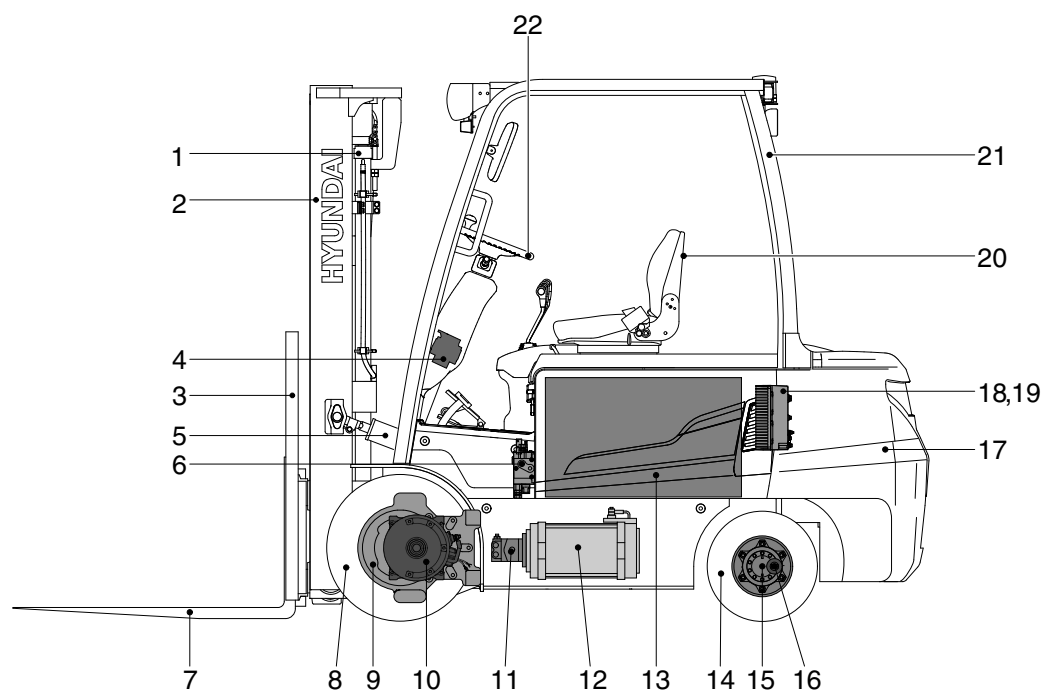


SECTION 2 REMOVAL & INSTALLATION OF UNIT

Group 1	Major components	2-1
Group 2	Removal and installation of unit	2-2

SECTION 2 REMOVAL & INSTALLATION OF UNIT

GROUP 1 MAJOR COMPONENTS



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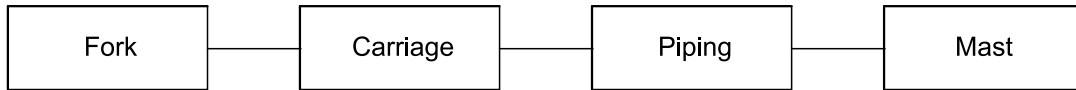
- | | | | | | |
|---|--------------------|----|-------------------|----|---------------------|
| 1 | Lift cylinder | 9 | Drive unit | 17 | Counterweight |
| 2 | Mast | 10 | Drive motor | 18 | Traction controller |
| 3 | Backrest | 11 | Hydraulic pump | 19 | Pump controller |
| 4 | Steering unit | 12 | Pump motor | 20 | Seat |
| 5 | Tilt cylinder | 13 | Battery | 21 | Overhead guard |
| 6 | Main control valve | 14 | Rear wheel | 22 | Steering wheel |
| 7 | Forks | 15 | Steering axle | | |
| 8 | Front wheel | 16 | Steering cylinder | | |

GROUP 2 REMOVAL AND INSTALLATION OF UNIT

Remove and install following units as explained in the flow chart.

1. MAST

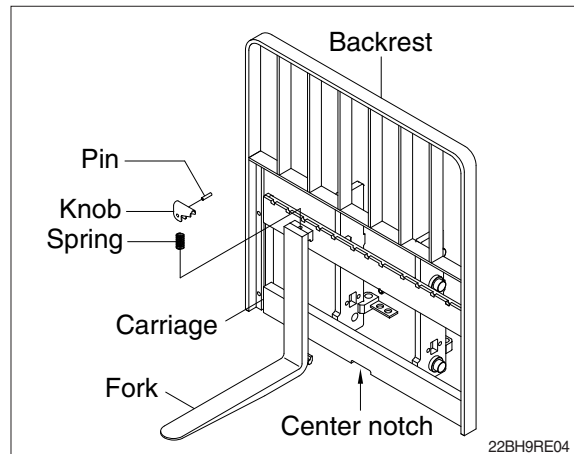
1) REMOVAL



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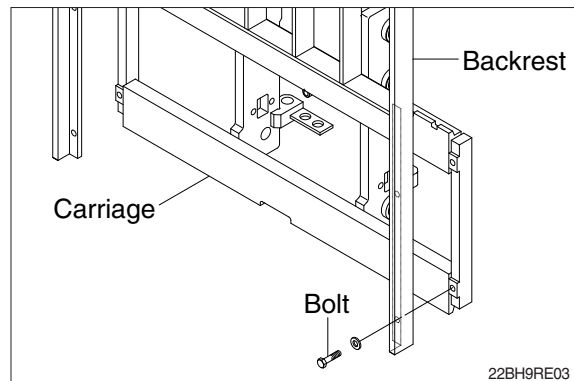
(1) Forks

