						

* Typical for JLG Straight Male Stud Fittings

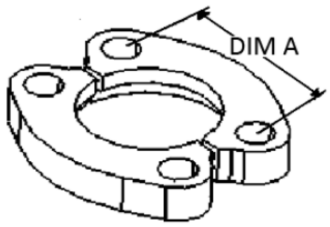
** Non typical for JLG Straight Male Stud Fittings, reference only.

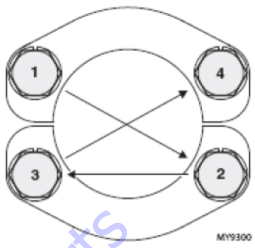
*** Typical for JLG Adjustable Fittings

Assembly Instructions for Flange Connections: (FL61 and FL62)

1. Make sure sealing surfaces are free of rust, splits, scratches, dirt, foreign matter or burrs.
2. Install o-ring as per “O-ring Installation (Replacement)” .
3. Pre-lubricate the o-ring with Hydraulic Oil.
4. Position flange and clamp halves.
5. Place lock washers on bolt and bolt through clamp halves.
6. Tighten all bolts by hand.
7. Torque bolts in diagonal sequence in two or more increments to the torque listed on Table 5-31and Table 5-32.

Table 5-31. Flange Code (FL61 & FL62) -Inch Fasteners

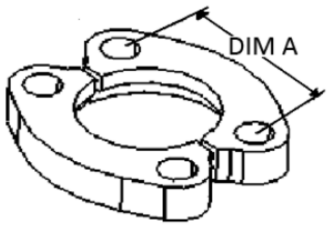


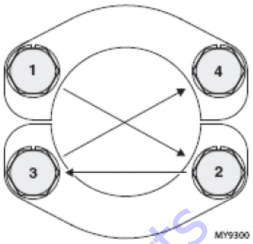


TYPE/FITTING IDENTIFICATION						STEEL 4-BOLT FLANGE SAE J518 (INCH FASTENERS)													
TYPE	Inch Flange SAE Dash Size	Flange Size		A*		Bolt Thread Size	Fastener Torque for Flanges Equipped with GRADE 5 Screws						Fastener Torque for Flanges Equipped with GRADE 8 Screws						
							[Ft-Lb]			[N-m]			[Ft-Lb]			[N-m]		
		(in)	(mm)	(in)	(mm)	(UNF)	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max
CODE 61 SPLIT FLANGE (FL61)	8	0.50	13	1.50	38.10	5/16-18	18	19	19	24	25	26	24	25	26	32	34	35
	12	0.75	19	1.88	47.75	3/8-16	32	33	35	43	45	47	44	46	49	60	63	66
	16	1.00	25	2.06	52.32	3/8-16	32	33	35	43	45	47	44	46	49	60	63	66
	20	1.25	32	2.31	58.67	7/16-14	52	54	57	70	74	77	68	71	75	92	97	101
	24	1.50	38	2.75	69.85	1/2-13	77	81	85	105	110	116	111	116	122	150	158	165
	32	2.00	51	3.06	77.72	1/2-13	77	81	85	105	110	116	111	116	122	150	158	165
	40	2.50	64	3.50	88.90	1/2-13	77	81	85	105	110	116	111	116	122	150	158	165
	48	3.00	76	4.19	106.43	5/8-11	155	163	170	210	221	231	218	228	239	295	310	325
	56	3.50	89	4.75	120.65	5/8-11	155	163	170	210	221	231	218	228	239	295	310	325
	64	4.00	102	5.13	130.30	5/8-11	155	163	170	210	221	231	218	228	239	295	310	325
	80	5.00	127	6.00	152.40	5/8-11	155	163	170	210	221	231	218	228	239	295	310	325
TYPE	Inch Flange SAE Dash Size	Flange Size		A*		Bolt Thread Size	Fastener Torque for Flanges Equipped with GRADE 5 Screws						Fastener Torque for Flanges Equipped with GRADE 8 Screws						
							[Ft-Lb]			[N-m]			[Ft-Lb]			[N-m]		
		(in)	(mm)	(in)	(mm)	(UNF)	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max
CODE 62 SPLIT FLANGE (FL62)	8	0.50	13	1.59	40.39	5/16-18	--	--	--	--	--	--	24	25	26	32	34	35
	12	0.75	19	2.00	50.80	3/8-16	--	--	--	--	--	--	44	46	49	60	63	66
	16	1.00	25	2.25	57.15	7/16-14	--	--	--	--	--	--	68	71	75	92	97	101
	20	1.25	32	2.62	66.55	1/2-13	--	--	--	--	--	--	111	116	122	150	158	165
	20	1.25	32	2.62	66.55	--	--	--	--	--	--	--	--	--	--	--	--	--
	24	1.50	38	3.12	79.25	5/8-11	--	--	--	--	--	--	218	228	239	295	310	325
	32	2.00	51	3.81	96.77	3/4-10	--	--	--	--	--	--	332	348	365	450	473	495

* A dimension for reference only.

Table 5-32. Flange Code (FL61 & FL62) - Metric Fasteners





TYPE/FITTING IDENTIFICATION						STEEL 4-BOLT FLANGE SAE J518 (INCH FASTENERS)													
TYPE	Inch Flange SAE Dash Size	Flange Size		A*		Bolt Thread Size	Fastener Torque for Flanges Equipped with CLASS 8.8 Screws						Fastener Torque for Flanges Equipped with CLASS 10.9 Screws					
							[Ft-Lb]			[N-m]			[Ft-Lb]			[N-m]		
		(in)	(mm)	(in)	(mm)	(Metric)	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max
CODE 61 SPLIT FLANGE (FL61)	8	0.50	13	1.50	38.10	(Metric)	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max
	12	0.75	19	1.88	47.75	M8x1.25	18	19	19	24	25	26	18	19	19	24	25	26
	16	1.00	25	2.06	52.32	M10x1.5	37	39	41	50	53	55	37	39	41	50	53	55
	20	1.25	32	2.31	58.67	M10x1.5	37	39	41	50	53	55	37	39	41	50	53	55
	24	1.50	38	2.75	69.85	M10x1.5	37	39	41	50	53	55	37	39	41	50	53	55
	32	2.00	51	3.06	77.72	M12x1.75	68	71	75	92	97	101	68	71	75	92	97	101
	40	2.50	64	3.50	88.90	M12x1.75	68	71	75	92	97	101	68	71	75	92	97	101
	48	3.00	76	4.19	106.43	M12x1.75	68	71	75	92	97	101	68	71	75	92	97	101
	56	3.50	89	4.75	120.65	M16x2	155	163	170	210	221	231	155	163	170	210	221	231
	64	4.00	102	5.13	130.30	M16x2	155	163	170	210	221	231	155	163	170	210	221	231
	80	5.00	127	6.00	152.40	M16x2	155	163	170	210	221	231	155	163	170	210	221	231
TYPE	Inch Flange SAE Dash Size	Flange Size		A*		Bolt Thread Size	Fastener Torque for Flanges Equipped with CLASS 8.8 Screws						Fastener Torque for Flanges Equipped with CLASS 10.9 Screws					
							[Ft-Lb]			[N-m]			[Ft-Lb]			[N-m]		
		(in)	(mm)	(in)	(mm)	(Metric)	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max	Min	Nom	Max
CODE 62 SPLIT FLANGE (FL62)	8	0.50	13	1.59	40.39	M8x1.25	--	--	--	--	--	--	24	25	26	32	34	35
	12	0.75	19	2.00	50.80	M10x1.5	--	--	--	--	--	--	52	54	57	70	74	77
	16	1.00	25	2.25	57.15	M12x1.75	--	--	--	--	--	--	96	101	105	130	137	143
	20	1.25	32	2.62	66.55	M12x1.75	--	--	--	--	--	--	96	101	105	130	137	143
	20	1.25	32	2.62	66.55	M14x2	--	--	--	--	--	--	133	139	146	180	189	198
	24	1.50	38	3.12	79.25	M16x2	--	--	--	--	--	--	218	228	239	295	310	325
	32	2.00	51	3.81	96.77	M20x2.5	--	--	--	--	--	--	406	426	446	550	578	605

* A dimension for reference only.

Double Wrench Method

To prevent undesired hose or connector rotation, two wrenches must be used; one torque wrench and one backup wrench. If two wrenches are not used, inadvertent component rotation may occur which absorbs torque and causes improper joint load and leads to leaks. For hose connections, the 'layline' printed on the hose is a good indicator of proper hose installation. A twisted lay-line usually indicates the hose is twisted. See Figure 5-11. for double wrench method requirements.

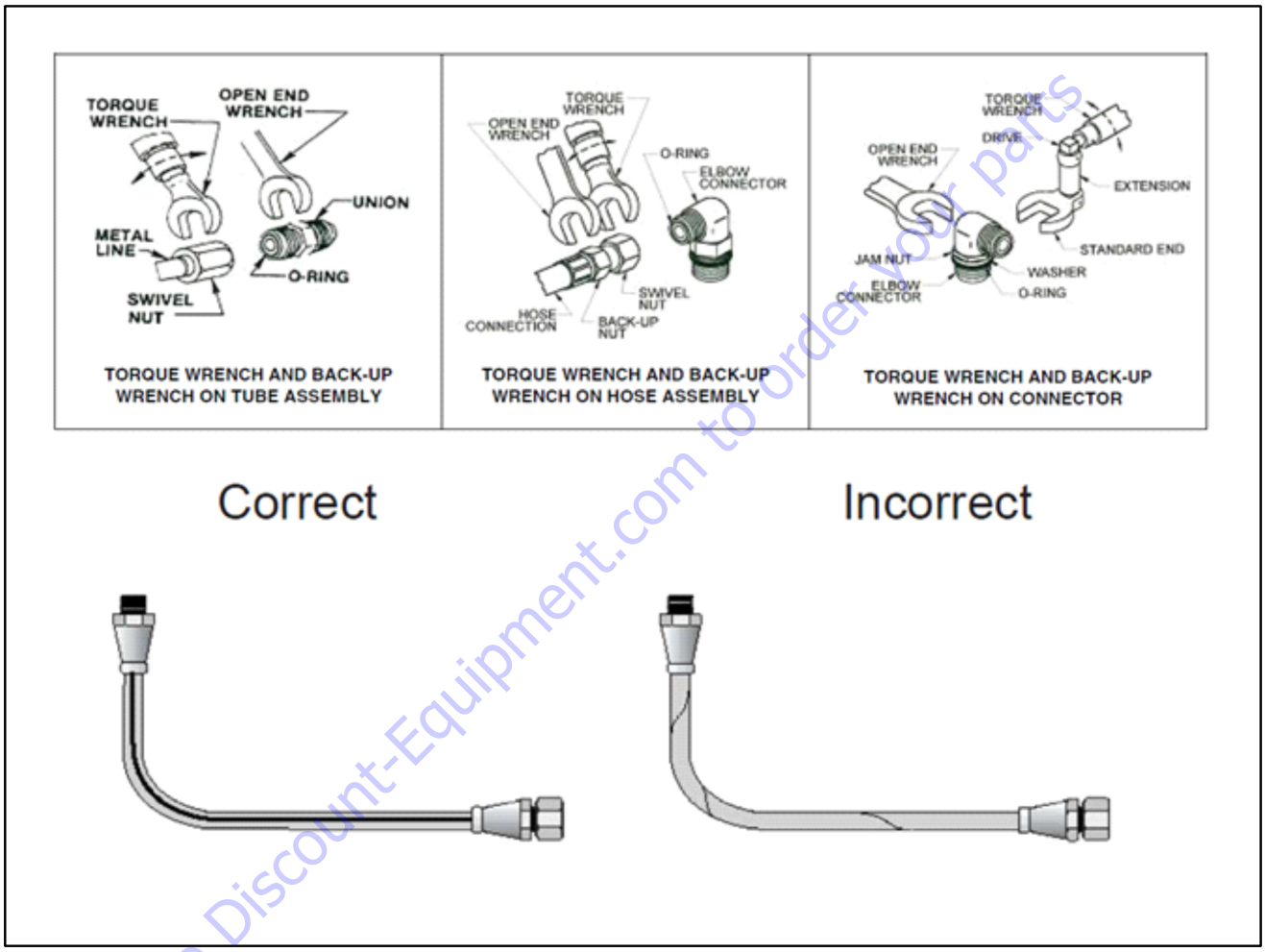


Figure 5-11. Double Wrench Method

FFWR and TFFT Methods

FFWR (FLATS FROM WRENCH RESISTANCE METHOD)

1. Tighten the swivel nut to the mating fitting until no lateral movement of the swivel nut can be detected; finger tight condition.
2. Mark a dot on one of the swivel hex nut flats and another dot in line on the connecting tube adapter. See Figure B.1.
3. Use the double wrench method per Appendix A, turn the swivel nut to tighten as shown in Figure 5-11. The nut is to be rotated clockwise the number of hex flats as defined by the applicable Table in Section 5.0.
4. After the connection has been properly tightened, mark a straight line across the connecting parts, not covering the dots, to indicate the connection has been properly tightened. See Figure 5-12.

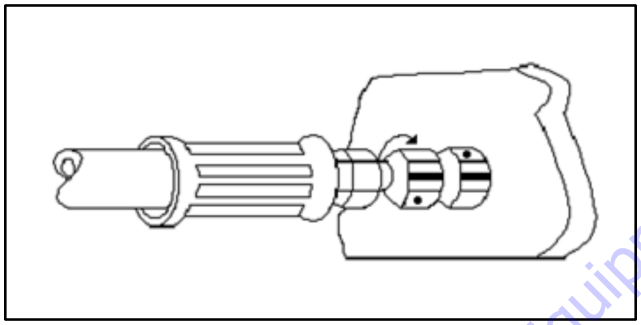


Figure 5-12. FFWR Method

TFFT (TURNS FROM FINGER TIGHT METHOD)

1. Tighten the swivel nut to the mating fitting until no lateral movement of the swivel nut can be detected; finger tight condition.
2. Mark a dot on one of the swivel hex nut flats and another dot in line on the connecting tube adapter.
3. Use the double wrench method per Appendix A, turn the swivel nut to tighten. The nut is to be rotated clockwise the number of turns as defined by the applicable Table in Section 5.0.
4. After the connection has been properly tightened, mark a straight line across the connecting parts, not covering the dots, to indicate the connection has been properly tightened.

Adjustable Stud End Assembly

For Adjustable Stud End Connections; the following assembly steps are to be performed:

1. Lubricate the o-ring with a light coat of hydraulic oil.
2. Position #1 – The o-ring should be located in the groove adjacent to the face of the backup washer. The washer and o-ring should be positioned at the extreme top end of the groove as shown.
3. Position #2 – Position the locknut to just touch the backup washer as shown. The locknut in this position will eliminate potential backup washer damage during the next step.
4. Position #3 – Install the connector into the straight thread box port until the metal backup washer contacts the face of the port as shown.
5. Position #4 – Adjust the connector to the proper position by turning out (counterclockwise) up to a maximum of one turn as shown to provide proper alignment with the mating connector, tube assembly, or hose assembly.
6. Position #5 – Using two wrenches, use the backup wrench to hold the connector in the desired position and then use the torque wrench to tighten the locknut to the appropriate torque.
7. Visually inspect, where possible, the joint to ensure the o-ring is not pinched or bulging out from under the washer and that the backup washer is properly seated flat against the face of the port.

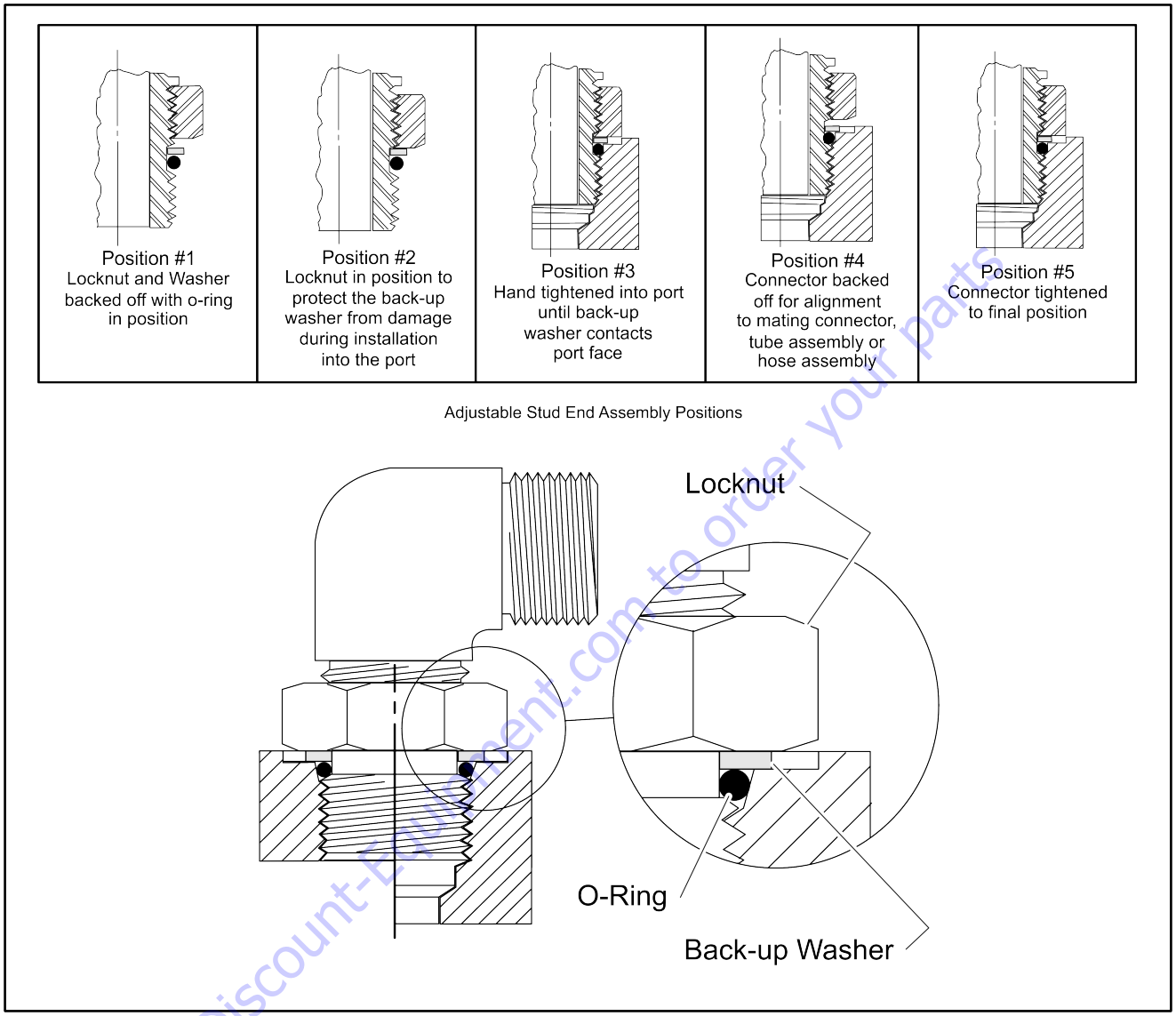


Figure 5-13. Adjustable Stud End Assembly

O-ring Installation (Replacement)

Care must be taken when installing o-rings over threads during replacement or installation. o-rings could become nicked or torn. A damaged o-ring could lead to leakage problems.

1. Inspect o-ring for tears or nicks. If any are found replace o-ring.
2. Ensure proper o-ring to be installed. Many o-rings look the same but are of different material, different hardness, or are slightly different diameters or widths.
3. Use a thread protector when replacing o-rings on fittings.
4. In ORB; ensure o-ring is properly seated in groove. On straight threads, ensure o-ring is seated all the way past the threads prior to installation.
5. Inspect o-ring for any visible nicks or tears. Replace if found.

5.3 HYDRAULIC CYLINDERS

Axle Lockout Cylinder

DISASSEMBLY

NOTICE

DISASSEMBLY OF THE CYLINDER SHOULD BE PERFORMED ON A CLEAN WORK SURFACE IN A DIRT FREE WORK AREA.

⚠ WARNING

ROD CAN FALL OUT OF BARREL AND CAUSE INJURY OR DAMAGE TO THE EQUIPMENT. BE CAREFUL WHEN REMOVING AXLE CYLINDER. OPENING BLEED VALVE CAN CAUSE ROD TO FALL OUT OF BARREL.

1. Open bleeder valve. Rotate rod and remove from barrel.
2. Remove two wear rings, wiper seal and rod seal from grooves of barrel bore. Do not scratch barrel bore.
3. Remove counterbalance valve and plugs.

CLEANING AND INSPECTION

1. Inspect bore and rod for scoring, pitting, or excessive wear.
2. Remove minor surface blemishes with wet sandpaper.
3. Pitting requires replacement of barrel and rod.

ASSEMBLY

NOTE: *Prior to cylinder assembly, ensure that the proper cylinder seal kit is used. See your JLG Parts Manual.*

NOTE: *Apply a light film of hydraulic oil to all components prior to assembly.*

NOTICE

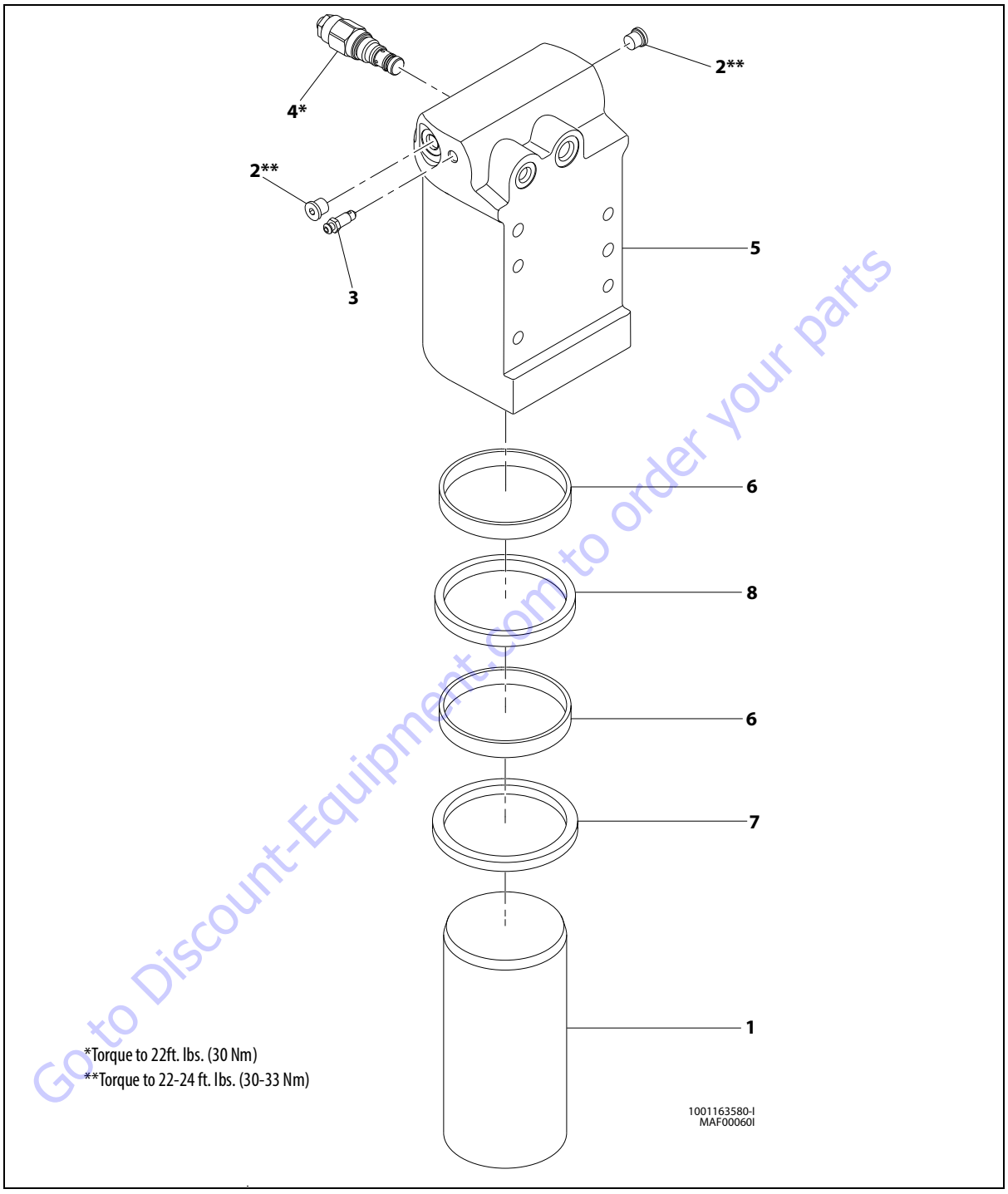
WHEN INSTALLING NEW SEALS, ENSURE SEALS ARE INSTALLED PROPERLY. IMPROPER SEAL INSTALLATION COULD RESULT IN CYLINDER LEAKAGE AND IMPROPER CYLINDER OPERATION.

1. Install two new wear rings, wiper seal and rod seal in barrel bore grooves. Make sure they are not twisted.
2. Lubricate rod bore with clean hydraulic fluid.

NOTICE

EXTREME CARE SHOULD BE TAKEN WHEN INSTALLING THE ROD. AVOID PULL ING THE ROD OFF-CENTER, WHICH COULD CAUSE DAMAGE TO THE ROD AND CYLINDER BARREL SURFACES.

3. Insert and push the rod into top of barrel bore, rotate to install the rod into barrel bore.
4. Install plugs and counterbalance valve. Torque the plugs to 22-24 ft. lbs. (30-33 Nm) and counterbalance valve to 22 ft. lbs. (30 Nm).
5. Bleed system.



1. Rod
2. Plug
3. Bleeder Valve
4. Counterbalance Valve
5. Barrel
6. Wear Ring
7. Rod Seal
8. Wiper seal

Figure 5-14. Axle Lockout Cylinder

Platform Level Cylinder

DISASSEMBLY

NOTICE

DISASSEMBLY OF THE CYLINDER SHOULD BE PERFORMED ON A CLEAN WORK SURFACE IN A DIRT FREE WORK AREA.

1. Connect a suitable auxiliary hydraulic power source to the cylinder port block fitting.

⚠ WARNING

DO NOT FULLY EXTEND CYLINDER TO THE END OF STROKE. RETRACT CYLINDER SLIGHTLY TO AVOID TRAPPING PRESSURE.

2. Operate the hydraulic power source and extend the cylinder. Shut down and disconnect the power source. Adequately support the cylinder rod, if applicable.
3. Remove the counterbalance valves and plugs from the cylinder port block. Discard o-rings.
4. Place the cylinder barrel into a suitable holding fixture.

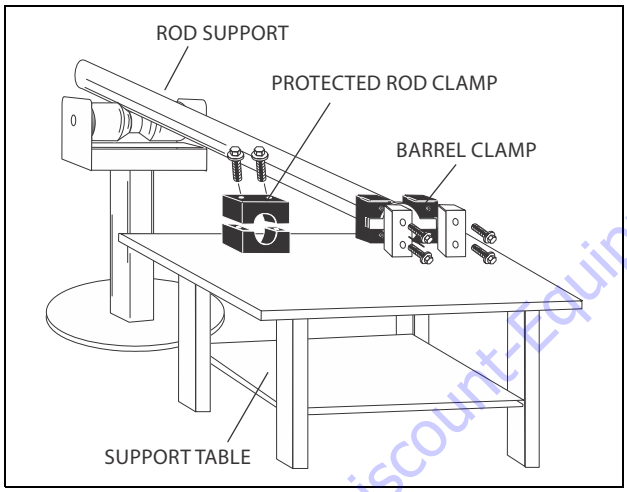


Figure 5-15. Cylinder Barrel Support

5. Mark cylinder head and barrel with a center punch for easy realignment. Using a hook spanner wrench, unscrew the cylinder head from the barrel.

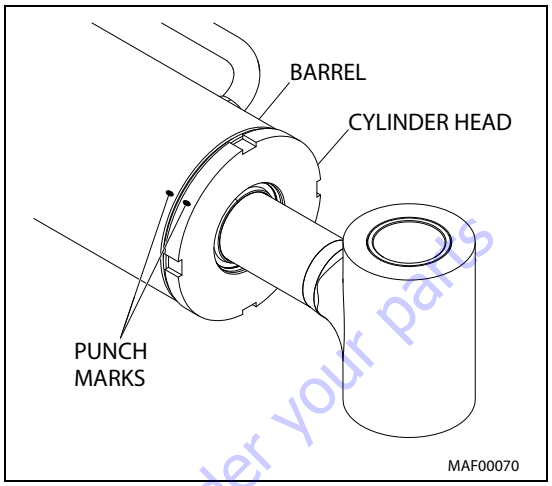


Figure 5-16. Cylinder Head Removal

6. Attach a suitable pulling device to the cylinder rod port block end or cylinder rod end, as applicable.

NOTICE

EXTREME CARE SHOULD BE TAKEN WHEN REMOVING THE CYLINDER ROD, HEAD AND PISTON. AVOID PULLING THE ROD OFF-CENTER, WHICH COULD CAUSE DAMAGE TO THE PISTON AND CYLINDER BARREL SURFACES.

7. With the barrel clamped securely, apply pressure to the rod pulling device and carefully withdraw the complete rod assembly from the cylinder barrel.

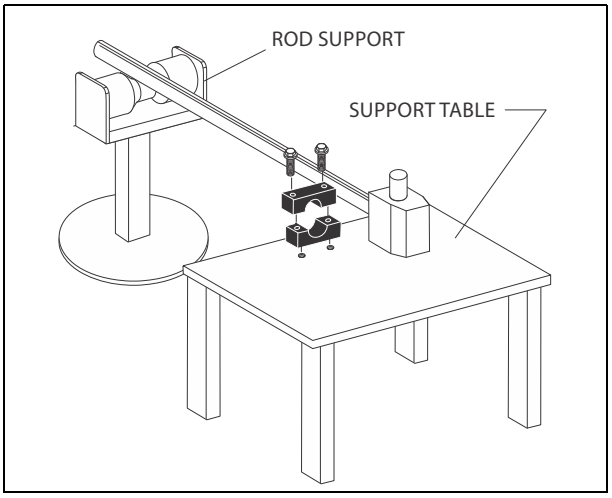
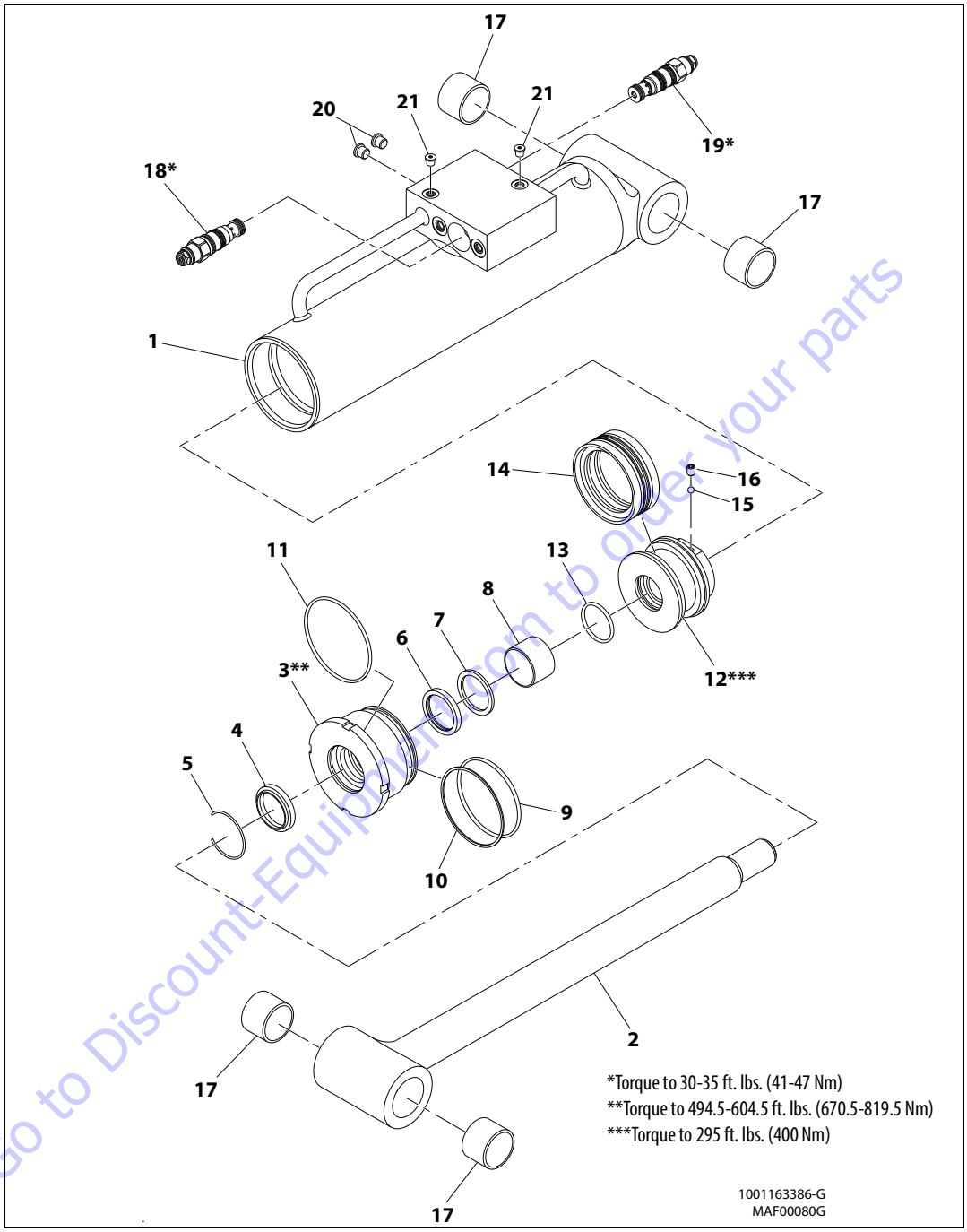


Figure 5-17. Cylinder Rod Support



1. Barrel
2. Rod
3. Head
4. Wiper Seal
5. Retaining Ring
6. Rod Seal
7. Backup Ring
8. Bearing
9. O-ring
10. Backup Ring
11. O-ring
12. Piston
13. O-ring
14. Piston Seal
15. Ball
16. Setscrew
17. Bushing
18. Counterbalance Valve
19. Counterbalance Valve
20. Plug
21. Plug

Figure 5-18. Platform Level Cylinder

8. Using suitable protection, clamp the cylinder rod in a vise or similar holding fixture as close to the piston as possible.
9. Loosen and remove the setscrew and ball which attaches the piston to the rod.
10. Screw the piston counterclockwise and remove the piston from cylinder rod.
11. Remove and discard the piston seal and o-ring.
12. Remove the rod from the holding fixture. Remove the cylinder head. Discard the o-rings, backup ring, rod seal, bearing, retaining ring and wiper seal.

CLEANING AND INSPECTION

1. Clean all parts thoroughly in an approved cleaning solvent.
2. Inspect the cylinder rod for scoring, tapering, ovality, or other damage. If necessary, dress rod with Scotch Briteor equivalent. Replace rod if necessary.
3. Inspect threaded portion of rod for excessive damage. Dress threads as necessary.
4. Inspect inner surface of cylinder barrel tube for scoring or other damage. Check inside diameter for tapering or ovality. Replace if necessary.
5. Inspect threaded portion of barrel for damage. Dress threads as necessary.
6. Inspect piston surface for damage and scoring and for distortion. Dress piston surface or replace piston as necessary.
7. Inspect threaded portion of piston for damage. Dress threads as necessary.
8. Inspect seal and o-ring grooves in piston for burrs and sharp edges. Dress applicable surfaces as necessary.
9. Inspect cylinder head inside diameter for scoring, tapering, ovality or other damage. Replace if necessary.
10. Inspect threaded portion of head for damage. Dress threads as necessary.
11. Inspect seal and o-ring grooves in head for burrs and sharp edges. Dress applicable surfaces as necessary.
12. Inspect cylinder head outside diameter for scoring, tapering, ovality or other damage. Replace if necessary.
13. If applicable, inspect rod and barrel bearings for signs of correct excessive wear or damage. Replace as necessary.
    a. Thoroughly clean hole (steel bushing) of burrs, dirt etc. to facilitate bearing installation.
    b. Inspect steel bushing for wear or other damage. If steel bushing is worn or damaged, rod/barrel must be replaced.
    c. Lubricate inner side of steel bushing prior to bearing installation.
    d. Using an arbor of the correct size, carefully press the bearing into steel bushing.

NOTE: *Install pin into the composite bearing dry. Lubrication is not required with nickel plated pins and bearings.*

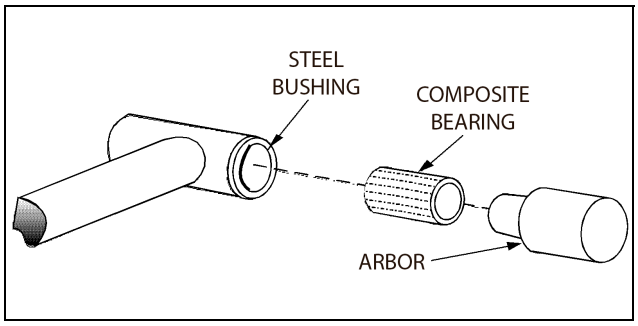


Figure 5-19. Composite Bearing Installation

14. Inspect port block fittings and holding valve. Replace if necessary.
15. Inspect the oil ports for blockage or the presence of dirt or other foreign material. Repair if necessary.
16. Inspect piston rings for cracks or other damage. Replace if necessary.

ASSEMBLY

NOTE: *Prior to cylinder assembly, ensure that the proper cylinder seal kit is used. See your JLG Parts Manual.*

NOTE: *Apply a light film of hydraulic oil to all components prior to assembly.*

1. A special tool is used to install a new rod seal into the applicable cylinder head groove.

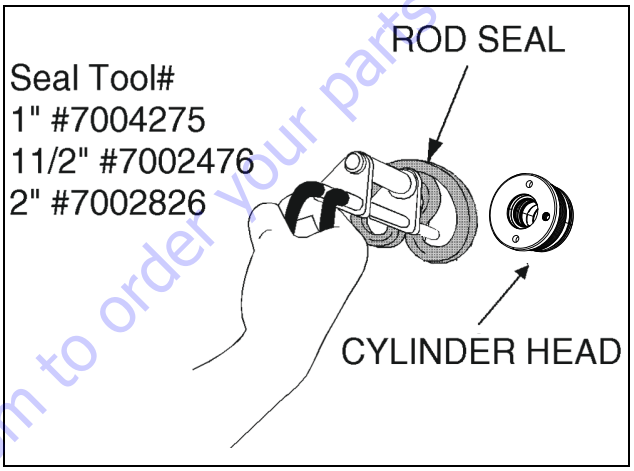


Figure 5-20. Rod Seal Installation

NOTICE

WHEN INSTALLING NEW SEALS, ENSURE SEALS ARE INSTALLED PROPERLY. IMPROPER SEAL INSTALLATION COULD RESULT IN CYLINDER LEAKAGE AND IMPROPER CYLINDER OPERATION.

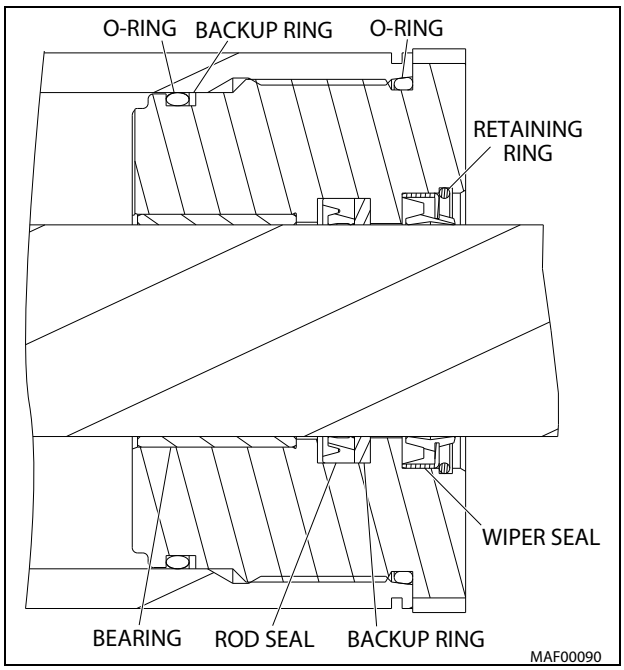


Figure 5-21. Cylinder Head Seal Installation

2. Use a soft mallet to tap a new wiper seal into the applicable cylinder head groove. Install a new retaining ring and bearing into the applicable inside diameter of the cylinder head groove.

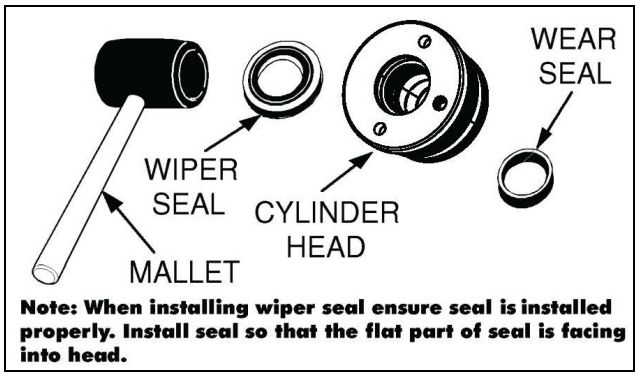


Figure 5-22. Wiper Seal Installation

3. Place a new o-rings and backup ring in the applicable outside diameter groove of the cylinder head.

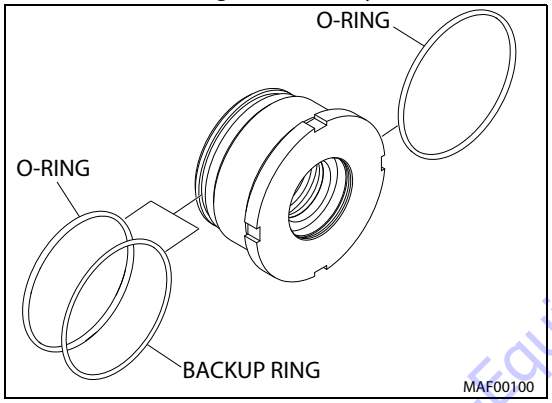


Figure 5-23. Installation of Head Seal Kit

4. Carefully install the cylinder head on the rod, ensuring that the wiper seal, retaining ring and rod seals are not damaged or dislodged. Torque the cylinder head to 494.5-604.5 ft. lbs. (670.5-819.5 Nm). Push the head along the rod to the rod end.

5. Using suitable protection, clamp the cylinder rod in a vise or similar holding fixture as close to piston as possible.

6. Place a new o-ring in the applicable inside diameter of the piston.

7. Carefully thread the piston on the cylinder rod, ensuring that the o-ring is not damaged or dislodged and hand tight. Torque the piston to 295 ft. lbs. (400 Nm). Secure using ball and setscrew.

8. Remove the cylinder rod from the holding fixture. Place new piston seal in the outer piston diameter groove. (A tube, with I.D. slightly larger than the O.D. of the piston is recommended to install the solid seal).

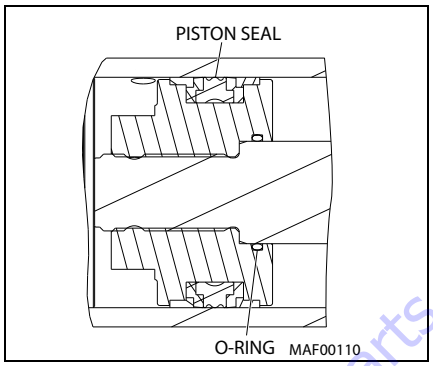


Figure 5-24. Piston Seal Kit Installation

9. Position the cylinder barrel in a suitable holding fixture.

NOTICE

EXTREME CARE SHOULD BE TAKEN WHEN INSTALLING THE CYLINDER ROD, HEAD AND PISTON. AVOID PULLING THE ROD OFF-CENTER, WHICH COULD CAUSE DAMAGE TO THE PISTON AND CYLINDER BARREL SURFACES.

10. With barrel clamped securely, and while adequately supporting the rod, insert the piston end into the barrel cylinder. Ensure that the piston loading piston seal are not damaged or dislodged.

11. Continue pushing the rod into the barrel until the cylinder head can be inserted into the cylinder barrel.

12. Screw the cylinder head into the barrel using a hook spanner wrench and torque cylinder head to 494.5-604.5 ft. lbs. (670.5-819.5 Nm).

13. Caulk at the machined area of the cylinder barrel end so that it locks the cylinder head in place and it does not unscrew from the barrel.

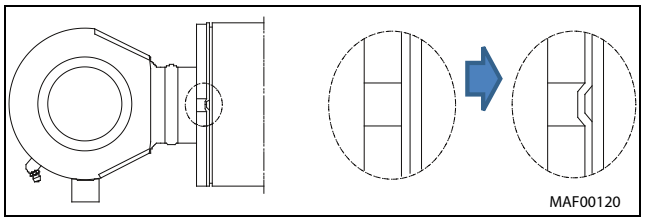


Figure 5-25. Caulking

14. After the cylinder has been reassembled, the rod should be pushed all the way in (fully retracted) prior to the reinstallation of any holding valve or valves.

15. Install the new o-rings and plugs into the cylinder port block. Install the counterbalance valves in the rod port block and torque to 30-35 ft. lbs. (41-47 Nm).

Jib Lift Cylinder (460SJ Only)

DISASSEMBLY

NOTICE

DISASSEMBLY OF THE CYLINDER SHOULD BE PERFORMED ON A CLEAN WORK SURFACE IN A DIRT FREE WORK AREA.

1. Connect a suitable auxiliary hydraulic power source to the cylinder port block fitting.

⚠ WARNING

DO NOT FULLY EXTEND CYLINDER TO THE END OF STROKE. RETRACT CYLINDER SLIGHTLY TO AVOID TRAPPING PRESSURE.

2. Operate the hydraulic power source and extend the cylinder. Shut down and disconnect the power source. Adequately support the cylinder rod, if applicable.
3. Remove the counterbalance holding valves and plugs from the cylinder port block. Discard o-rings.
4. Place the cylinder barrel into a suitable holding fixture.

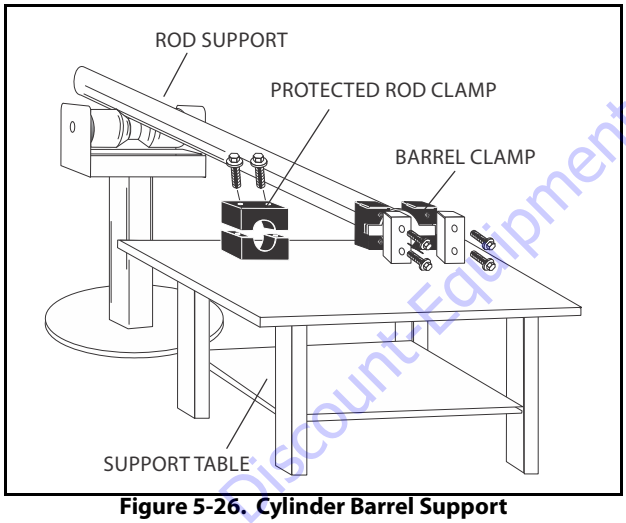


Figure 5-26. Cylinder Barrel Support

5. Mark cylinder head and barrel with a center punch for easy realignment. Using an allen wrench, loosen the cylinder head retainer capscrews and remove capscrews from cylinder barrel.

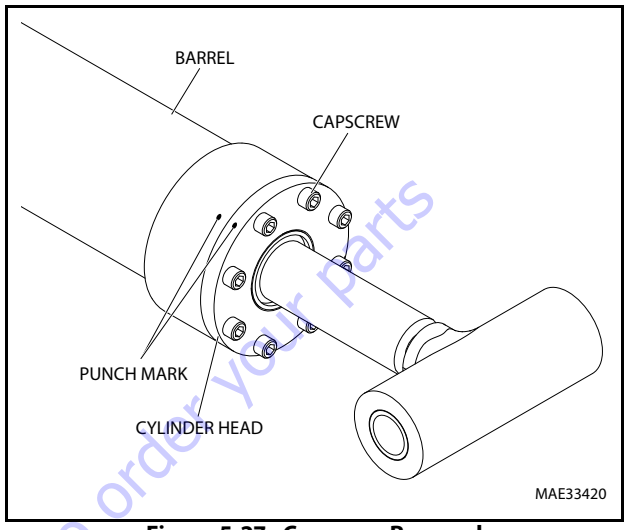


Figure 5-27. Capscrew Removal

6. Attach a suitable pulling device to the cylinder rod port block end or cylinder rod end, as applicable.

NOTICE

EXTREME CARE SHOULD BE TAKEN WHEN REMOVING THE CYLINDER ROD, HEAD AND PISTON. AVOID PULLING THE ROD OFF-CENTER, WHICH COULD CAUSE DAMAGE TO THE PISTON AND CYLINDER BARREL SURFACES.

7. With the barrel clamped securely, apply pressure to the rod pulling device and carefully withdraw the complete rod assembly from the cylinder barrel.

