

SECTION KK-KK
#502 JIB STRUT
ALIGN JIB STRUT SHEAVE WITH SHEAVES TO BE USED ON BOOM TOP
SCALE 0.150

- 17 FOR MAKEUP OF BOOM SEE BOOM RIGGING B60:500 DRAWING B1023382
- 18 DRAWING 81024556
- 19 DRAWING 81025289
- 20 DRAWING 81026075
- 21 DRAWING 81026079
- 22 RELOCATE FROM MAIN BOOM
- 23 QUANTITY 2 WHEN USED W/PIN 84020672 (ITEM R50). QUANTITY 4 WHEN USED W/PINS 84046933 AND 81029670 (ITEMS R55 & R56).
- 24 SUSPENSION PENDANT MAY APPEAR SLACK DURING RAISING AND OPERATION. CHECK SUSPENSION LOCATION AND PENDANT BUTTON NUMBER AND CONTINUE OPERATION.
- 25 MAST RIGGING M10:503 (R51) CONTAINS MAST BUTT ASSY 81025137 WITH "PASSIVE STOP". MAST RIGGING M11:503 (R52) CONTAINS MAST BUTT ASSY 84041201 WITH "ACTIVE STOP".

- 1 INSERT TRANSITION 6.0M I.D. TAG #81023400
- 2 BUTT 6.0M I.D. TAG #81029911
- 3 MAIN STRUT I.D. TAG #81025345
- 4 JIB STRUT I.D. TAG #81025348
- 5 TOP 12.0M I.D. TAG #81026672
- 6 INSERT 12.0M I.D. TAG #81023406
- 7 INSERT 6.0M I.D. TAG #81023411
- 8 INSERT 12M SUSPENSION I.D. TAG #81034272
- 9 UPPER POINT ASSY I.D. TAG #81029770 MUST BE EQUIPPED WITH ROLLER ASSY 81036285 (CALLED FOR ON UPPER POINT ASSY FRAME ITEM 4 AS OPTION 7).
- 10 REFER TO JIB LENGTH TABLE (SHEET 2) FOR SUSPENSION PENDANT BUTTON NUMBER. SEE SHEET 13 FOR OPERATIONAL INSTRUCTIONS
- 11 SEE BLOCK REEVING DRAWING 81038143 FOR RIGGING CONFIGURATION OPTIONS AND INSTRUCTIONS. SEE RIGGING WINCH ASSY 81024072 FOR BLOCK AND WIRE ROPE ASSEMBLY.
- 12 LOCATED IN WORKING POSITION. SEE SECTION P-P ON SHEET 2.
- 13 STOWS IN PARTS BOX 81028769
- 14 STOWS TEMPORARILY IN PARTS BOX 81028769 WHEN NOT USED.
- 15 STOWS IN PARTS BOX 81028769 AS PART OF LINK ASSY DEAD END 81042358. SWIVEL AND LINK COMPONENTS 81028934, 874138, A10670 & 562171 ARE NOT USED FOR LUFFING HOIST ROPE DEAD END.
- 16 FOR BOOM POINT CAPACITIES REQUIRING MORE THAN 5 PARTS OF HOIST LINE, ADDITIONAL SHEAVES ARE REQUIRED.

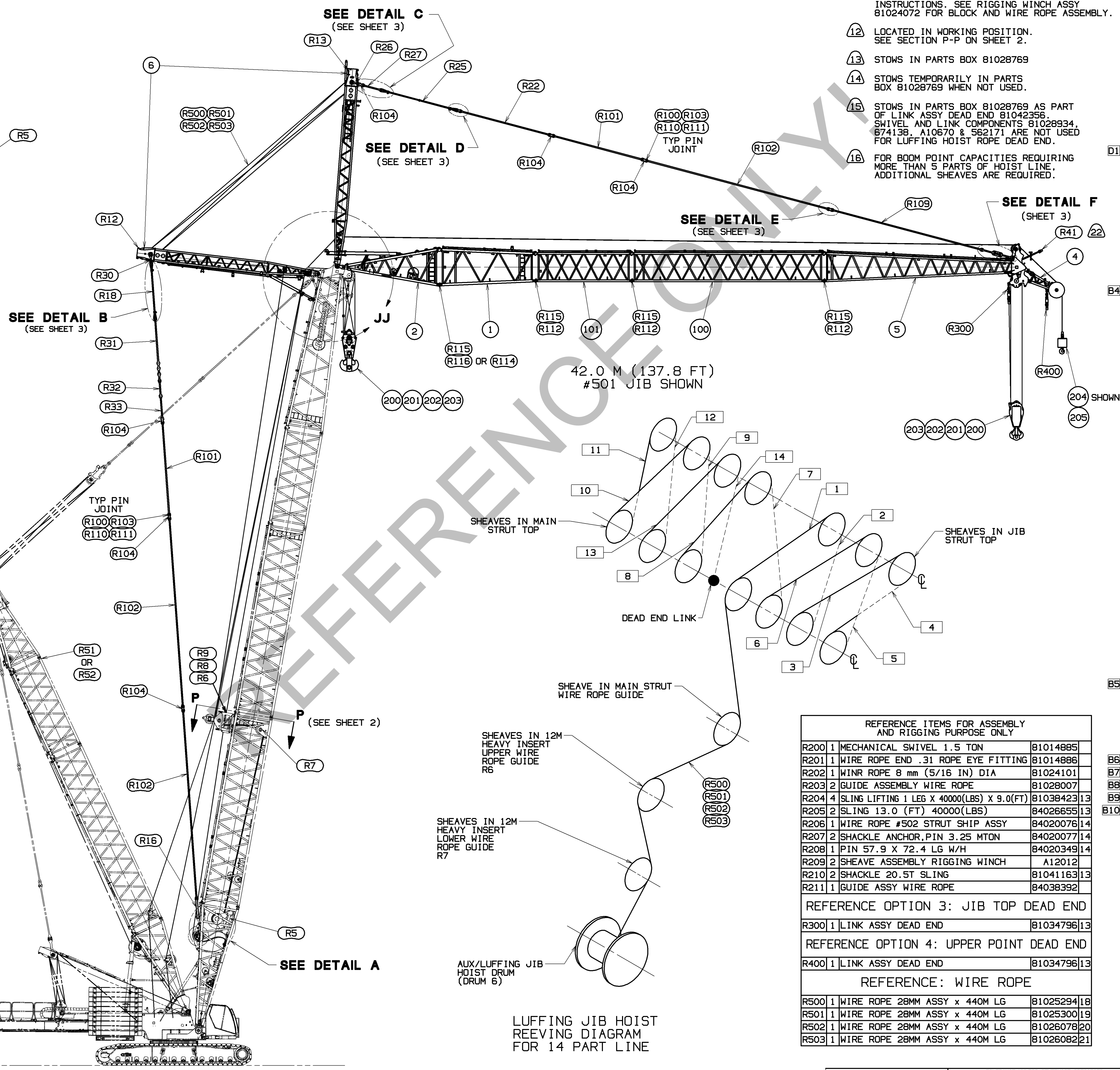
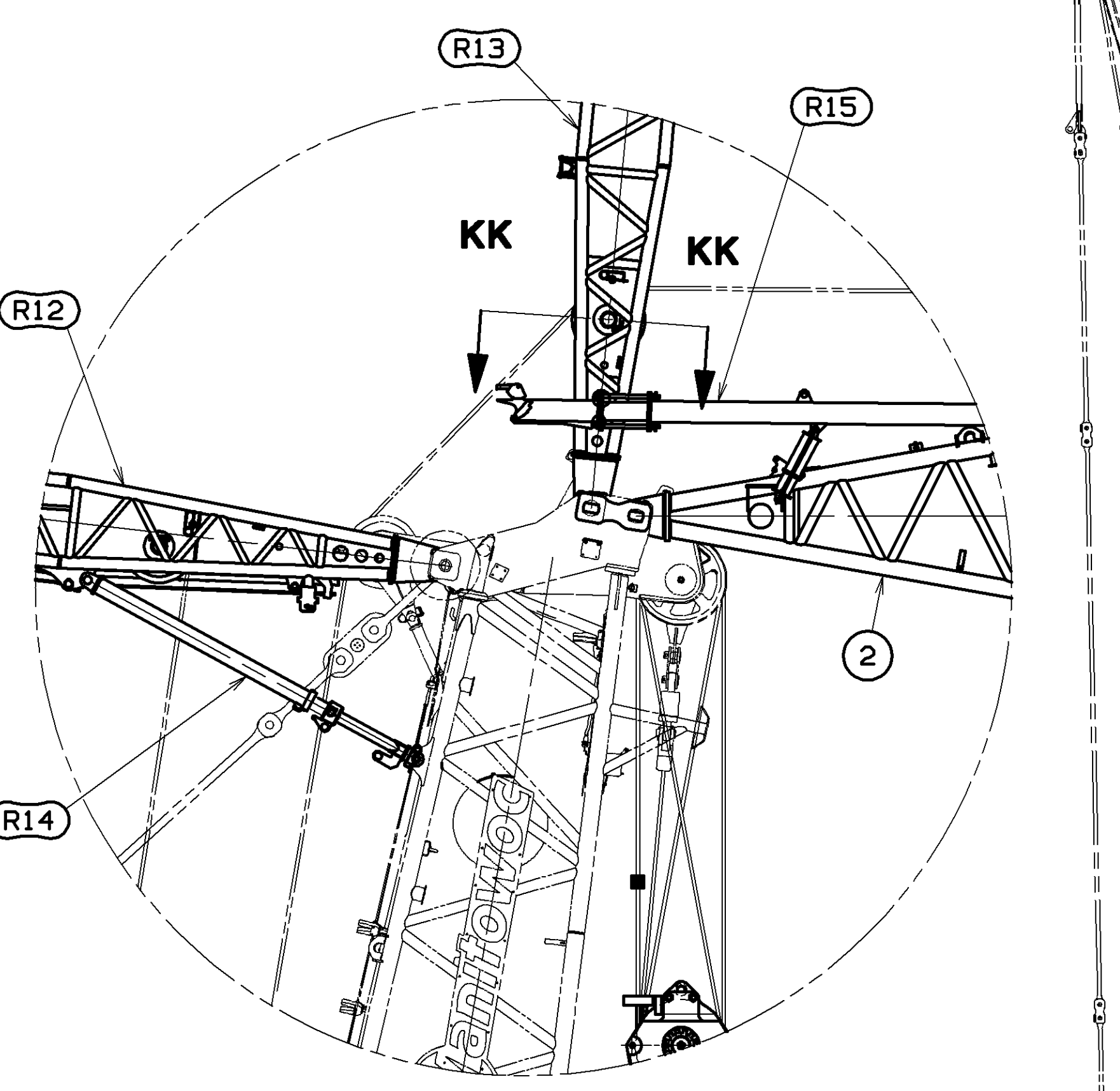
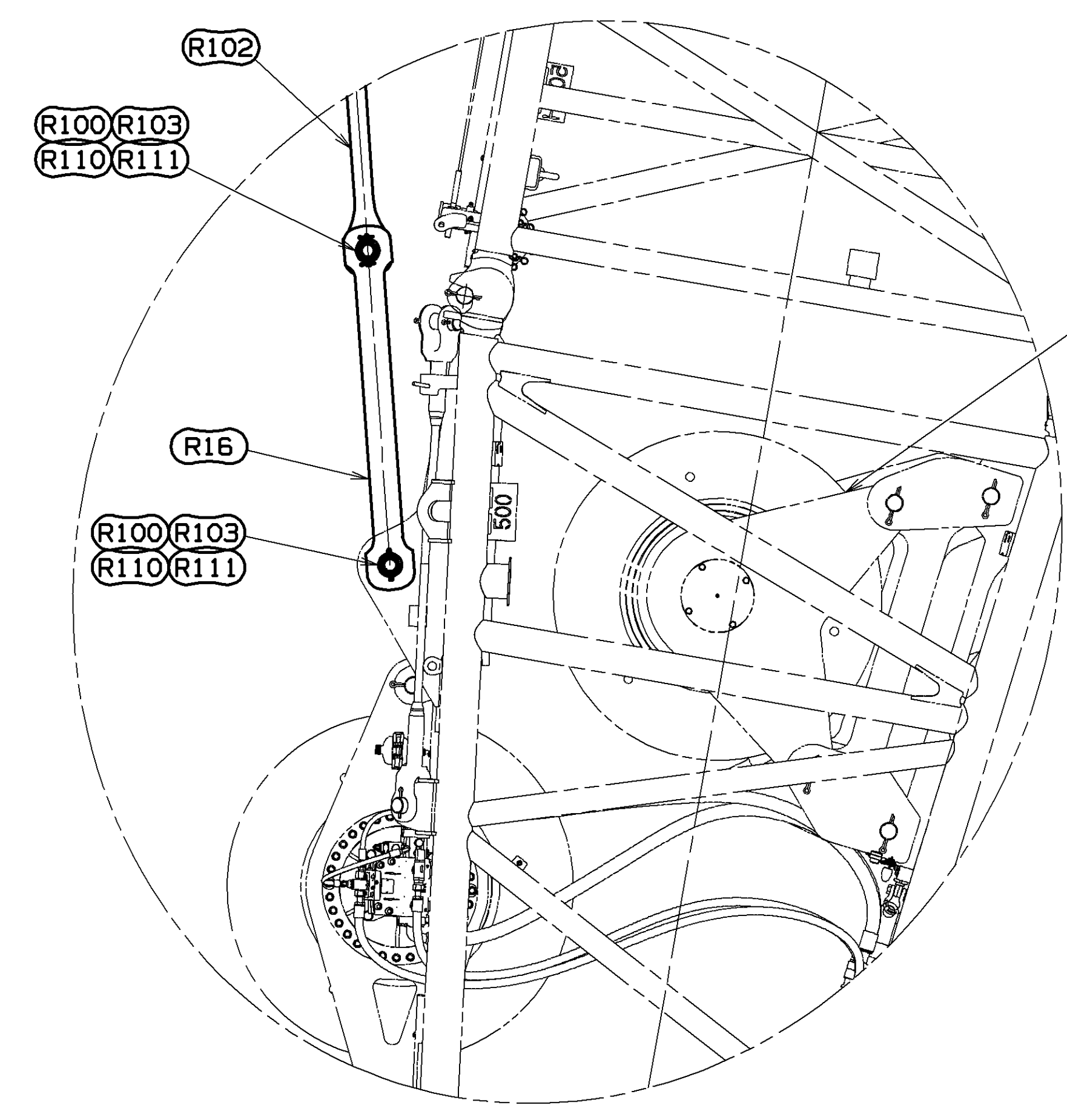
BILL OF MATERIAL				ASSEMBLED BY
QTY	DESCRIPTION	MATERIAL	REF. NO.	DATE
LUFFING JIB RIGGING LJ ON B60				
1	1	INSERT TRANSITION ASSY #500/501 6M	81023398	1
2	1	BUTT ASSY #500A 6.00 M	81024783	2
3				
4	1	UPPER POINT ASSY FRAME	81029769	9
5	1	TOP ASSY #501, 12M LJ	81026670	5
6	1	STRUT #502 SHIPPING ASSY	84020169	

OPTION 1: HOOK BLOCKS				
200	1	BLOCK 350 US TON 32MM 9 SHEAVES	A08833	16
201	1	BLOCK HOOK 250MT 28MM WR 7 SHEAVES	81031978	16
202	1	BLOCK HOOK 170MT 28MM WR 5 SHEAVES	81031981	16
203	1	BLOCK HOOK 100MT 28MM WR 3 SHEAVES	81031987	
204	1	WEIGHT BALL SWIVEL 22.2MT, 28MM & 32MM WR	81033344	
205	1	BLOCK HOOK 45 TON/41 MTON 1.12 DIA WR 1 SHV	236503	
206				

OPTION 2: UPPER BOOM POINT				
300				

BASIC REFERENCE ITEMS			
R1	1	GUIDE WIRE ROPE ASSY	81027767
R2	2	PIN 1 HOLE W/HD 65.0 DIA X 94.3 LG	81024951
R3	1	LINK #500 BOOM	81024955
R4	2	LOAD CELL LINK 145.150 KGS	84038493
R5	1	HOIST ASSY LUFFING	81027708
R6	1	GUIDE ASSY DRUM 6 UPPER	81027946
R7	1	GUIDE ASSY DRUM 6 LOWER	81027949
R8	1	GUIDE ASSY DRUM 2,3 LOWER	81029022
R9	1	GUIDE ASSY DRUM 2,3 UPPER	81029628
R10	4	COLLAR 70.50 MM I.D.	81029689
R11	4	PIN 2 HOLE 12.8 DIA X 98.0 LG	81029708
R12	1	STRUT #502, MAIN ASSY	81025344
R13	1	STRUT ASSY #502, JIB	81025347
R14	1	STRUT STOP MAIN STRUT #502	81032853
R15	2	STOP ASSY, JIB #501A	84037517
R16	4	LINK #501 BOOM BUTT	81030028
R17	2	PIN 1 HOLE W/HD 100.0 X 86.3 LG	81032176
R18	1	SPREADER ASSY #501 MAIN STRUT	81033881
R19	4	LINK #501 12M LJ TOP	81034288
R20	4	LINK #501 12M LJ TOP	81034289
R21	6	PIN 1 HOLE X/HD 65.0 DIA X 82.3 LG	81034298
R22	2	STRAP 5.78M #500/501 JIB	81036029
R23	4	PIN 1 HOLE W/HD 69.5 DIA X 86.3 LG	81036091
R24	4	PLATE JIB STRUT HOLDBACK	81036997
R25	1	SPREADER ASSY #500/501 TRANSITION INSERT	81036402
R26	2	STRAP #502 JIB STRUT, BASIC	81036865
R27	2	STRAP #502 JIB STRUT, BASIC	81036866
R28	2	PIN 1 HOLE W/HD 62.0 DIA X 85.8 LG	81036902
R29	4	SHIM .134 (IN) THK	81036908
R30	2	STRAP #502 MAIN STRUT, BASIC	81037361
R31	2	STRAP BASIC #502 MAIN STRUT BACKSTAY	81037362
R32	4	LINK #501 BACKSTAY, 1.38 M	81038262
R33	2	STRAP 1.42M #501 JIB 31.75 X 63.0	81038263
R34	2	PIN 1 HOLE W/HD 62.0 DIA X 92.0 LG	81039328
R35	4	LINK #500/501 BOOM	81039439
R36	4	PLATE 106X86X86	81039323
R37	1	PENDANT 31.8 (1.25 IN) DIA X 180.0 IN LG	277127
R38	1	SOCKET BUTTON FOR 28MM OR 32MM WR WITH PIN	A06278
R39	-	COLLAR 101MM I.D.	A12945
R40	-	PIN 2 HOLE 12.7 DIA X 128.0 LG	A12946
R41	1	ESI POSITION LIGHT AND ANEMOMETER	81031642
R42	1	LADDER 401 X 2400	81037823
R43	4	COLLAR 131.0MM ID	81033386
R44	4	COLLAR 121.0MM ID	81034036
R45	1	ARM 502 M STRUT RAISING	81036879
R46	2	STRUT SHIPPING, #502	84039032
R47	2	PIN #502 JIB STRUT HINGE	81039304
R48	2	PIN #501 JIB HINGE	81039305
R49	2	PLATE ANTIROTATION	81039285
R50	2	PIN WITH HEAD 100.0 DIA X 336.7 LG	84020672
R51	1	MAST RIGGING M10:503	81025690
R52	1	MAST RIGGING M11:503	84045340
R53	4	PIN 2 HOLE 2.25 DIA X 3.89 LG (IN)	81031296
R54	2	STAND ASSEMBLY	84046763
R55	2	PIN 1 HOLE W/HD 100.0 DIA X 162.3 LG	84046933
R56	2	PIN 1 HOLE W/HD 100.0 DIA X 94.3 LG	81029670

NO. REQ'D FOR THE FOLLOWING REFERENCE ITEMS ARE IN ONE OR BOTH TABLES (SHEET 2)			
R100	1	PIN COTTER 3/16 DIA X 1.50 LG	562085
R101	1	STRAP 6.00M #501 JIB 31.75 X 63.0	81029726
R102	1	STRAP 12.00M #501 JIB 31.75 X 63.0	81029728
R103	1	PIN 1 HOLE W/HD 62.0 DIA X 77.8 LG	81029806
R104	1	LINK #501 JIB	81029807
R105			
R106	1	LINK #501 SUSPENSION	81036108
R107	1	LINK #501 JIB SUSP	81036112
R108	1	STRAP 0.66M #501 JIB 31.75 X 63.0	81036224
R109	1	STRAP 9.67M #501 JIB 31.75 X 63.0	81036226
R110	1	PIN 2 HOLES 12.7 DIA X 93.0 LG	A11799
R111	1	COLLAR 66MM I.D.	A11800
R112	1	PIN 1 HOLE W/HD 70.0 DIA X 132.4 LG	A16733
R113			
R114	1	PIN 1 HOLE W/HD 75.80 DIA X 160.4 LG	A13294
R115	1	PIN SAFETY .243 OD X 5.00	563640
R116	1	PIN 2 HOLE 75.8 X 171.9 LG	84026091



REFERENCE ITEMS FOR ASSEMBLY AND RIGGING PURPOSE ONLY			
R200	1	MECHANICAL SWIVEL 1.5 TON	81014885
R201	1	WIRE ROPE END .31 ROPE EYE FITTING	81014886
R202	1	WINR ROPE 8 mm (5/16 IN) DIA	81024101
R203	2	GUIDE ASSEMBLY WIRE ROPE	81028007
R204	4	SLING LIFTING 1 LEG X 4000(LBS) X 9.0(FT)	81038423
R205	2	SLING 13.0 (FT) 40000(LBS)	84026655
R206	1	WIRE ROPE #502 STRUT SHIP ASSY	84020076
R207	2	SHACKLE ANCHOR, PIN 3.25 MTON	84020077
R208	1	PIN 57.9 X 72.4 LG W/H	84020349
R209	2	SHEAVE ASSEMBLY RIGGING WINCH	A12012
R210	2	SHACKLE 20.5T SLING	81041163
R211	1	GUIDE ASSY WIRE ROPE	84038392

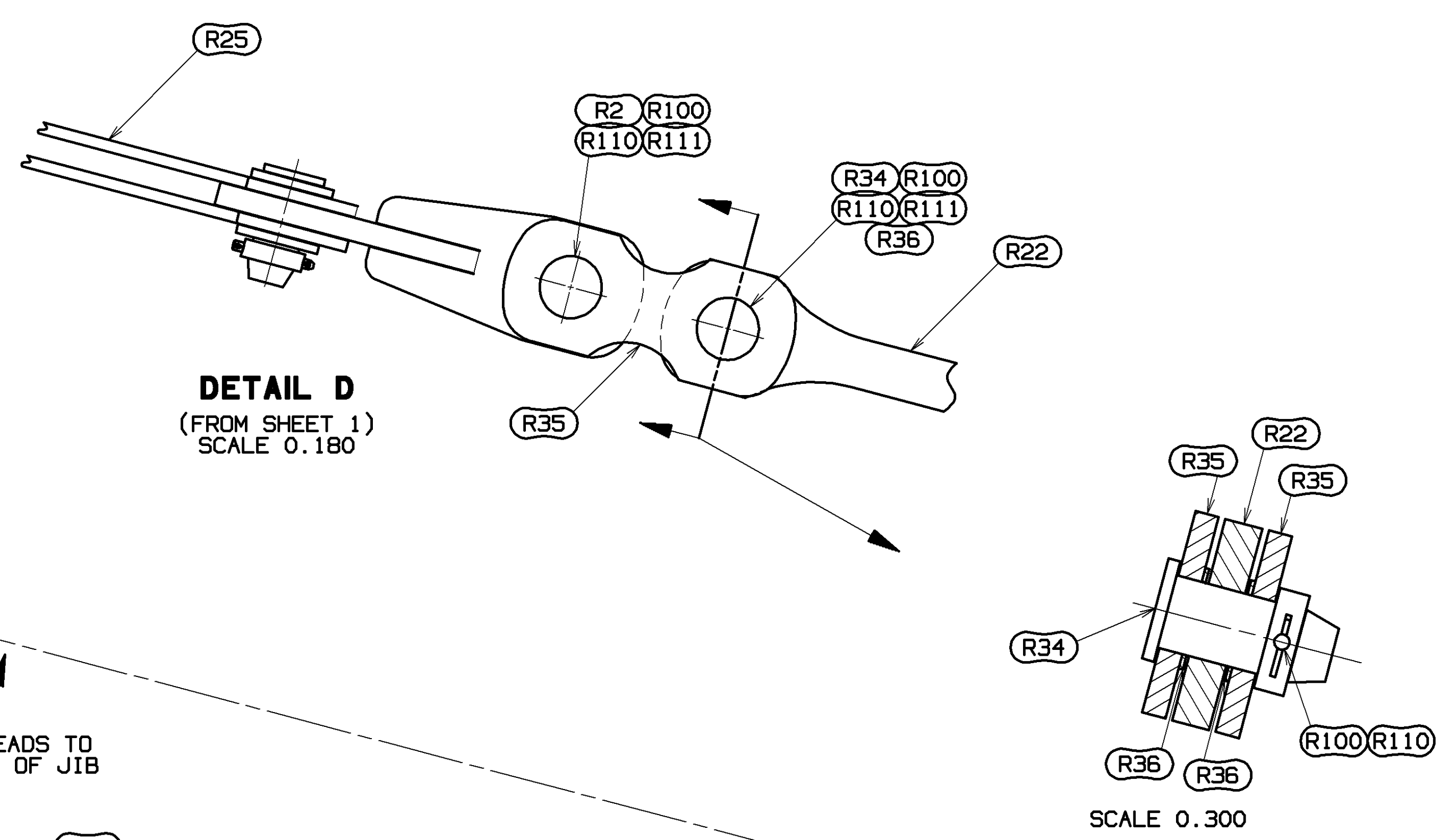
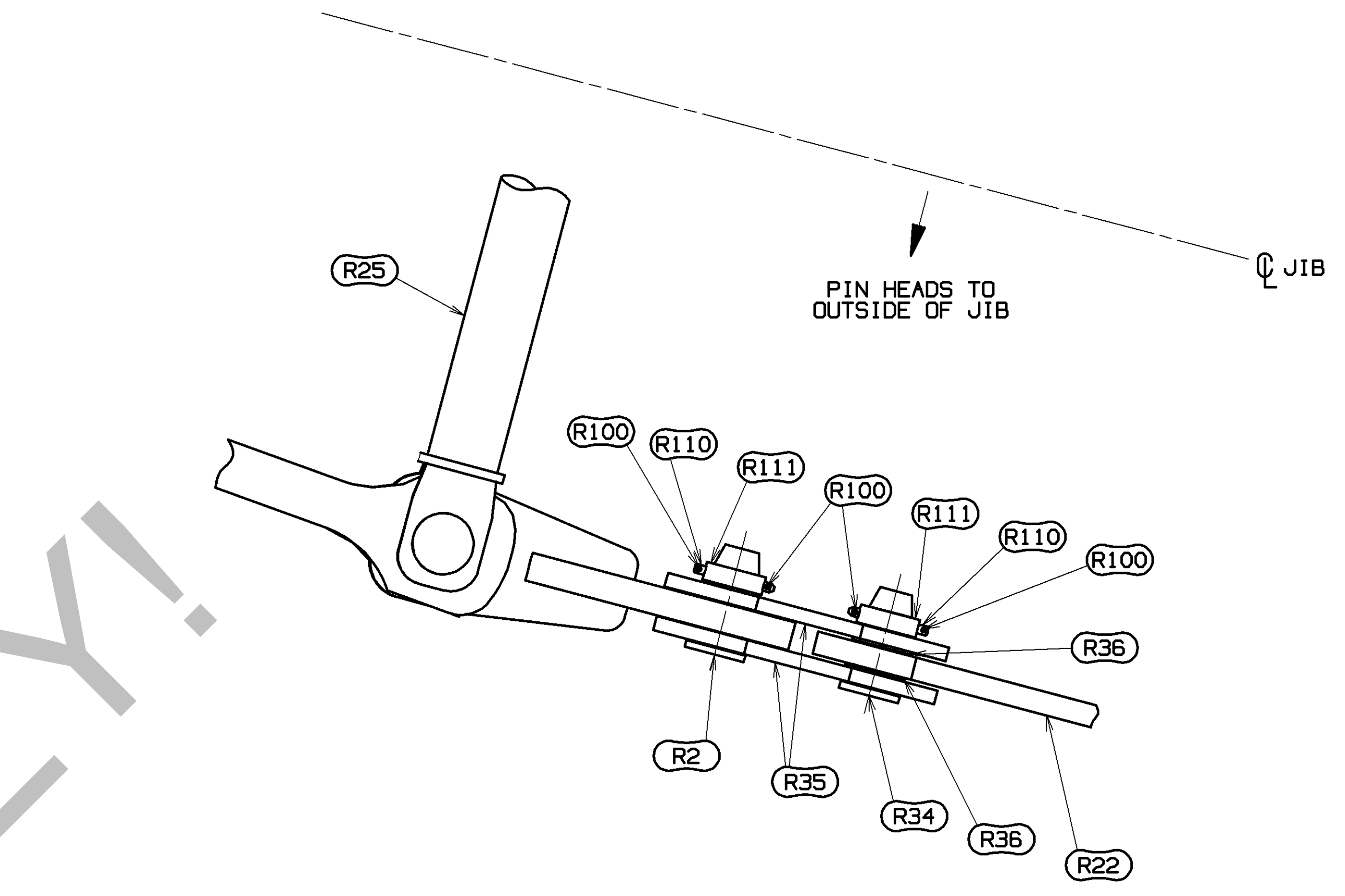
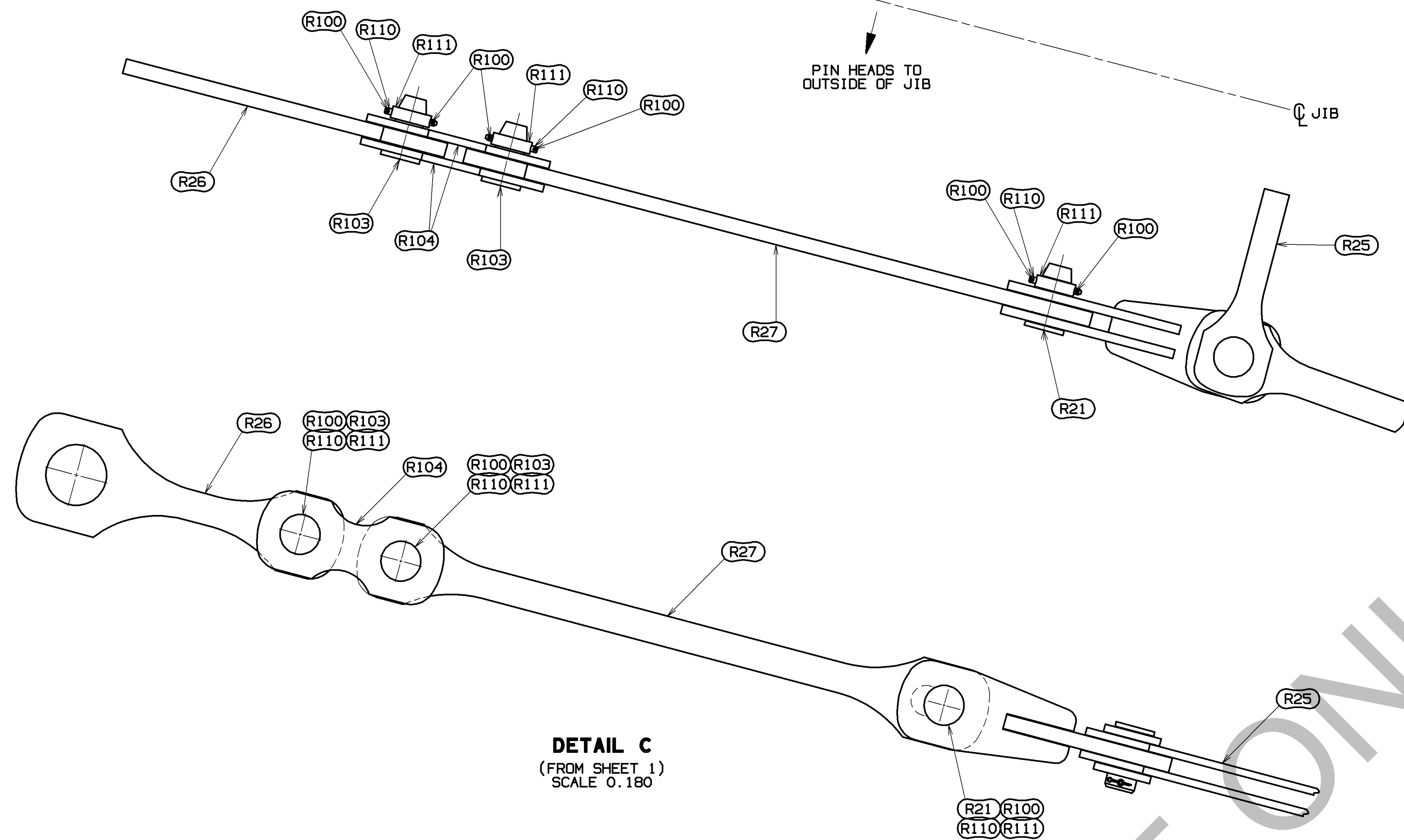
REFERENCE OPTION 3: JIB TOP DEAD END			
R300	1	LINK ASSY DEAD END	81034796

REFERENCE OPTION 4: UPPER POINT DEAD END			
R400	1	LINK ASSY DEAD END	81034796

REFERENCE: WIRE ROPE			
R500	1	WIRE ROPE 28MM ASSY X 440M LG	81025294
R501	1	WIRE ROPE 28MM ASSY X 440M LG	81025300
R502	1	WIRE ROPE 28MM ASSY X 440M LG	81026078
R503	1	WIRE ROPE 28MM ASSY X 440M LG	81026082

