



Service Bulletin No. LT20051031
Subject: Mast Latch Reinforcement
Model: LT-12D, LT-12P
Product Group: Light Tower
Date: October 31, 2005

SERVICE BULLETIN

Group: LT

- Mandatory**

 Information

 Recommended Change

Series/Models Affected:
LT12 Series Light Towers

Model	Serial Number Range
LT-12 D	SN 900854 to SN 902429
LT-12 P	SN 900833 to SN 901536

SERVICE INFORMATION

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

Problem:


- Mast latch mounting plates on some LT12-series light towers may spread apart preventing full engagement of the latch pin.
- This condition may cause the mast to slide out of the receiver cradle during lifting and **may lead to injury or death and severe unit damage!**

Solution:

- Prevent mounting plates from spreading by welding two reinforcement gussets as described in the installation instructions.

PARTS INFORMATION

Quantity	Part #	Description	Remarks
2	29823	Gusset, .118 x 1.25 x 2.19	Requires two (2) per mast
1		Black High Gloss Spray Paint	Source locally



WARNING! Read and follow all directions and warnings for installation. Wear gloves, eye goggles, a breathing apparatus or other personal protection equipment required by law and for your own safety. Contents are extremely flammable. Vapors and mist may be harmful if inhaled, apply in well-ventilated areas, contents are harmful or fatal if swallowed.

AVOID POTENTIALLY TOXIC FUMES AND DUST! HAZARDOUS FUMES CAN BE GENERATED WHEN WELDING, SOLDERING OR USING A TORCH TO HEAT PAINT!

INSTALLATION INSTRUCTIONS

WORK SAFELY!

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

Begin by locating the light tower in an open work area free of any obstructions and overhead power lines. Make certain the light tower is on level ground and lower each of the stabilization jacks to prevent tipping.

Prepare the machine by raising the mast assembly from the horizontal (transport) position to the vertical (upright) position. Keep telescopic sections in the lowered position-**DO NOT EXTEND THE TELESCOPING SECTIONS!**

Once the mast is raised, loosen the mast locking knob as shown in photo (A) and using the handles (B) rotate the mast about 230 degrees as shown in photo (C).

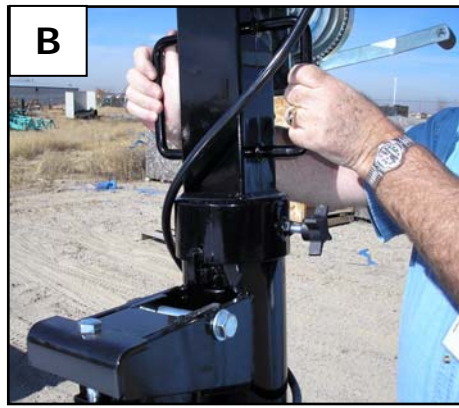
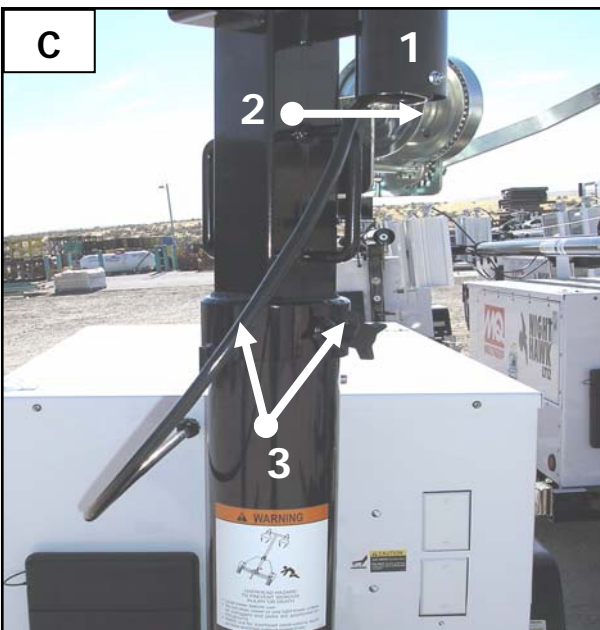
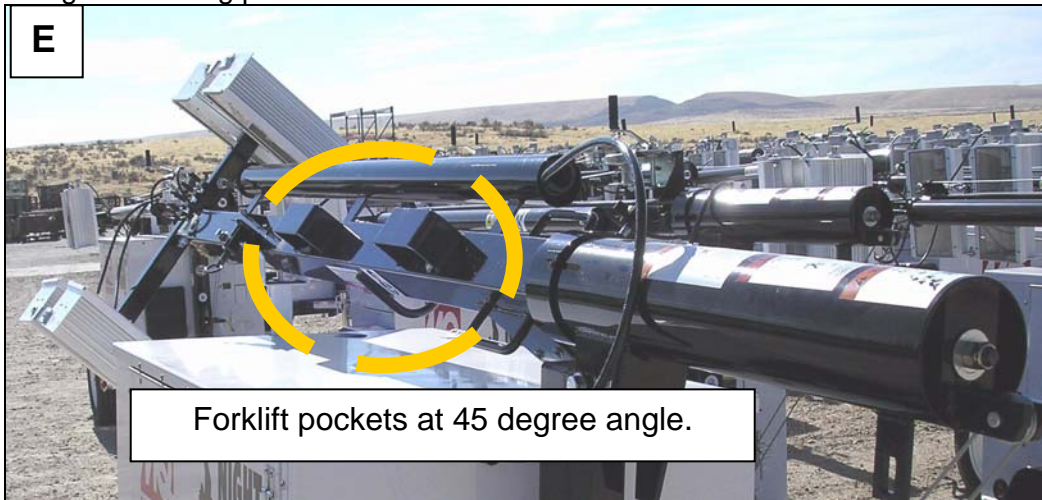


