

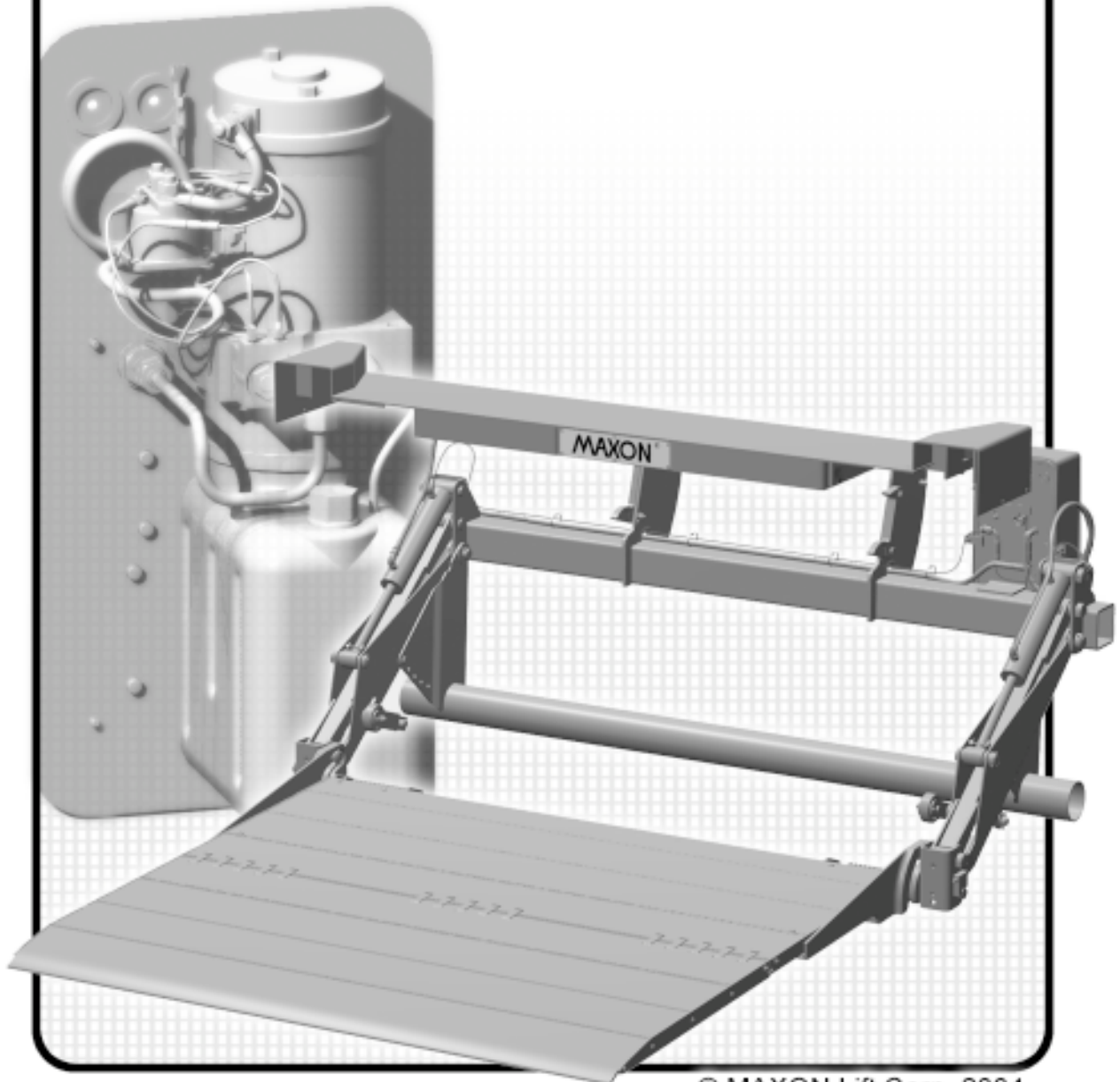
M-04-06  
JULY 2004

# MAXON®

INSTALLATION MANUAL

## GPT-25 & GPT-33

**TUK-A-WAY®**  
LIFT GATE SERIES



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Comply with the following **WARNINGS** while installing Liftgates. See Operation Manual M-04-05 for operating safety requirements.