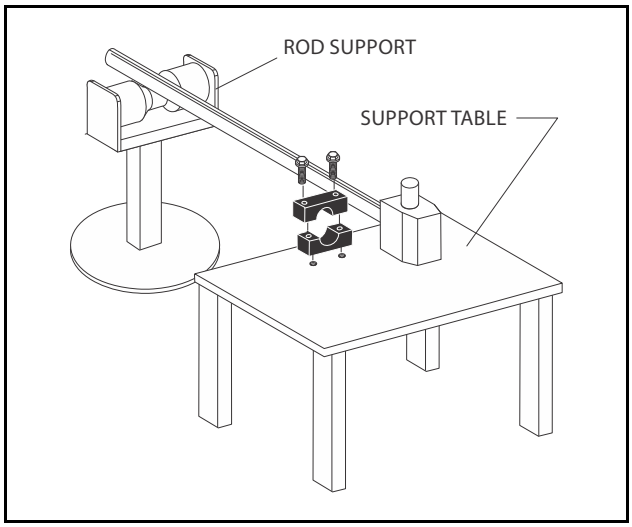
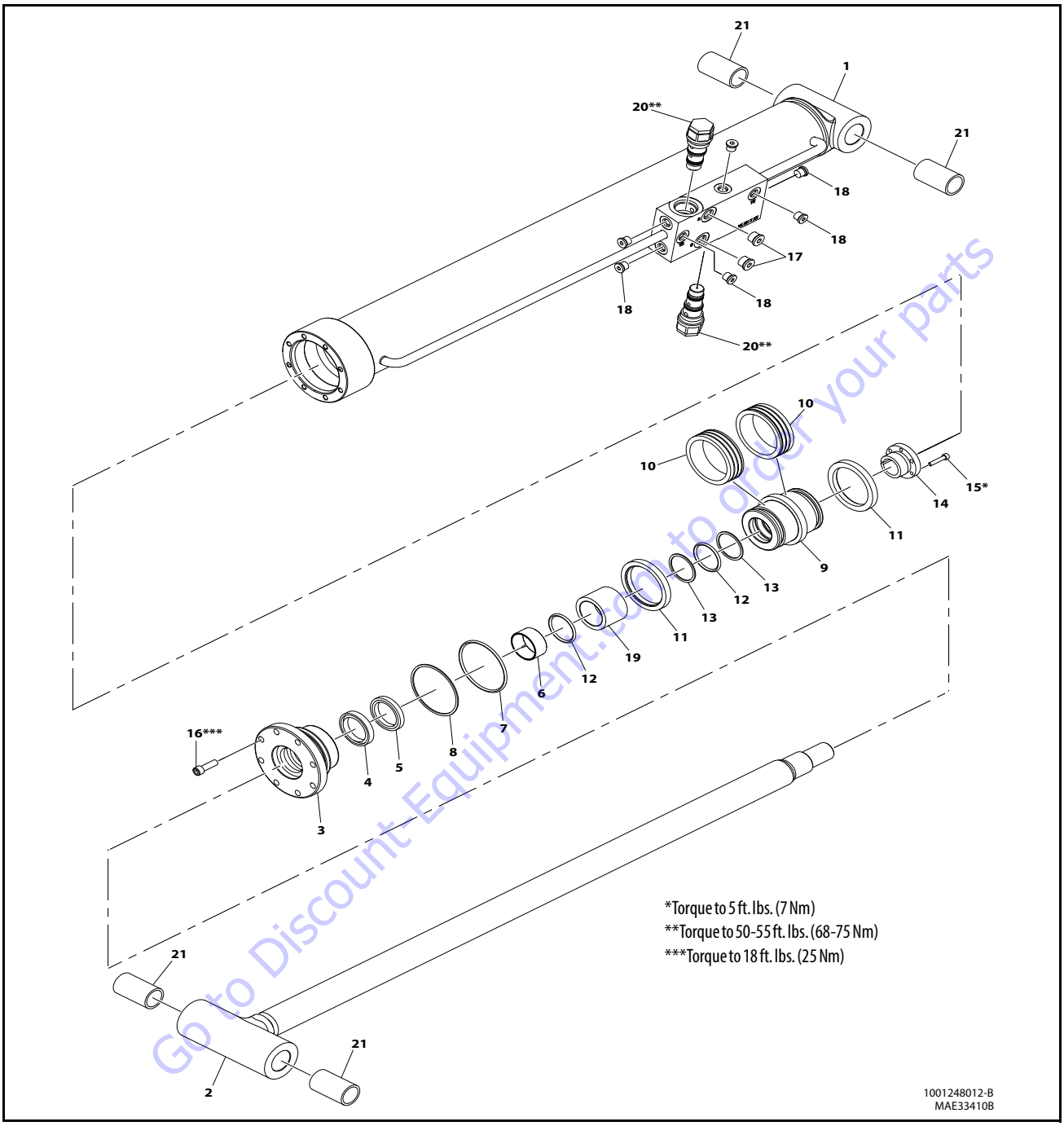


Figure 5-28. Cylinder Rod Support



1. Barrel
2. Rod
3. Head
4. Dust Wiper
5. Rod Seal
6. Wear Ring
7. O-ring
8. Backup Ring
9. Piston
10. Hydrolock Seal
11. Guidelock Ring
12. O-ring
13. Backup Ring
14. Tapered Bushing
15. Capscrew
16. Capscrew
17. Plug
18. Plug
19. Spacer
20. Counterbalance Valve
21. Bushing

Figure 5-29. Jib Lift Cylinder (460SJ Only)

8. Using suitable protection, clamp the cylinder rod in a vise or similar holding fixture as close to the piston as possible.
9. Remove capscrews from drilled holes.
10. Insert the capscrews in the threaded holes in the outer piece of the tapered bushing. Progressively tighten the capscrews until the bushing is loosen on the piston.
11. Remove the bushing from the piston.

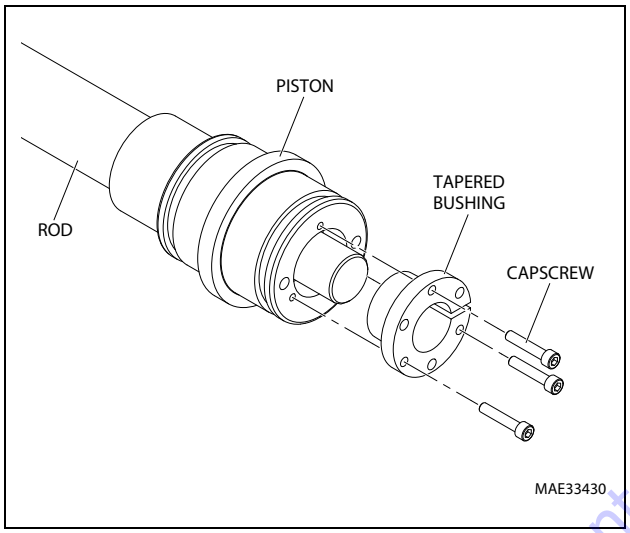


Figure 5-75. Tapered Bushing Removal

12. Screw the piston counterclockwise by hand and remove the piston from cylinder rod.
13. Remove and discard the piston o-rings, seal rings and backup rings.
14. Remove piston spacer from the rod.
15. Remove the rod from the holding fixture. Remove the cylinder head gland. Discard the o-rings, backup rings, rod seals, wear rings and wiper seals.

CLEANING AND INSPECTION

1. Clean all parts thoroughly in an approved cleaning solvent.
2. Inspect the cylinder rod for scoring, tapering, ovality or other damage. If necessary, dress rod with Scotch Brite or equivalent. Replace rod if necessary.
3. Inspect threaded portion of rod for excessive damage. Dress threads as necessary.
4. Inspect inner surface of cylinder barrel tube for scoring or other damage. Check inside diameter for tapering or ovality. Replace if necessary.
5. Inspect piston surface for damage and scoring and for distortion. Dress piston surface or replace piston as necessary.
6. Inspect threaded portion of piston for damage. Dress threads as necessary.
7. Inspect seal and o-ring grooves in piston for burrs and sharp edges. Dress applicable surfaces as necessary.
8. Inspect cylinder head inside diameter for scoring, tapering, ovality or other damage. Replace if necessary.
9. Inspect seal and o-ring grooves in head for burrs and sharp edges. Dress applicable surfaces as necessary.
10. Inspect cylinder head outside diameter for scoring, tapering, ovality or other damage. Replace if necessary.
11. Inspect rod and barrel bearings for signs of correct excessive wear or damage. Replace if necessary.
    a. Thoroughly clean hole, (steel bushing) of burrs, dirt etc. to facilitate bearing installation.
    b. Inspect steel bushing for wear or other damage. If steel bushing is worn or damaged, rod/barrel must be replaced.
    c. Lubricate inner side of steel bushing prior to bearing installation.
    d. Using an arbor of the correct size, carefully press the bearing into steel bushing.

NOTE: *Install pin into the composite bearing dry. Lubrication is not required with nickel plated pins and bearings.*

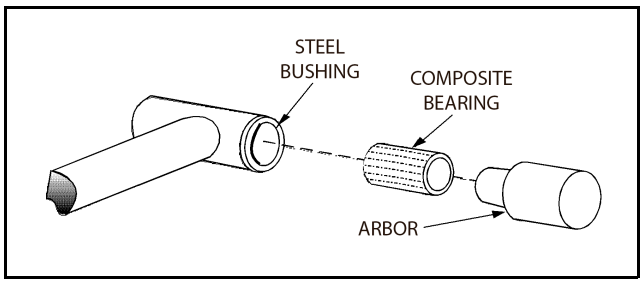


Figure 5-76. Composite Bearing Installation

12. If applicable, inspect port block fittings and holding valve. Replace if necessary.
13. Inspect the oil ports for blockage or the presence of dirt or other foreign material. Repair if necessary.
14. If applicable, inspect piston rings for cracks or other damage. Replace if necessary.

ASSEMBLY

NOTE: *Prior to cylinder assembly, ensure that the proper cylinder seal kit is used. See your JLG Parts Manual.*

NOTE: *Apply a light film of hydraulic oil to all components prior to assembly.*

1. A special tool is used to install a new rod seal into the applicable cylinder head gland groove.

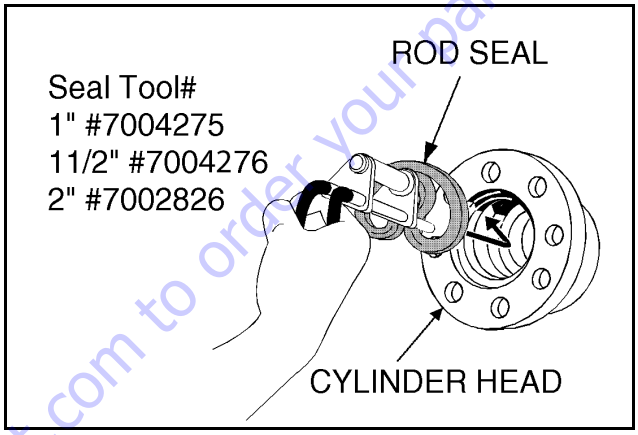


Figure 5-77. Rod Seal Installation

NOTICE

WHEN INSTALLING NEW SEALS, ENSURE SEALS ARE INSTALLED PROPERLY. IMPROPER SEAL INSTALLATION COULD RESULT IN CYLINDER LEAKAGE AND IMPROPER CYLINDER OPERATION.

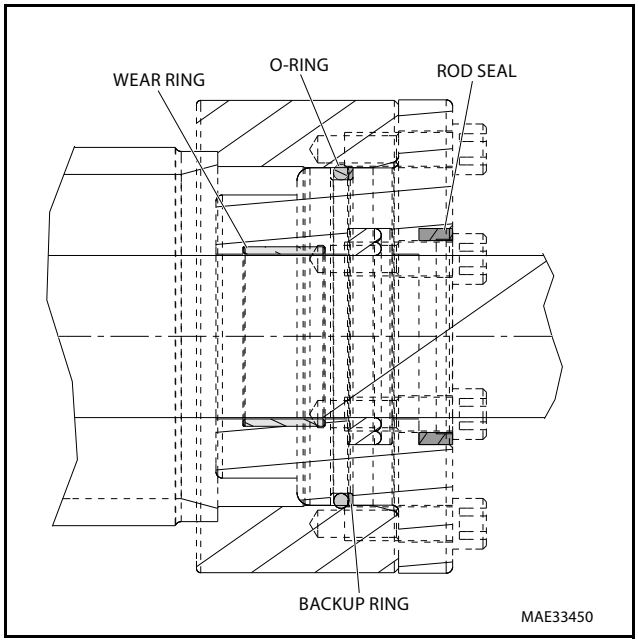


Figure 5-78. Cylinder Head Seal Installation

2. Use a soft mallet to tap a new wiper seal into the applicable cylinder head gland groove. Install a new wear ring into the applicable cylinder head gland groove.

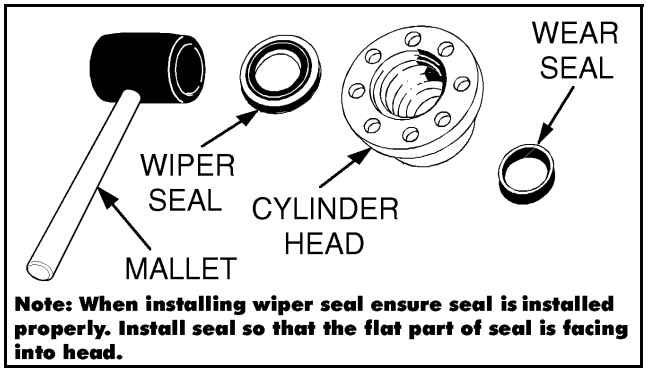


Figure 5-79. Wiper Seal Installation

3. Place a new o-ring and backup seal in the applicable outside diameter groove of the cylinder head.

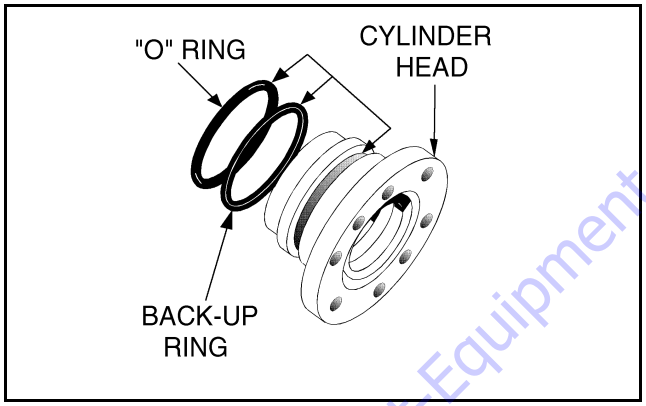


Figure 5-80. Installation of Head Seal Kit

4. Carefully install the head gland on the rod, ensuring that the wiper and rod seals are not damaged or dislodged. Push the head along the rod to the rod end, as applicable.

5. Carefully slide the piston spacer on the rod.

6. Using suitable protection, clamp the cylinder rod in a vise or similar holding fixture as close to piston as possible.

7. Place a new o-ring and backup rings in the inner piston diameter groove.

8. Carefully thread the piston on the cylinder rod hand tight, ensuring that the o-ring and backup rings are not damaged or dislodged.

9. Thread piston onto rod end and install the tapered bushing.

NOTE: *When installing the tapered bushing, piston and mating end of rod must be free of oil.*

10. Assemble the tapered bushing loosely into the piston and insert capscrews through the drilled holes in the bushing and into the tapped holes in the piston.

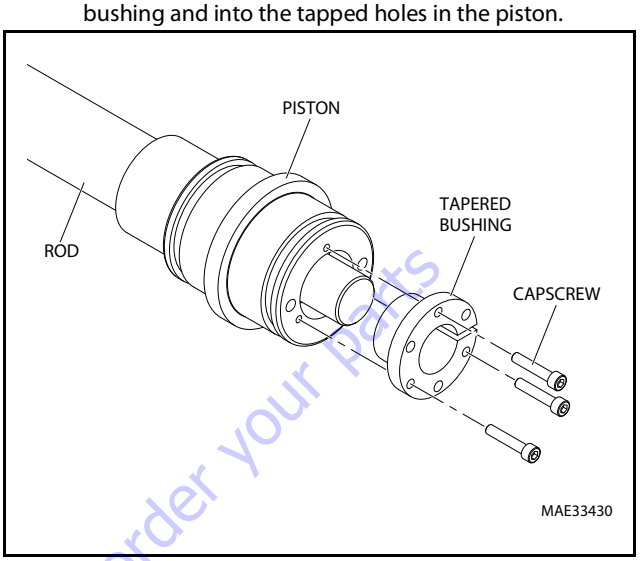


Figure 5-81. Tapered Bushing Installation

11. Tighten the capscrews evenly and progressively in rotation to 5 ft. lbs. (7 Nm).

12. After the screws have been torqued, tap the tapered bushing with a hammer (16 to 24 oz.) and brass shaft (approximately 3/4 in. diameter) as follows:

    a. Place the shaft against the cylinder rod and in contact with the bushing in the spaces between the capscrews.

    b. Tap each space once; this means the tapered bushing is tapped 3 times as there are 3 spaces between the capscrews.

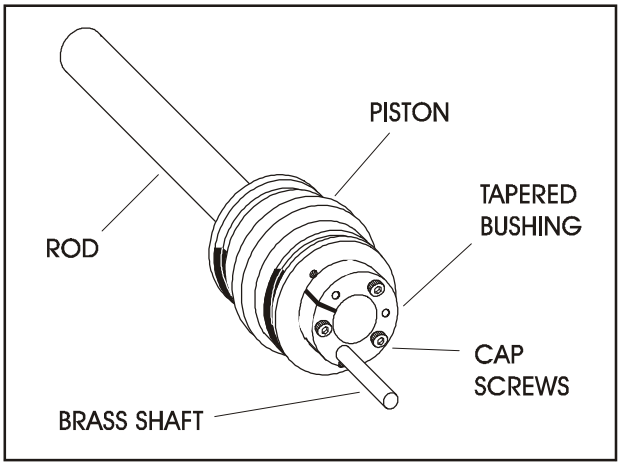


Figure 5-82. Seating the Tapered Bearing

13. Rotate the capscrews evenly and progressively in rotation to 5 ft. lbs. (7 Nm).

14. Remove the cylinder rod from the holding fixture.

NOTICE

WHEN INSTALLING HYDROLOCK PISTON SEALS, ENSURE SEALS ARE INSTALLED PROPERLY. REFER TO HYDROLOCKK PISTON SEAL INSTALLATION FOR CORRECT SEAL ORIENTATION. IMPROPER SEAL INSTALLATION COULD RESULT IN CYLINDER LEAKAGE AND IMPROPER CYLINDER OPERATION.

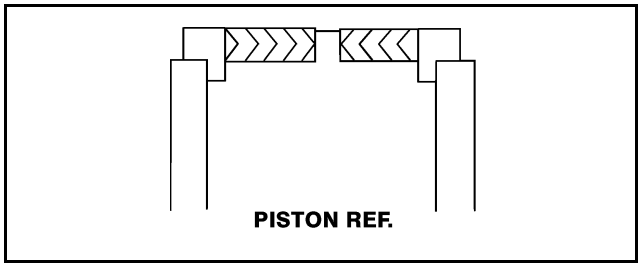


Figure 5-83. Hydrolock Piston Seal Installation

15. Place new hydrolock seal and guidelock rings in the outer piston diameter groove. (A tube, with I.D. slightly larger than the O.D. of the piston is recommended to install the solid seal).

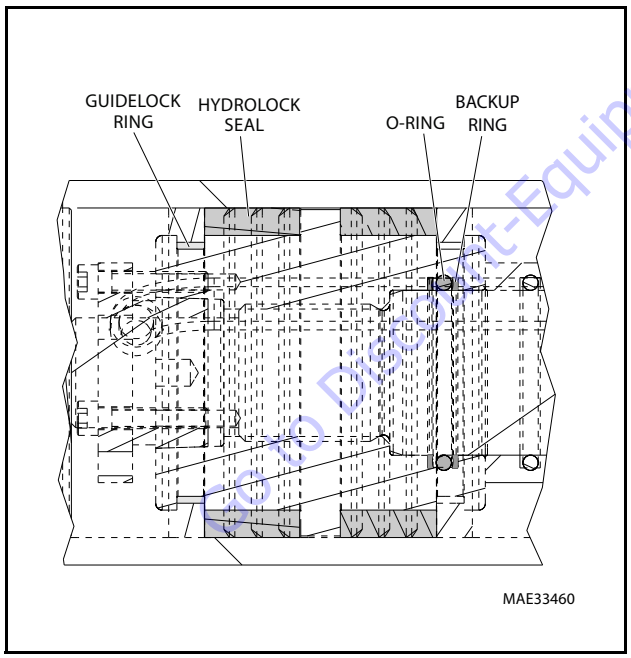


Figure 5-84. Piston Seal Kit Installation

16. Position the cylinder barrel in a suitable holding fixture.

NOTICE

EXTREME CARE SHOULD BE TAKEN WHEN INSTALLING THE CYLINDER ROD, HEAD, AND PISTON. AVOID PULLING THE ROD OFF-CENTER, WHICH COULD CAUSE DAMAGE TO THE PISTON AND CYLINDER BARREL SURFACES.

17. With barrel clamped secured and adequately supporting the rod, insert the piston end into the barrel cylinder. Ensure that the piston loading o-ring and seal ring are not damaged or dislodged.

18. Continue pushing the rod into the barrel until the cylinder head gland can be inserted into the barrel cylinder.

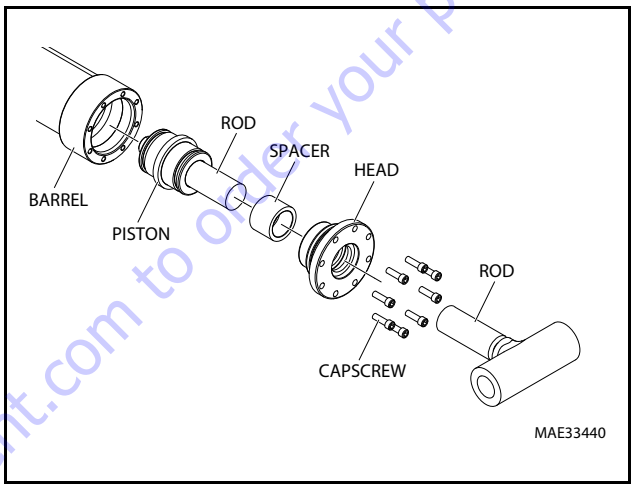


Figure 5-85. Rod Assembly Installation

19. Secure the cylinder head gland using the capscrews. Torque capscrews to 18 ft. lbs. (25 Nm).

20. After the cylinder has been reassembled, the rod should be pushed all the way in (fully retracted) prior to the reinstallation of any holding valve or valves.

21. If applicable, install the cartridge-type holding valve and fittings in the rod port block, using new o-rings as applicable. Torque valves to 50-55 ft. lbs. (68-75 Nm).

Main Lift Cylinder

DISASSEMBLY

NOTICE

DISASSEMBLY OF THE CYLINDER SHOULD BE PERFORMED ON A CLEAN WORK SURFACE IN A DIRT FREE WORK AREA.

1. Connect a suitable auxiliary hydraulic power source to the cylinder port block fitting.

⚠ WARNING

DO NOT FULLY EXTEND CYLINDER TO THE END OF STROKE. RETRACT CYLINDER SLIGHTLY TO AVOID TRAPPING PRESSURE.

2. Operate the hydraulic power source and extend the cylinder. Shut down and disconnect the power source. Adequately support the cylinder rod, if applicable.
3. Remove the check valve, cartridge valves, orifice plug and plugs from the cylinder port block. Discard o-rings.
4. Place the cylinder barrel into a suitable holding fixture.

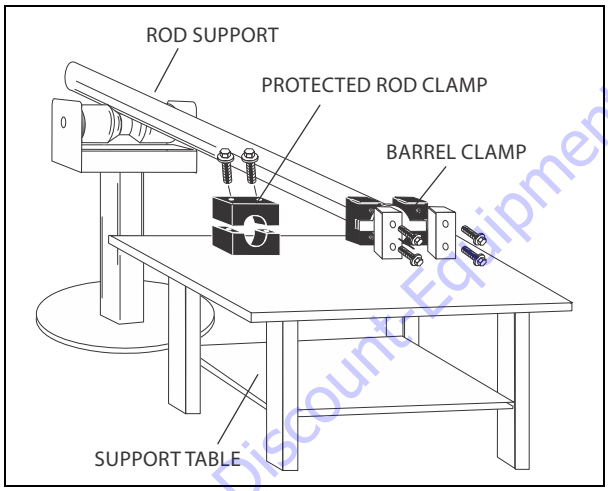


Figure 5-86. Cylinder Barrel Support

5. Mark cylinder head and barrel with a center punch for easy realignment. Using a hook wrench, unscrew the cylinder head from the barrel.

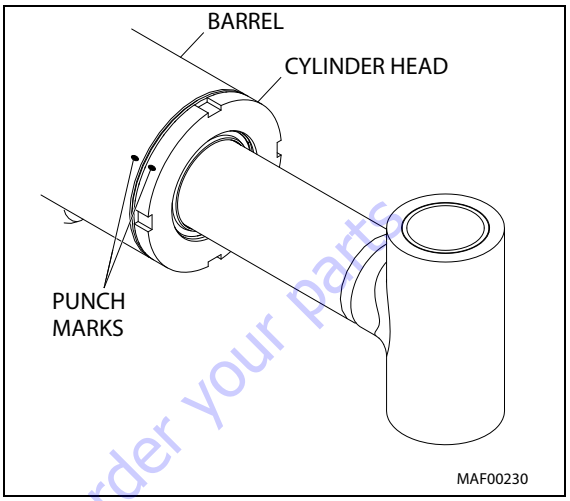


Figure 5-87. Cylinder Head Removal

6. Attach a suitable pulling device to the cylinder rod port block end or cylinder rod end, as applicable.

NOTICE

EXTREME CARE SHOULD BE TAKEN WHEN REMOVING THE CYLINDER ROD, HEAD AND PISTON. AVOID PULLING THE ROD OFF-CENTER, WHICH COULD CAUSE DAMAGE TO THE PISTON AND CYLINDER BARREL SURFACES.

7. With the barrel clamped securely, apply pressure to the rod pulling device and carefully withdraw the complete rod assembly from the cylinder barrel.

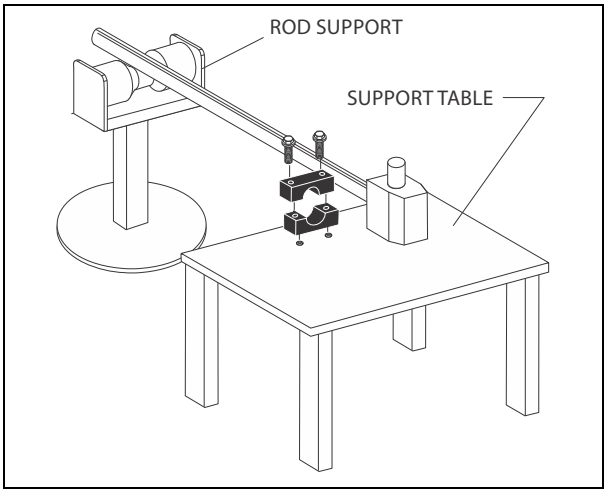
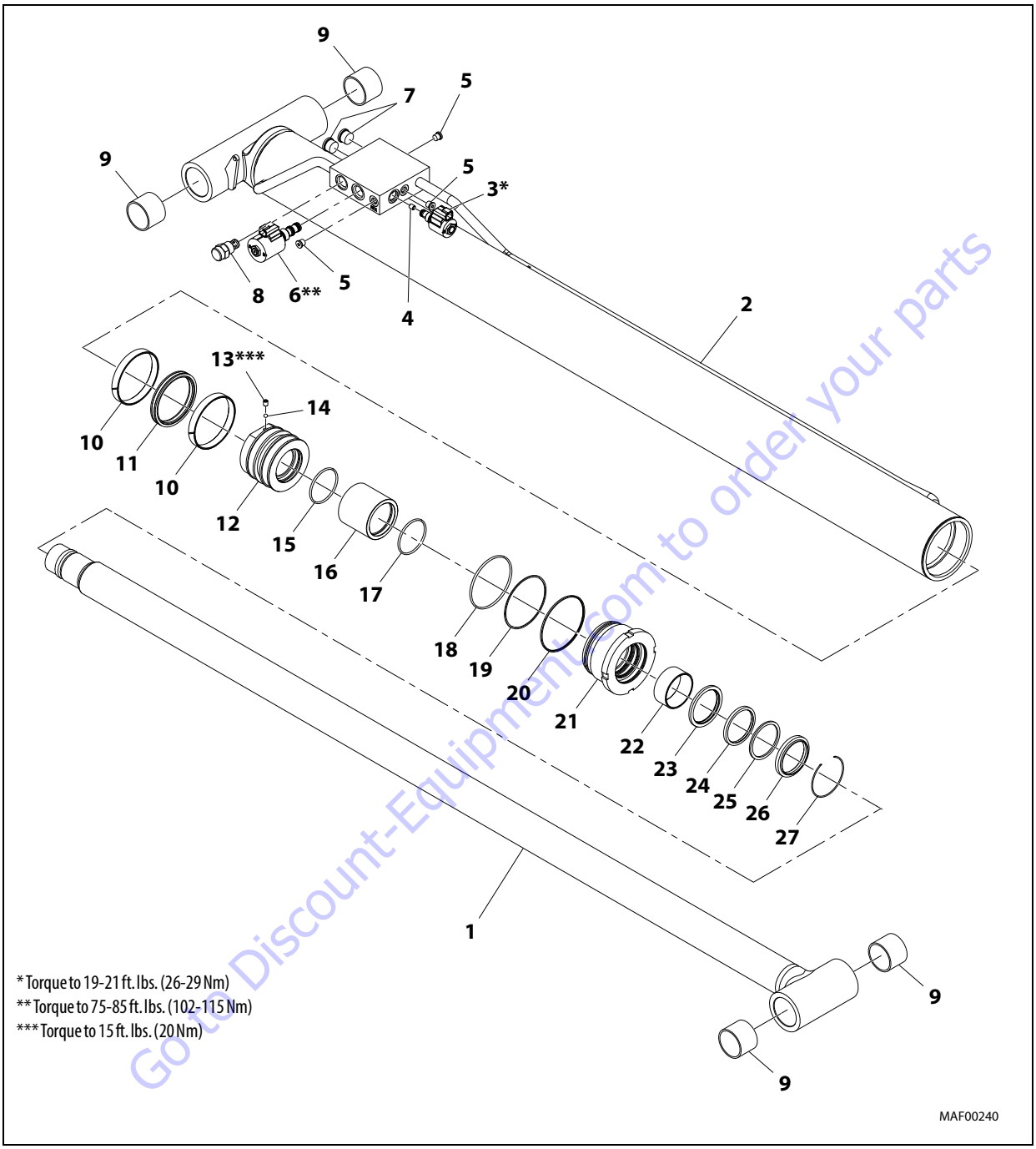


Figure 5-88. Cylinder Rod Support



1. Rod
2. Barrel
3. Cartridge Valve
4. Orifice Plug
5. Plug
6. Cartridge Valve
7. Plug
8. Check Valve
9. Bushing
10. Wear Ring
11. Piston Seal
12. Piston
13. Setscrew
14. Ball
15. O-ring
16. Spacer
17. O-ring
18. O-ring
19. Backup Ring
20. O-ring
21. Cylinder Head
22. Bearing
23. Buffer Ring
24. Rod Seal
25. Backup Ring
26. Wiper Seal
27. Retaining Ring

Figure 5-89. Main Lift Cylinder

8. Using suitable protection, clamp the cylinder rod in a vise or similar holding fixture as close to the piston as possible.
9. Loosen and remove the setscrew which attaches the piston to the rod.
10. Screw the piston counterclockwise by hand, and remove the piston from cylinder rod.
11. Remove and discard the piston o-ring, wear rings, and piston seal.
12. Remove piston spacer from the rod. Remove and discard the o-ring from the spacer.
13. Remove the rod from the holding fixture. Remove the cylinder head. Discard the o-rings, backup rings, rod seal, bearing, buffer seal and wiper seal.

CLEANING AND INSPECTION

1. Clean all parts thoroughly in an approved cleaning solvent.
2. Inspect the cylinder rod for scoring, tapering, ovality, or other damage. If necessary, dress rod with Scotch Brite or equivalent. Replace rod if necessary.
3. Inspect threaded portion of rod for excessive damage. Dress threads as necessary.
4. Inspect inner surface of cylinder barrel tube for scoring or other damage. Check inside diameter for tapering or ovality. Replace if necessary.
5. Inspect threaded portion of barrel for damage. Dress threads as necessary.
6. Inspect piston surface for damage and scoring and for distortion. Dress piston surface or replace piston as necessary.
7. Inspect threaded portion of piston for damage. Dress threads as necessary.
8. Inspect seal and o-ring grooves in piston for burrs and sharp edges. Dress applicable surfaces as necessary.
9. Inspect cylinder head inside diameter for scoring, tapering, ovality or other damage. Replace if necessary.
10. Inspect threaded portion of head for damage. Dress threads as necessary.
11. Inspect seal and o-ring grooves in head for burrs and sharp edges. Dress applicable surfaces as necessary.
12. Inspect cylinder head outside diameter for scoring, tapering, ovality or other damage. Replace if necessary.
13. If applicable, inspect rod and barrel bearings for signs of correct excessive wear or damage. Replace if necessary.
    a. Thoroughly clean hole (steel bushing) of burrs, dirt etc. to facilitate bearing installation.
    b. Inspect steel bushing for wear or other damage. If steel bushing is worn or damaged, rod/barrel must be replaced.
    c. Lubricate inner side of steel bushing prior to bearing installation.
    d. Using an arbor of the correct size, carefully press the bearing into steel bushing.

NOTE: *Install pin into the composite bearing dry. Lubrication is not required with nickel plated pins and bearings.*

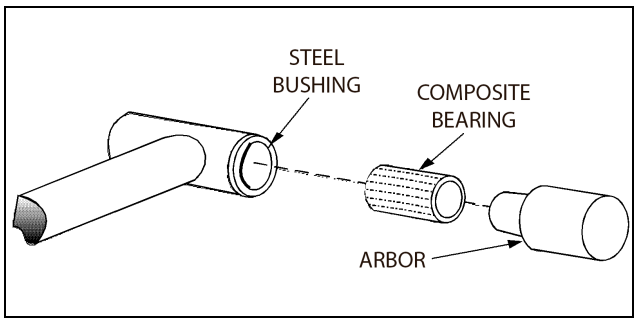


Figure 5-90. Composite Bearing Installation

14. Inspect spacer for burrs and sharp edges. If necessary, dress inside diameter surface with Scotch Brite or equivalent.
15. Inspect port block fittings and holding valve. Replace if necessary.
16. Inspect the oil ports for blockage or the presence of dirt or other foreign material. Repair if necessary.
17. Inspect piston rings for cracks or other damage. Replace if necessary.

ASSEMBLY

NOTE: *Prior to cylinder assembly, ensure that the proper cylinder seal kit is used. See your JLG Parts Manual.*

NOTE: *Apply a light film of hydraulic oil to all components prior to assembly.*

1. A special tool is used to install a new rod seal into the applicable cylinder head groove.

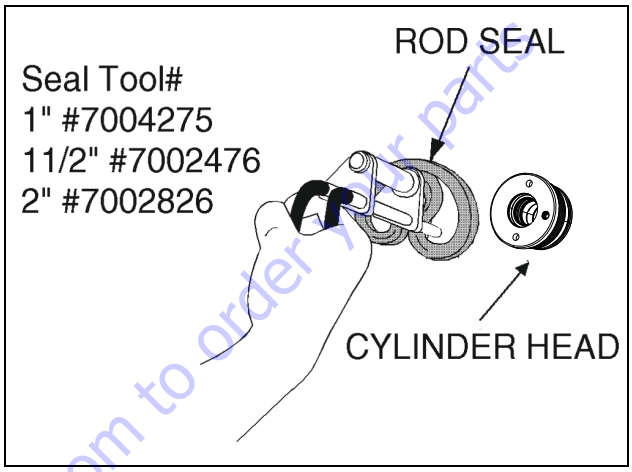


Figure 5-91. Rod Seal Installation

NOTICE

WHEN INSTALLING NEW SEALS, ENSURE SEALS ARE INSTALLED PROPERLY. IMPROPER SEAL INSTALLATION COULD RESULT IN CYLINDER LEAKAGE AND IMPROPER CYLINDER OPERATION.

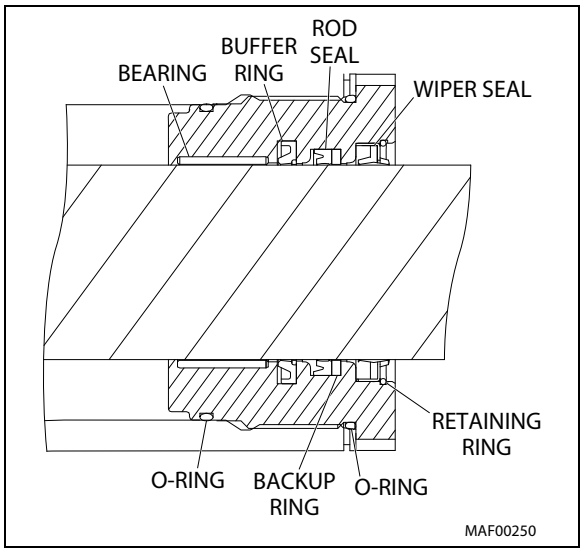


Figure 5-92. Cylinder Head Seal Installation

2. Use a soft mallet to tap a new wiper seal into the applicable cylinder head groove. Install new bearing, buffer ring, backup ring and retaining ring into the applicable inside diameter of the cylinder head groove.

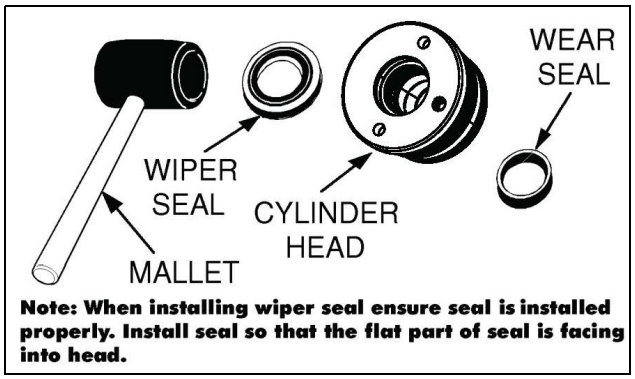


Figure 5-93. Wiper Seal Installation

3. Place new o-rings and backup ring in the applicable outside diameter groove of the cylinder head.

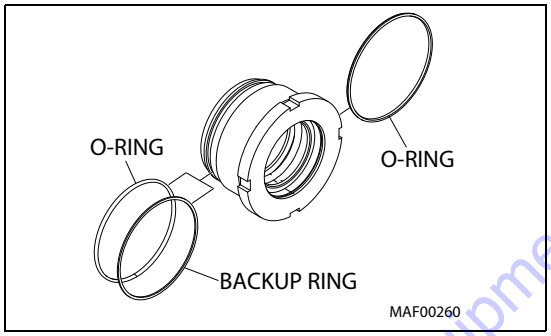


Figure 5-94. Installation of Head Seal Kit

4. Carefully install the cylinder head on the rod, ensuring that the wiper seal, backup ring, retaining ring and rod seals are not damaged or dislodged. Push the head along the rod to the rod end, as applicable.

5. Using suitable protection, clamp the cylinder rod in a vise or similar holding fixture as close to piston as possible.

6. Place a new o-ring in the inside diameter groove of spacer. Install the spacer tube onto the cylinder rod.

7. Carefully thread the piston on the cylinder rod, hand tight, ensuring that the o-ring and backup rings are not damaged or dislodged. Secure using setscrew and ball. Torque setscrew to 15 ft. lbs. (20 Nm).

8. Remove the cylinder rod from the holding fixture.

9. Place new wear rings and piston seal in the outer piston diameter groove. (A tube, with I.D. slightly larger than the O.D. of the piston is recommended to install the solid seal).

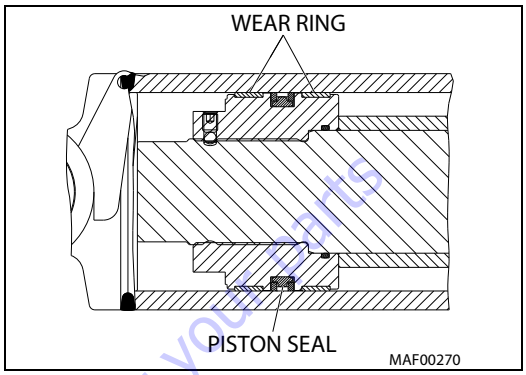


Figure 5-95. Piston Seal Kit Installation

10. Position the cylinder barrel in a suitable holding fixture.

NOTICE

EXTREME CARE SHOULD BE TAKEN WHEN INSTALLING THE CYLINDER ROD, HEAD AND PISTON. AVOID PULLING THE ROD OFF-CENTER, WHICH COULD CAUSE DAMAGE TO THE PISTON AND CYLINDER BARREL SURFACES.

11. With barrel clamped securely, and while adequately supporting the rod, insert the piston end into the barrel cylinder. Ensure that the piston loading wear rings and piston seal are not damaged or dislodged.

12. Continue pushing the rod into the barrel until the cylinder head can be inserted into the barrel cylinder.

13. Screw the cylinder head into the barrel using a hook wrench and torque the cylinder head.

14. Caulk at the machined area of the cylinder barrel end so that it locks the cylinder head in place and it does not unscrew from the barrel.

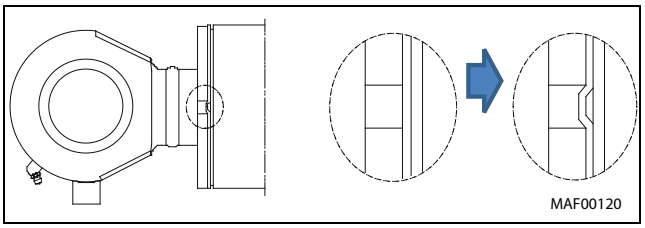


Figure 5-96. Caulking

15. Install the new o-rings, plugs, check valve, cartridge valves, pressure compensator valve and orifice plug in the cylinder port block. Torque as per values shown in Figure 5-89.

Master Cylinder

DISASSEMBLY

NOTICE

DISASSEMBLY OF THE CYLINDER SHOULD BE PERFORMED ON A CLEAN WORK SURFACE IN A DIRT FREE WORK AREA.

1. Connect a suitable auxiliary hydraulic power source to the cylinder port block fitting.

⚠ WARNING

DO NOT FULLY EXTEND CYLINDER TO THE END OF STROKE. RETRACT CYLINDER SLIGHTLY TO AVOID TRAPPING PRESSURE.

2. Operate the hydraulic power source and extend the cylinder. Shut down and disconnect the power source. Adequately support the cylinder rod, if applicable.
3. Remove the plugs from the cylinder ports.
4. Place the cylinder barrel into a suitable holding fixture.

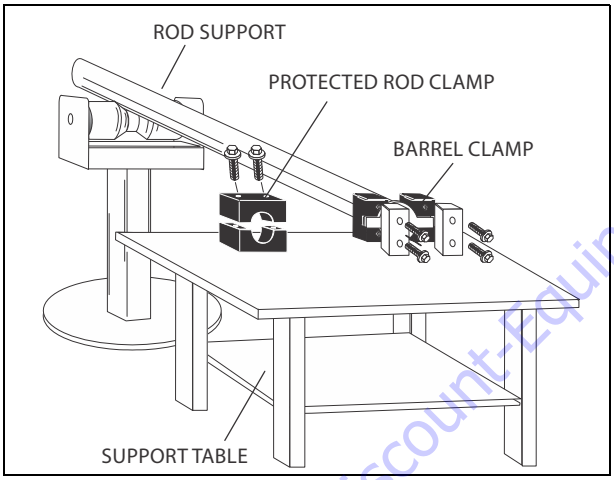


Figure 5-97. Cylinder Barrel Support

5. Mark cylinder head and barrel with a center punch for easy realignment. Using a hook spanner wrench, unscrew the cylinder head from the barrel.

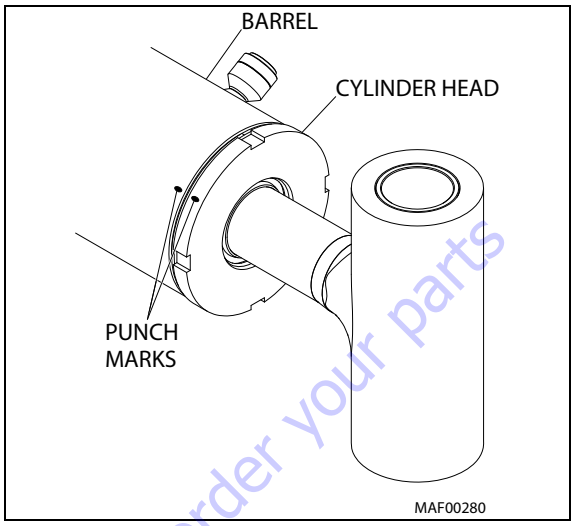


Figure 5-98. Cylinder Head Removal

6. Attach a suitable pulling device to the cylinder rod port block end or cylinder rod end, as applicable.

NOTICE

EXTREME CARE SHOULD BE TAKEN WHEN REMOVING THE CYLINDER ROD, HEAD AND PISTON. AVOID PULLING THE ROD OFF-CENTER, WHICH COULD CAUSE DAMAGE TO THE PISTON AND CYLINDER BARREL SURFACES.

7. With the barrel clamped securely, apply pressure to the rod pulling device and carefully withdraw the complete rod assembly from the cylinder barrel.

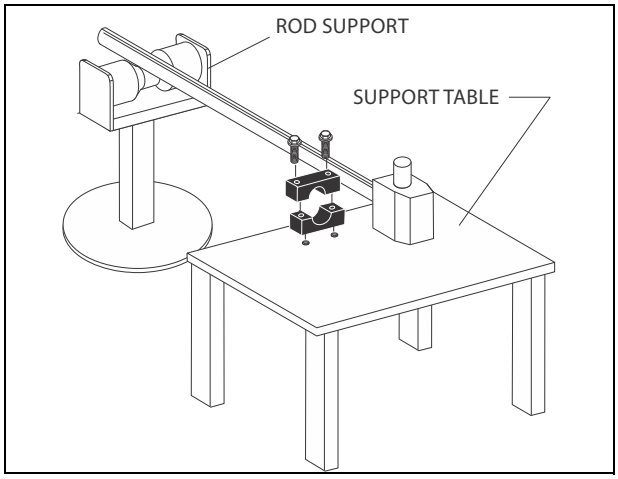
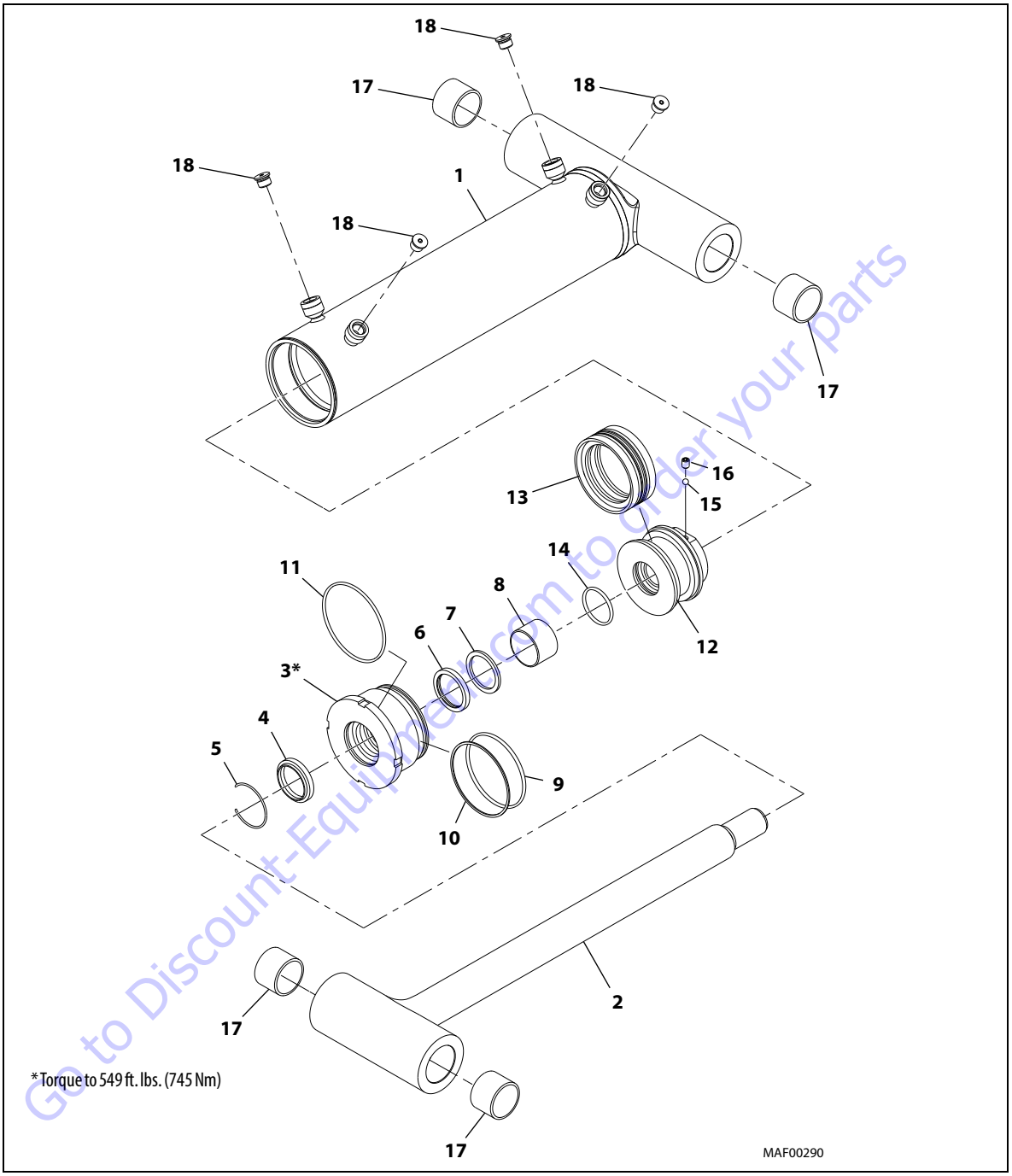


Figure 5-99. Cylinder Barrel Support



1. Barrel
2. Rod
3. Cylinder Head
4. Wiper Seal
5. Retaining Ring
6. Rod Seal
7. Backup Ring
8. Bearing
9. O-ring
10. Backup Ring
11. O-ring
12. Piston
13. Piston Seal
14. O-ring
15. Ball
16. Setscrew
17. Bushing
18. Bushing

Figure 5-100. Master Cylinder

8. Using suitable protection, clamp the cylinder rod in a vise or similar holding fixture as close to the piston as possible.
9. Loosen and remove the setscrew and ball which attaches the piston to the rod.
10. Screw the piston counterclockwise, by hand, and remove the piston from cylinder rod.
11. Remove and discard the piston seal and o-ring.
12. Remove the rod from the holding fixture. Remove the cylinder head. Discard the o-rings, backup rings, rod seal, bearing, retaining ring, and wiper seal.

