



Service Bulletin No. LT20070717
Subject: Mast Support Guide Pin
Model: LT-12D
Product Group: Light Tower/Generator
Date: July 17, 2007

SERVICE BULLETIN

Group: LT

THIS SERVICE BULLETIN IS MANDATORY!

Series/Parts Affected:
All LT-12D series Light Towers within VIN range
Machines Affected/Trailer Vehicle Identification Number (VIN)
903838 - 904667

SERVICE INFORMATION

MANDATORY UPDATE: FAILURE TO FOLLOW INSTRUCTIONS MAY LEAD TO INJURY OR DEATH AND CAUSE SEVERE UNIT DAMAGE!

Problem:

- Mast Support Guide Pin may break off if impacted.
- This condition may cause the mast to slide out of the receiver cradle during travel and ***may lead to injury or death and severe unit damage!***

Solution: Weld around the ***Mast Support Guide Pin*** on the top side of cradle.

PARTS INFORMATION

Quantity	Part #	Description	Remarks
1	29945	Mast Support W/A	If required.



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INSTRUCTIONS

WORK SAFELY!

This procedure should be performed only by a **qualified welder** following safe and approved welding techniques.

1. Place light tower in an open work area free of any obstructions and overhead power lines. Make certain light tower is placed on secure level ground and lower each of the stabilization jacks to prevent tipping. Place chock blocks under both wheels to prevent rolling.
2. To remove mast locking pin from mast support cradle, pull upward on locking pin retaining ring, then pull outward on mast locking pin. (Figure 1). Pull locking pin all the way out from mast support cradle.

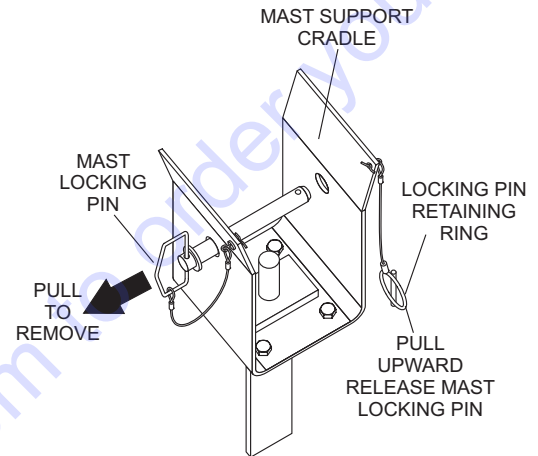


Figure 1. Mast Support Cradle

3. Turn mast winch handle (Figure 2) clockwise and raise mast assembly from horizontal (transport) position to the vertical (upright) position, approximately 3 feet (1 meter). Keep telescopic sections in the lowered position-**DO NOT EXTEND THE TELESCOPIC SECTIONS!**

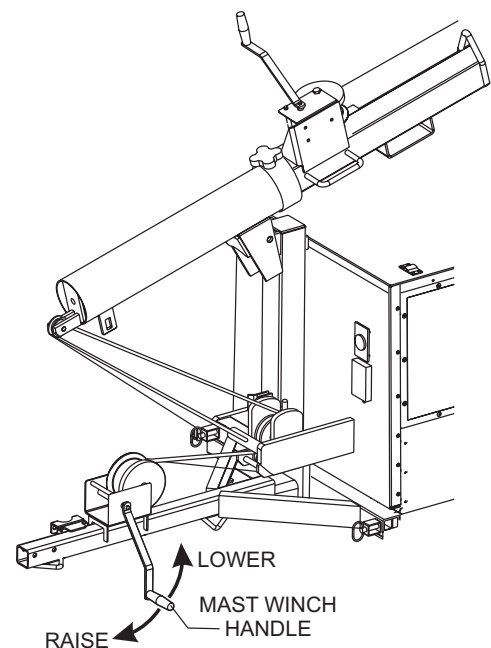


Figure 2. Raising Mast

4. Remove black rubber support pad (Figure 3) from mast support cradle. Set rubber support pad aside.

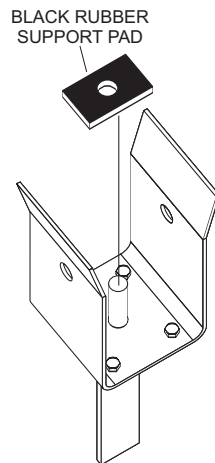


Figure 3. Black Rubber Pad

5. Using a 3/8-inch ratchet (Figure 4) with a 9/16-inch socket and a 9/16-inch combination wrench, remove the mounting bolts and associated hardware securing the mast support cradle to the frame. Set mounting hardware aside and remove mast support cradle.

