

Swing Hub Mounting Plate Replacement

Installation Instructions

For Kit: 1001120496

The purpose of this instruction is to replace the swing hub mounting plate on a JLG model 60H and 80HX boom lift.

CAUTION

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

Models Affected:

60H Boom Lift
80HX Boom Lift

Tools & Equipment Required:

- Stands and lifting equipment capable of lifting/supporting the affected components
- Portable power grinder
- Air carbon-arc equipment
- Electric welding equipment
- Cutting torch equipment
- Minimum 70,000 psi yield strength low hydrogen rod or wire (AWS 70 grade)
- Standard welder tools
- Standard mechanic tools
- Paint

Personnel Required:

Qualified JLG equipment mechanic
Certified welder

Parts/Material Required:

Swing drive mounting plate, P/N 0236421, Qty: 1

GENERAL REPAIR GUIDELINES:

This repair procedure provides parts and repair information for a specific discrepancy. It is the responsibility of the entity performing the repairs to determine if the discrepancy can be corrected by this procedure.

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

Reference the service and specifications manuals and illustrated parts manual for safe and proper disassembly/assembly procedures.

WELD REPAIR GUIDELINES:

All welding must be in strict accordance with ANSI/AWS D1.1, EN288-3 or EN288-4, or equivalent Australian standards, as required by applicable standards for aerial work platforms.

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.

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

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Procedure:

1. Remove all foreign matter (i.e., dirt, grease, rust, paint, etc.) from repair area.
2. Safely and properly remove the components required to gain access to the swing drive mounting plate on the turntable weldment. Reference the appropriate JLG Service and Maintenance manual for proper assembly/disassembly procedures.
3. Using a hand held power grinder or air carbon-arc equipment, remove the existing swing drive mounting plate.

Note: *Note: Do not damage the turntable base plate.*

4. Prepare area for welding. Remove any weld left from hub plate.
5. Install swing hub and pinion gear onto new hub mounting plate.
6. Locate and tack weld the hub mounting plate into the original position. Reference the attached illustration for proper backlash specification. Ensure that the hub mounting plate is flat against the base plate.
7. Once the proper position is achieved, weld into place using the recommended weld material with types and sizes as shown on the attached illustration.
8. Inspect welds using the magnetic particle 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 weld and inspection procedures.
9. Clean, prime, and paint the affected areas.
10. Reassemble all components.
11. Prepare the unit for operation. Cycle the swing and boom functions a minimum of five (5) times to ensure safe and proper operation.

Should any further discrepancies be discovered during the accomplishment of this procedure, contact JLG Industries, Inc. immediately for further evaluation.