## **WARNING**

- Read and understand the instructions in this **Installation Manual** before installing Liftgate.
- Before operating the Liftgate, read and understand the operating instructions in **Operation Manual M-04-05**.
- Comply with all **WARNING** and instruction decals attached to the Liftgate.
- Keep decals clean and legible. If decals are defaced or missing, replace them. Free replacement decals are available from **Maxon Customer Service**.
- Consider the safety and location of bystanders and location of nearby objects when operating the Liftgate. Stand to one side of the platform while operating the Liftgate
- Do not allow untrained persons to operate the Liftgate.
- Do not stand under, or allow obstructions under the platform when lowering the Liftgate. **Be sure your feet are clear of the Liftgate.**
- **Keep fingers, hands, arms, legs, and feet clear of moving Liftgate parts (and platform edges) when operating the Liftgate.**
- **Correctly stow platform when not in use. Extended platforms could create a hazard for people and vehicles passing by.**
- **Make sure vehicle battery power is disconnected** while installing Liftgate. Connect vehicle battery power to the Liftgate only when installation is complete or as required in the installation instructions.
- Wear appropriate safety equipment such as protective eyeglasses, faceshield and clothing while performing maintenance on the Liftgate and handling the battery. Debris from drilling and contact with battery acid may injure unprotected eyes and skin.
- Be careful working by an automotive type battery. Make sure the work area is well ventilated and there are no flames or sparks near the battery. Never lay objects on the battery that can short the terminals together. If battery acid gets in your eyes, immediately seek first aid. If acid gets on your skin, immediately wash it off with soap and water.
- If an emergency situation arises (vehicle or Liftgate) while operating the Liftgate, release the control Toggle Switch and the Liftgate will stop.
- A correctly installed Liftgate operates smoothly and reasonably quiet. The only noticeable noise during operation comes from the pump unit while the platform is raised and lowered. Listen for scraping, grating and binding noises and correct the problem before continuing to operate Liftgate.
- If it is necessary to stand on the platform while operating the Liftgate, keep your feet and any objects clear of the inboard edge of the platform. Your feet or objects on the platform could be trapped between the platform and the Liftgate extension plate.
- Never perform unauthorized modifications on the Liftgate. Modifications may result in early failure of the Liftgate and may create hazards for Liftgate operators and maintainers.