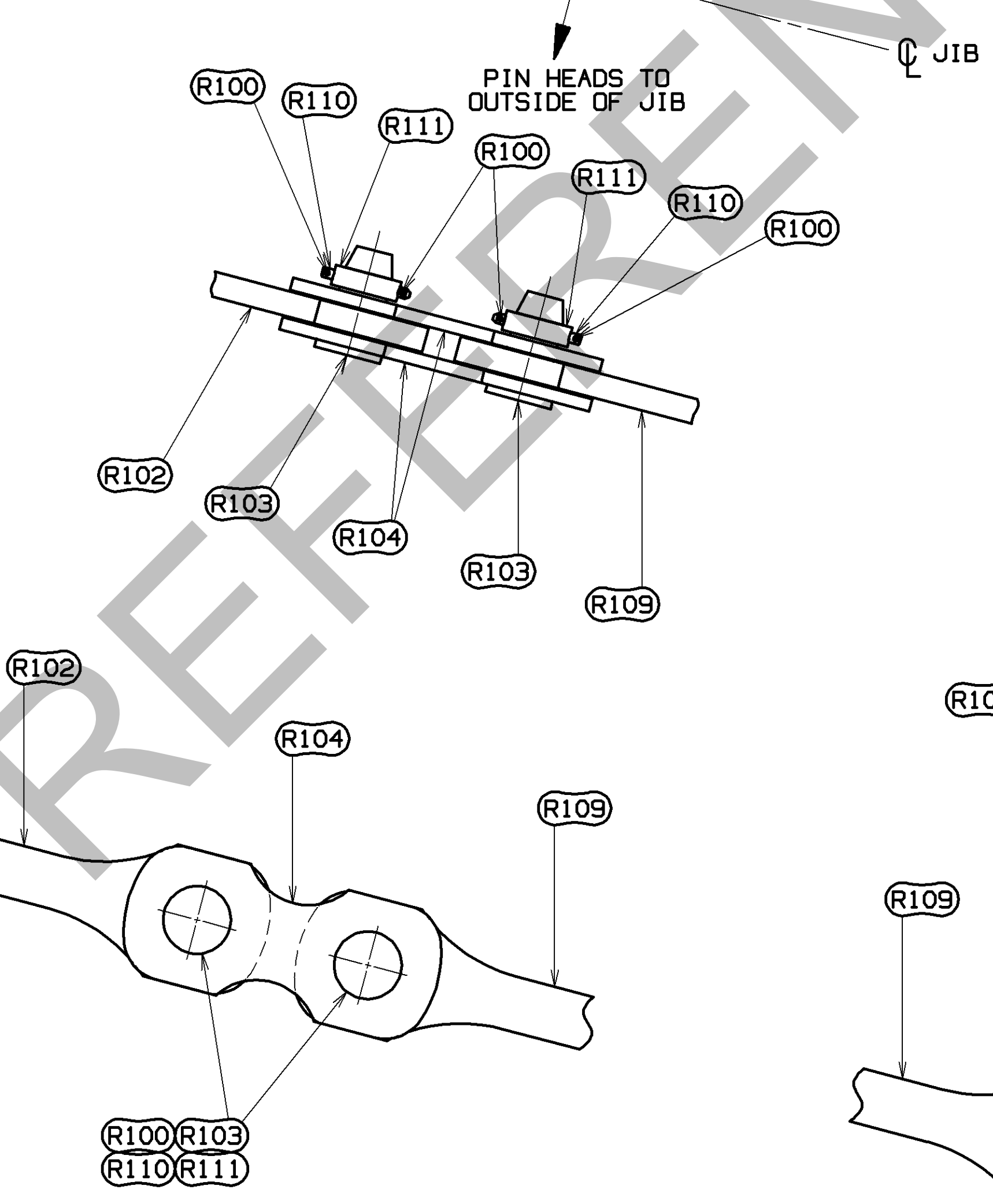
48.0 M (157.5 FT)
#500 BOOM SHOWN

LUFFING JIB HOIST REEVING DIAGRAM FOR 14 PART LINE

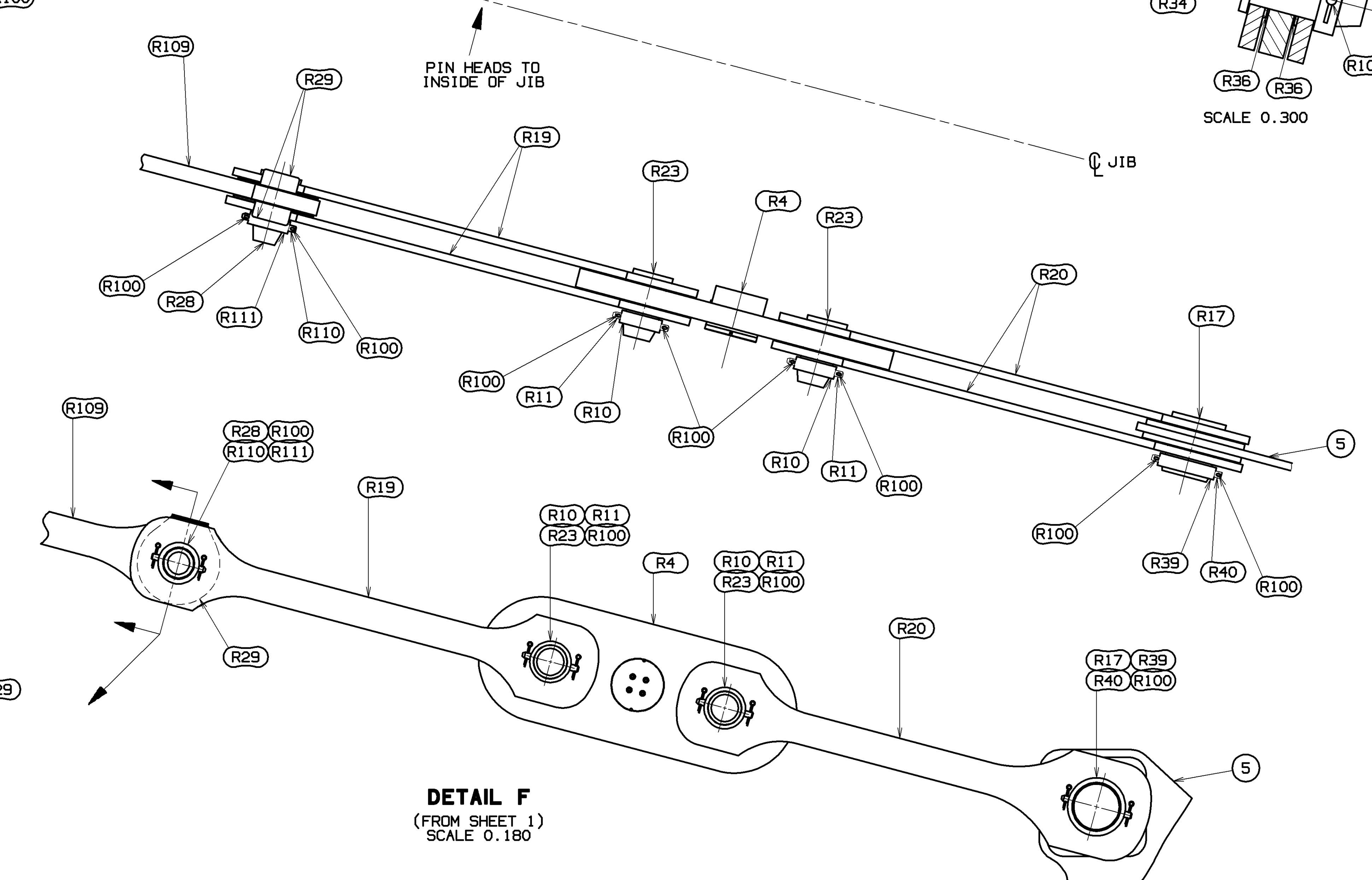


DETAIL C
(FROM SHEET 1)
SCALE 0.180

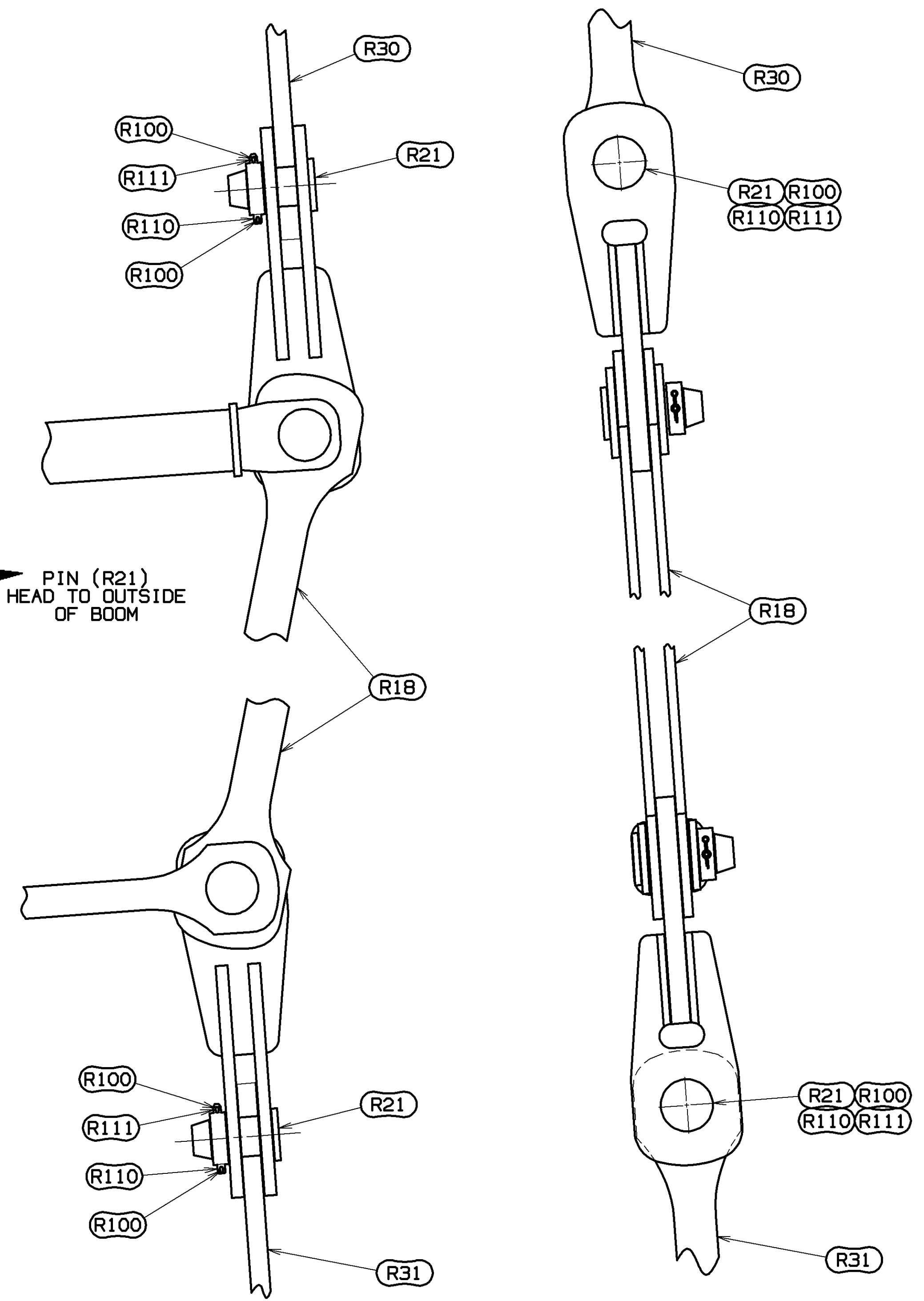
DETAIL D
(FROM SHEET 1)
SCALE 0.180



DETAIL E
(FROM SHEET 1)
SCALE 0.180



DETAIL F
(FROM SHEET 1)
SCALE 0.180



DETAIL B
(FROM SHEET 1)
SCALE 0.180

DETAIL E
(FROM SHEET 1)
SCALE 0.180

SCALE 0.300

PIN (R21)
HEAD TO OUTSIDE
OF BOOM

BOOM
CL

PIN HEADS TO
OUTSIDE OF JIB

CL JIB

PIN HEADS TO
OUTSIDE OF JIB

CL JIB

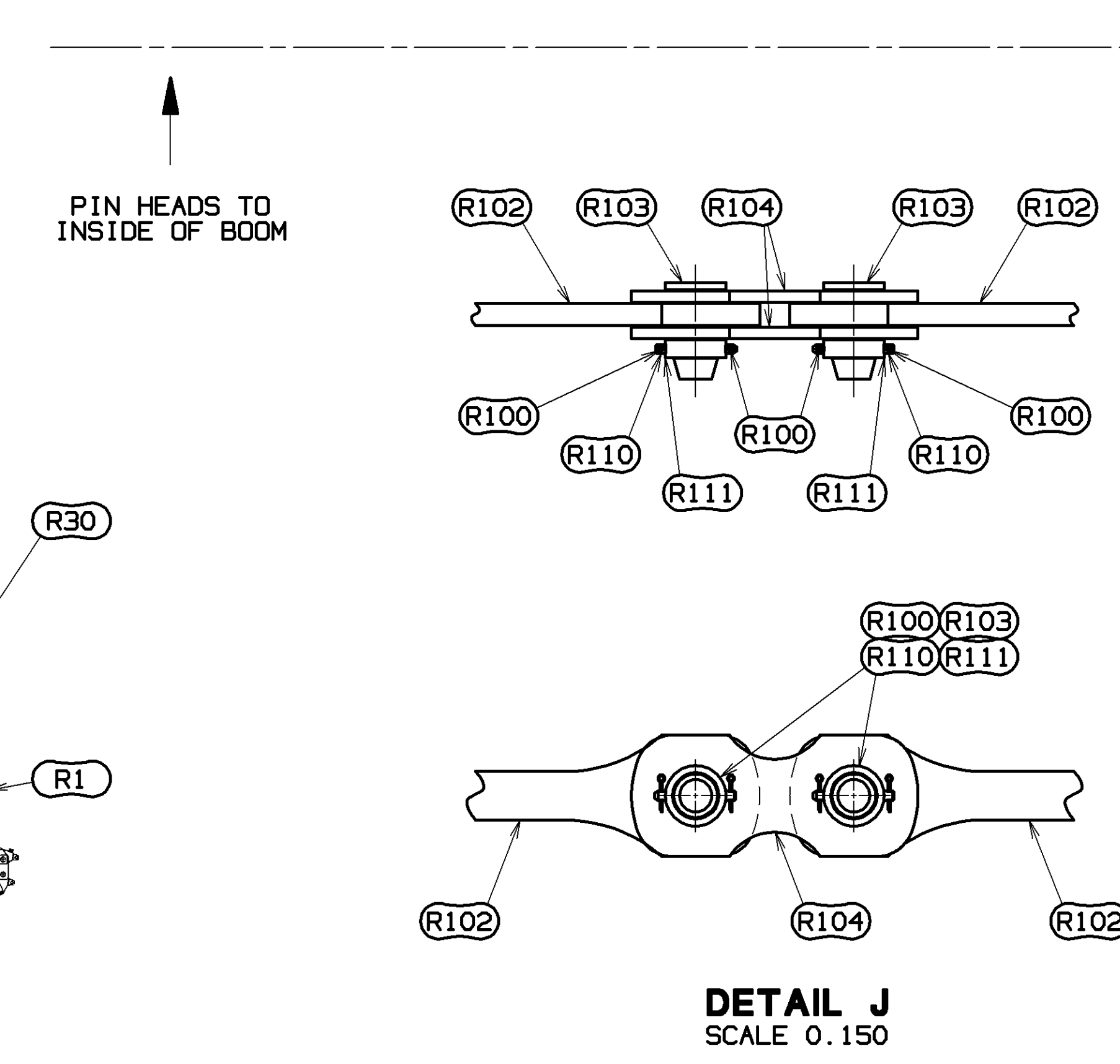
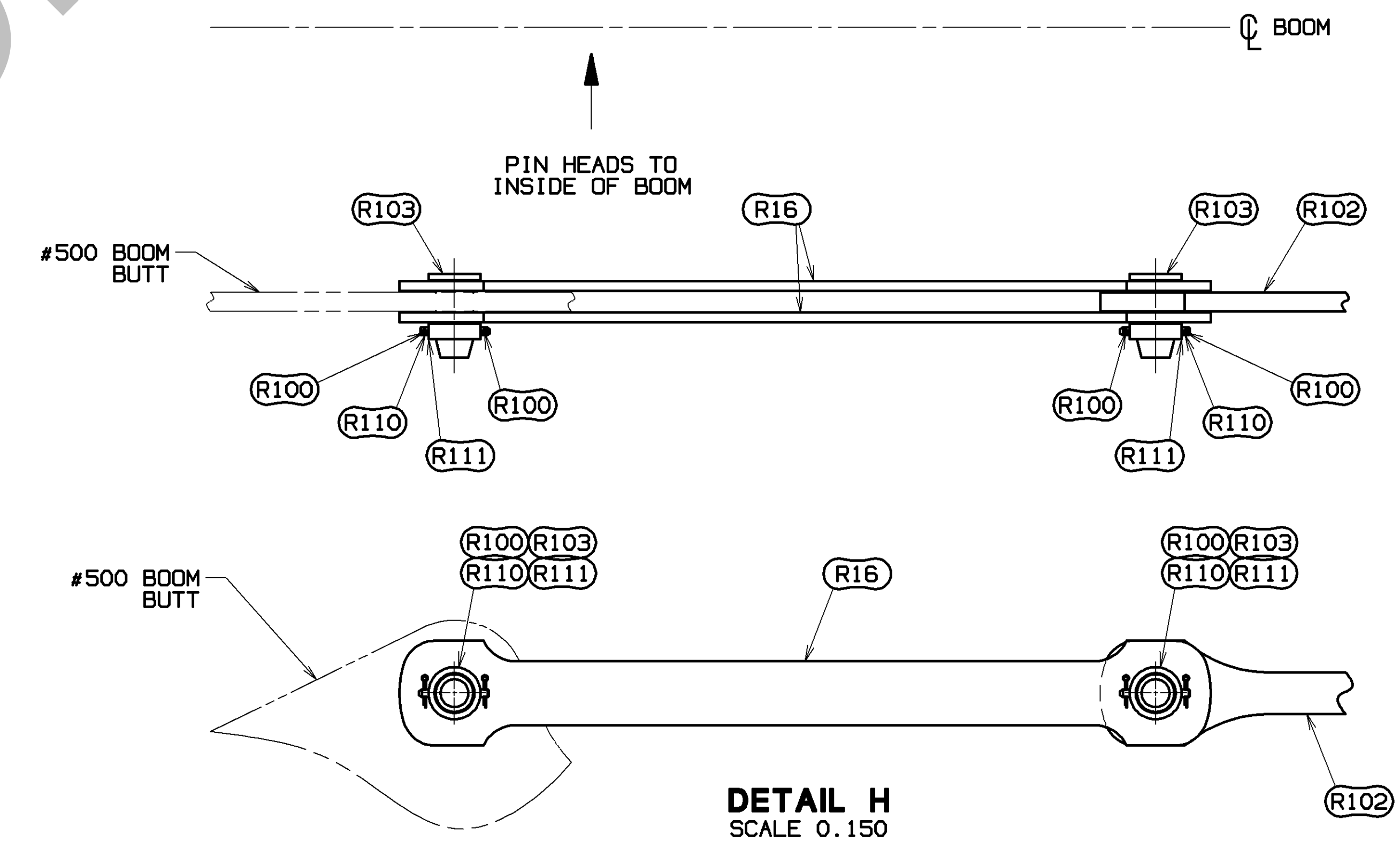
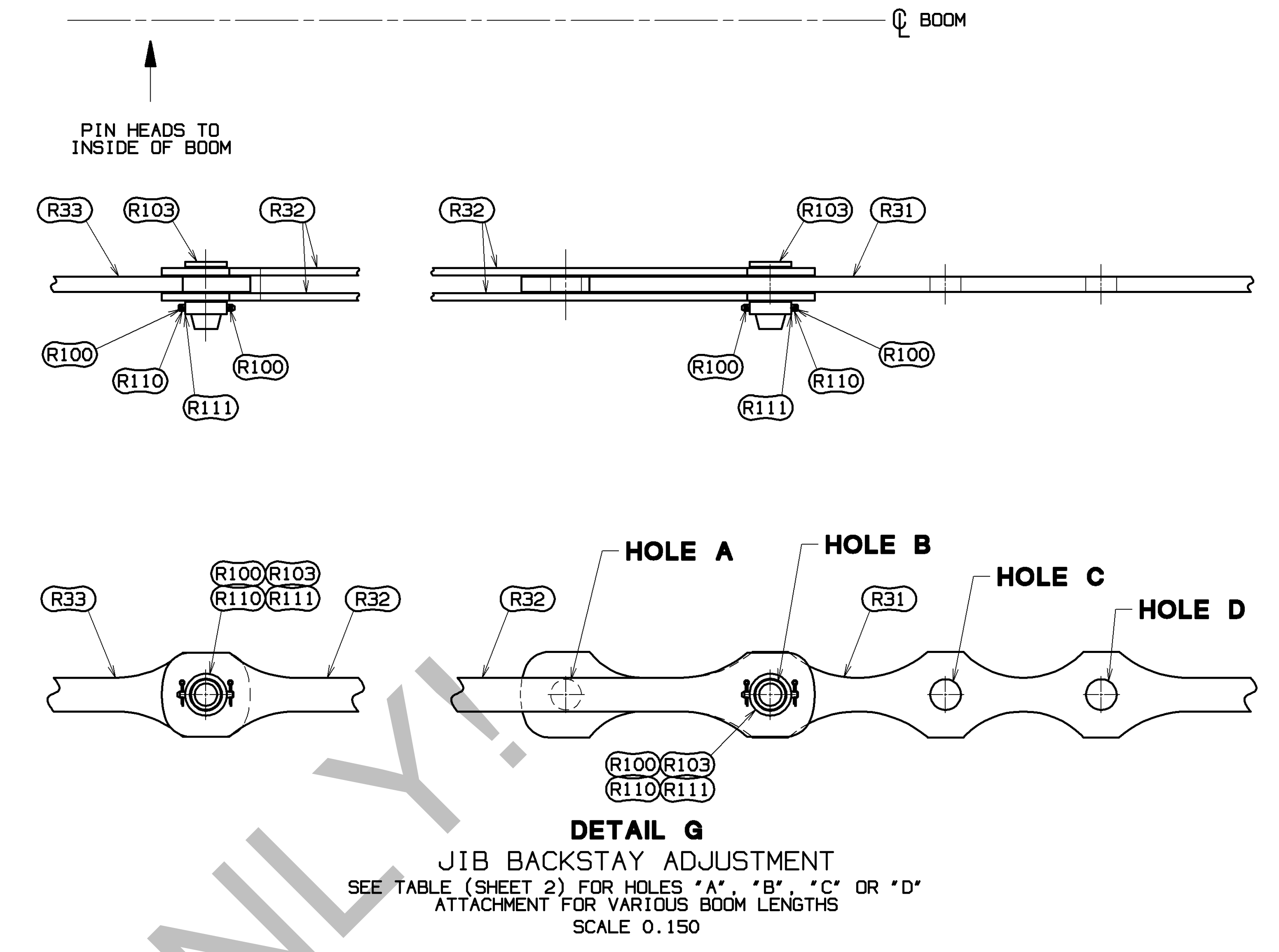
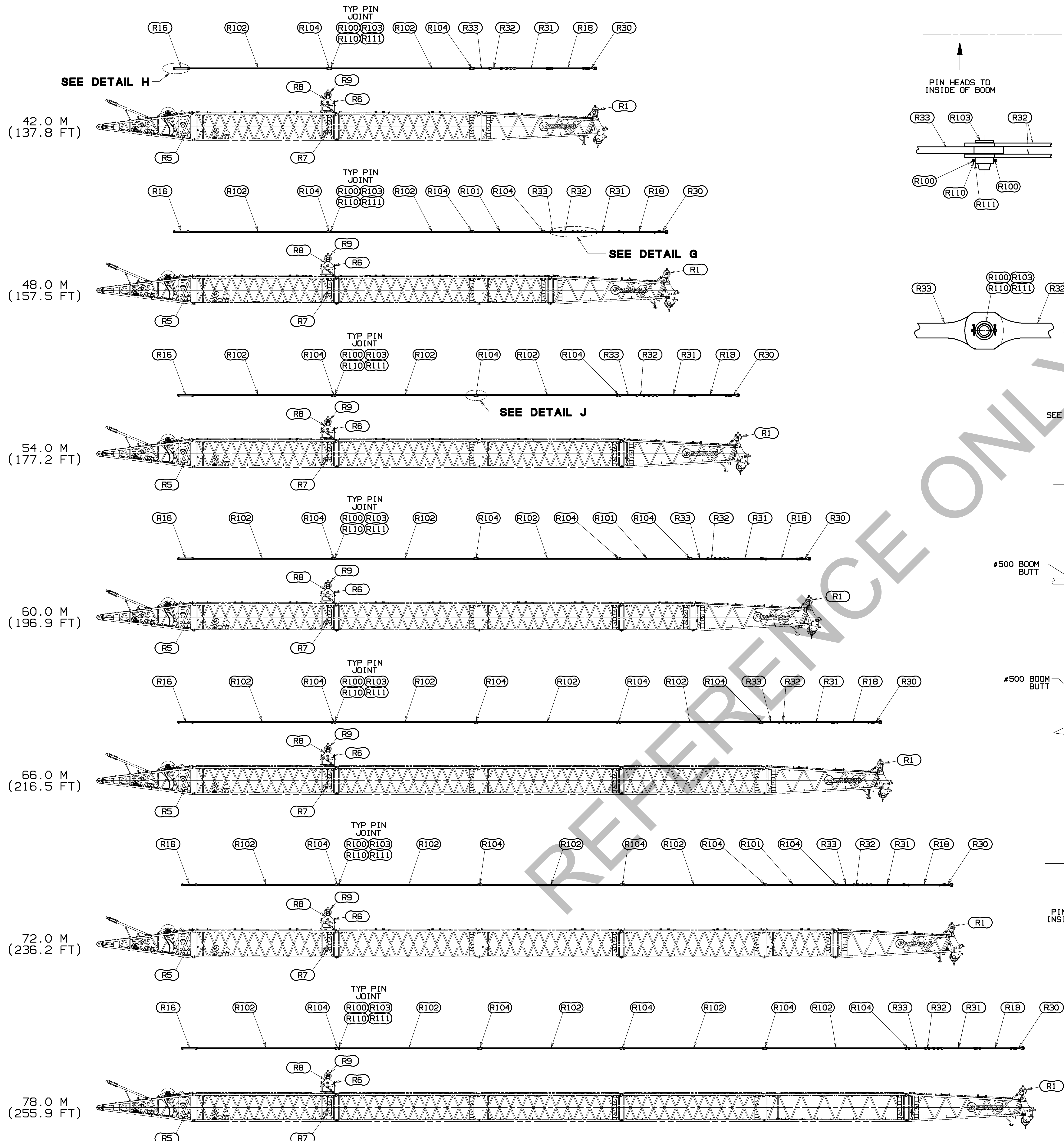
PIN HEADS TO
INSIDE OF JIB

CL JIB

TOLERANCE UNLESS OTHERWISE SPECIFIED		MATERIAL		FINISH	
DECIMAL PLACES	FABRICATION	DR. AUB	MANITOWOC, WISCONSIN	DATE	07-14-16
(1) PLACE 0.5	+0.12	CK. RHY	MODEL MLC300	REV. LNK	D
(2) PLACE 0.00	+0.08	APP. DLG			
(3) PLACE 0.000	+0.12				
ANGLES	+0.015				
	+0.008				
	+0.006				
	+0.004				

PRIVATE LABELING
REQUIREMENT TO
CONFORM TO
ENGINEERING
SPECIFICATION
S629103794 FOR
COMPONENTS LISTED
IN SECTION 05-026
DATE
07-14-16
REV. LNK
D

81023384
SHT 3 OF 15



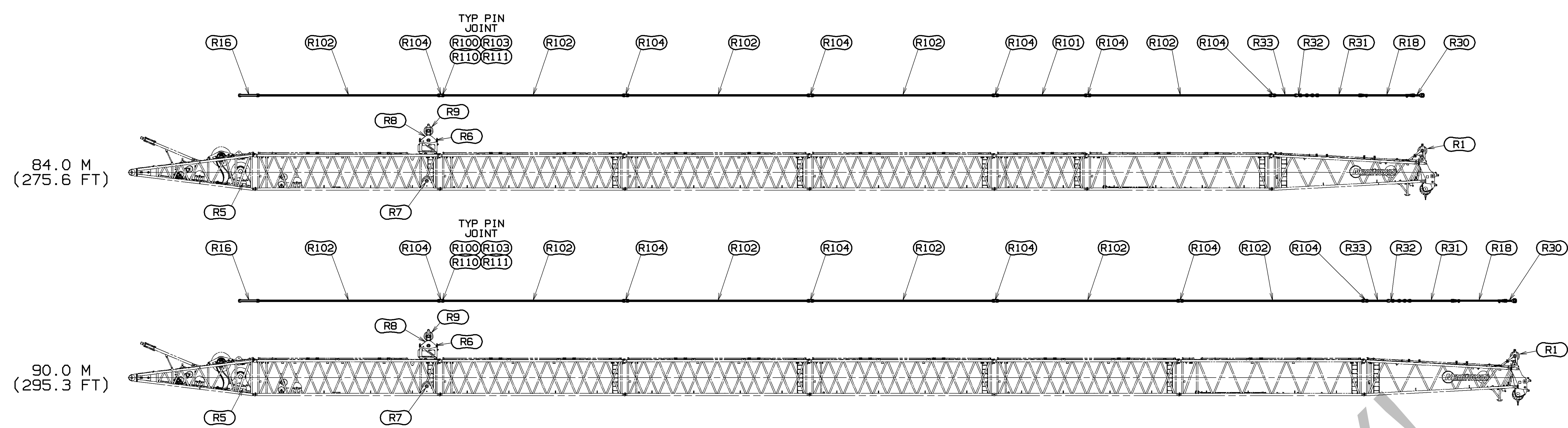
REQ'D #500 BOOM/#501 BACKSTAY STRAP ASSEMBLY
 SEE TABLE ON SHEET 2
 FOR TYP PIN JOINT SEE DETAILS A, B, G, H AND J

DO NOT SCALE THIS DRAWING

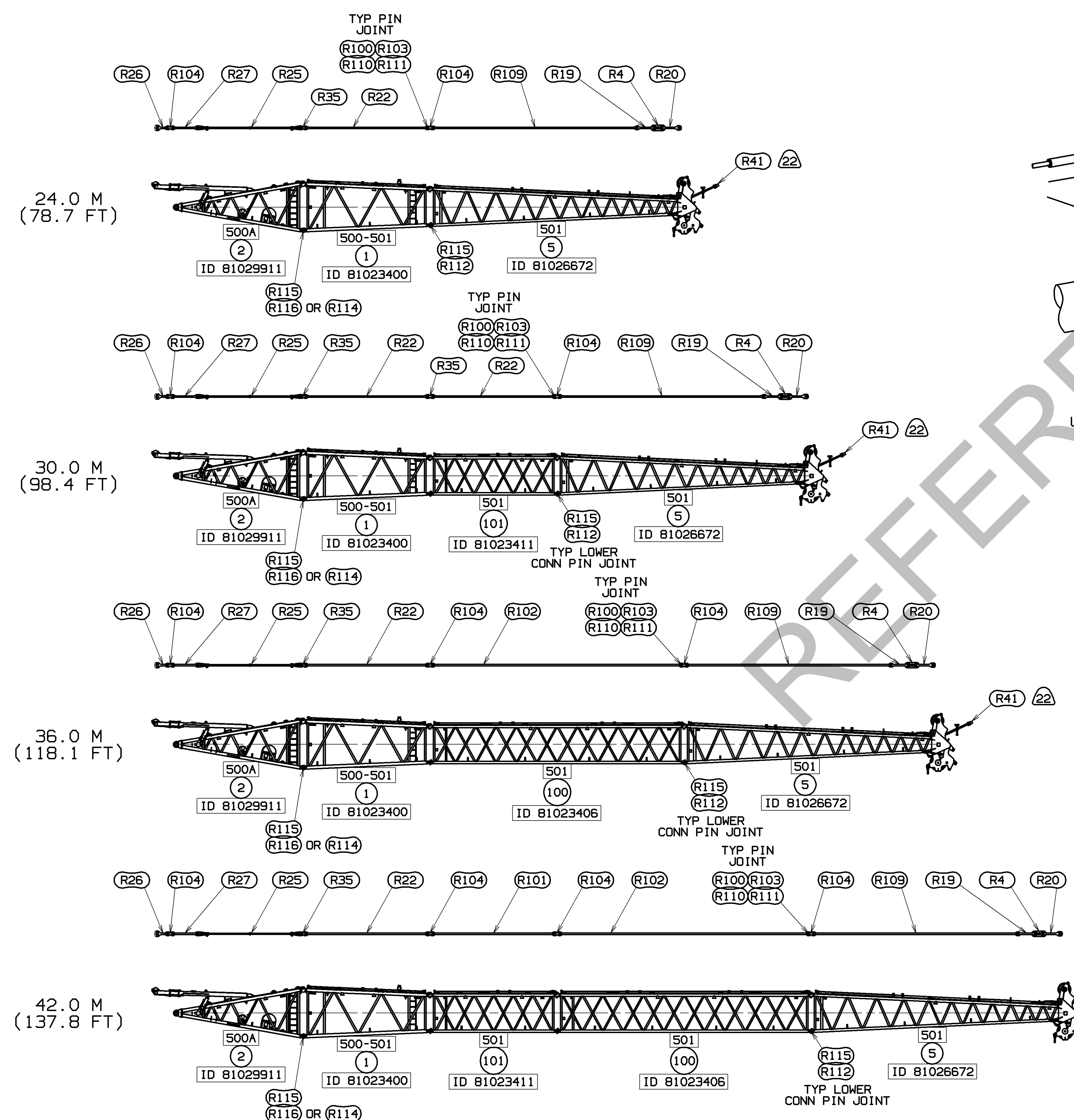
THIS DRAWING IS THE PROPERTY OF MANITOWOC CRANES, INC. IT IS LOANED, SUBJECT TO RETURN UPON DEMAND, AND ON EXPRESS CONDITION THAT IT IS NOT TO BE COPIED OR USED DIRECTLY OR INDIRECTLY IN ANY MANNER DETRIMENTAL TO OUR INTERESTS.	TOLERANCE UNLESS OTHERWISE SPECIFIED DECIMAL PLACES FRACTIONS FINISHING		DATE 07-14-16 REV. LTR. (D)	
	(1) PLACE 0.5 ±.12 ±.18	F. 10 FEET > 10 FEET		MANITOWOC CRANES, INC. MANITOWOC, WISCONSIN MODEL MLC300 APP DLG
	(2) PLACE 0.00 ±.06 ±.12 ±.015	±.005 ±.005 ±.005		
	(3) PLACE 0.000 ±.002 ±.002 ±.002	ANGLE 11.25° 11.25° 11.25°		

81023384
 SHT 4 OF 15

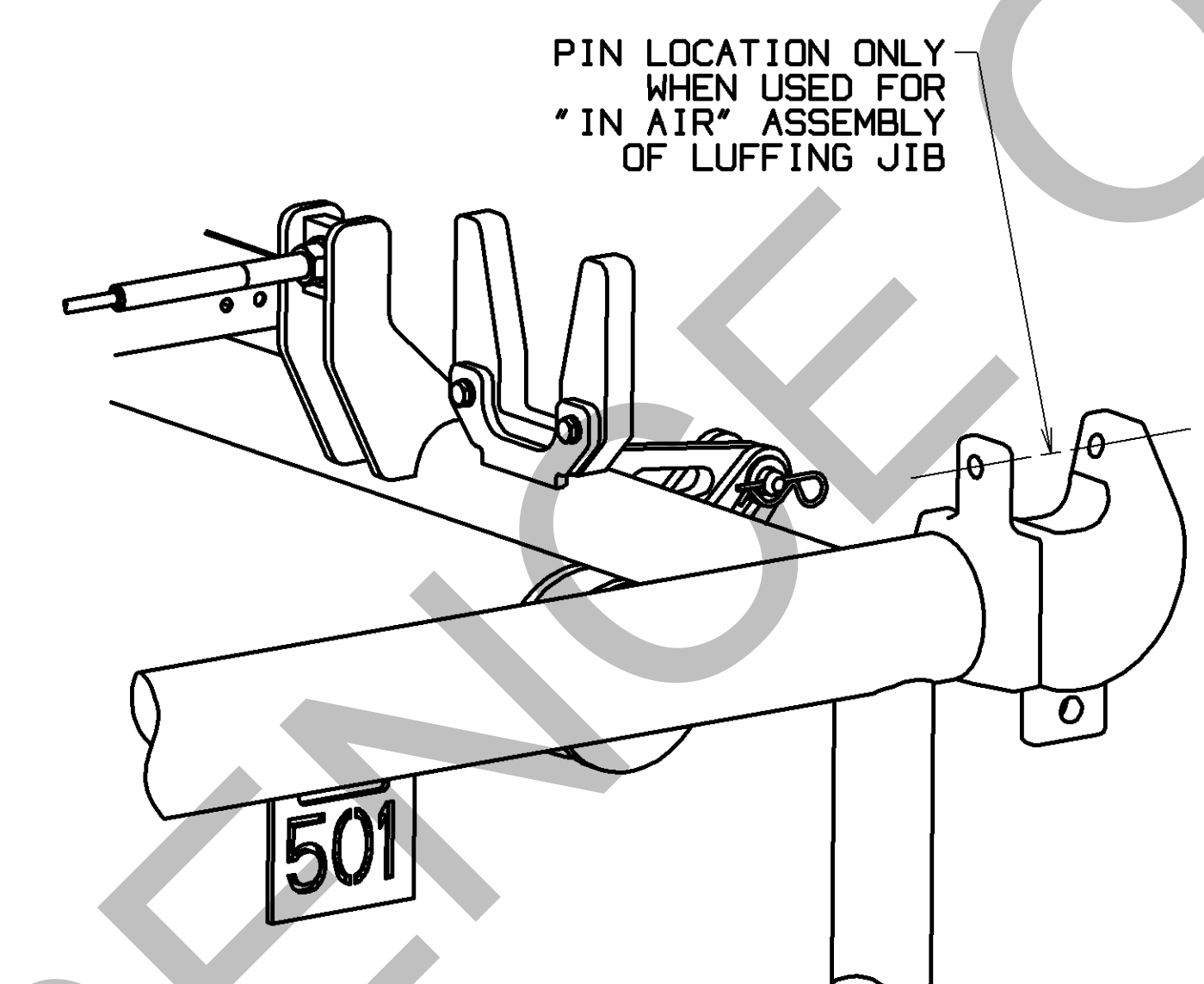
PRIVATE LABELING
 REQUIREMENT TO
 CONFORM TO
 ENGINEERING
 SPECIFICATION
 8629103794 FOR
 COMPONENTS LISTED
 IN SECTION 05-1056



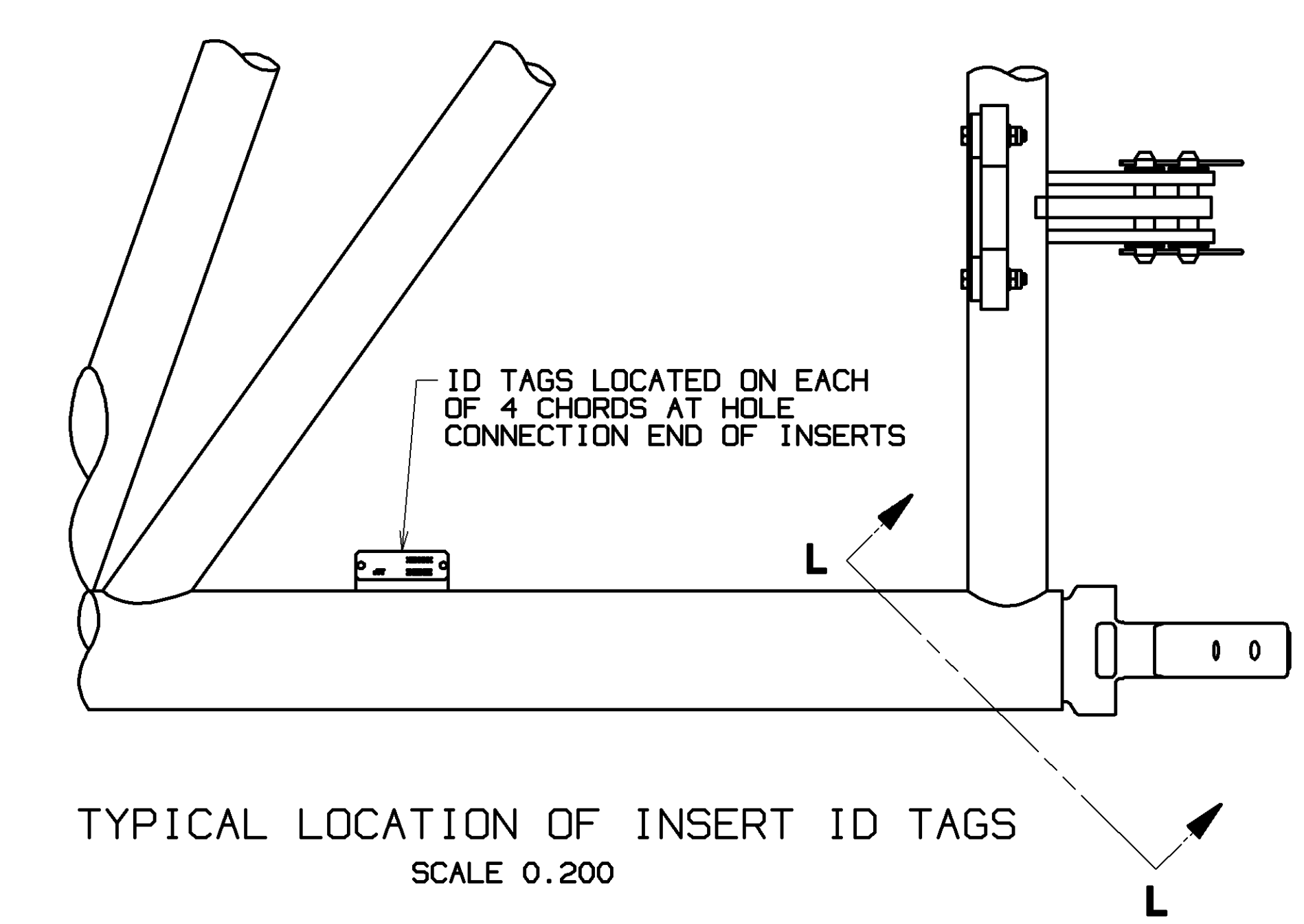
REQ'D #500 BOOM/#501 BACKSTAY STRAP ASSEMBLY
 SEE TABLE ON SHEET 2
 FOR TYP PIN JOINT SEE DETAILS A, B, G, H AND J
 SCALE 0.008



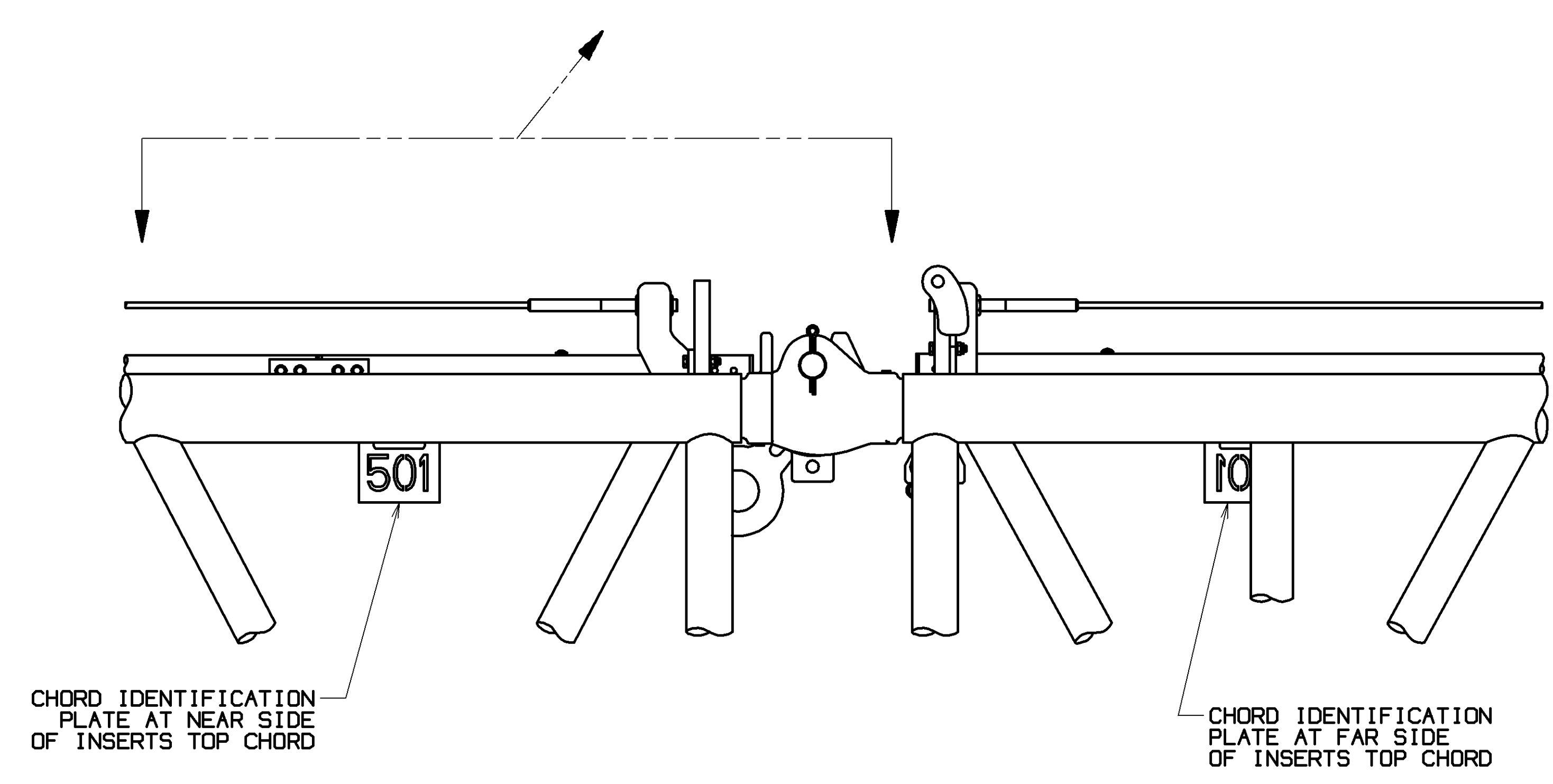
REQ'D. #501 JIB/BACKSTAY STRAP ASSEMBLY
 SEE TABLE ON SHEET 2
 FOR TYP PIN JOINT SEE DETAILS C, D, E, F AND K
 SCALE 0.010



VIEW L-L
 UPPER MALE CONNECTOR PIN HOLE
 SCALE 0.200



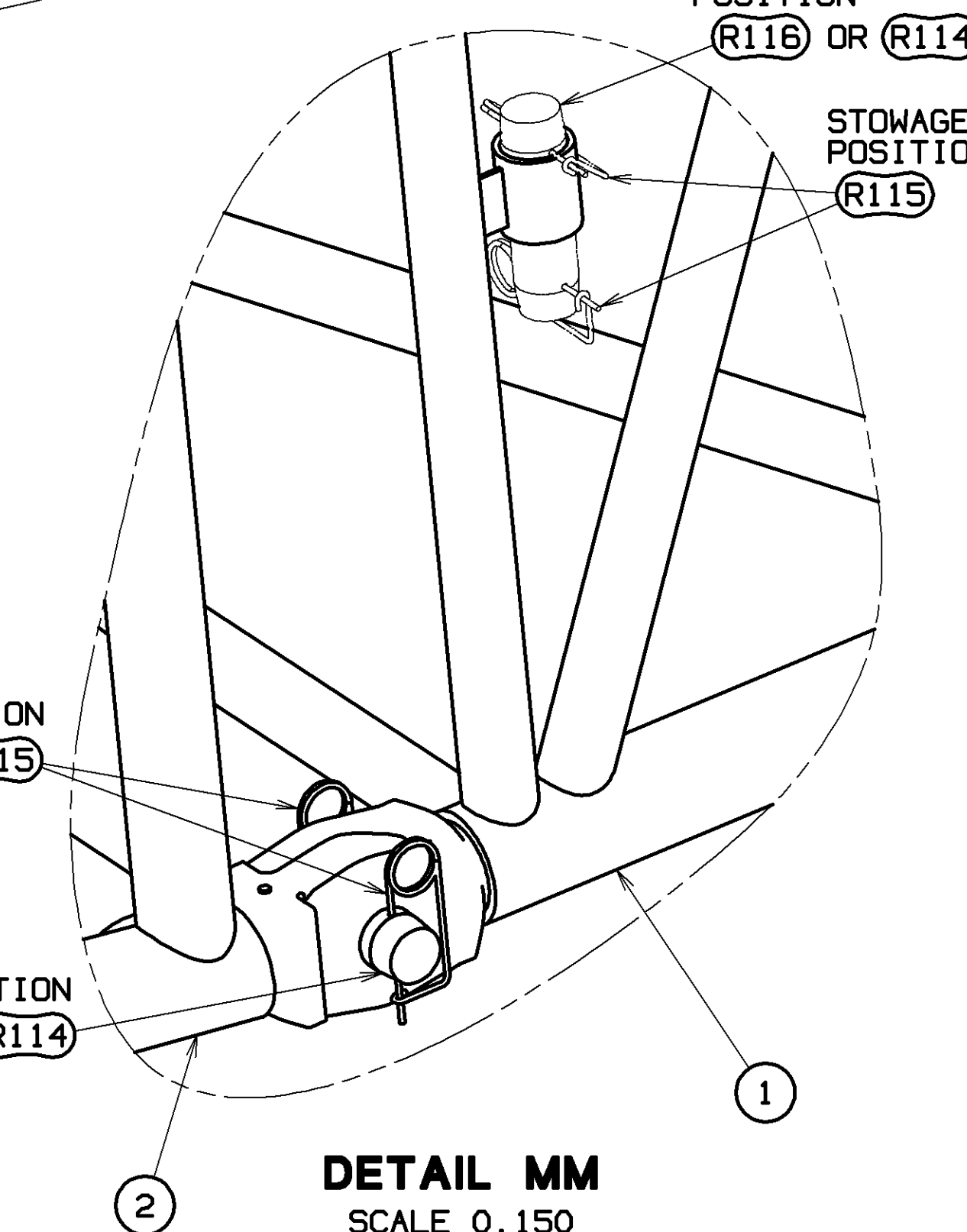
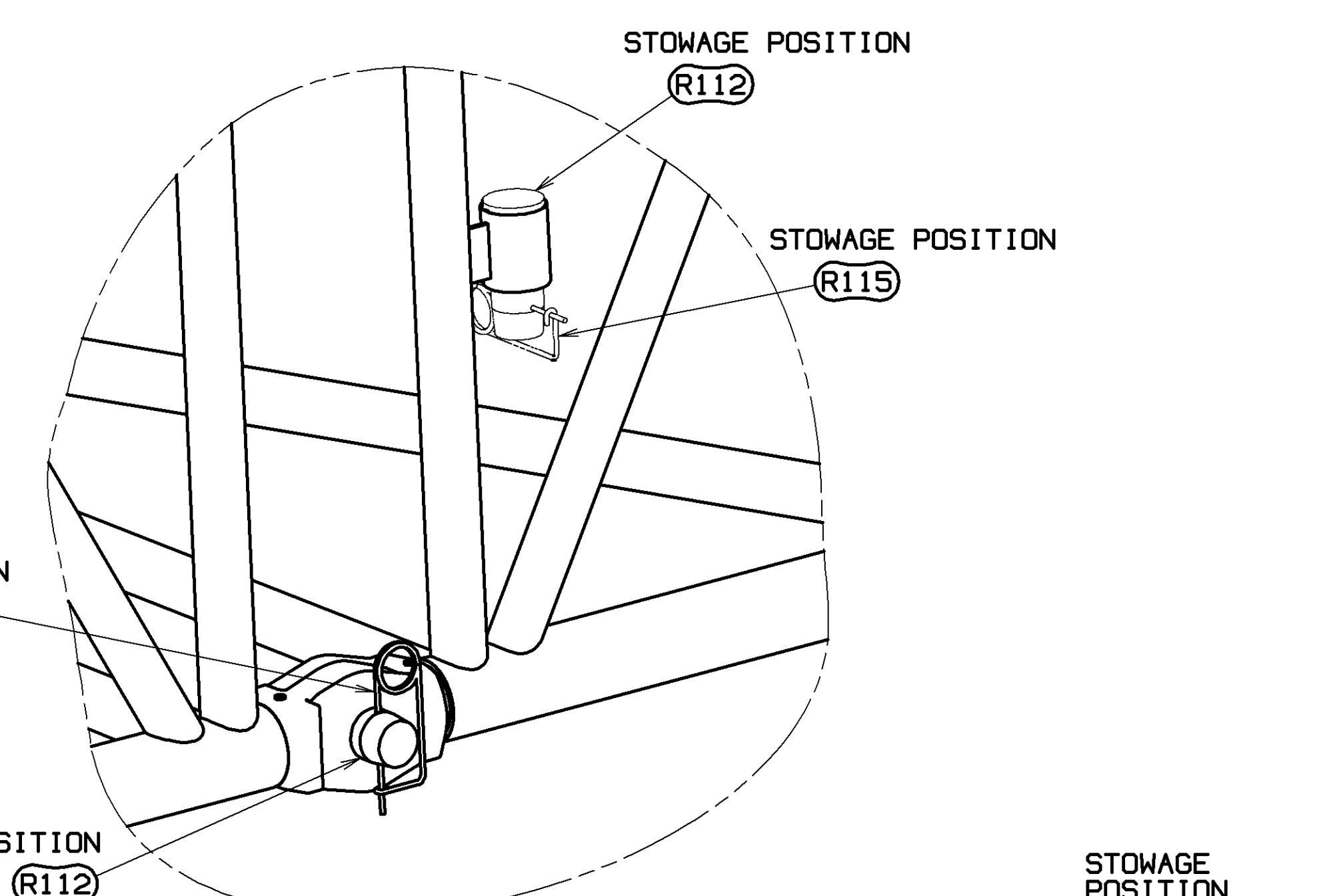
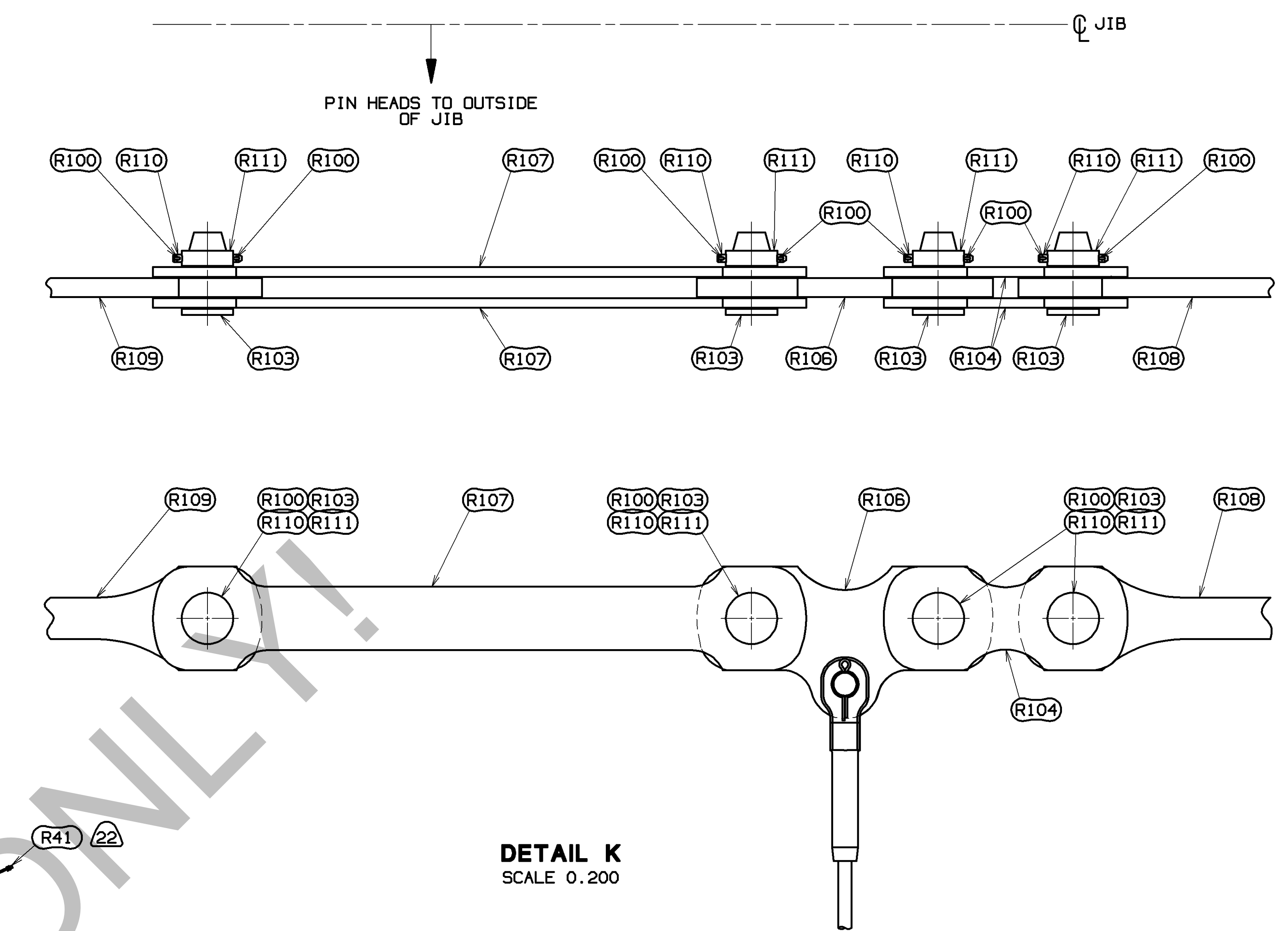
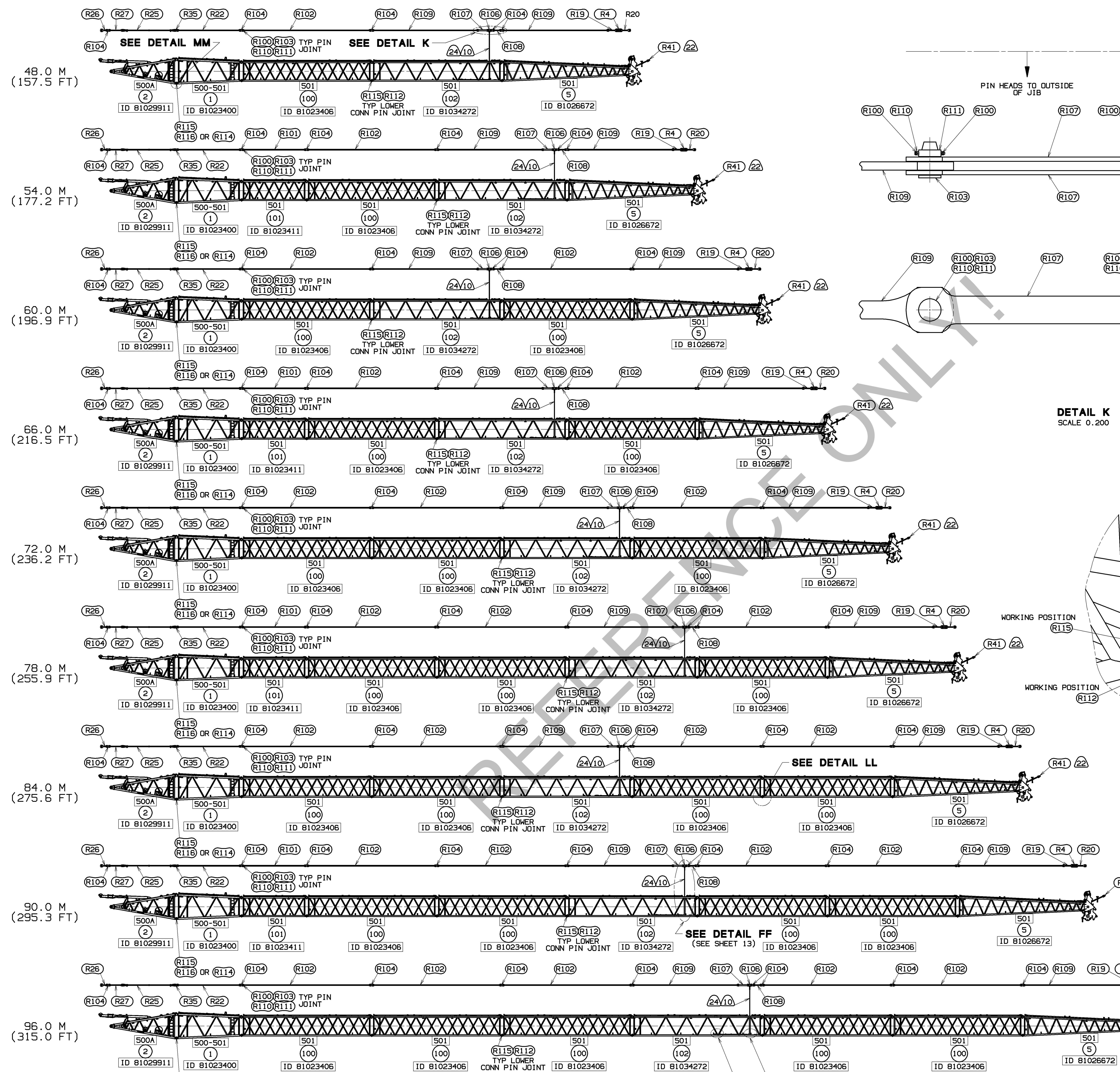
TYPICAL LOCATION OF INSERT ID TAGS
 SCALE 0.200