CLEANING AND INSPECTION

1. Clean all parts thoroughly in an approved cleaning solvent.
2. Inspect the cylinder rod for scoring, tapering, ovality or other damage. If necessary, dress rod with Scotch Brite or equivalent. Replace rod if necessary.
3. Inspect threaded portion of rod for excessive damage. Dress threads as necessary.
4. Inspect inner surface of cylinder barrel tube for scoring or other damage. Check inside diameter for tapering or ovality. Replace if necessary.
5. Inspect threaded portion of barrel for damage. Dress threads as necessary.
6. Inspect piston surface for damage and scoring and for distortion. Dress piston surface or replace piston as necessary.
7. Inspect threaded portion of piston for damage. Dress threads as necessary.
8. Inspect seal and o-ring grooves in piston for burrs and sharp edges. Dress applicable surfaces as necessary.
9. Inspect cylinder head inside diameter for scoring, tapering, ovality or other damage. Replace if necessary.
10. Inspect threaded portion of head for damage. Dress threads as necessary.
11. Inspect seal and o-ring grooves in head for burrs and sharp edges. Dress applicable surfaces as necessary.
12. Inspect cylinder head outside diameter for scoring, tapering or ovality other damage. Replace if necessary.
13. If applicable, inspect rod and barrel bearings for signs of correct excessive wear or damage. Replace if necessary.
    a. Thoroughly clean hole (steel bushing) of burrs, dirt etc. to facilitate bearing installation.
    b. Inspect steel bushing for wear or other damage. If steel bushing is worn or damaged, rod/barrel must be replaced.
    c. Lubricate inner side of steel bushing prior to bearing installation.
    d. Using an arbor of the correct size, carefully press the bearing into steel bushing.

NOTE: *Install pin into the composite bearing dry. Lubrication is not required with nickel plated pins and bearings.*

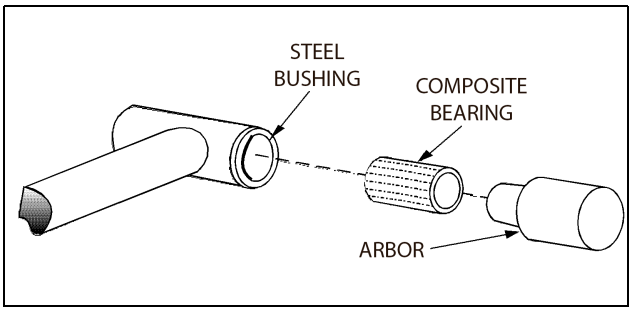


Figure 5-101. Composite Bearing Installation

14. Inspect the oil ports for blockage or the presence of dirt or other foreign material. Repair as necessary.

15. Inspect piston rings for cracks or other damage. Replace if necessary.

ASSEMBLY

NOTE: *Prior to cylinder assembly, ensure that the proper cylinder seal kit is used. See the respective JLG Parts Manual.*

NOTE: *Apply a light film of hydraulic oil to all components prior to assembly.*

1. A special tool is used to install a new rod seal into the applicable cylinder head groove.

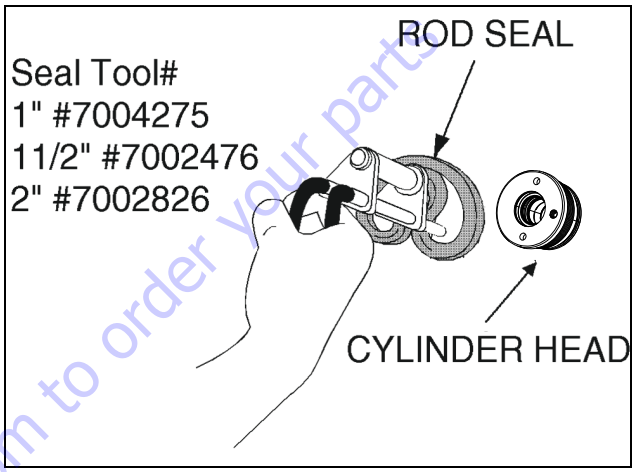


Figure 5-102. Rod Seal Installation

NOTICE

WHEN INSTALLING NEW SEALS, ENSURE SEALS ARE INSTALLED PROPERLY. IMPROPER SEAL INSTALLATION COULD RESULT IN CYLINDER LEAKAGE AND IMPROPER CYLINDER OPERATION.

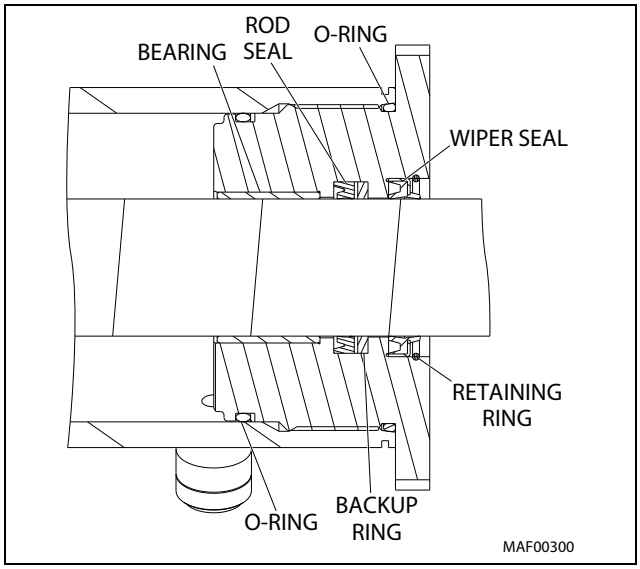


Figure 5-103. Cylinder Head Seal Installation

2. Use a soft mallet to tap a new wiper seal into the applicable cylinder head groove. Install a new retaining ring and bearing into the applicable inside diameter of the cylinder head groove.

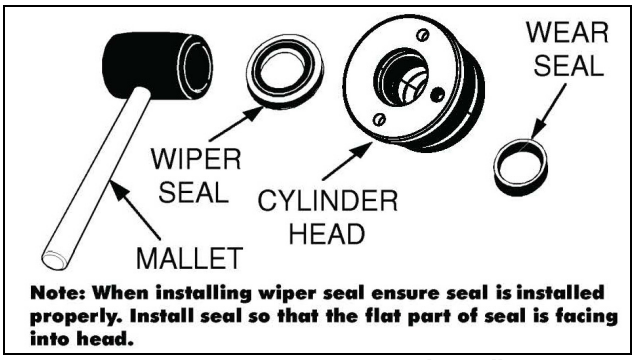


Figure 5-104. Wiper Seal Installation

3. Place new o-rings and backup ring in the applicable outside diameter groove of the cylinder head.

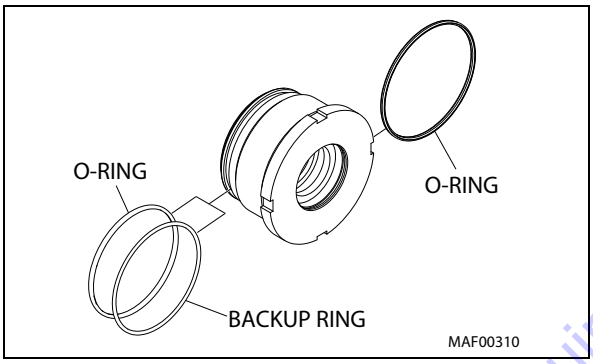


Figure 5-105. Installation of Head Seal Kit

4. Carefully install the cylinder head on the rod, ensuring that the wiper seal, bearing, retaining ring, backup ring and rod seals are not damaged or dislodged. Push the head along the rod to the rod end, as applicable.

5. Using suitable protection, clamp the cylinder rod in a vise or similar holding fixture as close to piston as possible.

6. Place new o-ring in the applicable inside diameter of the piston.

7. Carefully thread the piston on the cylinder rod, hand tight, ensuring that the o-ring and backup rings are not damaged or dislodged.

8. Install the setscrew and ball on the piston and attach the piston on the rod.

9. Remove the cylinder rod from the holding fixture.

10. Place new piston seal in the outer piston diameter groove. (A tube, with I.D. slightly larger than the O.D. of the piston is recommended to install the solid seal).

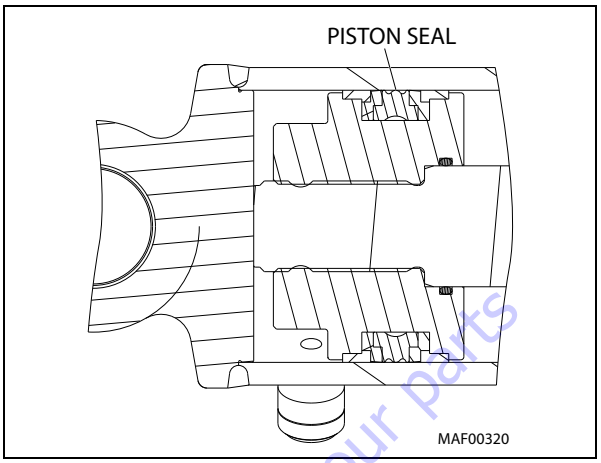


Figure 5-106. Installation of Piston Seal Kit

11. Position the cylinder barrel in a suitable holding fixture.

NOTICE

EXTREME CARE SHOULD BE TAKEN WHEN INSTALLING THE CYLINDER ROD, HEAD AND PISTON. AVOID PULLING THE ROD OFF-CENTER, WHICH COULD CAUSE DAMAGE TO THE PISTON AND CYLINDER BARREL SURFACES.

12. With barrel clamped secured and adequately supporting the rod, insert the piston end into the barrel cylinder. Ensure that the piston loading o-ring and piston seal is not damaged or dislodged.

13. Continue pushing the rod into the barrel until the cylinder head can be inserted into the barrel cylinder.

14. Screw the cylinder head into the barrel using a hook spanner wrench and torque cylinder head to 549 ft. lbs. (745 Nm).

15. Caulk at the machined area of the cylinder barrel end so that it locks the cylinder head in place and it does not unscrew from the barrel.

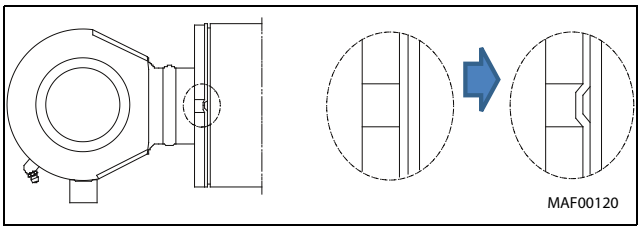


Figure 5-107. Caulking

16. After the cylinder has been reassembled, the rod should be pushed all the way in (fully retracted) prior to the reinstallation of any plugs.

17. Install the plugs in the cylinder ports.

Steer Cylinder

DISASSEMBLY

NOTICE

DISASSEMBLY OF THE CYLINDER SHOULD BE PERFORMED ON A CLEAN WORK SURFACE IN A DIRT FREE WORK AREA.

1. Connect a suitable auxiliary hydraulic power source to the cylinder port block fitting.

⚠ WARNING

DO NOT FULLY EXTEND CYLINDER TO THE END OF STROKE. RETRACT CYLINDER SLIGHTLY TO AVOID TRAPPING PRESSURE.

2. Operate the hydraulic power source and extend the cylinder. Shut down and disconnect the power source. Adequately support the cylinder rod, if applicable.
3. Remove the plugs from the cylinder ports. Discard o-rings.
4. Place the cylinder barrel into a suitable holding fixture.

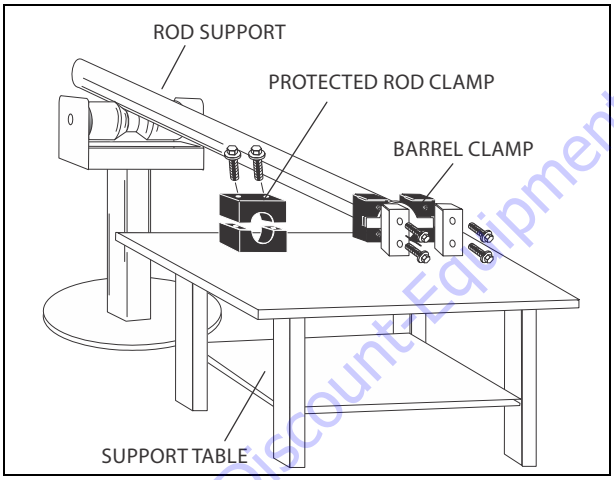


Figure 5-108. Cylinder Barrel Support

5. Using a hook spanner, loosen the cylinder head on both ends of the rod. Remove the cylinder heads from the barrel and the rod.

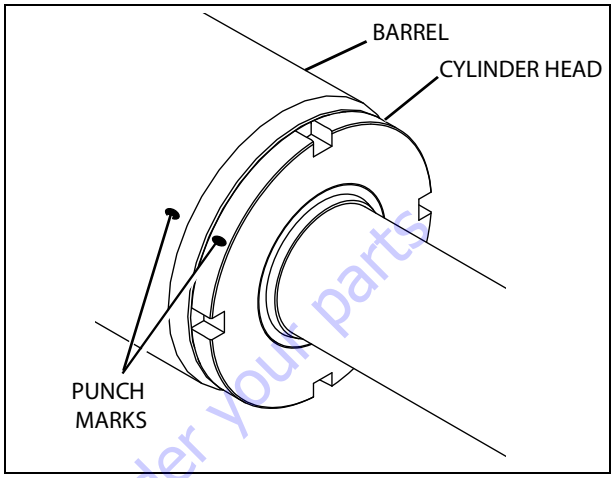


Figure 5-109. Cylinder Head Removal

6. Remove and discard the wiper seal, rod seal, backup ring, bearing, and o-ring from both the cylinder head.
7. Attach a suitable pulling device to the cylinder rod port block end or cylinder rod end, as applicable.

NOTICE

EXTREME CARE SHOULD BE TAKEN WHEN REMOVING THE CYLINDER ROD, HEAD AND PISTON. AVOID PULLING THE ROD OFF-CENTER, WHICH COULD CAUSE DAMAGE TO THE PISTON AND CYLINDER BARREL SURFACES.

8. With the barrel clamped securely, apply pressure to the rod pulling device and carefully withdraw the complete rod assembly from the cylinder barrel.

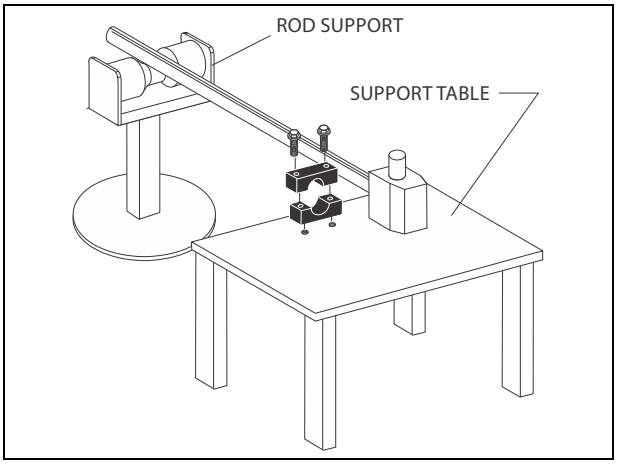
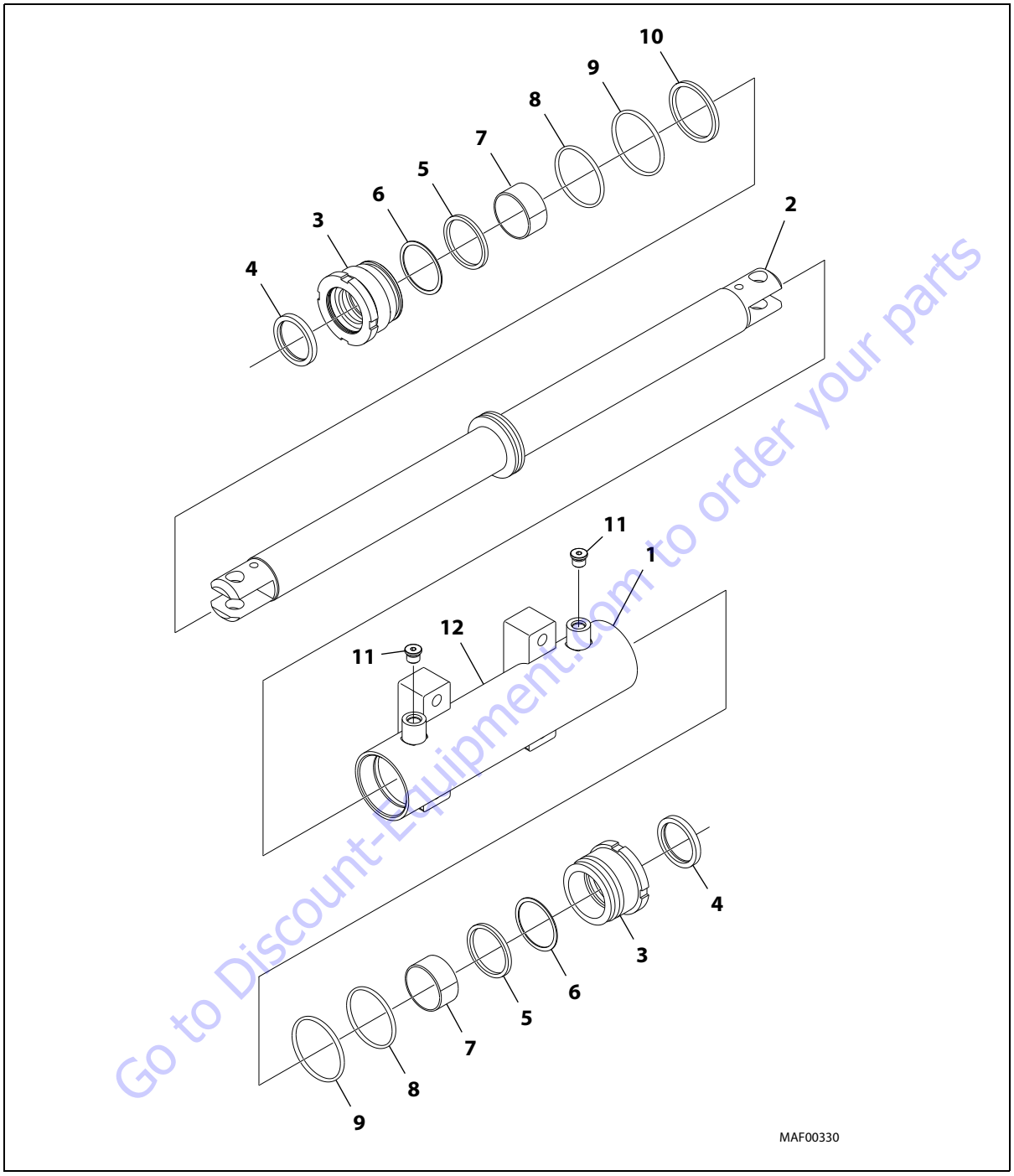


Figure 5-110. Cylinder Barrel Support

9. Remove and discard the piston seal form the rod.



1. Barrel
2. Rod
3. Cylinder Head
4. Wiper Seal
5. Rod Seal
6. Backup Ring
7. Bearing
8. O-ring
9. O-ring
10. Piston Seal
11. Plug

Figure 5-111. Steer Cylinder

CLEANING AND INSPECTION

1. Clean all parts thoroughly in an approved cleaning solvent.
2. Inspect the cylinder rod for scoring, tapering, ovality or other damage. If necessary, dress rod with Scotch Brite or equivalent. Replace rod if necessary.
3. Inspect inner surface of cylinder barrel tube for scoring or other damage. Check inside diameter for tapering or ovality. Replace if necessary.
4. Inspect threaded portion of barrel for damage. Dress threads as necessary.
5. Inspect cylinder head inside diameter for scoring, tapering, ovality or other damage. Replace if necessary.
6. Inspect threaded portion of head for damage. Dress threads as necessary.
7. Inspect seal and o-ring grooves in head for burrs and sharp edges. Dress applicable surfaces as necessary.
8. Inspect cylinder head outside diameter for scoring, tapering or ovality other damage. Replace if necessary.
9. Inspect port block fittings and valves. Replace if necessary.
10. Inspect the oil ports for blockage or the presence of dirt or other foreign material. Repair as necessary.

ASSEMBLY

NOTE: *Prior to cylinder assembly, ensure that the proper cylinder seal kit is used. See the respective JLG Parts Manual.*

NOTE: *Apply a light film of hydraulic oil to all components prior to assembly.*

1. A special tool is used to install a new rod seal into the applicable cylinder head groove.

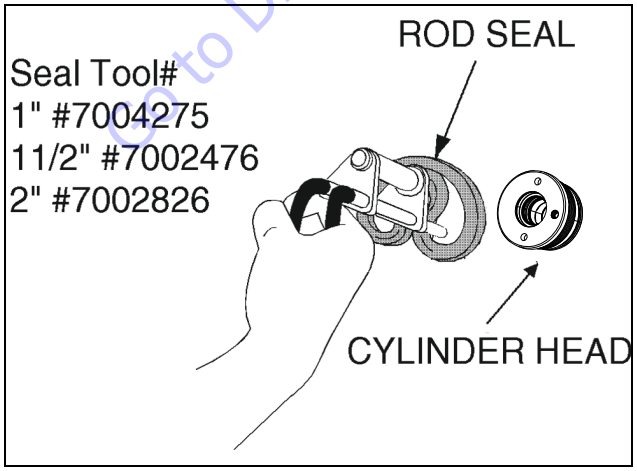


Figure 5-112. Rod Seal Installation

NOTICE

WHEN INSTALLING NEW SEALS, ENSURE SEALS ARE INSTALLED PROPERLY. IMPROPER SEAL INSTALLATION COULD RESULT IN CYLINDER LEAKAGE AND IMPROPER CYLINDER OPERATION.

2. Use a soft mallet to tap a new wiper seal into the applicable cylinder head groove. Install a new bearing and backup ring into the applicable inside diameter of the cylinder head groove.

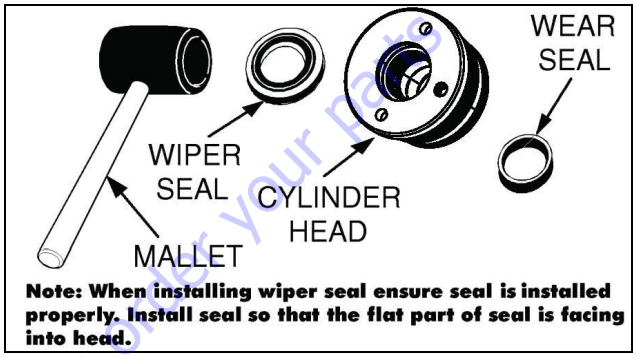


Figure 5-113. Wiper Seal Installation

3. Place new o-rings in the applicable outside diameter groove of the cylinder heads.
4. Place new piston seal in the applicable groove of the rod.
5. With barrel clamped secured and adequately supporting the rod, insert the rod into the barrel cylinder.
6. Carefully install the cylinder head on both the side of the rod, ensuring that the wiper and rod seals are not damaged or dislodged. Push the heads along the rod to the barrel, as applicable.
7. Install new plugs into the cylinder port block.

Telescope Cylinder

DISASSEMBLY

NOTICE

DISASSEMBLY OF THE CYLINDER SHOULD BE PERFORMED ON A CLEAN WORK SURFACE IN A DIRT FREE WORK AREA.

1. Connect a suitable auxiliary hydraulic power source to the cylinder port block fitting.

⚠ WARNING

DO NOT FULLY EXTEND CYLINDER TO THE END OF STROKE. RETRACT CYLINDER SLIGHTLY TO AVOID TRAPPING PRESSURE.

2. Operate the hydraulic power source and extend the cylinder. Shut down and disconnect the power source. Adequately support the cylinder rod, if applicable.
3. Remove the capscrews securing the valve block to the barrel end of the cylinder. Remove the valve assembly.
4. Remove the counterbalance valves, shuttle valve and plugs from the valve block and cylinder port block. Discard o-rings.
5. Place the cylinder barrel into a suitable holding fixture.

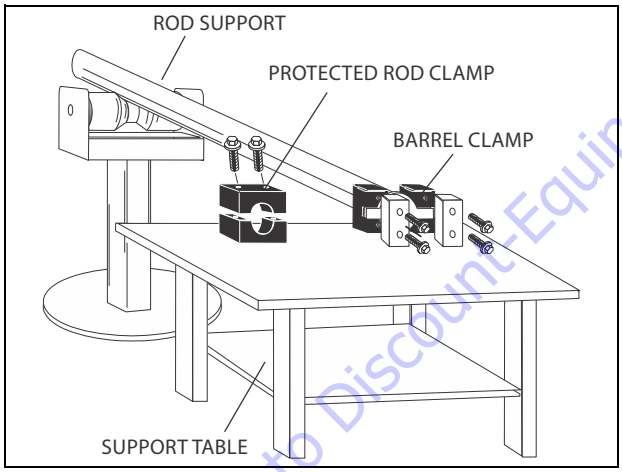


Figure 5-114. Cylinder Barrel Support

6. Mark cylinder head and barrel with a center punch for easy realignment. Using an allen wrench, loosen and remove the capscrews securing the wearpad plate and cylinder head to the barrel. Remove the hardware securing the wear pads to the plate. Remove the wear pads.

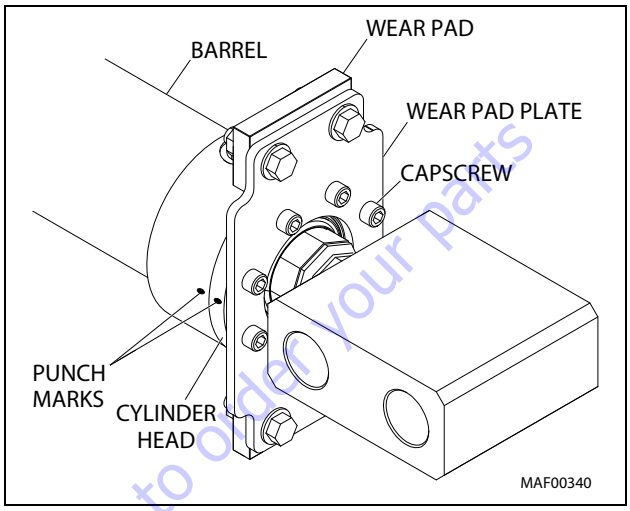


Figure 5-115. Cylinder Head Removal

7. Attach a suitable pulling device to the cylinder rod port block end or cylinder rod end, as applicable.

NOTICE

EXTREME CARE SHOULD BE TAKEN WHEN REMOVING THE CYLINDER ROD, HEAD AND PISTON. AVOID PULLING THE ROD OFF-CENTER, WHICH COULD CAUSE DAMAGE TO THE PISTON AND CYLINDER BARREL SURFACES.

8. With the barrel clamped securely, apply pressure to the rod pulling device and carefully withdraw the complete rod assembly from the cylinder barrel.

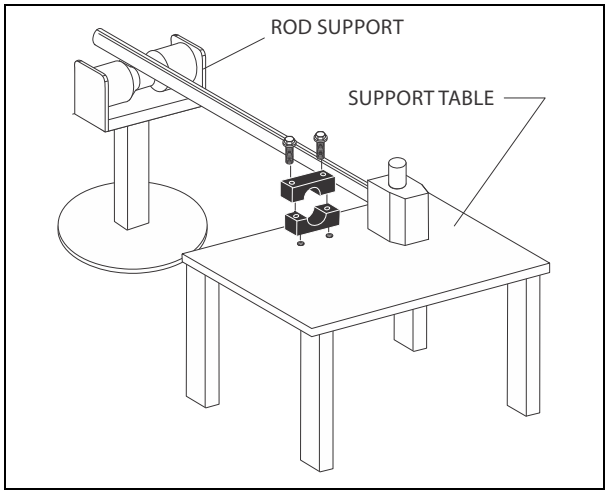
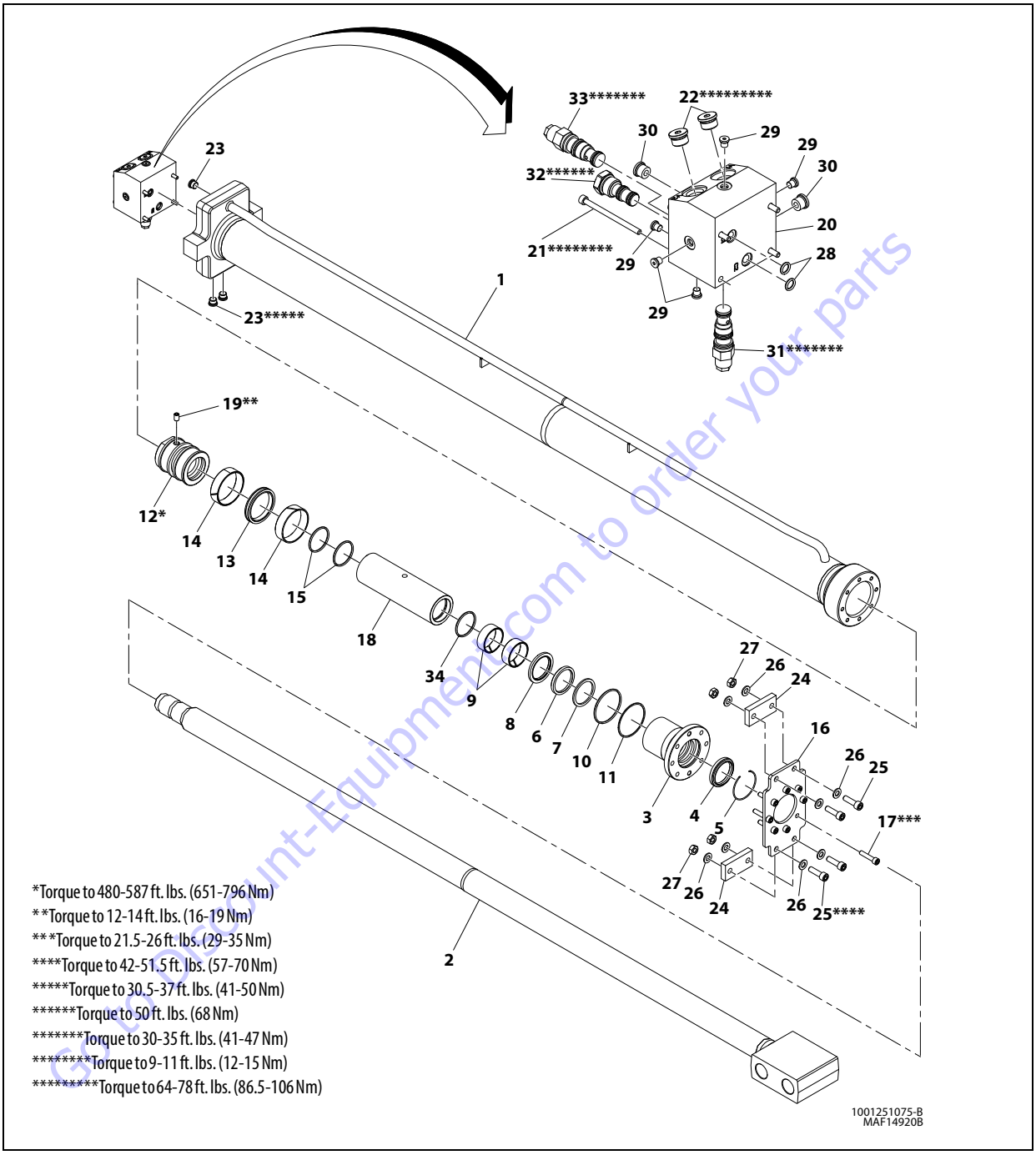


Figure 5-116. Cylinder Rod Support



1. Barrel
2. Rod
3. Head
4. Wiper Seal
5. Retaining Ring
6. Rod Seal
7. Backup Ring
8. Wear Ring
9. Wear Ring
10. O-ring
11. Backup Ring
12. Piston
13. Piston Seal
14. Wear Ring
15. O-ring
16. Plate
17. Capscrew
18. Spacer
19. Setscrew
20. Valve Assembly
21. Capscrew
22. Plug
23. Plug
24. Water Pad
25. Bolt
26. Washer
27. Nut
28. O-ring
29. Plug
30. Plug
31. Counterbalance Valve
32. Shuttle Valve
33. Counterbalance Valve
34. O-ring

Figure 5-117. Telescope Cylinder

9. Using suitable protection, clamp the cylinder rod in a vise or similar holding fixture as close to the piston as possible.
10. Remove and discard the piston o-ring, seal rings, backup rings and wear rings.
11. Loosen and remove the setscrew which attaches the piston to the rod.
12. Screw the piston counterclockwise and remove the piston from cylinder rod.
13. Remove piston spacer from the rod. Remove and discard the o-rings from the spacer.
14. Remove the rod from the holding fixture. Remove the cap and the cylinder head. Discard the o-rings, backup ring, wear rings, rod seal and wiper seal.

CLEANING AND INSPECTION

1. Clean all parts thoroughly in an approved cleaning solvent.
2. Inspect the cylinder rod for scoring, tapering, ovality, or other damage. If necessary, dress rod with Scotch Brite or equivalent. Replace rod if necessary.
3. Inspect threaded portion of rod for excessive damage. Dress threads as necessary.
4. Inspect inner surface of cylinder barrel tube for scoring or other damage. Check inside diameter for tapering or ovality. Replace if necessary.
5. Inspect threaded portion of barrel for damage. Dress threads as necessary.
6. Inspect piston surface for damage and scoring and for distortion. Dress piston surface or replace piston as necessary.
7. Inspect threaded portion of piston for damage. Dress threads as necessary.
8. Inspect seal and o-ring grooves in piston for burrs and sharp edges. Dress applicable surfaces as necessary.
9. Inspect cylinder head inside diameter for scoring, tapering, ovality or other damage. Replace if necessary.
10. Inspect threaded portion of head for damage. Dress threads as necessary.
11. Inspect seal and o-ring grooves in head for burrs and sharp edges. Dress applicable surfaces as necessary.
12. Inspect cylinder head outside diameter for scoring, tapering, ovality or other damage. Replace if necessary.
13. If applicable, inspect rod and barrel bearings for signs of correct excessive wear or damage. Replace if necessary.
    a. Thoroughly clean hole (steel bushing) of burrs, dirt etc. to facilitate bearing installation.
    b. Inspect steel bushing for wear or other damage. If steel bushing is worn or damaged, rod/barrel must be replaced.
    c. Lubricate inner side of steel bushing prior to bearing installation.
    d. Using an arbor of the correct size, carefully press the bearing into steel bushing.

NOTE: *Install pin into the composite bearing dry. Lubrication is not required with nickel plated pins and bearings.*

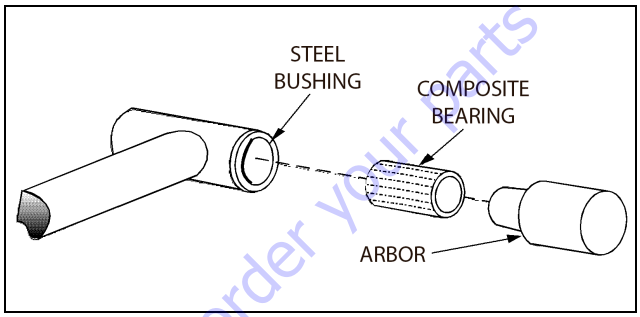


Figure 5-118. Composite Bearing Installation

14. Inspect spacer for burrs and sharp edges. If necessary, dress inside diameter surface with Scotch Brite or equivalent.
15. Inspect o-ring groove in spacer for burrs and sharp edges. Dress applicable surfaces as necessary.
16. Inspect port block fittings and holding valve. Replace if necessary.
17. Inspect the oil ports for blockage or the presence of dirt or other foreign material. Repair if necessary.
18. Inspect piston rings for cracks or other damage. Replace if necessary.

ASSEMBLY

NOTE: *Prior to cylinder assembly, ensure that the proper cylinder seal kit is used. See your JLG Parts Manual.*

NOTE: *Apply a light film of hydraulic oil to all components prior to assembly.*

1. A special tool is used to install a new rod seal into the applicable cylinder head groove.

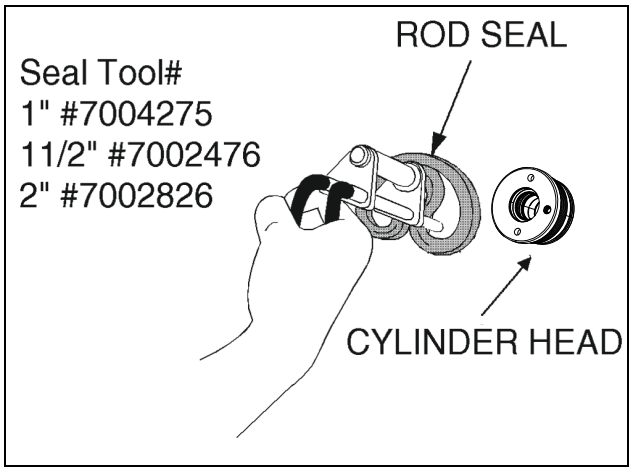


Figure 5-119. Rod Seal Installation

NOTICE

WHEN INSTALLING NEW SEALS, ENSURE SEALS ARE INSTALLED PROPERLY. IMPROPER SEAL INSTALLATION COULD RESULT IN CYLINDER LEAKAGE AND IMPROPER CYLINDER OPERATION.

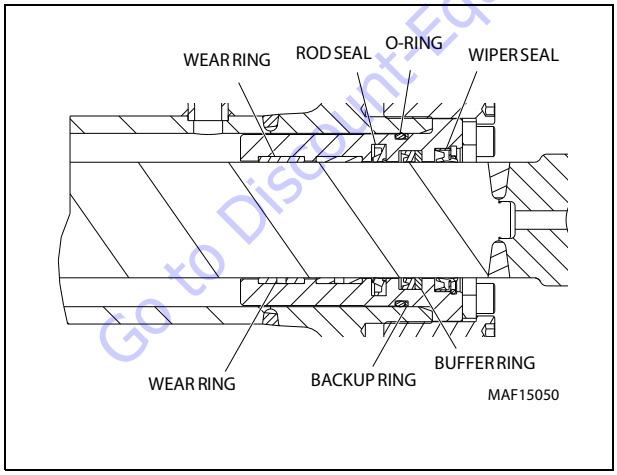


Figure 5-120. Cylinder Head Seal Installation

2. Use a soft mallet to tap a new wiper seal into the applicable cylinder head groove. Install new buffer ring, backup ring, o-ring, rod seal, wear ring and retaining ring into the applicable inside diameter of the cylinder head groove.

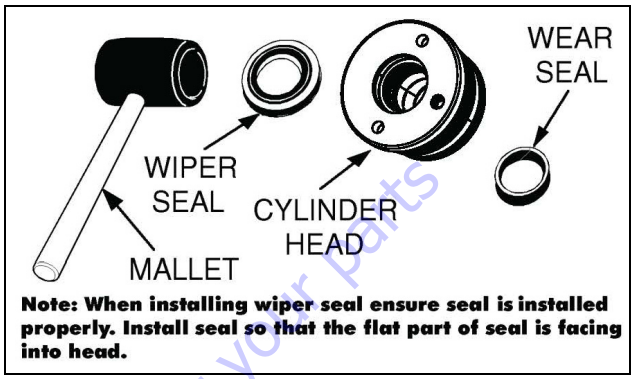


Figure 5-121. Wiper Seal Installation

3. Place new o-ring and backup ring in the applicable outside diameter groove of the cylinder head.

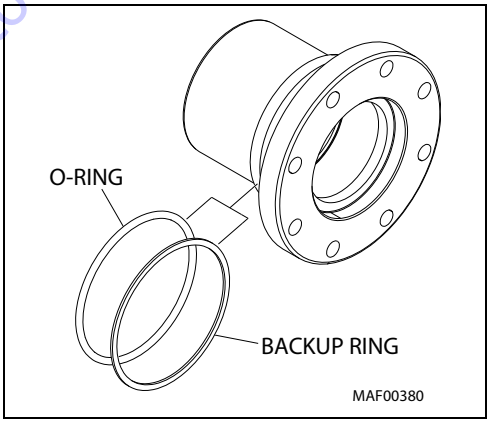


Figure 5-122. Installation of Head Seal Kit

4. Carefully install the cylinder head on the rod, ensuring that the wear ring, rod seal and wiper seal are not damaged or dislodged. Push the head along the rod to the rod end.

5. Place new o-rings in the applicable inside diameter groove of spacer.

6. Install the spacer tube onto the cylinder rod ensuring that the o-rings are not damaged or dislodged.

7. Place a new o-ring and backup rings in the inner piston diameter groove.

8. Using suitable protection, clamp the cylinder rod in a vise or similar holding fixture as close to piston as possible.

9. Carefully thread the piston on the cylinder rod till it abuts the spacer, ensuring that the o-ring and backup

ring is not damaged or dislodged. Torque the piston to 480-587 ft. lbs. (651-796 Nm).

10. Secure using setscrew. Torque setscrew to 12-14 ft. lbs. (16-19 Nm)
11. Remove the cylinder rod from the holding fixture.
12. Position the cylinder barrel in a suitable holding fixture.
13. Place new piston seal and wear rings in the outer piston diameter groove. (A tube, with I.D. slightly larger than the O.D. of the piston is recommended to install the solid seal).

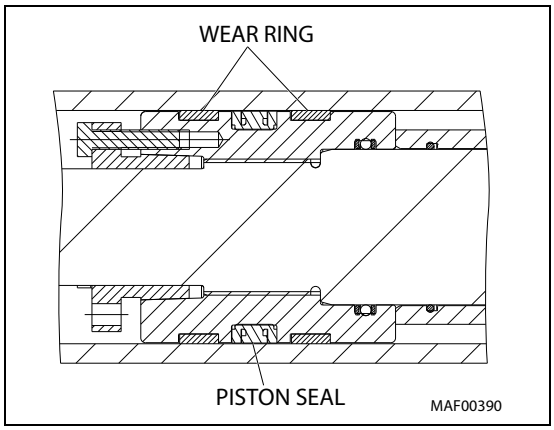


Figure 5-123. Piston Seal Kit Installation

NOTICE

EXTREME CARE SHOULD BE TAKEN WHEN INSTALLING THE CYLINDER ROD, HEAD AND PISTON. AVOID PULLING THE ROD OFF-CENTER, WHICH COULD CAUSE DAMAGE TO THE PISTON AND CYLINDER BARREL SURFACES.

14. With barrel clamped securely, and while adequately supporting the rod, insert the piston end into the barrel cylinder. Ensure that the piston loading o-ring and seal ring are not damaged or dislodged.
15. Continue pushing the rod into the barrel until the cylinder head can be inserted into the barrel cylinder.
16. Install wear pads onto the wearpad plate using bolts, washers and nuts.
17. Apply Medium Strength Threadlocking Compound to the capscrews. Secure the cylinder head to the barrel using the plate and capscrews. Torque capscrews to 21.5-26 ft. lbs. (29-35 Nm)
18. After the cylinder has been reassembled, the rod should be pushed all the way in (fully retracted) prior to the reinstallation of any holding valve or valves.
19. Install the counterbalance and shuttle valves onto the valve block. Torque counterbalance valve to 30-35 ft. lbs. (41-47 Nm) and shuttle valve to 50 ft. lbs. (68 Nm).
20. Apply Medium Strength Threadlocking Compound to the capscrews. Install the valve assembly at the barrel end of the cylinder and secure using capscrews. Torque Capscrew to 9-11 ft. lbs. (12-15 Nm).

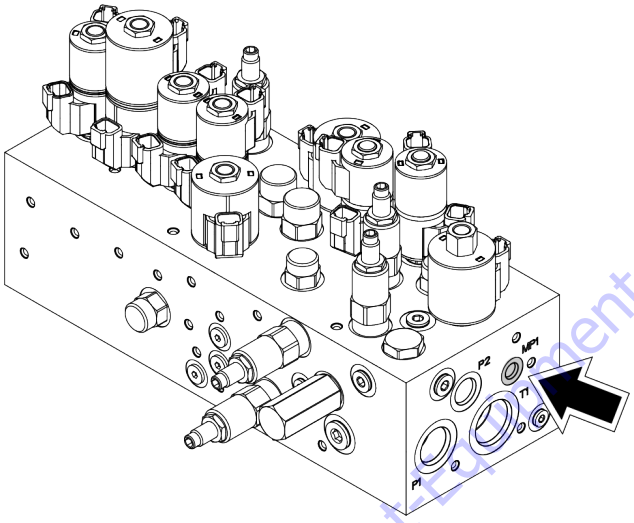
5.4 PRESSURE SETTING PROCEDURE

Cold temperatures have a significant impact on pressure readings. JLG Industries Inc. recommends operating the machine until the hydraulic system has warmed to normal operating temperatures prior to checking pressures. JLG Industries Inc. also recommends the use of a calibrated gauge. Pressure readings are acceptable if they are within ± 5% of specified pressures.

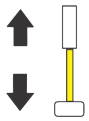
To ensure all pressures are set correctly, the following procedures must be followed.

Main System Relief

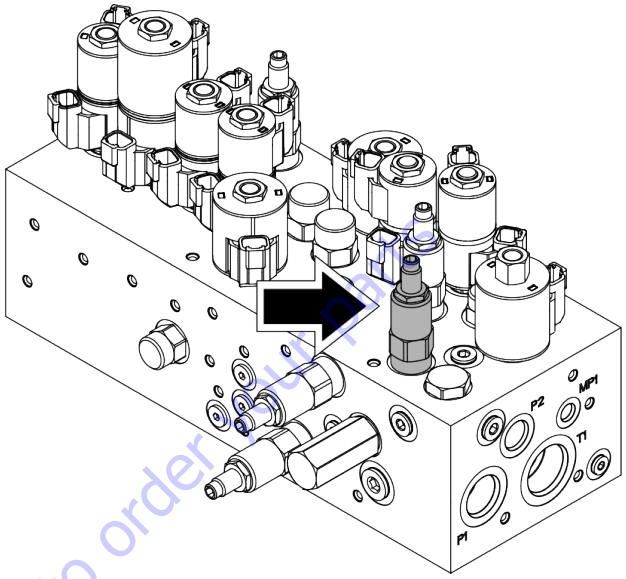
1. Install a pressure gauge at MP1 port of the Main Control Valve capable of reading pressures up to 4000 psi (275 Bar).



2. Activate telescope in function continuously at end of stroke. Observed pressure should be 3000 ± 75 psi (207 ± 6 Bar).

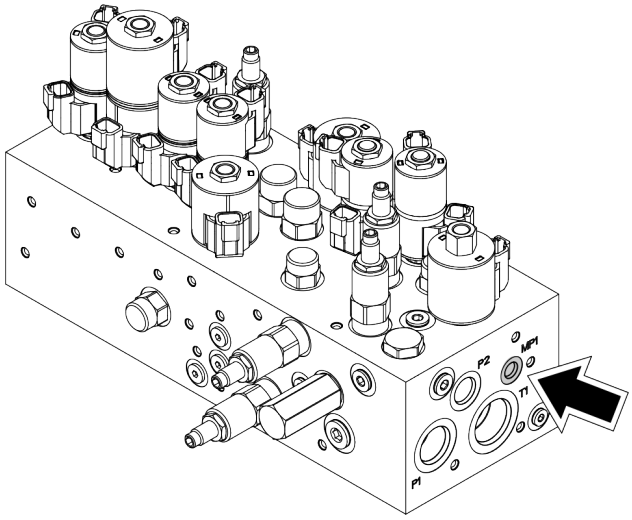


3. If necessary, loosen jam nut and adjust the Main System Relief valve clockwise to increase and counterclockwise to decrease.