# GPT-25 & GPT-33 LIFTGATE COMPONENTS

## ⚠ CAUTION

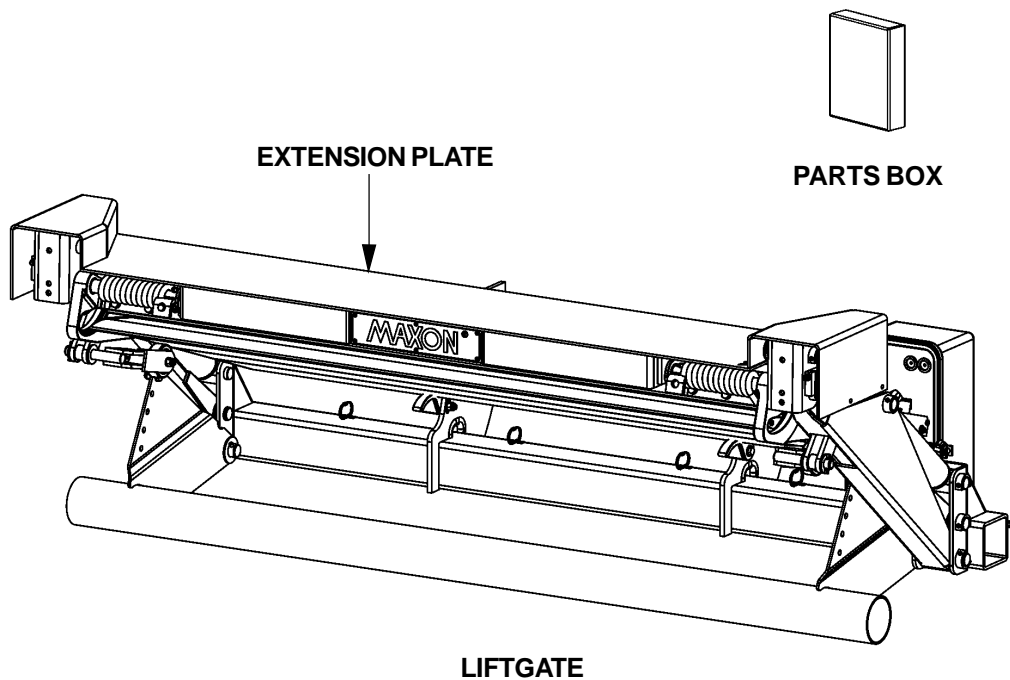
Prevent injuries and equipment damage. Before cutting the shipping straps from the Liftgate, put Liftgate on level ground that will support at least 1500 pounds. Be careful lifting and moving components after shipping straps are removed.

**NOTE:** Make sure you have all components and parts before you start installing Liftgate. Compare parts in the Part Box and each Kit Box with packing list enclosed in each box. If parts and components are missing or incorrect call:

**Maxon Customer Service**

**Call (800) 227-4116 or**

**Send e-mail to [customersupport@maxonlift.com](mailto:customersupport@maxonlift.com)**



**GPT-25 & GPT-33 COMPONENTS**

**FIG. 4-1**

## GPT-SERIES INSTALLATION PARTS BOX

ITEM	DESCCRIPTION	QTY.	PART NO.
1	FRAME CLIP, 1/2" X 1-3/8"	7	050079
2	COPPER LUG (#2 GA)	1	226778
3	SWITCH AND CABLE ASSY	1	264346
4	FUSED POWER CABLE, 200 AMP, 38' LG.	1	264422
5	DECAL & MANUAL KIT	1	-
	A. INSTALLATION MANUAL	1	M-04-06
	B. OPERATION MANUAL	1	M-04-05
	C. MAINTENANCE MANUAL	1	M-04-04
	D. WARRANTY CARD	1	M-78-78
	E. CUSTOMER SURVEY FORM	1	M-94-04
	F. DECALS		<b>REFER TO DECAL PAGES IN THIS MANUAL</b>
6	CLAMP, #10 RUBBER LOOM	2	801681
7	SELF-TAPPING SCREW, #10-24 X 1" LG.	4	900057-5
8	SHIM, PLATFORM ADJUSTMENT 1/16"	2	281166-01
9	SHIM, PLATFORM ADJUSTMENT 1/8"	2	281166-02
10	HOOK ASSEMBLY	1	227700
11	EYE, PAD	1	226938