- ① Lower the fork carriage until the forks are approximately 25 mm (1 in) from the floor.
 - ② Turn knob up and slide one fork at a time toward the center of the carriage where a notch has been cut in the bottom plate for easy removal.
 - ③ Remove only one fork at a time.
- ※ On larger forks it may be necessary to use a block of wood.



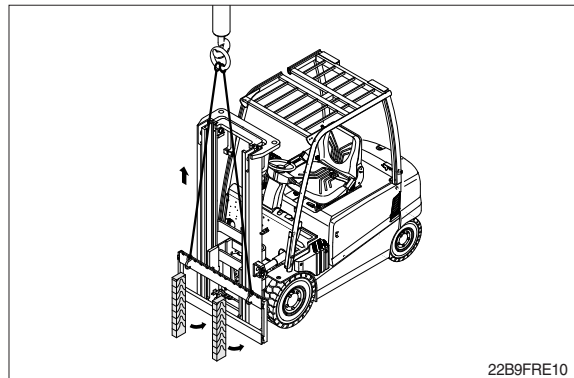
(2) Backrest (If necessary)

- ① Remove bolts securing backrest to fork carriage. Disassemble the backrest from the carriage.

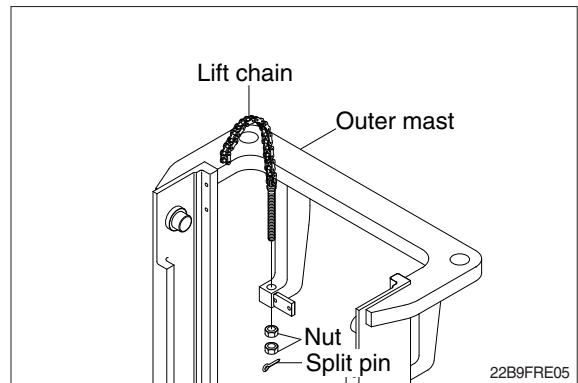


(3) Carriage

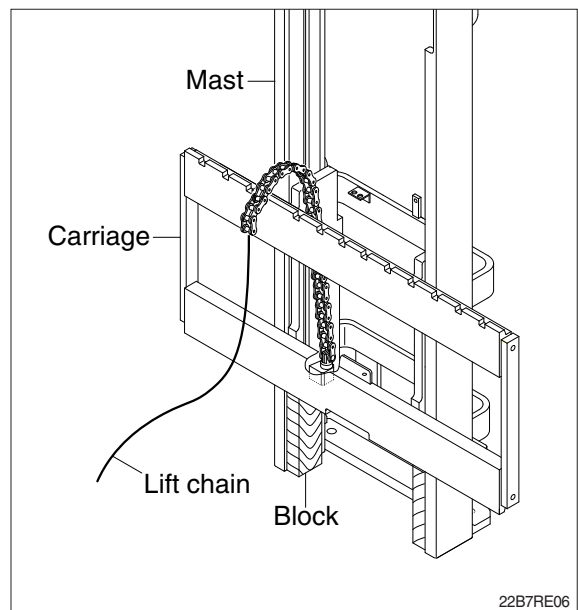
- ① With the mast vertical, raise the carriage high enough to place blocks under the load forks. This is done to create slack in the load chains when the carriage is lowered. Lower the carriage all the way down to the floor. Make sure the carriage is level, this will prevent any binding when the mast is raised.



- ② While supporting lift chains, remove the split pins and nuts from anchor pins of stationary upright.



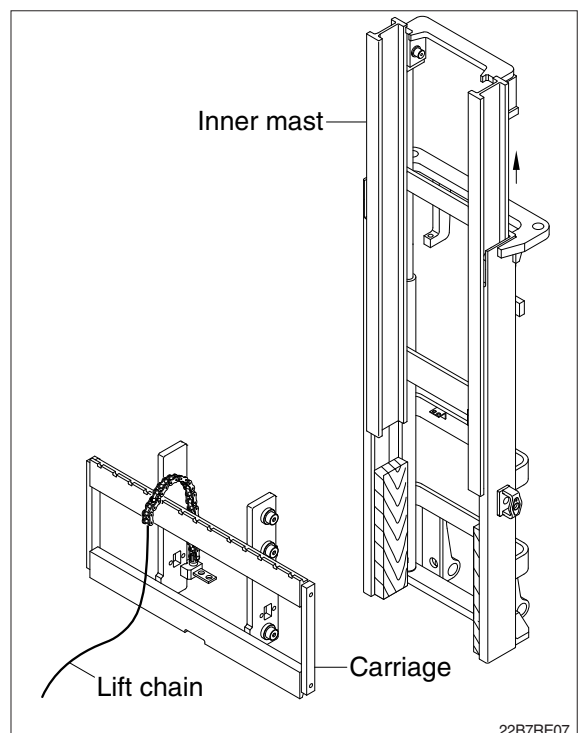
- ③ Pull the chains out of the sheaves and drape them over the front of the carriage.