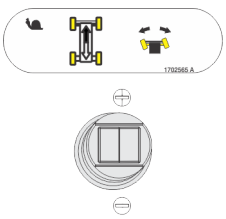


Steer Left Relief

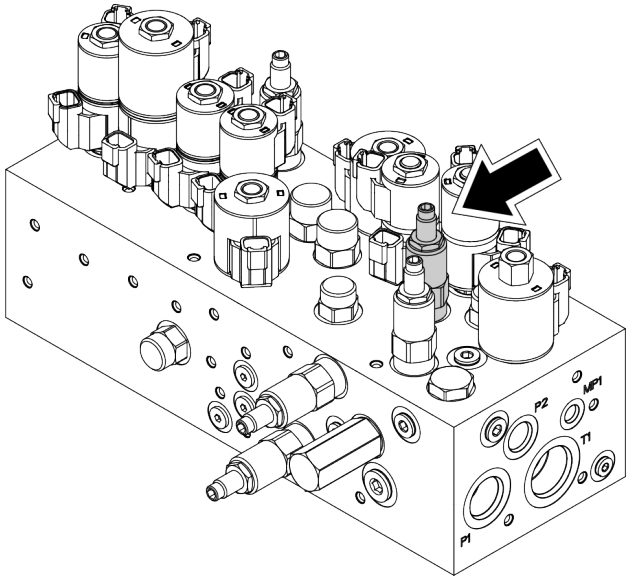
1. Install a pressure gauge at port MP1 of the Main Control Valve capable of reading pressures up to 4000 psi (275 Bar).



2. Activate Steer Left function continuously at end of stroke. Observed pressure should be 2750 ± 75 psi (190 ± 6 Bar).



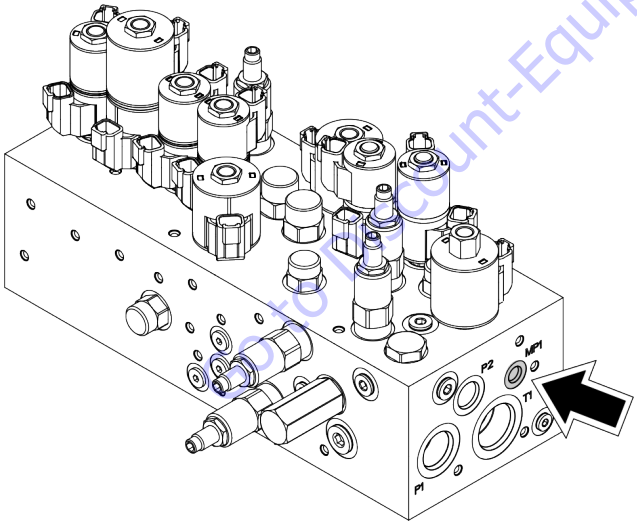
3. If necessary, loosen jam nut and adjust the Steer Left Relief valve clockwise to increase and counterclockwise to decrease.



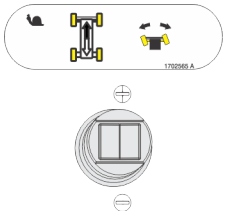
NOTE: *Steer left pressure at port 24 is 2500 psi (173 Bar); a gauge may be placed there for troubleshooting.*

Steer Right Relief

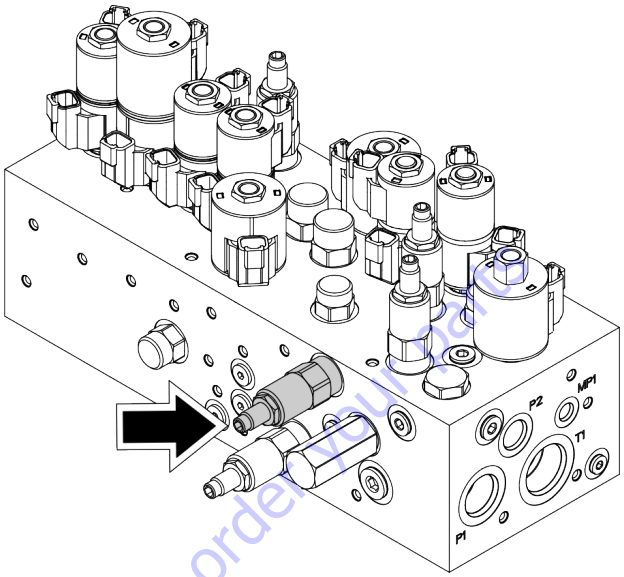
1. Install a pressure gauge at port MP1 of the Main Control Valve capable of reading pressures up to 4000 psi (275 Bar).



2. Activate Steer Right function continuously at end of stroke. Observed pressure should be 2750 ± 75 psi (190 ± 6 Bar).



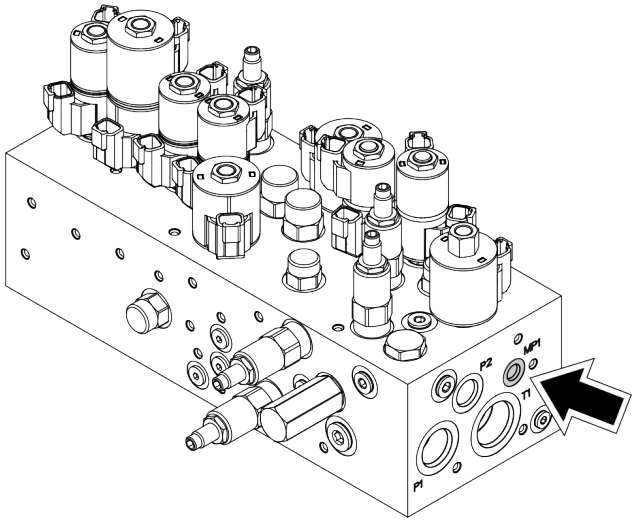
3. If necessary, loosen jam nut and adjust the Steer Right Relief valve clockwise to increase and counterclockwise to decrease.



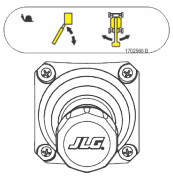
NOTE: *Steer Right pressure at port 23 is 2500 psi (173 Bar); a gauge may be placed there for troubleshooting.*

Swing Relief

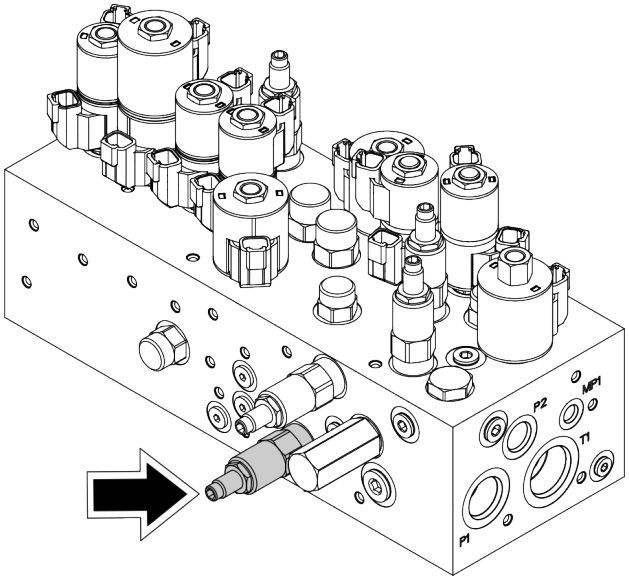
1. Install a pressure gauge at port MP1 of the Main Control Valve capable of reading pressures up to 3000 psi (207 Bar).



2. Activate Boom Swing Right or Left function continuously against the stop or lock. Observed pressure should be 1700 ± 50 psi (117 ± 4 Bar).



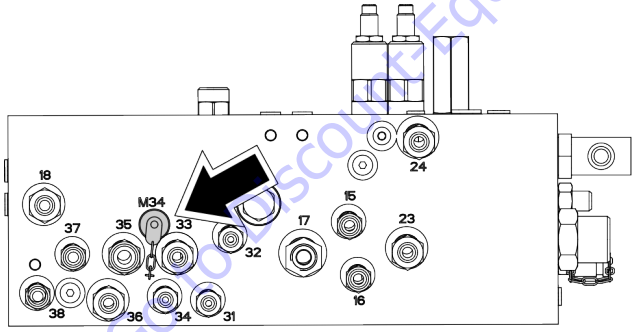
3. If necessary, loosen jam nut and adjust the Boom Swing Relief valve clockwise to increase and counterclockwise to decrease.



NOTE: *Boom Swing Right pressure at port 15 and Boom Swing Left pressure at port 16 is 1600 psi (110 Bar); a gauge may be placed there for troubleshooting.*

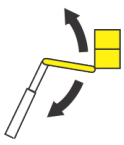
Jib Lift Down Relief (460SJ only)

1. Install a pressure gauge at port M34 of the Main Control Valve capable of reading pressures up to 3000 psi (207 Bar).

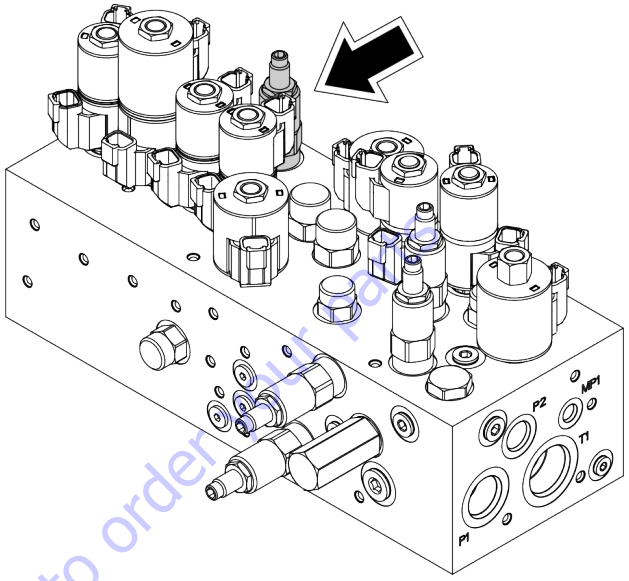


BOTTOM OF MAIN CONTROL VALVE

2. Activate Jib Lift Down function continuously at end of stroke. Observed pressure should be 1200 ± 50 psi (83 ± 4 Bar).



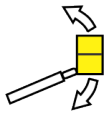
3. If necessary, loosen jam nut and adjust the Jib Lift Down Relief valve clockwise to increase and counterclockwise to decrease.



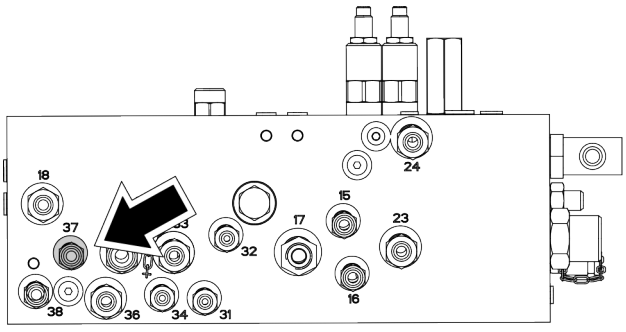
Platform Level Up Relief

The Platform Level Up relief is set at the vendor and does not normally need checked or adjusted. If necessary, the following procedure may be utilized for trouble shooting purposes:

1. Lift the main boom up enough to allow the platform to be fully leveled up.
2. Activate Level Up to end of stroke.



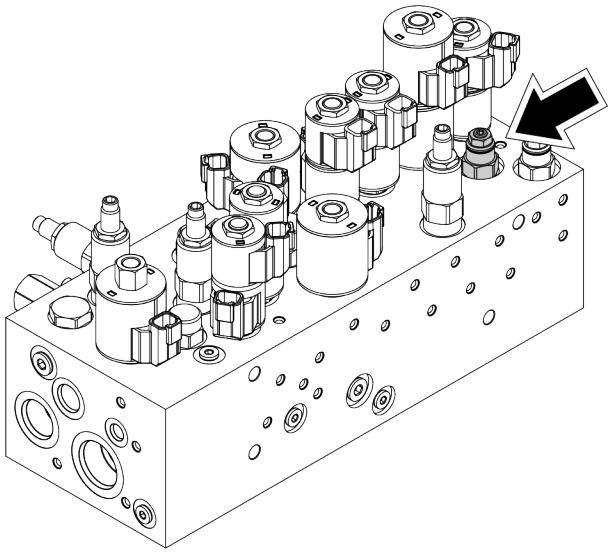
3. Remove the hose from the Level Up port on the main control valve (Port 37) - "T" a pressure gauge capable of reading pressures up to 4000 psi (275 Bar) onto this port and reconnect the hose.



BOTTOM OF MAIN CONTROL VALVE

4. Activate Main Boom Lift Down function using Auxiliary Mode continuously until fully lowered. Observed pressure should be 3200 ± 80 psi (220 ± 6 Bar).

5. If necessary, loosen jam nut and adjust the Platform Level Up Relief valve clockwise to decrease and counterclockwise to increase.



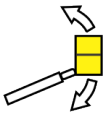
6. Remove "T" and the gauge and reinstall the hose.

Platform Level Down Relief

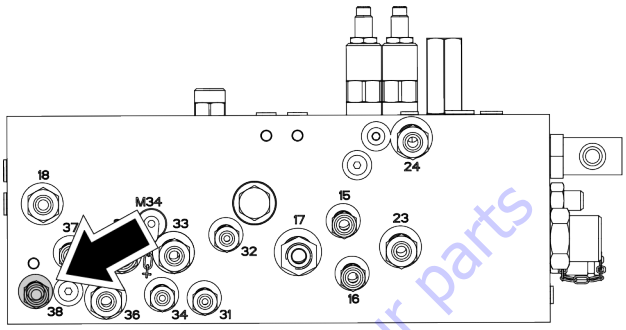
The Platform Level Down relief is set at the vendor and does not normally need checked or adjusted. If necessary, the following procedure may be utilized for trouble shooting purposes:

1. Lift the main boom up enough to allow the platform to be fully leveled down.

2. Activate Level Down to end of stroke.

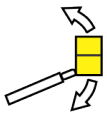


3. Remove the hose from the Level Down port on the main control valve (Port 38) - "T" a pressure gauge capable of reading pressures up to 3000 psi (207 Bar) onto this port and reconnect the hose.

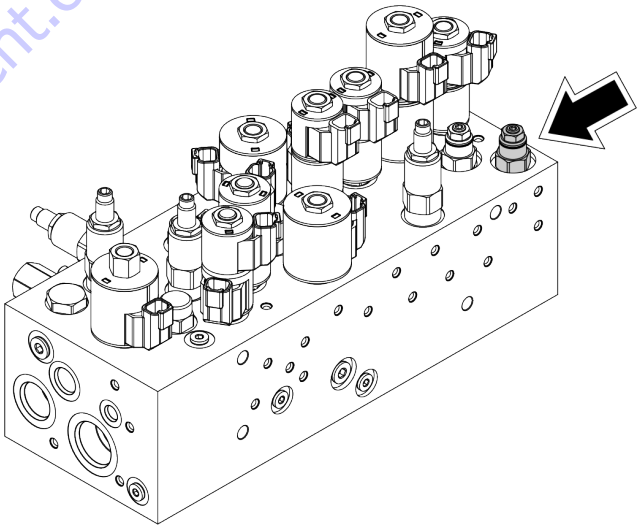


BOTTOM OF MAIN CONTROL VALVE

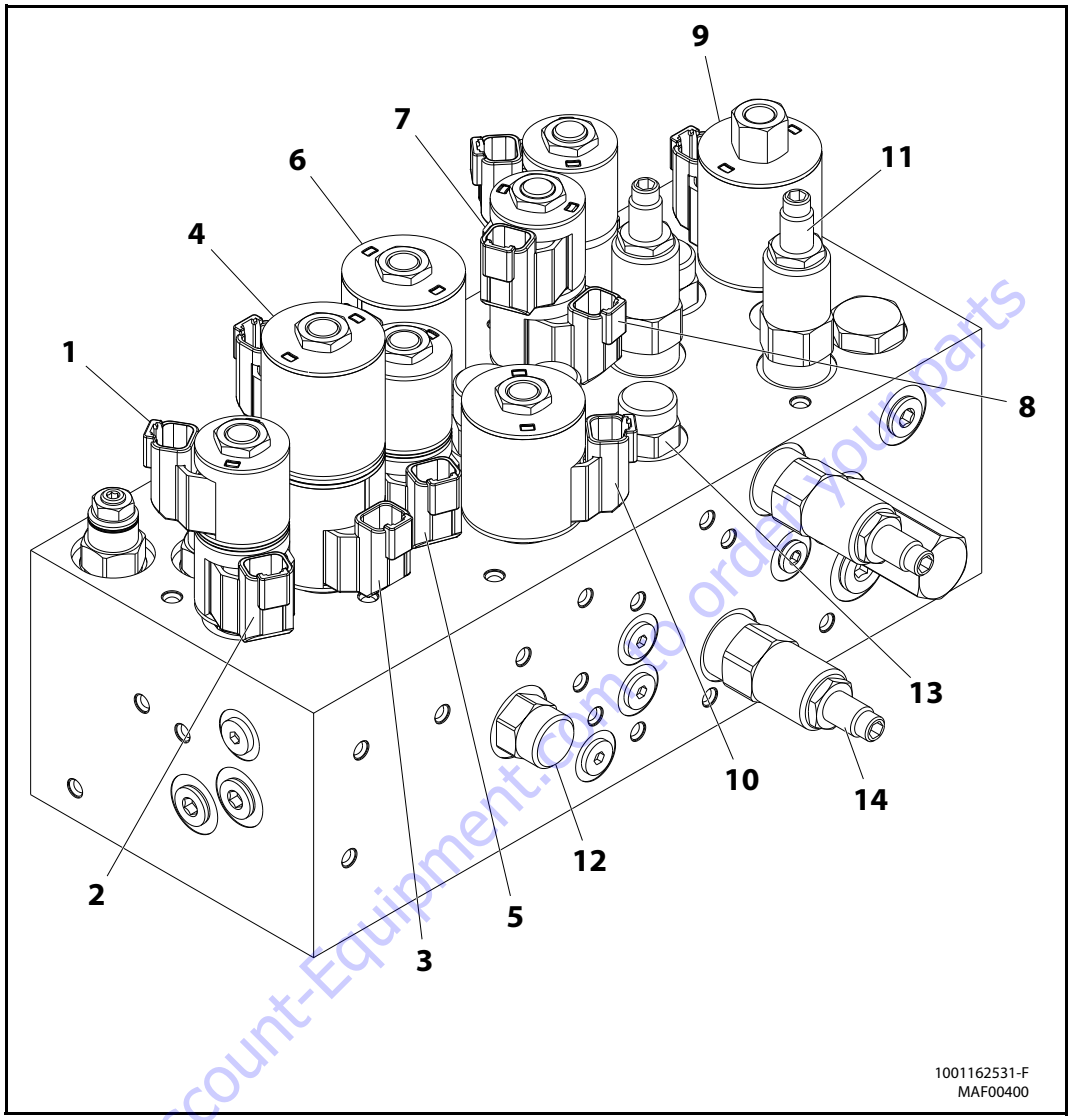
4. Activate Platform Level Down function continuously at end of stroke. Observed pressure should be 2000 ± 50 psi (138 ± 4 Bar).



5. If necessary, loosen jam nut and adjust the Platform Level Down Relief valve clockwise to decrease and counterclockwise to increase.

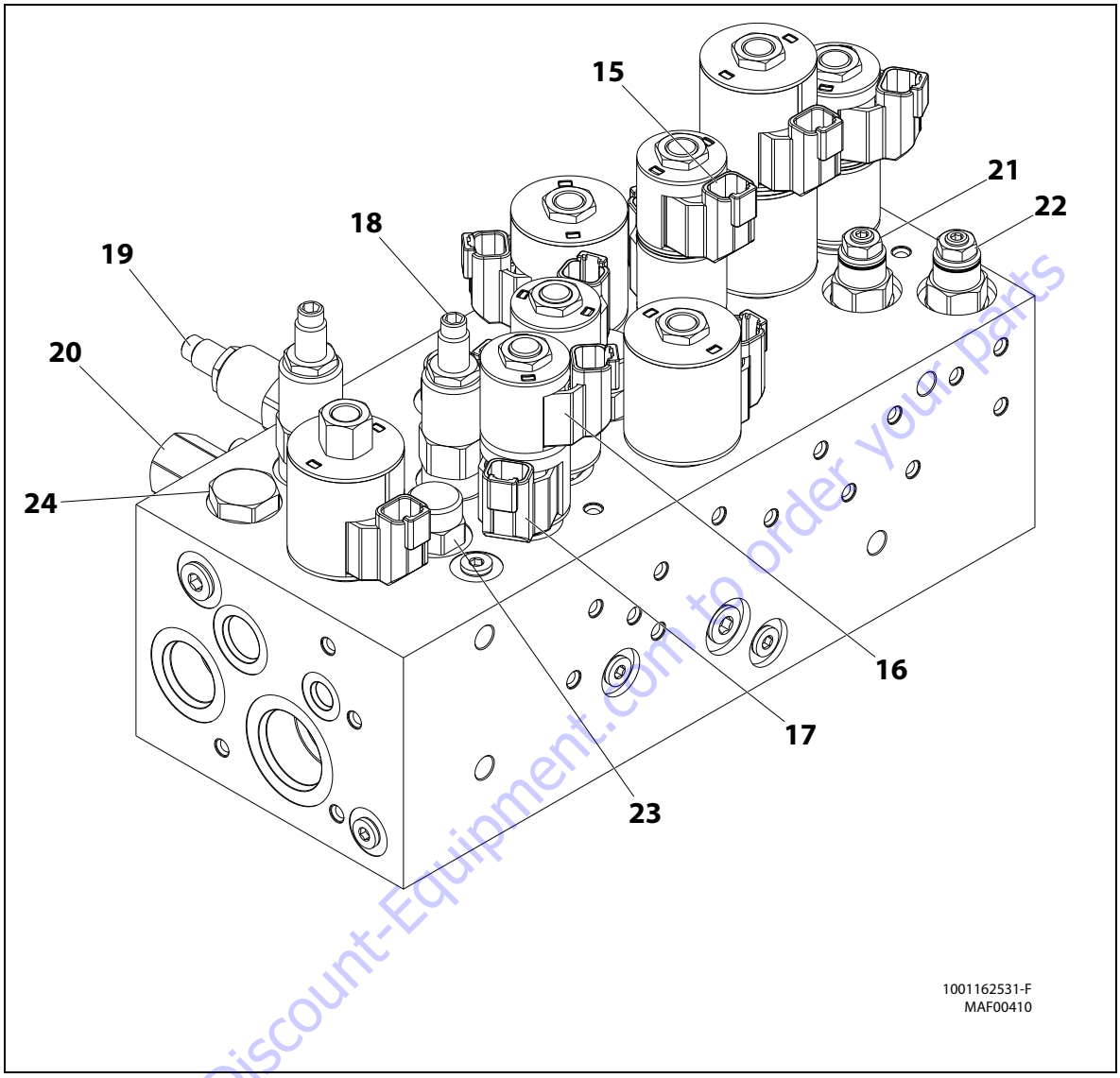


6. Remove "T" and the gauge and reinstall the hose.



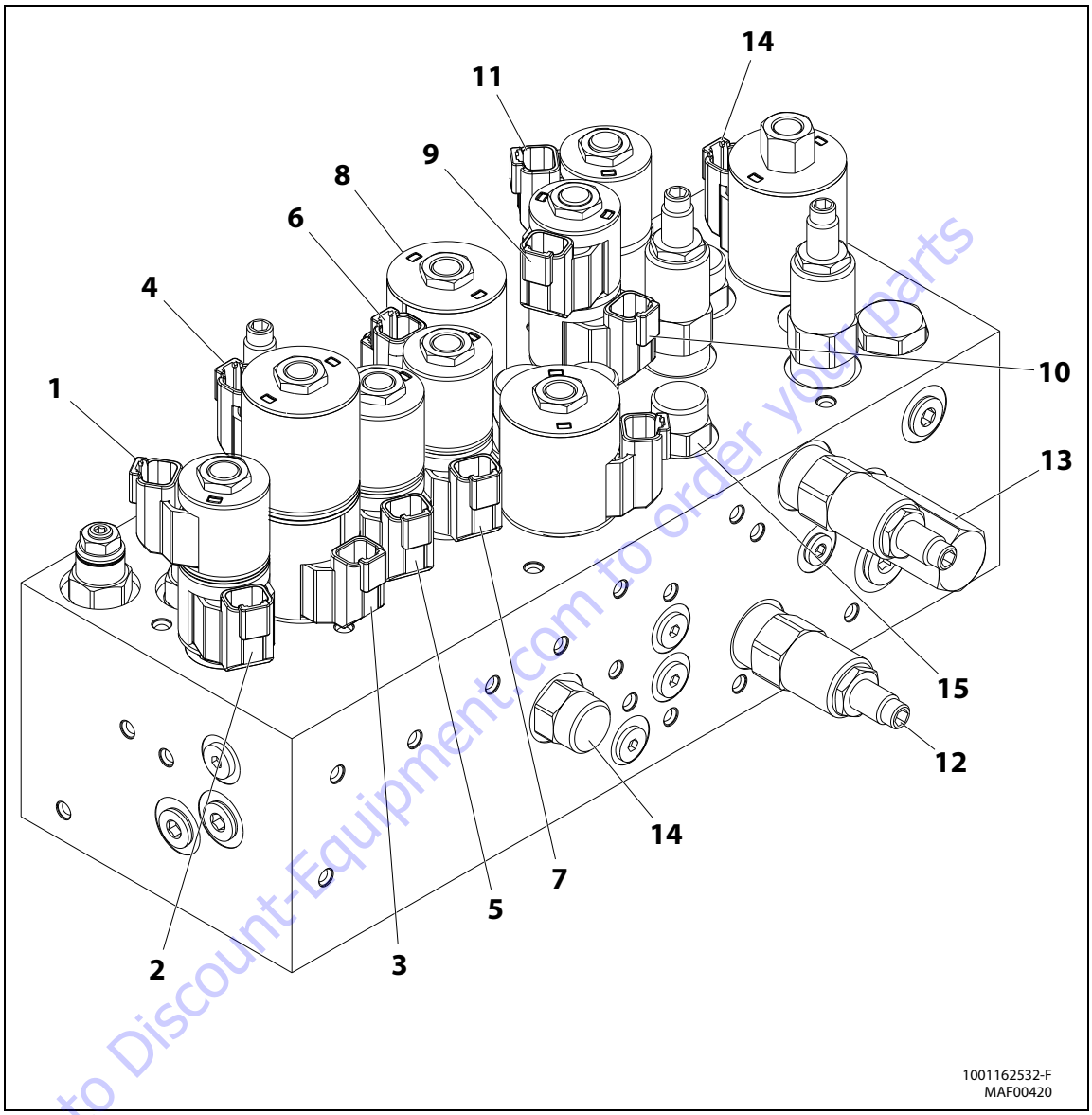
1. Level Up
2. Level Down
3. Tele In
4. Tele Out
5. Not Used
6. Not Used
7. Rotate Left
8. Rotate Right
9. Main Lift Up
10. Swing Right
11. Swing Left
12. Not Used
13. Not Used
14. Main Dump

Figure 5-124. Main Control Valve Identification (400S) - Sheet 1 of 2



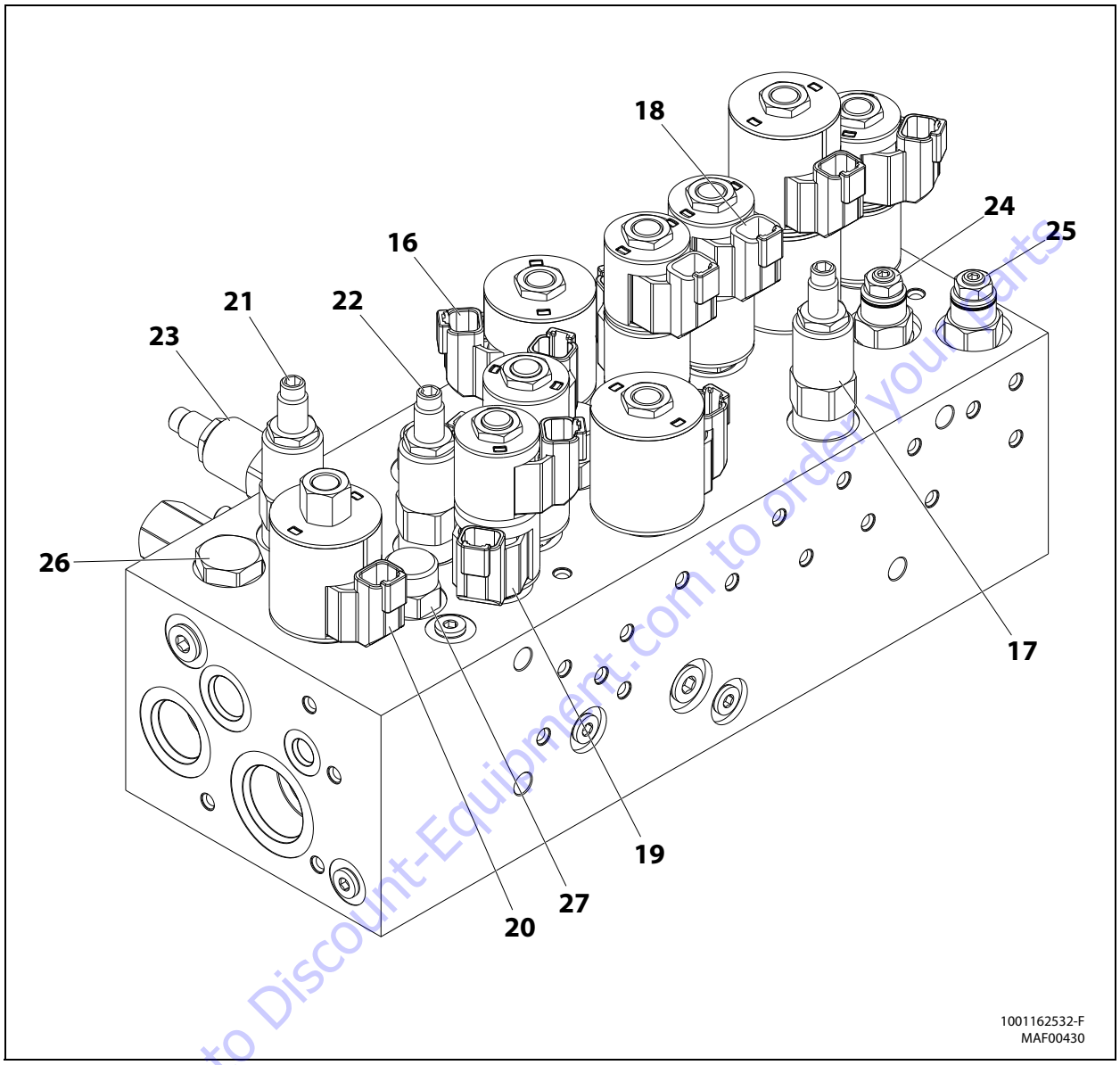
15. Rotate Left
16. Steer Left
17. Steer Right
18. Steer Left Relief
19. Steer Right Relief
20. Flow Regulator
21. Level Up Relief
22. Level Down Relief
23. Flow Regulator
24. Check Valve

Figure 5-125. Main Control Valve Identification (400S) - Sheet 2 of 2



1. Level Up
2. Level Down
3. Tele In
4. Tele Out
5. Jib Down
6. Rotate Left
7. Rotate Right
8. Main Lift Up
9. Swing Right
10. Swing Left
11. Steer Left
12. Swing Relief
13. Flow Regulator
14. Flow Regulator
15. Pressure Compensator

Figure 5-126. Main Control Valve Identification (460SJ) - Sheet 1 of 2



16. Flow Control
17. Jib Lift Relief
18. Jib Up
19. Steer Right
20. Main Dump
21. Steer Relief
22. Steer Left Relief
23. Steer Right Relief
24. Level Up Relief
25. Level Down Relief
26. Check Valve
27. Flow Regulator

Figure 5-127. Main Control Valve Identification (460SJ) - Sheet 2 of 2

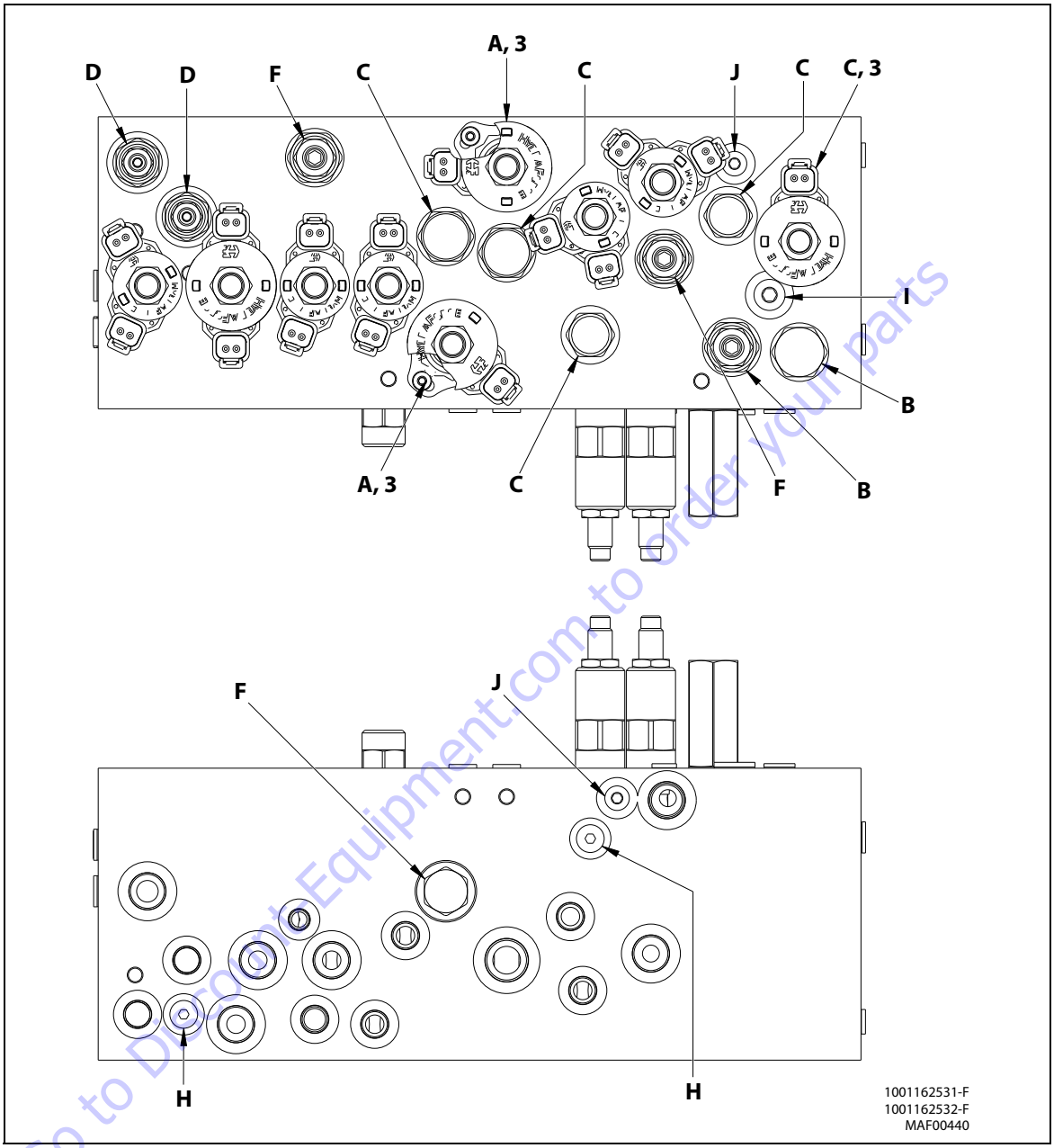


Figure 5-128. Main Control Valve Torque Values - Sheet 1 of 2

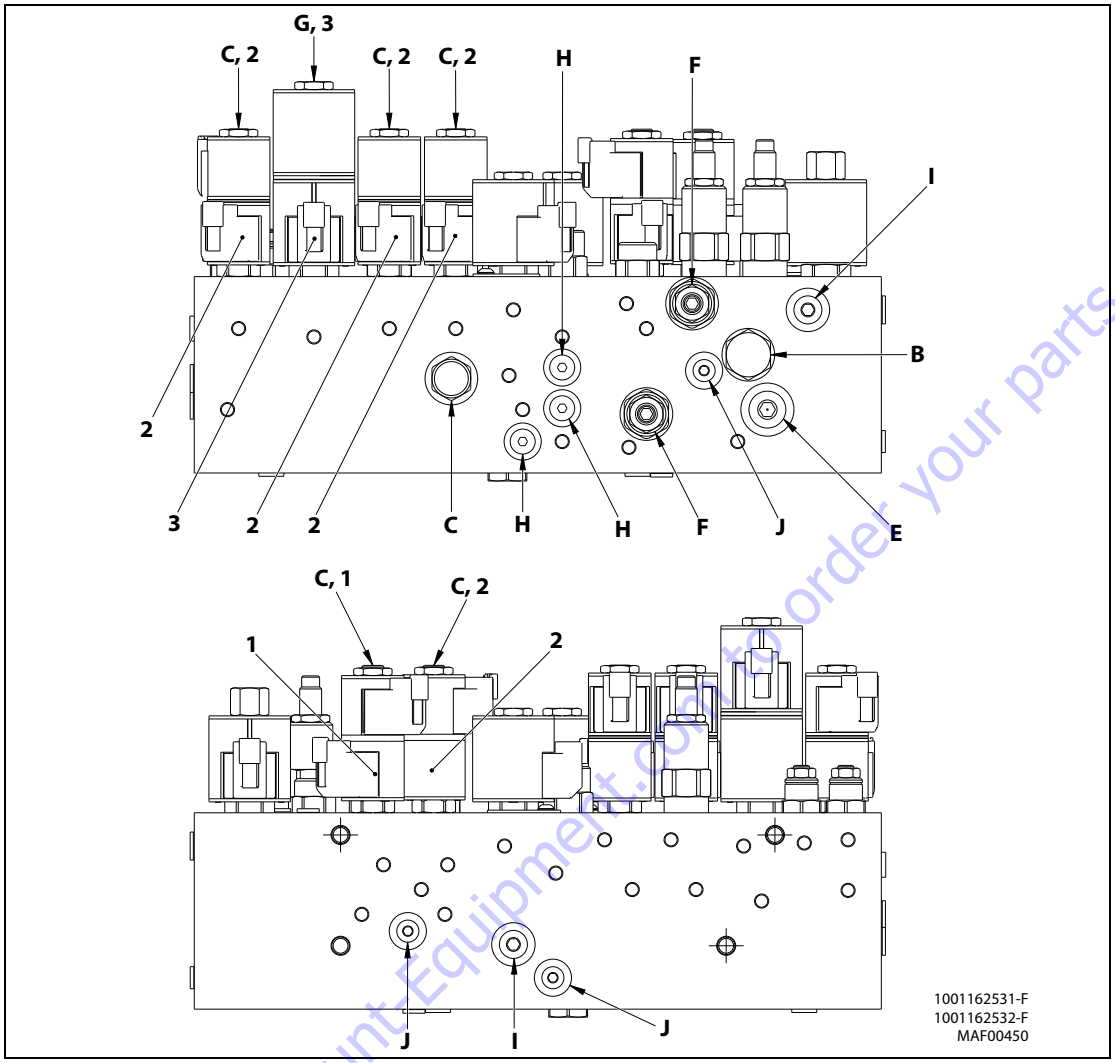


Table 5-33. Cartridge Torque Values

	Ft. lbs.	Nm
A	48	65
B	43	58
C	38	51
D	35	47
E	30	41
F	28	38
G	25	34
H	13	18
I	12	16
J	8	11

Table 5-34. Coil Torque Values

	Ft. lbs.	Nm
1	4.5	6
2	4.5	6
3	6	8

Table 5-35. Coil Resistance Values

	Temperature	Resistance
1	20°C	6.2
2	20°C	8.8
3	20°C	7.1

Figure 5-129. Main Control Valve Torque Values - Sheet 2 of 2

5.5 DRIVE PUMP PRE-FILL PROCEDURE

The case of the hydraulic drive pump, MUST be pre-filled before starting the engine. Failure to do so can cause premature failure of the pump.

1. Fill the hydraulic reservoir.
2. Determine if the hydraulic oil tank sight level gauge is higher than other hydraulic components.
   - **a.** Determine if the hydraulic oil tank sight level gauge is higher than the hydraulic drive pump assembly.
   - **b.** Determine if the hydraulic oil tank sight level gauge is higher than all hydraulic hose loops or routings between the hydraulic tank and the drive pump assembly.
   - **c.** If sight level gauge is the highest hydraulic oil level point, proceed to step 3.
   - **d.** If sight level gauge is NOT the highest hydraulic oil level point, low pressure air may need to be applied to the hydraulic oil tank (fill cap via air regulator) in conjunction with step 4 to get hydraulic oil to move over the air locks created by these high spots.
3. If the machine is be equipped with a hydraulic oil cooler option:
   - **a.** Determine if there is a hydraulic 'tee' fitting installed at the hydraulic drive pump that has a 'cap' fitting attached to it. (this will generally be at or near the top of the hydraulic drive pump body). This 'cap' fitting is to be used to manually fill the hydraulic drive pump case.
   - **b.** Remove 'cap' fitting.
   - **c.** Fill hydraulic drive pump case with hydraulic oil.
   - **d.** Reattach and torque 'cap' fitting.
   - **e.** Prefilling of the hydraulic drive pump w/oil cooler option is complete (Step #4 can be omitted at this point).s
4. If machine is NOT equipped with a hydraulic oil cooler option,
   - **a.** Locate a case access port on the hydraulic drive pump. Preferably one located at or near the top or upper sides of the pump.
   - **b.** Using the proper wrench, remove the o-ring plug to allow air to escape from the hydraulic drive pump case.
   - **c.** Hydraulic oil will flow by gravity from the hydraulic tank to the drive pump.
   - **d.** When hydraulic oil starts to flow out this port, the pump is full.
   - **e.** Re-install the o-ring plug and torque.
5. Pre-filling of the hydraulic drive pump is complete.