TYPICAL LOCATION OF JIB CHORD IDENTIFICATION PLATE
 SCALE 0.150

TOLERANCE UNLESS OTHERWISE SPECIFIED		FABRICATION		FINISHING		NOTE	DATE	BY	APP
DECIMAL PLACES	F. TO FEET	> 10 FEET	> 10 FEET	WELDING	PAINTING	DR. AJB	07-14-16		
(1) PLACE 0.5	±.12	±.18	±.05	TO BE	TO BE	CK. RHY			
(2) PLACE 0.00	±.08	±.12	±.015	TO BE	TO BE	APP DLG			
(3) PLACE 0.000	±.008	±.012	±.006	TO BE	TO BE				
ANGLES	±1.30°	±1.30°	±0.90°						

MANITOWOC CRANES, INC.	LUFFING JIB RIGGING
MODEL MLC300	LJ10:501 ON B60:500



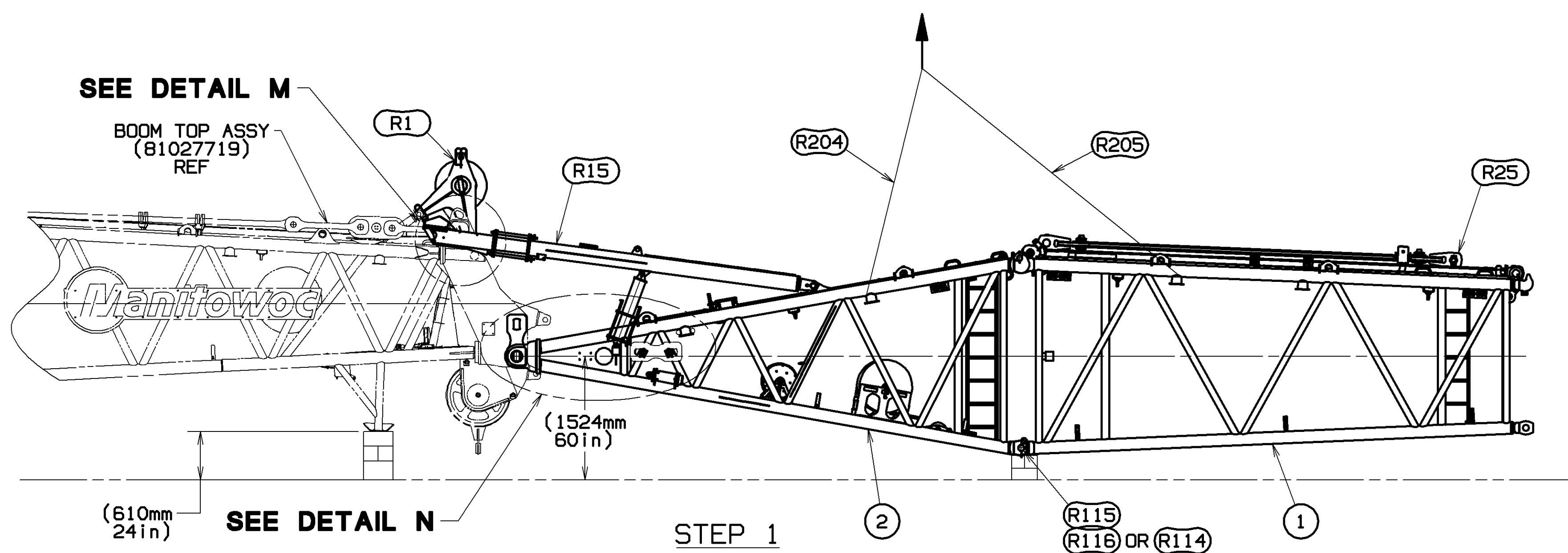
SEE DETAIL GG (SEE SHEET 13) SEE DETAIL HH (SEE SHEET 13)

THIS PRINT REMAINS THE PROPERTY OF METRAC CRANES, INC. ALL INFORMATION CONTAINED HEREIN IS CONFIDENTIAL AND IS LOANED, SUBJECT TO RETURN UPON DEMAND, AND ON EXPRESS CONDITION THAT IT IS NOT TO BE COPIED OR USED DIRECTLY OR INDIRECTLY IN ANY MANNER WITHOUT WRITTEN PERMISSION OF METRAC CRANES, INC.

DECIMAL PLACES	FRACTIONS	IN FEET	IN METERS
(1) PLACE 0.5	1/2	0.5	0.5
(2) PLACE 0.00	1/16	0.0625	0.0625
(3) PLACE 0.000	1/32	0.03125	0.03125

DATE	07-14-16
REV. LTR.	D
DR. AUB	Manitowoc Cranes, Inc.
CK. RHW	Manitowoc, Wisconsin
APP. DLG	MODEL MLC300
	LUFFING JIB RIGGING
	LJ10:501 ON B60:500

BILL OF MATERIAL		ASSEMBLIES USED IN
QTY	DESCRIPTION	MATERIAL

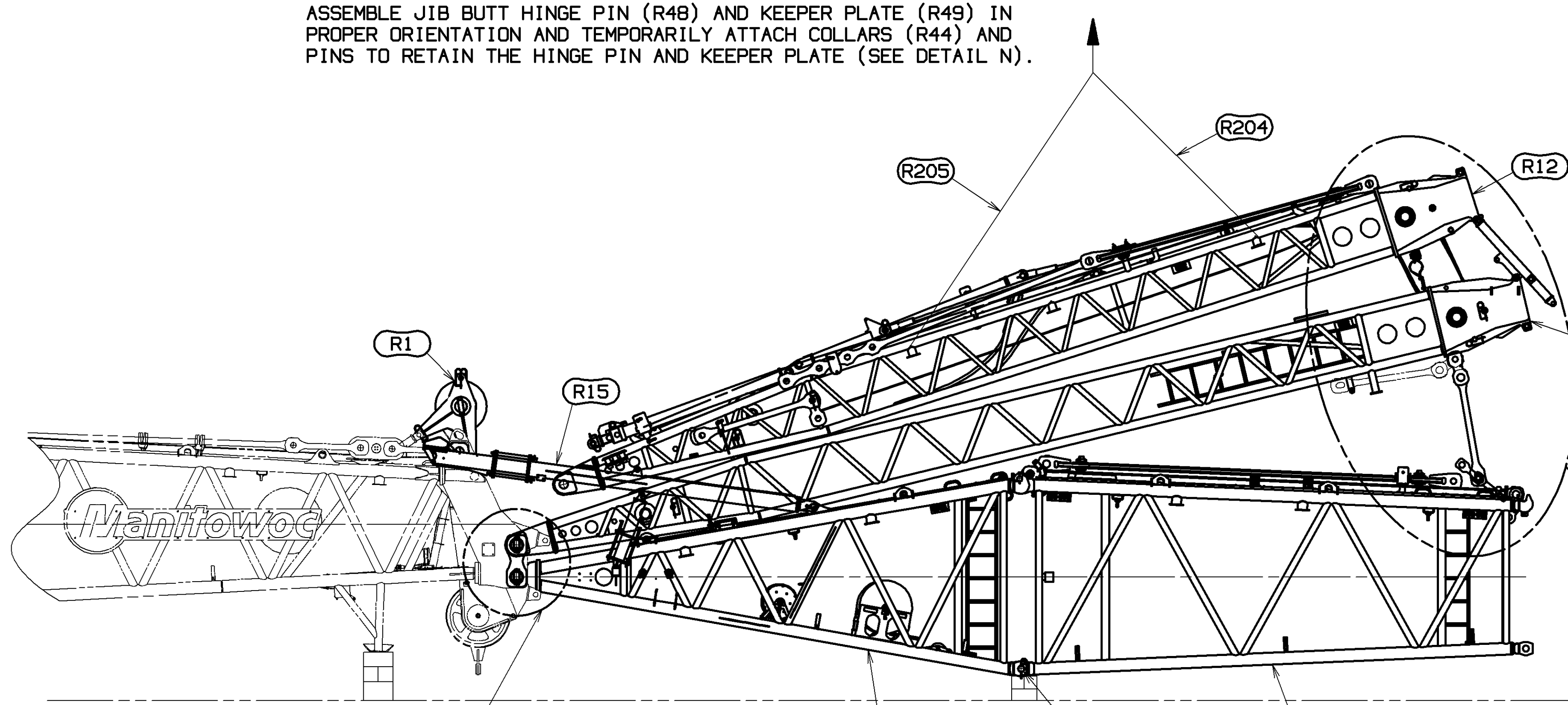


STEP 1
JIB BUTT/TRANSITION ASSEMBLY

(REFER TO SHEETS 14 & 15 FOR ALTERNATE STRUT & JIB ASSEMBLY)
RELOCATE JIB STOP STRUT HAIRPIN FROM SHIPPING POSITION TO WORKING POSITION TO ALLOW JIB STOP STRUT TO EXTEND (SEE DETAIL N).

USING ASSIST CRANE WITH SLINGS (R204) & (R205) ATTACH LUFFING JIB BUTT (ITEM 2) AND TRANSITION INSERT (ITEM 1) SHIPPING UNIT TO BLOCKED BOOM TOP AS SHOWN. ENSURE THAT LUFFING JIB STOPS (R15) ARE SUPPORTED AND SITTING ON TOP OF THE STOP LUGS ON THE BOOM TOP (SEE DETAIL M).

ASSEMBLE JIB BUTT HINGE PIN (R48) AND KEEPER PLATE (R49) IN PROPER ORIENTATION AND TEMPORARILY ATTACH COLLARS (R44) AND PINS TO RETAIN THE HINGE PIN AND KEEPER PLATE (SEE DETAIL N).

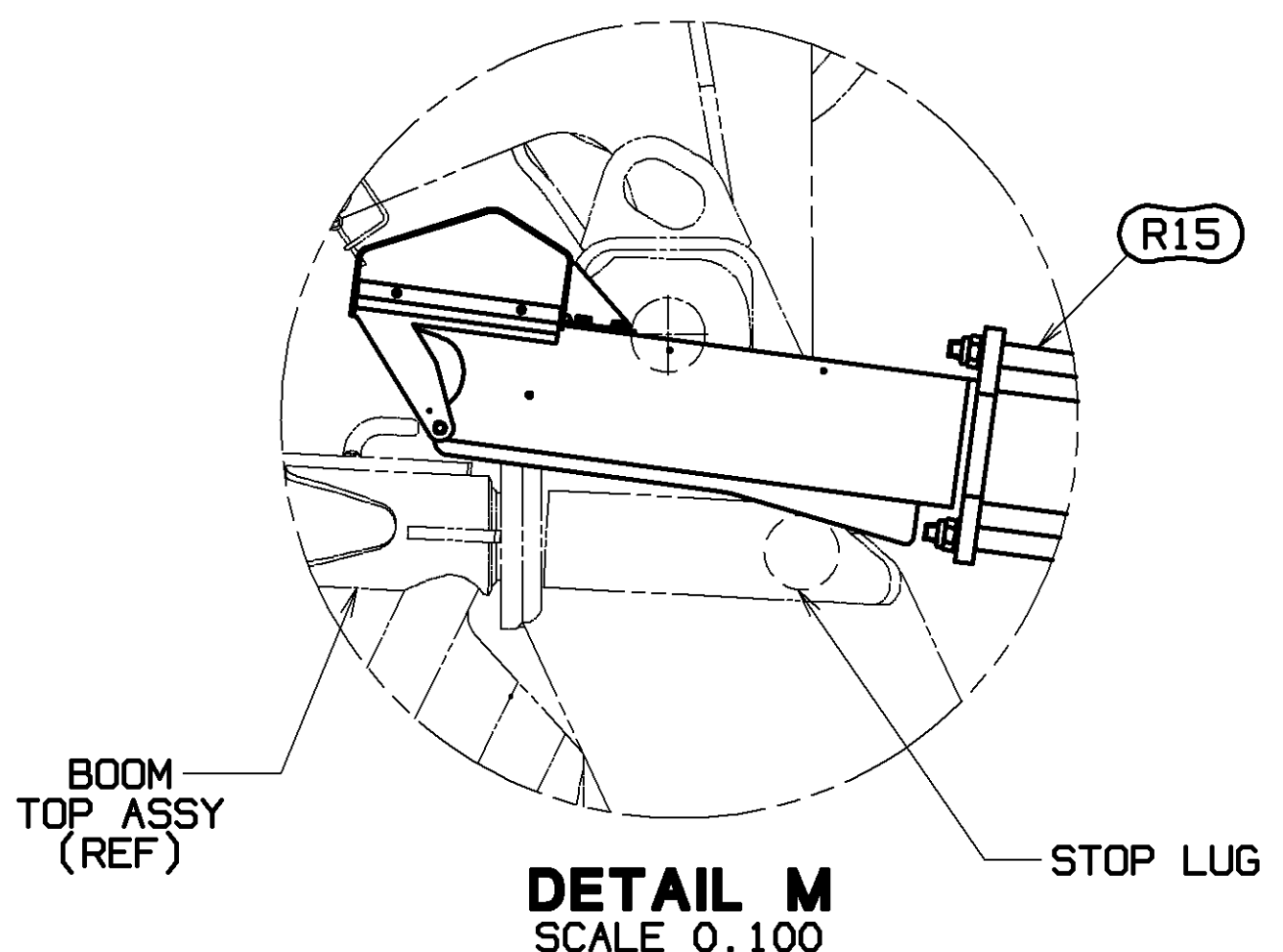


STEP 2
JIB STRUT ASSEMBLY

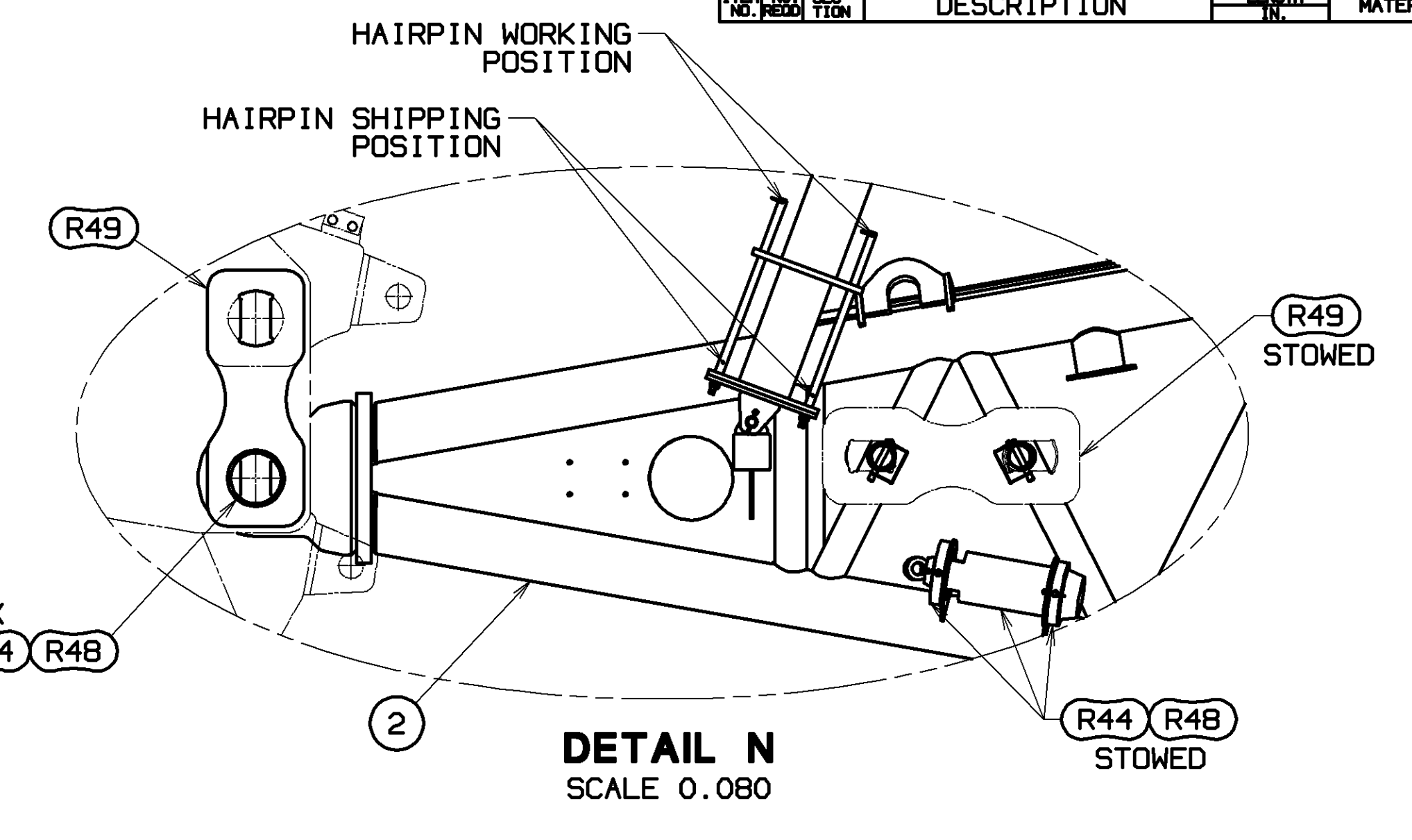
(REFER TO SHEETS 14 & 15 FOR ALTERNATE STRUT & JIB ASSEMBLY)

USING ASSIST CRANE WITH SLINGS (R204) & (R205) AS SHOWN, ASSEMBLE THE JIB STRUT (R13) AND MAIN STRUT (R12) IN THE "AS SHIPPED" CONFIGURATION (ITEM 6) ON TOP OF THE LUFFING JIB BUTT (ITEM 2) AND TRANSITION INSERT (ITEM 1). ATTACH JIB STRUT TO JIB STRUT HINGE ON BOOM TOP AND ASSEMBLE JIB STRUT HINGE PIN (R47) IN THE PROPER ORIENTATION AND ATTACH THE KEEPER PLATE (R49) AS ASSEMBLED IN STEP 1. ATTACH COLLARS (R43) AND PINS TO RETAIN KEEPER PLATE (R49) AND JIB STRUT PIN (R47). (SEE DETAIL R).

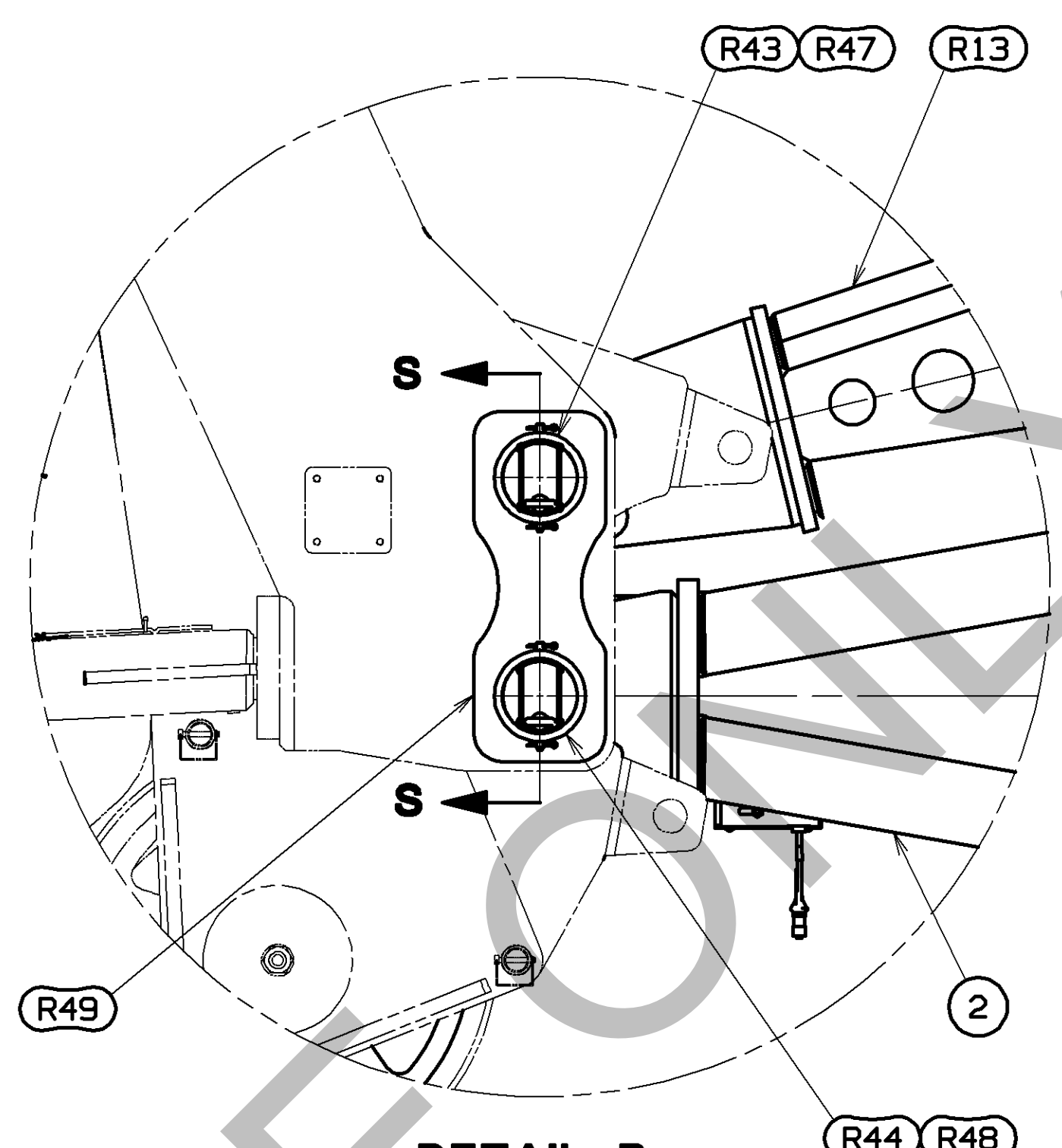
ON THE TRANSITION INSERT (ITEM 1) REMOVE STRAP PIN AND COLLAR FROM THE END OF THE SPREADER (R25) TO REMOVE SHIPPING/HOLD DOWN LINKS (R24). TEMPORARILY SET PIN ASIDE. REMOVE JIB STRUT BASIC STRAPS (R27)(R104)(R26) FROM SHIPPING BRACKET AND ALLOW THEM TO HANG UNTIL THE END OF BASIC STRAP (R27) IS ALIGNED WITH THE MIDDLE HOLE ON THE SHIPPING/HOLD DOWN LINKS (R24) ON THE TRANSITION INSERT (ITEM 2). ASSEMBLE LINKS TO BASIC STRAPS USING THE PREVIOUSLY REMOVED PIN. (SEE DETAIL T).



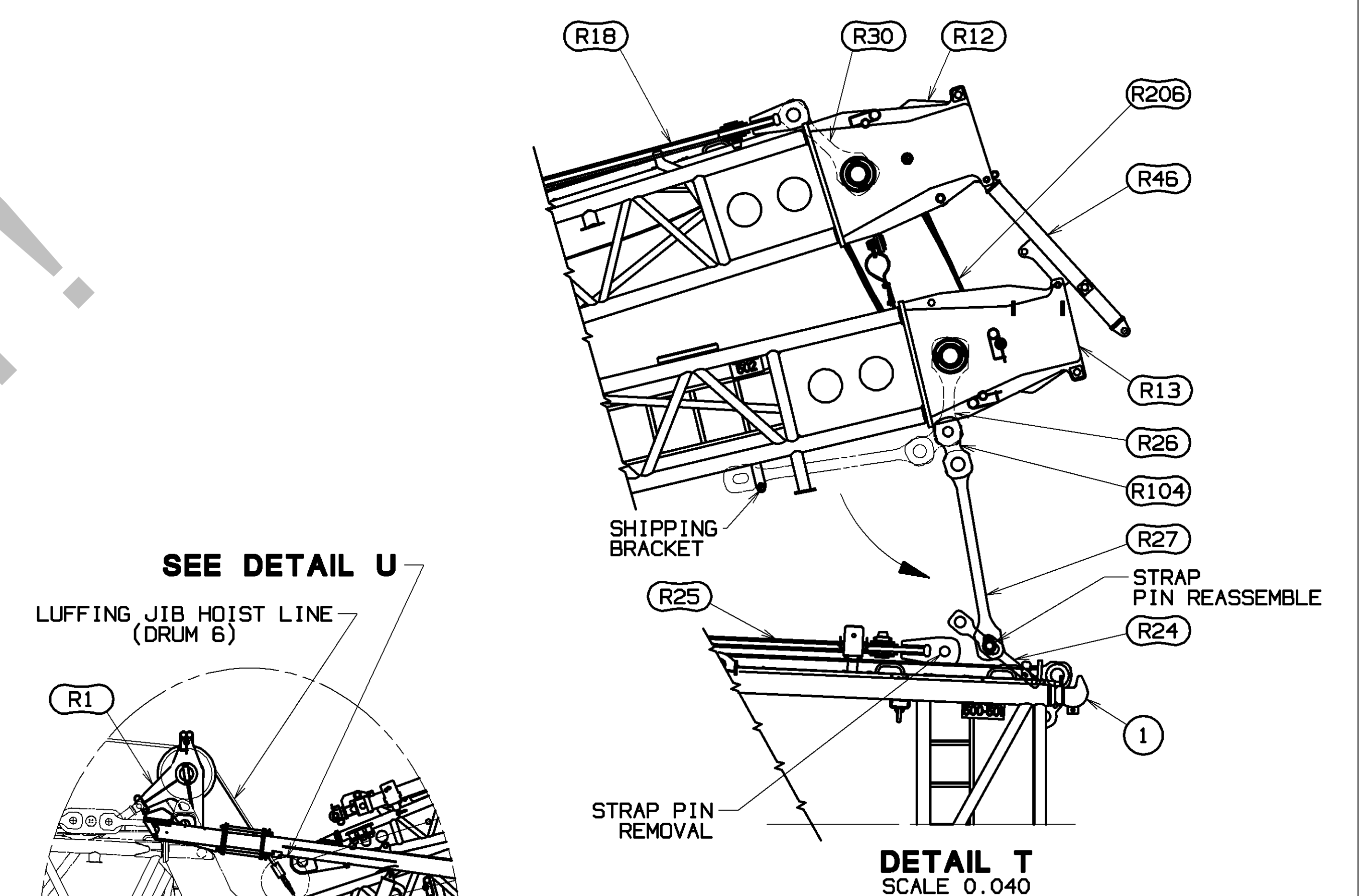
DETAIL M
SCALE 0.100



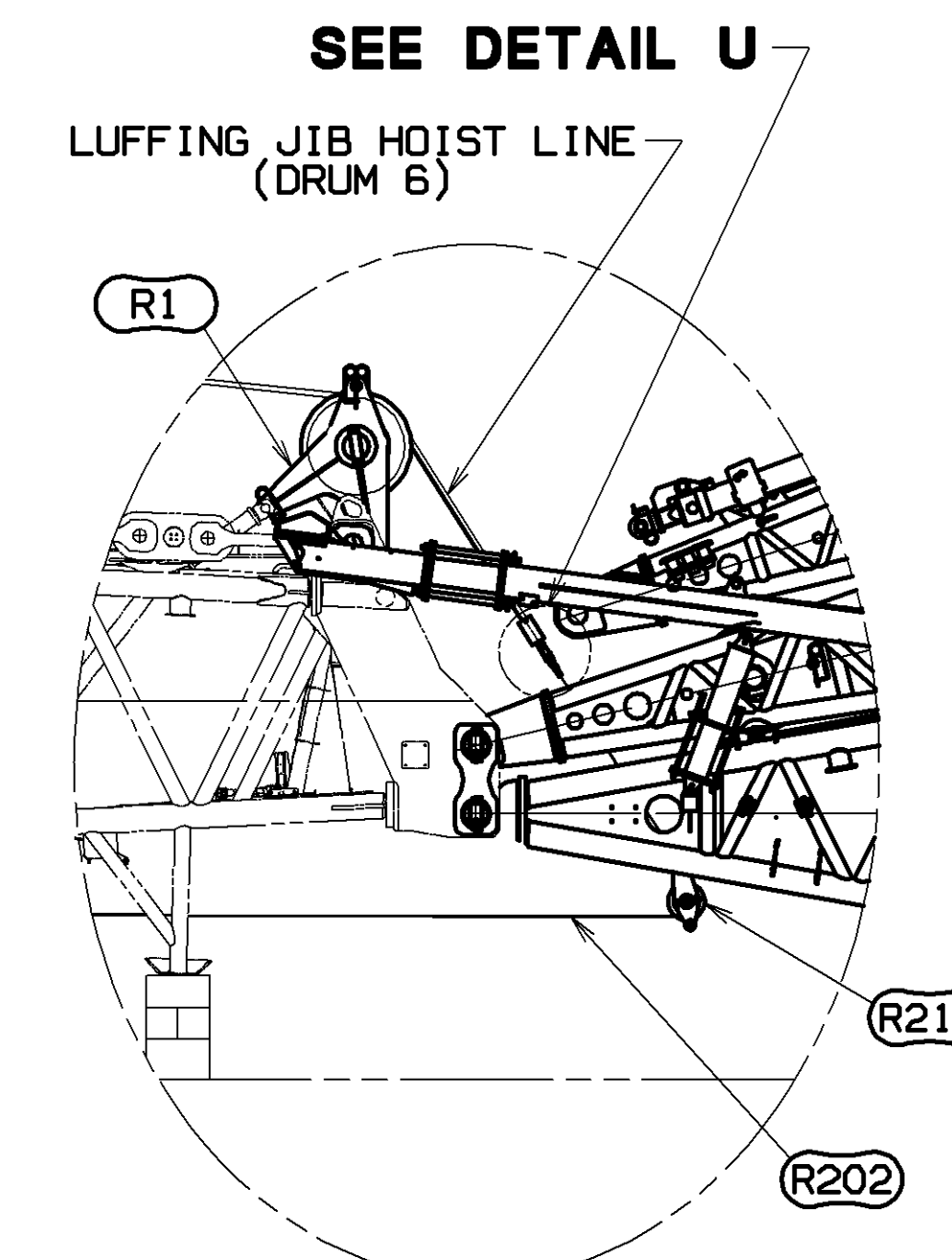
DETAIL N
SCALE 0.080



DETAIL R
SCALE 0.100



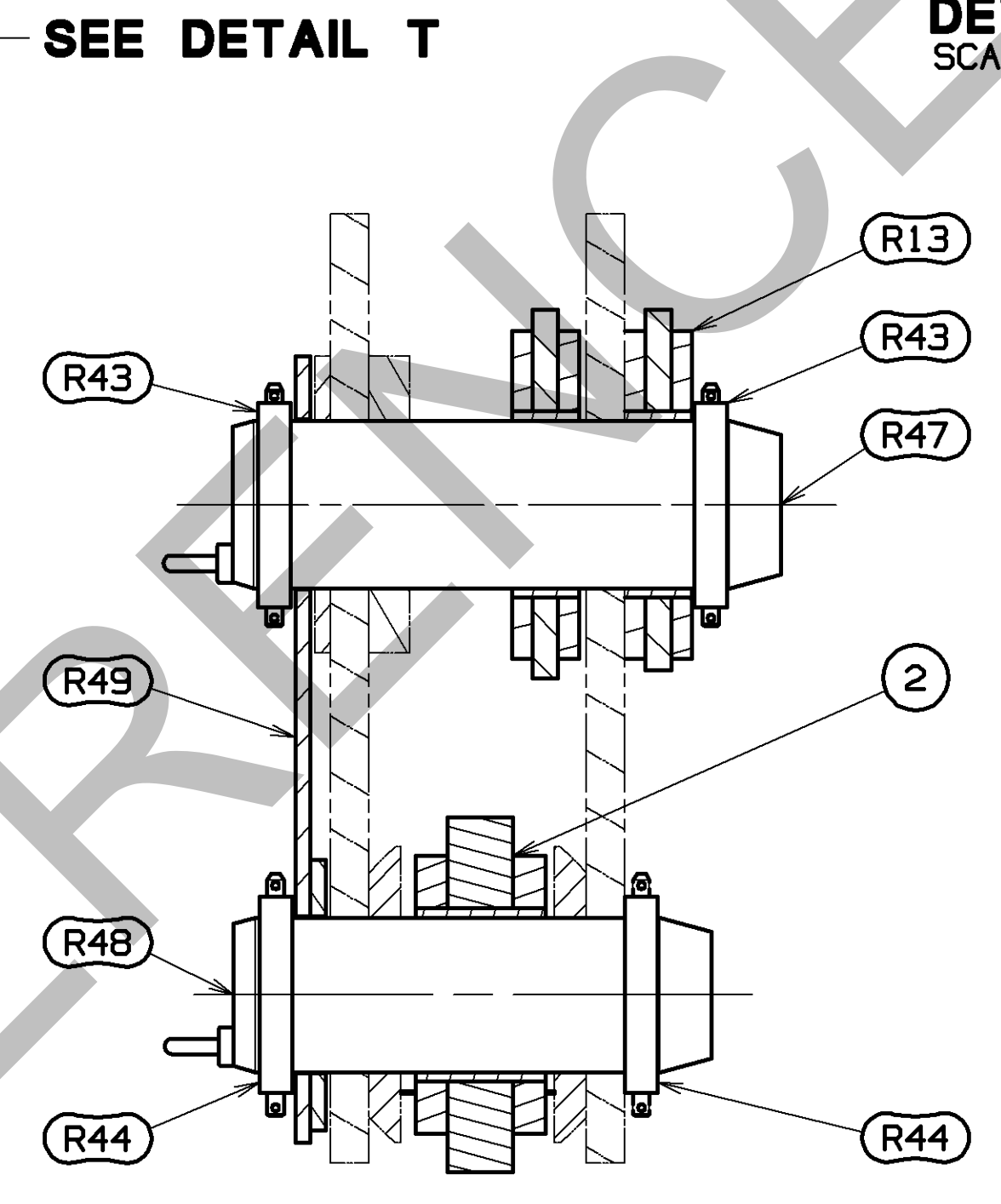
DETAIL T
SCALE 0.040



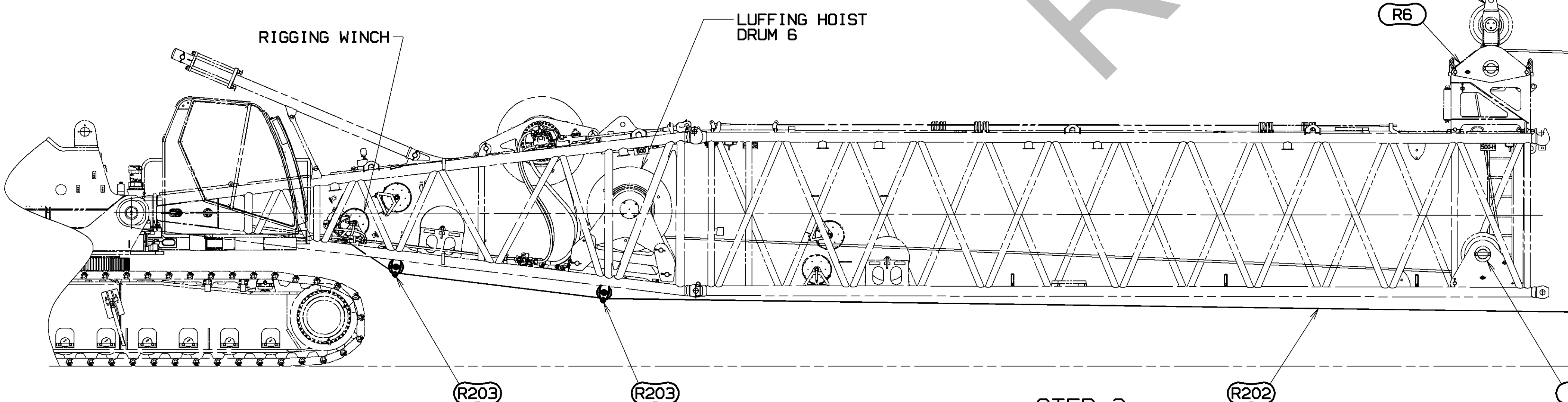
DETAIL NN

STRUT REEVING PREP WITHOUT LOWER BOOM POINT SHEAVES
VERIFY THAT ALL RIGGING WINCH WIRE ROPE GUIDE ASSY'S (R203) AND (R211) ARE IN WORKING POSITION. REFER TO STEP 3 AND DETAIL NN TO ROUTE RIGGING WINCH LINE (R202). RIGGING WINCH LINE (R202) TO ROUTE THRU ROPE GUIDES (R203) AND (R211) TO OVER BOOM TOP WIRE ROPE GUIDE (R1), OVER WIRE ROPE GUIDE (R6) AND UNDER WIRE ROPE GUIDE (R7).

CONTINUE AS NOTED IN STEP 3 ATTACHING RIGGING WINCH LINE TO LUFFING JIB HOIST LINE.