**TABLE 5-1**

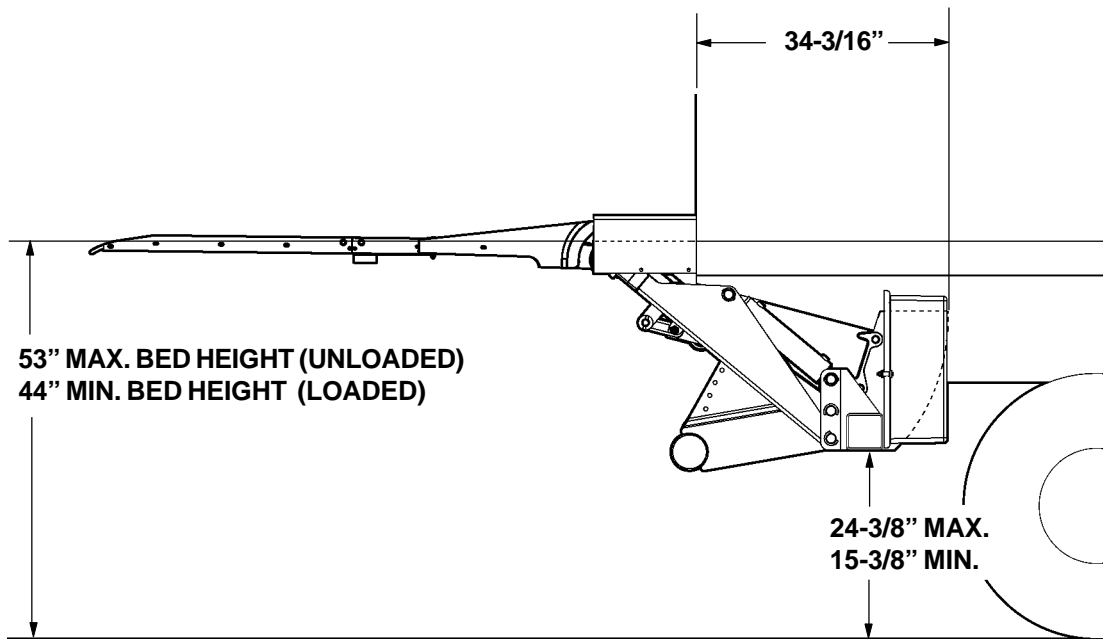
# STEP 1 - PREPARE VEHICLE

**NOTE:** The maximum operating Vehicle Body bed height for the GPT-25 and GPT-33 is 53" (unloaded). The minimum height is 44" (loaded). Do not install this Liftgate on Vehicle Bodies equipped with swing open doors.

**NOTE:** To install Liftgate correctly, you must park the Vehicle on level ground and follow the instructions in this manual.

**NOTE:** Measure the width of the Liftgate and the width of the Vehicle Body before you start doing this procedure. Ensure the Liftgate is the correct width for Vehicle.

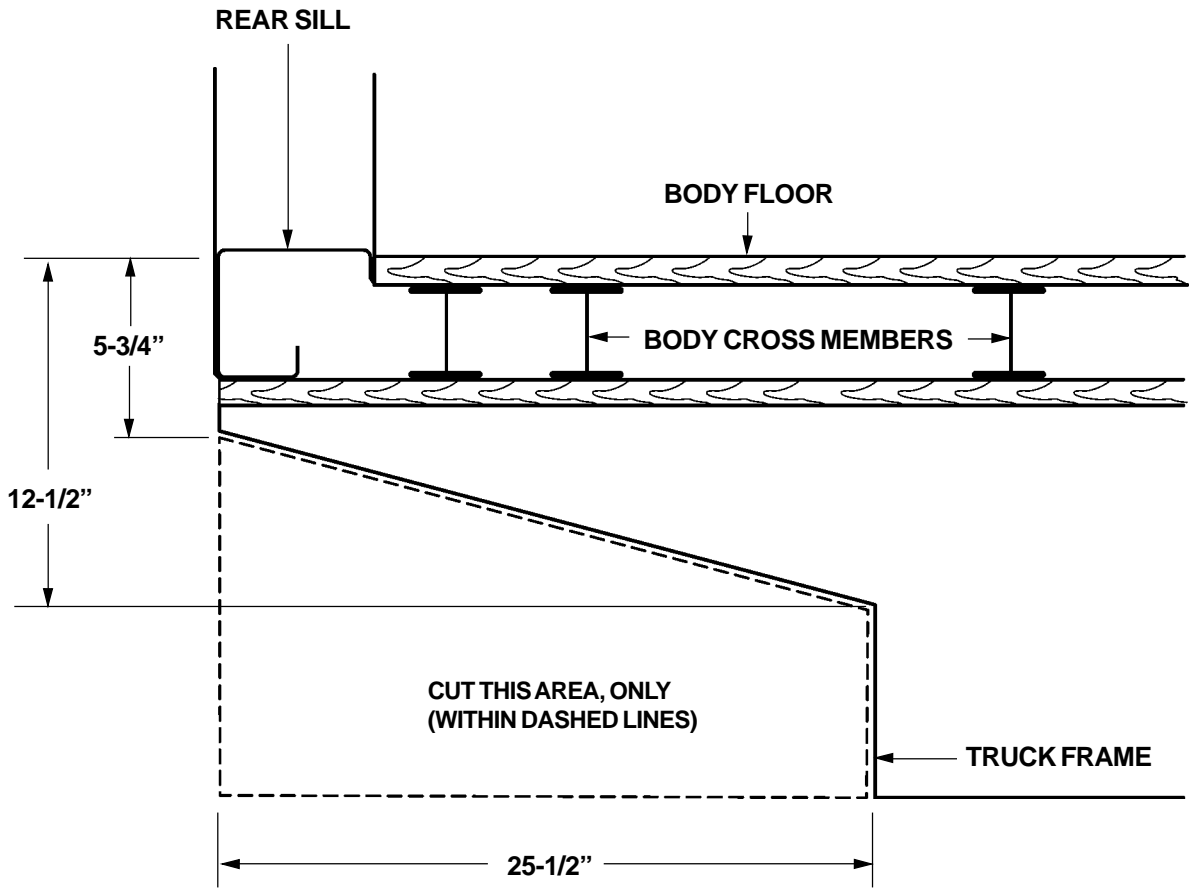
1. Check the Vehicle to ensure Liftgate will fit without interference. The Liftgate must fit within the clearance dimensions shown in **FIG. 6-1**.