5.6 HYDRAULIC SCHEMATICS

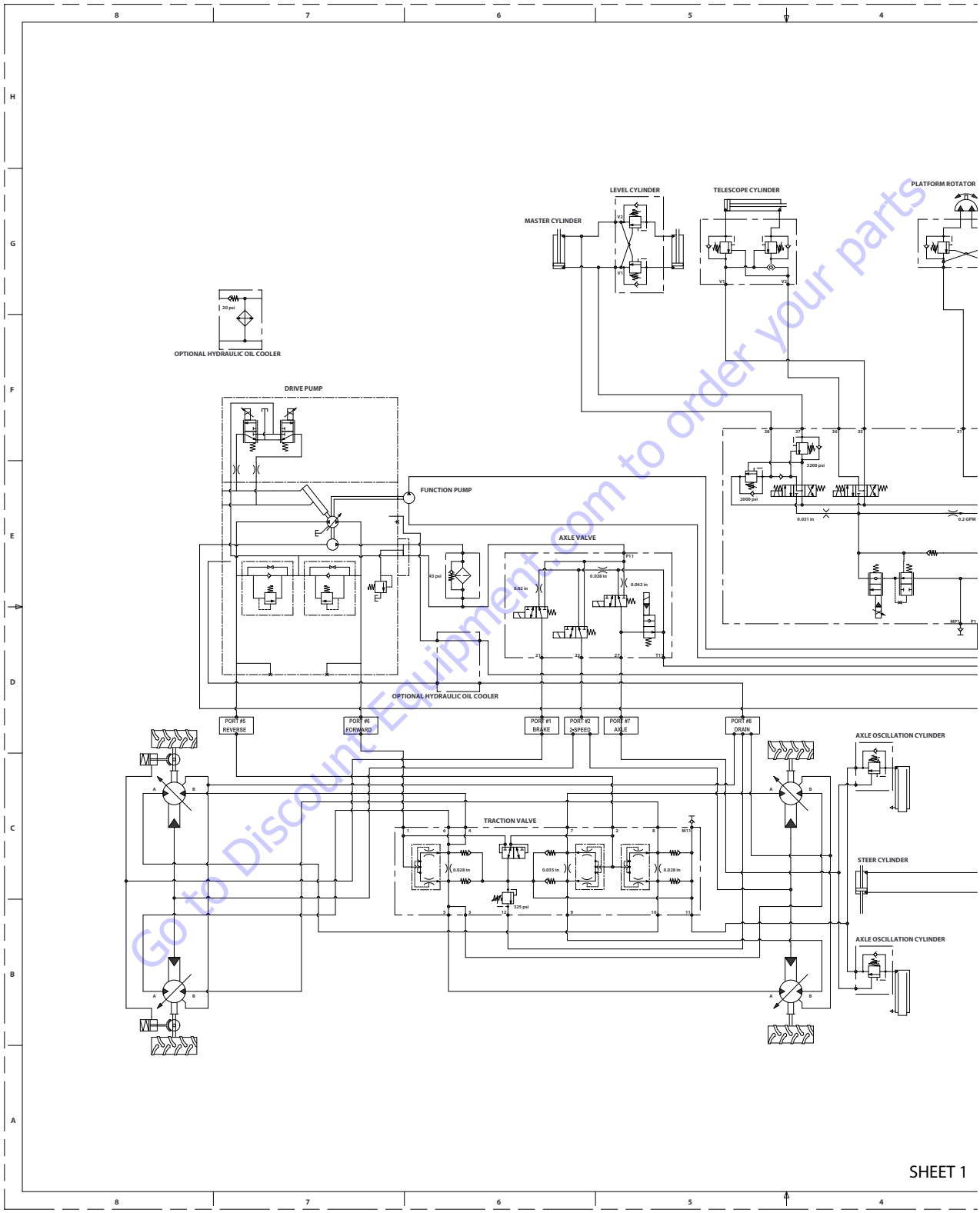


Figure 5-130. Hydraulic Schematic - Sheet 1 of 8

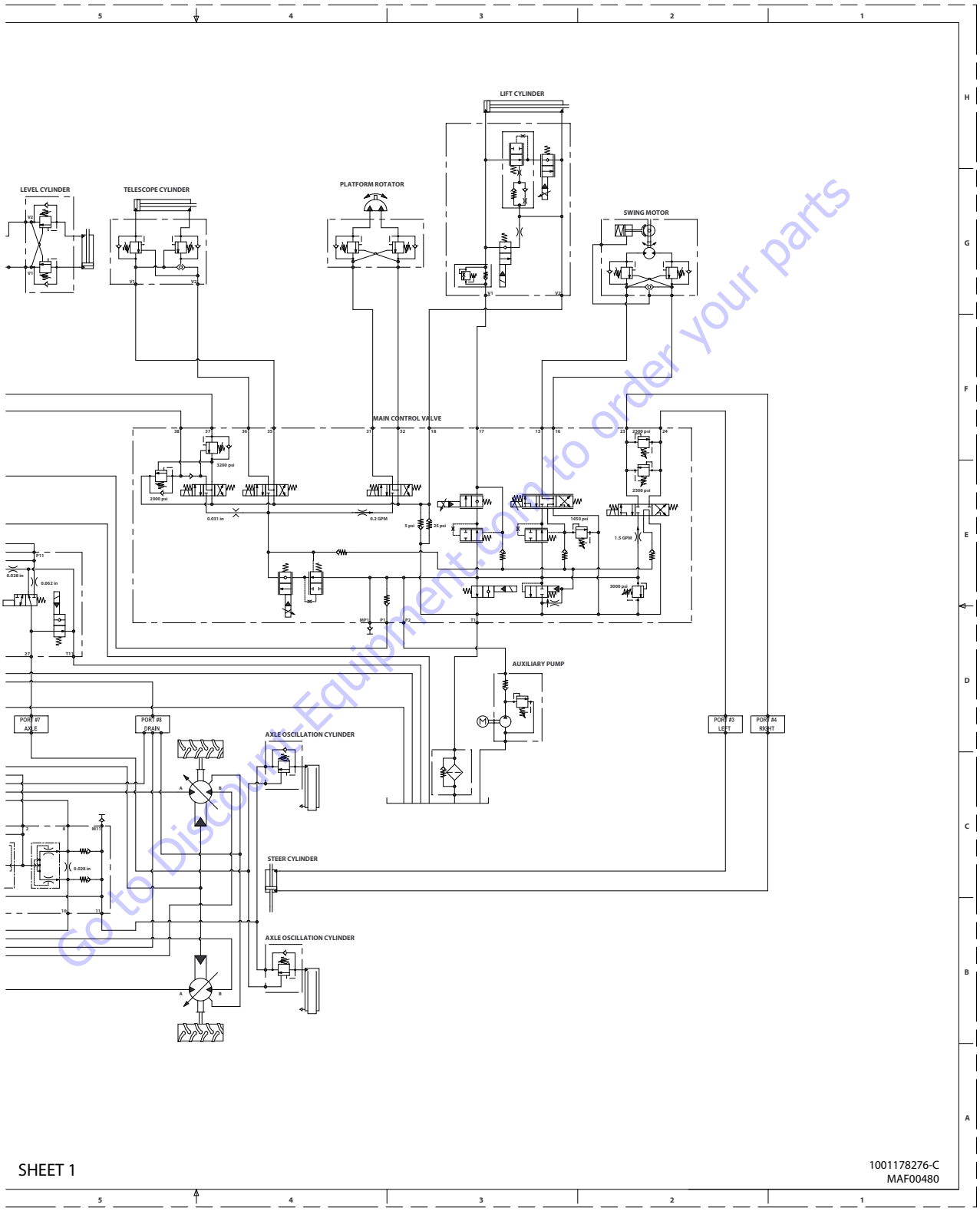


Figure 5-131. Hydraulic Schematic - Sheet 2 of 8

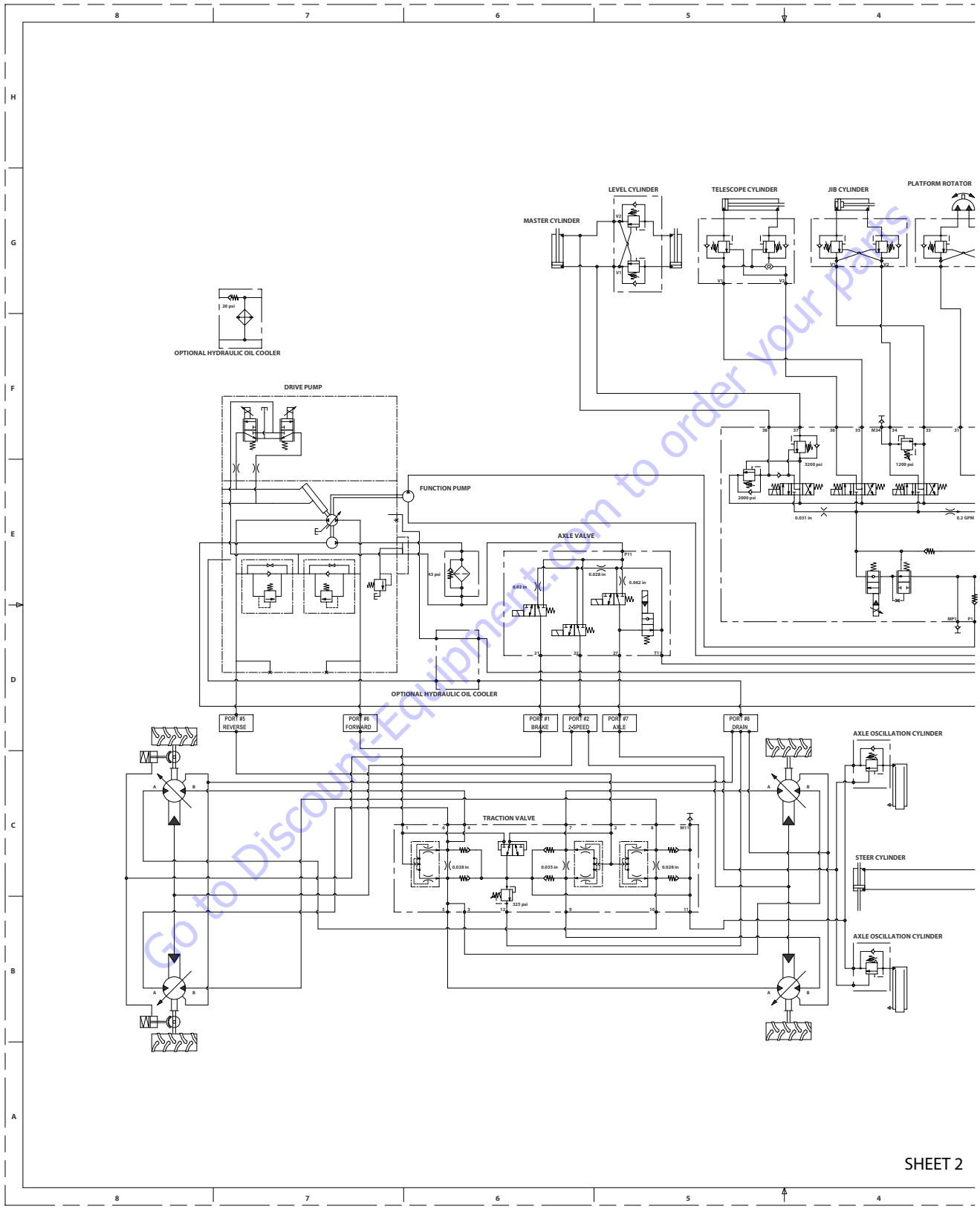


Figure 5-132. Hydraulic Schematic - Sheet 3 of 8

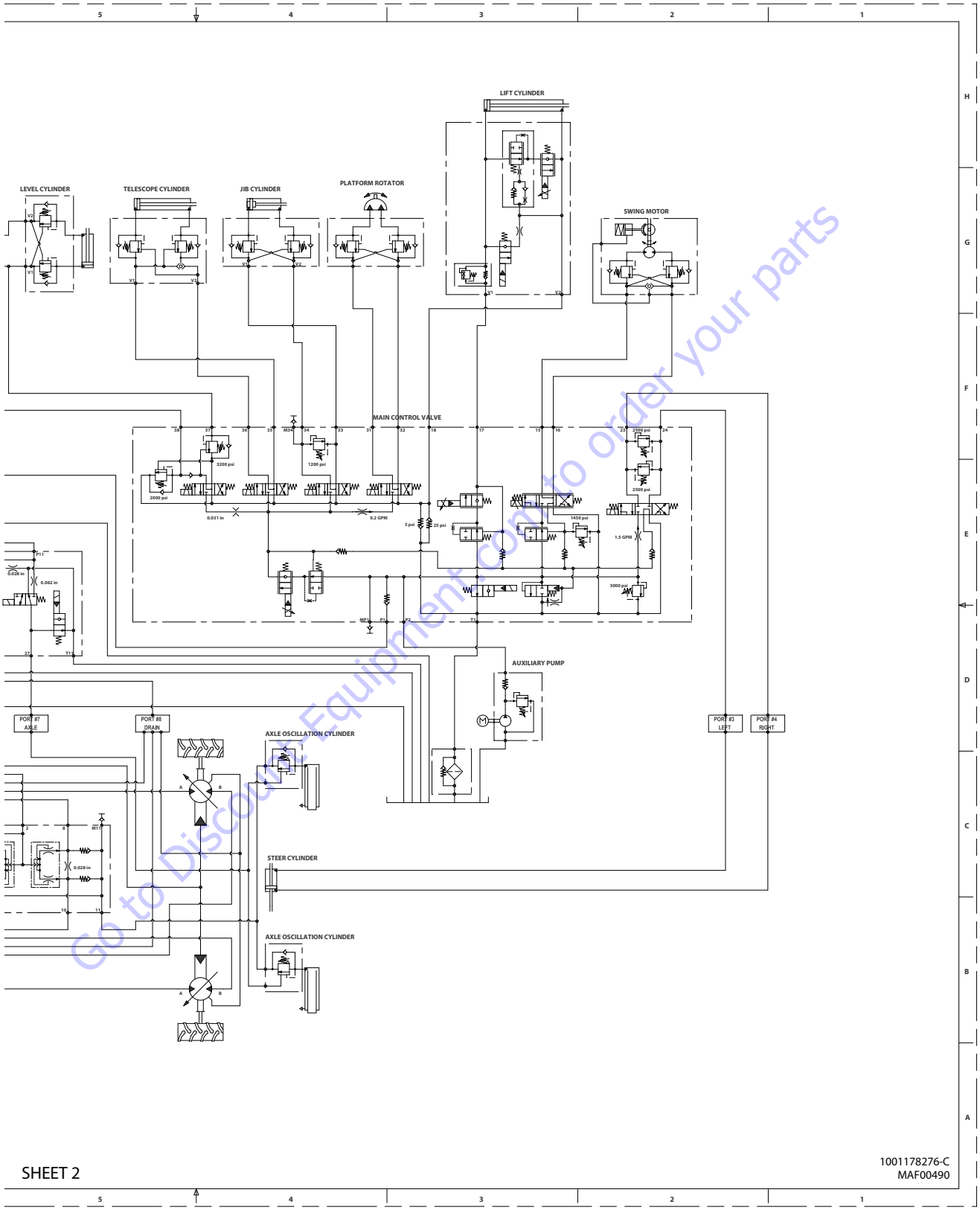


Figure 5-133. Hydraulic Schematic - Sheet 4 of 8

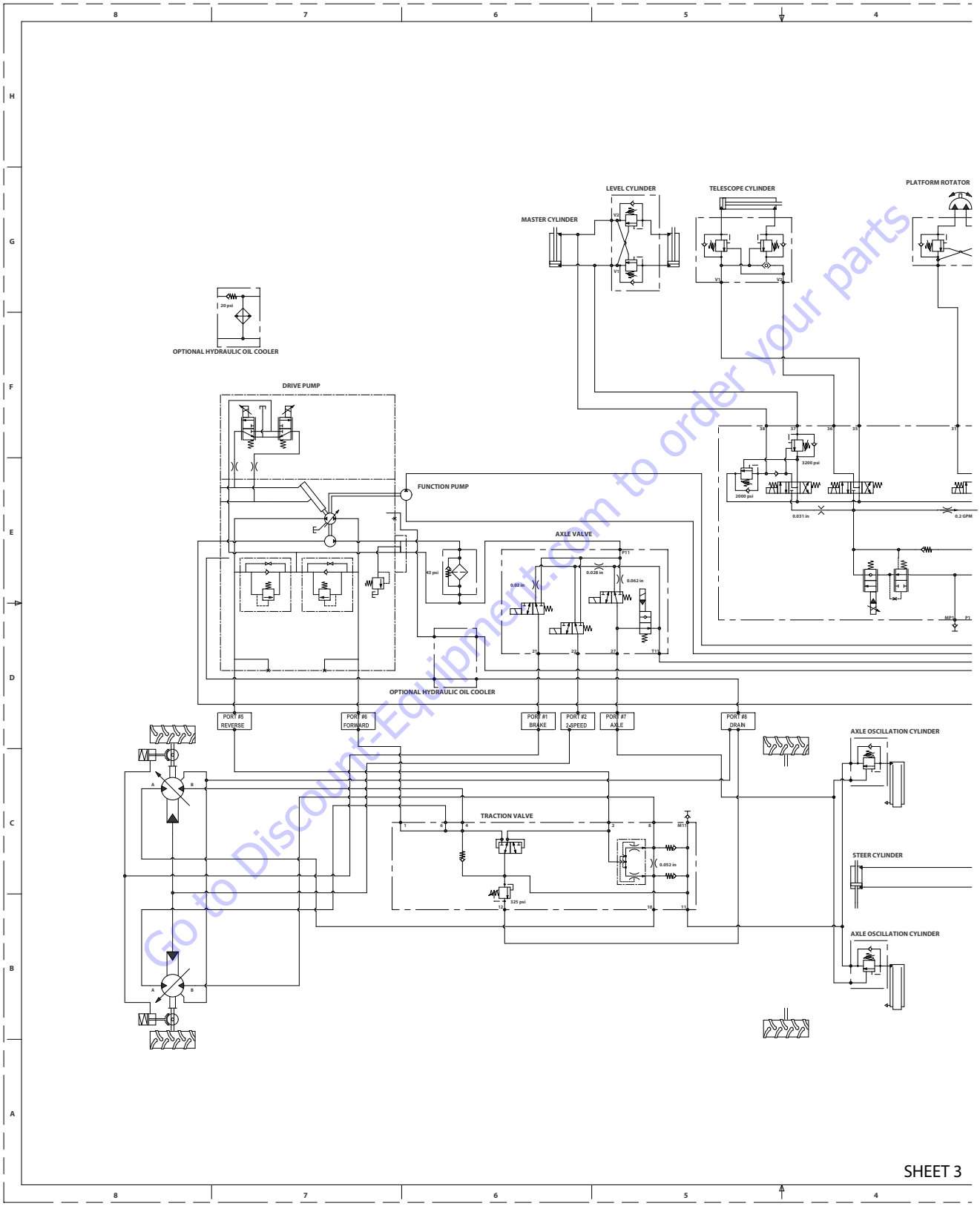


Figure 5-134. Hydraulic Schematic - Sheet 5 of 8

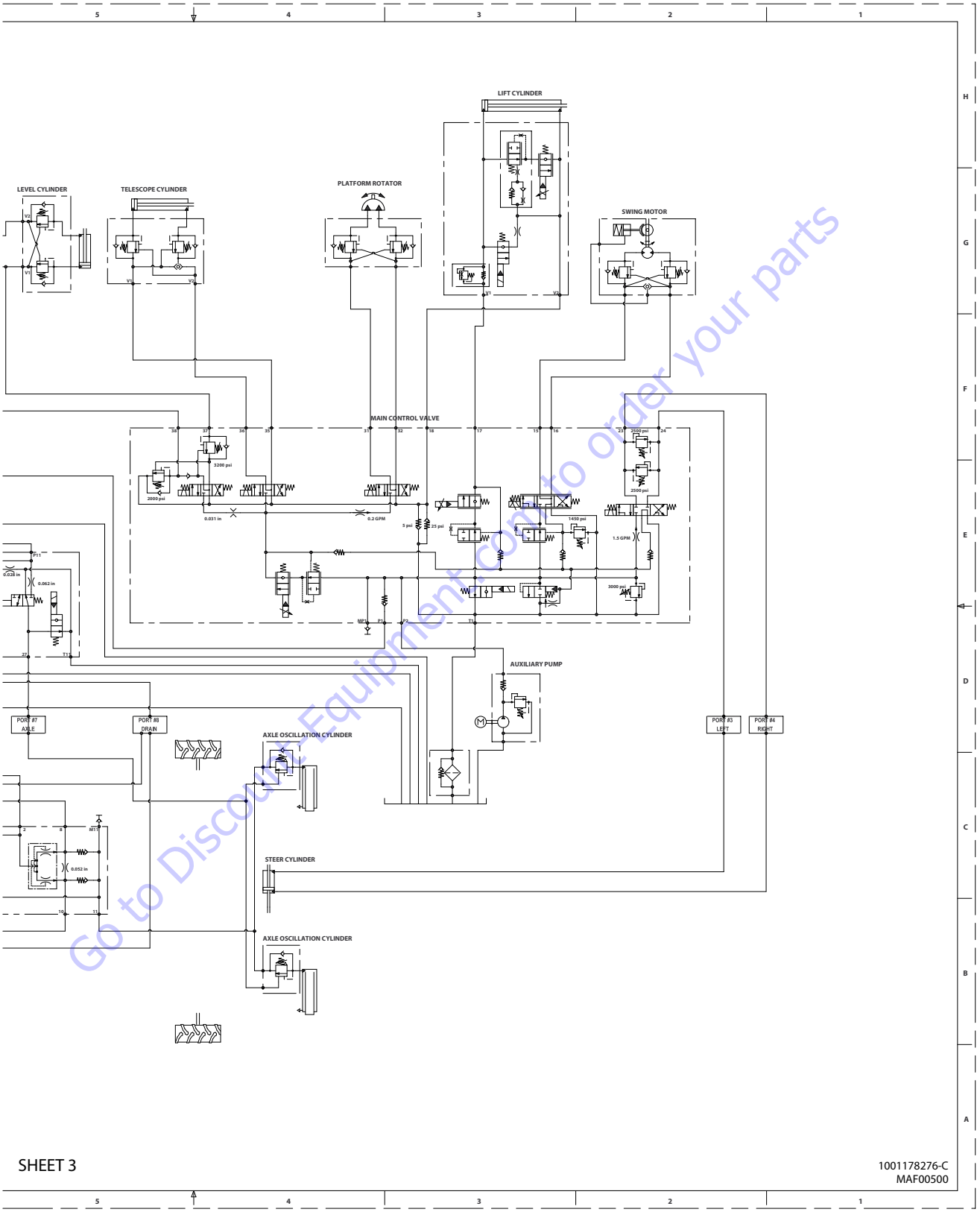


Figure 5-135. Hydraulic Schematic - Sheet 6 of 8

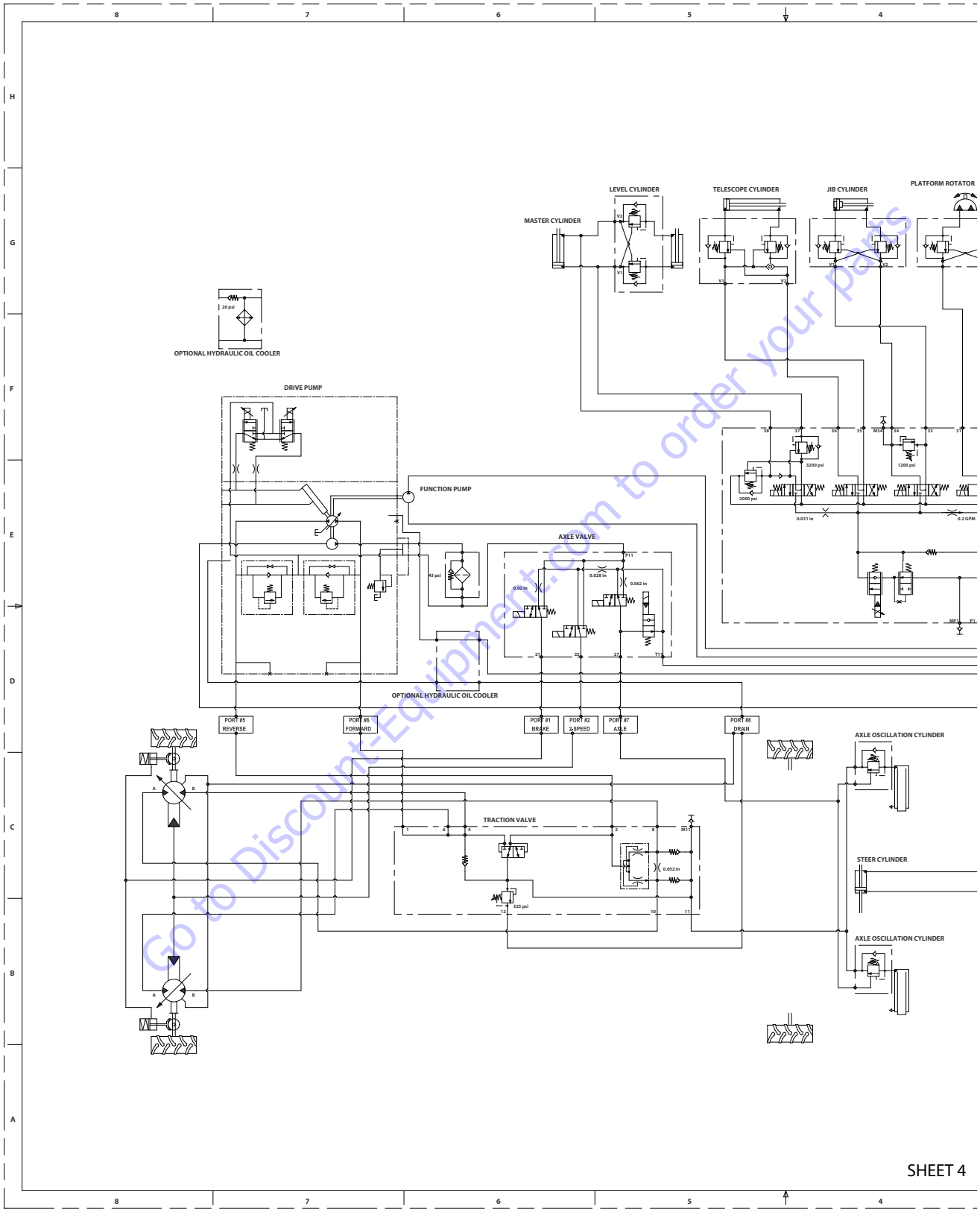


Figure 5-136. Hydraulic Schematic - Sheet 7 of 8

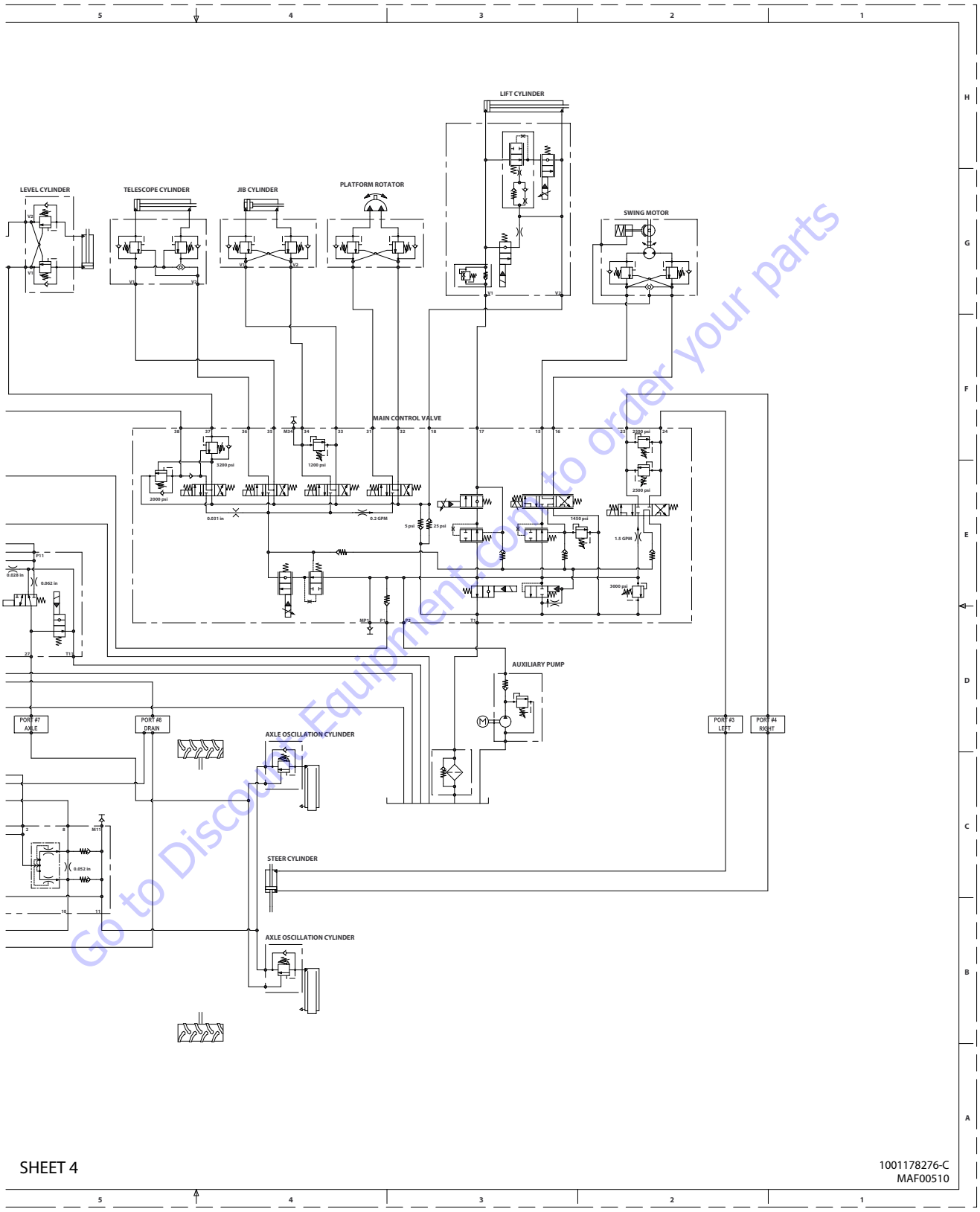
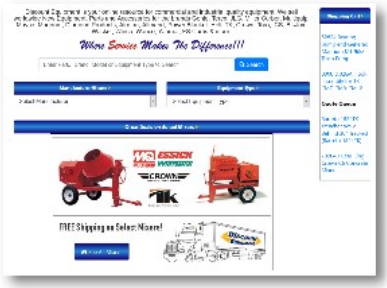


Figure 5-137. Hydraulic Schematic - Sheet 8 of 8

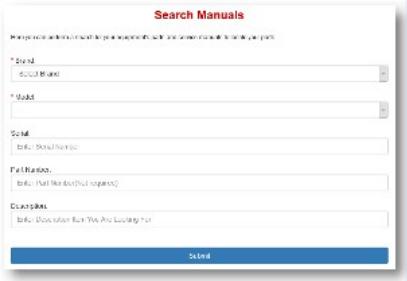
PARTS FINDER

Search Website by Part Number

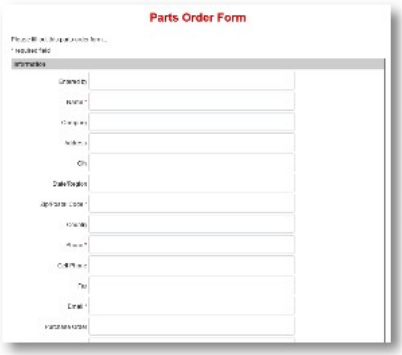
Discount Equipment



Search Manual Library For Parts Manual & Lookup Part Numbers – Purchase or Request Quote



Can't Find Part or Manual? Request Help by Manufacturer, Model & Description



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We sell worldwide for the brands: Genie, Terex, JLG, MultiQuip, Mikasa, Essick, Whiteman, Mayco, Toro Stone, Diamond Products, Generac Magnum, Airman, Haulotte, Barreto, Power Blanket, Nifty Lift, Atlas Copco, Chicago Pneumatic, Allmand, Miller Curber, Skyjack, Lull, Skytrak, Tsurumi, Husquvarna Target, , Stow, Wacker, Sakai, Mi-T- M, Sullair, Basic, Dynapac, MBW, Weber, Bartell, Bennar Newman, Haulotte, Ditch Runner, Menegotti, Morrison, Contec, Buddy, Crown, Edco, Wyco, Bomag, Laymor, Barreto, EZ Trench, Bil-Jax, F.S. Curtis, Gehl Pavers, Heli, Honda, ICS/PowerGrit, IHI, Partner, Imer, Clipper, MMD, Koshin, Rice, CH&E, General Equipment, ,AMida, Coleman, NAC, Gradall, Square Shooter, Kent, Stanley, Tamco, Toku, Hatz, Kohler, Robin, Wisconsin, Northrock, Oztec, Toker TK, Rol-Air, Small Line, Wanco, Yanmar

SECTION 6. JLG CONTROL SYSTEM

6.1 JLG CONTROL SYSTEM ANALYZER KIT INSTRUCTIONS

Introduction

NOTICE

WHEN INSTALLING A NEW POWER MODULE CONTROLLER ON THE MACHINE, IT WILL BE NECESSARY TO PROGRAM THE CONTROLLER FOR THE PROPER MACHINE CONFIGURATION, INCLUDING OPTIONS.

NOTICE

IT IS A GOOD PRACTICE TO AVOID PRESSURE-WASHING ELECTRICAL/ELECTRONIC COMPONENTS. SHOULD PRESSURE-WASHING BE UTILIZED TO WASH AREAS CONTAINING ELECTRICAL/ELECTRONIC COMPONENTS, JLG INDUSTRIES, INC. RECOMMENDS A MAXIMUM PRESSURE OF 750 PSI (52 BAR) AT A MINIMUM DISTANCE OF 12 INCHES (30.5 CM) AWAY FROM THESE COMPONENTS. IF ELECTRICAL/ELECTRONIC COMPONENTS ARE SPRAYED, SPRAYING MUST NOT BE DIRECT AND BE FOR BRIEF TIME PERIODS TO AVOID HEAVY SATURATION.

The JLG designed Control System is a 12 volt based control unit installed on the boom lift.

The JLG Control System has reduced the need for exposed terminal strips, diodes and trimpots and provides simplicity in viewing and adjusting the various personality settings for smooth control of: acceleration, deceleration, creep, min speed, and max.-speed for all boom, drive, and steering functions.

The main lift, swing, and drive are controlled by individual joysticks, with steering being controlled by a rocker switch built into the top the drive joystick. To activate Drive, Lift, and Swing simply pull up on the slide lock location on the joystick and move the handle into the direction desired.

The control system will control the voltage output to the valves and pump, as programmed for smooth operation and maximum cycle time. Ground control speeds for all boom functions can also be programmed into the control system.

The JLG Control System controller has a built in LED to indicate any faults. The system stores recent faults which may be accessed for troubleshooting. Optional equipment includes a soft touch system, head and tail lights, and ground alarm. These options may be added later but must be programmed into the control system when installed.

The Control System may be accessed utilizing a custom designed, hand held analyzer (Analyzer Kit, JLG part no. 2901443) which will display two lines of information at a time, by scrolling through the program.

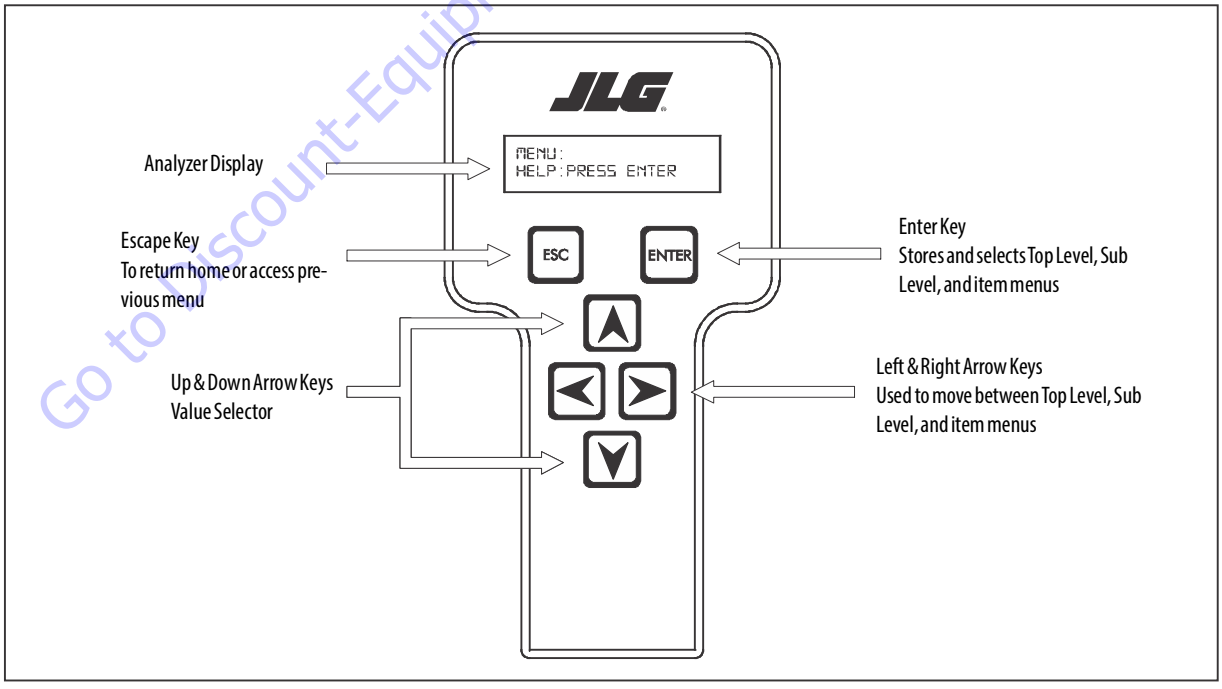


Figure 6-1. Hand Held Analyzer

To Connect the JLG Control System Analyzer

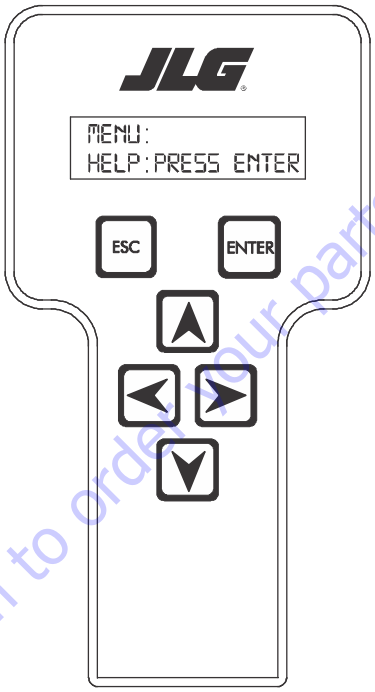
1. Connect the four pin end of the cable supplied with the analyzer, to the motor controller module located in the platform box or at the power module and connect the remaining end of the cable to the analyzer.

NOTE: *The cable has a four pin connector at each end of the cable; the cable cannot be connected backwards.*

2. Power up the Control System by turning the lower key to the platform or ground position and pulling both emergency stop buttons on.

Using the Analyzer

With the machine power on and the analyzer connected properly, the analyzer will display the following:



HELP:
PRESS ENTER

At this point, using the RIGHT  and LEFT  arrow keys, you can move between the top level menu items. To select a displayed menu item, press ENTER  . To cancel a selected menu item, press Escape  ; then you will be able to scroll using the right and left arrow keys to select a different menu item.

The top level menus are as follows:

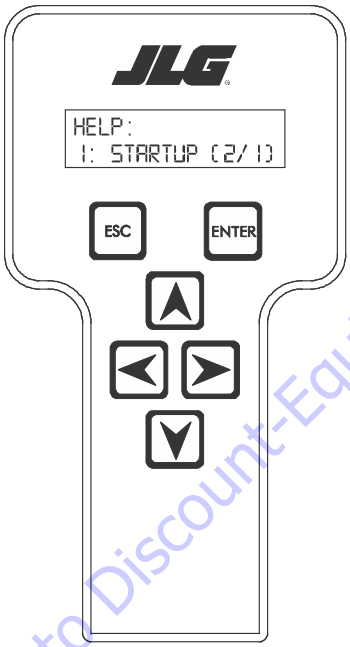
HELP
DIAGNOSTICS
ACTIVATE TEST
ACCESS LEVEL
PERSONALITIES
MACHINE SETUP
LEVEL VEHICLE (level 1 only)
CALIBRATIONS (view only)

If you press **ENTER** 

, at the **HELP: PRESS ENTER** display, and a fault is present, the analyzer display will scroll the fault across the screen. If there was no fault detected, the display will read: **HELP: EVERYTHING OK.** If powered up at the ground station, the display will read: **GROUND OK.**

If **ENTER** 

is pressed again, the display moves to the following display:



LOGGED HELP
1: STARTUP (2/1)

At this point, the analyzer will display the last fault the system has seen, if any are present. You may scroll through the fault logs to view what the last 25 faults were. Use the right and left arrow keys to scroll through the fault logs. To return to the beginning, press **ESCAPE** 

two times. **STARTUP (2/1)** indicates a power up.

When a top level menu is selected, a new set of menu items may be offered: for example:

DRIVE
BOOM
SYSTEM
DATALOG
VERSIONS

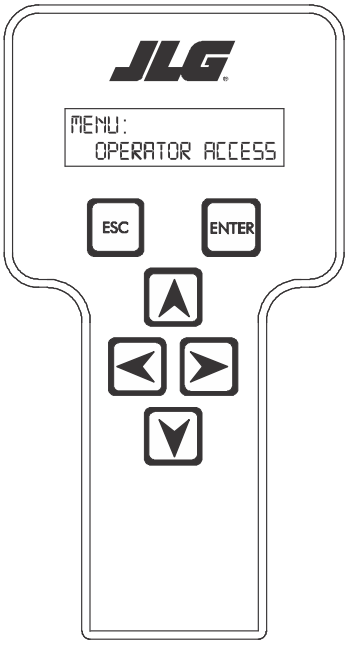
Pressing **ENTER** 

with any of the above displayed menus, will display additional sub-menus within the selected menu. In some cases, such as **DRIVE**, the next level is the parameter or information to be changed. Refer to the flow chart for what menus are available within the top level menus. You may only view the personality settings for selected menus while in access level 2. Remember, you may always cancel a selected menu item by pressing the **ESCAPE** 

key.

Changing the Access Level of the Hand Held Analyzer

When the analyzer is first connected, you will be in Operator Access which enables you to only view most settings which cannot be changed until you enter a password to advance to a lower level. This ensures that a setting cannot be accidentally altered. To change the access level, the correct password must be entered. To enter the password, scroll to the **ACCESS LEVEL** menu. For example:



ACCESS LEVEL:
CODE 00000

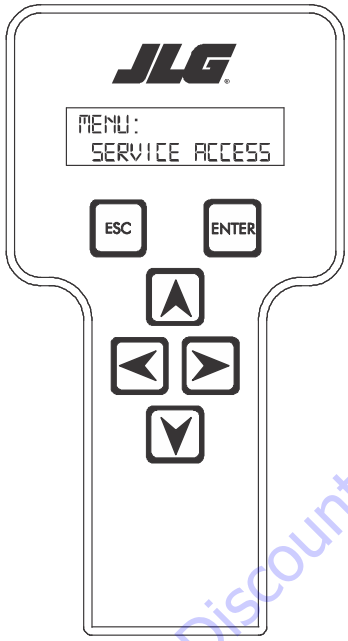
Press **ENTER** to select the **ACCESS LEVEL** menu.

Using the **UP** or **DOWN** arrow keys, enter the first digit of the password, 3.

Then using the **RIGHT** arrow key, position the cursor to the right one space to enter the second digit of the password.

Use the **UP** or **DOWN** arrow key to enter the second digit of the password which is 33271.

Once the correct password is displayed, press **ENTER**. The access level should display the following, if the password was entered correctly:

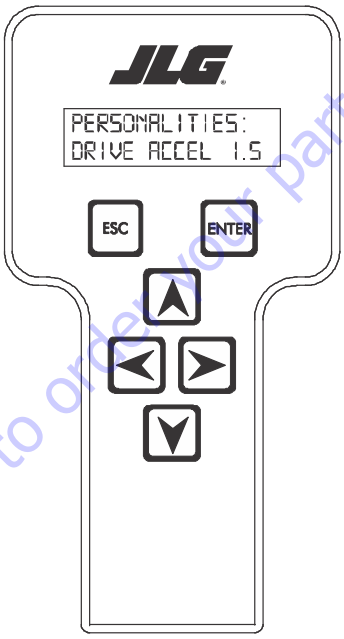


MENU:
SERVICE ACCESS

Repeat the above steps if the correct access level is not displayed or you can not adjust the personality settings.

Adjusting Parameters Using the Hand Held Analyzer

Once you have gained access to level 1, and a personality item is selected, press the **UP** or **DOWN** arrow keys to adjust its value, for example:

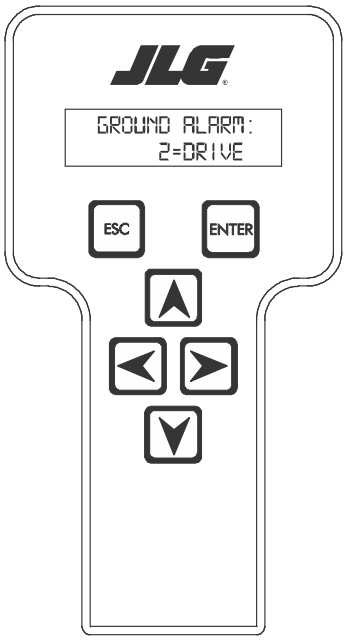


DRIVE:
ACCEL 1.5s

There will be a minimum and maximum for the value to ensure efficient operation. The Value will not increase if the **UP** arrow is pressed when at the maximum value nor will the value decrease if the **DOWN** arrow is pressed and the value is at the minimum value for any particular personality. If the value does not change when pressing the up and down arrows, check the access level to ensure you are at access level 1.

Machine Setup

When a machine digit item is selected, press the **UP** or **DOWN** arrow keys to adjust its value, for example:



GROUND ALARM:
2 = DRIVE

The effect of the machine digit value is displayed along with its value. The above display would be selected if the machine was equipped with a ground alarm and you wanted it to sound when driving. There are certain settings allowed to install optional features or select the machine model.

When selection the machine model to match the size of the machine, the personality settings will all default to the factory recommended setting.

NOTE: *Refer to Personality Ranges/Defaults for the recommended factory settings.*

NOTE: *Password 33271 will give you access to level 1, which will permit you to change all machine personality settings.*

There is a setting that JLG strongly recommends that you do not change. This setting is so noted below:

ELEVATION CUTBACK

⚠ WARNING

CHANGING THIS SETTING MAY ADVERSELY AFFECT THE PERFORMANCE OF YOUR MACHINE.

NOTICE

ITS IS A GOOD PRACTICE TO AVOID PRESSURE-WASHING ELECTRICAL/ELECTRONIC COMPONENTS. SHOULD PRESSURE-WASHING BE UTILIZED TO WASH AREAS CONTAINING ELECTRICAL/ELECTRONIC COMPONENTS, JLG INDUSTRIES INC. RECOMMENDS A MAXIMUM PRESSURE OF 750 PSI (52 BAR) AT A MINIMUM DISTANCE OF 12 INCHES (30.5CM) AWAY FROM THESE COMPONENTS. IF ELECTRICAL/ELECTRONIC COMPONENTS ARE SPRAYED, SPRAYING MUST NOT BE DIRECT AND BE FOR BRIEF TIME PERIODS TO AVOID HEAVY SATURATION.

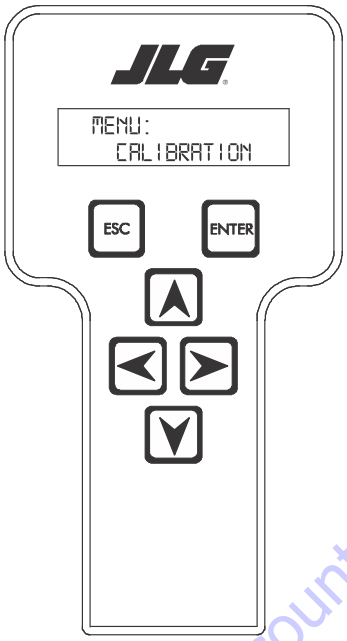
Tilt Sensor Calibration

Refer to Figure 6-2., Tilt Sensor Location.

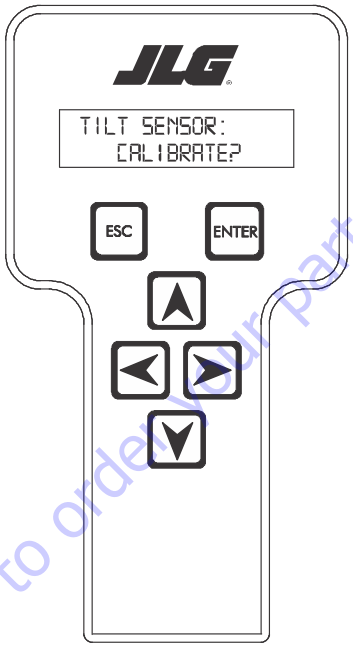
⚠ WARNING

DO NOT CALIBRATE THE TILT SENSOR EXCEPT ON A LEVEL SURFACE.

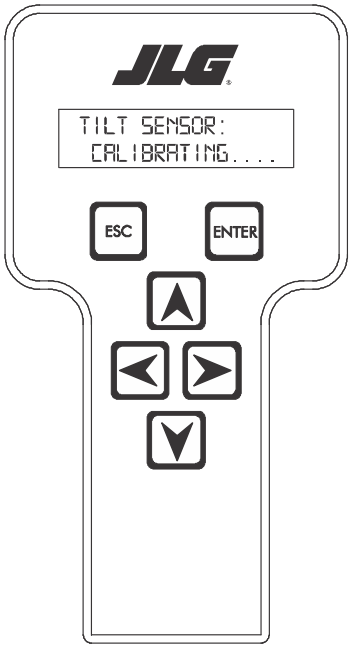
1. Place the machine on a firm, level surface.
2. Using the analyzer, go to Service Access level. Refer to Changing the Access Level of the Hand Held Analyzer in this section.
3. Using the arrow keys, navigate to Calibrations Menu as shown below and press **ENTER** (ENTER).



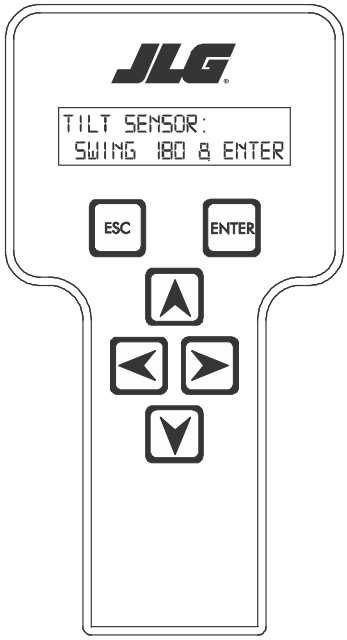
4. Using the arrow keys, navigate to the Tilt Sensor calibration as shown below and press **ENTER** (ENTER).



the screen will then read:

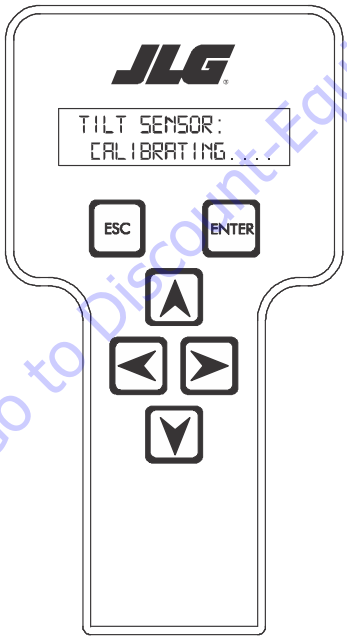


5. When the sensor is calibrated in that position, the screen will read:

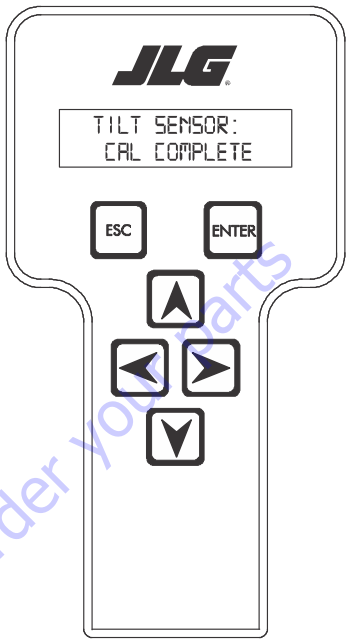


6. Swing the machine 180 degrees, making sure the boom is centered and in the transport position, and **ENTER** 

. The screen will read:



7. When the calibration is complete the screen will read as shown below. Return the machine to the travel position.



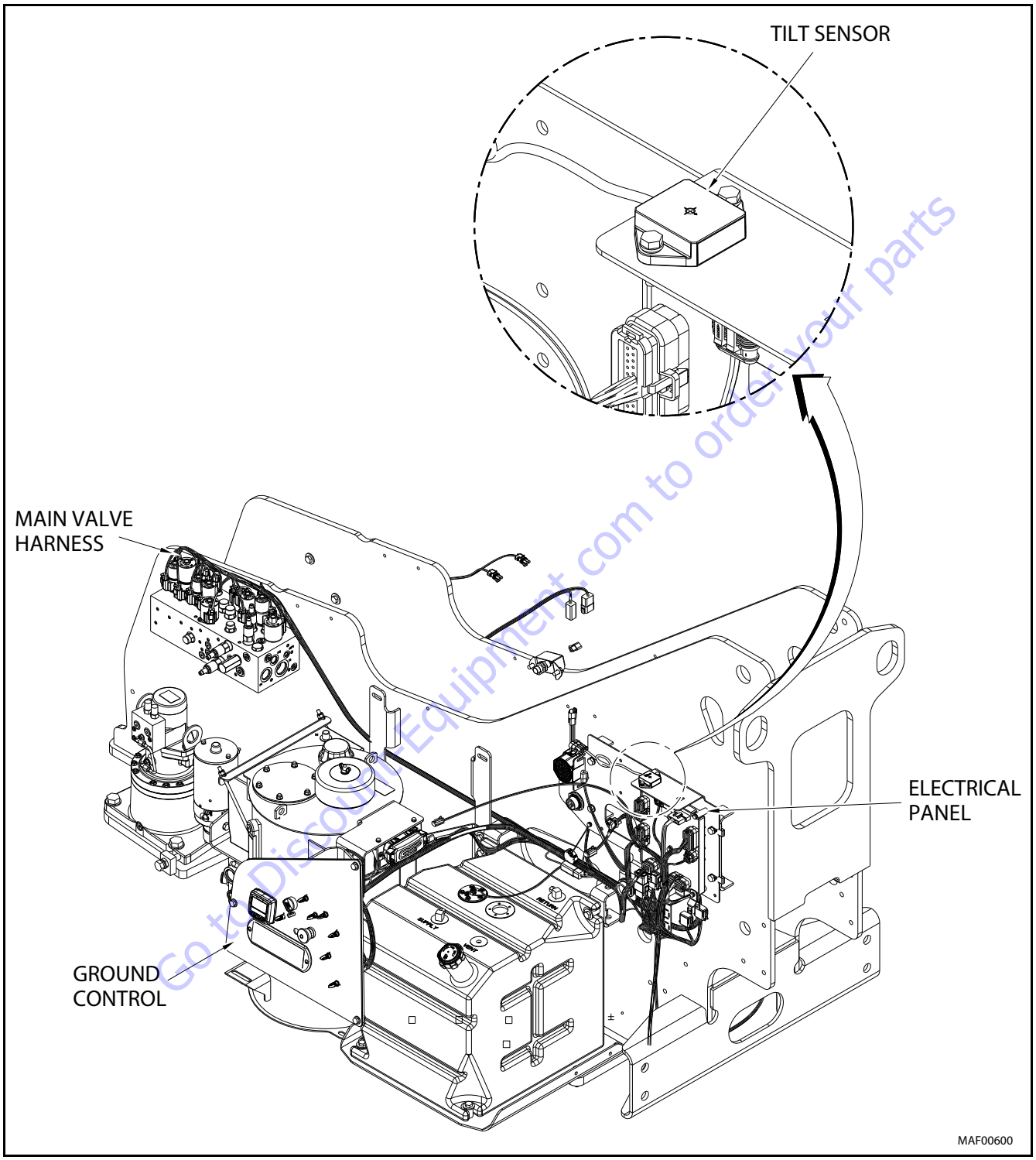


Figure 6-2. Tilt Sensor Location

Ground Control Console Display Gauge

(See Figure 6-6., Ground Control Console Display Gauge)

The Display Gauge shows engine hours, fuel level (if applicable), and Diagnostic Trouble Codes (DTCs) from both the JLG Control System and the engine control system. During machine start up, with no active DTCs in the control system, the splash screen will show for 3 seconds and then switch to main screen. If there is an active DTC while powering up the machine, the splash screen will show for 3 seconds, and then launch the Diagnostics Screen. The indicator lamp will light when there is an active DTC in the Fault Log.