- ④ Slowly raise inner mast upright until mast clears top of fork carriage. Move carriage to work area and lower the mast.

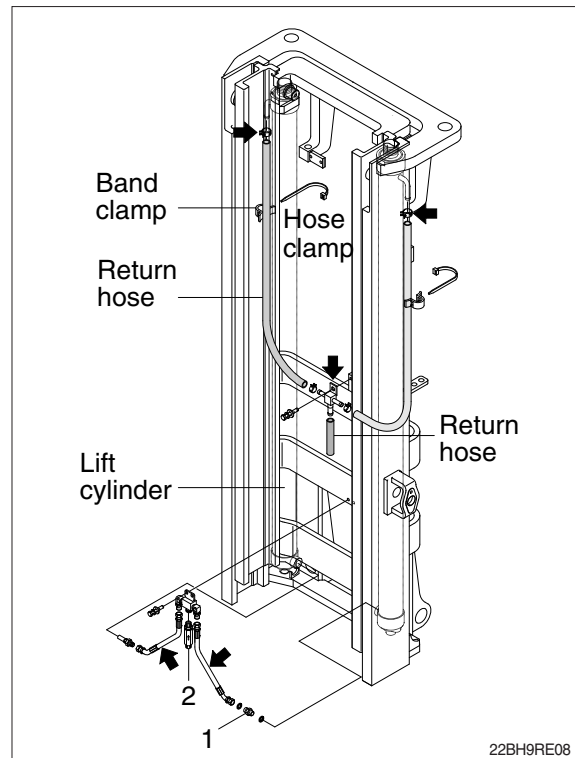
▲ Make sure that carriage remains on floor and does not bind while mast is being raised.

- ⑤ Inspect all parts for wear or damage. Replace all worn or damaged parts.



(4) Piping

- ① Remove the return hoses and clamps attached to the cylinder.
- ② Remove the return hoses from the connector.
- ③ Remove hose assembly, tee, velocity fuse valve (1) from the lift cylinder.
- ④ Disconnect hose assembly from the flow regulator (2).
- ⑤ Disconnect the hoses from the lift cylinders after removing band clamp and hose clamp.
- ⑥ Remove the return tee and hose clip from the hoses.

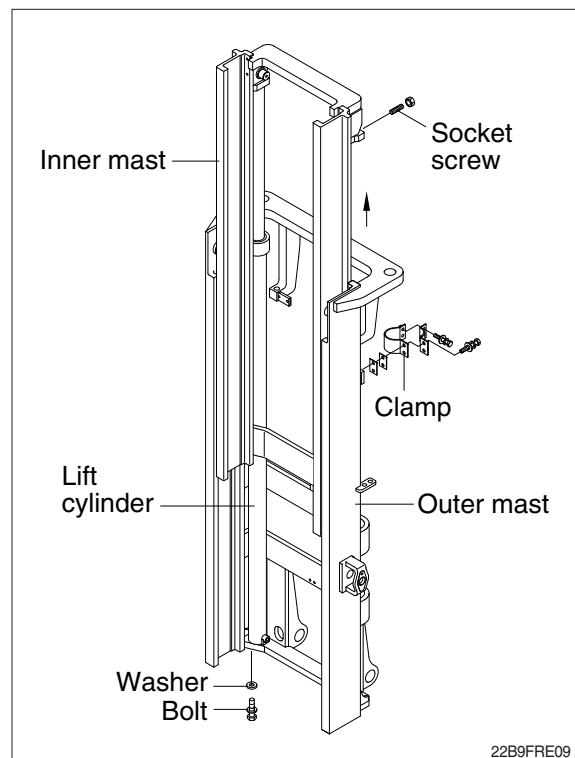


(5) Lift cylinder

- ① Loosen hexagonal bolts and washers securing the lift cylinders to outer mast.
- ② Bind the lift cylinder with overhead hoist rope and pull up so that the rope has no slack or binding.

▲ Make sure that the lift cylinder be tightened firmly for safety.

