

The following instructions describes the preparation and installation of the Outrigger Stop Block.

1.1 MODELS AFFECTED

G10-43A, G10-55A & G12-55A

1.2 WELD REPAIR GUIDELINES

⚠ CAUTION

Use all applicable Safety precautions while working on, around or under any machinery.

- All welding must be in accordance with ANSI/AWS D1.1 Standard.
- Disconnect the battery of the machine being repaired prior to welding.
- Ground only to the component being welded. Do not ground to any adjacent component or allow pins, wear pads, wire ropes, bearings, gears, seals, valves, electrical wiring, or hoses to be between the grounding position and the area to be welded.

NOTICE

Failure to comply with the above weld repair guidelines may result in component damage.

1.3 TOOLS AND EQUIPMENT REQUIRED

- Hand-held power grinder
- Electric welding equipment
- AWS 70 grade, low hydrogen rod or wire
- Standard welder tools
- Standard mechanic tools
- Paint

1.4 PERSONNEL REQUIRED

- Certified Welder

1.5 PARTS REQUIRED

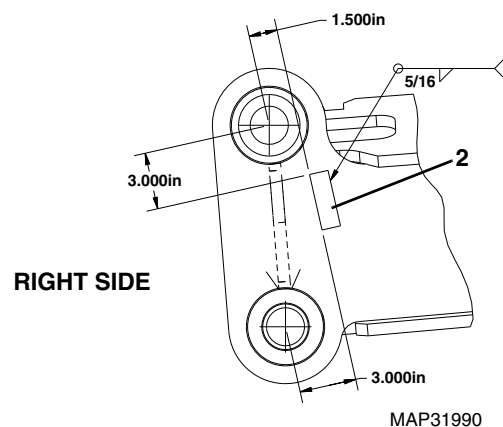
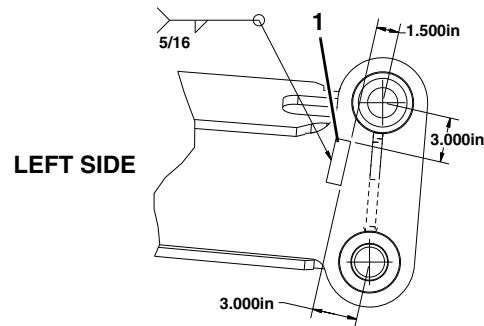
Outrigger Stop Block Kit: P/N 1001180818

1.6 PARTS LIST

P/N	Qty	Description
91161243	1	Square Bar, Left
91161243	1	Square Bar, Right

1.7 PREPARATION AND INSTALLATION

1. Park the machine on a firm, level surface, fully retract the boom, lower the boom, lower both outriggers, place the transmission in (N) NEUTRAL, engage the park brake and shut the engine OFF.
2. Place a Do Not Operate Tag on both the ignition key switch and steering wheel, stating that the machine should not be operated.
3. Open the engine cover. Allow the system fluids to cool.
4. Properly disconnect the battery.
5. Protect any hoses, wires and hydraulic cylinder rods before preparing or welding in the immediate area.
6. Thoroughly clean each installation area (i.e., dirt, grease, rust, paint, etc.)



7. Locate the Square Bar (1 & 2) P/N 91161243 into position and mark location as shown on the applicable illustration.
8. Tack weld both square bars in place and verify proper location.

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9. Weld both square bars as noted in the applicable illustration.
10. Inspect welds using the magnetic or dye-penetrant inspection methods to assure there are no cracks or deformities. If any cracks or deformities exist, grind to remove affected area(s) and repeat the weld and inspection procedures.
11. Clean, prime and paint the affected areas.
12. Remove all protective coverings from any hoses, wires and hydraulic cylinder rods.
13. Properly connect the battery.
14. Start machine, raise outriggers and verify proper contact between outrigger arms and stop blocks.
15. Remove the Do Not Operate Tag from the ignition key switch and the steering wheel.
16. Return machine to service.