SECTION S-S
SCALE 0.200



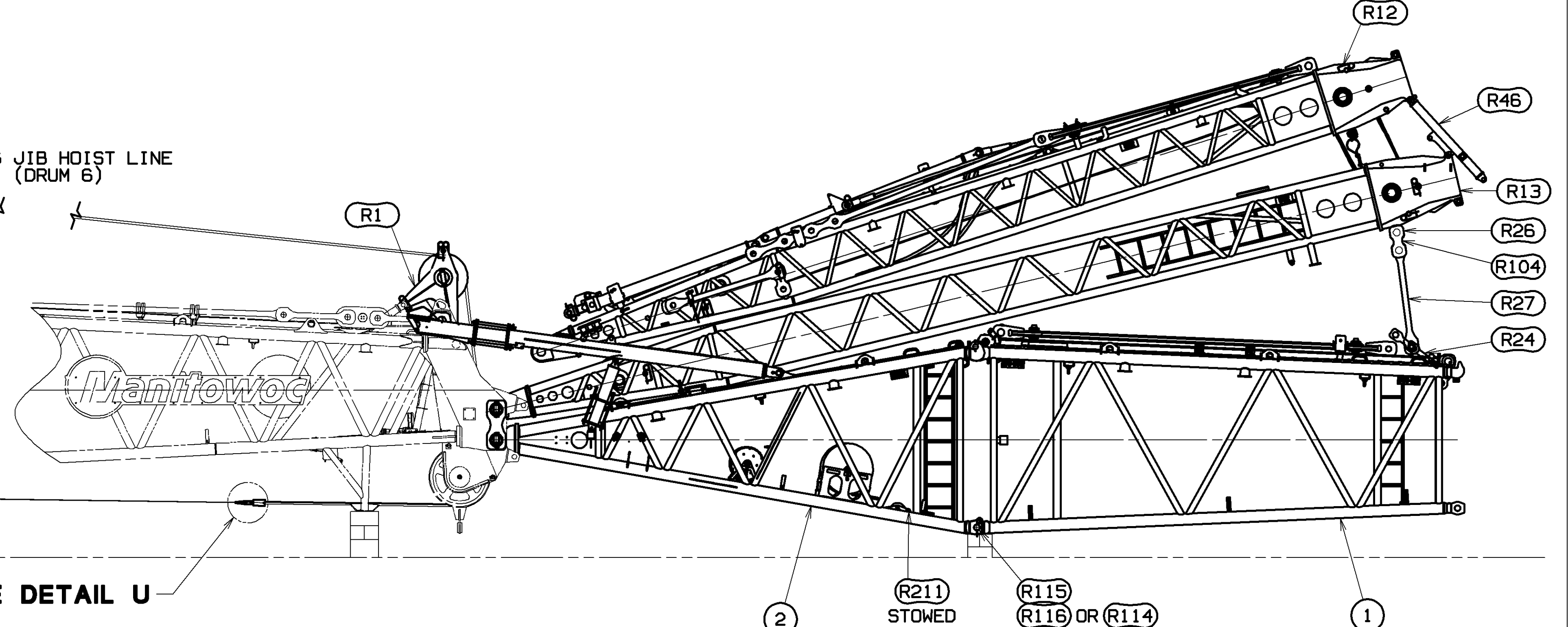
STEP 3
STRUT REEVING PREP

(REFER TO SHEETS 14 & 15 FOR ALTERNATE STRUT & JIB ASSEMBLY)

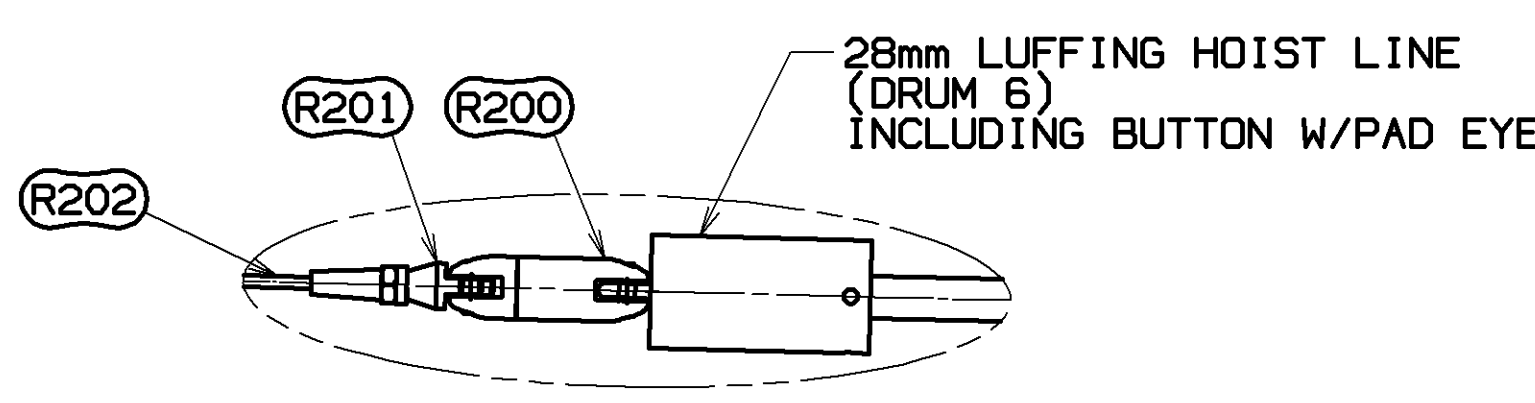
WHEN EQUIPPED WITH LOWER BOOM POINT SHEAVES, VERIFY THAT ALL RIGGING WINCH WIRE ROPE GUIDE ASSY'S (R203) ARE IN WORKING POSITION. ROUTE RIGGING WINCH LINE (R202) AS SHOWN. RIGGING WINCH LINE (R202) TO ROUTE THRU ROPE GUIDES (R203) UNDER LOWER BOOM POINT TO OVER BOOM TOP WIRE ROPE GUIDE (R1), OVER WIRE ROPE GUIDE (R6) AND UNDER WIRE ROPE GUIDE (R7).
WHEN NOT EQUIPPED WITH LOWER BOOM POINT SHEAVES SEE DETAIL NN FOR ROUTING OF RIGGING WINCH LINE (R202).

WITH RIGGING WINCH LINE ROUTED PER PREVIOUS INSTRUCTIONS, ATTACH RIGGING WINCH LINE (R202) TO 28mm LUFFING HOIST LINE (DRUM 6) AND PAY IN RIGGING WINCH UNTIL LUFFING HOIST IS UNDER BOTTOM OF LOWER BOOM POINT OR BETWEEN BOOM TOP WIRE ROPE GUARD (R1) AND WIRE ROPE GUIDE ASSY (R211). (SEE DETAIL U).

DETACH RIGGING WINCH LINE (R202) FROM 28mm LUFFING HOIST LINE.
REMOVE LUFFING HOIST LINE FROM LOWER BOOM POINT (IF EQUIPPED) AND BOOM TOP WIRE ROPE GUARD (R1) FOR USE IN STRUT REEVING STEP 4 ON SHEET 8.



SEE DETAIL U

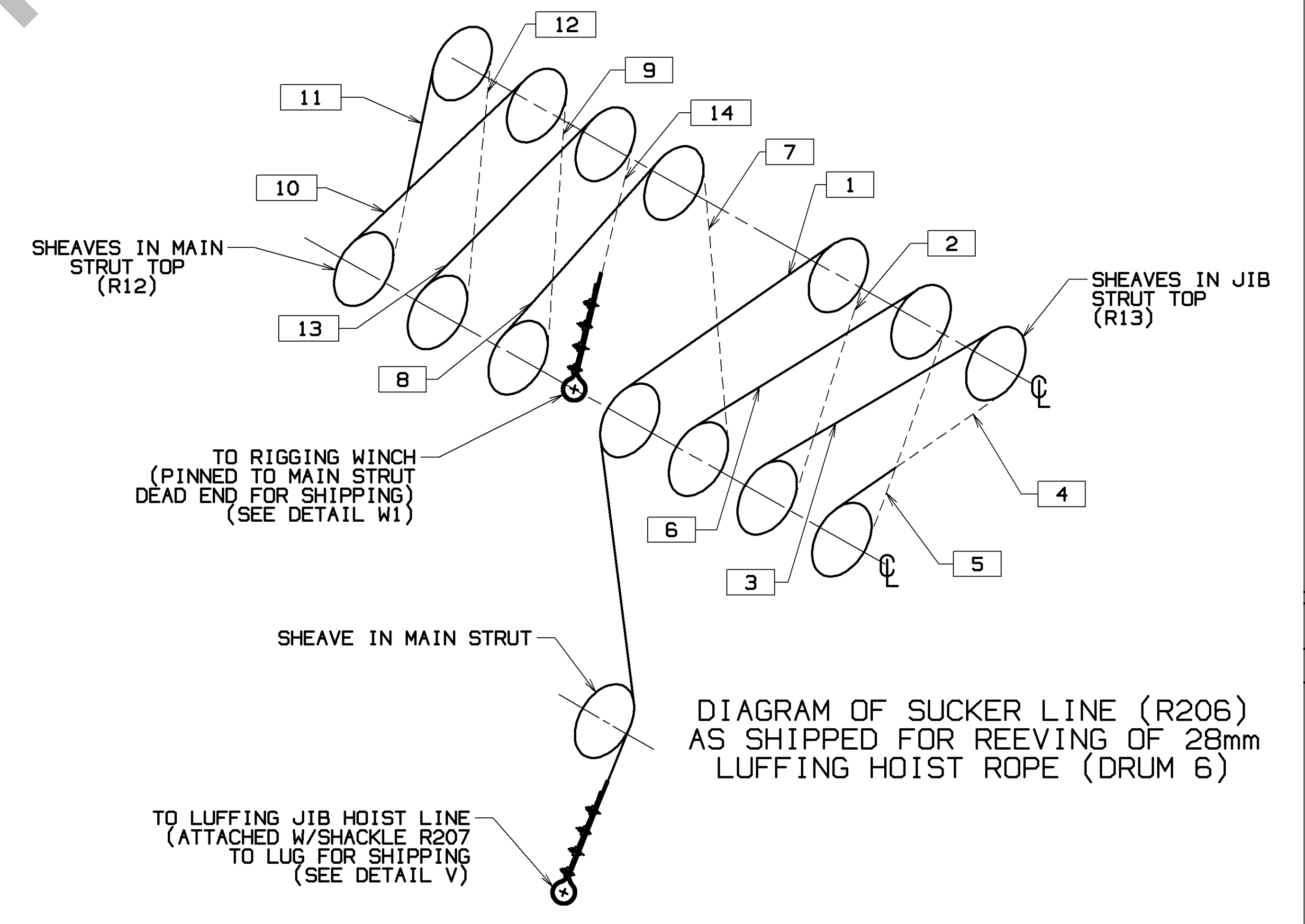
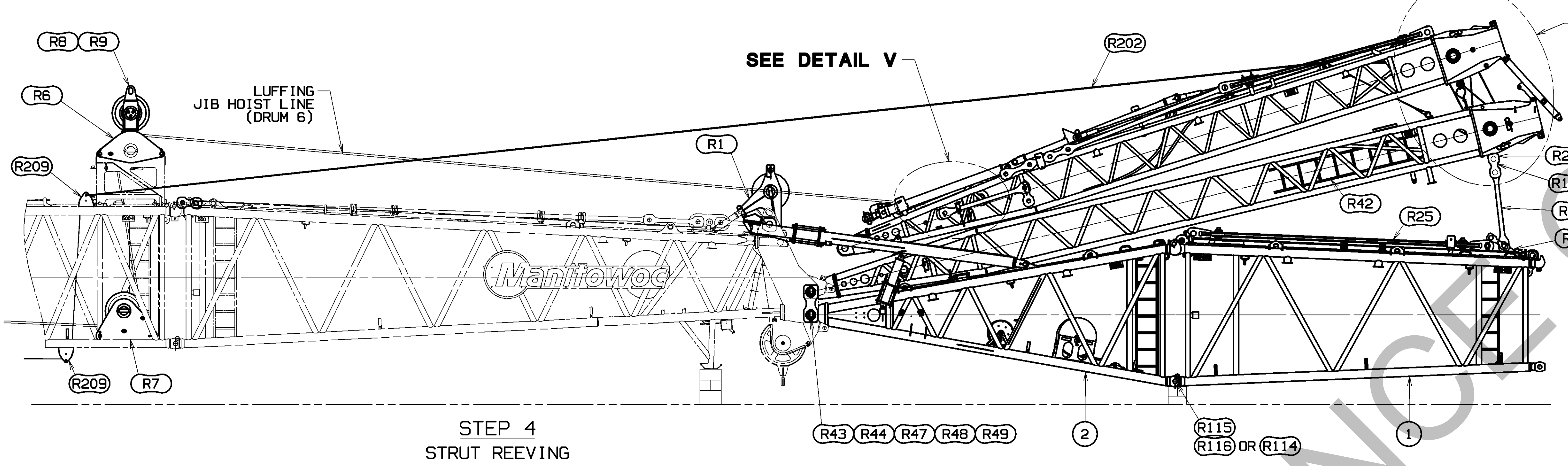
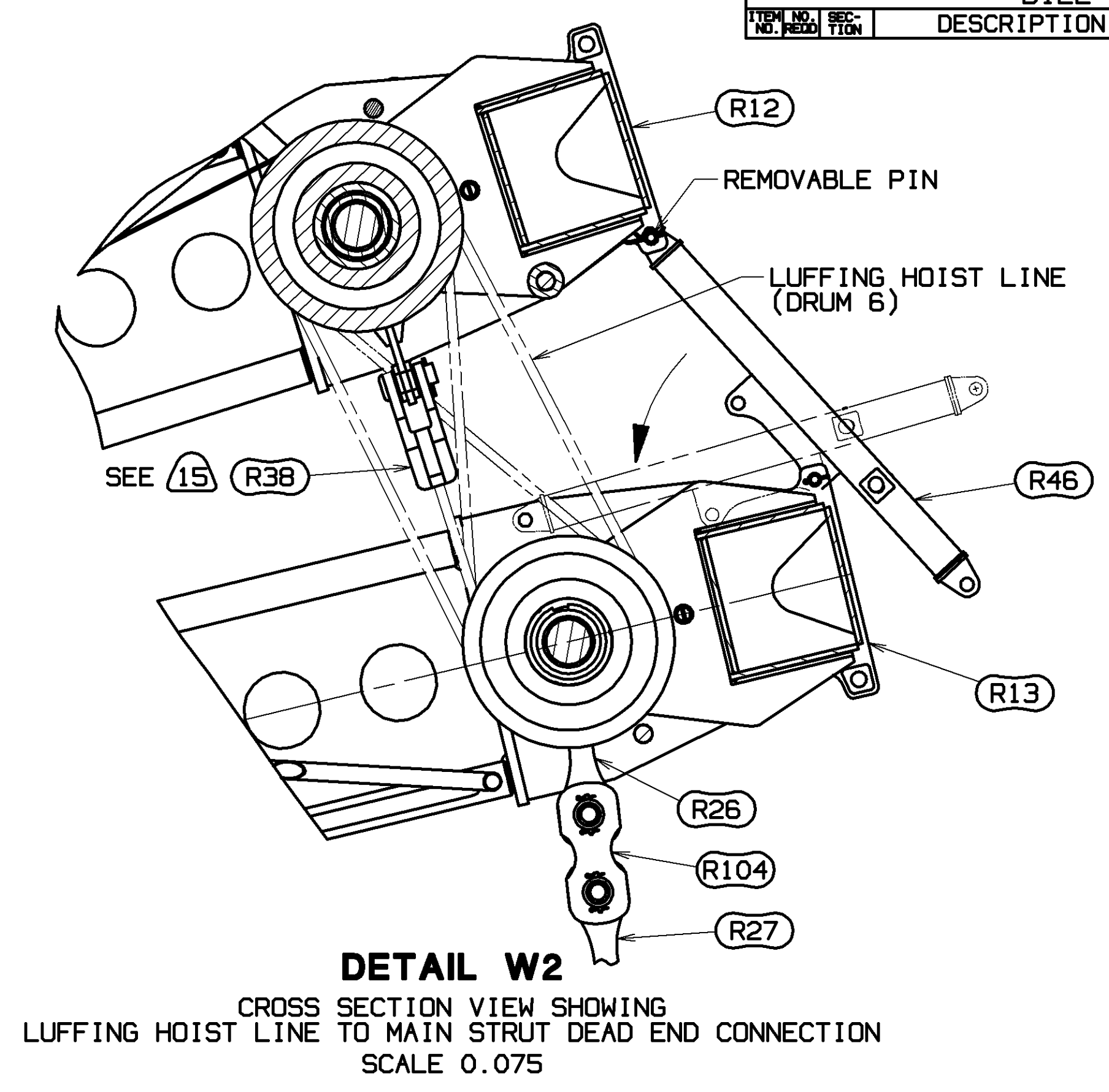
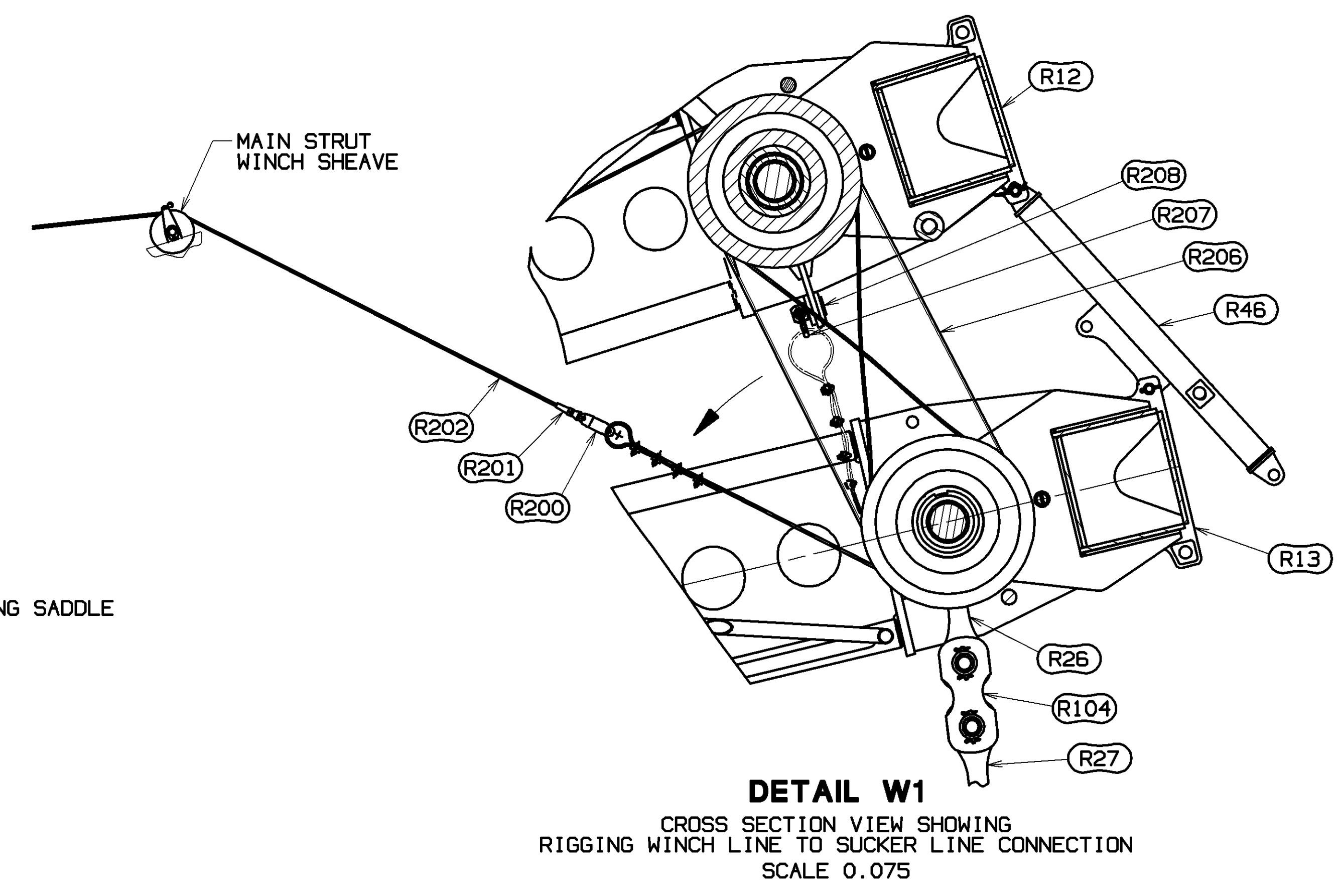
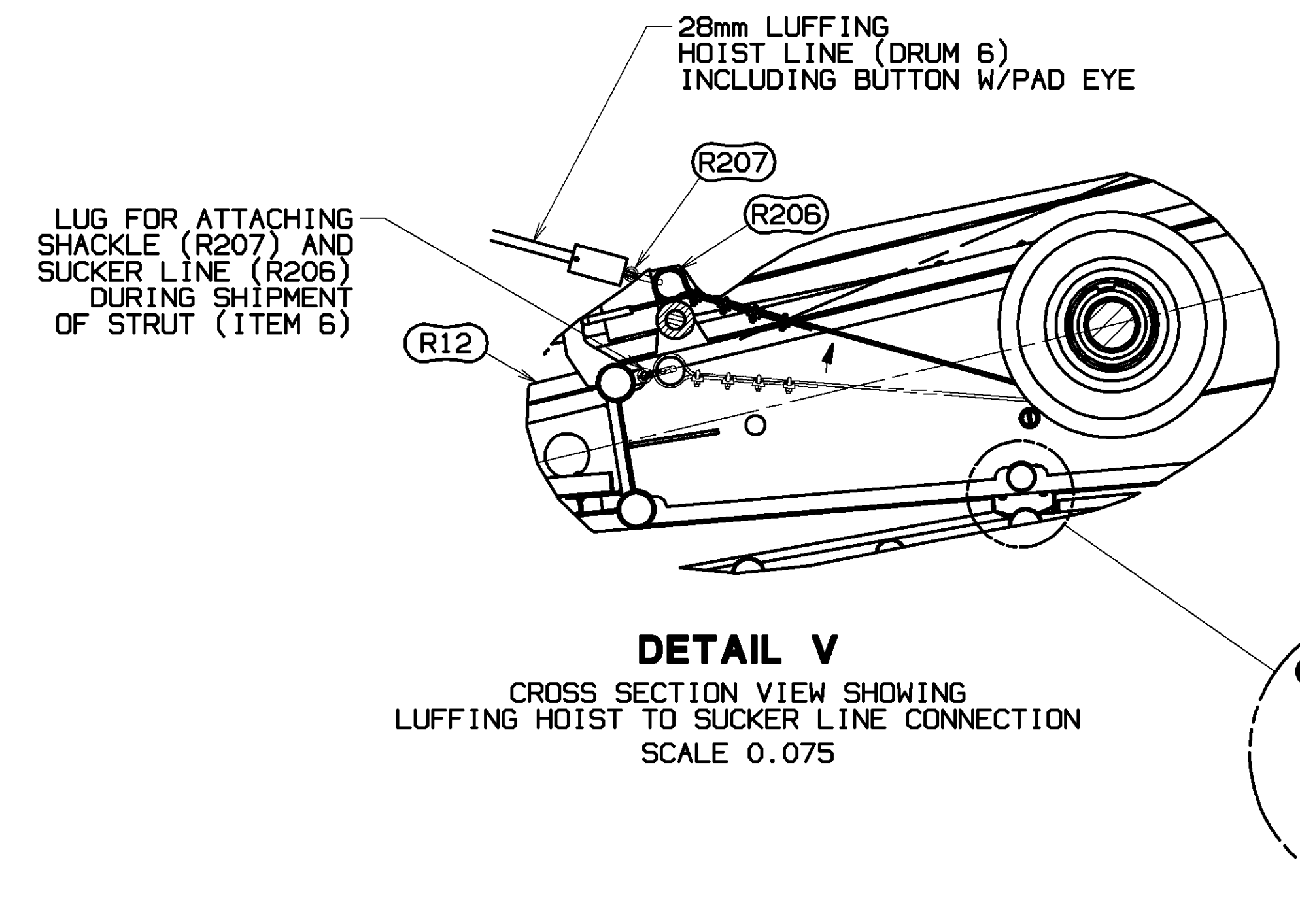


DETAIL U
SCALE .200

DECIMAL PLACES	FRACTION	10 FEET	10 FEET	10 FEET	MANUFACTURING	SCALE	MANUFACTURER	DESCRIPTION
(1) PLACE 0.5	1/2	±.10	±.10	±.05	±.05	0.025	Manitowoc Cranes, Inc.	LUFFING JIB RIGGING
(2) PLACE 0.00	±.00	±.08	±.12	±.015	±.015	0.025	Manitowoc Cranes, Inc.	LJ10:501 ON B60:500
(3) PLACE 0.000	±.000	±.06	±.08	±.008	±.008	0.025	Manitowoc Cranes, Inc.	

PRIVATE LABELING REQUIREMENT TO CONFORM TO ENGINEERING SPECIFICATION S629103794 FOR COMPONENTS LISTED IN G62900-09-026
DATE 07-14-16
REV. LTR. D

BILL OF MATERIAL		ASSEMBLIES USED IN
QTY	DESCRIPTION	MATERIAL



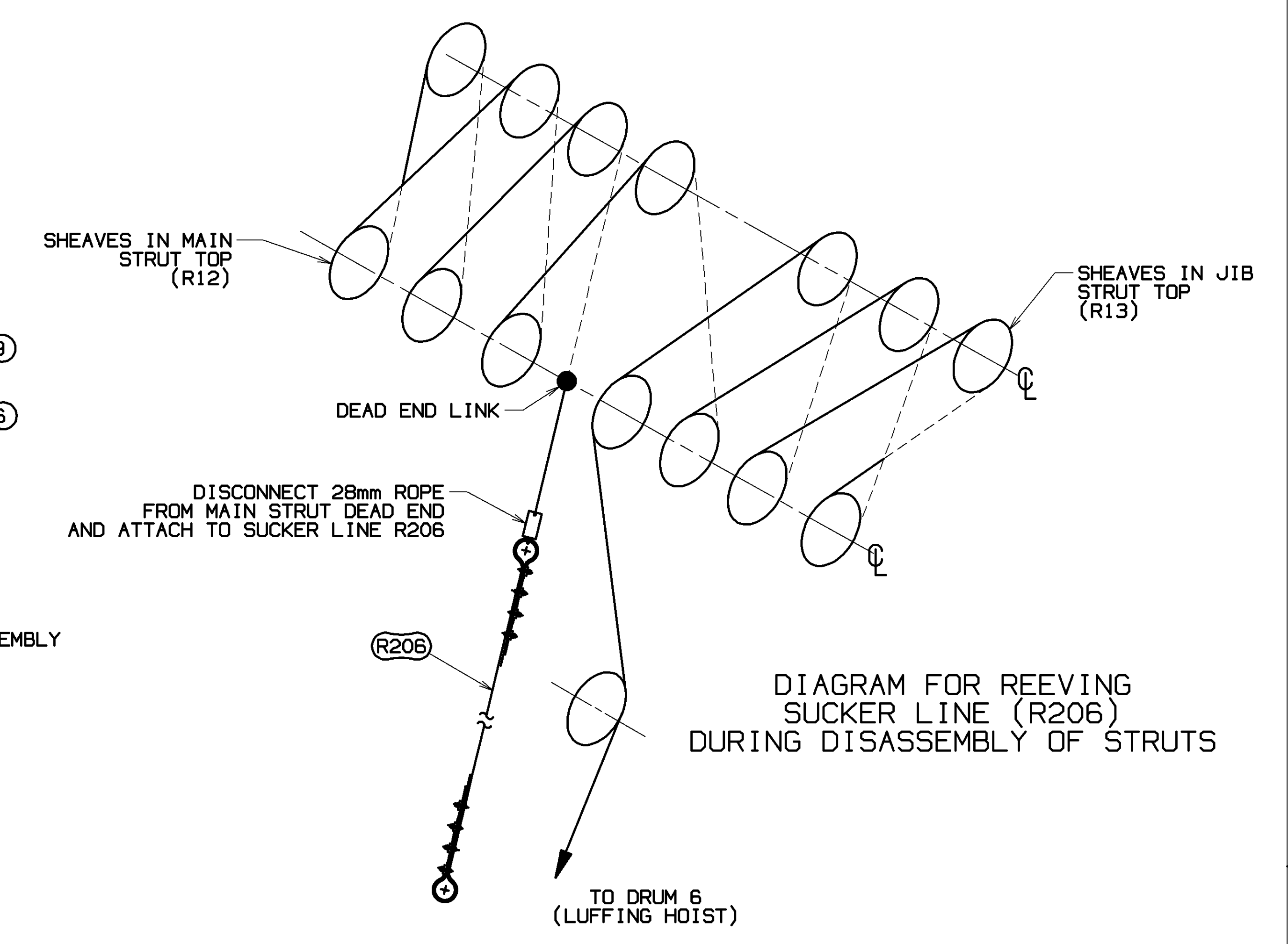
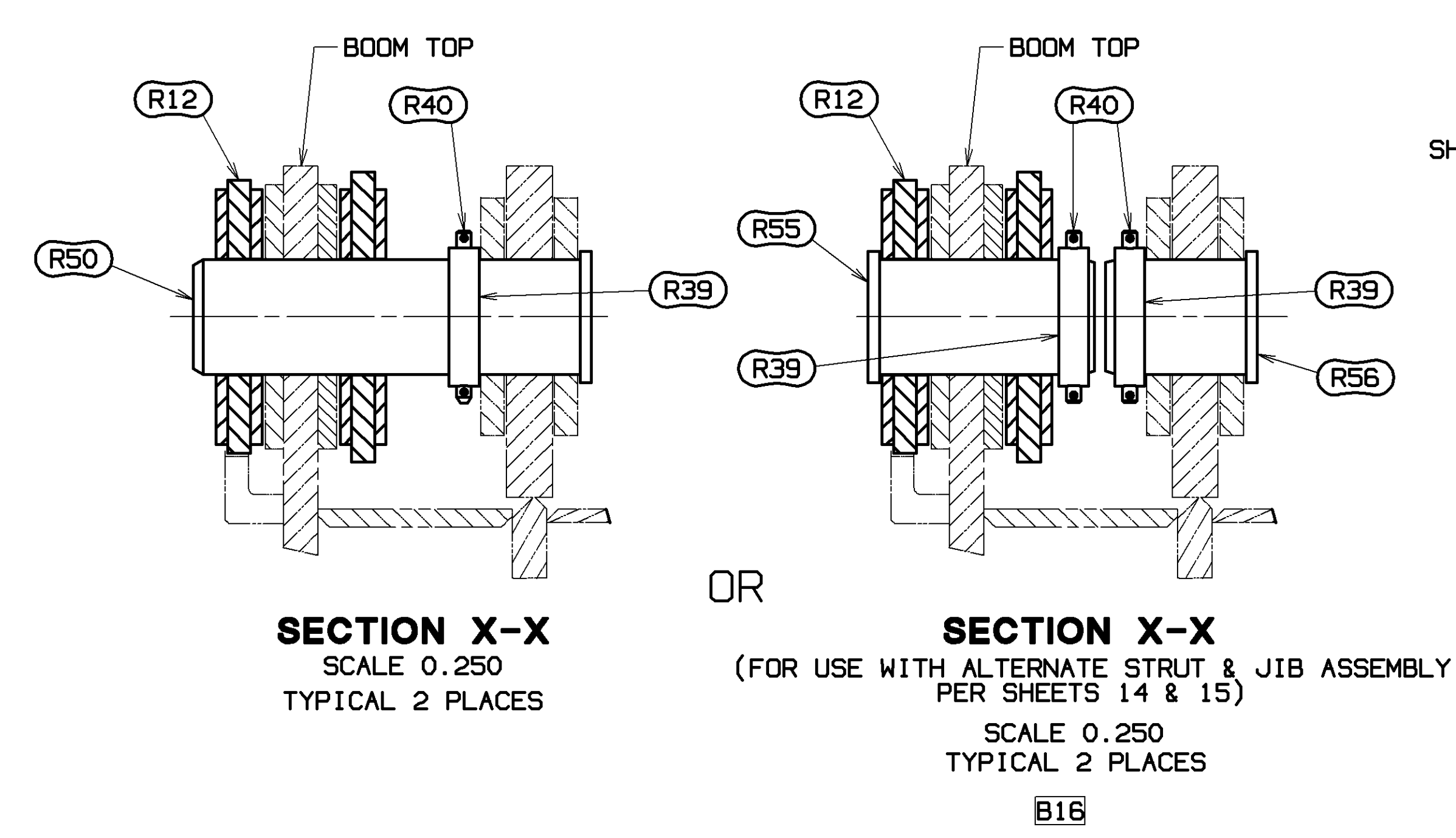
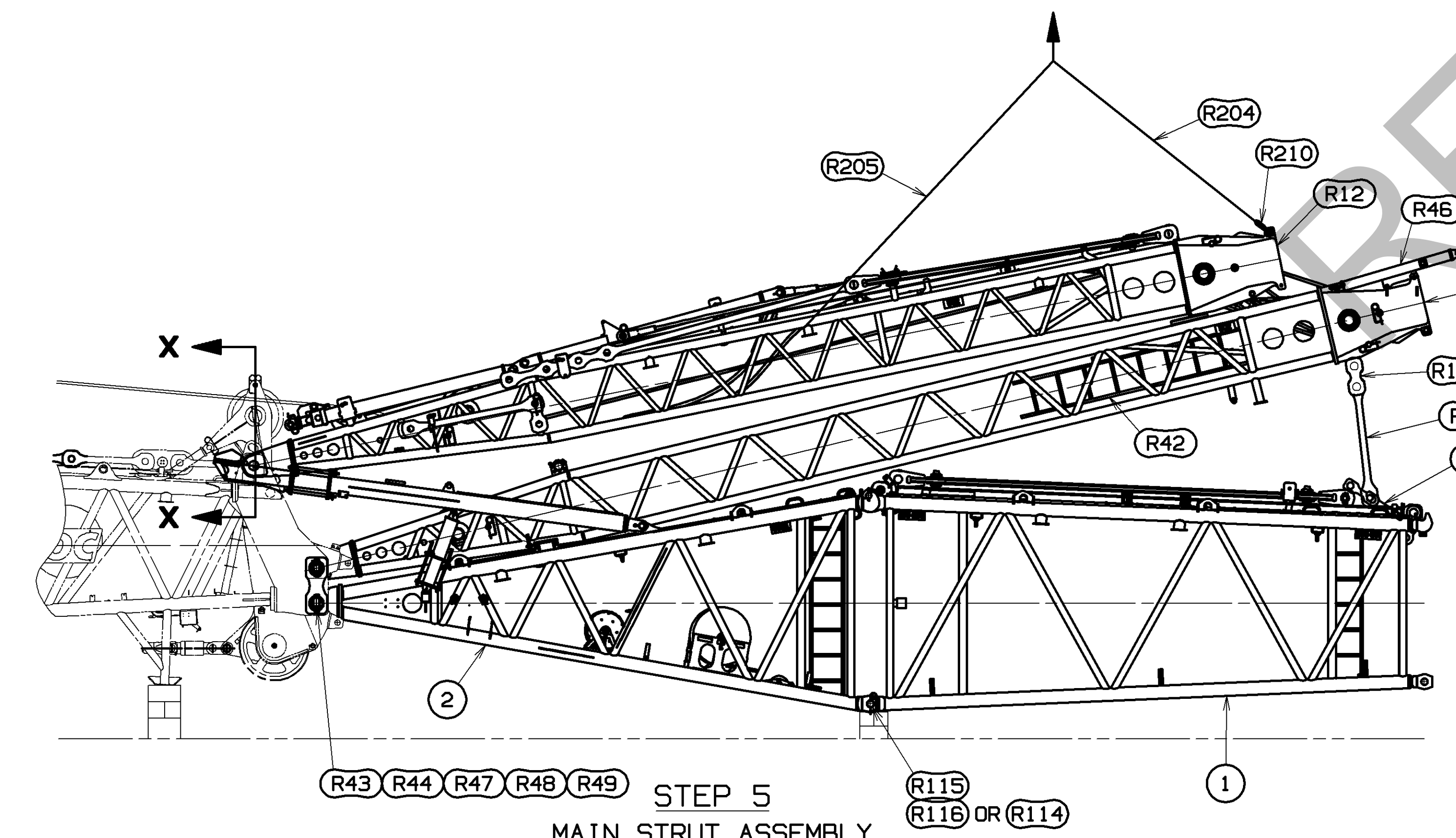
DETACH SHACKLE (R207) AND SUCKER LINE (R206) FROM STOWAGE LUG NEAR THE HINGE END OF THE MAIN STRUT (R12) AND ATTACH TO 28mm LUFFING HOIST LINE (DRUM 6). (SEE DETAIL V).

DETACH PIN (R208) AND SHACKLE (R207) FROM MAIN STRUT DEAD END AND SUCKER LINE (R206). STOW PIN AND SHACKLE IN PARTS BOX 81028769. PAY OUT RIGGING WINCH LINE (R202) OVER MAIN STRUT WINCH SHEAVE AND ATTACH TO THIS END OF SUCKER LINE (R206). (SEE DETAIL W1)

PAY IN RIGGING WINCH LINE (R202) TO PULL 28mm LUFFING HOIST LINE (DRUM 6) INTO REEVING OF MAIN AND JIB STRUT SHEAVES. DETACH RIGGING WINCH LINE (R202) FROM SUCKER LINE (R206) AND POSITION RIGGING WINCH LINE (R202) ON BOOM TOP FOR USE IN RAISING ARM HOOK-UP STEP 7 ON SHEET 9. DETACH SUCKER LINE (R206) AND SHACKLE (R207) FROM LUFFING HOIST LINE AND ATTACH LUFFING LINE TO DEAD END (R38) LOCATED IN THE MAIN STRUT (R12). (SEE DETAIL W2).

STORE SUCKER LINE (R206) AND SHACKLE (R207) IN PARTS BOX 81028769 WHEN NOT USED.

NOTE: THE LADDER (R42) STORED WITH THE JIB STRUT MAY BE USED TO PROVIDE ACCESS TO THE TOP OF THE MAIN STRUT DURING THE REEVING OPERATION. TO ACCESS THE MAIN STRUT, ATTACH THE HOOKS ON THE END OF THE LADDER TO THE SUPPORT BAR ON THE LEFT SIDE OF THE MAIN STRUT.



DISCONNECT THE SHIPPING LINKS LOCATED ON THE HINGE END OF THE JIB STRUT TO ALLOW THE MAIN STRUT (R12) TO LIFT FREE. (SEE DETAIL V). USING AN ASSIST CRANE WITH SLINGS (R204) & (R205) AND SHACKLE (R210) AS SHOWN LIFT THE MAIN STRUT (R12) SLIGHTLY FROM ITS SHIPPING POSITION UNTIL THE STRUT SUPPORTS (R46) CONNECTING THE STRUT HEADS ARE ABLE TO BE DISCONNECTED. REMOVE THE PIN FROM THE MAIN STRUT SIDE OF THE STRUT SUPPORTS AND ROTATE STRUT INTO HORIZONTAL OR STOWAGE POSITION ON JIB STRUT (R13). REATTACH STRUT (R46) WITH PIN PREVIOUSLY REMOVED FROM MAIN STRUT. (SEE DETAIL W2).

WITH THE MAIN STRUT (R12) FREE, PAY OUT LUFFING HOIST LINE (DRUM 6) AS THE MAIN STRUT (R12) IS LIFTED AND THE HINGE IS ATTACHED TO THE BOOM TOP. SECURE MAIN STRUT HINGE PIN (R50) WITH PROVIDED COLLARS (R39) AND PINS (R40). (SEE SECTION X-X).

LOWER THE MAIN STRUT UNTIL THE HEAD IS RESTING ON THE PLASTIC PAD ON THE JIB STRUT.