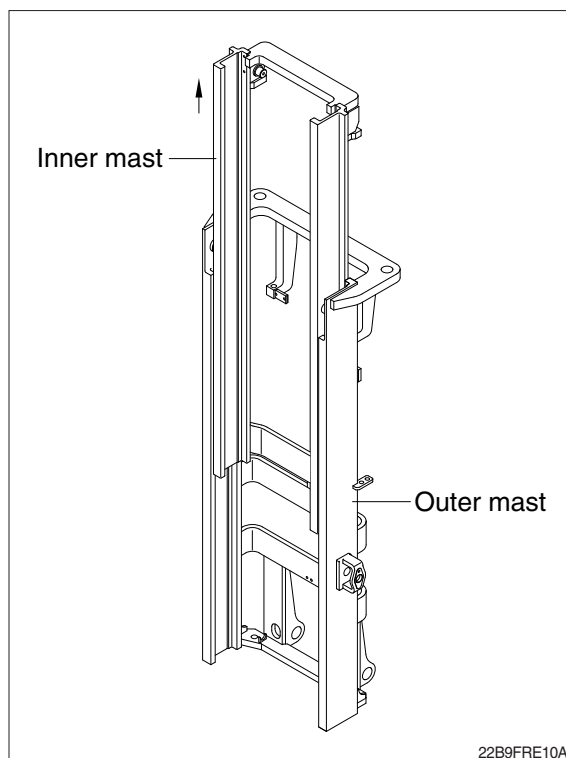
- ③ Loosen and remove hexagon bolts and clamp securing cylinder.
- ④ Using an overhead hoist, slowly raise the inner mast high enough to clear lift cylinder.
- ⑤ Using an overhead hoist, draw out lift cylinder carefully and put down on the work floor.



(6) Inner mast

- ① Using an overhead hoist raise the inner mast straight and carefully draw out of outer mast section.

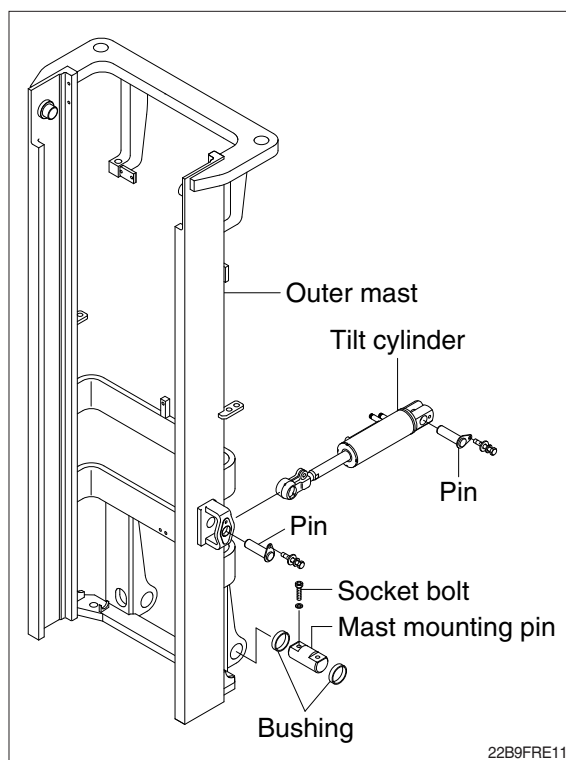
▲ Be careful the mast not to swing or fall.



(7) Tilt cylinder pin

(8) Mast mounting pin

- ① Attach a crane to the stay at the top of the outer mast, and raise enough to sustain jacked up machine.
 - ※ This operation is carried out from under the machine, so use a pit, or if there is no pit, jack up the machine and loosen with on impact wrench.
- ② Loosen the mounting socket bolts and remove mast mounting pin. Then slowly raise the outer mast.



2) INSTALLATION

After assembling mast components totally without piping connections, install mast assembly to the equipment.

※ Installation procedure for each of mast component is the reverse of the removal procedure.

(1) Mast mounting pin

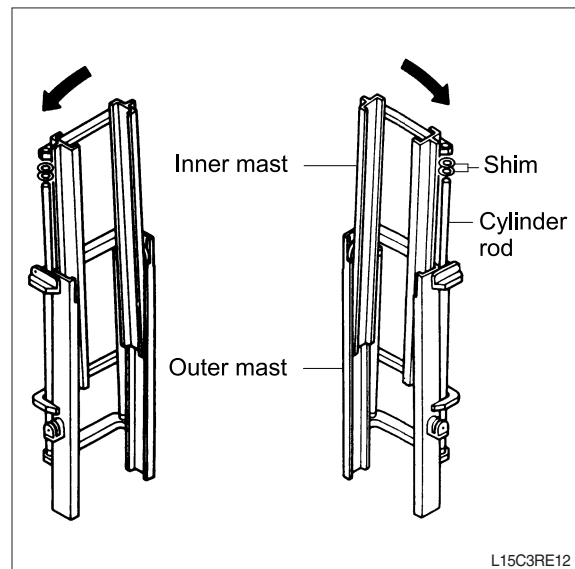
- ① Check the mast mounting pin, and bushing for wear.
- ② Jack up the machine so that the front is raised and then using an overhead hoist assemble outer mast to drive axle unit.
- ③ Tighten mounting socket bolts for the mast mounting pin.
 - Tightening torque : 25.2~34.2 kgf · m (182~247 lbf · ft)

(2) Tilt cylinder pin

Hold the mast with a crane, operate the tilt control lever and align the holes, then knock the pin.