Photo (C) shows the how mast should appear after being rotated 230 degrees. Note the location of the collector tube (1), winch (2) and mast lock knob & wire (3). Tighten the mast locking knob as shown in (D) so it will not rotate during gusset installation.



Carefully lower the mast to the horizontal (transport) position making sure the winch handle clears the top of the cabinet. Forklift pockets should be pointing upward at about a 45 degree angle as shown in photo (E) for a good welding position.



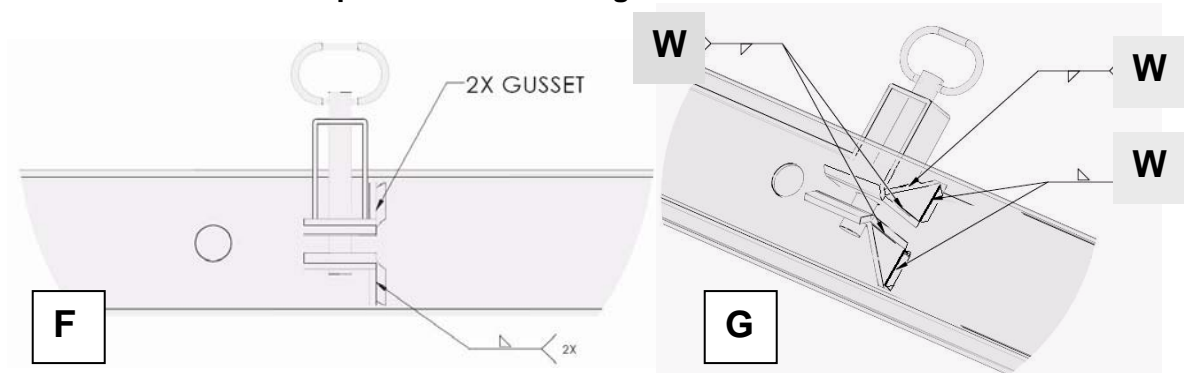
Prepare the mast for welding by performing the following steps:

- Remove paint a minimum of 101mm (4-inches) from area to be heated during welding. 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.
- 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.

DC WELDER SETTINGS

- **Disconnect light tower battery** to prevent engine damage.
- **Locate welder ground clamp as close to the work as possible!**
- **Wire Feed Settings (MIG)** Volts 20.5, with a wire speed of 275 inches/minute (fine tune as necessary), 0.035" mild steel solid wire with mixture of 75% argon / 25% CO₂
- **Stick Weld Settings** – Use 3/32" (6011) rod with a current setting of 60-80 amps or lower (fine tune as necessary).
- **CAUTION! EXCESSIVE HEAT CAN CAUSE STRUCTURAL FAILURE!**

Diagrams (F-G) show where gussets should be located alongside latch mounting plates. The “W” indicates the bead placement for each gusset.



**The following photo shows how the finished support plates appear after welding and painting.
Important! Wait for tube to cool before painting!**



WARRANTY INFORMATION

Campaign: Reference No. 00510-0046

Fill-out the enclosed Warranty Campaign Form and return to the MQ Warranty Department. A Multiquip warranty analyst will call you with a claim number upon completing the form.

Labor Allowance: 1 Hour Flat Rate for installation.