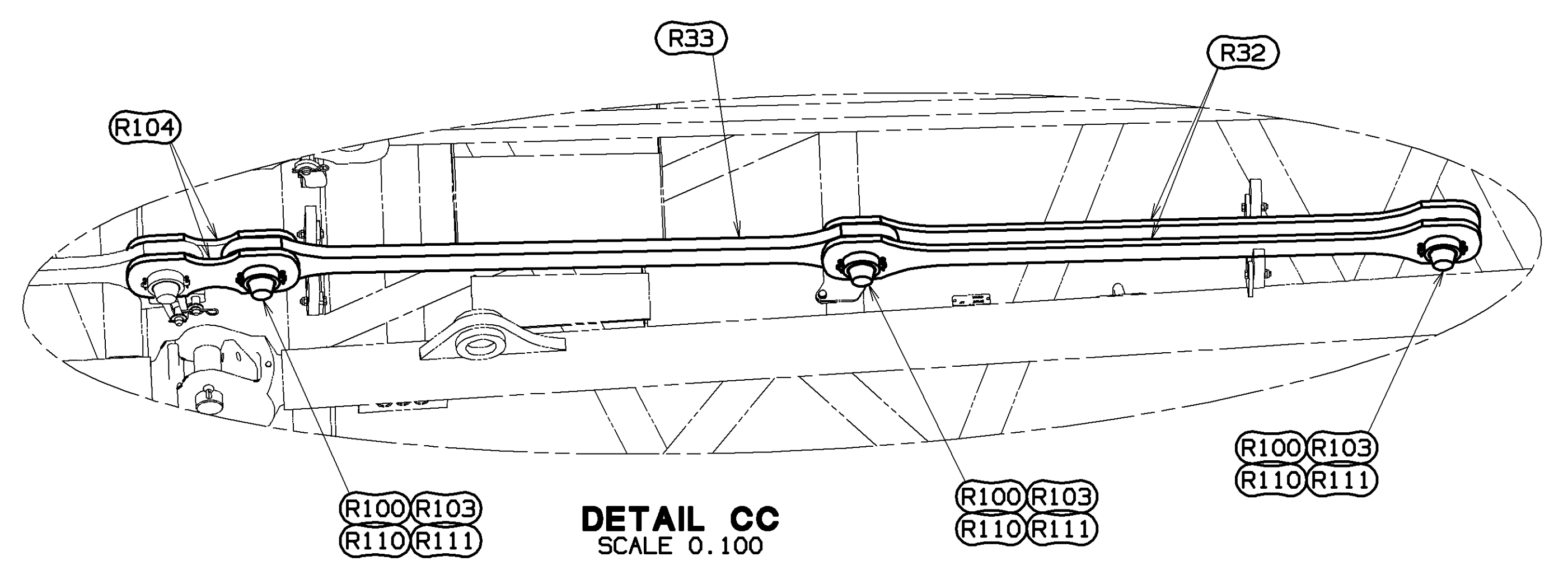
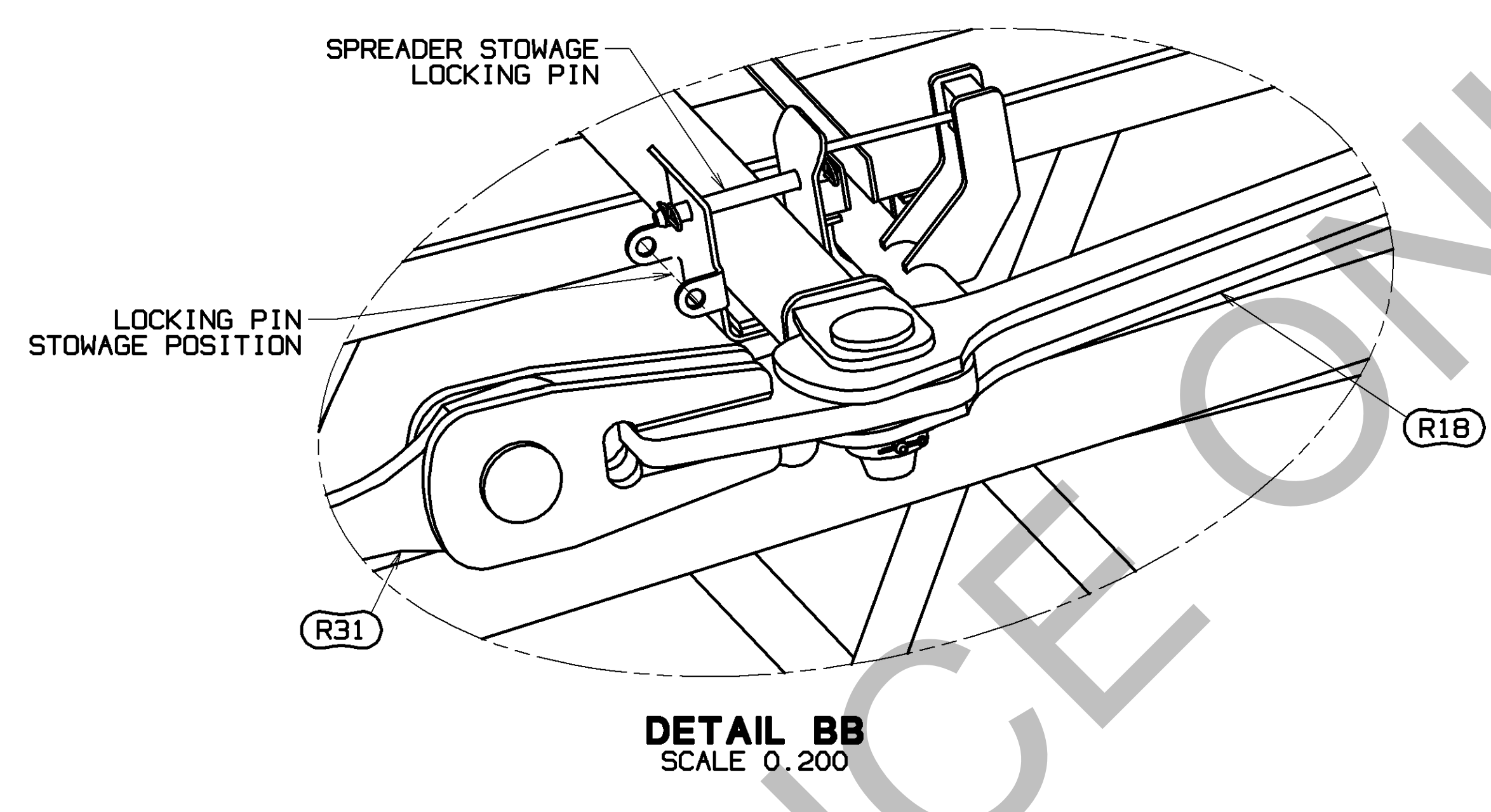
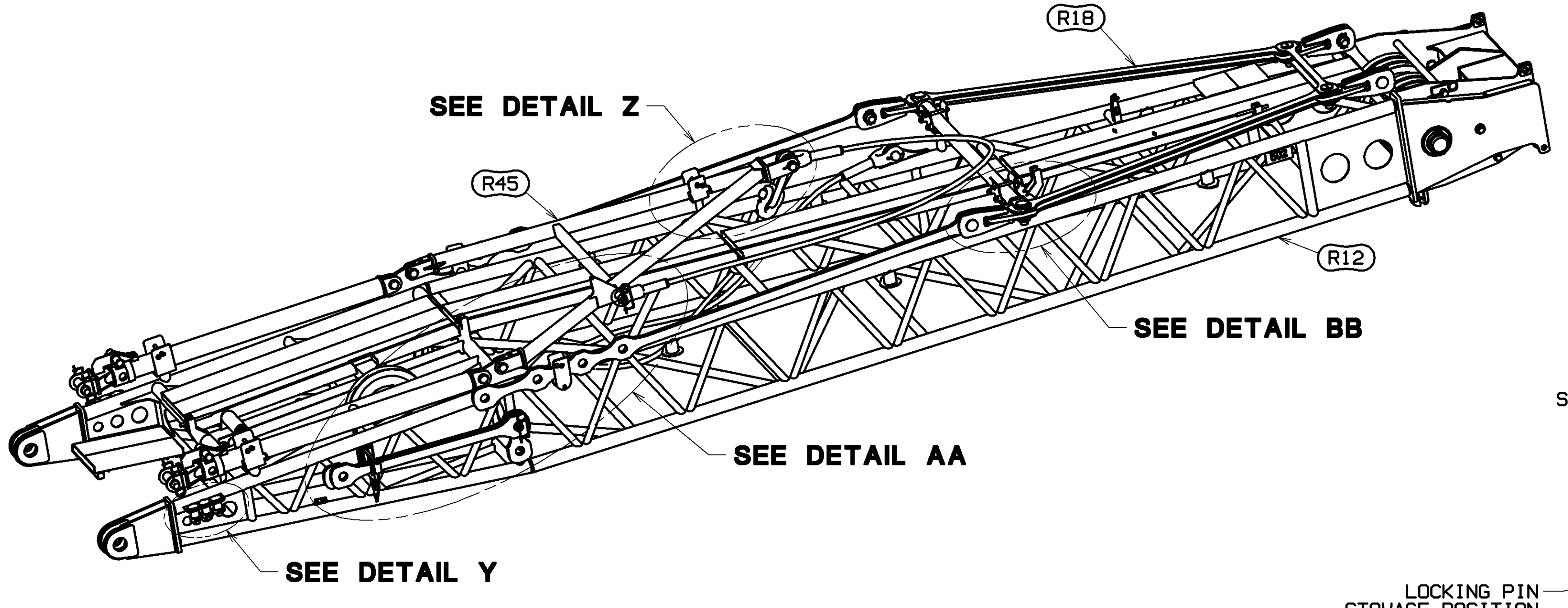
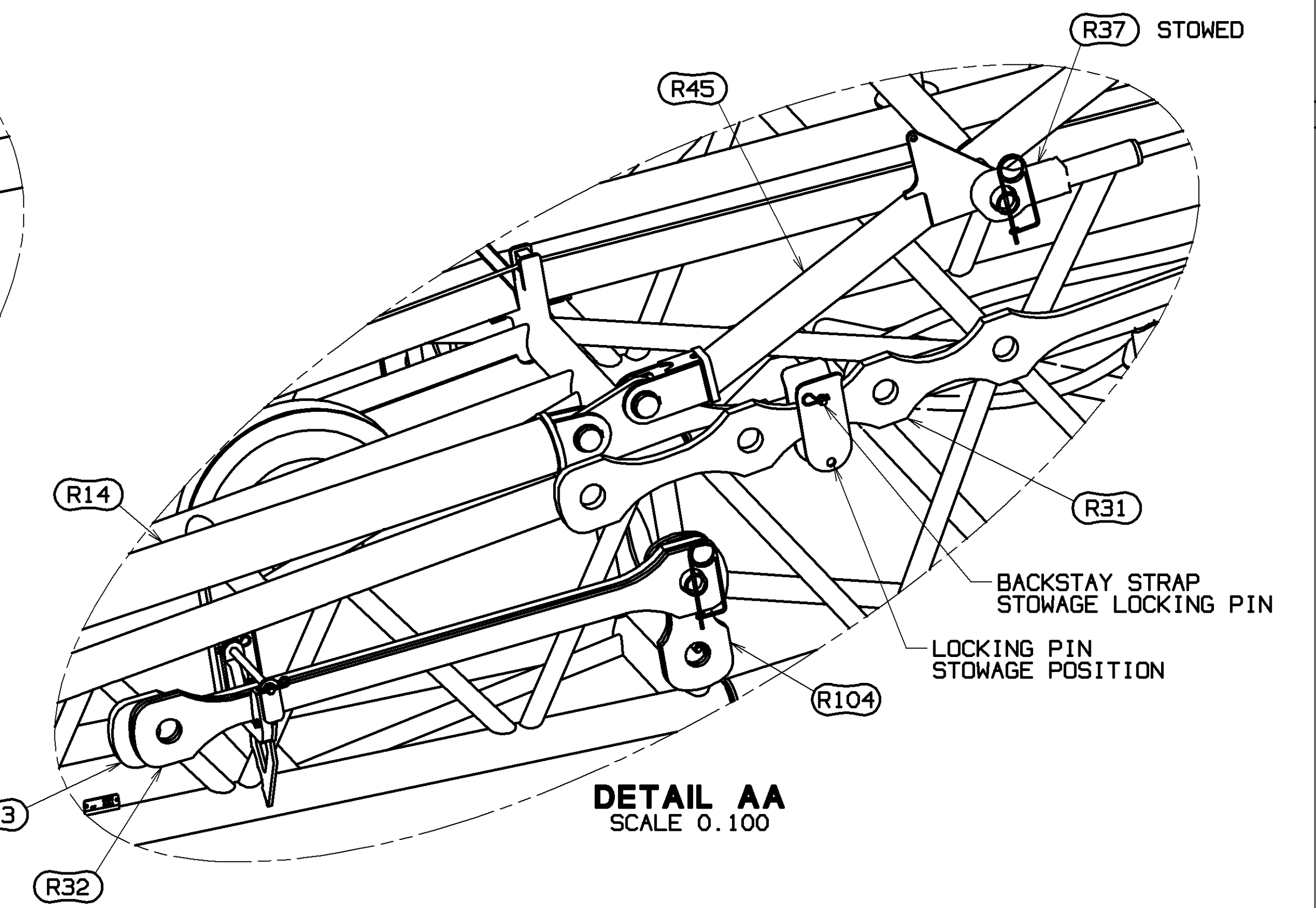
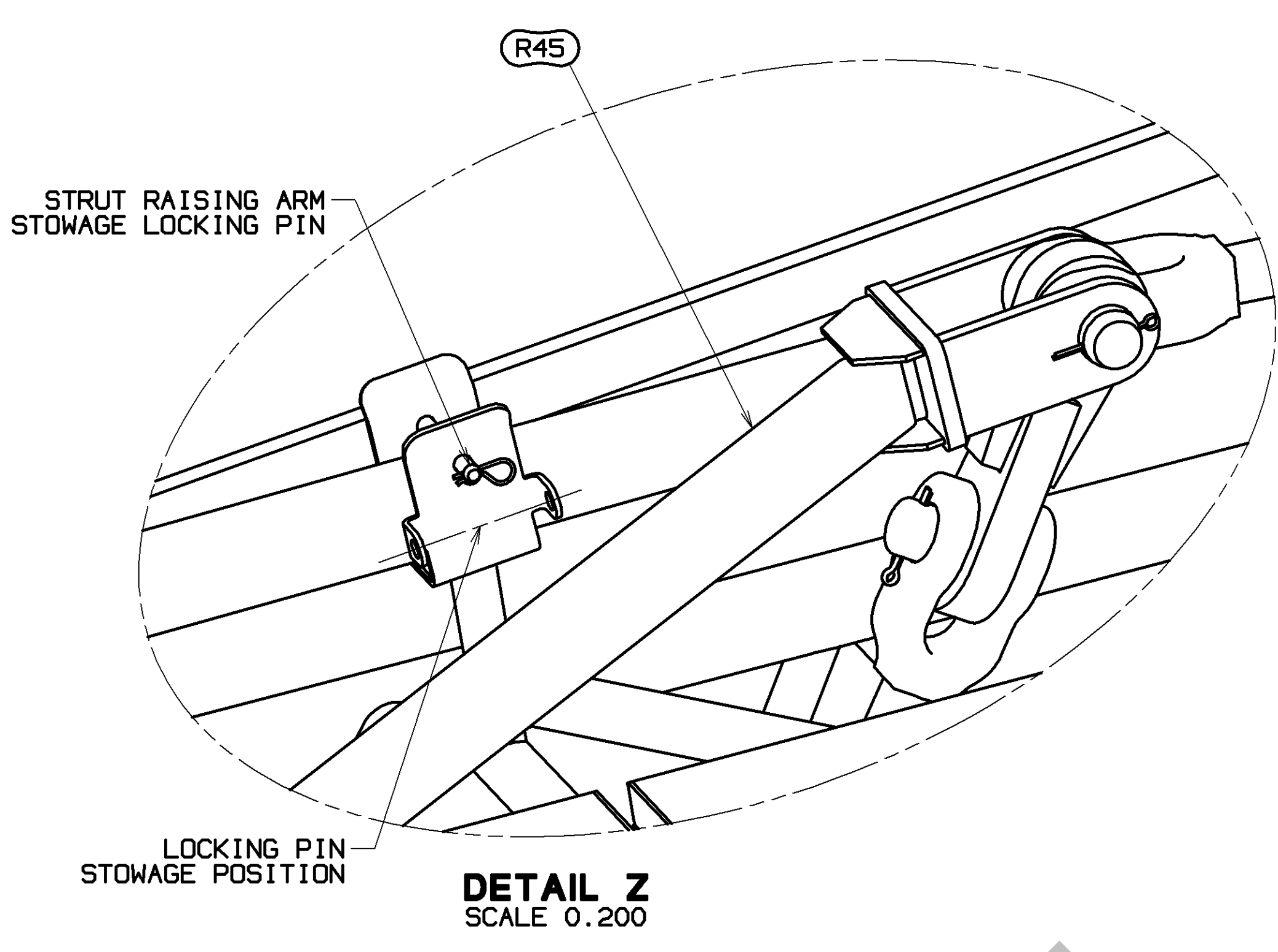
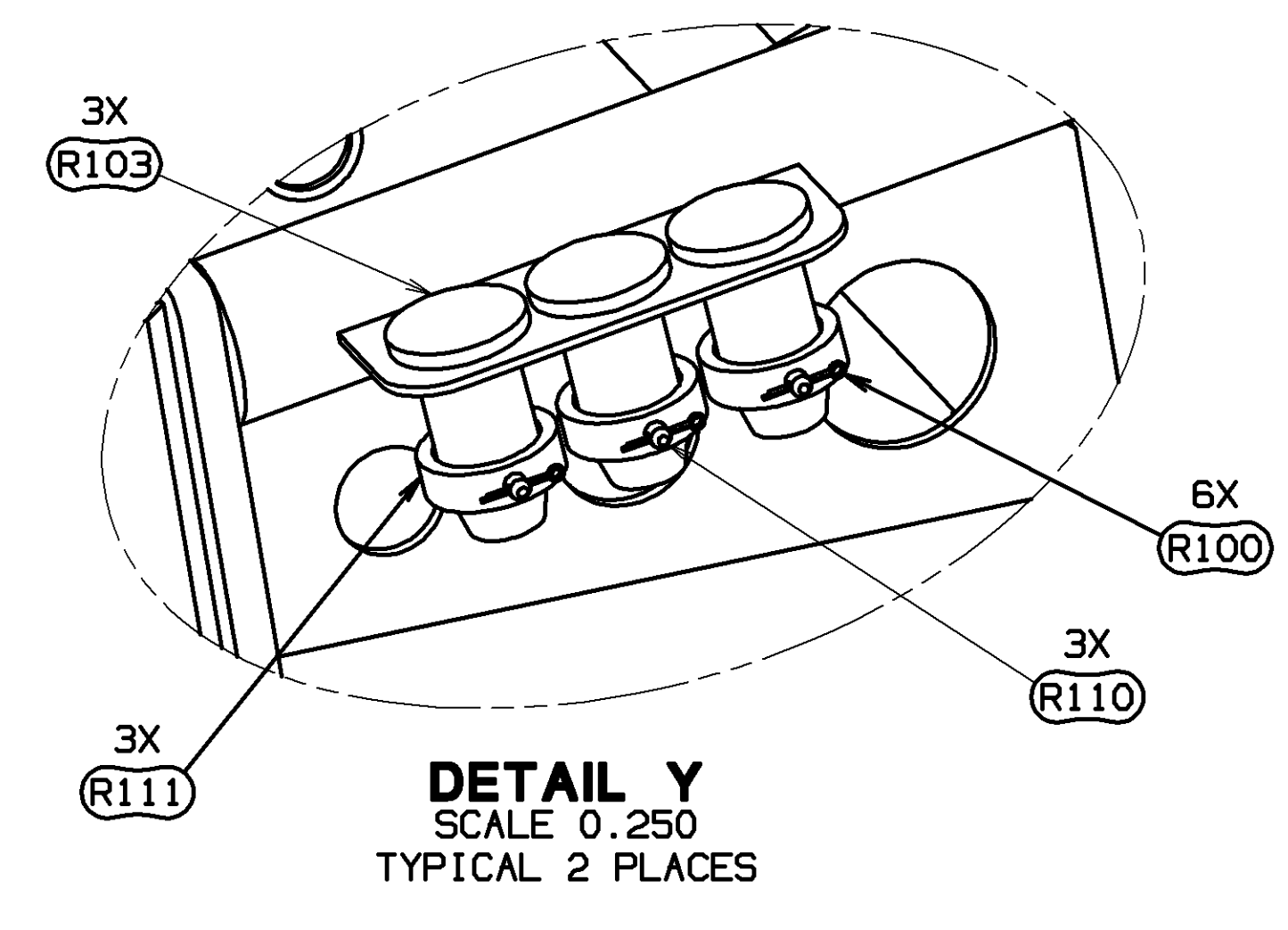
NOTE: THE LADDER (R42) STORED WITH THE JIB STRUT MAY BE USED TO PROVIDE ACCESS TO THE SUPPORT LINKS. TO ACCESS THE SUPPORT LINKS, ATTACH THE RUNG OF THE LADDER THAT WILL SUPPORT IT AT AN APPROPRIATE HEIGHT ON THE HOOKS LOCATED ON EITHER SIDE OF THE JIB STRUT HEAD.

81023384
SHT 8 OF 15

PRIVATE LABELING REQUIREMENT TO CONFORM TO ENGINEERING SPECIFICATION 8629103794 FOR COMPONENTS LISTED IN 81023384-05-026
DATE 07-14-16
REV. LNK (D)

DECIMAL PLACES	FRACTIONS	ANGLE	MANUFACTURING	DR. AUB	DATE	MANITOWOC CRANES, INC.	REV. LNK
1) PLACE 0.5	1/2	15, 30, 45, 60, 75, 90	AS SHOWN				
2) PLACE 0.00	1/16, 1/8, 3/16, 1/4, 3/8, 1/2, 5/8, 3/4						
3) PLACE 0.000	1/64, 1/32, 3/64, 1/16, 1/8, 3/16, 1/4, 3/8, 1/2, 5/8, 3/4						

BILL OF MATERIAL				ASSEMBLIES USED ON
QTY	DESCRIPTION	MATERIAL	QTY	NO.



STEP 6
PINS AND STRAP REMOVAL FROM MAIN STRUT (R12)

(REFER TO SHEETS 14 & 15 FOR ALTERNATE STRUT & JIB ASSEMBLY)

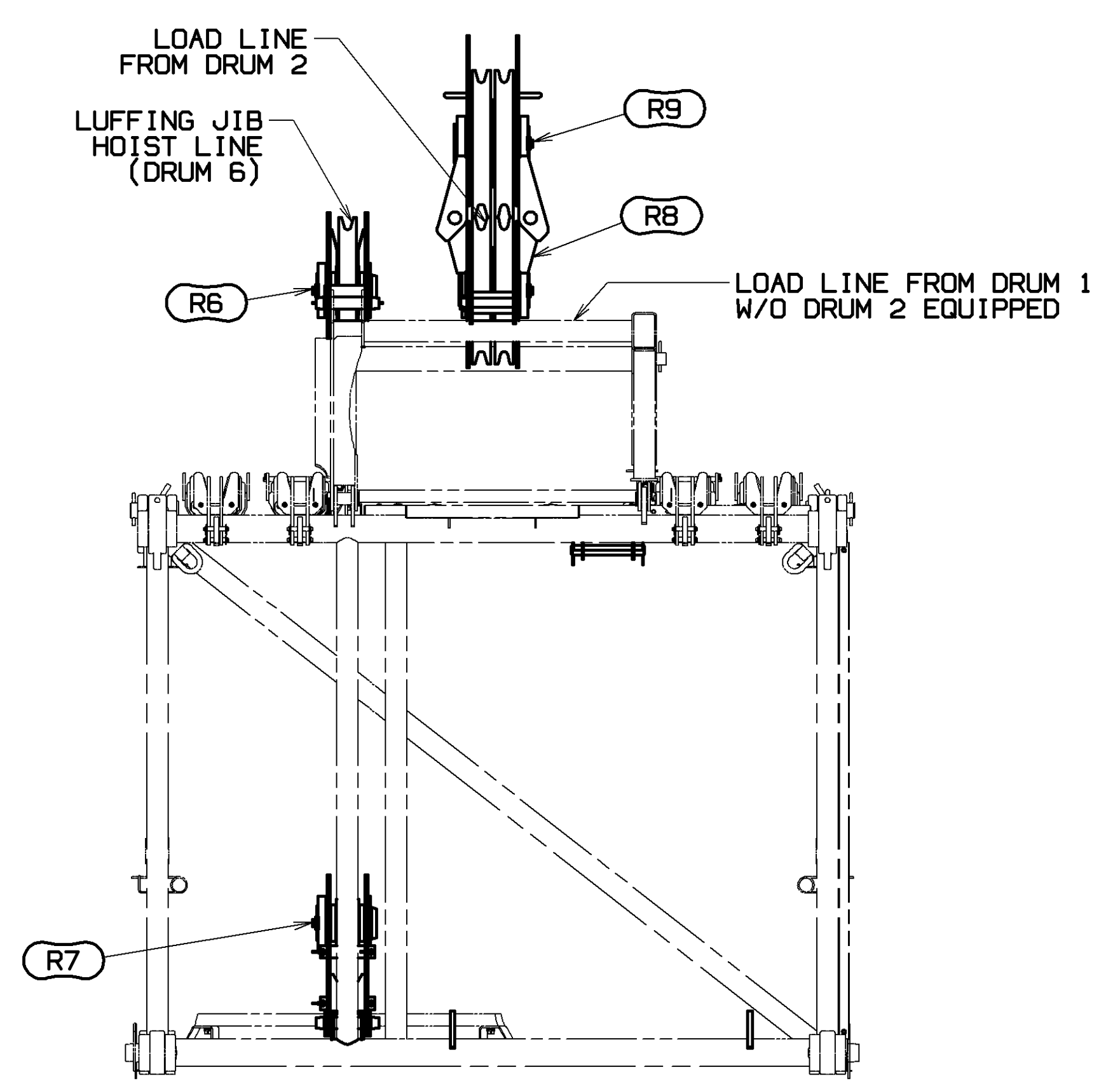
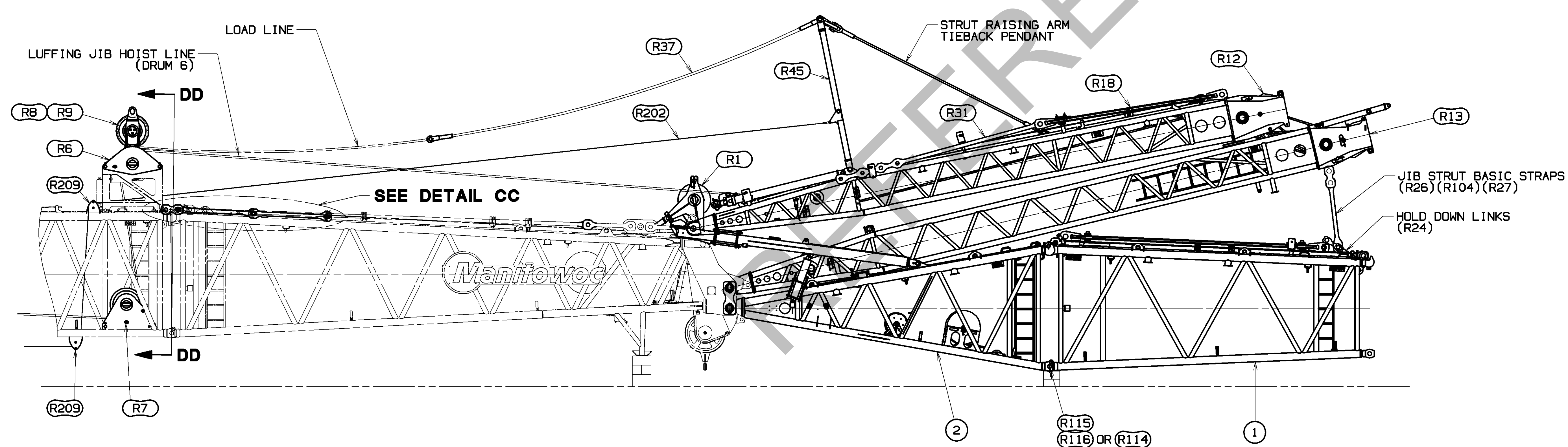
FROM THE TOP OF THE MAIN STRUT (R12) REMOVE THE PIN HOLDING THE STRUT RAISING ARM (R45) IN SHIPPING POSITION AND STOW PIN IN THE TABS ON THE SHIPPING BRACKET. (SEE DETAIL Z)

REMOVE PINS HOLDING MAIN STRUT BACKSTAY STRAPS (R31) AND SPREADER ASSY (R18) IN SHIPPING POSITION AND STOW PINS IN DESIGNATED STOWAGE LOCATIONS. (SEE DETAILS AA & BB)

REMOVE STRAPS (R33) AND LINKS (R32 & R104) FROM SHIPPING POSITION. (SEE DETAIL AA)

REMOVE STRAP PINS (R103), COLLARS (R111) AND PINS (R110) FROM SHIPPING POSITION. (SEE DETAIL Y)

POSITION STRAPS, LINKS, PINS AND COLLARS ON BOOM TOP (81027719) WITH LINKS (R104) ATTACHED TO PRECEDING INSERT STRAP. (SEE DETAIL CC)



STEP 7
RAISING ARM HOOK-UP

(REFER TO SHEETS 14 & 15 FOR ALTERNATE STRUT & JIB ASSEMBLY)

DETACH RAISING PENDANT (R37) FROM ITS SHIPPING LOCATION (SEE DETAIL AA) AND ATTACH THE FREE END OF THE PENDANT TO AN APPROPRIATE LOAD LINE. ATTACH RIGGING WINCH LINE (R202) TO MAIN STRUT RAISING ARM (R45).

NOTE: IF DRUM 2 IS EQUIPPED, DRUM 2 MUST BE USED FOR STRUT RAISING. DRUM 1 OR 3 CANNOT BE USED. THE LOAD LINE FROM DRUM 2 MUST BE CONTAINED BETWEEN THE TWO SHEAVES ON THE WIRE ROPE GUIDES (R8 & R9). IF USING LOAD LINE FROM DRUM 1 (WITHOUT DRUM 2 EQUIPPED), THE LOAD LINE MUST LAY ON THE TOP OF THE WIRE ROPE GUIDE FRAME AND THE UPPER AND LOWER SHEAVES (R8 & R9) MUST BE REMOVED FROM THE FRAME. SPECIAL CARE MUST BE TAKEN TO ENSURE THAT THE ROPE PROPERLY SPOOLS ON THE DRUM DURING THE FOLLOWING STEPS. (SEE SECTION DD-DD)

CAUTION: IF RIGGING WINCH IS NOT USED, MAIN STRUT RAISING ARM (R45) MAY RAISE SUDDENLY WHEN LOAD LINE IS RETRACTED CAUSING LOAD LINE AND DEAD END TO DROP ONTO BOOM TOP.

PAY IN RIGGING WINCH LINE (R202) RAISING THE MAIN STRUT RAISING ARM (R45) INTO WORKING POSITION. PAY IN THE LOAD LINE UNTIL THE STRUT RAISING ARM TIE BACK PENDANT IS TAUT. AT THIS POINT, THE RIGGING WINCH LINE MAY BE DISCONNECTED OR KEPT TAUT THROUGH RAISING PROCESS.

CONTINUE TO RETRACT THE LOAD LINE WHILE PAYING OUT THE LUFFING HOIST LINE (DRUM 6) TO RAISE THE MAIN STRUT (R12). DO NOT ALLOW THE JIB STRUT (R13) OR TRANSITION INSERT (ITEM 1) TO RAISE MORE THAN 300mm (12 inches) ABOVE GROUND OR BLOCKING. CONTROL HOIST SPEED BY WATCHING THE SLACK IN THE HOLD DOWN LINKS/JIB STRUT BASIC STRAP (R24)(R26)(R27)(R104).

<small>THIS DRAWING IS THE PROPERTY OF MANITOWOC CRANES, INC. ALL INFORMATION CONTAINED HEREIN IS CONFIDENTIAL. IT IS LOANED, SUBJECT TO RETURN UPON DEMAND, AND ON EXPRESS CONDITION THAT IT IS NOT TO BE COPIED OR USED DIRECTLY OR INDIRECTLY IN ANY MANNER UNLESS OTHERWISE SPECIFIED BY MANITOWOC CRANES, INC.</small>	<small>TOLERANCE UNLESS OTHERWISE SPECIFIED</small>		<small>SCALE 0.025</small> Manitowoc Cranes, Inc. <small>DR. AUB</small> <small>CK. RHY</small> <small>APP. DLG</small>	LUFFING JIB RIGGING LJ10:501 ON B60:500	
	<small>DECIMAL PLACES</small> 1) PLACE 0.5 ±0.12 2) PLACE 0.00 ±0.08 3) PLACE 0.000 ±0.008	<small>FABRICATION</small> ± 10 FEET ± 0.18 ± 12 FEET ± 0.15 ± 15 FEET ± 0.08			<small>MACHINING</small> ± 0.015 ± 0.008 ± 0.004
	<small>ANGLES</small> ± 1.0°	<small>WELDING</small> ± 0.008 ± 0.004			<small>DRUM</small> ± 0.008 ± 0.004

PRIVATE LABELING REQUIREMENT TO CONFORM TO ENGINEERING SPECIFICATION 8629103794 FOR COMPONENTS LISTED IN SECTION 09-026

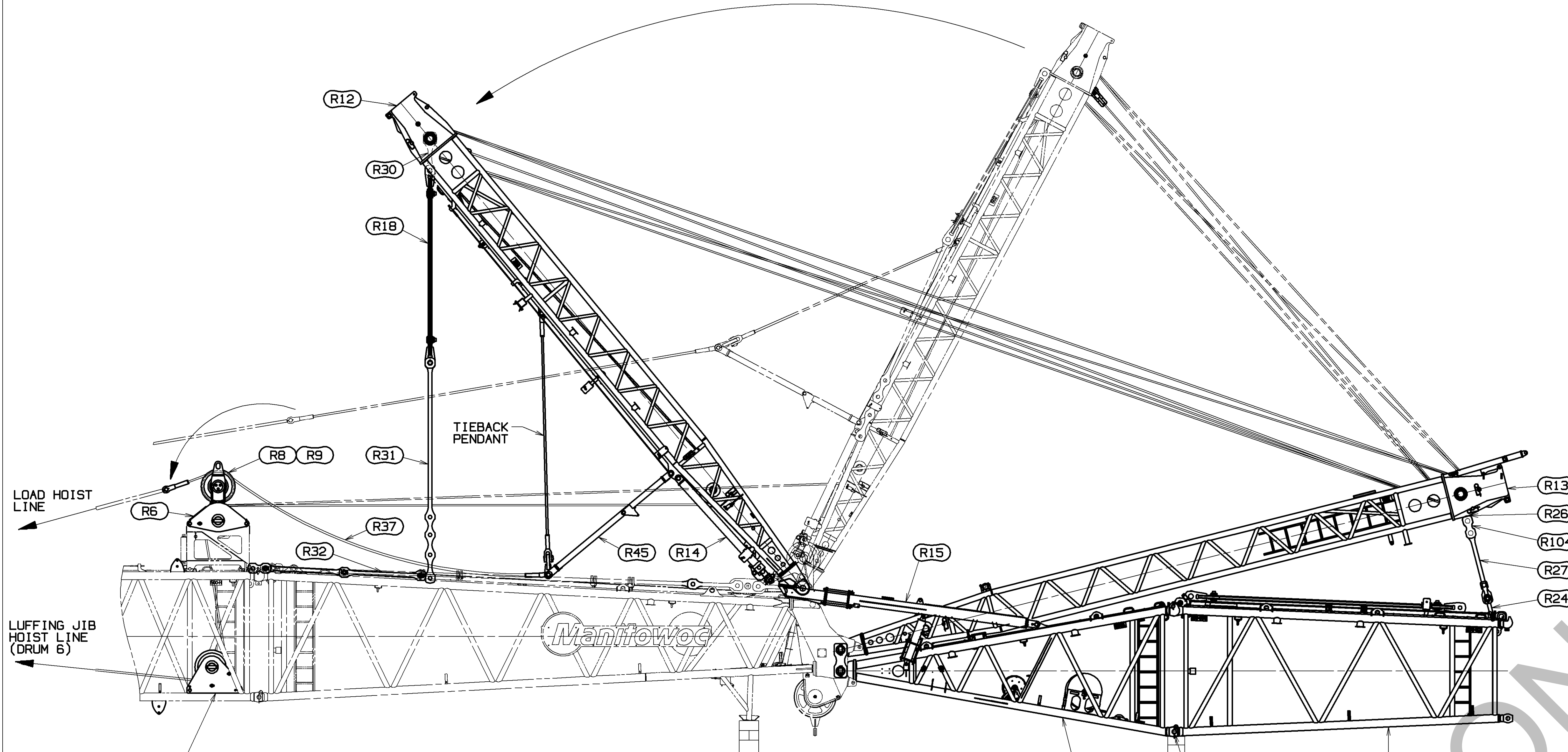
DATE 07-14-16

REV. LNK (D)

81023384

SHT 9 OF 15

BILL OF MATERIAL		ASSEMBLED USED ON
QTY	DESCRIPTION	MATERIAL



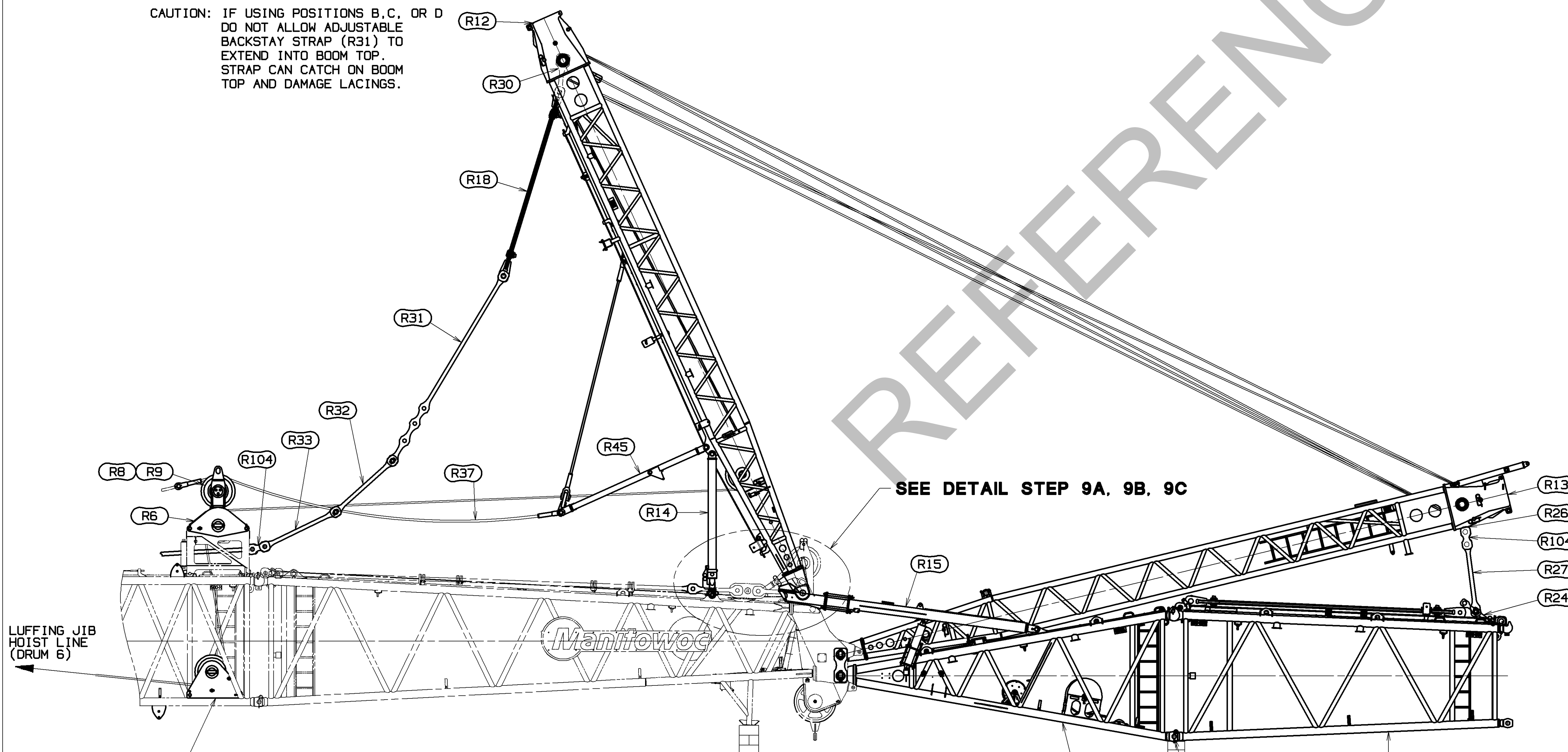
STEP 8
MAIN STRUT RAISING AND BACKSTAY CONNECTION
 (REFER TO SHEETS 14 & 15 FOR ALTERNATE STRUT & JIB ASSEMBLY)

CONTINUE TO PAY IN LOAD HOIST, RAISING THE MAIN STRUT (R12) OVER VERTICAL, ENSURING THAT THE LUFFING HOIST REEVING DOES NOT BECOME SLACK. WITH THE MAIN STRUT BEYOND VERTICAL, CONTROL OF ITS ANGLE WILL TRANSITION FROM THE LOAD LINE (ATTACHED TO THE RAISING PENDANT R37) TO THE LUFFING HOIST (DRUM 6).

AS THE MAIN STRUT (R12) CONTINUES BEYOND VERTICAL, THE BACKSTAY STRAPS (R30)(R31) AND SPREADER (R18) WILL BEGIN TO HANG VERTICALLY. RAISE THE MAIN STRUT UNTIL THE BACKSTAY STRAPS (R31) HANG IN POSITION OVER THE LUFFING JIB BACKSTAY STRAPS LOCATED ON THE MAIN BOOM.

ATTACH THE LINKS (R32) FROM THE MAIN BOOM TOP TO THE ADJUSTABLE BACKSTAY STRAP (R31). VERIFY HOLE LOCATION (A,B,C, OR D) PER BOOM LENGTH TABLE ON SHEET 2 AND DETAIL G ON SHEET 4.

CAUTION: IF USING POSITIONS B,C, OR D DO NOT ALLOW ADJUSTABLE BACKSTAY STRAP (R31) TO EXTEND INTO BOOM TOP. STRAP CAN CATCH ON BOOM TOP AND DAMAGE LACINGS.

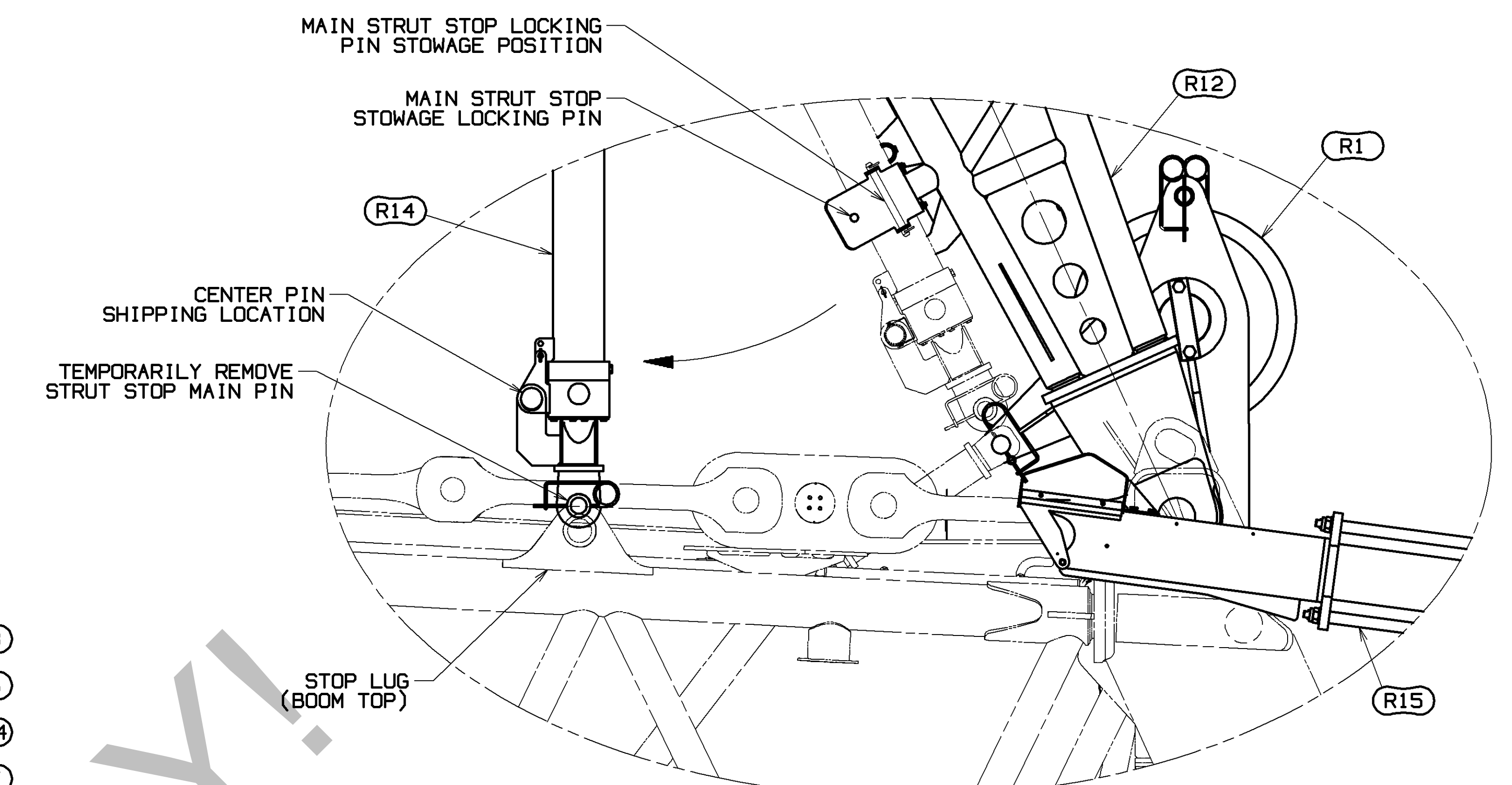


STEP 9
STRUT STOP CONNECTION
 (REFER TO SHEETS 14 & 15 FOR ALTERNATE STRUT & JIB ASSEMBLY)

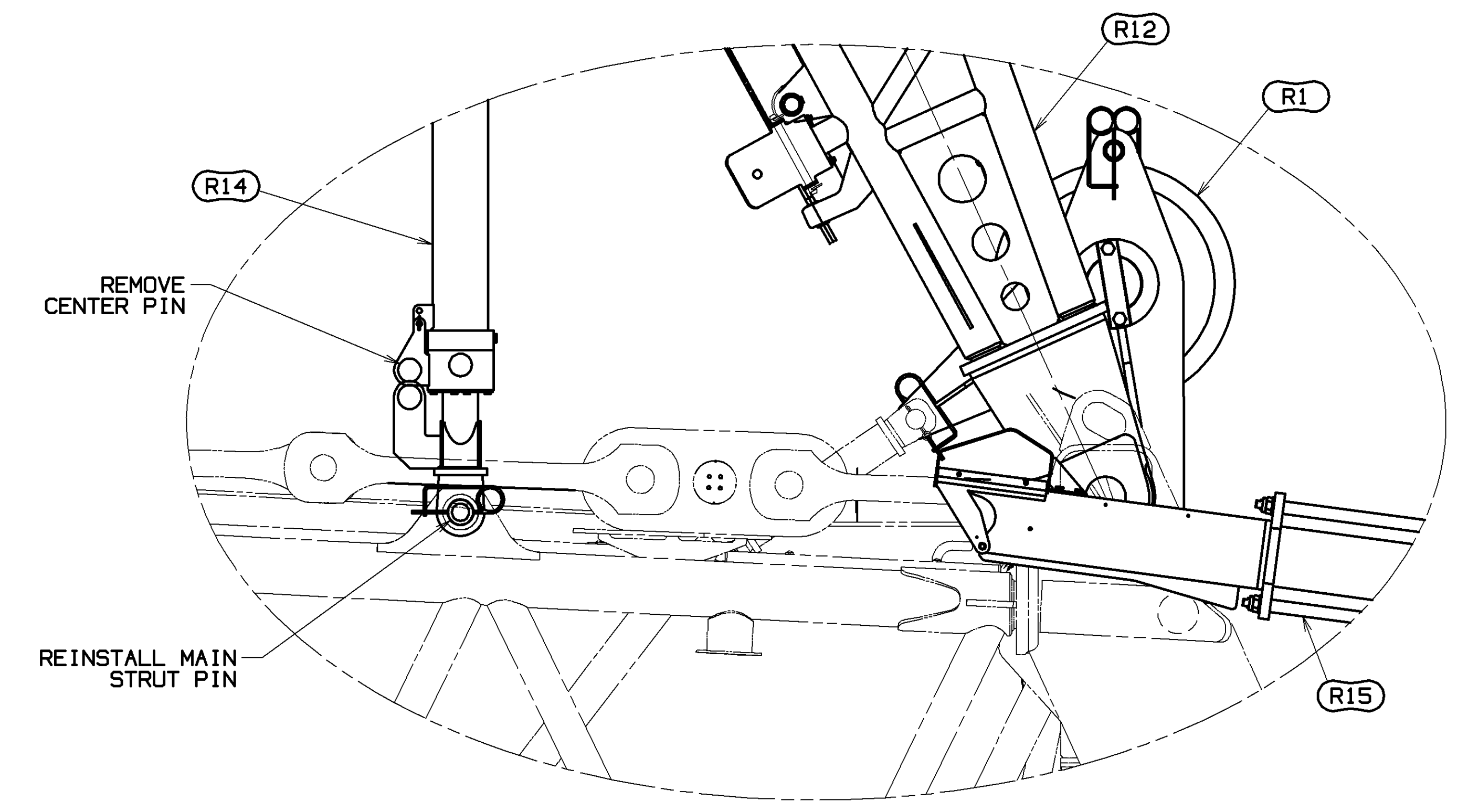
PAY IN THE LUFFING JIB HOIST LINE (DRUM 6) TO BRING THE MAIN STRUT (R12) BACK TOWARDS VERTICAL AND TO POSITION STRUT STOP (R14) OVER THE STOP LUG ON THE MAIN BOOM TOP. WITH MAIN STRUT STOP (R14) IN STOWED POSITION REMOVE STRUT STOP STORAGE LOCKING PINS, ALLOWING STOP TO HANG VERTICALLY ABOVE THE STOP LUGS. PLACE LOCKING PINS IN THE TABS ON THE BRACKET. TEMPORARILY REMOVE THE MAIN PIN FROM THE END OF THE MAIN STRUT STOP (R14). (SEE DETAIL STEP 9A)