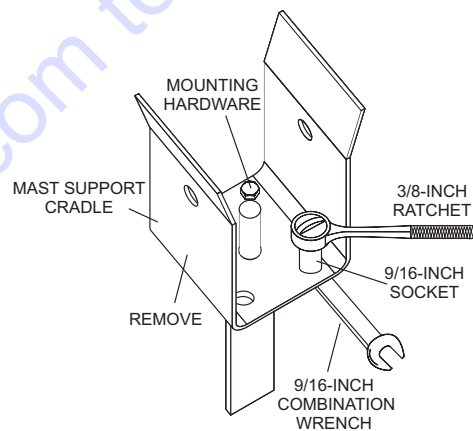


Figure 4. Mast Support Cradle Removal

6. Perform the following when preparing the mast support guide pin for welding:
 - Remove paint from area to be heated during welding.

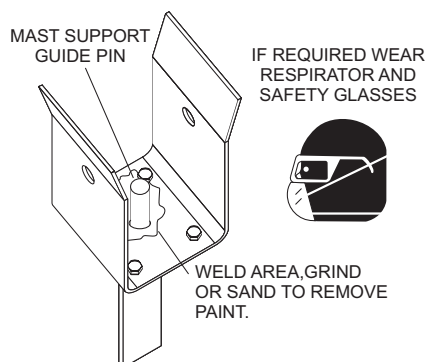


Figure 5. Preparing Mast Support Cradle

- If paint cannot be removed wear an approved respirator before heating or welding to prevent inhalation of hazardous material.
- If sanding or grinding paint wear an approved respirator to avoid breathing in dust or other hazardous material. In addition wear suitable eye protection to protect eyes from dust or debris.
- **DO NOT** use chlorinated solvents in areas where welding will take place.
- Do all work in an area that is well ventilated to prevent inhalation of dust and toxic fumes.
- Always properly dispose of paint and solvents.

Welding Recommendations

Current and voltage settings will vary according to the machine and operator.

Stick Weld Application

Use a 7018 (3/32-inch) stick with a rod current setting of 60 to 80 amps or lower. Fine tune as necessary.

MIG/Wire Feed Weld Application

Set voltage to 20.5, with a wire speed feed rate of 275 inches/minute. Fine tune as necessary. Use 0.035-inch mild steel solid wire with a mixture of 75% argon and 25% CO₂.

6. Using either the stick or MIG wire feed method of welding; weld area around mast support guide pin (Figure 6). Locate welder ground clamp as close to the mast support cradle as possible.
7. At the completion of the welding process, remove any burrs or rough edges surrounding the mast support guide pin.
8. Clean area around guide pin with a wire brush, then paint guide pin area with **white glossy spray paint**. Let mast support cradle cool before painting.

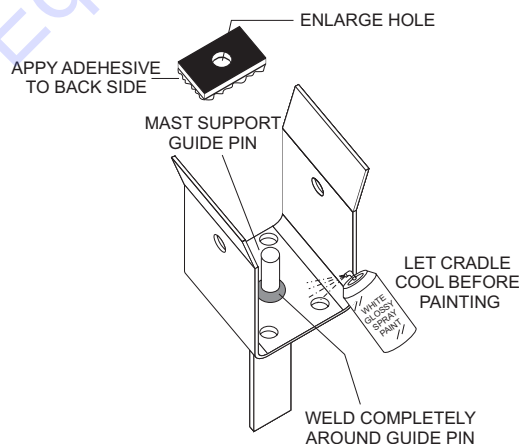


Figure 6. Mast Support Guide Pin Welding

CAUTION: When welding, remember excessive heat can cause structural failure!

9. Enlarge hole on black rubber support pad (Figure 6) to accommodate for the additional welding. Place adhesive on backside of pad and reinstall back into support cradle.
10. Place support cradle onto frame, and hand-tighten mounting hardware.
11. Turn mast winch handle counterclockwise and lower mast assembly slowly onto mast support cradle, aligning mast assembly with guide pin. Once mast assembly has been properly aligned with guide pin, securely tighten support cradle mounting hardware.
12. Insert locking pin into mast support cradle and lock.

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