LIFTGATE CLEARANCE DIMENSIONS  
FIG. 6-1

# STEP 1 - PREPARE VEHICLE - Continued

2. Fit Liftgate to truck body by cutting frame as shown in FIG. 7-1.



VEHICLE FRAME CUT FOR GPT-25 & GPT-33  
FIG. 7-1

## STEP 2 - WELD LIFTGATE TO VEHICLE

### ⚠ WARNING

Keep Liftgate clamped to forklift until Liftgate is welded (or bolted if required) to vehicle body. Liftgate may be damaged and create a hazard for the installer if it falls off the forklift.

1. Clamp Liftgate to forklift as shown in FIG. 8-1.

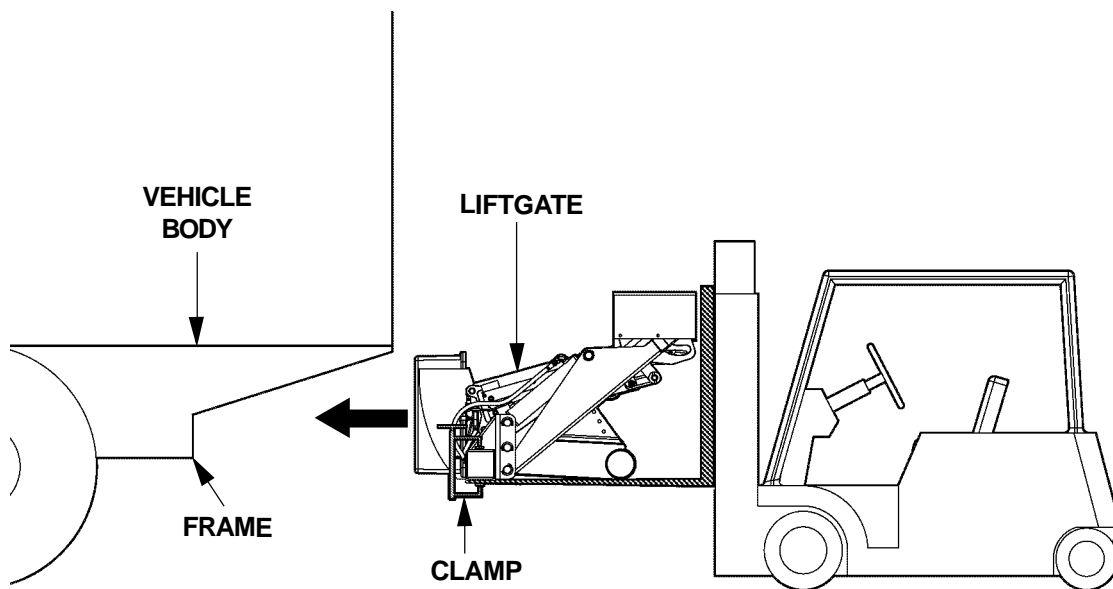