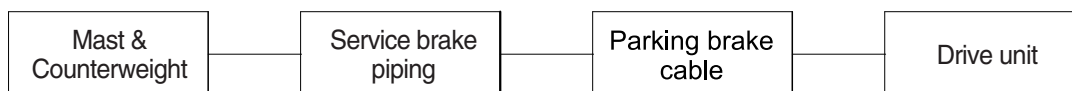
(3) Lift cylinder installation and adjustment

- ① Assemble the lift cylinder inside the outer mast, then tighten the stopper bolt. If the cylinder assembly has been replaced, adjust as follows so that the left and right cylinders are synchronized at the maximum lifting height.
 - ② Assemble the cylinder rod to the inner mast, and check the left-to-right play of the mast at the maximum lifting height.
- ※ If play is to LEFT, install adjustment shim to LEFT cylinder.
- ※ If play is to RIGHT, install adjustment shim to RIGHT cylinder.
- Shim thickness : 1.0 mm (0.04 in)



2. POWER TRAIN ASSEMBLY

1) REMOVAL

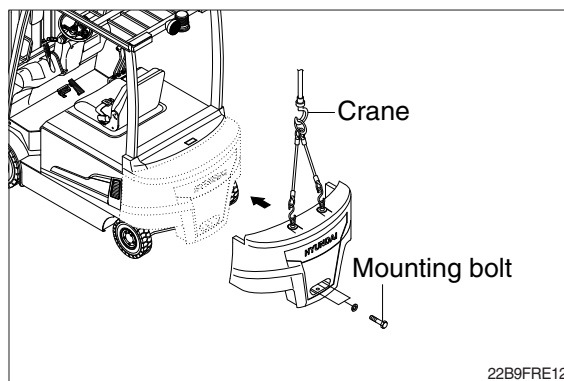


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(1) Mast and counterweight

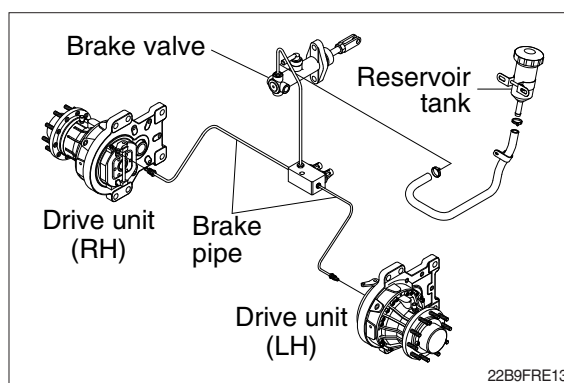
Refer to section on mast(Page 2-2)

- ※ After removing mast, remove the counterweight to prevent the truck from turning over.



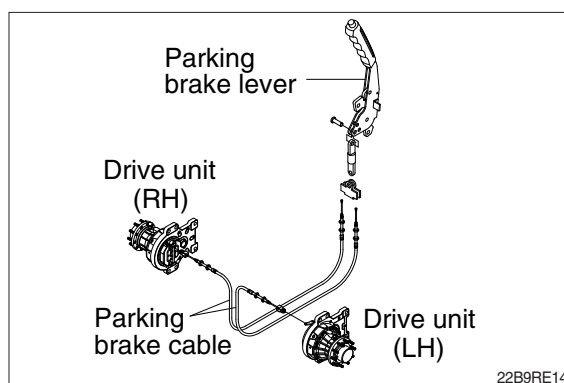
(2) Service brake piping

Disconnect the service brake piping from the drive unit.



(3) Parking brake cable

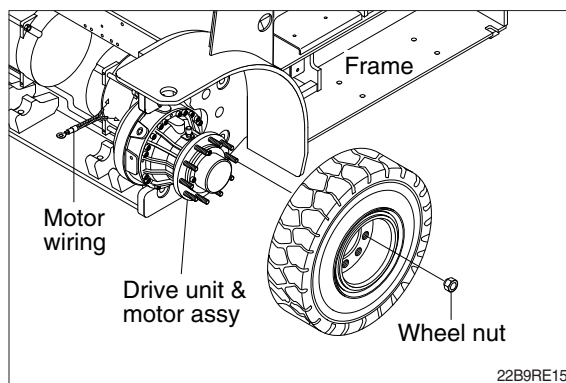
Disconnect parking brake cable from the drive unit.



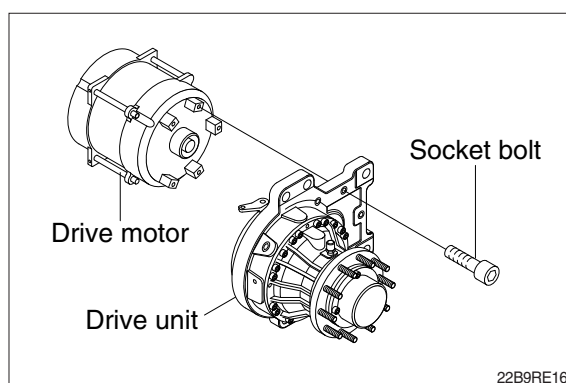
(4) Drive unit & motor assy

※ Drain the oil before disassembling the drive unit.