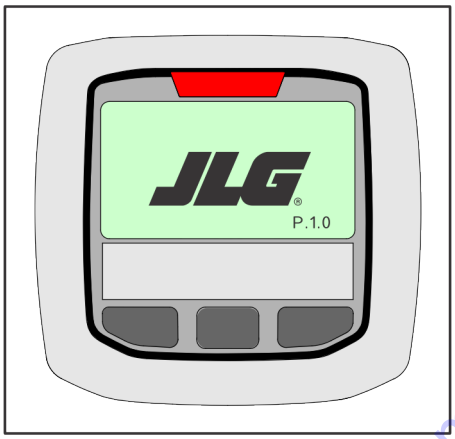


Figure 6-3. Splash Screen

The Diagnostic Screen will show active and inactive faults from the JLG Control System on the screen. An asterisk (*) will be displayed to show active faults.

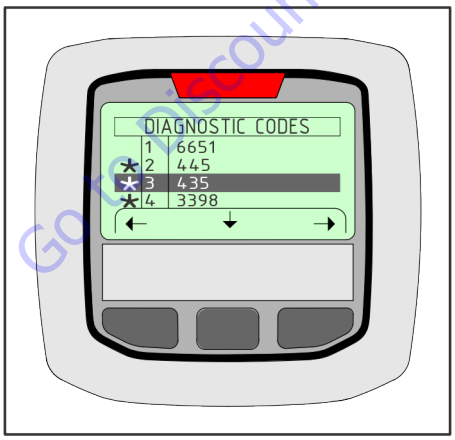


Figure 6-4. Diagnostic Screen

The Engine Diagnostics Screen will show SPN (Suspect Parameter Number), FMI (Failure Mode Identifier), and Occurrence count information. Engine SPN text is not scrollable. If there is more than one engine trouble code, the operator must exit from the Engine DTC Screen to see other SPN and FMI information.

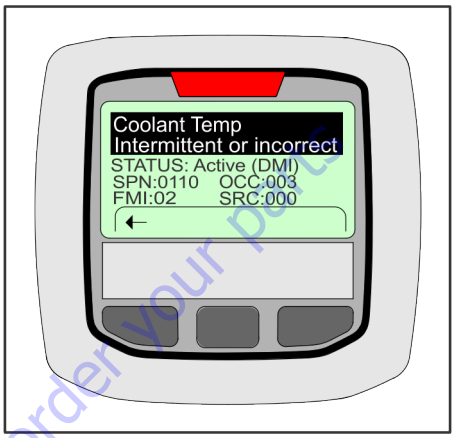


Figure 6-5. Engine Diagnostic Screen

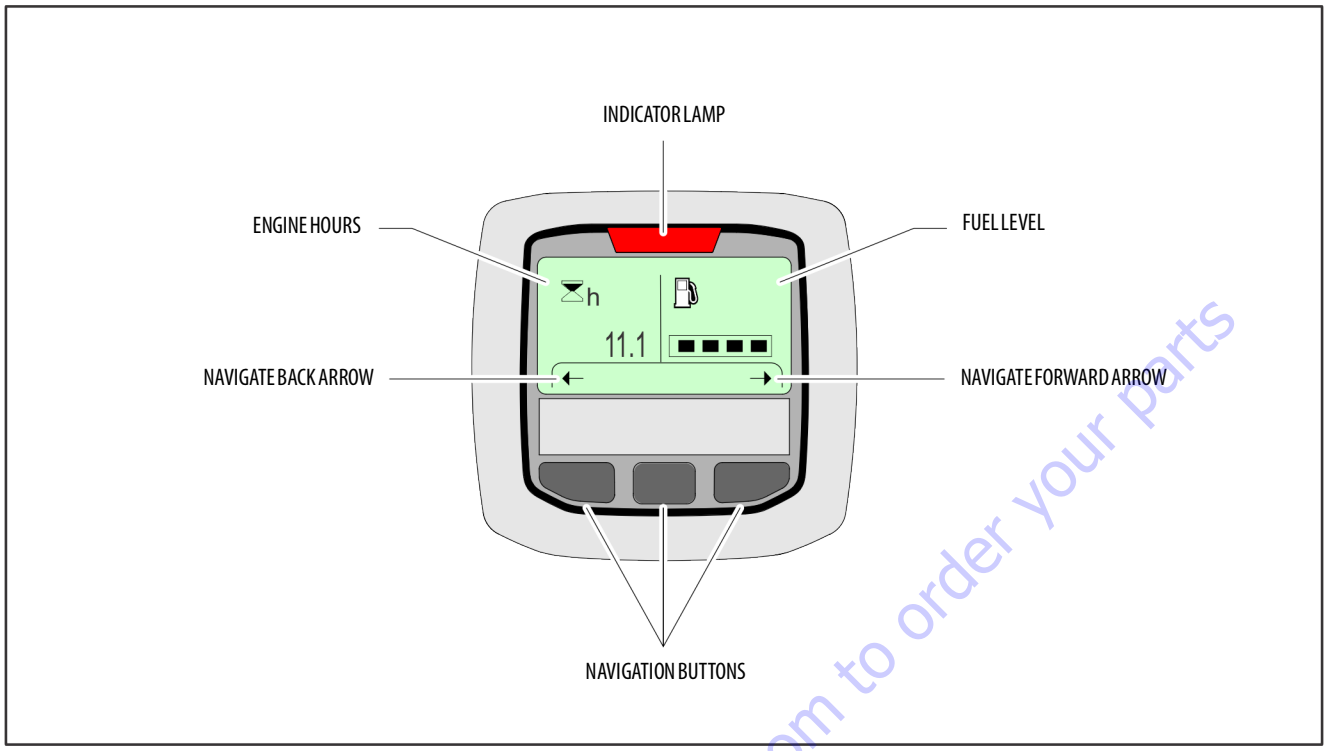


Figure 6-6. Ground Control Console Display Gauge

Table 6-1. Analyzer Abbreviations

ABBREVIATION	MEANING
ACCEL	ACCELERATE
ACT	ACTIVE
A/D	ANALOG DIGITAL CONVERTER COUNT
AMB.	AMBIENT
ANG	ANGLE
AUX	AUXILIARY
BCS	BOOM CONTROL SYSTEM
BM	BOOM LENGTH ANGLE MODULE
BLAM	BOOM LENGTH ANGLE MODULE
BR	BROKEN
BSK	BASKET
CAL	CALIBRATION
CL	CLOSED
CM	CHASSIS MODULE
CNTL	CONTROL
CNTRL	CONTROL
C/O	CUT OUT
CONT(S)	CONTRACTOR(S)
COOR	COORDINATED
CRK PT	CRACK POINT
CRP	CREEP
CUT	CUTOUT
CYL	CYLINDER
DECEL	DECELERATE
D	DOWN
DN	DOWN
DWN	DOWN
DEG.	DEGREE
DOS	DRIVE ORIENTATION SYSTEM
DRV	DRIVE
E	ERROR
E&T	ELEVATED & TILTED
ELEV	ELEVATION
ENG	ENGINE
EXT	EXTEND
F	FRONT
FL	FLOW
FNT	FRONT
FOR	FORWARD
FWD	FORWARD
FSW	FOOT SWITCH
FUNC	FUNCTION
G	GROUND

Table 6-1. Analyzer Abbreviations

ABBREVIATION	MEANING
GND	GROUND
GRN	GREEN
GM	GROUND MODULE
H	HOURS
HW	HARDWARE
HWFS	HARDWARE FAILSAFE
I	IN or CURRENT
JOY	JOYSTICK
L	LEFT
LB	POUND
LEN	LENGTH
LIM	LIMIT
LT	LEFT
LVL	LEVEL
M	MINUTES
MIN	MINIMUM
MAX	MAXIMUM
M	MAIN
MN	MAIN
NO	NORMALLY OPEN or NO
NC	NORMALLY CLOSED
O	OUT
O/C	OPEN CIRCUIT
OP	OPEN
O/R	OVERRIDE or OUTRIGGER
O//R	OVERRIDE
OSC	OSCILLATING
OVRD	OVERRIDE
P	PLATFORM
P	PRESSURE
PCV	PROPORTIONAL CONTROL VALVE
PLAT	PLATFORM
PLT	PLATFORM
PM	PLATFORM MODULE
POT	POTENTIOMETER
PRES	PRESSURE
PRS	PRESSURE
PT	POINT
R	REAR or RIGHT
REV	REVERSE or REVISION
RET	RETRACT
ROT.	ROTATE
RT	RIGHT

Table 6-1. Analyzer Abbreviations

ABBREVIATION	MEANING
S/C	SHORT CIRCUIT
SEL	SELECTOR
SN	SERIAL NUMBER
SPD	SPEED
STOW	STOWED
STOWD	STOWED
SW	SWITCH or SOFTWARE
TELE	TELESCOPE
TEMP	TEMPERATURE
TORQ.	TORQUE
TRN	TRANSPORT
T/T	TURNTABLE
T	TOWER
TURNTBL	TURNTABLE
TWR	TOWER
U	UPPER or UP
V	VOLT
VER	VERSION
VLV	VALVE
WIT	WITNESS
YEL	YELLOW

Figure 6-7. Analyzer Connecting Points

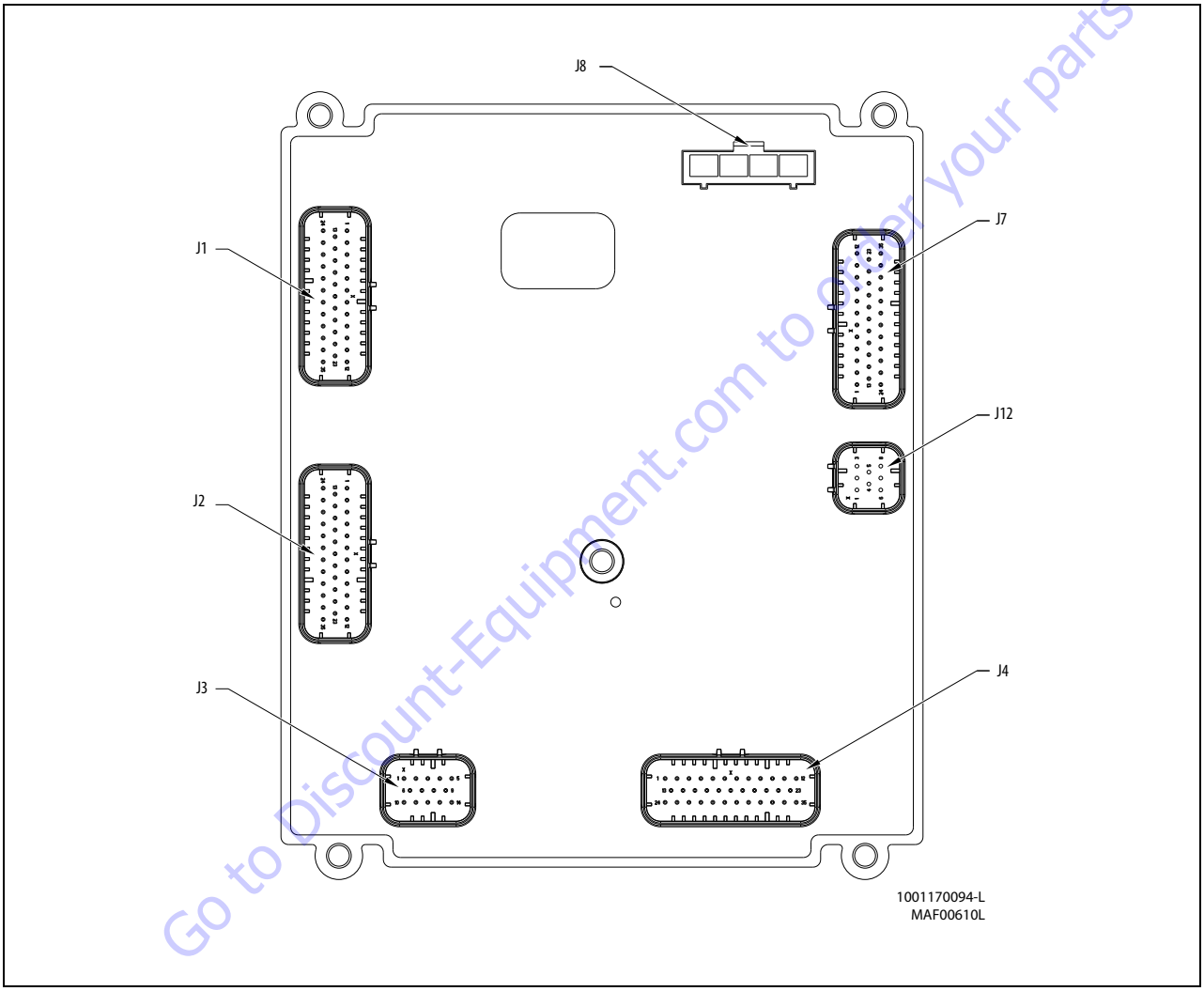


Figure 6-8. Ground Control Module Pin Connections

Connector	Pin	Function	Type	
J1 (Natural)	1	UNUSED (PROPORTIONAL FUEL RACK ACTUATOR)	DIGITAL	OUTPUT
	2	OSCILLATING AXLE VALVE #2	DIGITAL	OUTPUT
	3	DRIVE FORWARD / LEFT TRACK DRIVE FORWARD VALVE	DIGITAL	OUTPUT
	4	UNUSED (GROUND)	GROUND	INPUT
	5	UNUSED (GROUND)	GROUND	INPUT
	6	DRIVE REVERSE / LEFT TRACK DRIVE REVERSE VALVE	DIGITAL	OUTPUT
	7	OSCILLATING AXLE VALVE #1	DIGITAL	OUTPUT
	8	UNUSED (GROUND)	GROUND	INPUT
	9	MSSO SWITCH GROUND	GROUND	INPUT
	10	ECU POWER	DIGITAL	OUTPUT
	11	START RELAY	DIGITAL	OUTPUT
	12	ENGAGE GLOW PLUGS RELAY	DIGITAL	OUTPUT
	13	APU ENABLE RELAY	DIGITAL	OUTPUT
	14	UNUSED (ENGINE COOLANT TEMPERATURE SENSOR)	ANALOG	INPUT
	15	UNUSED (ENGINE OIL PRESSURE SENSOR)	ANALOG	INPUT
	16	UNUSED (ENGINE SPEED SENSOR)	FREQUENCY	INPUT
	17	UNUSED (ENGINE SPEED SENSOR GROUND)	GROUND	INPUT
	18	UNUSED (ENGINE GROUND)	GROUND	INPUT
	19	UNUSED (GROUND)	GROUND	INPUT
	20	2 SPEED VALVE	DIGITAL	OUTPUT
	21	UNUSED (TOWER ELEVATION SWITCH #2)	DIGITAL	INPUT
	22	GENERATOR ENABLE RELAY	DIGITAL	OUTPUT
	23	BRAKE VALVE	DIGITAL	OUTPUT
	24	UNUSED	N/C	N/C
	25	UNUSED (RESERVED FOR RS-485 HIGH)	SERIAL	I/O
	26	UNUSED (RESERVED FOR RS-485 LOW)	SERIAL	I/O
	27	BRAKE / 2 SPEED VALVE GROUND	GROUND	INPUT
	28	ANALYZER POWER	VOLTAGE	OUTPUT
	29	ANALYZER RS-232 RX	SERIAL	INPUT
	30	ANALYZER RS-232 TX	SERIAL	OUTPUT
	31	ANALYZER GROUND	GROUND	INPUT
	32	ALTERNATOR EXCITATION	DIGITAL	OUTPUT
	33	UNUSED (GROUND)	GROUND	INPUT
	34	TELESCOPE RETRACTED SWITCH #2	DIGITAL	INPUT
	35	CAPACITY LENGTH SWITCH #2	DIGITAL	INPUT

Connector	Pin	Function	Type	
J2 (Gray)	1	UNUSED (STEER DUMP VALVE)	DIGITAL	OUTPUT
	2	GROUND ALARM	DIGITAL	OUTPUT
	3	UNUSED (TOWER TELESCOPE IN VALVE)	DIGITAL	OUTPUT
	4	MAIN TELESCOPE IN VALVE	DIGITAL	OUTPUT
	5	PLATFORM LEVEL UP VALVE	DIGITAL	OUTPUT
	6	FUEL SENSOR GROUND	GROUND	INPUT
	7	PLATFORM LEVEL DOWN VALVE	DIGITAL	OUTPUT
	8	FRONT STEER RIGHT / RIGHT TRACK DRIVE REVERSE VALVE	DIGITAL	OUTPUT
	9	AUX MAIN LIFT DOWN / TOWER LIFT DOWN VALVE	DIGITAL	OUTPUT
	10	PLATFORM ROTATE LEFT VALVE	DIGITAL	OUTPUT
	11	MAIN LIFT UP VALVE	DIGITAL	OUTPUT
	12	JIB LIFT UP VALVE	DIGITAL	OUTPUT
	13	MAIN DUMP VALVE	DIGITAL	OUTPUT
	14	MAIN TELESCOPE / PLATFORM LEVEL VALVES GROUND	GROUND	INPUT
	15	UNUSED (TOWER TELESCOPE OUT VALVE)	DIGITAL	OUTPUT
	16	MAIN TELESCOPE OUT VALVE	DIGITAL	OUTPUT
	17	PLATFORM ROTATE / JIB LIFT VALVE GROUND	GROUND	INPUT
	18	UNUSED (STEER DUMP VALVE GROUND)	GROUND	INPUT
	19	FRONT LEFT STEER / RIGHT TRACK DRIVE FORWARD VALVE	DIGITAL	OUTPUT
	20	TOWER LIFT UP VALVE	DIGITAL	OUTPUT
	21	AUX MAIN LIFT DOWN / PLATFORM ROTATE RIGHT VALVE	DIGITAL	OUTPUT
	22	MAIN LIFT DOWN VALVE	DIGITAL	OUTPUT
	23	AUX TOWER LIFT DOWN / JIB LIFT DOWN VALVE	DIGITAL	OUTPUT
	24	UNUSED (CONFIGURATION #2)	DIGITAL	INPUT
	25	FUEL SENSOR SIGNAL	ANALOG	INPUT
	26	HEAD / TAIL LIGHT ENABLE RELAY	DIGITAL	OUTPUT
	27	GROUND ALARM / HORN OUTPUT	DIGITAL	OUTPUT
	28	STEER VALVES GROUND	GROUND	INPUT
	29	GROUND ALARM GROUND	GROUND	INPUT
	30	MAIN DUMP VALVE GROUND	GROUND	INPUT
	31	FLOW CONTROL VALVE	DIGITAL	OUTPUT
	32	UNUSED (REAR STEER RIGHT VALVE)	DIGITAL	OUTPUT
	33	UNUSED (REAR STEER LEFT VALVE)	DIGITAL	OUTPUT
	34	SWING LEFT VALVE	DIGITAL	OUTPUT
	35	SWING RIGHT VALVE	DIGITAL	OUTPUT

Connector	Pin	Function	Type	
J3 (Black)	1	DRIVE / LEFT TRACK DRIVE VALVES CURRENT FEEDBACK	GROUND	INPUT
	2	AUX DOWN / RIGHT TRACK DRIVE VALVES CURRENT FEEDBACK	GROUND	INPUT
	3	UNUSED (CABLE BRAKE SWITCH GROUND)	GROUND	INPUT
	4	SWING VALVES CURRENT FEEDBACK	GROUND	INPUT
	5	TOWER LIFT / AUX DOWN VALVES CURRENT FEEDBACK	GROUND	INPUT
	6	FLOW CONTROL VALVE CURRENT FEEDBACK	GROUND	INPUT
	7	GROUND ALARM POWER	VBAT	OUTPUT
	8	UNUSED (CABLE BRAKE SWITCH)	DIGITAL	INPUT
	9	CRIBBING ENABLE SWITCH	DIGITAL	INPUT
	10	UNUSED (INPUT)	DIGITAL	INPUT
	11	UNUSED (CONFIGURATION #1)	DIGITAL	INPUT
	12	UNUSED (+5 VOLTS)	VOLTAGE	OUTPUT
	13	UNUSED (INPUT)	ANALOG	INPUT
	14	MAIN LIFT VALVES CURRENT FEEDBACK	GROUND	INPUT

Connector	Pin	Function	Type	
J4 (Blue)	1	CRIBBING ENGAGED INDICATOR	DIGITAL	OUTPUT
	2	SYSTEM DISTRESS INDICATOR	DIGITAL	OUTPUT
	3	GLOWPLUG INDICATOR	DIGITAL	OUTPUT
	4	ENGINE START SWITCH	DIGITAL	INPUT
	5	PLATFORM LEVEL DOWN SWITCH	DIGITAL	INPUT
	6	PLATFORM ROTATE LEFT SWITCH	DIGITAL	INPUT
	7	MAIN TELESCOPE IN SWITCH	DIGITAL	INPUT
	8	JIB LIFT DOWN SWITCH	DIGITAL	INPUT
	9	UNUSED (JIB LEFT SWITCH)	DIGITAL	INPUT
	10	TOWER LIFT UP SWITCH	DIGITAL	INPUT
	11	UNUSED (TOWER TELESCOPE IN SWITCH)	DIGITAL	INPUT
	12	UNUSED (OUTPUT)	DIGITAL	OUTPUT
	13	LOW FUEL INDICATOR	DIGITAL	OUTPUT
	14	PLATFORM OVERLOADED INDICATOR	DIGITAL	OUTPUT
	15	UNUSED (BOOM MALFUNCTION INDICATOR)	DIGITAL	OUTPUT
	16	AUXILIARY POWER / FUNCTION ENABLE SWITCH	DIGITAL	INPUT
	17	PLATFORM LEVEL UP SWITCH	DIGITAL	INPUT
	18	PLATFORM ROTATE RIGHT SWITCH	DIGITAL	INPUT
	19	JIB LIFT UP SWITCH	DIGITAL	INPUT
	20	UNUSED (JIB RIGHT SWITCH)	DIGITAL	INPUT
	21	TOWER LIFT DOWN SWITCH	DIGITAL	INPUT
	22	UNUSED (TOWER TELESCOPE OUT SWITCH)	DIGITAL	INPUT
	23	MAIN LIFT UP SWITCH	DIGITAL	INPUT
	24	UNUSED (BATTERY VOLTAGE)	VBAT	OUTPUT
	25	SWITCHES POWER	VBAT	OUTPUT
	26	BATTERY LOW / NOT CHARGING INDICATOR	DIGITAL	OUTPUT
	27	UNUSED (OUTPUT)	DIGITAL	OUTPUT
	28	ENGINE HIGH COOLANT TEMPERATURE INDICATOR	DIGITAL	OUTPUT
	29	ENGINE LOW OIL PRESSURE INDICATOR	DIGITAL	OUTPUT
	30	MAIN TELESCOPE OUT SWITCH	DIGITAL	INPUT
	31	INDICATORS GROUND	GROUND	INPUT
	32	INDICATORS GROUND	GROUND	INPUT
	33	MAIN LIFT DOWN SWITCH	DIGITAL	INPUT
	34	SWING LEFT SWITCH	DIGITAL	INPUT
	35	SWING RIGHT SWITCH	DIGITAL	INPUT

Connector	Pin	Function	Type	
J7 (Black)	1	PLATFORM EMS	DIGITAL	INPUT
	2	PLATFORM MODE	DIGITAL	INPUT
	3	GROUND MODE	DIGITAL	INPUT
	4	BOOM ANGLE SENSOR #1	ANALOG	INPUT
	5	UNUSED (ENGINE SPEED SENSOR)	VOLTAGE	OUTPUT
	6	CAN1 TERMINATOR	TERM	I/O
	7	BOOM ANGLE SENSOR #2	ANALOG	INPUT
	8	UNUSED (INPUT)	ANALOG	INPUT
	9	BOOM ANGLE SENSOR GROUND	GROUND	INPUT
	10	TILT SENSOR GROUND	GROUND	INPUT
	11	TOWER ELEVATION SWITCH	DIGITAL	INPUT
	12	OSCILLATING AXLE SWING SWITCH #1	DIGITAL	INPUT
	13	CAN1 HIGH	SERIAL	I/O
	14	GROUND MODE POWER TO PLATFORM	DIGITAL	INPUT
	15	FOOTSWITCH	DIGITAL	INPUT
	16	BOOM ANGLE SENSOR POWER	VOLTAGE	OUTPUT
	17	CAN1 TERMINATOR	TERM	I/O
	18	CAN1 SHIELD	GROUND	INPUT
	19	IGNITION RELAY GROUND	GROUND	INPUT
	20	OSCILLATING AXLE SWING SWITCH #2	ANALOG	INPUT
	21	TELESCOPE RETRACTED SWITCH #1	DIGITAL	INPUT
	22	UNUSED (INPUT)	DIGITAL	INPUT
	23	CAPACITY LENGTH SWITCH #1	DIGITAL	INPUT
	24	CAN1 LOW	SERIAL	I/O
	25	GROUND DISPLAY GROUND	GROUND	INPUT
	26	UNUSED (+5 VOLTS)	VOLTAGE	OUTPUT
	27	UNUSED (+5 VOLTS)	VOLTAGE	OUTPUT
	28	TELESCOPE RETRACTED SWITCH GROUND	GROUND	INPUT
	29	GROUND DISPLAY POWER	VBAT	OUTPUT
	30	UNUSED (BATTERY VOLTAGE)	VBAT	OUTPUT
	31	UNUSED (BATTERY VOLTAGE)	VBAT	OUTPUT
	32	TRANSPORT SWITCHES POWER	VBAT	OUTPUT
	33	TELESCOPE RETRACTED SWITCH POWER	VBAT	OUTPUT
	34	TILT SENSOR POWER	VBAT	OUTPUT
	35	DOS SWITCH	DIGITAL	INPUT

Connector	Pin	Function	Type	
J8 (Black)	1	MODULE GROUND	GROUND	OUTPUT
	2	MODULE POWER	VBAT	INPUT
	3	GROUND TO PLATFORM MODULE	GROUND	INPUT
	4	POWER TO PLATFORM MODULE	VBAT	OUTPUT

Connector	Pin	Function	Type	
J12 (RED)	1	UNUSED	FREQUENCY	INPUT
	2	UNUSED	FREQUENCY	INPUT
	3	CAN2 HIGH	SERIAL	I/O
	4	CAN2 LOW	SERIAL	I/O
	5	CAN2 SHIELD	GROUND	INPUT
	6	CAN2 TERMINATOR	TERM	I/O
	7	CAN2 TERMINATOR	TERM	I/O
	8	MSSO SWITCH	DIGITAL	INPUT

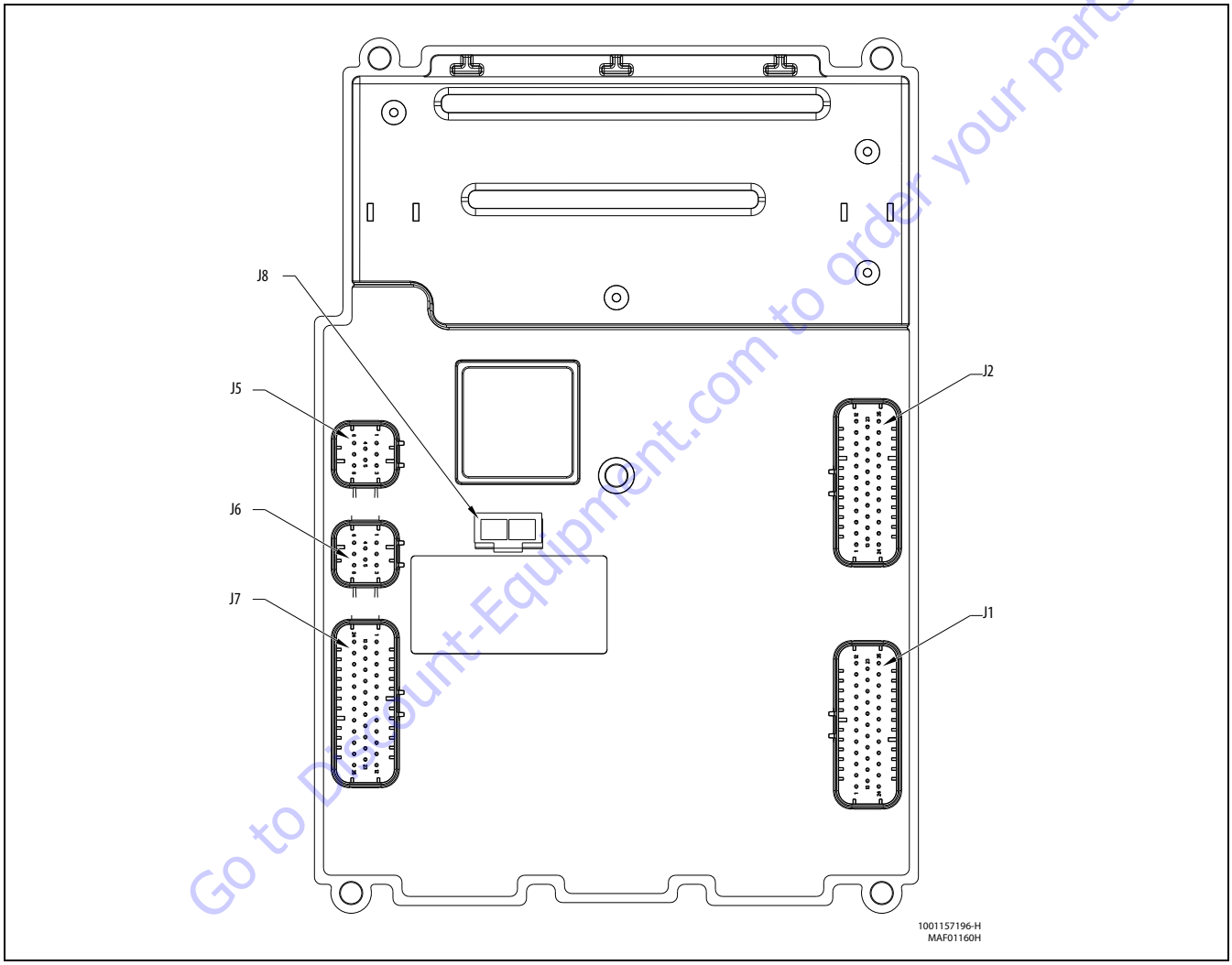


Figure 6-9. Platform Control Module Pin Connections

CONNECTOR	PIN	ASSIGNMENT	FUNCTION
J1 (Natural)	1	TOWER LIFT UP SWITCH	DIGITAL INPUT
	2	TOWER LIFT DOWN SWITCH	DIGITAL INPUT
	3	UNUSED (TOWER TELESCOPE IN SWITCH)	DIGITAL INPUT
	4	UNUSED (TOWER TELESCOPE OUT SWITCH)	DIGITAL INPUT
	5	MAIN TELESCOPE IN SWITCH	DIGITAL INPUT
	6	MAIN TELESCOPE OUT SWITCH	DIGITAL INPUT
	7	PLATFORM ROTATE RIGHT SWITCH	DIGITAL INPUT
	8	PLATFORM ROTATE LEFT SWITCH	DIGITAL INPUT
	9	PLATFORM LEVEL UP SWITCH	DIGITAL INPUT
	10	PLATFORM LEVEL DOWN SWITCH	DIGITAL INPUT
	11	JIB LIFT UP SWITCH	DIGITAL INPUT
	12	JIB LIFT DOWN SWITCH	DIGITAL INPUT
	13	SPEED PUMP POTENTIOMETER GROUND	GROUND
	14	ENGINE START SWITCH	DIGITAL INPUT
	15	AUXILIARY POWER SWITCH	DIGITAL INPUT
	16	UNUSED (CRAB STEER SELECT SWITCH)	DIGITAL INPUT
	17	UNUSED (COORDINATED STEER SELECT SWITCH)	DIGITAL INPUT
	18	SWITCH POWER	BATTERY VOLTAGE
	19	UNUSED	DIGITAL INPUT
	20	SOFT TOUCH SWITCH	DIGITAL INPUT
	21	UNUSED (CAPACITY SELECT SWITCH)	DIGITAL INPUT
	22	UNUSED	DIGITAL INPUT
	23	SKYGUARD INPUT #2 SWITCH	DIGITAL INPUT
	24	UNUSED	DIGITAL INPUT
	25	UNUSED	DIGITAL INPUT
	26	UNUSED	DIGITAL INPUT
	27	MAX SPEED SWITCH	DIGITAL INPUT
	28	MAX TORQUE SWITCH	DIGITAL INPUT
	29	SOFT TOUCH / SKYGUARD OVERRIDE BUTTON	DIGITAL INPUT
	30	HEAD / TAIL LIGHT SWITCH	DIGITAL INPUT
	31	HORN BUTTON	DIGITAL INPUT
	32	CREEP SWITCH	DIGITAL INPUT
	33	FUEL SELECT SWITCH	DIGITAL INPUT
	34	SPEED PUMP POTENTIOMETER POWER	+7 REFERENCE VOLTAGE
	35	SPEED PUMP POTENTIOMETER SIGNAL	DIGITAL INPUT

CONNECTOR	PIN	ASSIGNMENT	FUNCTION
J2 (Gray)	1	UNUSED (JIB RIGHT SWITCH)	DIGITAL INPUT
	2	UNUSED (JIB LEFT SWITCH)	DIGITAL INPUT
	3	UNUSED (POWER)	HS DIGITAL INPUT
	4	DOS OVERRIDE SWITCH	HS DIGITAL INPUT
	5	UNUSED	LAMP OUTPUT
	6	CHASSIS TILTED INDICATOR	LAMP OUTPUT
	7	FUNCTION ENABLE INDICATOR	LAMP OUTPUT
	8	VEHICLE SYSTEM DISTRESS INDICATOR	LAMP OUTPUT
	9	CREEP SPEED INDICATOR	LAMP OUTPUT
	10	UNUSED (BROKEN CABLE INDICATOR)	LAMP OUTPUT
	11	PLATFORM OVERLOADED INDICATOR	LAMP OUTPUT
	12	500 / 600 LB CAPACITY INDICATOR	LAMP OUTPUT
	13	1000 LB CAPACITY INDICATOR	LAMP OUTPUT
	14	DOS INDICATOR	LAMP OUTPUT
	15	GENERATOR ON INDICATOR	LAMP OUTPUT
	16	SOFT TOUCH / SKYGUARD INDICATOR	LAMP OUTPUT
	17	GLOW PLUG ENGAGED INDICATOR	LAMP OUTPUT
	18	INDICATOR GROUND	GROUND
	19	UNUSED (LOW BATTERY INDICATOR)	LAMP OUTPUT
	20	UNUSED	LAMP OUTPUT
	21	LOW FUEL INDICATOR	LAMP OUTPUT
	22	1/4 FUEL LEVEL INDICATOR	LAMP OUTPUT
	23	3/4 FUEL LEVEL INDICATOR	LAMP OUTPUT
	24	1/2 FUEL LEVEL INDICATOR	LAMP OUTPUT
	25	INDICATOR GROUND	GROUND
	26	ANALYZER POWER	ANALYZER POWER
	27	ANALYZER GROUND	ANALYZER GROUND
	28	ANALYZER RX	ANALYZER RX
	29	ANALYZER TX	ANALYZER TX
	30	UNUSED (POWER)	BATTERY VOLTAGE
	31	SOFT TOUCH POWER	BATTERY VOLTAGE
	32	LSS POWER	BATTERY VOLTAGE
	33	OPTION POWER	BATTERY VOLTAGE
	34	UNUSED POWER	BATTERY VOLTAGE
	35	FULL FUEL LEVEL INDICATOR	LAMP OUTPUT

CONNECTOR	PIN	ASSIGNMENT	FUNCTION
J5 (Natural)	1	LIFT / SWING JOYSTICK POWER	SUPPLY VOLTAGE
	2	LIFT CENTER TAP	INPUT
	3	LIFT SIGNAL	INPUT
	4	SWING SIGNAL	INPUT
	5	SWING CENTER TAP	INPUT
	6	UNUSED	INPUT
	7	LIFT / SWING JOYSTICK GROUND	GROUND
	8	UNUSED (GROUND)	GROUND

CONNECTOR	PIN	ASSIGNMENT	FUNCTION
J7 (Black)	1	GROUND MODE	GROUND MODE
	2	PLATFORM EMS	PLATFORM EMS
	3	PLATFORM EMS TO GROUND MODULE	PLATFORM MODE
	4	FOOT SWITCH POWER	BATTERY VOLTAGE
	5	GENERATOR SWITCH POWER	BATTERY VOLTAGE
	6	UNUSED (JIB BLOCK LIMIT SWITCH POWER)	BATTERY VOLTAGE
	7	SKYGUARD POWER	BATTERY VOLTAGE
	8	FOOTSWITCH DISENGAGE	DIGITAL INPUT
	9	GENERATOR SWITCH	DIGITAL INPUT
	10	UNUSED (+7 VOLTS)	+7 REFERENCE VOLTAGE
	11	UNUSED	ANALOG INPUT
	12	UNUSED	ANALOG INPUT
	13	UNUSED	ANALOG INPUT
	14	UNUSED (GROUND)	GROUND
	15	UNUSED (+7 VOLTS)	+7 REFERENCE VOLTAGE
	16	LSS GROUND	GROUND
	17	UNUSED (JIB BLOCK LIMIT SWITCH)	HS DIGITAL INPUT
	18	SKYGUARD INPUT #1 SWITCH	HS DIGITAL INPUT
	19	PLATFORM ALARM	LAMP OUTPUT
	20	PLATFORM ALARM GROUND	GROUND
	21	UNALLOCATED	UNALLOCATED
	22	UNALLOCATED	UNALLOCATED
	23	UNUSED (VALVES GROUND)	GROUND
	24	SKYGUARD GROUND	GROUND
	25	UNALLOCATED	UNALLOCATED
	26	UNALLOCATED	UNALLOCATED
	27	UNALLOCATED	UNALLOCATED
	28	UNALLOCATED	UNALLOCATED
	29	OPTION GROUND	GROUND
	30	CAN LOW	CAN LOW
	31	CAN HIGH	CAN HIGH
	32	CAN SHIELD	CAN SHIELD
	33	UNALLOCATED	UNALLOCATED
	34	UNALLOCATED	UNALLOCATED
	35	UNUSED (GROUND)	GROUND

CONNECTOR	PIN	ASSIGNMENT	FUNCTION
J6 (Black)	1	DRIVE / STEER JOYSTICK POWER	SUPPLY VOLTAGE
	2	DRIVE CENTER TAP	INPUT
	3	DRIVE SIGNAL	INPUT
	4	STEER SIGNAL	INPUT
	5	STEER LEFT	INPUT
	6	STEER RIGHT	INPUT
	7	DRIVE / STEER JOYSTICK GROUND	GROUND
	8	UNUSED (GROUND)	GROUND

CONNECTOR	PIN	ASSIGNMENT	FUNCTION
J8	1	MODULE GROUND	GROUND
	2	MODULE POWER	BATTERY VOLTAGE

Table 6-2. Machine Configuration Programming Information (Software Version P2.14)

Configuration Label/Digit	Number	Description	Default Number
MODEL NUMBER: 1	0	????: Visible only on a Non-Configured UGM.	
	1	**400S**	**1**
	2	400SC	
	3	450AJ	
MARKET: 2*	**1**	**USA**	**1**
	2	ANSI EXPORT	
	3	CSA	
	4	CE	
	5	AUSTRALIA	
	6	JAPAN	
	7	GB	
*Certain model selections will limit market options.			
ENGINE: 3*	1	KUBOTA D1105	
	2	GM DUAL FUEL: GM/PSI 0.97 Dual Fuel (Tier 3)z	
	3	KUBOTA DUAL FUEL	
	4	FORD DUAL FUEL	
	5	**DEUTZ EMR2: (Tier 4i)**	**5**
	6	DEUTZ EMR4: (Tier 4f)	
*Certain model selections will limit engine options. *Certain market selections will limit engine options.			
STARTER LOCKOUT: 4*	**1**	**DISABLED: Automatic pre-glow time determined by ambient air temperature; engine start can be attempted at any time during pre-glow.**	**1**
	2	ENABLED: Automatic pre-glow time determined by ambient air temperature; engine start is NOT permitted until pre-glow is finished.	
*Only visible for diesel engine selections.			
ENGINE SHUTDOWN: 5	1	DISABLED: No engine shutdown.	
	2	ENABLED: Shutdown engine for high coolant temperature fault or low oil pressure fault.	**2**

Table 6-2. Machine Configuration Programming Information (Software Version P2.14)

Configuration Label/Digit	Number	Description	Default Number
FUEL CUTOUT: 6*	1	ONE RESTART: One restart with limited run time when near Empty.	
	2	ENGINE STOP: No starting permitted when near Empty.	
	3	NONE	
	4	**RESTART: Restarts allowed with limited run time when near Empty.**	**4**
*Only visible for diesel engine selections			
TILT: 7*	1	5 DEGREES: Reduces the maximum speed of all boom functions to creep when tilted more than 5 degrees and above elevation; also reduces drive speed to creep.	
	2	4 DEGREES: Reduces the maximum speed of all boom functions to creep when tilted more than 4 degrees and above elevation; also reduces drive speed to creep.	
	3	3 DEGREES: Reduces the maximum speed of all boom functions to creep when tilted more than 3 degrees and above elevation; also reduces drive speed to creep.	
	4	5 DEG + CUT: Reduces the maximum speed of all boom functions to creep when tilted more than 5 degrees and above elevation; also disallows tower lift up, drive, telescope out and lift up.	
	5	4 DEG + CUT: Reduces the maximum speed of all boom functions to creep when tilted more than 4 degrees and above elevation; also disallows tower lift up, drive, telescope out and lift up.	
	6	3 DEG + CUT: Reduces the maximum speed of all boom functions to creep when tilted more than 3 degrees and above elevation; also disallows tower lift up, drive, telescope out and lift up.	
	7	**5 DEG + DRV CUT: Reduces the maximum speed of all boom functions to creep when tilted more than 5 degrees and above elevation; also reduces drive speed to creep when drive reversal is allowed, drive is disallowed otherwise.**	**7**
	8	4 DEG + DRV CUT: Reduces the maximum speed of all boom functions to creep when tilted more than 4 degrees and above elevation; also reduces drive speed to creep when drive reversal is allowed, drive is disallowed otherwise.	
	9	3 DEG + DRV CUT: Reduces the maximum speed of all boom functions to creep when tilted more than 3 degrees and above elevation; also reduces drive speed to creep when drive reversal is allowed, drive is disallowed otherwise.	
*Certain market selections will limit tilt options and alter default setting.			
4 WHEEL STEER: 8*	**1**	**NO: 4 Wheel Steer not installed.**	**1**
	2	YES: 4 Wheel Steer installed.	
*Certain model selections will limit visibility.			
JIB: 9*	**1**	**NO: No jib installed.**	**1**
	2	YES: Jib installed, which has up and down movements only.	
*Certain model selections will limit visibility.			

Table 6-2. Machine Configuration Programming Information (Software Version P2.14)

Configuration Label/Digit	Number	Description	Default Number
SOFT TOUCH: 10*	**1**	**NO: No Soft Touch system installed.**	**1**
	2	YES: Soft Touch system installed.	
* Certain model selections will limit visibility			
SKYGUARD: 11	1	NO: No SkyGuard system installed.	
	2	**BAR/SKYLINE: SkyGuard system installed**	**2**
	3	SKYEYE: SkyGuard system installed.	
GEN SET/WELDER: 12	**1**	**NO: No generator installed.**	**1**
	2	BELT DRIVE: Belt driven setup.	
GEN SET CUTOUT: 13*	**1**	**MOTION ENABLED: Motion enabled when generator is ON.**	**1**
	2	MOTION CUTOUT: Motion cutout in platform mode only.	
* Only visible if Gen Set / Welder selection is not NO.			
H & T LIGHTS: 14	**1**	**NO: No head and tail lights installed.**	**1**
	2	YES: Head and tail lights installed.	
LOAD SYSTEM: 15*	1	NO: No load sensor installed.	
	2	WARN ONLY: Functions in creep, overload lamp lit, platform alarm beeps (5 sec ON, 2 sec OFF).	
	3	**CUTOUT PLATFORM: All functions cutout, overload lamp lit, platform alarm beeps (5 sec ON, 2 sec OFF).**	**3**
	4	CUTOUT ALL: All functions cutout, flash overload light (500mS on, 500mS off), platform alarm beeps (5 sec ON, 2 sec OFF).	
* Certain market selections will limit load system options or alter default setting.			
FUNCTION CUTOUT: 16*	**1**	**NO: No drive cutout.**	**1**
	2	BOOM CUTOUT: Boom function cutout while driving above elevation.	
	3	DRIVE CUTOUT: Drive & steer cutout above elevation.	
* Certain market selections will limit function cutout options or alter default setting.			
GROUND ALARM: 17	1	NO: No ground alarm installed.	
	2	DRIVE: Travel alarm sounds when the drive function is active.	
	3	DESCENT: Descent alarm sounds when lift down is active.	
	4	**MOTION: Motion alarm sounds when any function is active.**	**4**

Table 6-2. Machine Configuration Programming Information (Software Version P2.14)

Configuration Label/Digit	Number	Description	Default Number
DRIVE TYPE: 18*	**1**	**4WD: 4 wheel drive.**	**1**
	2	2WD: 2 wheel drive.	
* Certain model selections will limit visibility.			
DISPLAY UNITS: 19*	1	METRIC: Celsius, Kilograms, KiloPascal.	
	2	**IMPERIAL: Fahrenheit, Pounds, Pounds/in^2**	**2**
* Certain market selections will alter default setting.			
CLEARSKY: 20	**1**	**NO: ClearSky (telematics) options is disabled.**	**1**
	2	YES: ClearSky (telematics) option is enabled.	
CRIBBING OPTION: 21*	**1**	**NO: Cribbing Option is disabled.**	**1**
	2	YES: Cribbing Option is enabled.	
* Certain model selections will limit visibility.			
ALERT BEACON: 22	**1**	**OFF FOR CREEP**	**1**
	2	IN CREEP 20FPM	
TEMP CUTOUT: 23*	**1**	**NO: No Low Temp Cutout system installed.**	**1**
	2	YES: Low Temp Cutout system installed.	
* Only visible under certain market selections.			
PLAT LVL OVR CUT: 24	**1**	**NO: Platform Level functions above elevation.**	**1**
	2	YES: Platform Level does not function above elevation.	
CAPACITY: 25*	1	SINGLE: Single Capacity system installed.	
	2	**DUAL: Dual Capacity system installed.**	**2**
	3	TRIPLE: Triple Capacity system installed.	
* Certain model selections will limit visibility. * Certain model selections will limit capacity options. * Certain market selections will limit capacity options.			
ALARM / HORN: 26	1	SEPARATE: Ambient alarm installed.	
	2	**COMBINED: Single Horn / Alarm installed.**	**2**

Table 6-2. Machine Configuration Programming Information (Software Version P2.14)

Configuration Label/Digit	Number	Description	Default Number
WATER IN FUEL SESNOR:	**1**	**NO: Water in Fuel Sensor not installed.**	
27*	2	YES: Water in Fuel Sensor is installed.	**2**
*Only visible if engine selection is Deutz EMR4.			