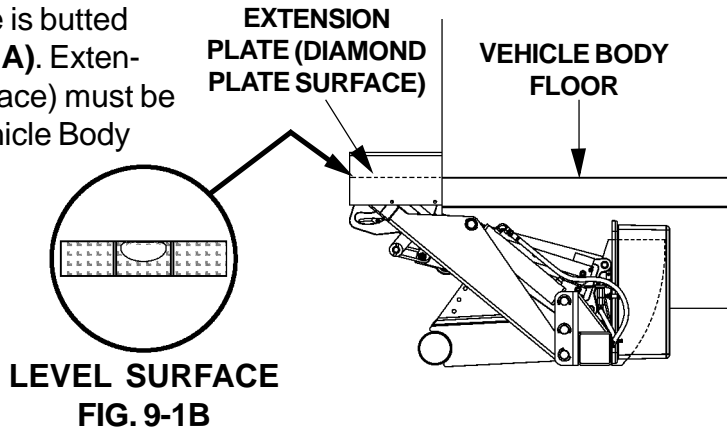
FIG. 8-1

2. Use forklift to center the Liftgate in position on the back of the Vehicle Body and Frame (FIG. 8-1). If necessary, have 1 person operate the forklift and 1 other person check alignment of Liftgate and Vehicle.



## STEP 2 - WELD LIFTGATE TO VEHICLE - Continued

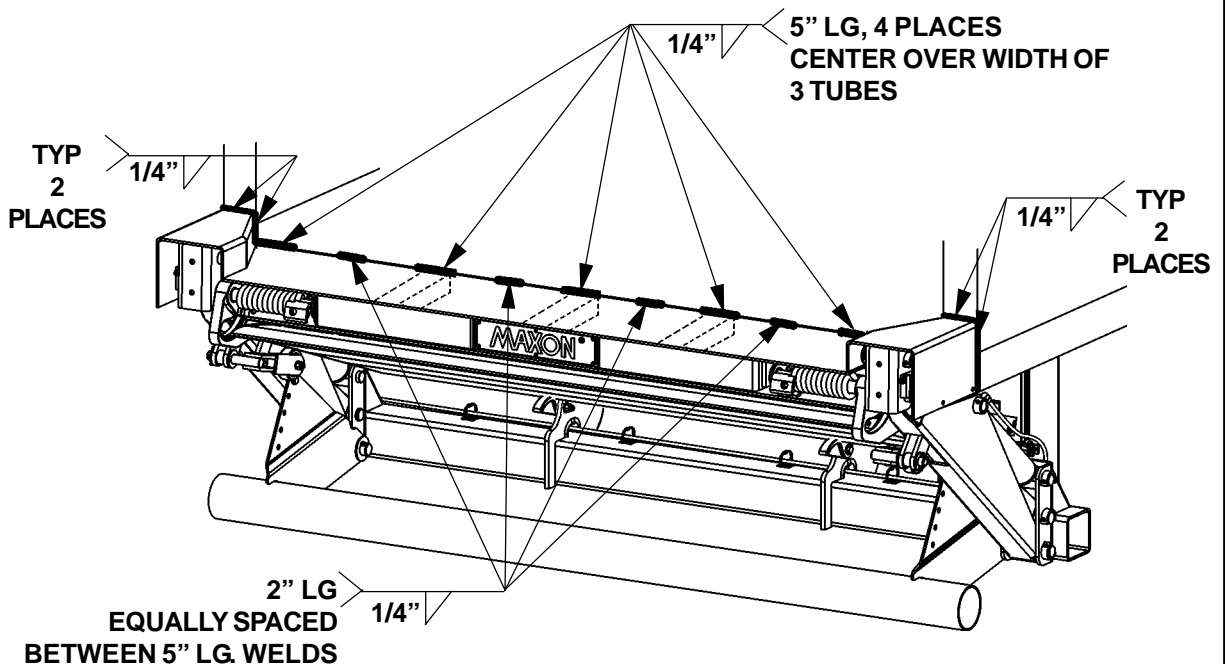
3. Make sure the Extension Plate is butted against Vehicle Body (**FIG. 9-1A**). Extension Plate (diamond plate surface) must be level and flush with floor of Vehicle Body (**FIGS. 9-1 & 9-1B**).