REMOVE THE CENTER PIN FROM ITS SHIPPING LOCATION ON THE MAIN STRUT STOP AND ALLOW THE INNER MOST TUBE TO TELESCOPE OUTWARD UNTIL THE END OF THE STOP CAN BE CONNECTED TO THE STOP LUG USING THE PREVIOUSLY REMOVED MAIN PIN. (SEE DETAIL STEP 9B)

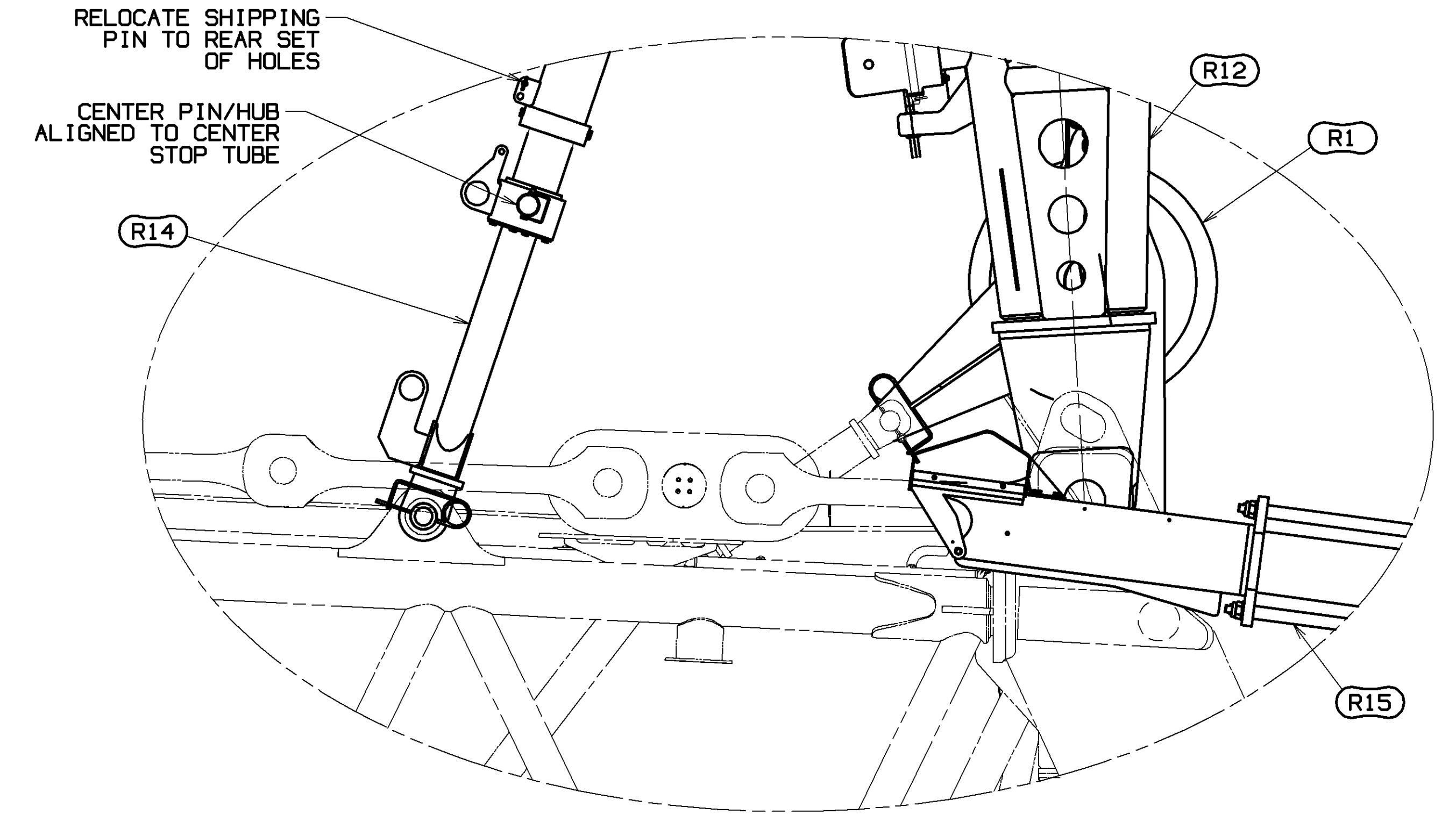
BEGIN RETRACTING THE LUFFING JIB HOIST LINE (DRUM 6) WHILE ALLOWING THE INNER MOST STOP TUBE TO TELESCOPE. WHEN THE CENTER HUB ON THE INNER MOST TUBE IS ALIGNED WITH THE EQUIVALENT HOLE ON THE MIDDLE STOP TUBE, USE THE CENTER PIN (REMOVED IN 'DETAIL STEP 9B') TO LOCK THE TUBES TOGETHER. REMOVE THE SHIPPING PIN CONNECTING THE MIDDLE TUBE TO THE OUTER MOST TUBE AND STORE PIN IN THE REAR MOST SET OF HOLES. (SEE DETAIL STEP 9C)



DETAIL STEP 9A
 SCALE 0.100



DETAIL STEP 9B
 SCALE 0.100



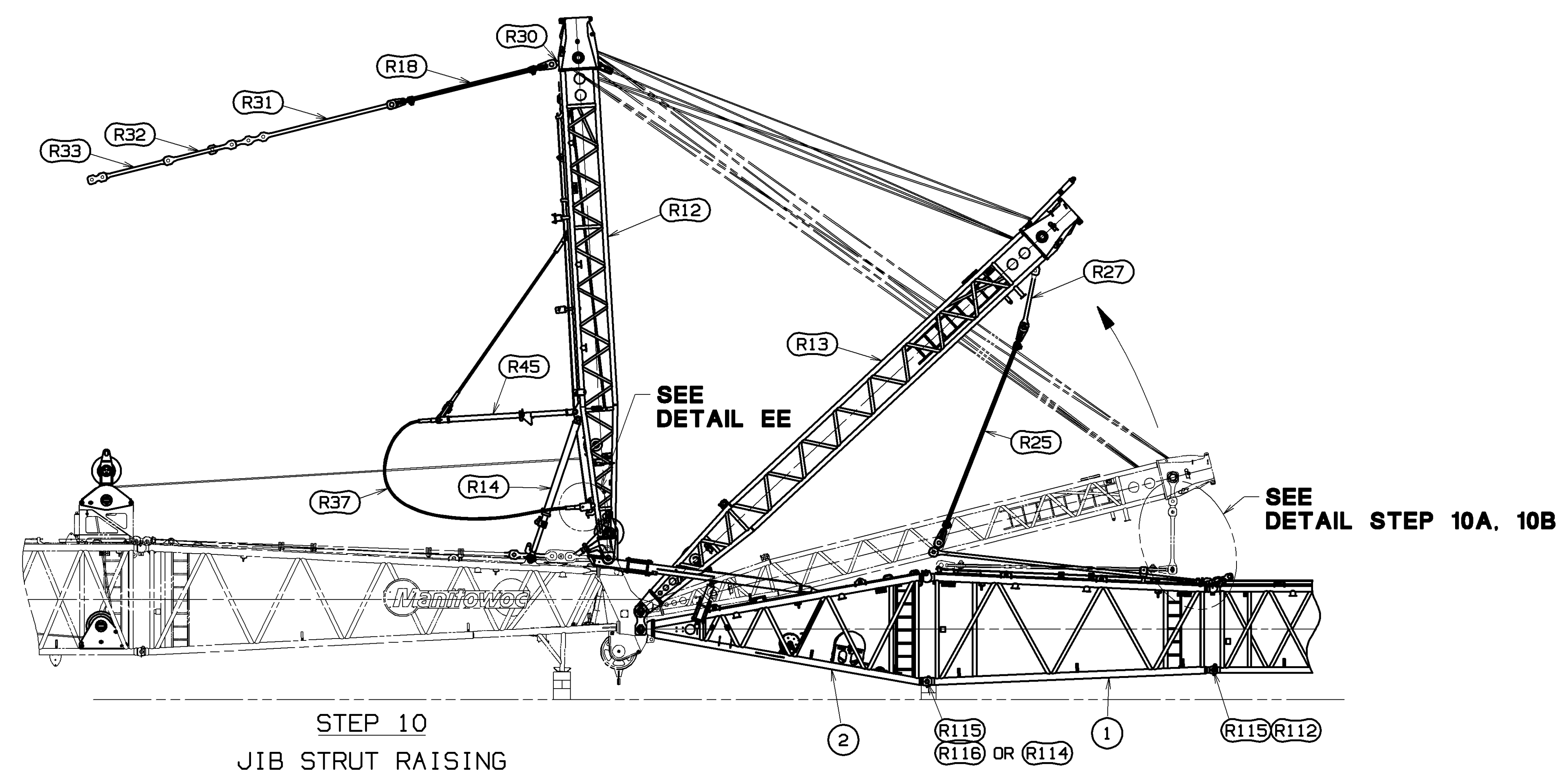
DETAIL STEP 9C
 SCALE 0.100

REFERENCE ONLY!

81023384
 SHT 10 OF 15

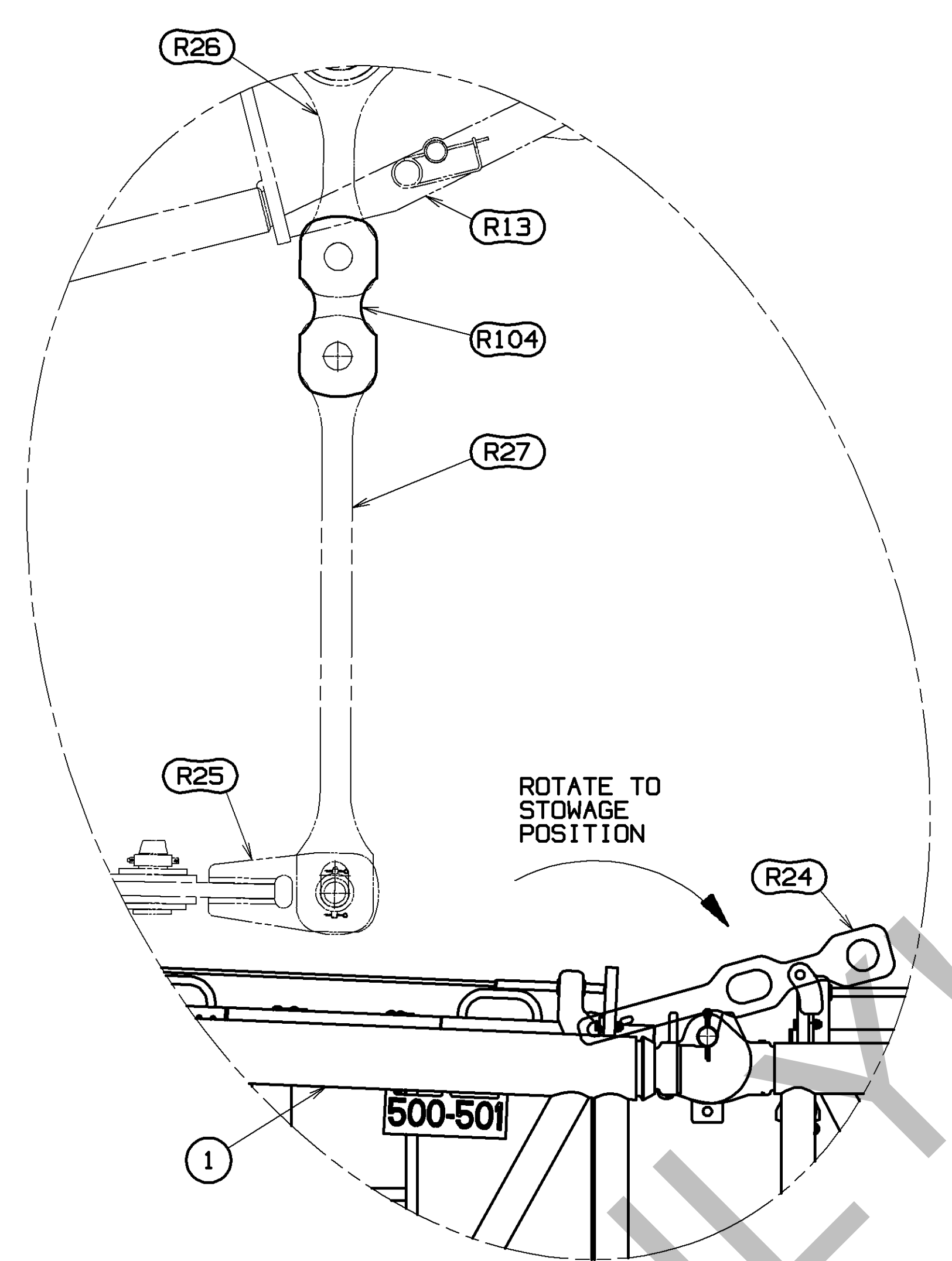
PRIVATE LABELING REQUIREMENT TO CONFORM TO ENGINEERING SPECIFICATION 8629103794 FOR COMPONENTS LISTED IN 06200-09-026
 DATE 07-14-16
 REV. LNK D

<small>THIS PRINT REMAINS THE PROPERTY OF MANITOWOC CRANES, INC. IF IT IS LOST, SUBJECT TO RETURN (BY OWNER) AND ON EXPRESS CONDITION THAT IT IS NOT TO BE COPIED OR USED DIRECTLY OR INDIRECTLY IN ANY MANNER DETRIMENTAL TO OUR INTERESTS.</small>	<small>TOLERANCE UNLESS OTHERWISE SPECIFIED</small>		<small>SCALE</small> 1:0.25 Manitowoc Cranes, Inc. Manitowoc, Wisconsin MODEL MLC300 APP DLG	LUFFING JIB RIGGING LJ10:501 ON B60:500
	<small>DECIMAL PLACES</small> (1) PLACE 0.5 ±.12 ±.18 ±.03 (2) PLACE 0.00 ±.06 ±.12 ±.015 (3) PLACE 0.000 ±.006 ±.008 ±.001	<small>FABRICATION</small> ±.10 FEET ±.10 FEET ±.05 <small>MACHINING</small> ±.015 ±.015 ±.015 ±.005 ±.005 ±.005		

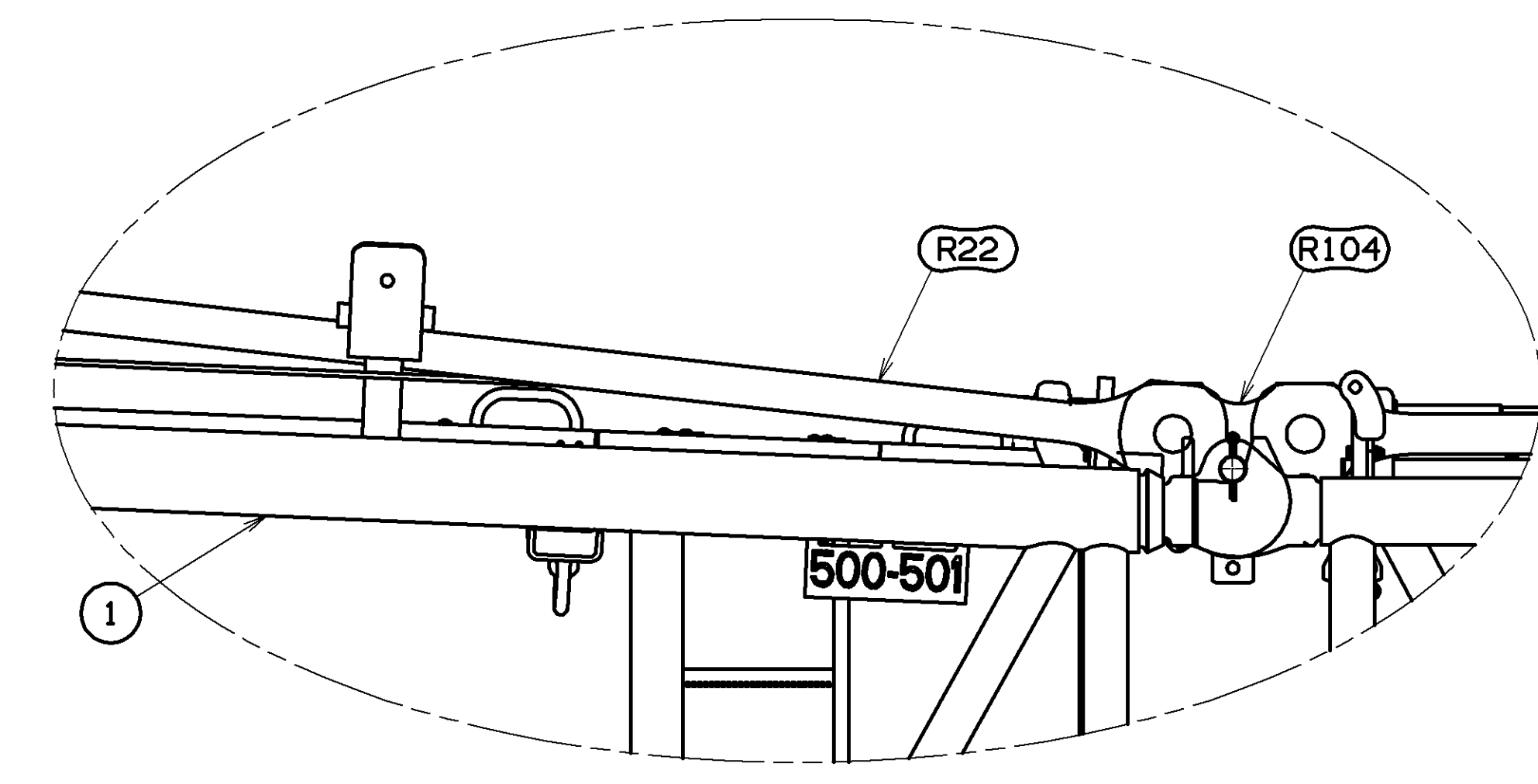


STEP 10
 JIB STRUT RAISING

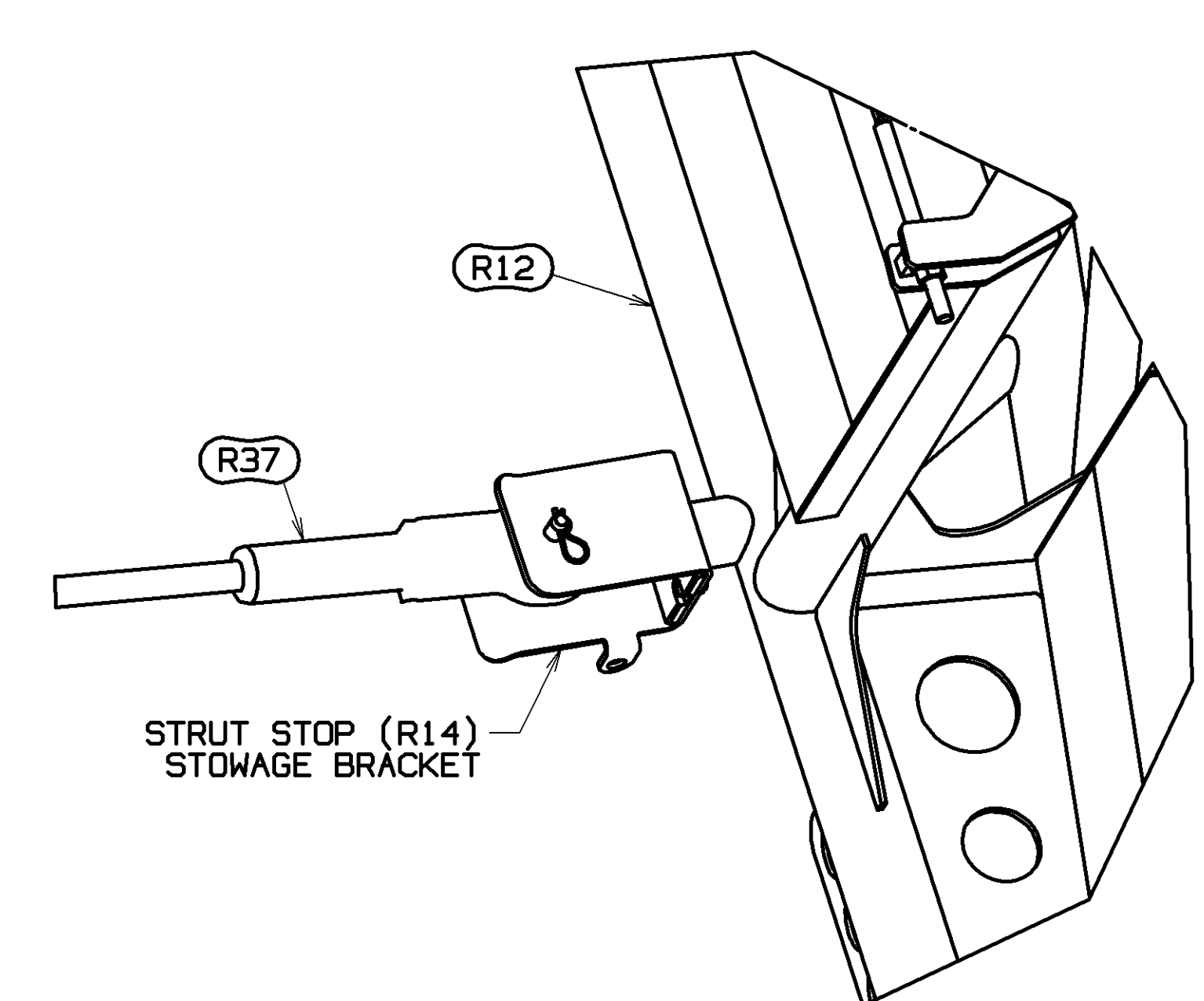
(REFER TO SHEETS 14 & 15 FOR ALTERNATE STRUT & JIB ASSEMBLY)
 PAYOUT THE LUFFING JIB HOIST LINE (DRUM 6) UNTIL THE MAIN STRUT (R12) RESTS ON THE MAIN STRUT STOPS (R14). DETACH THE LOAD LINE FROM THE STRUT RAISING PENDANT (R37) AND ATTACH END OF STRUT RAISING PENDANT TO STRUT STOP STORAGE BRACKET. (SEE DETAIL EE).
 COMPLETE THE ASSEMBLY OF DESIRED JIB CONFIGURATION TO JIB BUTT (ITEM 2) AND TRANSITION INSERT (ITEM 1). INSTALL LOWER JIB CONNECTOR PINS. (SEE DETAIL LL ON SHEET 6). ASSEMBLE STRAP/LINK CONNECTIONS BEGINNING AT JIB TOP. DETACH THE HOLD BACK LINKS (R24) CONNECTING THE JIB STRUT BASIC STRAPS (R27)(R104)(R26) TO THE TRANSITION INSERT (ITEM 1). ATTACH THE BASIC STRAP (R27) TO THE FRONTSTAY SPREADER (R25). (SEE DETAIL STEP 10A).
 ASSEMBLE STRAP/LINK CONNECTION (R22 & R104) AT TRANSITION INSERT (ITEM 1) AND #501 INSERT. (SEE DETAIL STEP 10B).
 RETRACT THE LUFFING JIB HOIST LINE (DRUM 6) TO RAISE THE JIB STRUT (R13) FROM ITS ASSEMBLY POSITION.
 THE LUFFING JIB IS READY FOR RAISING AND OPERATION.



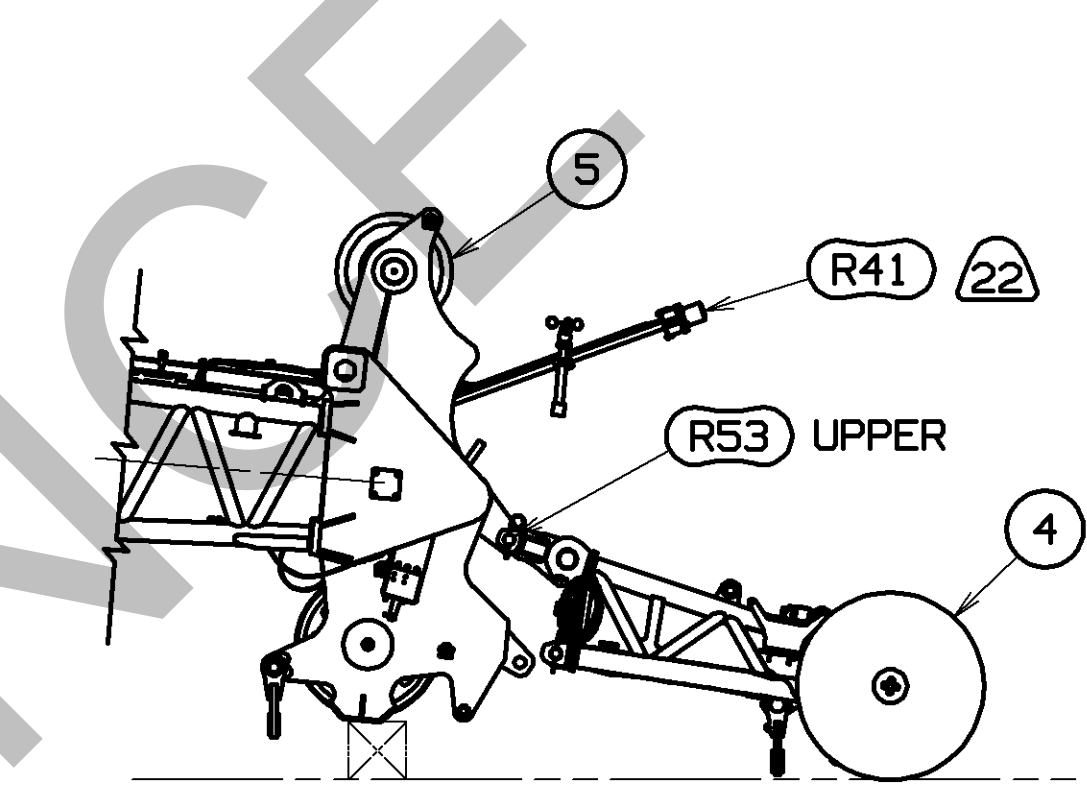
DETAIL STEP 10A
 SCALE 0.100



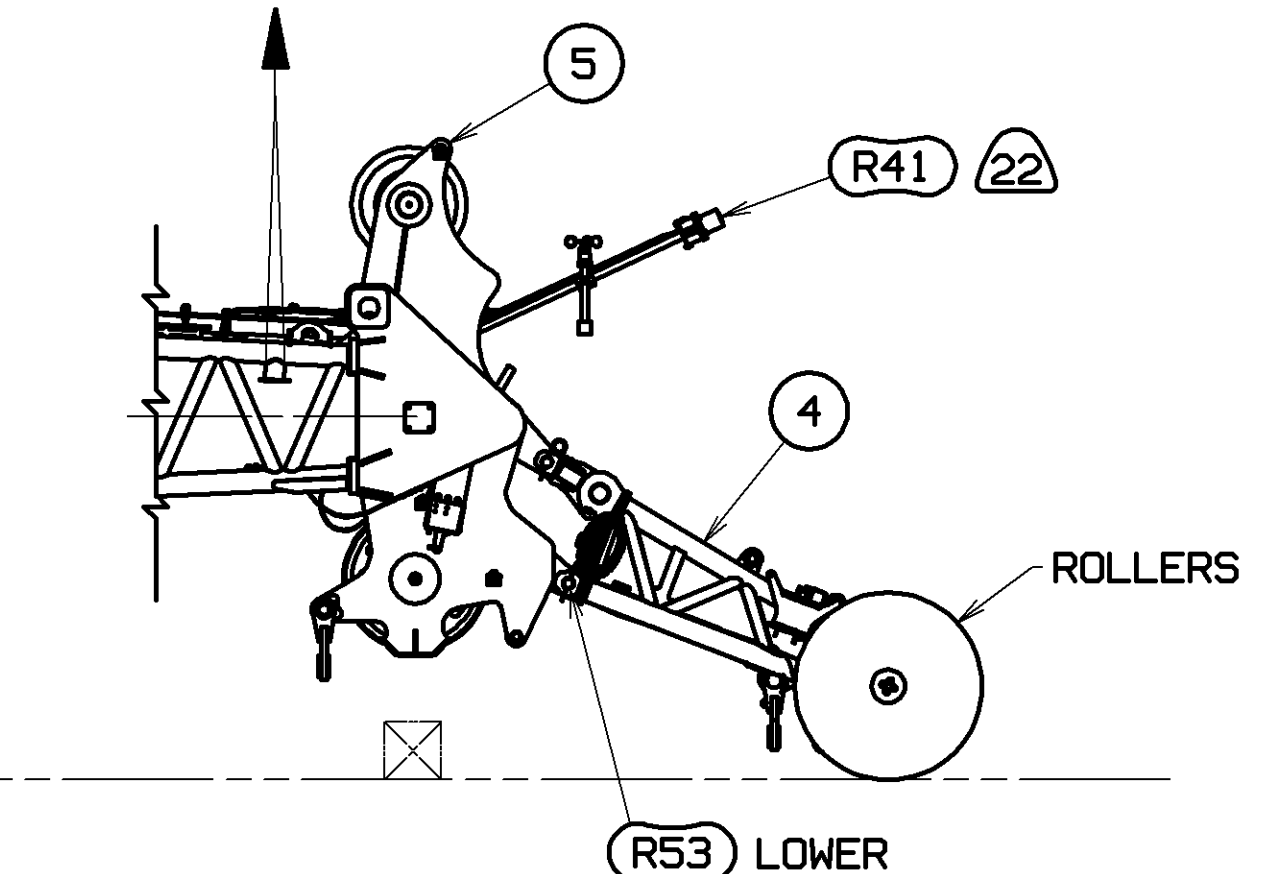
DETAIL STEP 10B
 SCALE 0.100



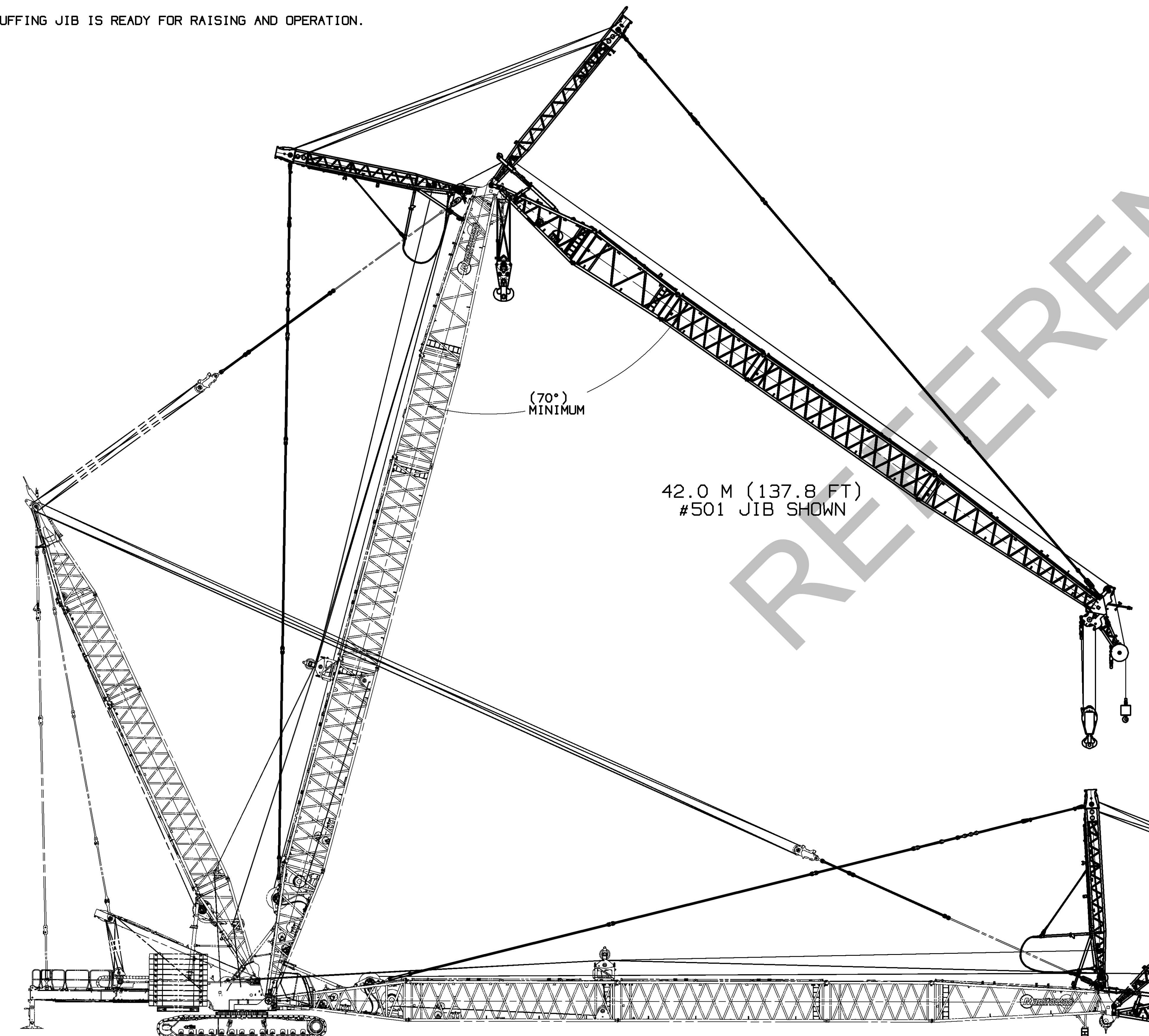
DETAIL EE
 SCALE 0.150



DETAIL PP
 UPPER BOOM POINT INSTALLATION
 SCALE 0.025



ALIGN UPPER BOOM POINT (ITEM 4) UPPER HOLES WITH HOLES IN THE JIB TOP (ITEM 5) AND INSTALL (2) PINS (R53) AND SAFETY PINS (2) PINS (R53) AND SAFETY PINS.
 USING ASSIST CRANE ATTACH SLINGS TO JIB TOP LIFTING LUGS AND LIFT JIB TOP TO ALIGN THE LOWER HOLES IN THE UPPER BOOM POINT (ITEM 4) WITH THE HOLES IN THE JIB TOP (ITEM 5). INSTALL (2) PINS (R53) AND SAFETY PINS. LOWER JIB TOP TO ALLOW ROLLERS TO CONTACT GROUND. REMOVE SLINGS.



48.0 M (157.5 FT)
 #500 BOOM SHOWN
 SCALE 0.008

TO RAISE BOOM AND JIB

CONSULT LUFFING JIB RAISING PROCEDURE 9502-A TO DETERMINE WHEN LOWER POINTS NEED TO BE REMOVED. WHEN BOOM AND JIB ARE READY TO BE ERECTED, CHECK THAT JIB STOP LATCH AND LOCK OPERATE FREELY. JIB STOP OPERATES BASED ON JIB ANGLE ABOVE HORIZONTAL AND REQUIRES NO FURTHER OPERATOR INTERACTION.

BOOM UP WHILE LUFFING JIB POINT WHEELS ROLL ON GROUND. WHEN REQUIRED BOOM TO JIB ANGLE FOR THE LENGTHS ARE REACHED, REMOVE EXCESS JIB PENDANT SLACK.

NOTE: DO NOT UNDER ANY CONDITION ALLOW BOOM TO LUFFING JIB ANGLE TO BECOME LESS THAN 70°.

RAISE BOOM AND LUFFING JIB SIMULTANEOUSLY WITH ONLY BOOM HOIST UNTIL BOOM REACHES ANGLE LISTED IN THE LUFFING JIB RAISING PROCEDURE 9502-A.

TO LOWER BOOM AND JIB

POSITION BOOM AT 83° PRIOR TO LOWERING LUFFING JIB. LOWER LUFFING JIB UNTIL BOOM TO LUFFING JIB ANGLE REACHES VALUE SPECIFIED IN LUFFING JIB RAISING PROCEDURE 9502-A. LOWER BOOM UNTIL LUFFING JIB POINT ROLLERS CONTACT GROUND. CONTINUE TO LOWER BOOM WHILE LUFFING JIB ROLLERS ROLL ALONG GROUND.

NOTE: DO NOT UNDER ANY CONDITION ALLOW BOOM TO LUFFING JIB ANGLE TO BECOME LESS THAN 70°.

DURING BOOM AND JIB LOWERING, BOOM STOPS MUST LOCK AND RIDE OVER TOP OF JIB STOP TUBES. (SEE DETAIL M ON SHEET 7).

SEE DETAIL PP

TOLERANCE UNLESS OTHERWISE SPECIFIED		FINISHING		MATERIAL	
DECIMAL PLACES	FRACTIONS	WELDING	WELDING	WELDING	WELDING
(1) PLACE 0.5	±.12	±.18	±.03	±.03	±.03
(2) PLACE 0.00	±.08	±.12	±.015	±.015	±.015
(3) PLACE 0.000	±.008	±.012	±.008	±.008	±.008
ANGLES	±.30°	±.30°	±.30°	±.30°	±.30°

DISASSEMBLY PROCEDURE 1

JIB STRUT TIE OFF

(REVERSE OF STEP 10 ON SHEET 11)
 LUFF DOWN TO DETACH STRAP/LINK CONNECTION AT TRANSITION INSERT (ITEM 1) AND #501 INSERT. (SEE DETAIL STEP 10B ON SHEET 11).

DETACH BASIC STRAP (R27) FROM FRONTSTAY SPREADER (R25).
 ATTACH HOLD BACK LINKS (R24) TO BASIC STRAP (R27). (SEE DETAIL STEP 10A ON SHEET 11).

DETACH #501 JIB INSERTS FROM TRANSITION INSERT (ITEM 1).
 ATTACH STRUT RAISING PENDANT (R37) TO LOAD LINE.

DISASSEMBLY PROCEDURE 2

STRUT STOP DISCONNECT

(REVERSE OF STEP 9 ON SHEET 10)
 PAY OUT LUFFING JIB HOIST LINE (DRUM 6) TO ALLOW LOCKING OF MAIN STRUT STOP TUBES (R14). (SEE DETAIL STEPS 9C AND 9B ON SHEET 10).

WITH MAIN STRUT STOP (R14) RETRACTED TEMPORARILY REMOVE THE MAIN PIN FROM THE END OF THE MAIN STRUT STOP AND STOW STRUT STOP TO MAIN STRUT (R12).
 RETURN MAIN PIN TO END OF MAIN STRUT STOP (R14). (SEE DETAIL STEP 9A ON SHEET 10).

DISASSEMBLY PROCEDURE 3

BACKSTAY DISCONNECT AND MAIN STRUT LOWERING

(REVERSE OF STEP 8 ON SHEET 10 AND STEP 7 ON SHEET 9)
 PAY OUT LUFFING HOIST TO POSITION SPREADER (R18) AND MAIN STRUT BACKSTAY STRAPS (R31) VERTICALLY. WITH LINKS (R32) HORIZONTALLY SUPPORTED ON BOOM TOP STRAP BRACKETS. DISCONNECT ADJUSTABLE BACKSTAY STRAP (R31) FROM LINKS (R32). (SEE DETAIL CC ON SHEET 9).

CAUTION: IF USING POSITIONS B.C. OR D DO NOT ALLOW ADJUSTABLE BACKSTAY STRAP (R31) TO EXTEND INTO BOOM TOP. STRAP CAN CATCH ON BOOM TOP AND DAMAGE LACINGS.

ATTACH RIGGING WINCH LINE (R202) TO THE MAIN STRUT RAISING ARM (R45).
 CAUTION: IF RIGGING WINCH IS NOT USED MAIN STRUT RAISING ARM (R45) MAY COLLAPSE SUDDENLY WHEN LOAD LINE IS PAYED OUT CAUSING LOAD LINE AND DEAD END TO DROP ONTO BOOM TOP.

PAY IN LUFFING HOIST TO BRING MAIN STRUT TOWARD VERTICAL. [CONTROL OF ITS ANGLE WILL TRANSITION FROM THE LUFFING HOIST LINE TO THE LOAD LINE ATTACHED TO THE RAISING PENDANT (R37)].
 CONTINUE TO PAY OUT LOAD LINE WHILE PAYING IN LUFFING HOIST LINE (DRUM 6), ENSURING THAT THE LUFFING HOIST REEVING DOES NOT BECOME SLACK. LOWER THE MAIN STRUT UNTIL THE HEAD IS RESTING ON THE PLASTIC PAD ON THE JIB STRUT.

NOTE: DO NOT ALLOW THE JIB STRUT (R13) OR TRANSITION INSERT (ITEM 1) TO RAISE MORE THAN 300mm (12 INCHES) ABOVE GROUND OR BLOCKING.

CONTROL HOIST SPEED BY WATCHING THE SLACK IN THE HOLD DOWN LINKS/JIB STRUT BASIC STRAPS (R24)(R27)(R104)(R26).

WITH RIGGING WINCH LINE (R202) CONTROLLING MAIN STRUT RAISING ARM (R45). DETACH LOAD LINE FROM STRUT RAISING PENDANT (R37) AND STOW FREE END OF PENDANT (R37) ON RAISING ARM (R45). (SEE DETAIL AA ON SHEET 9).

PAY OUT RIGGING WINCH LINE (R202) LOWERING THE MAIN STRUT RAISING ARM (R45) INTO STOWAGE POSITION. ENGAGE LOCKING PINS TO SECURE RAISING ARM (R45). (SEE DETAIL Z ON SHEET 9).
 DETACH RIGGING WINCH LINE (R202) FROM MAIN STRUT RAISING ARM (R45).

DISASSEMBLY PROCEDURE 4

BACKSTAY STRAP STOWAGE ON MAIN STRUT

RELOCATE STRAPS/LINKS (R32)(R33)(R104) AND PINS/COLLARS (R100)(R103)(R110)(R111) FROM BOOM TOP (SEE DETAIL CC ON SHEET 9) TO STOWED POSITION ON MAIN STRUT (R12). (SEE DETAIL Y AND DETAIL AA ON SHEET 9).

ENGAGE LOCKING PINS TO SECURE BACKSTAY STRAPS (R31) AND SPREADER ASSY (R18) IN SHIPPING POSITION. (SEE DETAIL BB ON SHEET 9).

DISASSEMBLY PROCEDURE 5

MAIN STRUT DISASSEMBLY

(REVERSE OF STEP 5 ON SHEET 8)

USING AN ASSIST CRANE TO SUPPORT THE MAIN STRUT (R12). DETACH THE MAIN STRUT HINGE FROM THE BOOM TOP. HINGE PINS (R40) AND COLLARS (R39) ARE TO REMAIN WITH BOOM TOP. (SEE SECTION X-X ON SHEET 8).
 CONTINUE TO SUPPORT MAIN STRUT UNTIL STRUT SUPPORTS (R46) BETWEEN THE STRUTS CAN BE CONNECTED. (SEE DETAIL W2 ON SHEET 8).

LOWER MAIN STRUT ONTO JIB STRUT AND ATTACH SHIPPING LINKS LOCATED ON THE HINGE END. (SEE DETAIL V ON SHEET 8).

DISASSEMBLY PROCEDURE 6

STRUT SUCKER LINE REEVING

(REVERSE OF STEP 4 ON SHEET 8)

DETACH LUFFING HOIST LINE (DRUM 6) FROM MAIN STRUT (R12) DEAD END (R38). (SEE DETAIL W2 ON SHEET 8).
 ATTACH SUCKER LINE (R206) AND SHACKLE (R207) TO UNATTACHED END OF LUFFING HOIST LINE. (SEE DETAIL V ON SHEET 8 FOR ROPE CONNECTION).
 PAY IN HOIST LINE BRINGING SUCKER LINE INTO REEVING.
 DETACH HOIST LINE AND SECURE BOTH ENDS OF SUCKER LINE (R206) PER DETAIL V AND W1 ON SHEET 8.