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Table 6-3. Machine Configuration Programming Settings - 400S (Software Version P2.14)

400S	ANSI USA	ANSI Export	CSA	CE	Australia	Japan	GB
Model Number	**1**	**1**	**1**	**1**	**1**	**1**	**1**
Market	**1**	**2**	**3**	**4**	**5**	**6**	**7**
Engine	X	X	X	X	X	X	X
	2	2	2	X	X	2	X
	3	3	3	X	X	3	X
	X	X	X	X	X	X	X
	5	**5**	**5**	**5**	**5**	**5**	**5**
	6	6	6	6	6	6	6
Starter Lockout	**1**	**1**	**1**	**1**	**1**	**1**	**1**
	2	2	2	2	2	2	2
Engine Shutdown	1	1	1	1	1	1	1
	2	**2**	**2**	**2**	**2**	**2**	**2**
Fuel Cutout	1	1	1	1	1	1	1
	2	2	2	2	2	2	2
	X	X	X	X	X	X	X
	4	**4**	**4**	**4**	**4**	**4**	**4**
Tilt	X	X	X	X	X	X	X
	X	X	X	X	X	X	X
	X	X	X	X	X	X	X
	4	4	4	4	4	4	4
	5	5	5	5	5	5	5
	6	6	6	6	6	6	6
	7	**7**	**7**	**7**	**7**	**7**	**7**
	8	8	8	8	8	8	8
	9	9	9	9	9	9	9
4 Wheeler Steer	**1**	**1**	**1**	**1**	**1**	**1**	**1**
	X	X	X	X	X	X	X
Jib	**1**	**1**	**1**	**1**	**1**	**1**	**1**
	2	2	2	2	2	2	2
Soft Touch	**1**	**1**	**1**	**1**	**1**	**1**	**1**
	2	2	2	2	2	2	2
SkyGuard	1	1	1	1	1	1	1
	2	**2**	**2**	**2**	**2**	**2**	**2**
	3	3	3	3	3	3	3
Gen Set / Welder	**1**	**1**	**1**	**1**	**1**	**1**	**1**
	2	2	2	2	2	2	2
Gen Set Cutout	**1**	**1**	**1**	**1**	**1**	**1**	**1**
	2	2	2	2	2	2	2
Head & Taillights	**1**	**1**	**1**	**1**	**1**	**1**	**1**
	2	2	2	2	2	2	2

Table 6-3. Machine Configuration Programming Settings - 400S (Software Version P2.14)

400S	ANSI USA	ANSI Export	CSA	CE	Australia	Japan	GB
Load System	X	1	X	X	X	X	X
	X	X	X	X	X	X	X
	3	**3**	**3**	X	**3**	**3**	**3**
	4	4	4	**4**	X	4	4
Function Cutout	**1**	**1**	**1**	X	**1**	**1**	**1**
	X	2	2	**2**	2	2	2
	3	3	3	X	3	3	3
Ground Alarm	1	1	1	1	1	1	1
	2	2	2	2	2	2	2
	3	3	3	3	3	3	3
	4	**4**	**4**	**4**	**4**	**4**	**4**
Drive Type	**1**	**1**	**1**	**1**	**1**	**1**	**1**
	2	2	2	2	2	2	2
Display Units	1	1	**1**	**1**	**1**	**1**	**1**
	2	**2**	2	2	2	2	2
Clearsky	**1**	**1**	**1**	**1**	**1**	**1**	**1**
	2	2	2	2	2	2	2
Cribbing Option	**1**	**1**	**1**	**1**	**1**	**1**	**1**
	2	2	2	X	X	2	X
Alert Beacon	**1**	**1**	**1**	**1**	1	**1**	**1**
	2	2	2	2	**2**	2	2
Temp Cutout	**1**	**1**	**1**	**1**	**1**	**1**	**1**
	X	2	X	2	X	X	2
Plat Lvl Ovr Cut	**1**	**1**	**1**	**1**	**1**	**1**	**1**
	2	2	2	2	2	2	2
Capacity	1	1	1	1	**1**	1	1
	2	**2**	**2**	**2**	X	**2**	**2**
	3	3	3	3	3	3	3
Alarm/Horn	1	1	1	1	1	1	1
	2	**2**	**2**	**2**	**2**	**2**	**2**
WATER IN FUEL SENSOR	**1**	**1**	**1**	**1**	**1**	**1**	**1**
	2	2	2	2	2	2	2

BOLD BLUE TEXT indicates the default setting. Plain text indicates another available selection. ***RED ITALIC TEXT*** indicates the default when option is factory installed. SHADED CELLS indicate hidden menu or selection.

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Table 6-4. Machine Configuration Programming Settings - 460SJ (Software Version P2.14)

460SJ	ANSI USA	ANSI Export	CSA	CE	Australia	Japan	GB
Model Number	**1**	**1**	**1**	**1**	**1**	**1**	**1**
Market	**1**	**2**	**3**	**4**	**5**	**6**	**7**
Engine	X	X	X	X	X	X	X
	2	2	2	X	X	2	X
	3	3	3	X	X	3	X
	X	X	X	X	X	X	X
	5	**5**	**5**	**5**	**5**	**5**	**5**
	6	6	6	6	6	6	6
Starter Lockout	**1**	**1**	**1**	**1**	**1**	**1**	**1**
	2	2	2	2	2	2	2
Engine Shutdown	1	1	1	1	1	1	1
	2	**2**	**2**	**2**	**2**	**2**	**2**
Fuel Cutout	1	1	1	1	1	1	1
	2	2	2	2	2	2	2
	X	X	X	X	X	X	X
	4	**4**	**4**	**4**	**4**	**4**	**4**
Tilt	X	X	X	X	X	X	X
	X	X	X	X	X	X	X
	X	X	X	X	X	X	X
	4	4	4	4	4	4	4
	5	5	5	5	5	5	5
	6	6	6	6	6	6	6
	7	**7**	**7**	**7**	**7**	**7**	**7**
	8	8	8	8	8	8	8
	9	9	9	9	9	9	9
4 Wheel Steer	**1**	**1**	**1**	**1**	**1**	**1**	**1**
	X	X	X	X	X	X	X
Jib	1	1	1	1	1	1	1
	2	***2***	***2***	***2***	***2***	***2***	***2***
Soft Touch	**1**	**1**	**1**	**1**	**1**	**1**	**1**
	2	2	2	2	2	2	2
SkyGuard	1	1	1	1	1	1	1
	2	**2**	**2**	**2**	**2**	**2**	**2**
	3	3	3	3	3	3	3
Gen Set / Welder	**1**	**1**	**1**	**1**	**1**	**1**	**1**
	2	2	2	2	2	2	2
Gen Set Cutout	**1**	**1**	**1**	**1**	**1**	**1**	**1**
	2	2	2	2	2	2	2
Head & Taillights	**1**	**1**	**1**	**1**	**1**	**1**	**1**
	2	2	2	2	2	2	2

Table 6-4. Machine Configuration Programming Settings - 460SJ (Software Version P2.14)

460SJ	ANSI USA	ANSI Export	CSA	CE	Australia	Japan	GB
Load System	X	1	X	X	X	X	X
	X	X	X	X	X	X	X
	3	**3**	**3**	X	**3**	**3**	**3**
	4	4	4	**4**	X	4	4
Function Cutout	**1**	**1**	**1**	X	**1**	**1**	**1**
	X	2	2	**2**	2	2	2
	3	3	3	X	3	3	3
Ground Alarm	1	1	1	1	1	1	1
	2	2	2	2	2	2	2
	3	3	3	3	3	3	3
	4	**4**	**4**	**4**	**4**	**4**	**4**
Drive Type	**1**	**1**	**1**	**1**	**1**	**1**	**1**
	2	2	2	2	2	2	2
Display Units	1	1	**1**	**1**	**1**	**1**	**1**
	2	**2**	2	2	2	2	2
Clearsky	**1**	**1**	**1**	**1**	**1**	**1**	**1**
	2	2	2	2	2	2	2
Cribbing Option	**1**	**1**	**1**	**1**	**1**	**1**	**1**
	2	2	2	X	X	2	X
Alert Beacon	**1**	**1**	**1**	**1**	1	**1**	**1**
	2	2	2	2	**2**	2	2
Temp Cutout	**1**	**1**	**1**	**1**	**1**	**1**	**1**
	X	2	X	2	X	X	2
Plat Lvl Ovr Cut	**1**	**1**	**1**	**1**	**1**	**1**	**1**
	2	2	2	2	2	2	2
Capacity	**1**	**1**	**1**	**1**	**1**	**1**	**1**
	2	2	2	2	X	2	2
	3	3	3	3	3	3	3
Alarm/Horn	1	1	1	1	1	1	1
	2	**2**	**2**	**2**	**2**	**2**	**2**
WATER IN FUEL SENSOR	**1**	**1**	**1**	**1**	**1**	**1**	**1**
	2	2	2	2	2	2	2

BOLD BLUE TEXT indicates the default setting. Plain text indicates another available selection. ***RED ITALIC TEXT*** indicates the default when option is factory installed. SHADED CELLS indicate hidden menu or selection.

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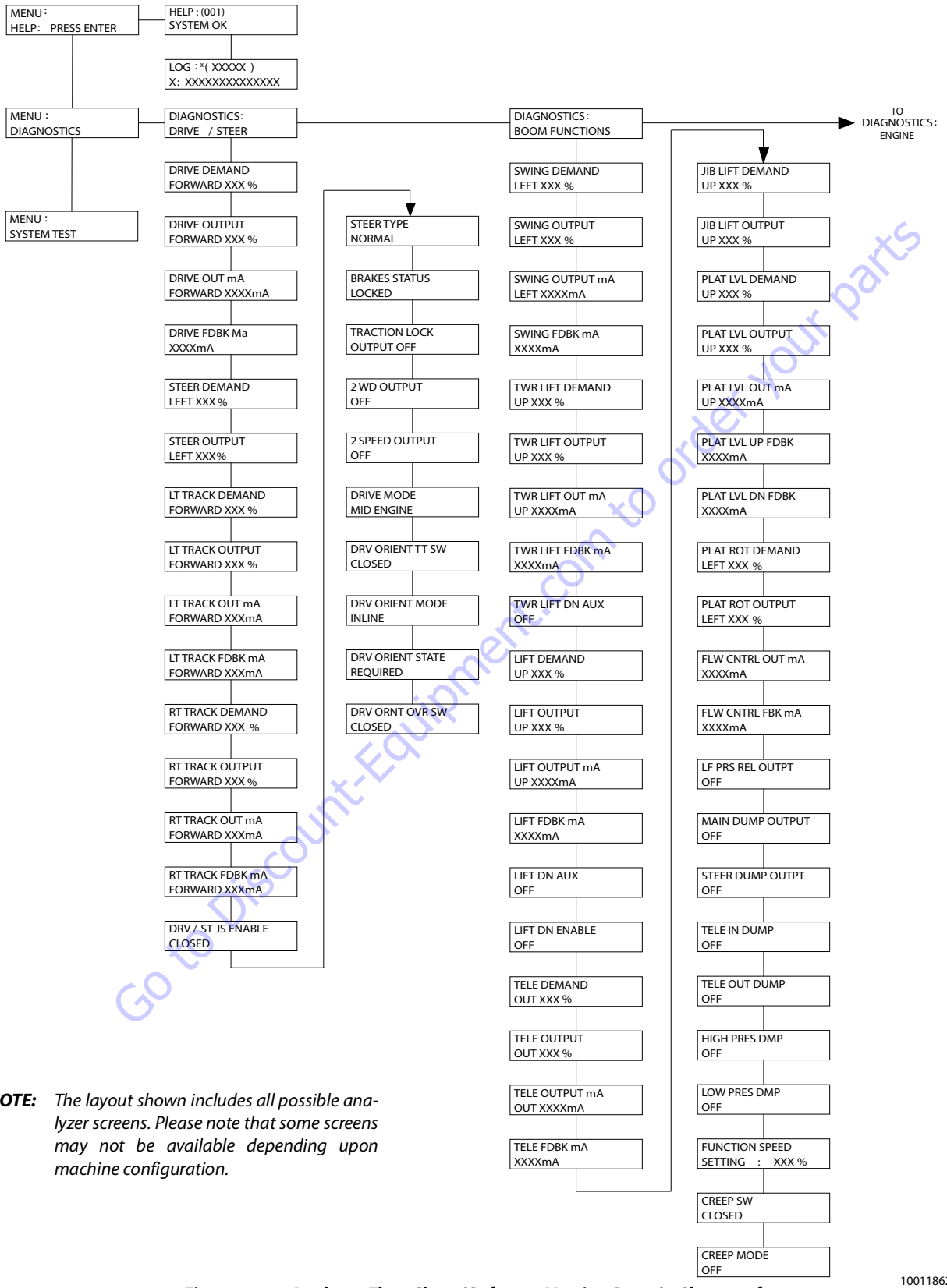
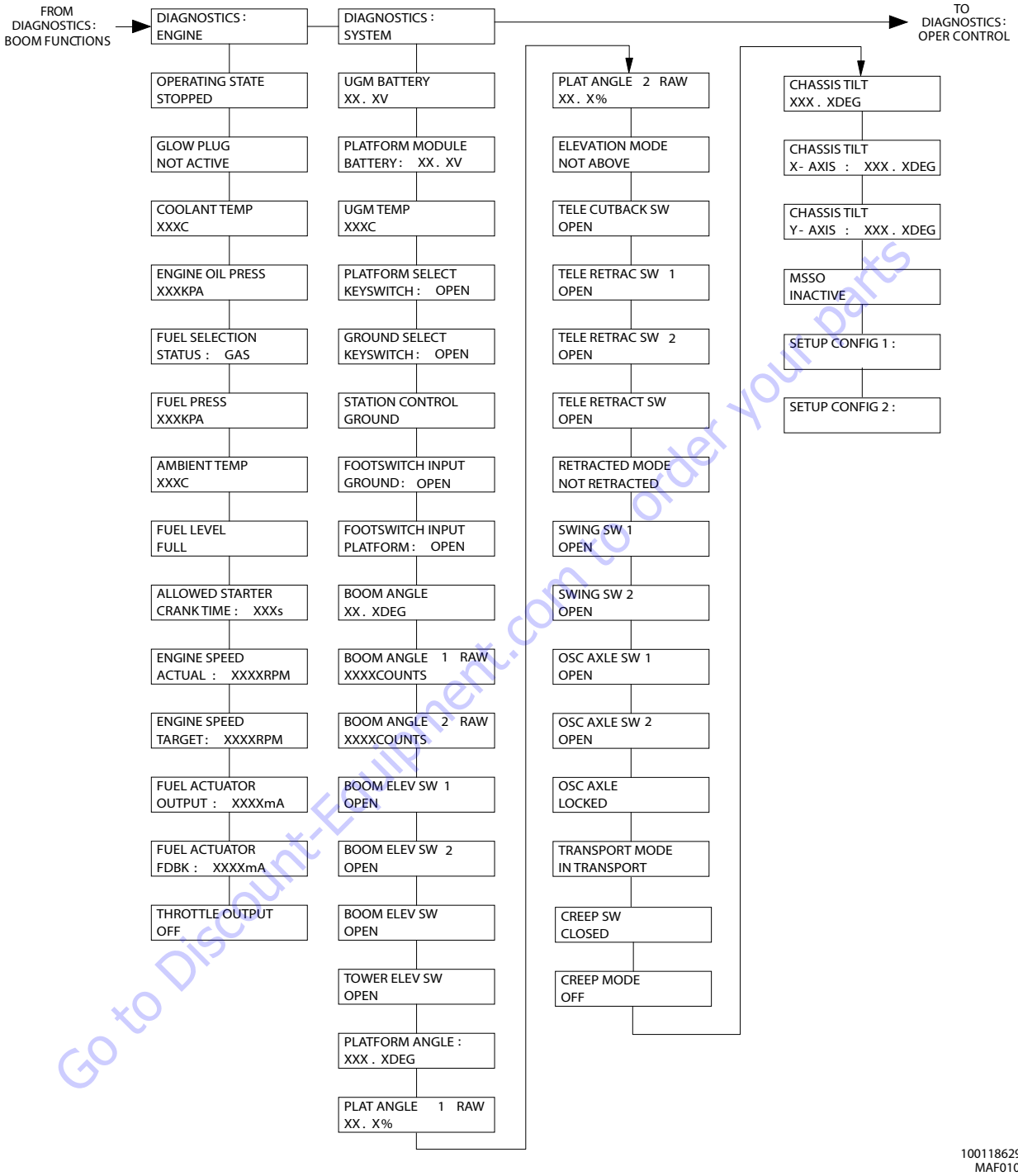


NOTE: *The layout shown includes all possible analyzer screens. Please note that some screens may not be available depending upon machine configuration.*

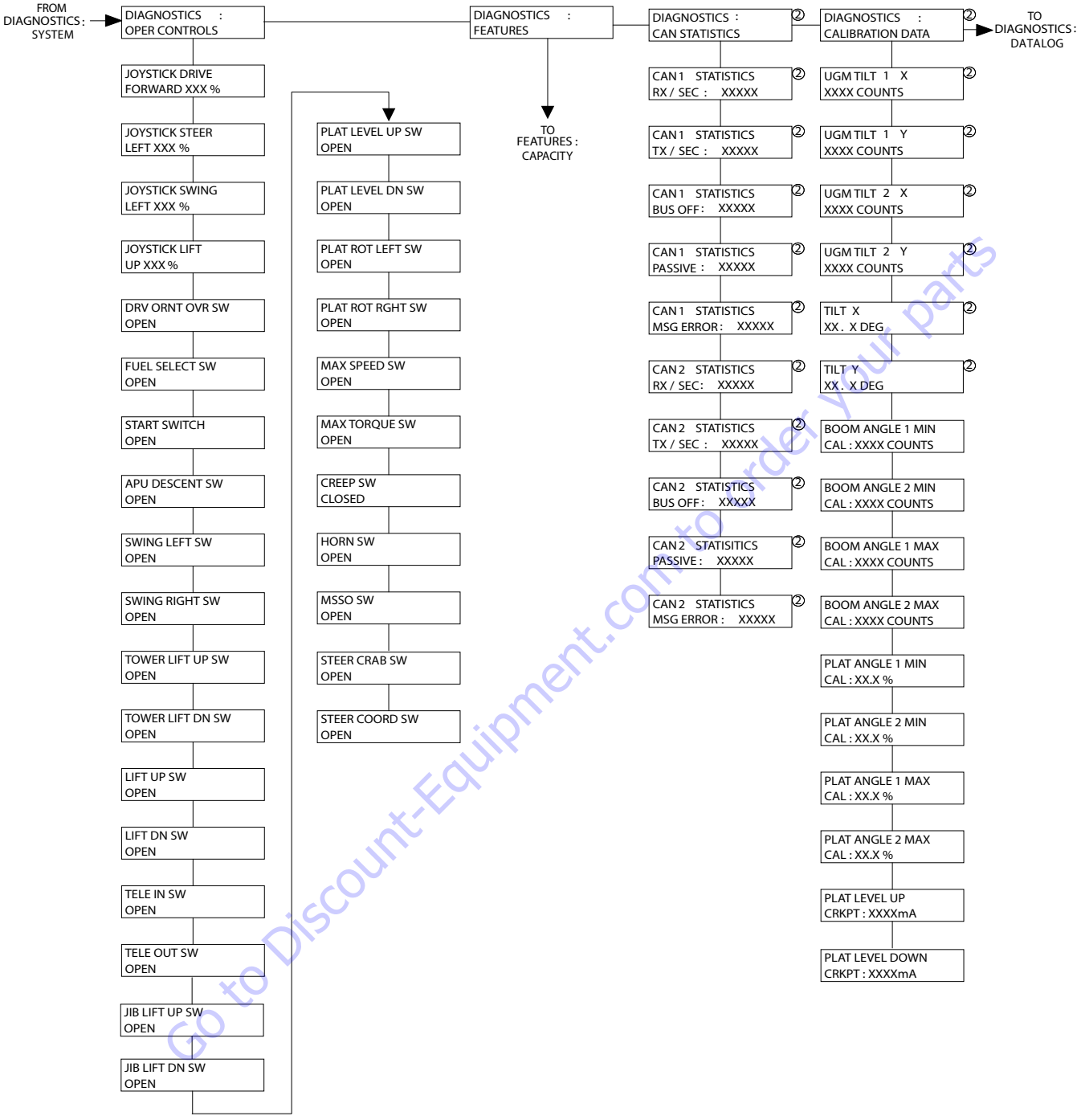
1001186299-L
MAF01040L

Figure 6-10. Analyzer Flow Chart (Software Version P2.14) - Sheet 1 of 9



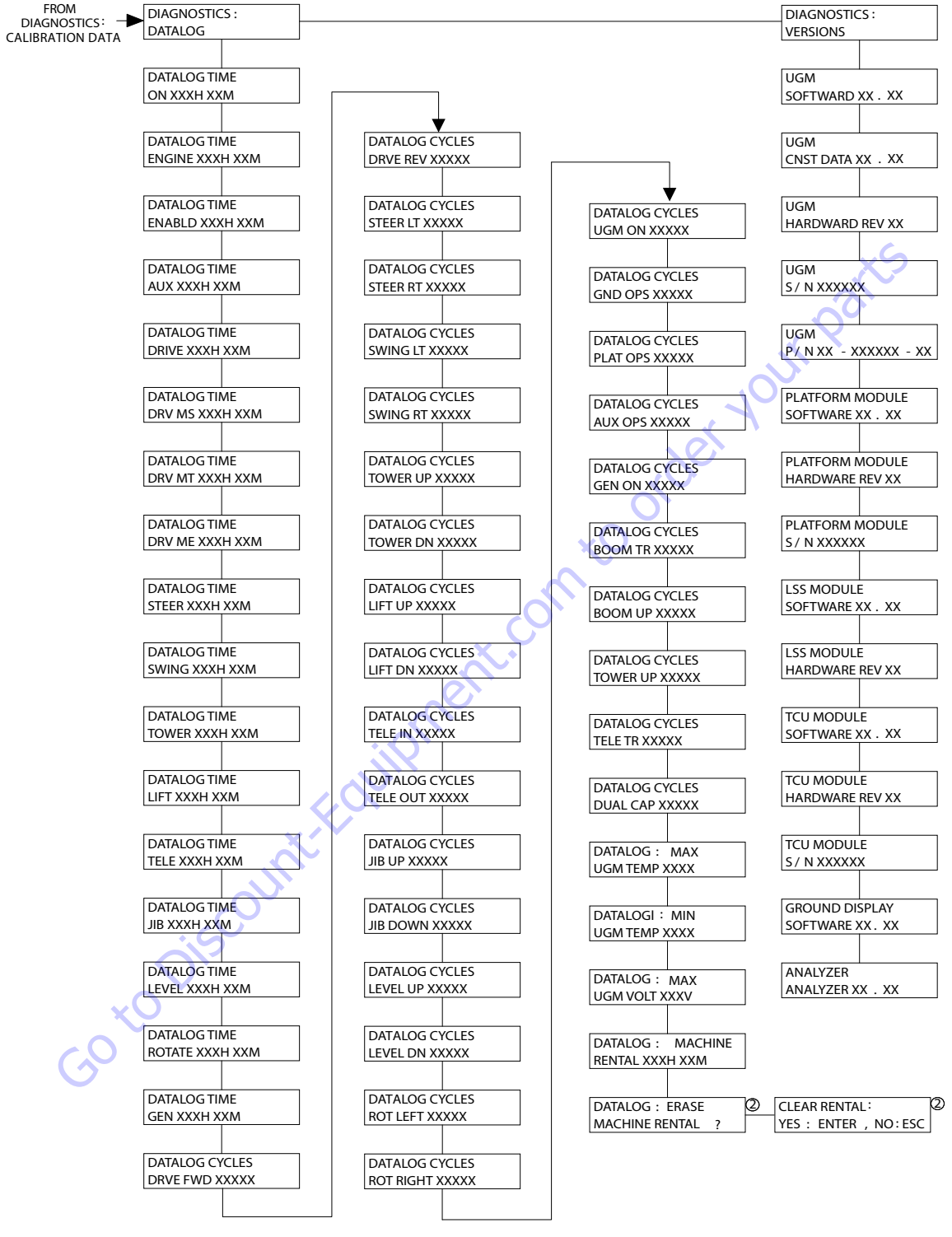
NOTE: *The layout shown includes all possible analyzer screens. Please note that some screens may not be available depending upon machine configuration.*

Figure 6-11. Analyzer Flow Chart (Software Version P2.14) - Sheet 2 of 9



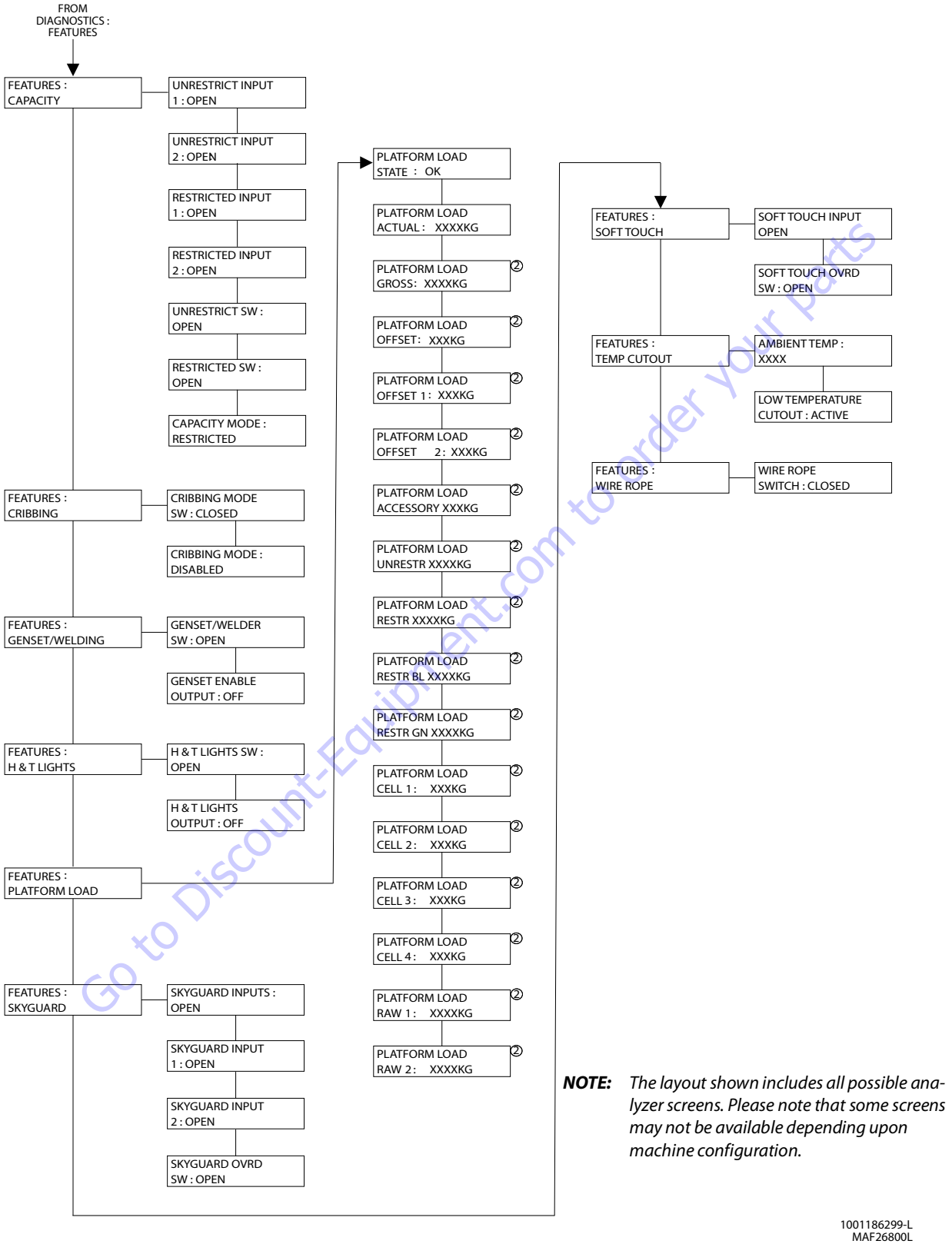
NOTE: *The layout shown includes all possible analyzer screens. Please note that some screens may not be available depending upon machine configuration.*

Figure 6-12. Analyzer Flow Chart (Software Version P2.14) - Sheet 3 of 9



NOTE: *The layout shown includes all possible analyzer screens. Please note that some screens may not be available depending upon machine configuration.*

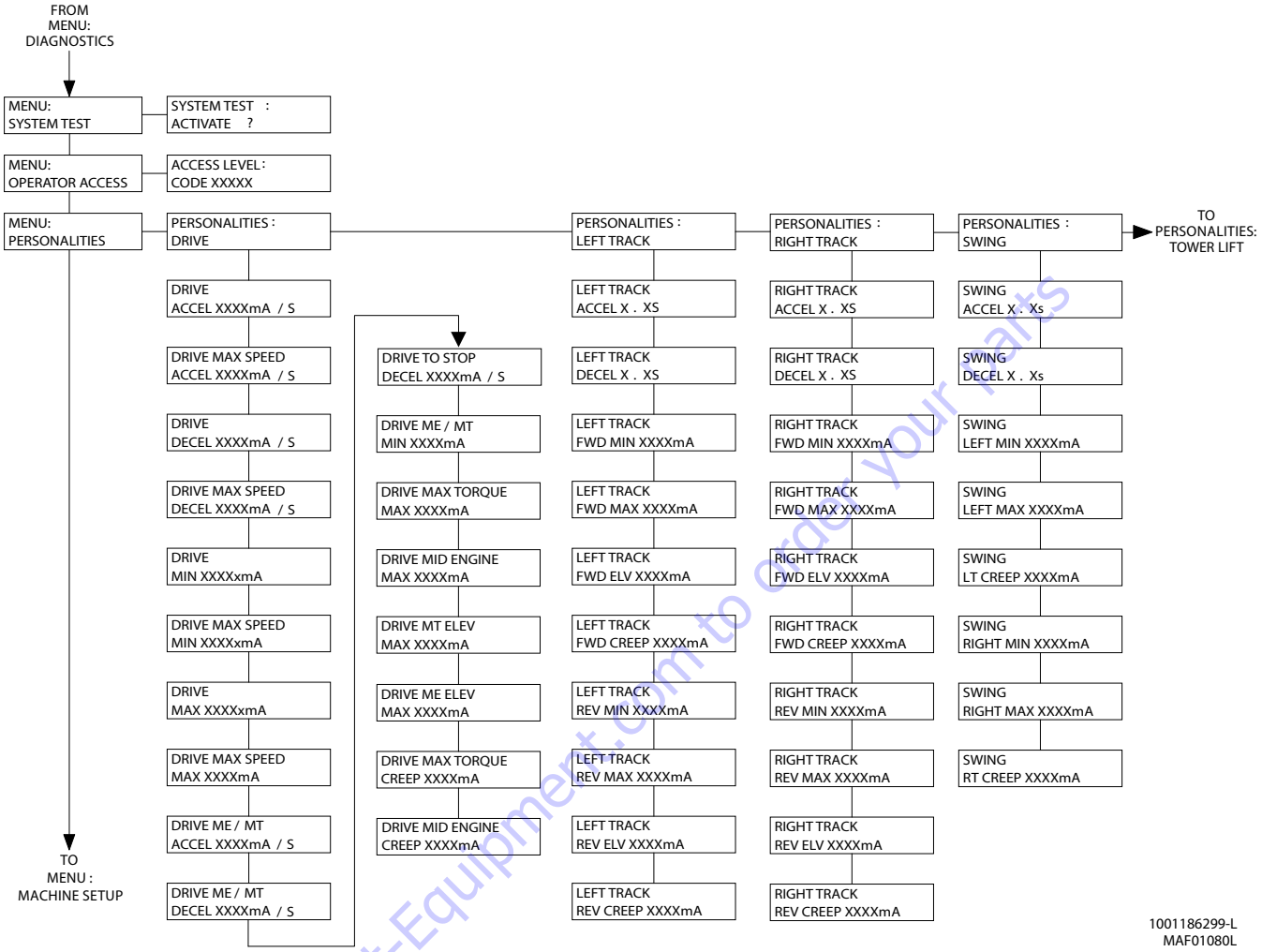
Figure 6-13. Analyzer Flow Chart (Software Version P2.14) - Sheet 4 of 9



NOTE: *The layout shown includes all possible analyzer screens. Please note that some screens may not be available depending upon machine configuration.*

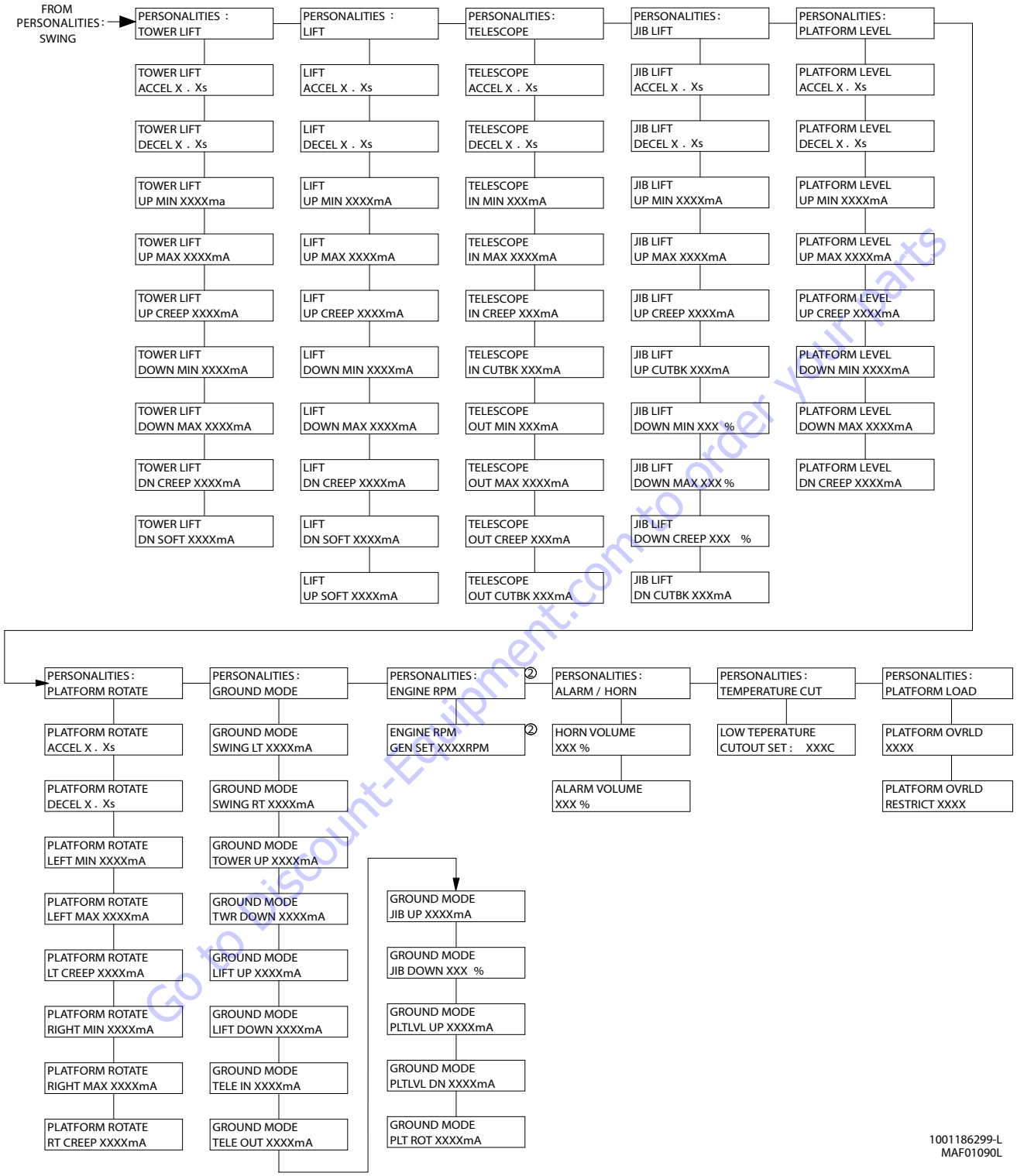
1001186299-L
MAF26800L

Figure 6-14. Analyzer Flow Chart (Software Version P2.14) - Sheet 5 of 9



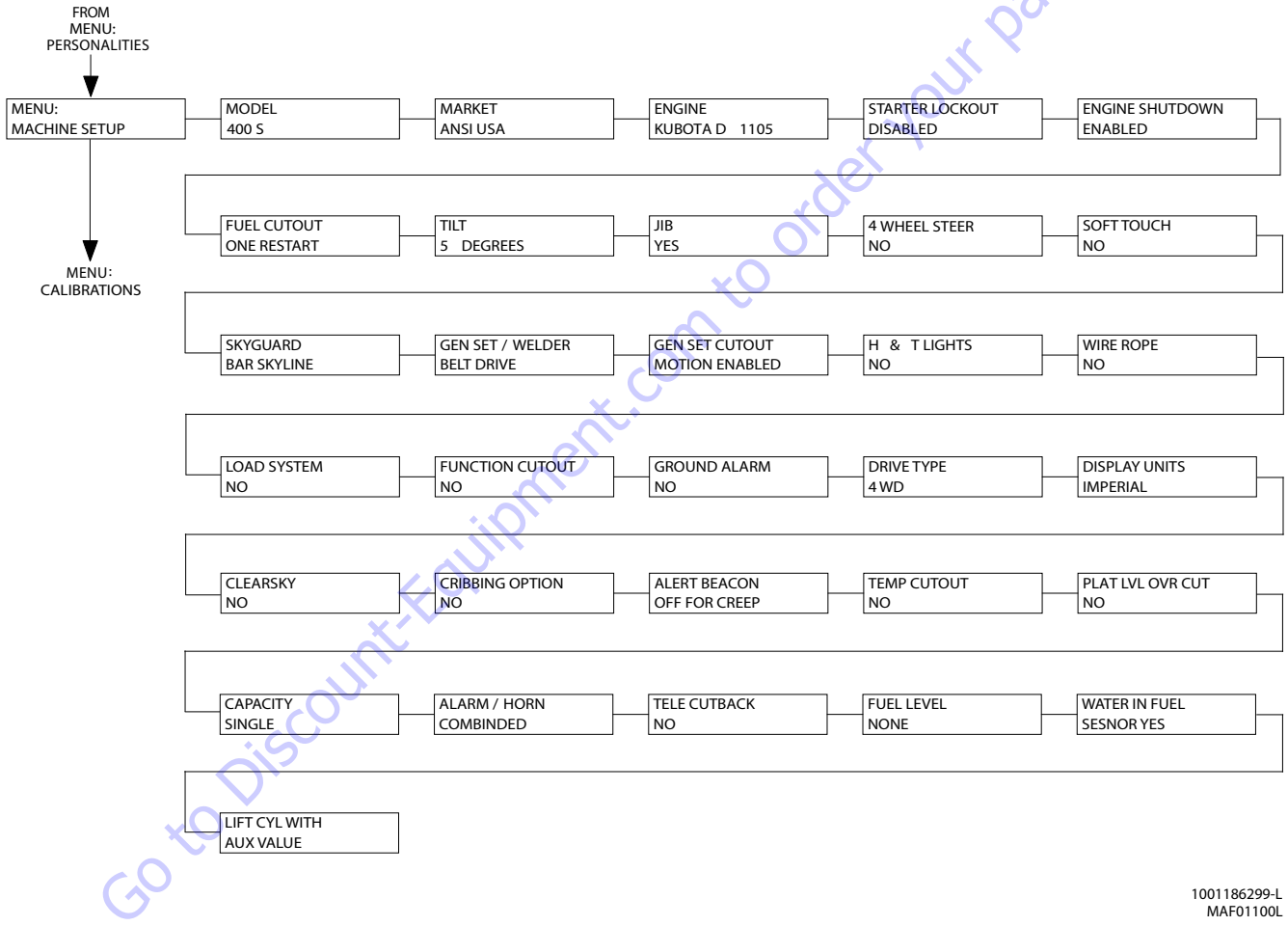
NOTE: *The layout shown includes all possible analyzer screens. Please note that some screens may not be available depending upon machine configuration.*

Figure 6-15. Analyzer Flow Chart (Software Version P2.14) - Sheet 6 of 9



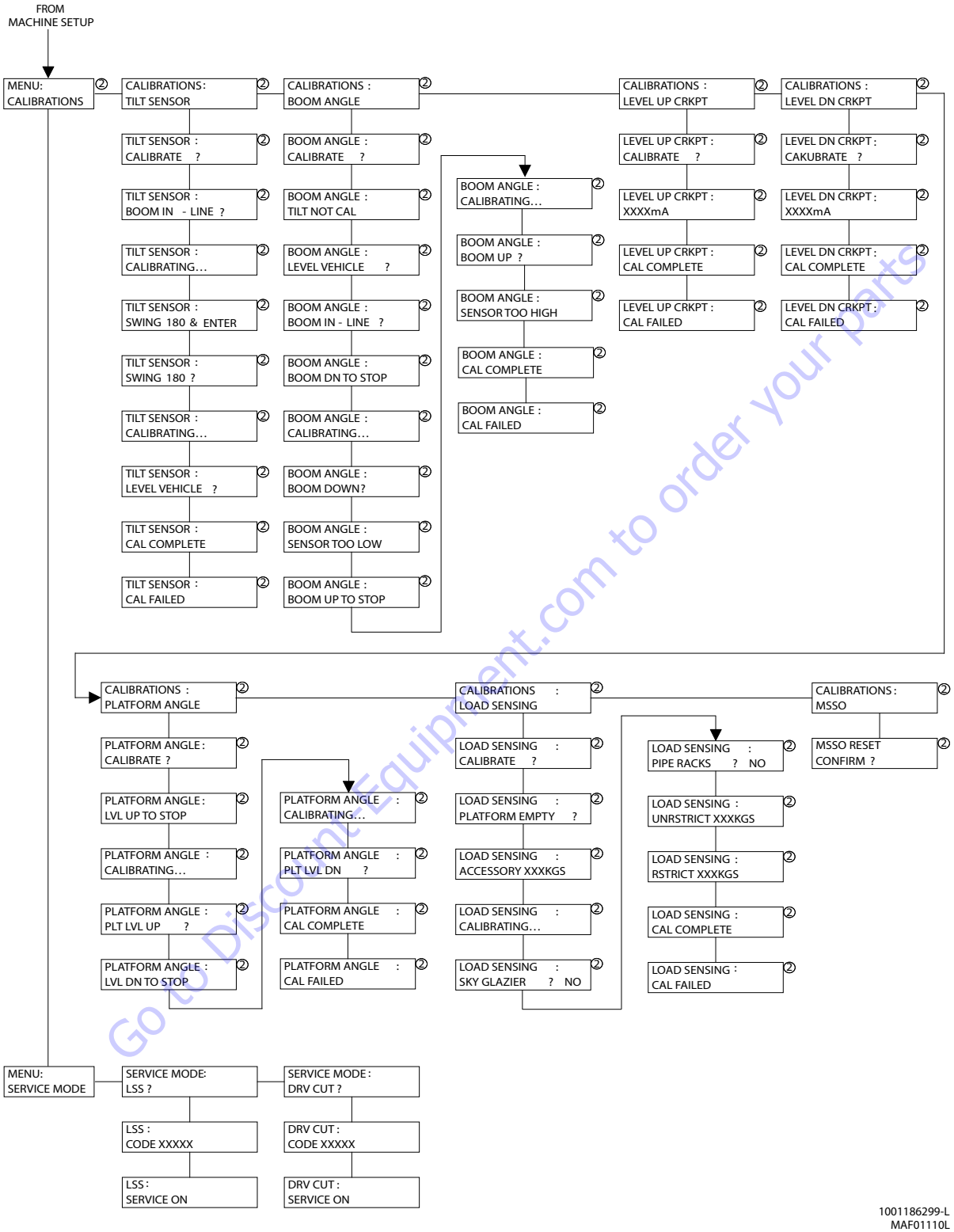
NOTE: *The layout shown includes all possible analyzer screens. Please note that some screens may not be available depending upon machine configuration.*

Figure 6-16. Analyzer Flow Chart (Software Version P2.14) - Sheet 7 of 9



NOTE: *The layout shown includes all possible analyzer screens. Please note that some screens may not be available depending upon machine configuration.*

Figure 6-17. Analyzer Flow Chart (Software Version P2.14) - Sheet 8 of 9



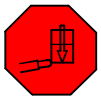
NOTE: *The layout shown includes all possible analyzer screens. Please note that some screens may not be available depending upon machine configuration.*

Figure 6-18. Analyzer Flow Chart (Software Version P2.14) - Sheet 9 of 9

6.2 LSS SYSTEM

The JLG-designed Load Sensing System (LSS) measures platform load via a sensor mounted in the platform support structure. If the actual platform load exceeds the selected Rated Load, the following will occur:

1. The Overload Visual Warning Indicator will flash at the selected control position (platform or ground).



2. The Platform and Ground Alarms will sound 5 seconds On, and 2 seconds Off.
3. All normal movement will be prevented from the platform control position (optional - ground control functions may be prevented).
4. Further movement is permitted by:
   a. Removing the excess platform load until actual platform load is less than Rated Load.
   b. Operation of the overriding emergency system (Auxiliary Power Unit).
   c. By an authorized person at the ground control position (optional - ground control functions may be prevented).
5. The Load Sensing System MUST be calibrated when one or more of the following conditions occur:
   a. LSS Sensor removal or replacement
   b. Addition or removal of certain platform mounted accessories. (Refer to Calibration)
   c. Platform is removed, replaced, repaired or shows evidence of impact.

NOTICE

THE LOAD SENSING SYSTEM REQUIRES PERIODIC FUNCTION VERIFICATION NOT TO EXCEED 6 MONTHS FROM PREVIOUS VERIFICATION. REFER TO TESTING & EVALUATION.

All calibration procedures are menu driven through the use of a JLG Analyzer.

Diagnostic Menu

The Diagnostic Menu is another troubleshooting tool for the Load Sensing System. Sensor and status information is presented in real-time for the technician. Several sub-menus exist to organize the data.

To access the Diagnostic Menu, use the LEFT and RIGHT Arrow keys to select DIAGNOSTICS from the Top Level Menu. Press the ENTER key to view the menu.

Press the LEFT and RIGHT Arrow keys to view the displays and select the various sub-menus. To access a sub-menu, press the ENTER key. Once in a sub-menu, press the LEFT and RIGHT Arrow keys to view the various displays (just like a Top Level menu). To exit a sub-menu, press the ESC key.

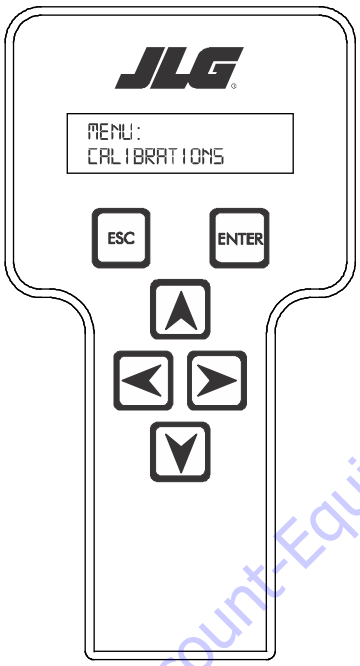
Table 6-5, Diagnostic Menu Descriptions details the structure of the Diagnostic Menu, and describes the meaning of each piece of information presented.