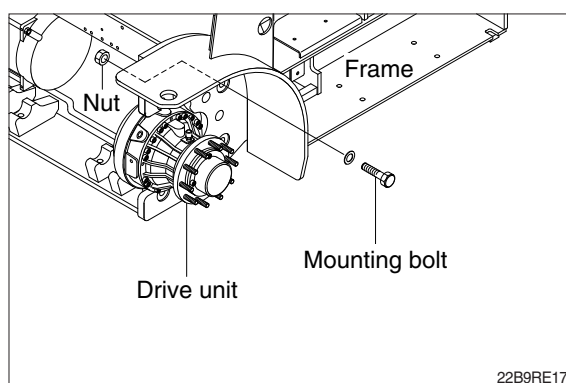
- ① Unscrew ten wheel nuts and remove the wheel.



- ② Remove five socket bolts holding the drive motor in place.
- ③ Carefully remove the drive motor from the drive unit.



- ④ Loosen six mounting bolts on the truck frame and carefully take out the drive unit.

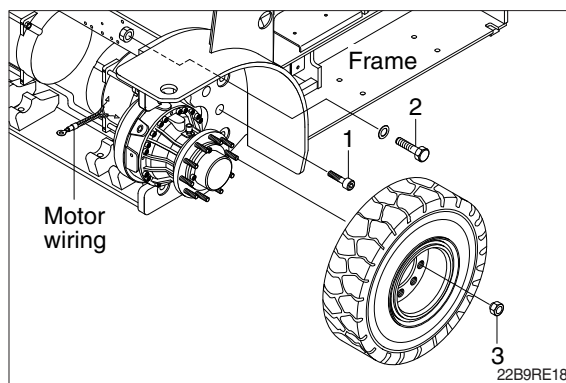


2) INSTALLATION

Installation is the reverse order of removal, but be careful of the following tightening torque.

• Tightening torque

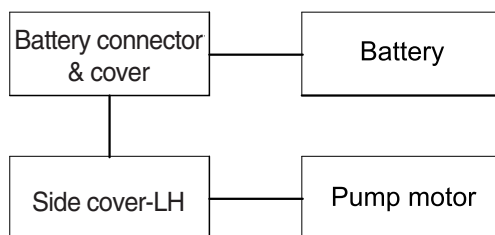
Item	kgf · m	lbf · ft
Drive motor (1)	6 ~ 8	43.4 ~ 57.9
Drive unit (2)	53 ~ 58	383 ~ 420
Wheel nut (3)	13.4 ~ 18	96.9 ~ 130



3. ELECTRICAL COMPONENTS

Before removing each component, disconnect cables and earth lines attached to the component.

1) REMOVAL



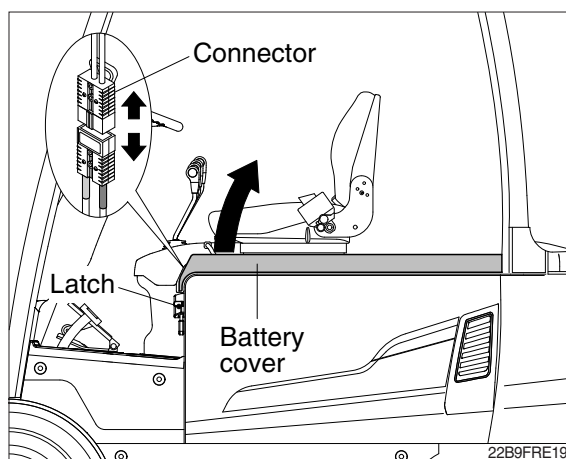
B15T5RE001

(1) Battery

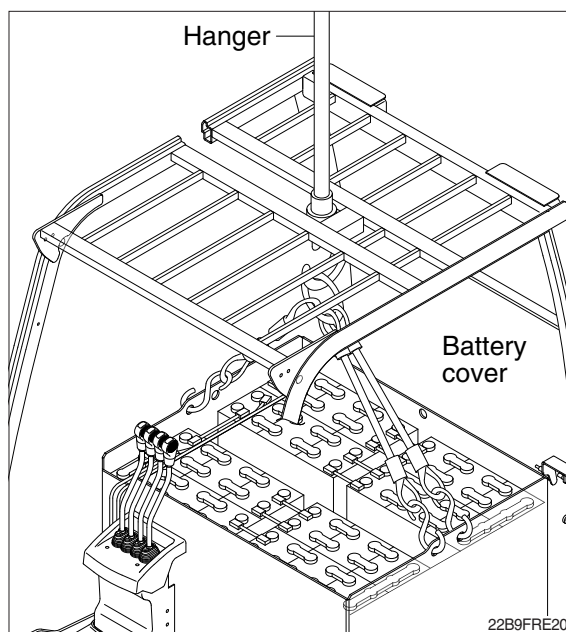
- ⚠ Before pulling out the battery plug, tilt the mast forward a little, and lower the fork to the lowest position.

The batteries weigh from around 970 kg to 1495 kg so the extreme care must be taken when handling them.

- ① Disconnect the battery connector.
Release the battery cover latch and open the battery cover.