DISASSEMBLY PROCEDURE 7

JIB STRUT DISASSEMBLY

(REVERSE OF STEP 2 ON SHEET 7)

USING AN ASSIST CRANE TO SUPPORT THE MAIN STRUT (R12) AND JIB STRUT (R13).
 DETACH BASIC STRAP (R27) FROM SHIPPING/HOLD DOWN LINKS.
 POSITION JIB STRUT BASIC STRAPS (R27)(R104)(R26) TO SHIPPING BRACKET AND ENGAGE LOCKING PIN.
 REPIN SHIPPING/HOLD DOWN LINK (R24) TO SPREADER (R25) LOCATED ON TRANSITION INSERT (ITEM 1). (SEE DETAIL T ON SHEET 7).

DETACH JIB STRUT (R13) FROM JIB STRUT HINGE ON BOOM TOP. HINGE PINS (R47), COLLARS (R43) AND RETAINING HARDWARE TO BE REASSEMBLED INTO JIB STRUT HINGE FOR SHIPPING. (SEE DETAIL R AND SECTION S-S ON SHEET 7).

TRAILER STRUT #502 SHIPPING ASSY (ITEM 6).

DISASSEMBLY PROCEDURE 8

JIB DISASSEMBLY

(REVERSE OF STEP 1 ON SHEET 7)

USING AN ASSIST CRANE DETACH TRANSITION INSERT (ITEM 1) FROM JIB BUTT (ITEM 2).

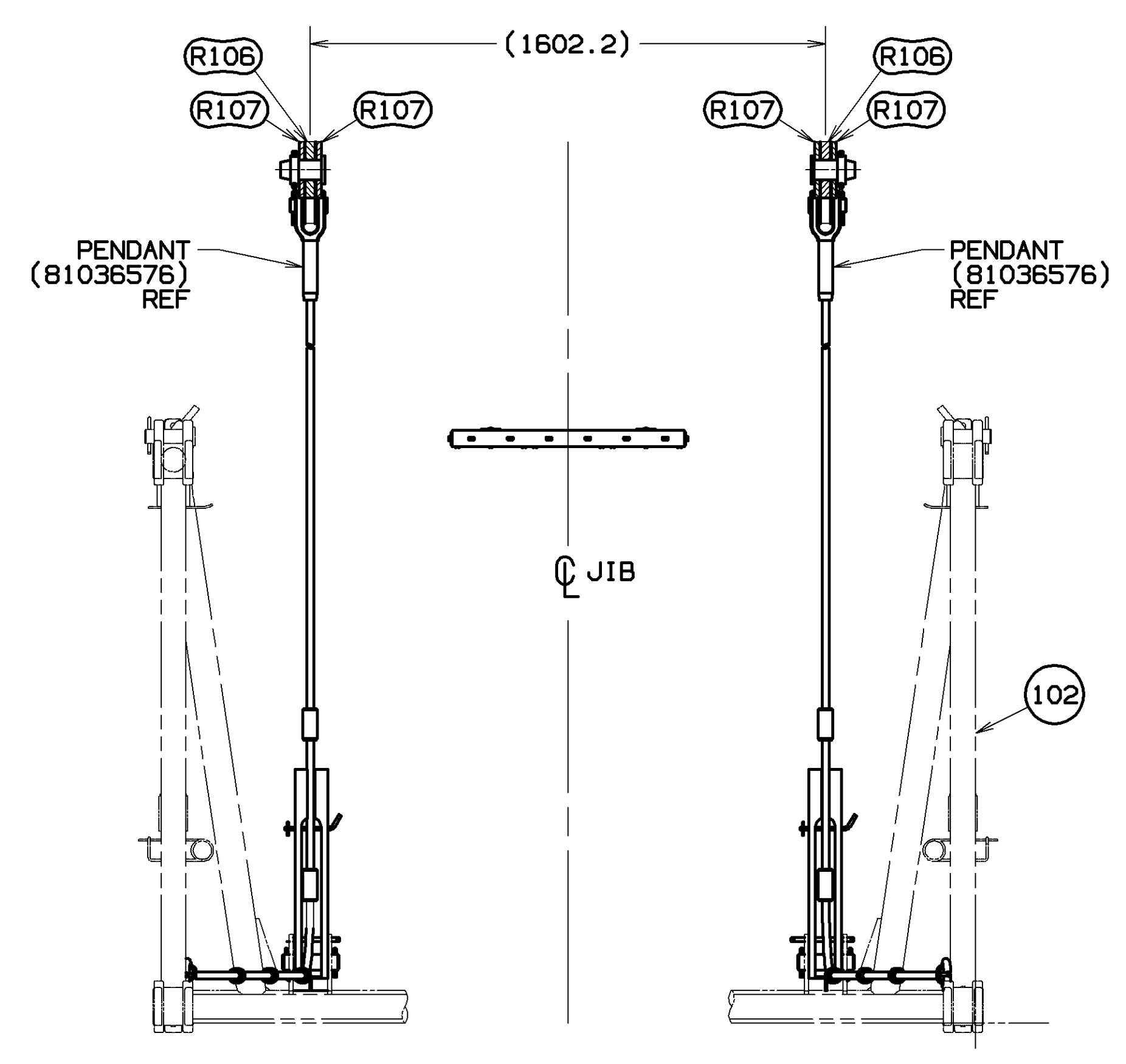
USING AN ASSIST CRANE TO SUPPORT JIB BUTT (ITEM 2), DETACH JIB BUTT FROM JIB BUTT HINGE ON BOOM TOP.
 POSITION HINGE PINS (R48), COLLARS (R44), KEEPER PLATES (R49) AND RETAINING HARDWARE TO SHIPPING POSITION ON JIB BUTT. (SEE DETAIL N ON SHEET 7).

REFERENCE ONLY!

81023384
 SHT 12 OF 15

PRIVATE LABELING REQUIREMENT TO CONFORM TO ENGINEERING SPECIFICATION 8629103794 FOR COMPONENTS LISTED IN SECTION 05-1056
 DATE 07-14-16
 REV. LNK (D)

TOLERANCE UNLESS OTHERWISE SPECIFIED		SCALE	Mantowoc Cranes, Inc.	
DECIMAL PLACES	FABRICATION	MACHINING	DR. AJB	LUFFING JIB RIGGING
(1) PLACE 0.5	± 0.12	± 0.18	± 0.03	MODEL MLC300
(2) PLACE 0.00	± 0.08	± 0.12	± 0.015	LJ10:501 ON B60:500
(3) PLACE 0.000	± 0.008	± 0.008	± 0.008	
ANGLES	± 1.30	± 0.50		



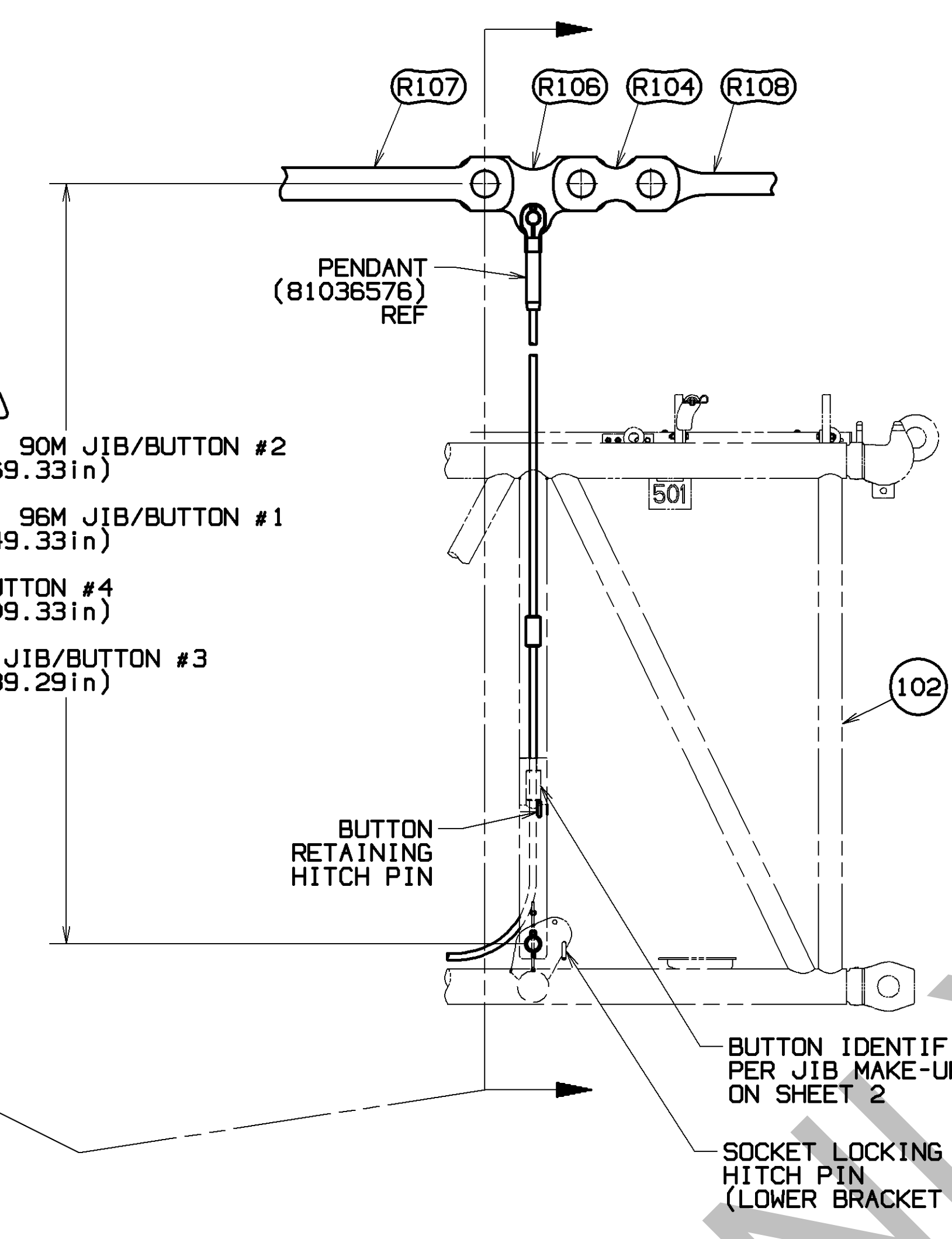
SEE 24

48M, 72M & 90M JIB/BUTTON #2
4301mm (169.331in)

54M, 78M & 96M JIB/BUTTON #1
3793mm (149.331in)

60M JIB/BUTTON #4
5317mm (209.331in)

66M & 84M JIB/BUTTON #3
4808mm (189.291in)



DETAIL FF
(FROM SHEET 6)
SCALE 0.070

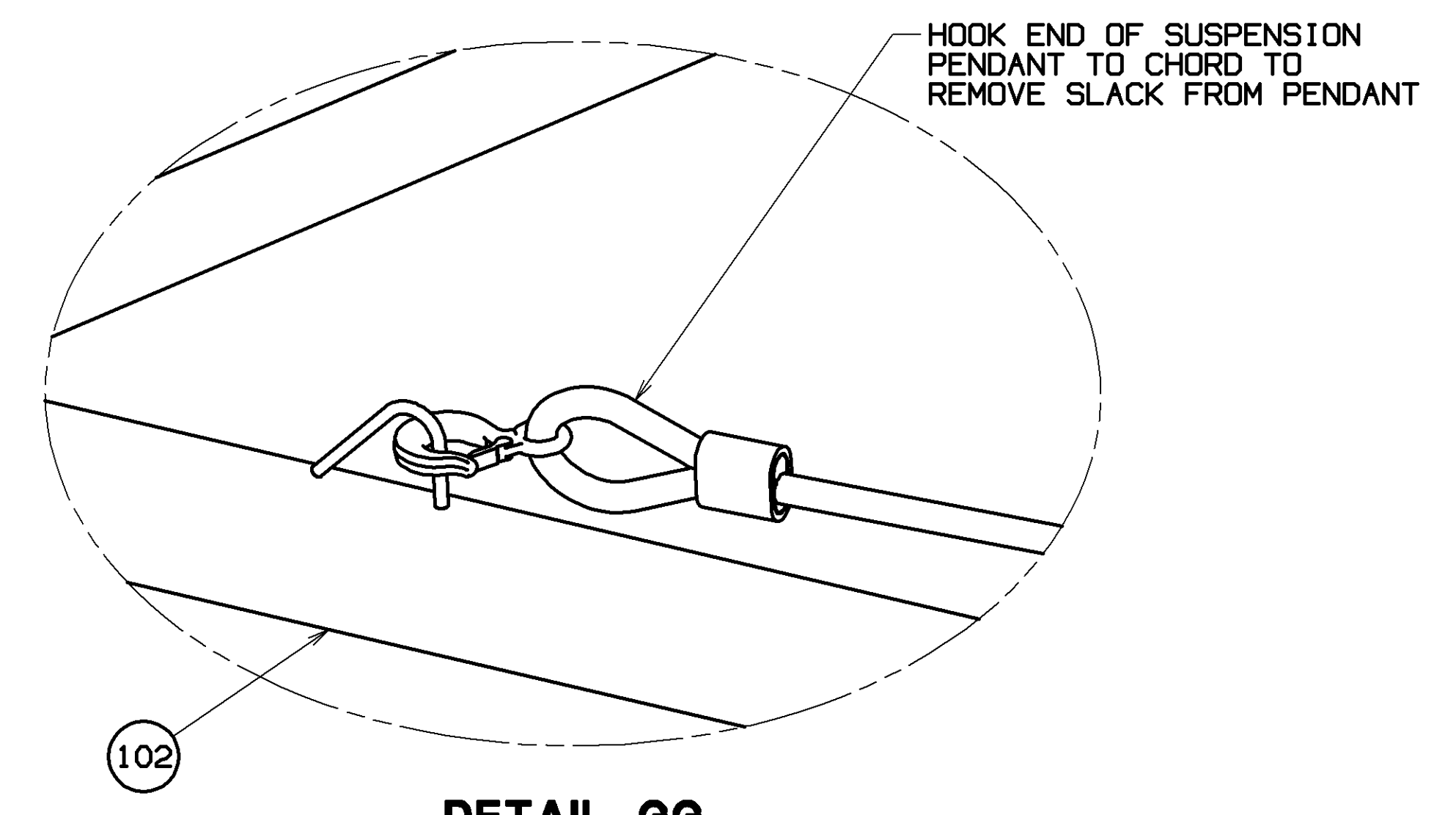
INTERMEDIATE SUSPENSION OPERATIONAL INSTRUCTIONS

SEE JIB MAKEUP VIEWS ON SHEETS 5 & 6 AND JIB LENGTH TABLE ON SHEET 2 FOR REQUIRED SUSPENSION AND WIRE ROPE BUTTON IDENTIFICATION LOCATION.

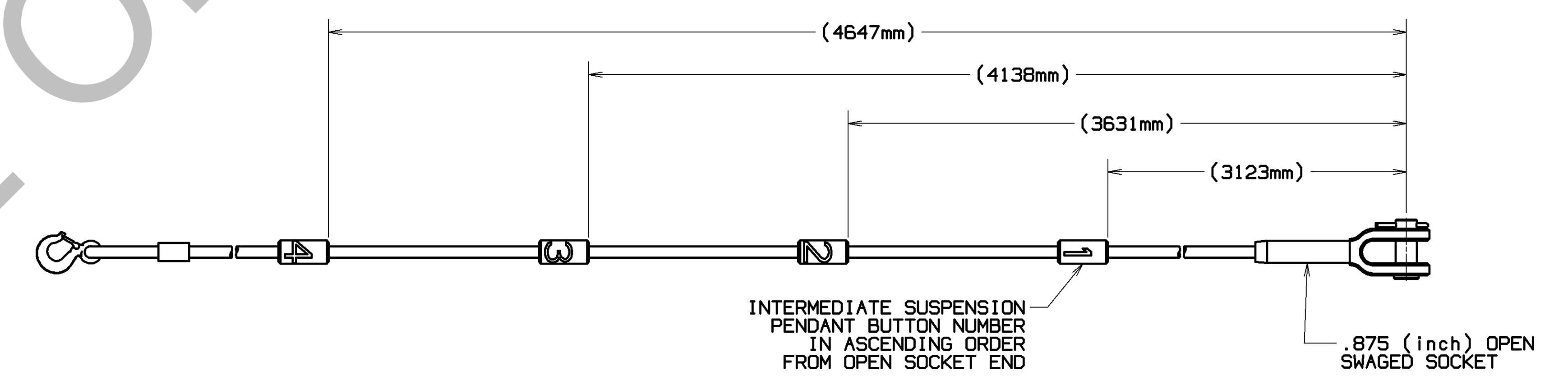
1. FROM STOWED POSITION REMOVE SOCKET LOCKING HITCH PIN FROM SOCKET AND LOWER BRACKET HOLE. (SEE DETAIL HH - STOWED) PIVOT SOCKET INTO ASSEMBLY PREP POSITION AND REINSTALL SOCKET LOCKING HITCH PIN INTO SOCKET AND UPPER BRACKET HOLE. (SEE DETAIL HH - ASSEMBLY PREP)
2. VERIFY THAT CORRECT PENDANT BUTTON IS INSTALLED IN SOCKET. IF NEEDED REMOVE BUTTON RETAINING HITCH PIN FROM SOCKET AND POSITION THE IDENTIFIED PENDANT INTO SOCKET. REINSTALL BUTTON RETAINING HITCH PIN INTO SOCKET, LOCKING PENDANT IN POSITION. (SEE DETAIL HH - ASSEMBLY PREP)
3. RELOCATE SOCKET LOCKING HITCH PIN FROM SOCKET AND UPPER BRACKET HOLE TO LOWER BRACKET HOLE. (SEE DETAIL HH - WORKING)
4. BOOM UP SLOWLY AS PENDANT BECOMES TIGHT AND SOCKET PIVOTS INTO WORKING POSITION. (SEE DETAIL HH - WORKING)

FOR STOWAGE OF INTERMEDIATE SUSPENSION REVERSE SETUP INSTRUCTION STEPS 1 THRU 4, ASSURING SOCKET PIVOTS TOWARD STOWAGE POSITION.

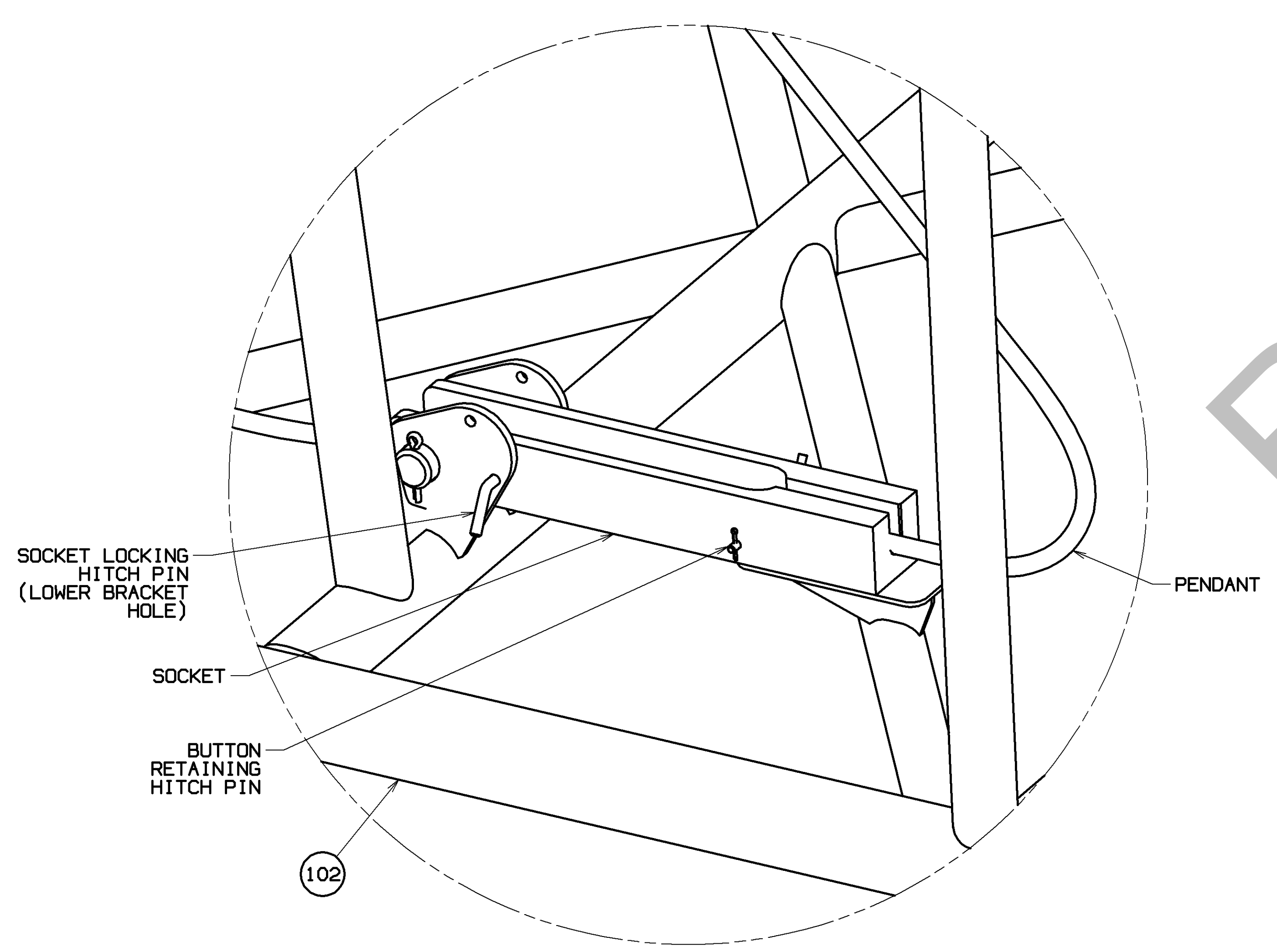
VERIFY THAT SLACK IN PENDANT ALLOWS FOR SOCKET TO PIVOT INTO STOWED POSITION. (SEE DETAIL GG).



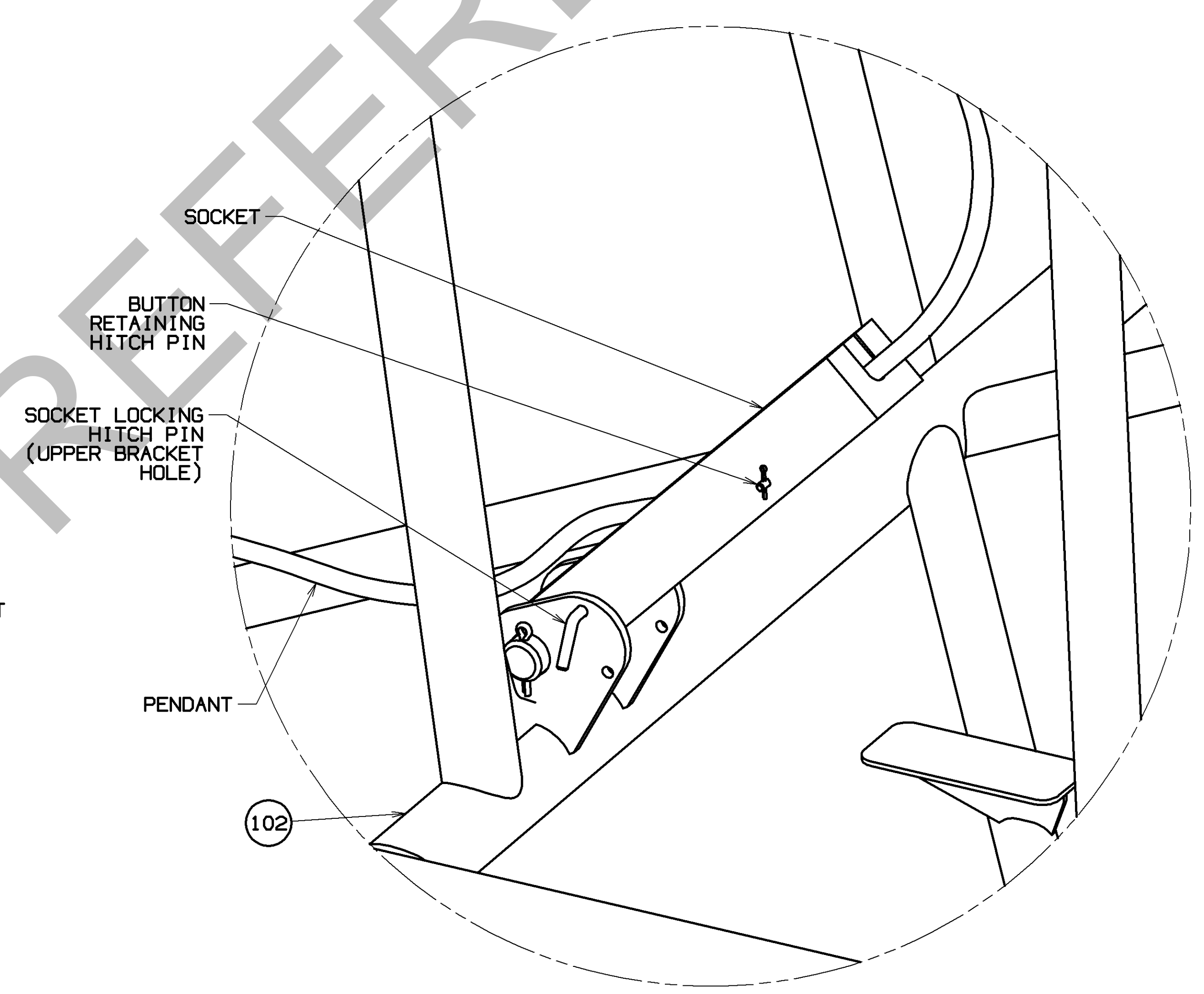
DETAIL GG
(FROM SHEET 6)
SCALE .250



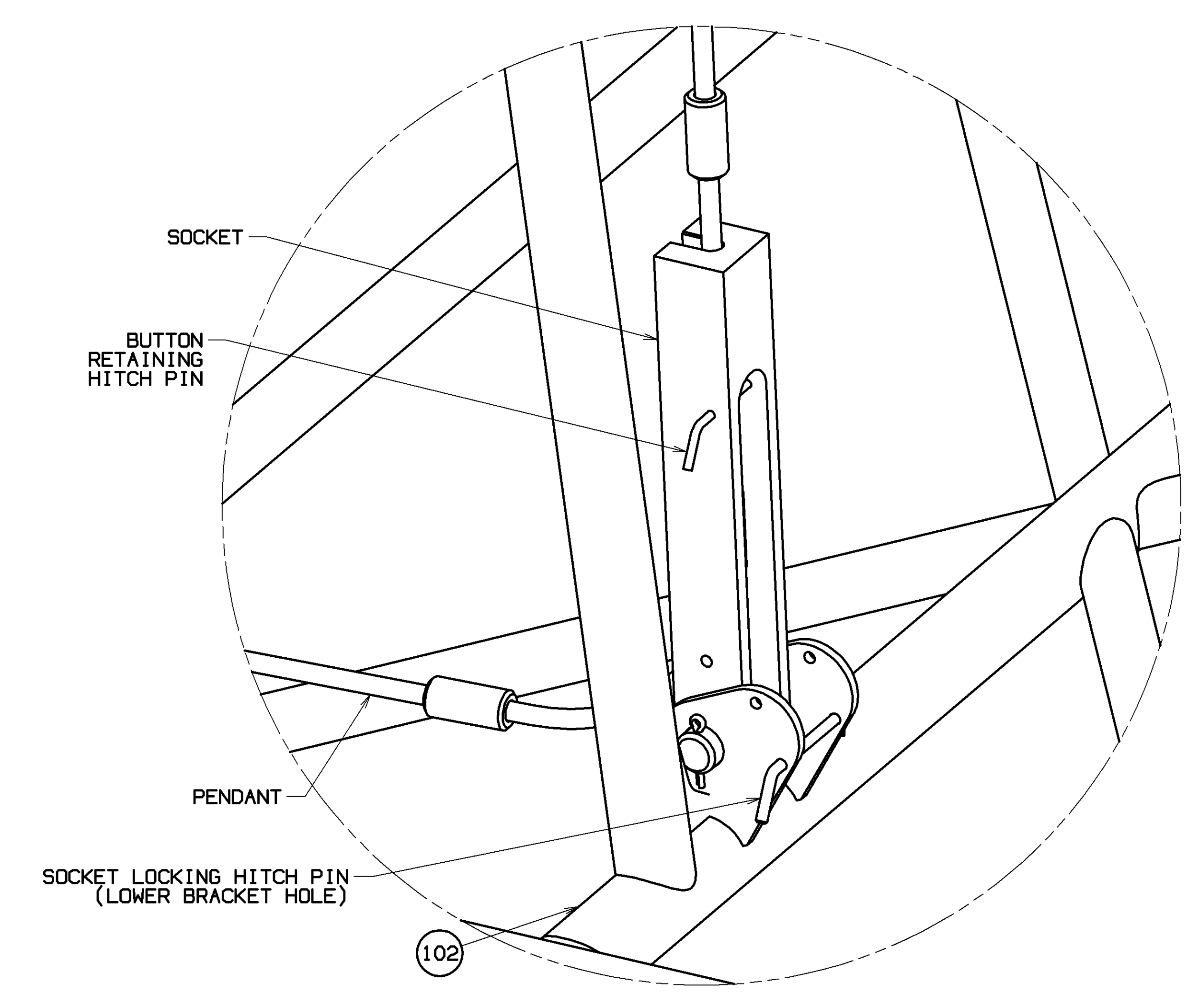
PENDANT (81036576) BUTTON NUMBER IDENTIFICATION LOCATION
SCALE 0.150



DETAIL HH - STOWED
(FROM SHEET 6)
SCALE 0.250



DETAIL HH - ASSEMBLY PREP
(FROM SHEET 6)
SCALE 0.250



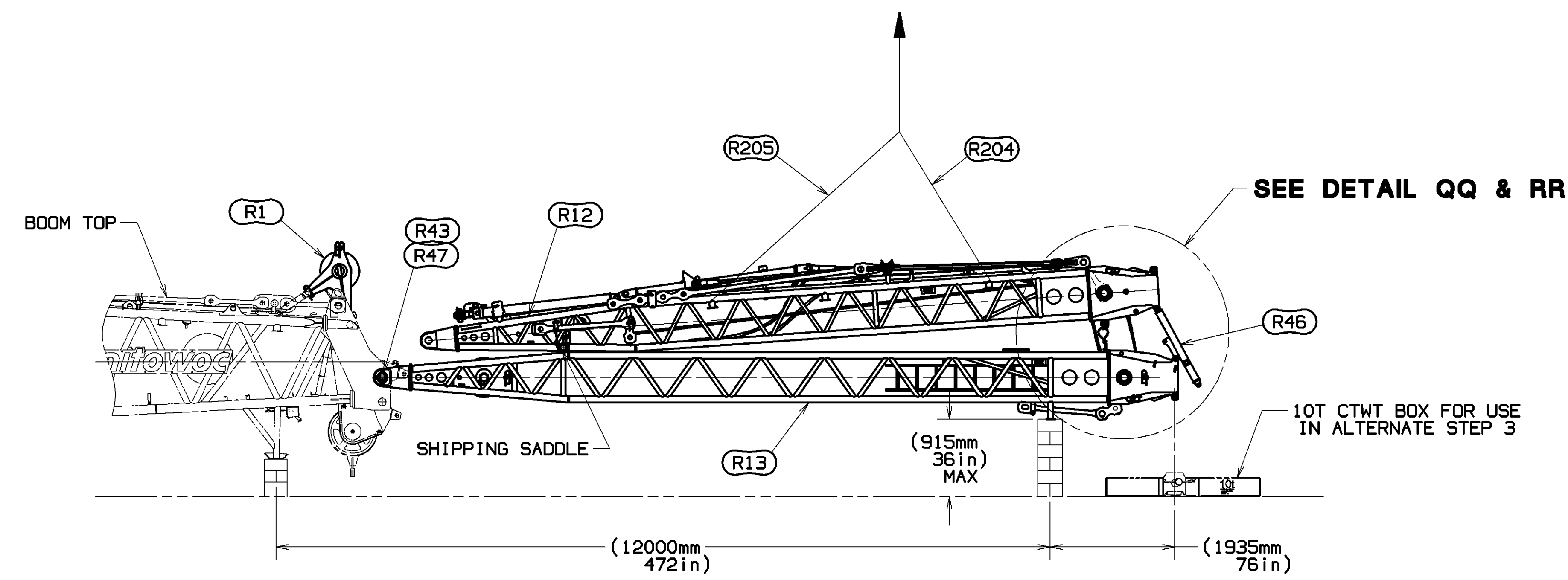
DETAIL HH - WORKING
(FROM SHEET 6)
SCALE 0.250

81023384
SHT 13 OF 15

PRIVATE LABELING REQUIREMENT TO CONFORM TO ENGINEERING SPECIFICATION 8629103794 FOR COMPONENTS LISTED IN SECTION 05-1026
DATE 07-14-16
REV. LNK
D

<small>THIS DRAWING IS THE PROPERTY OF MARITOWO CRANES, INC. ALL INFORMATION CONTAINED HEREIN IS CONFIDENTIAL. IT IS LOANED, SUBJECT TO RETURN UPON DEMAND, AND ON EXPRESS CONDITION THAT IT IS NOT TO BE COPIED OR USED DIRECTLY OR INDIRECTLY IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF MARITOWO CRANES, INC.</small>	<small>DECIMAL PLACES</small> <small>FRACTIONS</small> <small>ANGLES</small>			<small>UNLESS OTHERWISE SPECIFIED</small> <small>FABRICATION</small> <small>FINISHING</small>	<small>REVISIONS</small> <small>DATE</small> <small>BY</small> <small>APP</small>	Maritowoc Cranes, Inc. Maritowoc, Wisconsin MODEL MLC300	LUFFING JIB RIGGING LJ10:501 ON B60:500	
	<small>(1) PLACE</small> <small>(2) PLACE</small> <small>(3) PLACE</small>	<small>0.5</small> <small>0.00</small> <small>0.000</small>	<small>±.12</small> <small>±.08</small> <small>±.015</small>	<small>±.18</small> <small>±.12</small> <small>±.008</small>	<small>AS PER</small> <small>TO THE</small> <small>APPROPRIATE</small> <small>INDUSTRY</small> <small>STANDARDS</small>	<small>DR. AJB</small> <small>CK. RHV</small> <small>APP. DLG</small>	<small>DATE</small> <small>REV.</small>	<small>NO.</small> <small>REV.</small>
	<small>11.25°</small> <small>11.25°</small> <small>11.25°</small>	<small>11.25°</small> <small>11.25°</small> <small>11.25°</small>	<small>11.25°</small> <small>11.25°</small> <small>11.25°</small>	<small>11.25°</small> <small>11.25°</small> <small>11.25°</small>	<small>11.25°</small> <small>11.25°</small> <small>11.25°</small>	<small>11.25°</small> <small>11.25°</small> <small>11.25°</small>	<small>11.25°</small> <small>11.25°</small> <small>11.25°</small>	<small>11.25°</small> <small>11.25°</small> <small>11.25°</small>
	<small>11.25°</small> <small>11.25°</small> <small>11.25°</small>	<small>11.25°</small> <small>11.25°</small> <small>11.25°</small>	<small>11.25°</small> <small>11.25°</small> <small>11.25°</small>	<small>11.25°</small> <small>11.25°</small> <small>11.25°</small>	<small>11.25°</small> <small>11.25°</small> <small>11.25°</small>	<small>11.25°</small> <small>11.25°</small> <small>11.25°</small>	<small>11.25°</small> <small>11.25°</small> <small>11.25°</small>	<small>11.25°</small> <small>11.25°</small> <small>11.25°</small>

BILL OF MATERIAL				ASSEMBLIES USED ON
QTY	DESCRIPTION	MATERIAL	REF. QTY	



ALTERNATE STEP 1
JIB STRUT ASSEMBLY

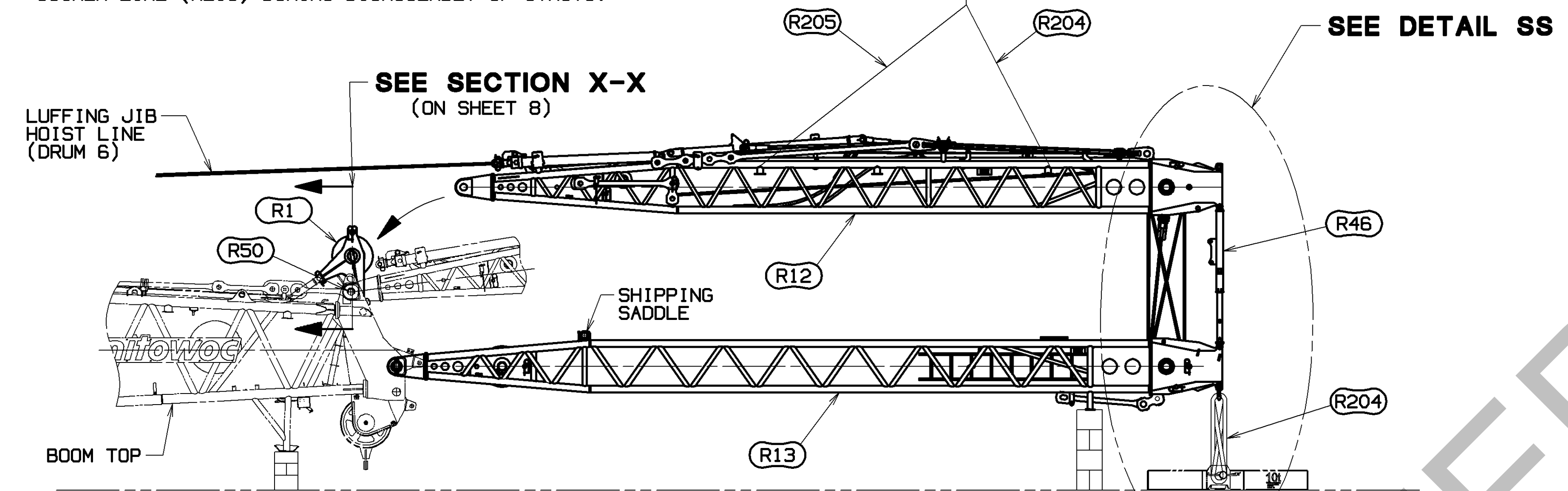
PROVIDE BLOCKING AND (1) 10T CTWT BOX AS SHOWN. USING ASSIST CRANE WITH SLINGS (R204) & (R205) AS SHOWN, LIFT THE JIB STRUT (R13) AND MAIN STRUT (R12) IN THE "AS SHIPPED" CONFIGURATION (ITEM 6) AND ATTACH JIB STRUT (R13) TO JIB STRUT HINGE ON BOOM TOP AS SHOWN.

ASSEMBLE JIB STRUT HINGE PIN (R47) AND TEMPORARILY ATTACH COLLARS (R43) AND PINS TO RETAIN THE HINGE PIN. (REFER TO DETAIL R AND SECTION S-S ON SHEET 7).

IF SHIPPING STRUT (R46) IS ATTACHED PER DETAIL QQ, MAIN STRUT (R12) MAY BE ELEVATED USING ASSIST CRANE TO PIVOT AROUND SHIPPING SADDLE (SEE DETAIL V ON SHEET 8) AND RELOCATE SHIPPING STRUT (R46) TO JIB STRUT (R13) PER DETAIL RR. (REPOSITION OF THE SHIPPING STRUT WILL AID IN THE REEVING OF STRUTS PER STEP 2).

ALTERNATE STEP 2
STRUT REEVING

REFER TO STEP 3 (STRUT REEVING PREP) ON SHEET 7 AND STEP 4 (STRUT REEVING) ON SHEET 8. SEE SHEET 8 FOR DIAGRAM FOR REEVING OF 28mm LUFFING HOIST ROPE (DRUM 6) AND FOR DIAGRAM FOR REEVING SUCKER LINE (R206) DURING DISASSEMBLY OF STRUTS.



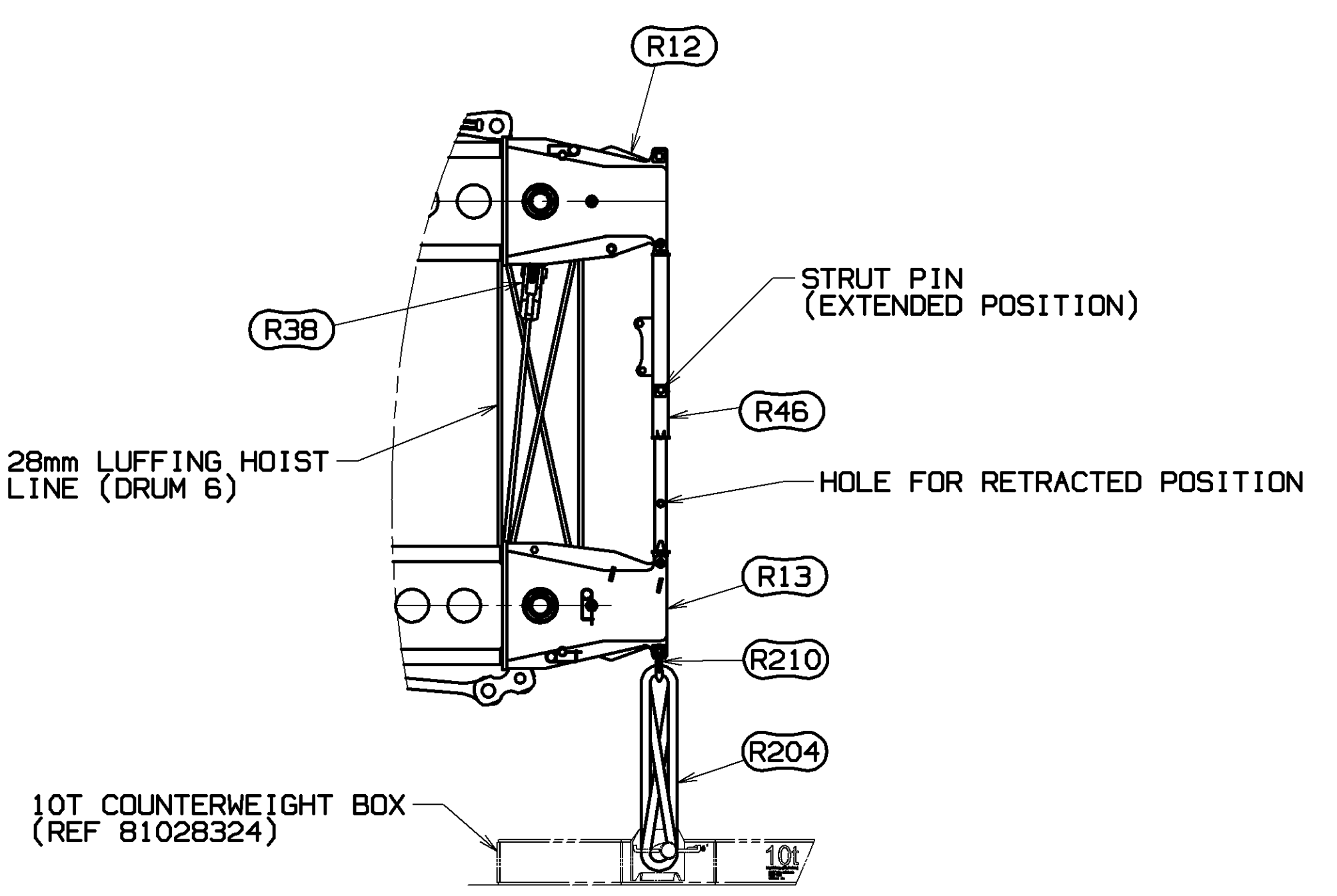
ALTERNATE STEP 3
MAIN STRUT ASSEMBLY

SECURE JIB STRUT (R13) TO 10T CTWT BOX WITH SHACKLE (R210) AND DOUBLE WRAP SLING (R204) (2-PLACES). WITH SHIPPING STRUT (R46) POSITIONED AS SHOWN IN DETAIL RR, REMOVE STRUT PIN FROM SHIPPING STRUT RETRACTED POSITION. (SEE DETAIL SS).