Table 6-5. Diagnostic Menu Descriptions

Diagnostics Menu (Displayed on Analyzer 1st Line)	Parameter (Displayed on Analyzer 2nd Line)	Parameter Value (Displayed on Analyzer 2nd Line)	Description
PLATFORM LOAD	STATE:	OK / OVERLOAD	LSS Status.
PLATFORM LOAD	ACTUAL:	XXX.X KG	Calibrated weight of the platform. ??? if Platform Load is Unhealthy**.
PLATFORM LOAD (service*)	GROSS:	XXX.X KG	Gross weight of the platform. ??? if both Cells are Unhealthy**.
PLATFORM LOAD (service*)	OFFSET 1:	XXX.X KG	Stored offset weight of Cell 1. ??? if LSS is not calibrated.
PLATFORM LOAD (service*)	OFFSET 2:	XXX.X KG	Stored offset weight of Cell 1. ??? if LSS is not calibrated.
PLATFORM LOAD (service*)	ACCESSORY	XXX.X KG	Stored accessory weight. ??? if LSS is not calibrated.
PLATFORM LOAD (service*)	UNRESTRICT	XXX.X KG	UGM will set Unrestricted Rated Load as defined by Machine Configuration.
PLATFORM LOAD (service*)	RESTRICT	XXX.X KG	UGM will set Restricted Rated Load as defined by Machine Configuration.
PLATFORM LOAD (service*)	RAW 1:	XXX.X KG	Gross value from Cell 1. ??? if Unhealthy**.
PLATFORM LOAD (service*)	RAW 2:	XXX.X KG	Gross value from Cell 2. ??? if Unhealthy**.
* Indicates only visible in service view mode ** Typically indicates a DTC is active			

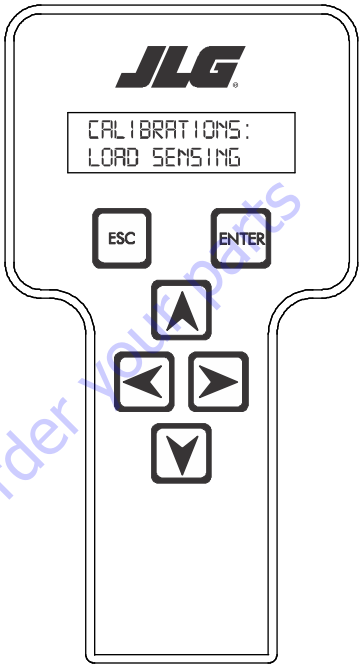
Calibration Procedure

1. Remove everything from the platform, except permanently fixed JLG Accessories, to allow the Load Sensing System to record its' weight during calibration. This includes all tools, debris, and customer-installed devices.
2. Plug the JLG Analyzer into the Machine at the Ground Station and enter Service Access Password 33271.
3. The platform should be approximately level for calibration. Level the platform from ground control (if necessary) to within +/- 5°.
4. To access the Calibration Menu, use the LEFT and RIGHT Arrow keys to select CALIBRATION from the Top Level Menu. The screen will read:

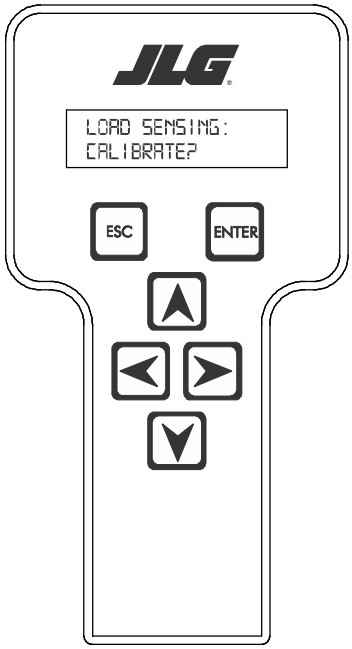


NOTE: *The Calibration Menu is not available in OPERATOR ACCESS.*

5. Press the ENTER key (ENTER) to view the menu. Upon entry to the Calibration Menu, the JLG Control System will link to the Analyzer and the screen will read:



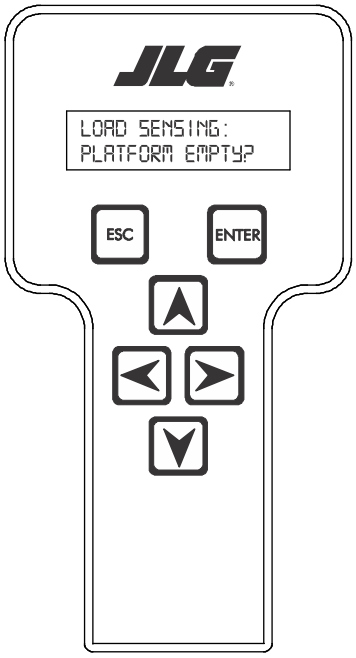
6. Press Enter (ENTER). The Screen will read:



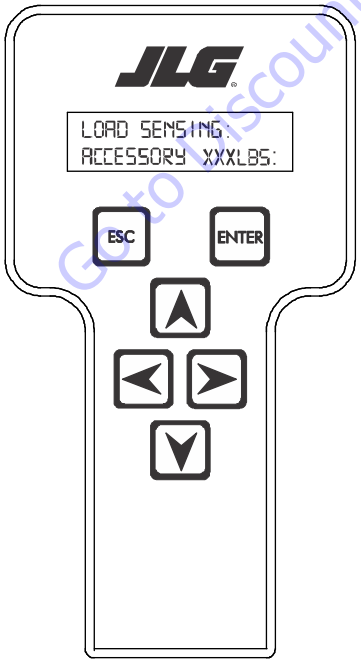
NOTE: *Calibration will auto fail if LSS DTC's are active (443, 444, 4479, 4480, 663, 821, 822, 823, 824, 8218, 8222 -> 8238, 991, 992, 993, 994 or 99285).*

Pressing the ESC key [ESC] after starting calibration and before calibration is complete will display the CAL FAILED message. This will not disturb the prior calibration information.

7. Press ENTER [ENTER]. The analyzer screen will read:



8. If the platform is empty, press ENTER [ENTER]. The screen will read:



NOTE: *Accessory weight will reset to 0 lb each time the machine is re-calibrated and will need to be re-entered.*

NOTE: *The Accessory weight will be temporarily stored in the Control System until calibration has been completed successfully.*

Refer to Table 6-6, Accessory Weights. Use the up and down analyzer keys to enter the accessory weight(s) (in lb). When all the accessory weights are entered, press ENTER [ENTER]. The screen will read:

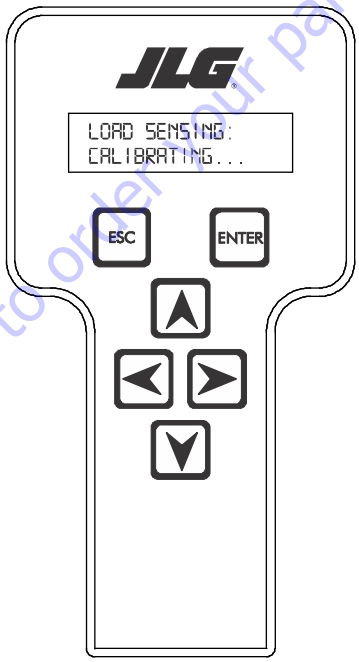


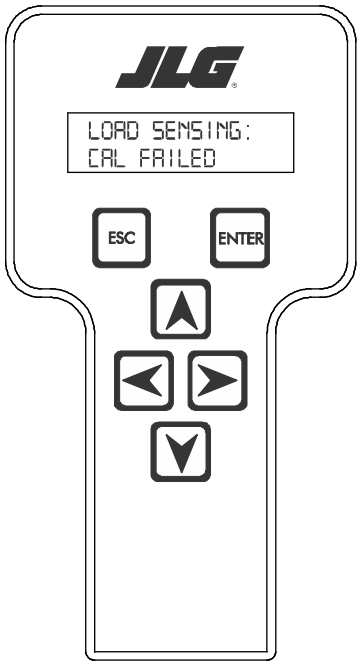
Table 6-6. Accessory Weights

Accessory	Weight
SkyWelder (stick welder)	70 lb (32 kg)
SkyWelder Prep	Prep only = 15 lb (7 kg) Full install = 70 lb (32 kg)
SkyCutter (plasma cutter)	70 lb (32 kg)
SkCutter / SkyWelder Combo	140 lb (64 kg)
Fire Extinguisher	45 lb (20 kg)
Overhead SoftTouch	80 lb (36 kg)
Work Surface	20 lb (9 kg)

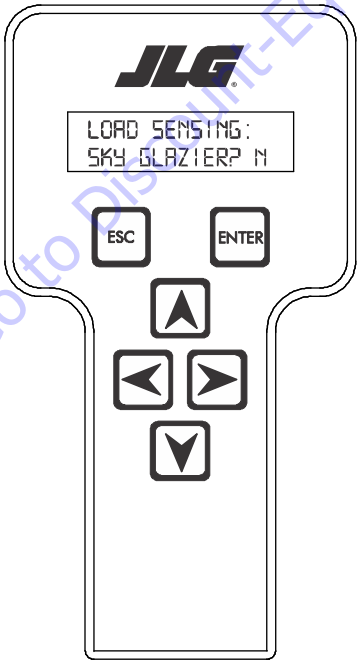
NOTE: *Not all Accessories are available on every JLG model. Some Accessory combinations are prohibited due to excessive weight and/or load restriction. If any installed JLG Accessories are labeled with weight decals but are not listed in the table above, include their weight when entering the ACC WEIGHT value.*

9. The control system will calculate the load cell readings and ensure it is greater than 130 lb (59 kg), but less than 575 lb(261 kg).

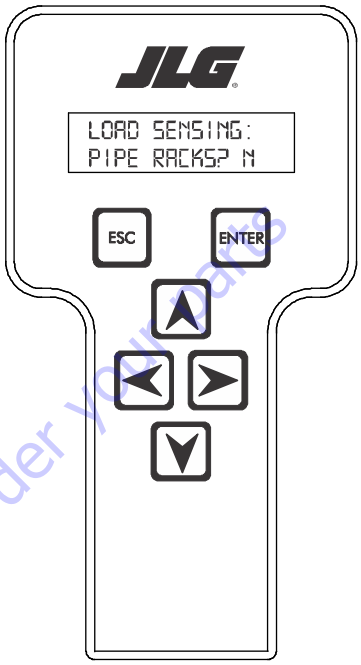
If the platform weight is not within the allowed range, the calibration attempt will be unsuccessful and the Analyzer will show the following:



10. Press ENTER (ENTER). The control system will ask for installed accessories. The screen will show the following:



11. Use the analyzer keys to select N for no or Y for yes. Press ENTER (ENTER). The screen will read:



12. Use the analyzer keys to select N for no or Y for yes. Press ENTER (ENTER). The control system will default to an estimate of unrestricted capacity, which can be adjusted if necessary. Refer to Table 6-7, SkyGlazier Capacity Reductions and Table 6-8, Pipe Rack Capacity Reductions.

    The screen will read:

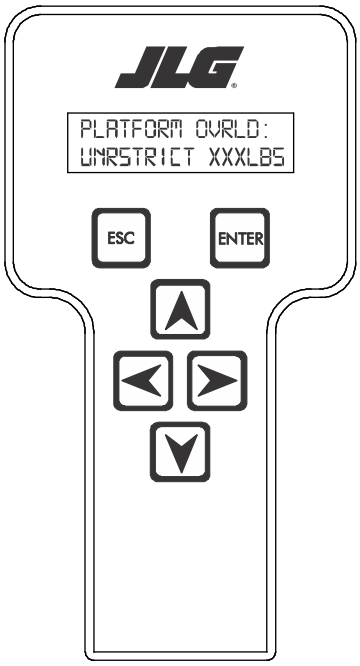


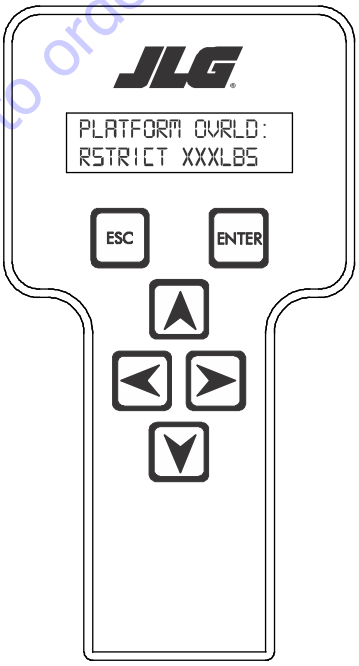
Table 6-7. SkyGlazier Capacity Reductions

Capacity	PLATFORM OVRLD	PLATFORM OVRLD RESTRICT
500 lb (227 kg)	400 lb (181 kg)	n/a
550 lb (250 kg)	400 lb (181 kg)	n/a
600 lb (272 kg)	400 lb (181 kg)	n/a
750 lb (340 kg)	n/a	590 lb (268 kg)
1000 lb (454 kg)	n/a	750 lb (340 kg)
Note: If both SkyGlazier and Pipe Racks are configured, capacity will be the lower of the two values.		

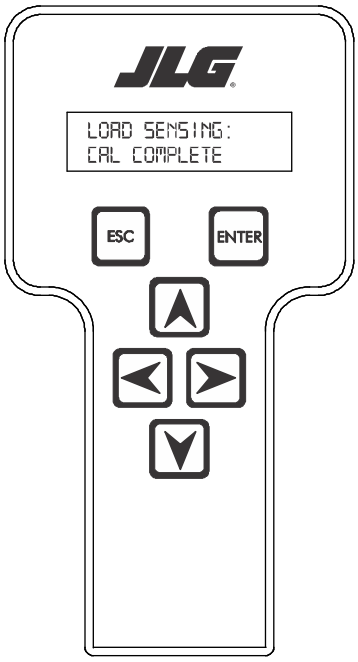
Table 6-8. Pipe Rack Capacity Reductions

Capacity	PLATFORM OVRLD	PLATFORM OVRLD RESTRICT
500 lb (227 kg)	400 lb (181 kg)	n/a
550 lb (250 kg)	450 lb (204 kg)	n/a
600 lb (272 kg)	500 lb (227 kg)	n/a
750 lb (340 kg)	n/a	650 lb (295 kg)
1000 lb (454 kg)	n/a	900 lb (408 kg)
Note: If both SkyGlazier and Pipe Racks are configured, capacity will be the lower of the two values.		

13. Press ENTER (ENTER). The following screen will be displayed for restricted capacity, which can be adjusted if necessary. Refer to Table 6-7, SkyGlazier Capacity Reductions and Table 6-8, Pipe Rack Capacity Reductions.



14. Press ENTER (ENTER). If calibration is successful, the screen will read:



Testing & Evaluation

Refer to Troubleshooting if the Load Sensing System fails to meet these guidelines.

1. Connect the JLG Analyzer.
2. Level the Platform. The platform should be approximately level for analysis, or the guidelines below will not be applicable. Level the platform from Ground Control (if necessary) to within ±5 degrees.
3. Observe the Empty Platform Weight. Proceed to the DIAGNOSTICS, PLTLOAD sub-menu and observe the measured platform load. All tools, debris, and customer-installed devices shall be removed during evaluation. Ideally, the PLTLOAD should be zero but can vary ±15 lb (± 7 kg). Further, the reading should be stable and should not vary by more than ±2 lb (±1kg) (unless there is heavy influence from wind or vibration).
4. Use the Technician's Weight to Evaluate. The technician should enter the platform and record the PLTLOAD reading while standing in the center of the platform.
5. Confirm Control System Warnings and Interlocks. Using the keyswitch, select Platform Mode and power-up. Start the vehicle's engine and ensure that all controls are functional and the Load Sensing System's Overload Visual and Audible Warnings are not active. Simulate an Overload by unplugging the Shear Beam Load Cell. The Overload Visual Warning should flash, and the Audible Warning (at Platform and Ground) should sound for 5 seconds On, and 2 seconds Off. With the engine running, all control should be prevented. Cycle the Platform EMS to stop the engine and then power-up again. The Overload Visual and Audible Warning should continue. Confirm that controls are responsive when using the Auxiliary Power Unit for emergency movement. Reconnect the Load Cell. The Overload Visual and Audible Warnings should cease and normal control function should return. Switch the vehicle's keyswitch to Ground Mode and repeat the above procedure. The Overload Visual Warning at the Ground Controls should flash, and the Audible Warning (at Platform and Ground) should sound for 5 seconds On, 2 seconds Off. However, the controls should remain functional when using the engine and the Auxiliary Power Unit (if the Control System's MACHINE SETUP, LOAD is set to "2=CUTOUT PLT". If set to "3=CUTOUT ALL", then Ground Controls will be prevented when using the engine as in the platform).
6. Confirm Control System Capacity Indication (optional for vehicles with Dual Capacity Ratings). For vehicles equipped with a Capacity Select switch on the Platform Console Box, it is necessary to examine an additional interface between the Load Sensing System and the Control System. Using the keyswitch, select Platform Mode and power-up. If necessary, put the boom in the transport position (completely stowed) and center the Jib Plus (if equipped). Place the Capacity Select switch in the unrestricted position and ensure that the proper indicator illuminates on the Platform Console Box. Plug the JLG Analyzer into the Analyzer connection and proceed to the DIAGNOSTICS, SYSTEM submenu. Ensure that the CAPACITY displays indicate OFF. Place the Capacity Select switch in the unrestricted position (if so equipped) and ensure that the proper indicator illuminates on the Platform Console Box (but does not flash). For vehicles with unrestricted capacity, ensure that the unrestricted CAPACITY display indicates ON but the restricted CAPACITY indicates OFF. For vehicles with restricted capacity, ensure that the unrestricted CAPACITY display indicates OFF but the restricted CAPACITY indicates ON.
7. Confirm Load Sensing System Performance with Calibrated Weights. Operate the vehicle from Ground Control and place the boom in the transport position (fully stowed) for safety. Plug the JLG Analyzer into the control system connection and proceed to the DIAGNOSTICS, PLTLOAD display. Place 500 lb (230 kg) in the platform and ensure that PLTLOAD is with ±5% of the actual weight. For Dual Capacity vehicles, do the same for the alternate capacity (unrestricted or restricted).

Troubleshooting

The following tables are furnished to provide possible resolutions for common difficulties. Difficulties are classified as General, Calibration, Measurement Performance, and Host System Functionality.

Table 6-9. LSS Troubleshooting Chart

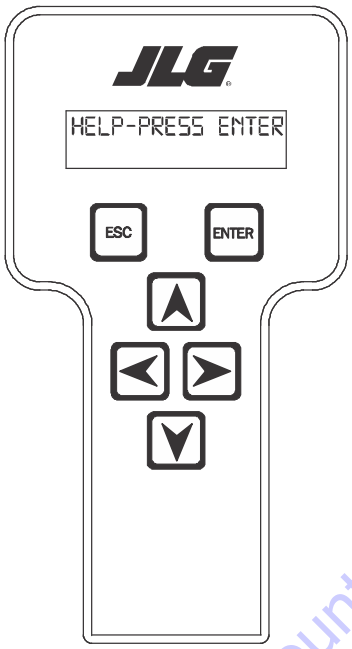
Difficulty	Possible Resolution
Empty Platform Weight (DIAGNOSTICS, PLATFORM LOAD) is not within ±15lb (±7 kg) of zero. or Platform Load readings (DIAGNOTICS, PLTLOAD) are unstable by more than ±2 lb (±1 kg) (without the influence of vibration or wind). or There are large variations in Platform Load (DIAGNOSTICS, PLTLOAD) based on the location of the load. Tolerance to variations is 20 lb for an evaluation using the technician's weight, and ±5% of Rated Load when using calibrated weights.	The LSS System is unable to properly measure the platform weight. 1. The Load Cell is not properly plugged into the LSS Harness. It is possible poor electrical contact is made. 2. Wiring leading to the Load Cell is damaged. Carefully inspect sensor wiring where it passes through cable clamps for signs of damage. Inspect wiring where damage to the channel is apparent. 3. The Load Cell was not assembled properly during installation. Examine the sensor's reading using the JLG Analyzer. Proceed to the DIAGNOSTICS, CELL, LOAD displays and determine if the readings are reasonable. It is often helpful to apply slight downward pressure above the sensor and observe that its output increases (increasing force measurement; decreasing means the sensor is mounted upside-down). 4. The Load Cell is contaminated by debris or moisture. Examine the sensor's reading using the JLG Analyzer. Proceed to the DIAGNOSTICS, CELL, LOAD displays and determine if the readings are reasonable and stable (not changing by more than ±2lb (±1 kg) (without the influence of vibration or wind). Lack of measurement stability is a key indication of contamination. Unplug the connector and inspect for dirt or moisture. Look carefully into the female connector on the sensor's cordset for evidence of contamination. Debris should be brushed away with a soft bristle brush (do not introduce any cleaners as they will leave conductive residue). Moisture should be allowed to evaporate or accelerated with a heat-gun (use low heat and be carefully to not melt connector materials). Moisture intrusion into the molded portion of the connector (capillary action into the wire bundle) or the Shear Beam Load Cell itself will require replacement of the sensor. 5. The Load Cell has been mechanically damaged. If the Load Cell is physically deformed or has damage to the cover it should be replaced immediately. It is also possible to have invisible mechanical damage resulting from an extreme overload (>6000 lb [>2722 kg]).
The Visual and Audible Overload Warnings fail to sound when platform is loaded beyond Rated Load, or when simulated by unplugging the Load Cell. Controls remain functional at Platform and Ground Control positions.	The Control System is failing to regard the overload signal from the LSS System, or the signal is shorted. 1. The Load Sensing System must be enabled within the Control System. Plug the JLG Analyzer into the Control System, enter the Access Level 1 password (33271), and examine the MACHINE SETUP, LOAD sub-menu. The selection "2=CUTOUT PLT" should be displayed (platform controls prevented during overload, ground controls remain operational). In country- or customer-specific circumstance, the selection "3=CUTOUT ALL" is used (platform and ground controls prevented during overload).
The Ground Audible Warning fails to sound, but the Platform Audible Warning sounds properly.	The Ground Alarm is missing or improperly installed. Verify that the device is mounted. Verify wiring from the Main Terminal Box and Ground Module.
Controls remain functional at the Ground Control position during an overload, or when simulated by unplugging the Load Cell. The Controls at the Platform Control position are prevented when using the engine, but not when using the Auxiliary Power Unit.	The JLG Control System is configured to prevent platform controls only in the event of overload. Alternately, the Host Control System can be configured to prevent ground and platform controls for country- or customer-specific circumstances. Using the JLG Analyzer, enter the Access Level 1 password (33271). Proceed to the MACHINE SETUP, LOAD sub-menu. Set this parameter to "2=CUTOUT PLT" to prevent platform controls in the event of overload. Set this parameter to "3=CUTOUT ALL" to prevent platform and ground controls in the event of overload.

6.3 RESETTING THE MSSO SYSTEM

1. Use the following procedure to reset the MSSO system.
2. Position the Platform/Ground select switch to the desired position.
3. Plug the analyzer into the connector coming from the ground control module or from the platform console.

NOTE: *If performing the procedure from the platform console, the Emergency Stop switch on the ground console must also be pulled out.*

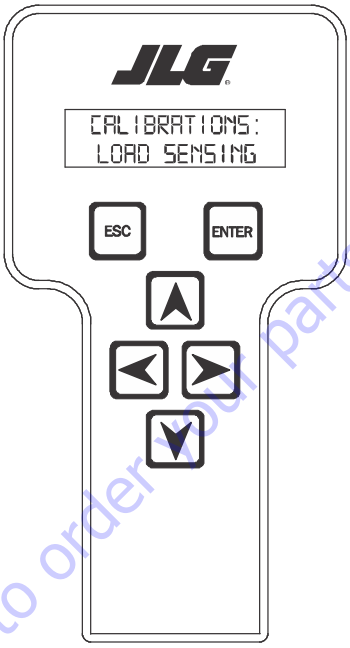
4. Pull out the Emergency Stop switch.
5. The analyzer screen should read:



6. Use the arrow button to reach OPERATOR ACCESS. Press Enter 

.
7. Enter the Access Code, 33271.
8. Use the right Arrow key to reach MENU: CALIBRATIONS. Press Enter 

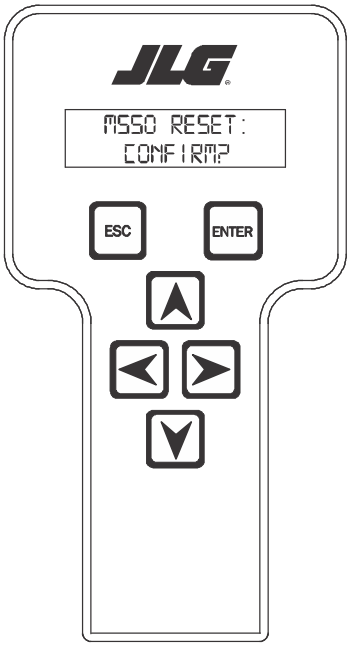
.
9. Use the arrow keys to reach the LOAD SENSING menu. The screen should read:



10. Press ENTER 

.
11. Use the left arrow key  or right arrow key  arrow to reach MSSO RESET.

12. Press Enter (ENTER). The screen will read:

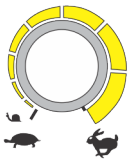


13. Press Enter (ENTER). The JLG Control System will reset an active 873 DTC and the MSSO System will be reset. Press Escape (ESC) to return to the CALIBRATIONS menu.

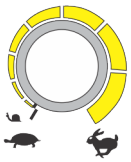
6.4 MACHINE MODEL ADJUSTMENT

Adjustment Notes

1. Personality settings can be adjusted anywhere within the adjustment range in order to achieve optimum machine performance.
2. Stop watch should be started with the function movement, not with actuation of the joystick or switch.
3. Drive speeds should be set to the values below regardless of the tire size.
4. All speed tests are run from the platform, these speeds do not reflect the ground control operation.
5. The Function Speed Control knob must be at full speed (turned clockwise completely) unless noted.



6. Some flow control functions may not work with the Function Speed Control knob clicked into the creep position.

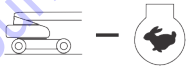


7. Functional speeds may vary due to cold thick hydraulic oil. Test should be run with the oil temperature above 38° C (100° F)

Machine Orientation When Performing Test

DRIVE (BELOW ELEVATION)

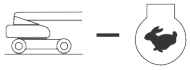
1. Test should be done on a smooth, level surface. The Drive Select Switch should be in the "Max Speed" position.



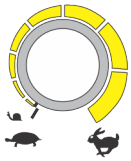
2. Start approximately 7.6m (25 ft) from starting point so the unit is at a maximum speed when starting the test.
3. Results should be recorded for a 61m (200ft) course.
4. Drive forward, "High Speed", record time
5. Drive Reverse, "High Speed", record time

DRIVE (ABOVE ELEVATION)

1. Test should be done on a smooth, level surface. The Drive Select Switch should be in the "Max Speed" position.

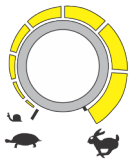


2. The boom should be > 10° above horizontal to ensure the drive is operating in Max Torque mode.
3. Results should be recorded for a 15.2m (50ft) course.
4. Drive forward, record time
5. Drive Reverse, record time
6. Turn Platform Speed Control Knob fully counterclockwise to enter Creep mode.



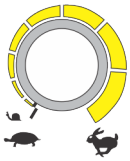
7. Creep light on Panel must be energized.

8. Verify that machine will Drive Forward and Reverse.
9. Return Knob to fully clockwise.



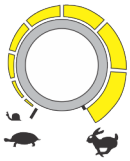
SWING

1. Boom at full elevation, Telescope retracted. Swing Right until over rear axle or end stop (if equipped).
2. Swing Left 360° or end stop (if equipped), record time.
3. Swing Right 360° or end stop (if equipped), record time.
4. Turn Platform Speed Control Knob fully counterclockwise to enter Creep mode.



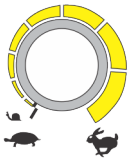
5. Creep light on Panel must be energized.

6. Verify that machine will swing left and right.
7. Return Function Speed Knob to fully clockwise.



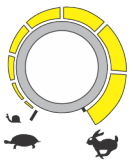
MAIN LIFT

1. Main Lift in stowed position, Telescope Retracted.
2. Main Lift Up, record time.
3. Main Lift Down, record time.
4. Turn Platform Speed Control Knob fully counterclockwise to enter Creep mode.



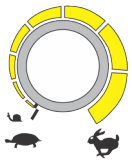
5. Creep light on Panel must be energized.

6. Verify that machine will Lift Up and Down.
7. Return Knob to fully clockwise.



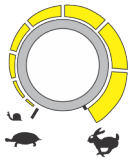
TELESCOPE

1. Main Lift at full elevation, Telescope Retracted.
2. Telescope Out, record time.
3. Telescope In, record time.
4. Turn Platform Speed Control Knob fully counterclockwise to enter Creep mode.



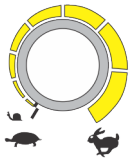
5. Creep light on Panel must be energized.

6. Verify that machine will Telescope In and Out.
7. Return Knob to fully clockwise.



JIB LIFT

1. Platform level and centered with the boom. Jib Lift Down until stop.
2. Jib Lift Up, record time.
3. Jib Lift Down, record time.
4. Turn Platform Speed Control Knob fully counterclockwise to enter Creep mode.

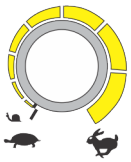


5. Creep light on Panel must be energized.

6. Verify that machine will Jib Lift Up and Down.
7. Return Knob to fully clockwise.

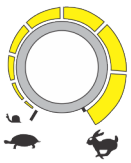
PLATFORM ROTATE

1. Platform level, Rotate Platform Right until stop
2. Platform Left, record time.
3. Platform Right, record time.
4. Turn Platform Speed Control Knob fully counterclockwise to enter Creep mode.



5. Creep light on Panel must be energized.

6. Verify that machine will Platform Rotate Left and Right.
7. Return Knob to fully clockwise.



NOTE: *When the platform speed control knob is turned fully counterclockwise. The platform rotate may not work, this is acceptable.*

Table 6-10. Machine Model Adjustment Speeds

FUNCTION		ADJUSTMENT RANGES	400S / 460SJ MODEL DEFAULTS		MODEL TIME RANGES (IN SECONDS)	
					400S	460SJ
DRIVE			4WD	2WD		
	Accel	25 – 2000mA/s	300mA/s			
	Decel	25 – 2000mA/s	800 mA/s			
	Min	250 – 1000mA	725 mA			
	Max	250 – 1400mA	1175 mA		30 – 34	30 – 34
Drive to Stop	Decel	25 – 2000mA/s	400 mA/s			
MT: Elevated	Max	250 – 1200mA	890 mA	795 mA	68 – 85	68 – 85
ME: Elevated	Max	250 – 1200mA	990 mA	835mA	68 – 85	68 – 85
Max Torque	Creep	250 – 1200mA	890 mA	795 mA		
Mid Engine	Creep	250 – 1200mA	990 mA	835mA		
ME = Mid Engine, MT = Max Torque						
SWING						
	Accel	0 – 3s	2.2 s			
	Decel	0 – 2s	1.2s			
LEFT	Min	250 – 1400mA	420 mA			
	Max	250 – 1400mA	860 mA		70 – 90	70 – 90
	Creep	250 – 1400mA	650 mA			
RIGHT	Min	250 – 1400mA	400 mA			
	Max	250 – 1400mA	800 mA		70 – 90	70 – 90
	Creep	250 – 1400mA	650 mA			
LIFT						
	Accel	0 – 3s	1.5 s			
	Decel	0 – 2s	0.8 s			
UP	Min	250 – 1400mA	400 mA			
	Max	250 – 1400mA	900 mA		33 – 40	34 – 41
	Creep	250 – 1400mA	600 mA			
DOWN	Min	250 – 1400mA	380 mA			
	Max	250 – 1400mA	750 mA		33 – 40	34 – 41
	Creep	250 – 1400mA	500 mA			
	Soft Down	250 – 1400mA	450 mA			
	Soft Down	250 – 1400mA	450 mA			
TELECOPE						
	Accel	0 – 3s	1 s			
	Decel	0 – 2s	0.8 s			
IN	Min	250 – 1400mA	415 mA			
	Max	250 – 1400mA	890 mA		33 – 40	33 – 40
	Creep	250 – 1400mA	580 mA			
OUT	Min	250 – 1400mA	415 mA			
	Max	250 – 1400mA	780 mA		33 – 40	33 – 40
	Creep	250 – 1400mA	525 mA			

Table 6-10. Machine Model Adjustment Speeds

FUNCTION		ADJUSTMENT RANGES	400S / 460SJ MODEL DEFAULTS	MODEL TIME RANGES (IN SECONDS)	
				400S	460SJ
JIB LIFT					
	Accel	0 – 3s	1.2 s		
	Decel	0 – 2s	0.5 s		
UP	Min	250 – 1400mA	350 mA		
	Max	250 – 1400mA	690 mA	18 – 22	18 – 22
	Creep	250 – 1400mA	500 mA		
DOWN	Min	250 – 1400mA	350 mA		
	Max	250 – 1400mA	630 mA	18 – 22	18 – 22
	Creep	250 – 1400mA	450 mA		
PLATFORM LEVEL					
	Accel	0 – 3s	0 s		
	Decel	0 – 2s	0 s		
UP	Min	250 – 1400mA	400 mA		
	Max	250 – 1400mA	600 mA		
	Creep	250 – 1400mA	600 mA		
DOWN	Min	250 – 1400mA	400 mA		
	Max	250 – 1400mA	600 mA		
	Creep	250 – 1400mA	600 mA		
PLATFORM ROTATE					
	Accel	0 – 3s	0 s		
	Decel	0 – 2s	0 s		
LEFT	Min	250 – 1400mA	500 mA		
	Max	250 – 1400mA	600 mA	20 – 25	20 – 25
	Creep	250 – 1400mA	600 mA		
RIGHT	Min	250 – 1400mA	500 mA		
	Max	250 – 1400mA	600 mA	20 – 25	20 – 25
	Creep	250 – 1400mA	600 mA		
GROUND MODE					
SWING	Left	250 – 1400mA	855 mA		
	Right	250 – 1400mA	795 mA		
LIFT	Up	250 – 1400mA	895 mA		
	Down	250 – 1400mA	745 mA		
TELESCOPE	In	250 – 1400mA	885 mA		
	Out	250 – 1400mA	775 mA		
JIB	Up	250 – 1400mA	685 mA		
	Down	250 – 1400mA	625 mA		
PLATFORM	Up / Down	250 – 1400mA	595 mA		
PLATFORM	Left / Right	250 – 1400mA	595 mA		

1001193361-F

Table 6-11. Diagnostic Trouble Code Chart

Help Message	DTC	Fault Condition/Trigger (For configurable items, fault applies only if configured. All listed conditions to be met unless stated otherwise)	Required Control Response or State Assignment	Conditions Required for Movement and/or to Clear Fault	400S	450AJ
Note: "Controls Initialized" means all controls have been released / returned to neutral, and the machine enable (footswitch) has been released.						
EVERYTHING OK	001[1]	Machine is in Platform Mode; The UGM determines no problems exist	No response required for this DTC		X	X
GROUND MODE OK	002[1]	Machine is in Ground Mode; The UGM determines no problems exist	No response required for this DTC		X	X
RUNNING AT CUTBACK – OUT OF TRANSPORT POSITION	0010[1]	Machine is in the Out of Transport position	Response described in Drive Modes section	Machine is not in the Out of Transport position	X	X
FSW OPEN	0011[1]	Machine is in Platform Mode; Any of the following Platform inputs become active after power up, but before Machine Enabled: Drive joystick is not in the neutral position Steer; Lift and/or Swing joystick is not in the neutral position; Tower Lift (340AJ, 450AJ); Telescope; Platform Level; Platform Rotate; Jib Lift (if MACHINE SETUP > JIB = YES)	The UGM shall not Enable the Machine	Controls initialized	X	X
RUNNING AT CREEP - CREEP SWITCH OPEN	0012[1]	Machine is in Platform Mode; Platform Creep switch input = HIGH; DTC 0013 is not active	The UGM shall limit the machine to Creep speed	Platform Creep switch input = Low	X	X
RUNNING AT CREEP - TILTED AND ABOVE ELEVATION	0013[1]	Machine is in Platform Mode; The Boom is Above Elevation; Machine chassis is considered Tilted	The UGM shall limit the machine to Creep speed; If MACHINE SETUP > TILT = (angle) + CUT, response described in Tilted Output Cutouts section	Not all of the trigger conditions are met	X	X
LOAD SENSOR READING UNDER WEIGHT	0015	LSS has been calibrated and the UGM has determined that the load sensing system reading is less than -50 lb for 2 seconds. If the load sensing system determines that the reading is greater than -50 lb for 5 seconds this fault will no longer be annunciated. No control system interlocks present when DTC is active.		Ensure platform is not resting on the ground or is not leveled at an extreme negative angle. Re-calibrate the load sensing system if the above items are not a factor.		
FUEL LEVEL LOW – ENGINE SHUTDOWN	0031	Engine Shutdown has occurred due to Fuel Level = EMPTY condition.	Response described in Fuel Shutdown section	Power Cycled	X	X
APU ACTIVE	0035	Auxiliary Power/Emergency Descent Mode is active	Response described in Auxiliary Power/Emergency Descent Mode section	Auxiliary Power/Emergency Descent Mode is not active	X	X

Table 6-11. Diagnostic Trouble Code Chart

Help Message	DTC	Fault Condition/Trigger (For configurable items, fault applies only if configured. All listed conditions to be met unless stated otherwise)	Required Control Response or State Assignment	Conditions Required for Movement and/or to Clear Fault	400S	450AJ
FUNCTION PREVENTED - FUNCTION SELECTED BEFORE GROUND ENABLE	0036	Machine is in Ground Mode; Any of the following Ground inputs become active after power up, but before Machine Enabled: Lift; Swing; Tower Lift (340AJ, 450AJ); Telescope; Platform Level; Platform Rotate; Jib Lift (if MACHINE SETUP > JIB = YES)	The UGM shall not Enable the Machine	Controls initialized	X	X
SKYGUARD ACTIVE – FUNCTIONS CUTOUT	0039	MACHINE SETUP > SKYGUARD = YES; Machine is in Platform Mode; SkyGuard Enabled	Response described in SkyGuard section	Not all of the trigger conditions are met	X	X
KEYSWITCH FAULTY	212	UGM Ground Mode input J7-3 input = High; UGM Platform Mode input J7-2 input = High	The UGM shall assume a station selection of Ground	(J7-3 input = LOW) or (J7-2 input = LOW)	X	X
FSW FAULTY	213	The ground footswitch input and platform footswitch input have been both HIGH or both LOW for greater than or equal to 1 second	The UGM shall not Enable the Machine	Power Cycled	X	X
FUNCTION PROBLEM - HORN PERMANENTLY SELECTED	221	Machine is in Platform Mode; The Horn switch input = High at Startup	The UGM shall prohibit Horn; Ground and Platform Alarm are still permitted	The Horn switch input = Low	X	X
FUNCTION PROBLEM - STEER LEFT PERMANENTLY SELECTED	224	Machine is in Platform Mode; The Steer Left switch input = High at Startup	The UGM shall prohibit Steer Left and Right; The UGM shall limit Drive to Creep	The Steer Left switch input = Low; Steer Left and Right and full Drive speed permitted after controls are initialized	X	X
FUNCTION PROBLEM - STEER RIGHT PERMANENTLY SELECTED	225	Machine is in Platform Mode; The Steer Right switch input = High at Startup	The UGM shall prohibit Steer Left and Right; The UGM shall limit Drive to Creep	The Steer Right switch input = Low; Steer Left and Right and full Drive speed permitted after controls are initialized	X	X
STEER SWITCHES FAULTY	227	The Steer Left switch input = High; The Steer Right switch input = High; (detectable in Platform or Ground mode)	The UGM shall prohibit Steer; The UGM shall limit Drive to Creep	The Steer Left switch input = Low; The Steer Right switch input = Low; Steer and full Drive speed permitted after controls are initialized	X	X
FSW INTERLOCK TRIPPED	2211	Machine is in Platform Mode; The Footswitch is active for more than seven seconds with no Drive, Steer, or Boom commands	The UGM shall disable Machine Enable	The footswitch is released	X	X

Table 6-11. Diagnostic Trouble Code Chart

Help Message	DTC	Fault Condition/Trigger (For configurable items, fault applies only if configured. All listed conditions to be met unless stated otherwise)	Required Control Response or State Assignment	Conditions Required for Movement and/or to Clear Fault	400S	450AJ
DRIVE LOCKED - JOYSTICK MOVED BEFORE FOOTSWITCH	2212	Machine is in Platform Mode; The UGM detects one of the following conditions: Drive joystick is not in the neutral position at Startup; Drive joystick is not in the neutral position when Footswitch becomes active or while DTC 2213, 2221 or 2223 is active	If triggered by the Drive joystick not being in the neutral position at Startup, the UGM shall prohibit Drive and Steer. If triggered by the Drive joystick not being in the neutral position when Footswitch becomes active or while DTC 2213, 2221 or 2223 is active, the UGM shall not Enable the Machine	If triggered by the Drive joystick not being in the neutral position at Startup, then (Drive joystick is returned to its neutral position) and (Drive and Steer permitted after controls initialized) If triggered by the Drive joystick not being in the neutral position when Footswitch becomes active or while DTC 2213, 2221 or 2223, then controls initialized	X	X
STEER LOCKED - SELECTED BEFORE FOOTSWITCH	2213	Machine is in Platform Mode; A Steer input is active when Footswitch becomes active or while DTC 2212, 2221 or 2223 is active	The UGM shall not Enable the Machine	Controls initialized	X	X
D/S JOY. OUT OF RANGE HIGH	2216	The PM detects that the Drive or Steer joystick signal voltage > 8.1V and reports the fault to the UGM.	The UGM shall prohibit Drive; Brake release and Steer still permitted	The PM no longer reports the fault	X	X
D/S JOY. CENTER TAP BAD	2217	The PM detects that the Drive or Steer center tap voltage is not between 3.31 volts and 3.75 volts and reports the fault to the UGM	The UGM shall prohibit Drive; Brake release and Steer still permitted	The PM detects that the drive/steer center tap voltage is between 3.31 and 3.75 volts and no longer reports the fault to the UGM	X	X
L/S JOY. OUT OF RANGE HIGH	2219	The PM detects that the Lift or Swing joystick signal voltage > 8.1V and reports the fault to the UGM.	If the Machine is in Platform Mode, the UGM shall prohibit Lift and Swing	The PM detects that the Lift and Swing joystick signal voltage is < 8.1V and no longer reports the fault to the UGM	X	X
L/S JOY. CENTER TAP BAD	2220	The PM detects that the Lift or Swing center tap voltage is not between 3.31 volts and 3.75 volts and reports the fault to the UGM	If the Machine is in Platform Mode, the UGM shall prohibit Lift and Swing	The PM detects that the lift/swing center tap voltage is between 3.31 and 3.75 volts and no longer reports the fault to the UGM	X	X
LIFT/SWING LOCKED - JOYSTICK MOVED BEFORE FOOTSWITCH	2221	Machine is in Platform Mode; The UGM detects one of the following conditions: Lift and/or Swing joystick is not in the neutral position at Startup; Lift and/or Swing joystick is not in the neutral position when Footswitch becomes active or while DTC 2212, 2213 or 2223 is active	If triggered by the Lift and/or Swing joystick not being in the neutral position at Startup, the UGM shall prohibit Lift and Swing. If triggered by Lift and/or Swing joystick is not in the neutral position when Footswitch becomes active or while DTC 2212, 2213 or 2223 is active, the UGM shall not Enable the Machine	If triggered by the Lift and/or Swing joystick not being in the neutral position at Startup, then (Lift and/or Swing joystick is returned to its neutral position) and (Lift and Swing permitted after controls initialized) If triggered by the Lift and/or Swing joystick is not in the neutral position when Footswitch becomes active or while DTC 2212, 2213 or 2223 is active, then controls initialized	X	X
WAITING FOR FSW TO BE OPEN	2222	Machine is in Platform Mode; Footswitch is active at Start Up	The UGM shall not Enable the Machine	Controls initialized	X	X

Table 6-11. Diagnostic Trouble Code Chart

Help Message	DTC	Fault Condition/Trigger (For configurable items, fault applies only if configured. All listed conditions to be met unless stated otherwise)	Required Control Response or State Assignment	Conditions Required for Movement and/or to Clear Fault	400S	450AJ
FUNCTION SWITCHES LOCKED - SELECTED BEFORE ENABLE	2223	Machine is in Platform Mode; Any of the following Platform inputs are active when Footswitch becomes active or while DTC 2212, 2213 or 2221 is active: Tower Lift; Telescope; Platform Level; Platform Rotate; Jib Lift (if MACHINE SETUP > JIB = YES)	The UGM shall not Enable the Machine	Controls initialized	X	X
FOOTSWITCH SELECTED BEFORE START	2224	Machine is in Platform Mode; The engine is stopped; Startup time has expired; The Footswitch is active before the Platform Engine Start switch input = High	The UGM shall prohibit Engine Start	The Platform Engine Start switch input = Low;	X	X
FUNCTION PROBLEM - PLATFORM ROTATE LEFT PERMANENTLY SELECTED	2247	Machine is in Platform Mode; The Platform Rotate Left switch input = High at Startup	The UGM shall prohibit Platform Rotate Left and Right	The Platform Rotate Left switch input = Low; Platform Rotate Left and Right permitted after controls are initialized	X	X
FUNCTION PROBLEM - PLATFORM ROTATE RIGHT PERMANENTLY SELECTED	2248	Machine is in Platform Mode; The Platform Rotate Right switch input = High at Startup	The UGM shall prohibit Platform Rotate Left and Right	The Platform Rotate Right switch input = Low; Platform Rotate Left and Right permitted after controls are initialized	X	X
FUNCTION PROBLEM - JIB LIFT UP PERMANENTLY SELECTED	2249	Machine is in Platform Mode; MACHINE SETUP > JIB = YES; The Jib Lift Up switch input = High at Startup	The UGM shall prohibit Jib Lift Up and Down	The Jib Lift Up switch input = Low; Jib Lift Up and Down permitted after controls are initialized	X	X
FUNCTION PROBLEM - JIB LIFT DOWN PERMANENTLY SELECTED	2250	Machine is in Platform Mode; MACHINE SETUP > JIB = YES; The Jib Lift Down switch input = High at Startup	The UGM shall prohibit Jib Lift Up and Down	The Jib Lift Down switch input = Low; Jib Lift Up and Down permitted after controls are initialized	X	X
FUNCTION PROBLEM - TELESCOPE IN PERMANENTLY SELECTED	2251	Machine is in Platform Mode; The Telescope In switch input = High at Startup	The UGM shall prohibit Telescope In and Out	The Telescope In switch input = Low; Telescope permitted after controls are initialized	X	X
FUNCTION PROBLEM - TELESCOPE OUT PERMANENTLY SELECTED	2252	Machine is in Platform Mode; The Telescope Out switch input = High at Startup	The UGM shall prohibit Telescope In and Out	The Telescope Out switch input = Low; Telescope permitted after controls are initialized	X	X
FUNCTION PROBLEM - TOWER LIFT UP PERMANENTLY SELECTED	2257	Machine is in Platform Mode; The Tower Lift Up switch input = High at Startup	The UGM shall prohibit Tower Lift Up and Down	The Tower Lift In switch input = Low; Tower Lift Up and Down permitted after controls are initialized		X
FUNCTION PROBLEM - TOWER LIFT DOWN PERMANENTLY SELECTED	2258	Machine is in Platform Mode; The Tower Lift Down switch input = High at Startup	The UGM shall prohibit Tower Lift Up and Down	The Tower Lift Down switch input = Low; Tower Lift Up and Down permitted after controls are initialized		X
FUNCTION PROBLEM - PLATFORM LEVEL UP PERMANENTLY SELECTED	2262	Machine is in Platform Mode; The Platform Level Up switch input = High at Startup	The UGM shall prohibit Platform Level Up and Down	The Platform Level Up switch input = Low; Platform Level Up and Down permitted after controls are initialized	X	X
FUNCTION PROBLEM - PLATFORM LEVEL DOWN PERMANENTLY SELECTED	2263	Machine is in Platform Mode; The Platform Level Down switch input = High at Startup	The UGM shall prohibit Platform Level Up and Down	The Platform Level Down switch input = Low; Platform Level Up and Down permitted after controls are initialized	X	X

Table 6-11. Diagnostic Trouble Code Chart

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FUNCTION PROBLEM - DOS OVERRIDE PERMANENTLY SELECTED	2264	Machine is in Platform Mode; The DOS Override switch input = High at Startup	No response required for this DTC	The DOS Override switch input = Low	X	X
FUNCTION PROBLEM - SOFT TOUCH / SKYGUARD OVERRIDE PERMANENTLY SELECTED	2286	[(MACHINE SETUP > SKYGUARD = YES) or (MACHINE SETUP > SOFT TOUCH = YES)]; Machine is in Platform Mode; The Soft Touch / SkyGuard Override switch input = High at Startup	No response required for this DTC	The Soft Touch / SkyGuard Override switch input = Low	X	X
FUNCTION SWITCHES FAULTY - CHECK DIAGNOSTICS/BOOM	234	The UGM detects one of the following conditions (continuous monitoring): The machine is in Ground Mode and both direction inputs of the following boom controls are engaged at the same time: Engine Start/Aux, Telescope, Platform Level, Platform Rotate, Jib Lift, Tower Lift, Lift, or Swing. The machine is in Platform Mode and both direction inputs of the following boom controls are engaged at the same time: Engine Start/Aux, Telescope, Platform Level, Platform Rotate, Jib Lift (MACHINE SETUP > JIB = YES), Tower Lift (340AJ, 450AJ); or for Drive Mode – Max Speed/Max Torque	Disable whichever boom functions whose boom control inputs are triggering the fault. If Engine Start/Aux at fault, disable Engine Start but permit Auxiliary Power/Emergency Descent.	None of the boom controls that trigger this fault have both of their direction inputs engaged at the same time	X	X
FUNCTION SWITCHES LOCKED - SELECTED BEFORE AUX POWER	235	The UGM detects one of the following conditions: The machine is in Ground Mode and the engine is stopped and the ground APU/Function Enable switch becomes engaged while a Ground control input is already engaged. The machine is in Platform Mode and the engine is stopped and the platform APU/Auxiliary Descent switch becomes engaged while a Platform control input is already engaged.	The UGM not enable Auxiliary Power/ Emergency Descent mode	The applicable APU/Auxiliary Descent switch is disengaged or all applicable control inputs become disengaged or the engine state becomes ENGINE RUNNING	X	X
FUNCTION SWITCHES LOCKED - SELECTED BEFORE START SWITCH	236	The UGM detects one of the following conditions: The machine is in Ground Mode and the engine is stopped and any configured boom control is already engaged and the ground start switch changes from not engaged to engaged The machine is in Platform Mode and the engine is stopped and any drive/steer or configured boom control is already engaged and the footswitch is not engaged and the platform start switch changes from not engaged to engaged	The UGM shall prohibit Engine Start	The selected station's start switch is no longer engaged	X	X
START SWITCH LOCKED - SELECTED BEFORE KEYSWITCH	237	The start switch for the selected station is engaged during the UGM startup sequence	The UGM shall prohibit Engine Start	The selected station's start switch is no longer engaged	X	X
FUNCTION PROBLEM - GROUND ENABLE PERMANENTLY SELECTED	2310	Machine is in Ground Mode; The Ground Enable switch input = High at Startup	The UGM shall prohibit Engine Start; The UGM shall not Enable the Machine	Controls initialized	X	X
BOOM ANGLE SENSOR – NOT CALIBRATED	2343	The Boom Angle Sensor has not been calibrated	The UGM shall assume the Boom is Above Elevation; The UGM shall report a faulted boom angle of 90 degrees	Boom angle sensor calibrated	X	X