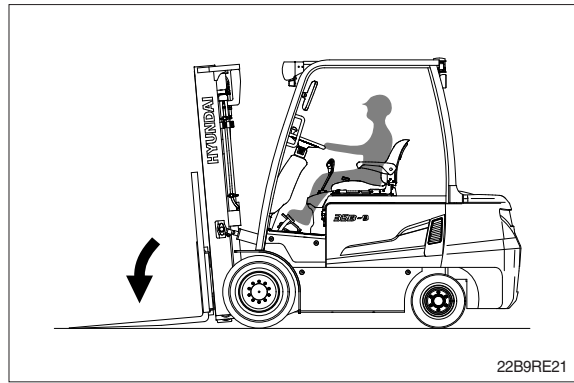


- ② Using a battery hanger, carefully raise the battery assembly.
- ※ Be careful not to damage overhead guard or control system.

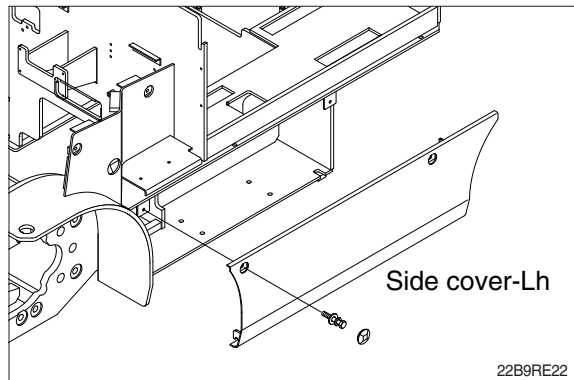


(2) Pump motor

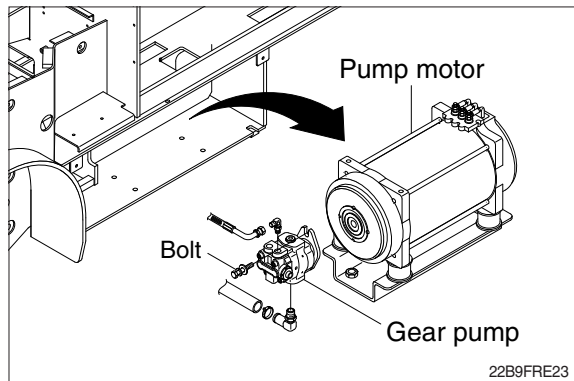
- ① Lower the fork to floor.



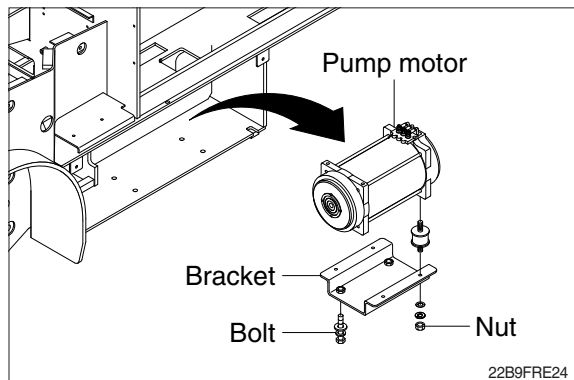
- ② Remove the side cover - LH.



- ③ Disconnect the wiring of pump motor, the rubber hose, the hydraulic hose.
- ④ Loosen the mounting bolts and remove the gear pump from pump motor.
 - Tightening torque : 5.5~8.3 kgf · m
(39.8~60 lbf · ft)



- ⑤ Remove the tightening bolts of the pump motor mounting bracket.
Remove the motor from mounting bracket.
 - Tightening torque
Bolt : 5.5~8.3 kgf · m (39.8~60 lbf · ft)
Nut : 2.0~3.0 kgf · m (14.5~21.7 lbf · ft)

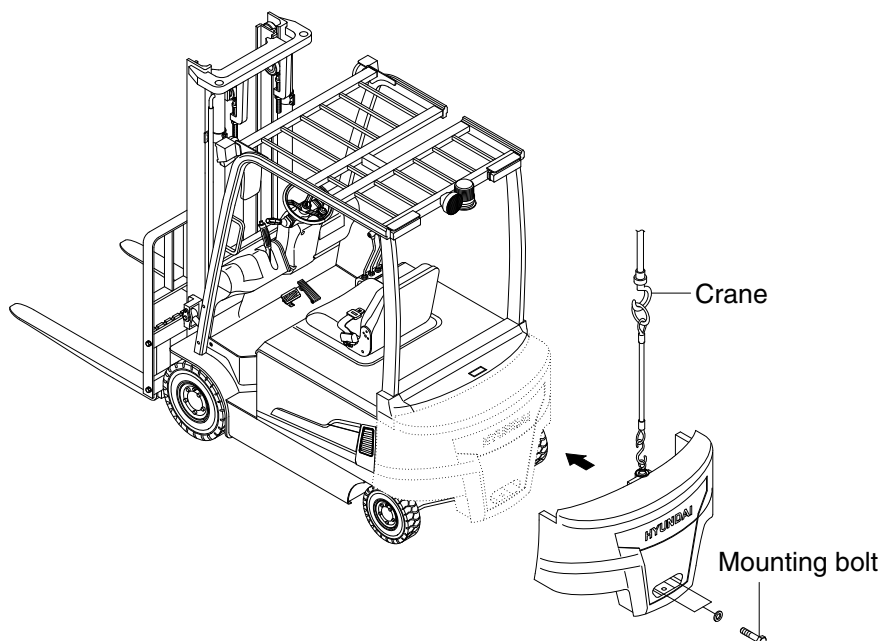


4. STEERING AXLE

1) REMOVAL



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① Counterweight

Install a lifting tool in the counterweight, and raise with a crane.