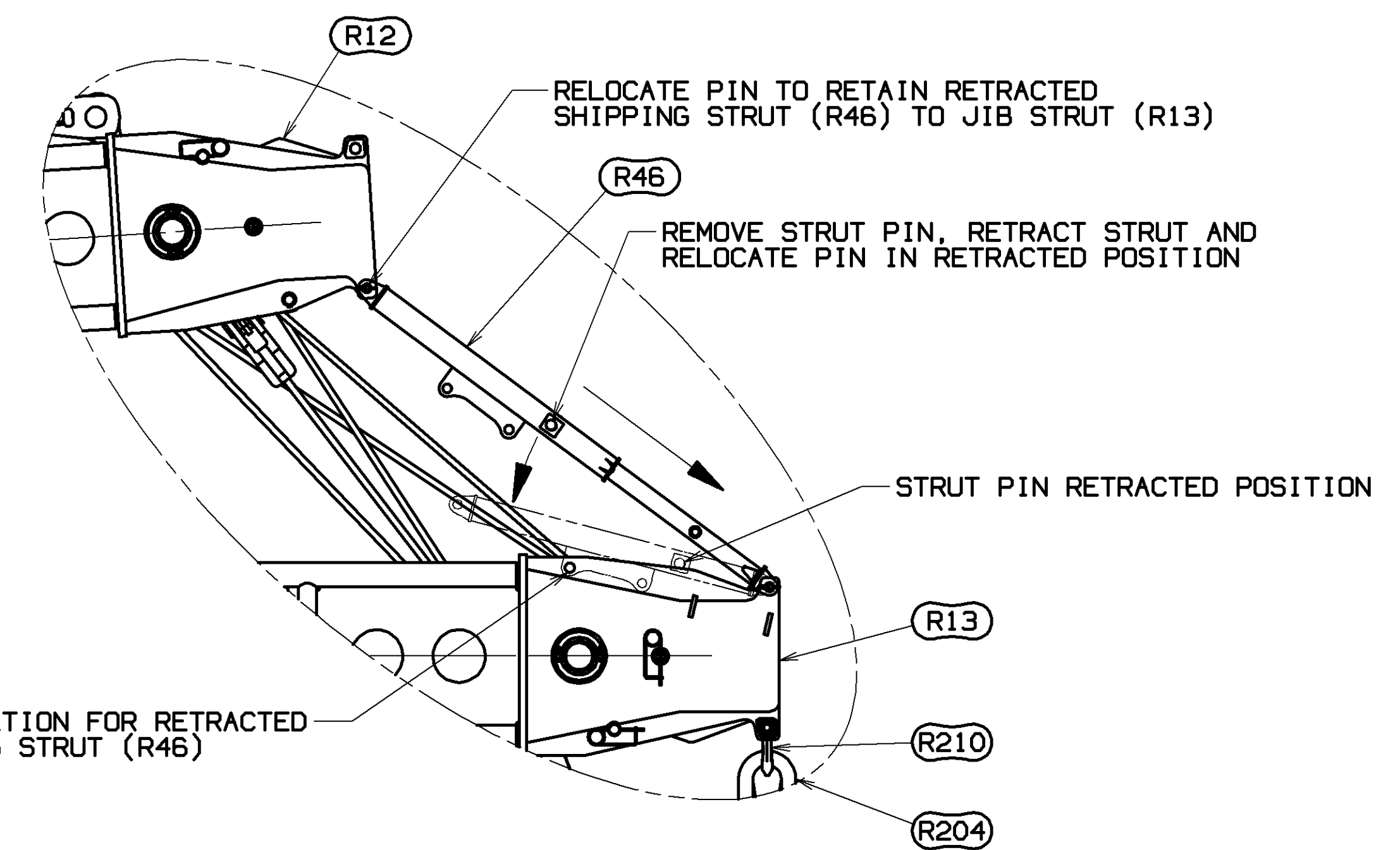
DISCONNECT THE SHIPPING LINKS AT THE SHIPPING SADDLES ON THE JIB STRUT (R13) TO ALLOW THE MAIN STRUT (R12) TO LIFT FREELY. (SEE DETAIL V ON SHEET 8). USING AN ASSIST CRANE WITH SLINGS (R204) & (R205) AS SHOWN LIFT THE MAIN STRUT (R12) FROM ITS SHIPPING POSITION WHILE PAYING OUT LUFFING HOIST LINE (DRUM 6) ALLOWING SHIPPING STRUT (R46) TO TELESCOPE TO EXTENDED POSITION. REPLACE STRUT PIN INTO SHIPPING STRUT EXTENDED POSITION. (SEE DETAIL SS).

WITH THE MAIN STRUT (R12) FREE, PIVOT MAIN STRUT HINGE TO THE BOOM TOP. SECURE MAIN STRUT HINGE PIN (R50 OR R55) WITH PROVIDED COLLARS (R39) AND PINS (R40). (SEE SECTION X-X ON SHEET 8).

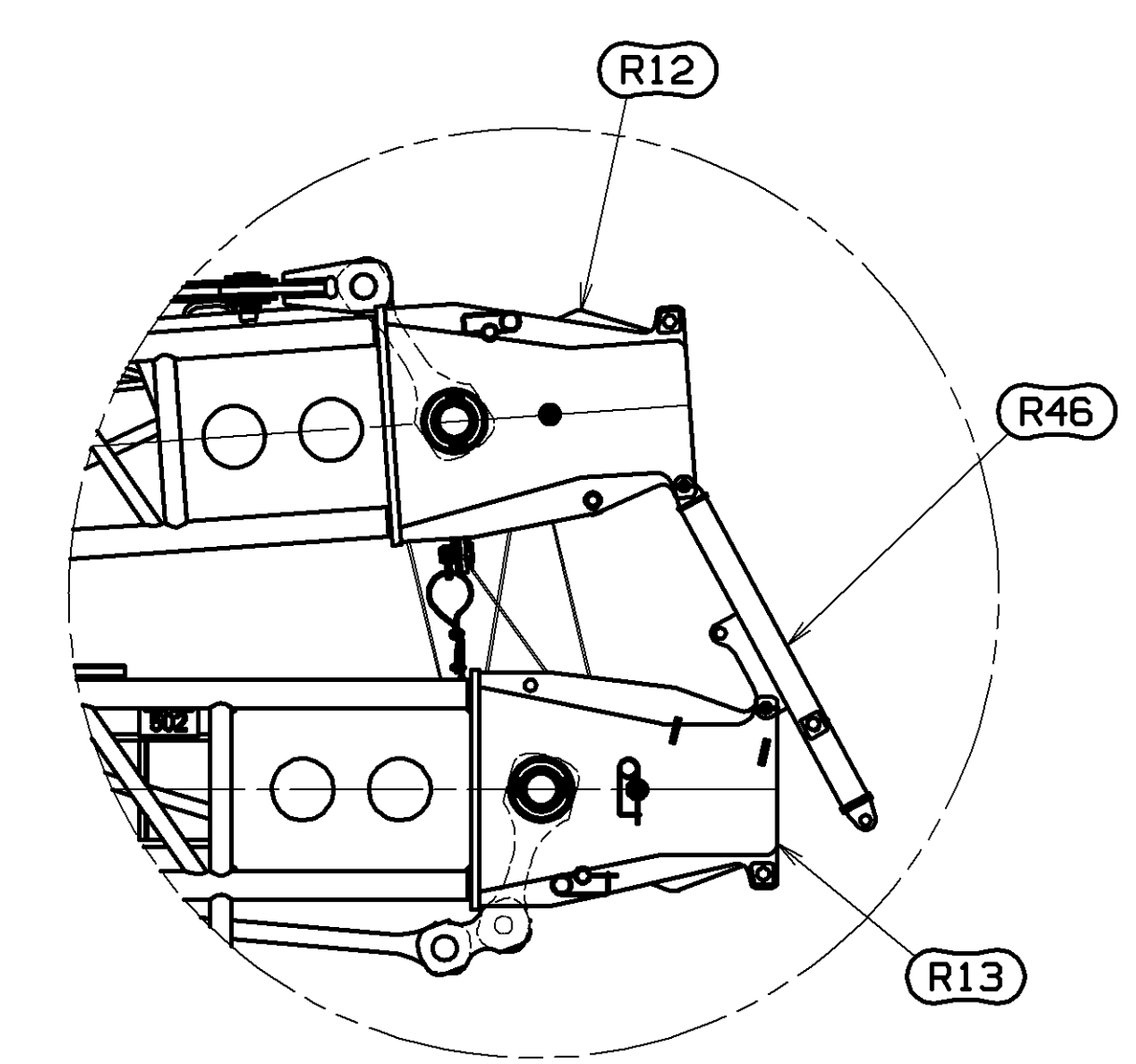
CAUTION: DO NOT ALLOW MAIN STRUT (R12) TO ROTATE BELOW HORIZONTAL WHEN PINNED TO BOOM TOP. DAMAGE MAY OCCUR.



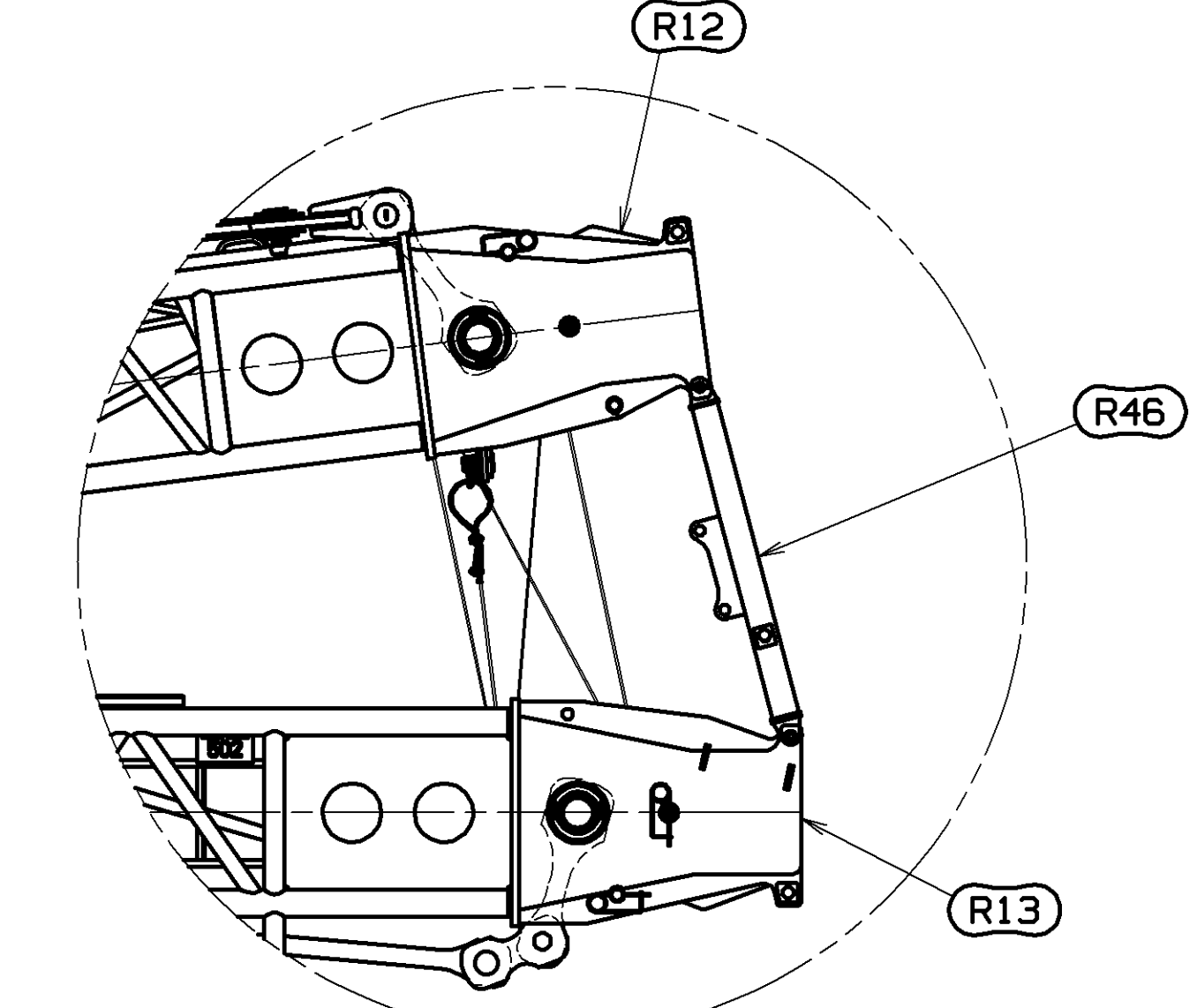
DETAIL SS
SCALE 0.030



DETAIL TT
SCALE 0.050



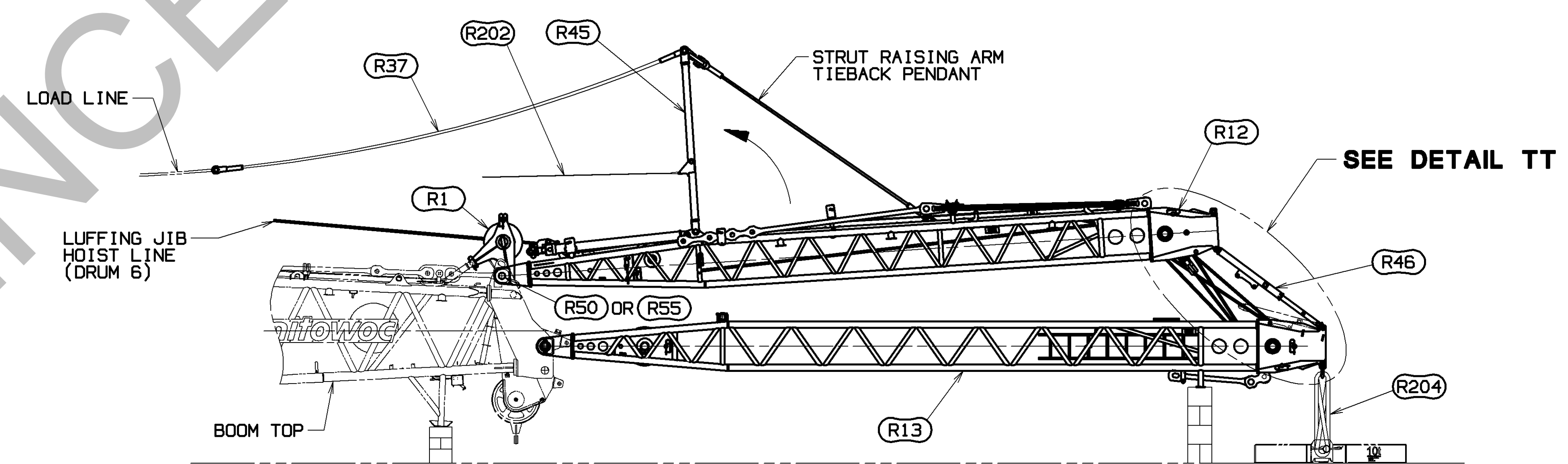
DETAIL QQ
POSITION OF SHIPPING STRUT (R46) WHEN TRANSPORTED ON A FLATBED TRAILER
SCALE 0.040



DETAIL RR
POSITION OF SHIPPING STRUT (R46) WHEN TRANSPORTED ON A DROP-DECK TRAILER
SCALE 0.040

ALTERNATE STEP 4
PINS AND STRAP REMOVAL FROM MAIN STRUT (R12)

REFER TO STEP 6 (PINS AND STRAP REMOVAL FROM MAIN STRUT (R12)) ON SHEET 9 TO PREP MAIN STRUT FOR RAISING ARM HOOK UP AND BACKSTAY CONNECTION



ALTERNATE STEP 5
RAISING ARM HOOK-UP

DETACH RAISING PENDANT (R37) FROM ITS SHIPPING LOCATION (SEE DETAIL AA ON SHEET 9) AND ATTACH THE FREE END OF THE PENDANT TO AN APPROPRIATE LOAD LINE. ATTACH RIGGING LINE (R202) TO MAIN STRUT RAISING ARM (R45).

NOTE: IF DRUM 2 IS EQUIPPED, DRUM 2 MUST BE USED FOR STRUT RAISING. DRUM 1 OR 3 CANNOT BE USED. THE LOAD LINE FROM DRUM 2 MUST BE CONTAINED BETWEEN THE TWO SHEAVES ON THE WIRE ROPE GUIDES (R8 & R9). IF USING LOAD LINE FROM DRUM 1 (WITHOUT DRUM 2 EQUIPPED), THE LOAD LINE MUST LAY ON THE TOP OF THE WIRE ROPE GUIDE FRAME AND THE UPPER AND LOWER SHEAVES (R8 & R9) MUST BE REMOVED FROM THE FRAME. SPECIAL CARE MUST BE TAKEN TO ENSURE THAT THE ROPE PROPERLY SPOOLS ON THE DRUM DURING THE FOLLOWING STEPS. (SEE SECTION DD-DD ON SHEET 9)

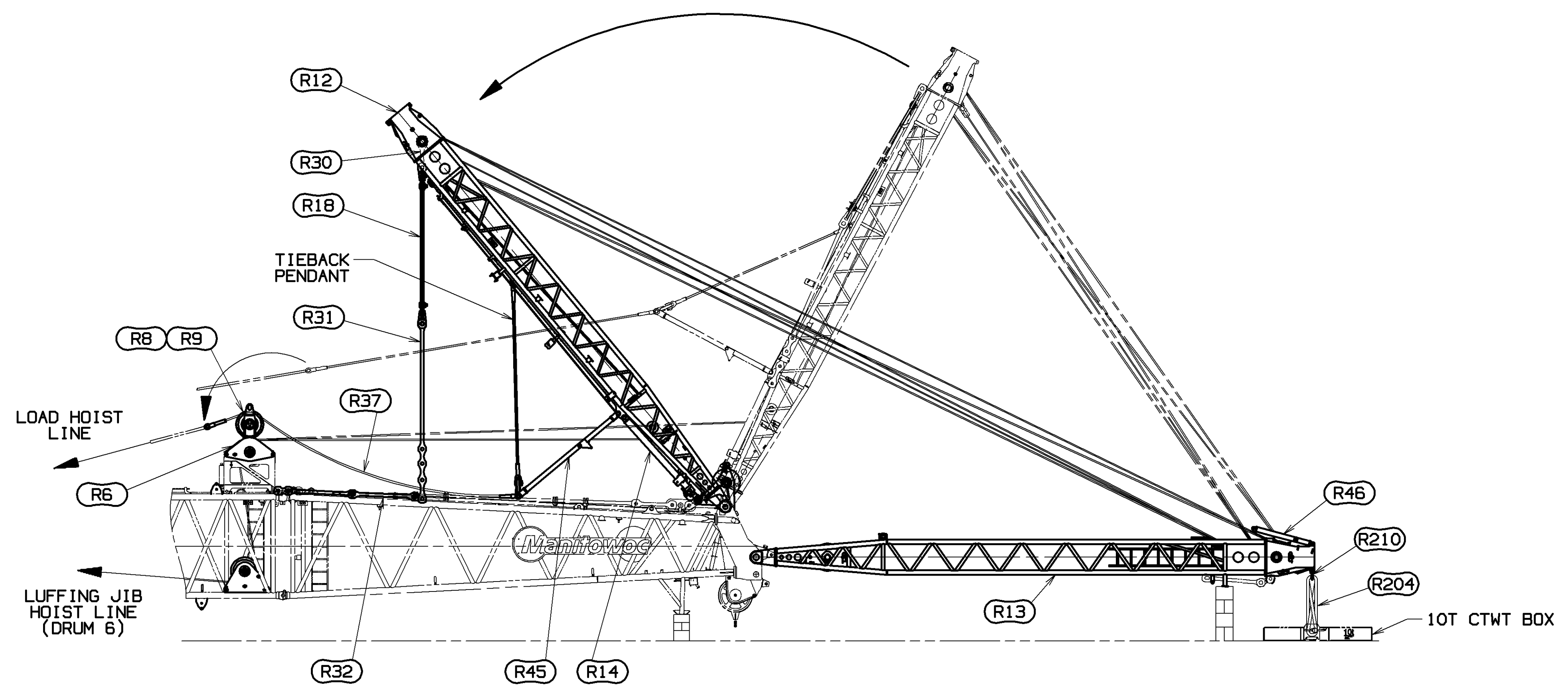
CAUTION: IF RIGGING WINCH IS NOT USED, MAIN STRUT RAISING ARM (R45) MAY RAISE SUDDENLY WHEN LOAD LINE IS RETRACTED CAUSING LOAD LINE AND DEAD END TO DROP ONTO BOOM TOP.

PAY IN RIGGING WINCH LINE (R202) RAISING THE MAIN STRUT RAISING ARM (R45) INTO WORKING POSITION. PAY IN THE LOAD LINE UNTIL THE STRUT RAISING ARM TIE BACK PENDANT IS TAUT. AT THIS POINT THE RIGGING WINCH LINE MAY BE DISCONNECTED OR KEPT TAUT THROUGH THE RAISING PROCESS.

CONTINUE TO SUPPORT MAIN STRUT (R12) WITH LOAD LINE AND REMOVE THE STRUT PIN FROM THE SHIPPING STRUT EXTENDED LOCATION AND THE PIN ATTACHING THE SHIPPING STRUT (R46) TO THE MAIN STRUT (R12). (SEE DETAIL TT).

RETRACT SHIPPING STRUT (R46) AND RELOCATE THE STRUT PIN TO THE RETRACTED POSITION. ROTATE THE SHIPPING STRUT (R46) INTO STOWAGE POSITION ON JIB STRUT (R13). REATTACH STRUT (R46) WITH THE PIN PREVIOUSLY REMOVED FROM MAIN STRUT. (SEE DETAIL TT).

<small>THIS PRINT REMAINS THE PROPERTY OF MARITOWOC CRANES, INC. ALL INFORMATION CONTAINED HEREIN IS CONFIDENTIAL. IT IS LOANED, SUBJECT TO RETURN UPON DEMAND, AND ON EXPRESS CONDITION THAT IT IS NOT TO BE COPIED OR USED DIRECTLY OR INDIRECTLY IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF MARITOWOC CRANES, INC.</small>	<small>TOLERANCE UNLESS OTHERWISE SPECIFIED</small> DECIMAL PLACES FABRICATION FINISHING (1) PLACE 0.5 ±.12 ±.18 ±.03 (2) PLACE 0.00 ±.08 ±.12 ±.015 (3) PLACE 0.000 ±.008 ±.008 ±.002	<small>WELD</small> G20 <small>DR. RHY</small> <small>CK. IMM</small> <small>APP DLG</small>	Maritowoc Cranes, Inc. Maritowoc, Wisconsin MODEL MLC300	LUFFING JIB RIGGING LJ10:501 ON B60:500	DATE 10-20-16 REF. LIT. D	
	<small>PRIVATE LABELING REQUIREMENT TO CONFORM TO ENGINEERING SPECIFICATION S629103794 FOR COMPONENTS LISTED IN SECTION 05-026</small>	<small>NO. 81023384</small>	<small>DATE</small> 10-20-16	<small>REF. LIT.</small> D	<small>NO. 81023384</small>	<small>DATE</small> 10-20-16
	<small>DO NOT SCALE THIS DRAWING</small>	<small>SHT 14 OF 15</small>	<small>SHT 14 OF 15</small>	<small>SHT 14 OF 15</small>	<small>SHT 14 OF 15</small>	<small>SHT 14 OF 15</small>



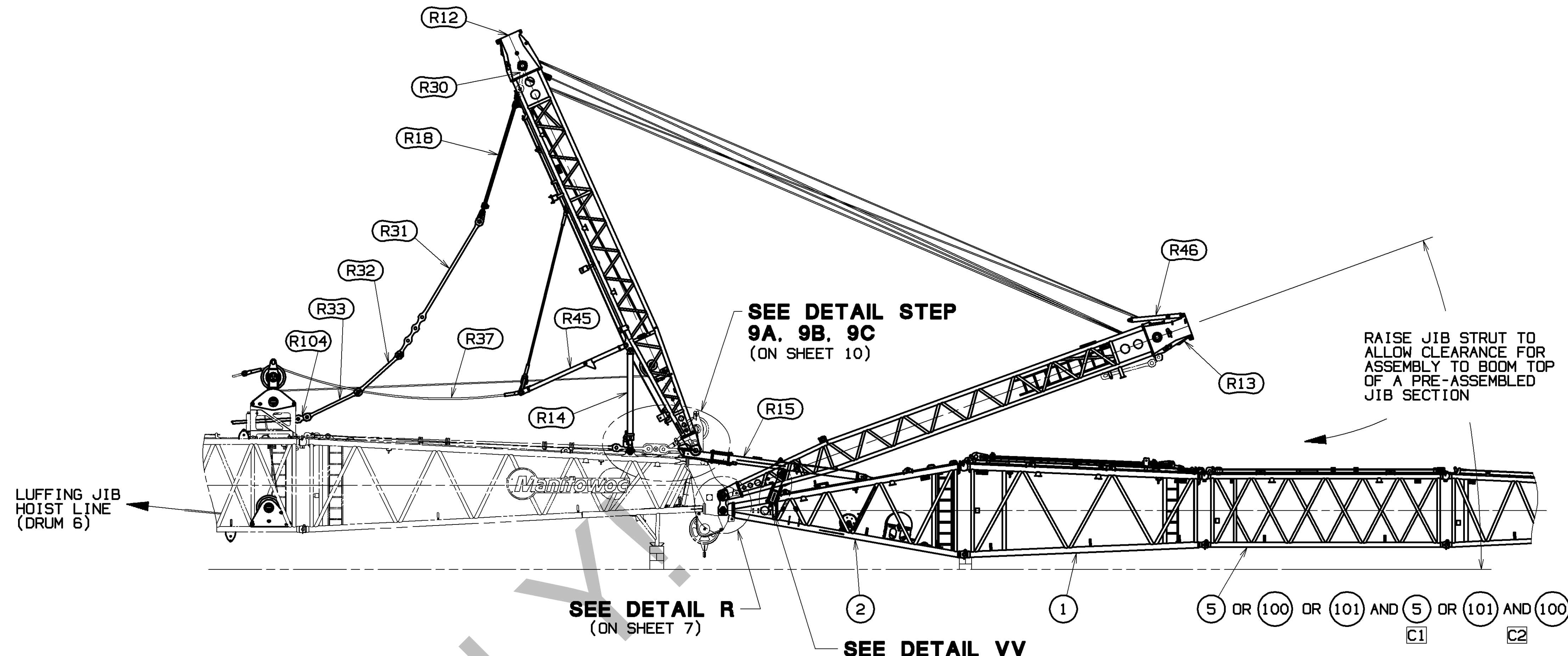
ALTERNATE STEP 6
MAIN STRUT RAISING AND BACKSTAY CONNECTION

CONTINUE TO PAY IN LOAD HOIST, RAISING THE MAIN STRUT (R12) OVER VERTICAL, ENSURING THAT THE LUFFING HOIST REEVING DOES NOT BECOME SLACK. WITH THE MAIN STRUT BEYOND VERTICAL, CONTROL OF ITS ANGLE WILL TRANSITION FROM THE LOAD LINE (ATTACHED TO THE RAISING PENDANT R37) TO THE LUFFING HOIST (DRUM 6).

AS THE MAIN STRUT (R12) CONTINUES BEYOND VERTICAL, THE BACKSTAY STRAPS (R30)(R31) AND SPREADER (R18) WILL BEGIN TO HANG VERTICALLY. RAISE THE MAIN STRUT UNTIL THE BACKSTAY STRAPS (R31) HANG IN POSITION OVER THE LUFFING JIB BACKSTAY STRAPS LOCATED ON THE MAIN BOOM.

ATTACH THE LINKS (R32) FROM THE MAIN BOOM TOP TO THE ADJUSTABLE BACKSTAY STRAP (R31). VERIFY HOLE LOCATION (A,B,C, OR D) PER BOOM LENGTH TABLE ON SHEET 2 AND DETAIL G ON SHEET 4.

CAUTION: IF USING POSITIONS B,C, OR D DO NOT ALLOW ADJUSTABLE BACKSTAY STRAP (R31) TO EXTEND INTO BOOM TOP. STRAP CAN CATCH ON BOOM TOP AND DAMAGE LACINGS.



ALTERNATE STEP 7
STRUT STOP CONNECTION AND JIB BUTT ASSEMBLY

PAY IN THE LUFFING JIB HOIST LINE (DRUM 6) TO BRING THE MAIN STRUT (R12) BACK TOWARDS VERTICAL AND TO POSITION STRUT STOP (R14) OVER THE STOP LUG ON THE MAIN BOOM TOP. WITH MAIN STRUT STOP (R14) IN STOWED POSITION REMOVE STRUT STOP STOWAGE LOCKING PINS. ALLOWING STOP TO HANG VERTICALLY ABOVE THE STOP LUGS. PLACE LOCKING PINS IN THE TABS ON THE BRACKET. TEMPORARILY REMOVE THE MAIN PIN FROM THE END OF THE MAIN STRUT STOP (R14). (SEE DETAIL STEP 9A ON SHEET 10)

REMOVE THE CENTER PIN FROM ITS SHIPPING LOCATION ON THE MAIN STRUT STOP AND ALLOW THE INNER MOST TUBE TO TELESCOPE OUTWARD UNTIL THE END OF THE STOP CAN BE CONNECTED TO THE STOP LUG USING THE PREVIOUSLY REMOVED MAIN PIN. (SEE DETAIL STEP 9B ON SHEET 10)

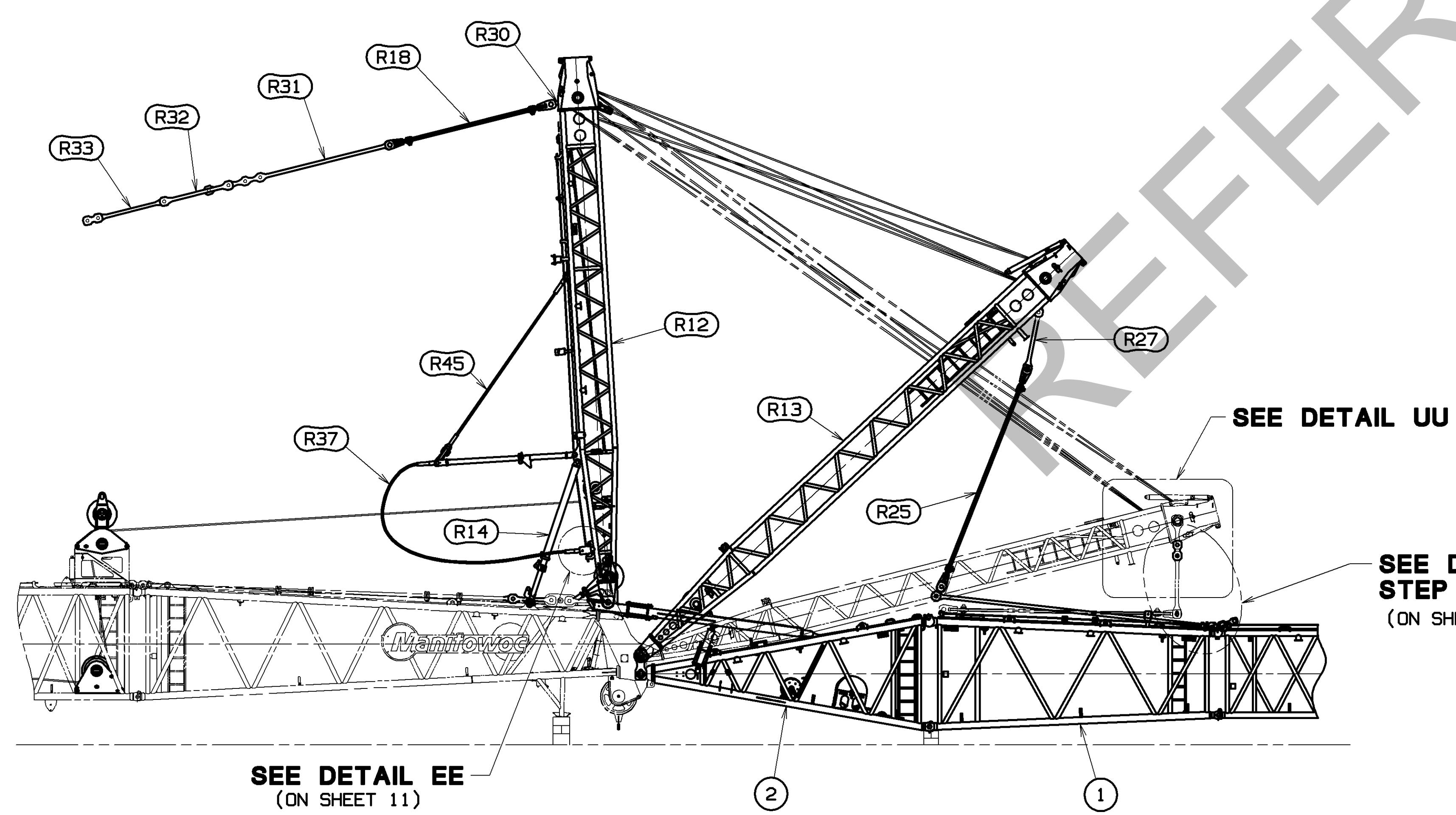
BEGIN RETRACTING THE LUFFING JIB HOIST LINE (DRUM 6) WHILE ALLOWING THE INNER MOST STOP TUBE TO TELESCOPE. WHEN THE CENTER HUB ON THE INNER MOST TUBE IS ALIGNED WITH THE EQUIVALENT HOLE ON THE MIDDLE STOP TUBE, USE THE CENTER PIN (REMOVED IN 'DETAIL STEP 9B' ON SHEET 10) TO LOCK THE TUBES TOGETHER. REMOVE THE SHIPPING PIN CONNECTING THE MIDDLE TUBE TO THE OUTER MOST TUBE AND STORE PIN IN THE REAR MOST SET OF HOLES. (SEE DETAIL STEP 9C ON SHEET 10)

PAYOUT THE LUFFING JIB HOIST LINE (DRUM 6) UNTIL THE MAIN STRUT (R12) RESTS ON THE MAIN STRUT STOPS (R14). (SEE ALTERNATE STEP 8 VIEW). DETACH THE LOAD LINE FROM THE STRUT RAISING PENDANT (R37) AND ATTACH END OF STRUT RAISING PENDANT TO STRUT STOP STOWAGE BRACKET. (SEE ALTERNATE STEP 8 VIEW ON SHEET 15 AND SEE DETAIL EE ON SHEET 11).

DETACH 10T CTWT BOX FROM JIB STRUT (R13) AND STOW SLINGS (R209) AND SHACKLES (R210) IN PARTS BOX 81028769.

PRE-ASSEMBLE (PER DESIRED BOOM CONFIGURATION) THE #501 JIB BUTT (ITEM 2), #500/501 TRANSITION INSERT (ITEM 1), AND EITHER #501 JIB TOP (ITEM 5), 12M INSERT (ITEM 100), 6M INSERT AND #501 JIB TOP (ITEMS 101 AND 5), OR 6M INSERT AND 12M INSERT (ITEMS 101 AND 100). USING ASSIST CRANE AND STAND ASSEMBLY (R54) RAISE JIB STOPS TO ASSEMBLY POSITION. RELOCATE JIB STOP STRUT HAIRPIN FROM SHIPPING POSITION TO WORKING POSITION TO ALLOW JIB STOP STRUT TO EXTEND. (SEE DETAIL VV).

RAISE JIB STRUT (R13) TO ALLOW THE 3 PIECE PRE-ASSEMBLED JIB SECTION (ITEMS 2, 1, AND 5 OR 100 OR 101) TO BE LOCATED AND ASSEMBLED TO BOOM TOP AS SHOWN. ENSURE THAT LUFFING JIB STOPS (R15) ARE SUPPORTED AND SITTING ON TOP OF THE STOP LUGS ON THE BOOM TOP (SEE DETAIL STEP 9A, 9B AND 9C ON SHEET 10). REMOVE STAND ASSEMBLY (R54) AND STORE IN PARTS BOX 81028769. ASSEMBLE JIB BUTT HINGE PIN (R48) AND KEEPER PLATE (R49) IN PROPER ORIENTATION AND ATTACH COLLARS (R44) AND PINS TO RETAIN THE HINGE PIN AND KEEPER PLATE. (SEE DETAIL R AND SECTION S-S ON SHEET 7).

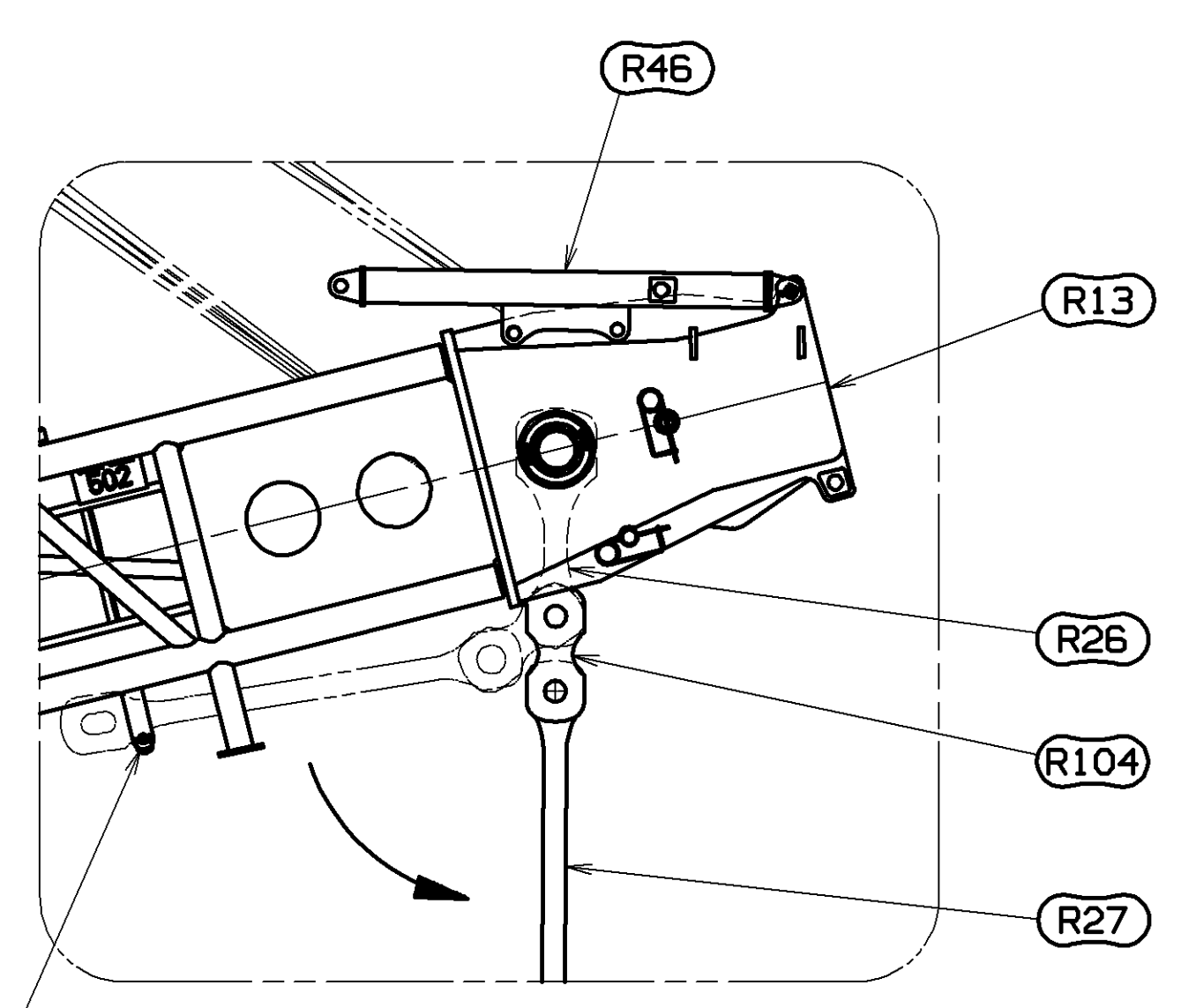


ALTERNATE STEP 8
JIB STRUT RAISING

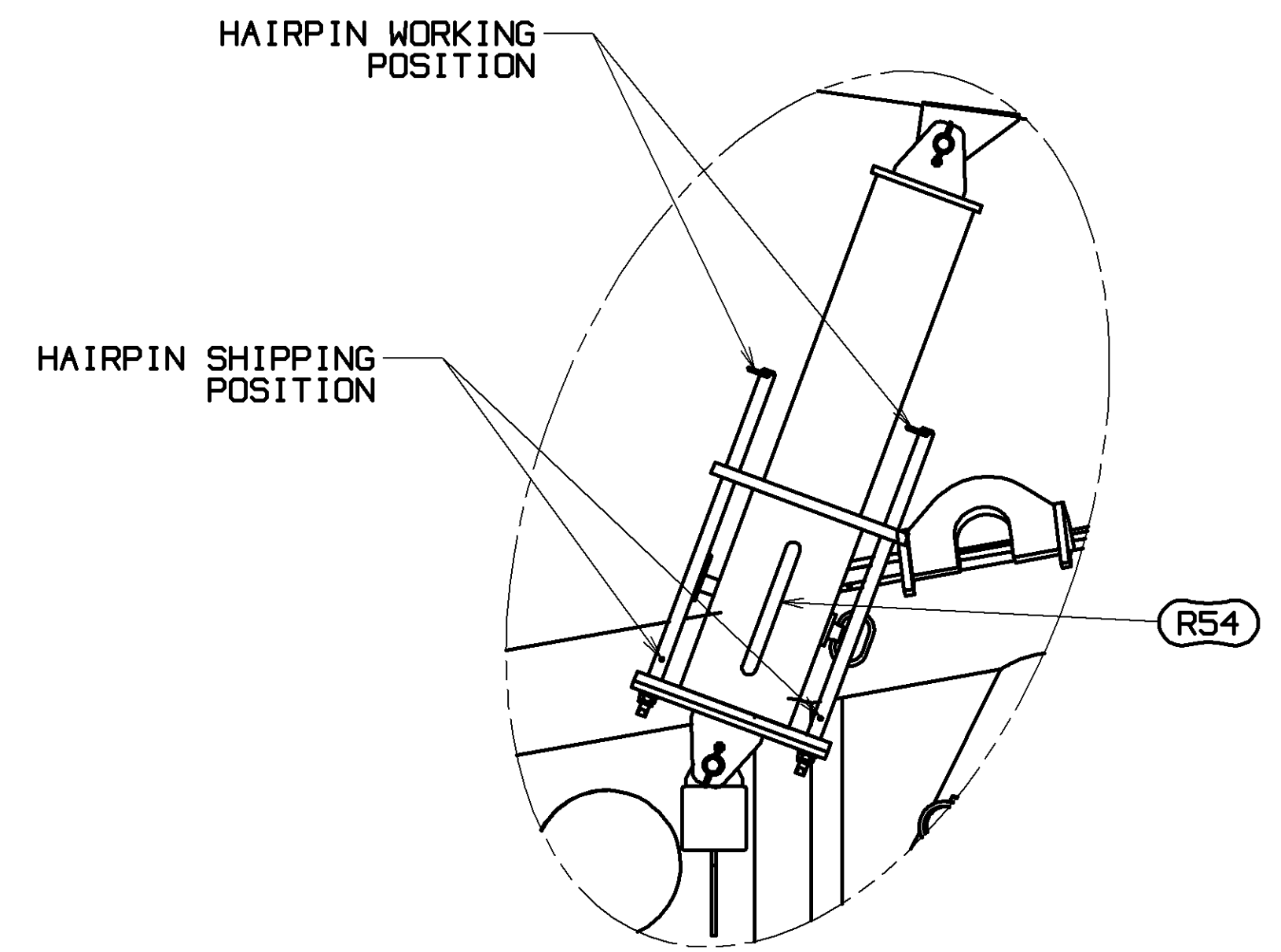
COMPLETE THE ASSEMBLY OF DESIRED JIB CONFIGURATION TO PRE-ASSEMBLED JIB BUTT ASSY. INSTALL LOWER JIB CONNECTOR PINS. (SEE DETAIL LL ON SHEET 6). ASSEMBLE STRAP/LINK CONNECTIONS BEGINNING AT THE JIB TOP. LOWER JIB STRUT TO REMOVE JIB STRUT BASIC STRAPS (R27) (R104) (R26) FROM SHIPPING BRACKET. (SEE DETAIL UU). ALIGN AND ATTACH THE BASIC STRAP (R27) TO THE FRONTSTAY SPREADER (R25). (SEE DETAIL STEP 10A ON SHEET 11). ASSEMBLE STRAP/LINK CONNECTION (R22 & R104) AT TRANSITION INSERT (ITEM 1) AND #501 INSERT. (SEE DETAIL STEP 10B ON SHEET 11). RETRACT THE LUFFING JIB HOIST LINE (DRUM 6) TO RAISE THE JIB STRUT (R13) FROM ITS ASSEMBLY POSITION.

THE LUFFING JIB IS READY FOR RAISING AND OPERATION.

RETURN TO SHEET 11 FOR UPPER BOOM POINT INSTALLATION (DETAIL PP) AND INSTRUCTIONS TO RAISE AND LOWER BOOM AND JIB.



DETAIL UU
SCALE 0.050



DETAIL VV
SCALE 0.125