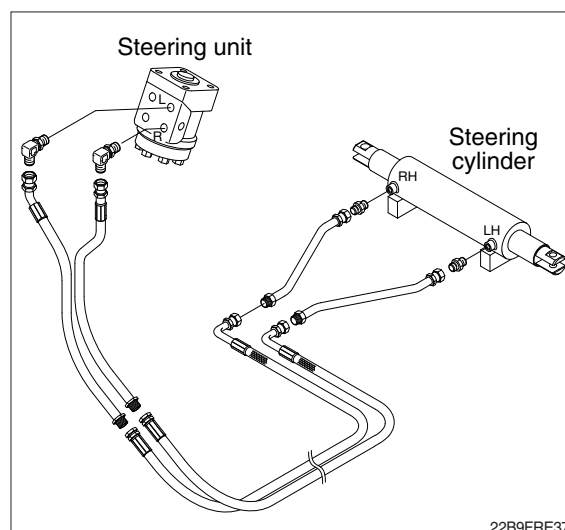
Remove the mounting bolts, raise slightly and move to the rear.

- Weight of counterweight (standard)

22B-9F	740 kg (1630 lb)	30B-9F	1194 kg (2630 lb)
25B-9F	890 kg (1960 lb)	-	-

- Tightening torque : 184~214 kgf · m (1330~1545 lbf · ft)

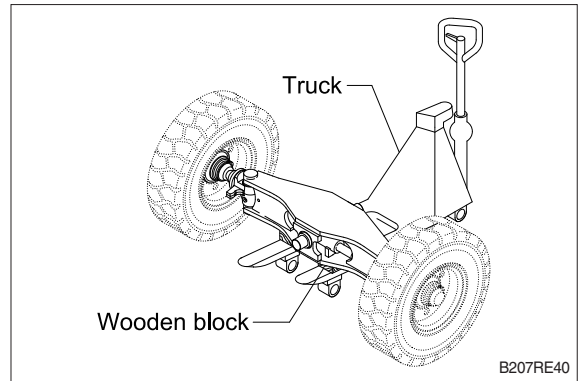
② Hose



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③ Mounting bolt

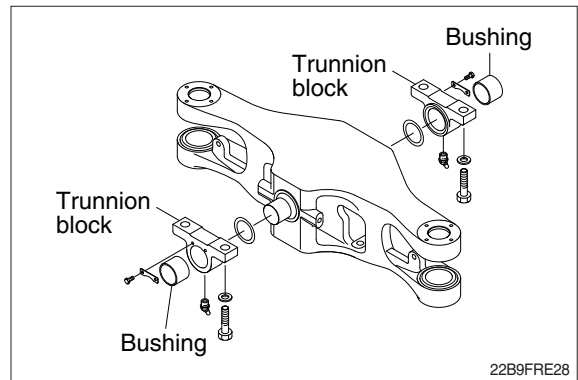
Put a block under the steering axle, support on a truck, and raise the frame with a crane. Remove the mounting bolts installed to the frame, and pull out to the rear. There are shims between the support and rear axle to prevent play.



(2) Installation

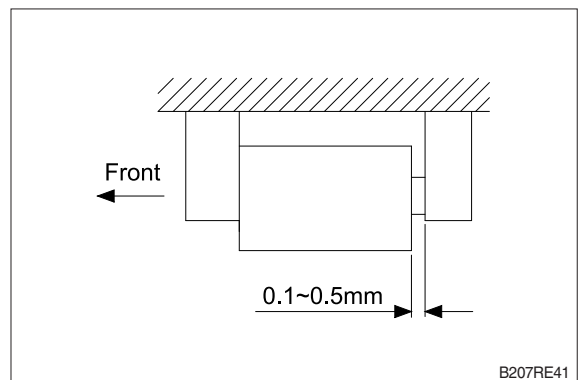
Installation is in the reverse order to removal, but be careful of the following points.

- ① When replacing the bushing at the support, install so that the hole in the bushing faces down.



- ② Install the support so that the clearance is under 0.5mm when the support is pushed fully to the rear. Tightening torque of mounting bolt for support. Apply loctite #277.

• 59~65 kgf · m (427~470 lbf · ft)



- ③ When installing the rear wheel, coat the hub bolt and tighten the nut to 22~24 kgf · m (159~174 lbf · ft).
- ④ When installing the counterweight, align with the center of frame. Coat the mounting bolt with molybdenum disulphide and tighter.