**SIDE VIEW OF EXTENSION PLATE AND TRUCK BODY (FORKLIFT NOT SHOWN)**  
**FIG. 9-1A**

**NOTE:** If needed, weld RH end of Extension Plate to Vehicle Body. Then ensure Extension Plate (diamond plate surface) is flush with Vehicle Body and level before welding LH end. Weld the floor level portion of the Extension Plate after the ends are correctly welded.

4. Weld the top of Extension Plate to Vehicle Body sill as shown in **FIG. 9-2**.



**EXTENSION PLATE WELDS - VIEWED FROM ABOVE**  
**(FORKLIFT NOT SHOWN)**  
**FIG. 9-2**

## STEP 2 - WELD LIFTGATE TO VEHICLE - Continued

### ⚠ WARNING

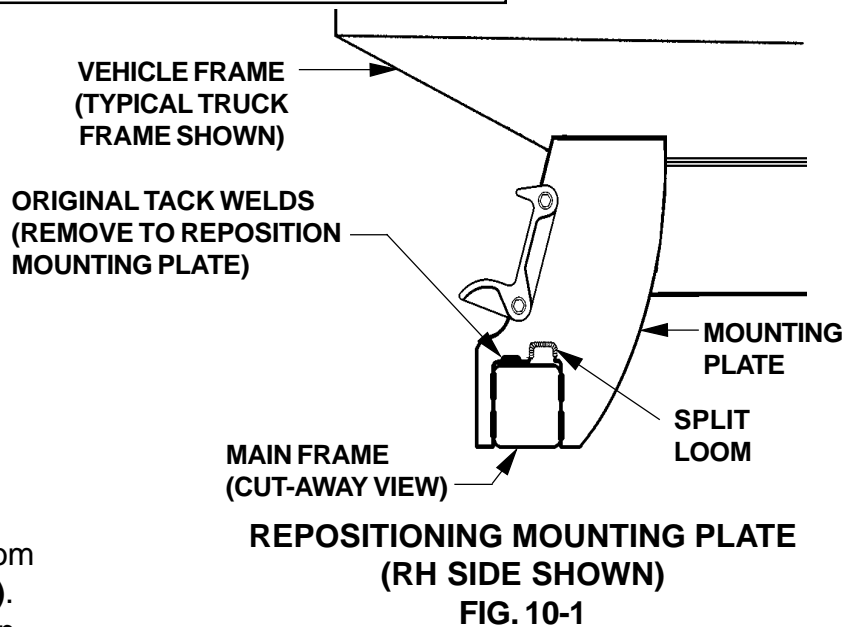
Liftgate is shipped from factory with Mounting Plates that are only Tack Welded to Main Frame. Weld as shown in illustration before operating Liftgate.

### CAUTION

Prevent damaged hydraulic hoses and saddles. Before welding next to hydraulic hoses and saddles, protect the hoses and saddles with a heat-resistant cover.

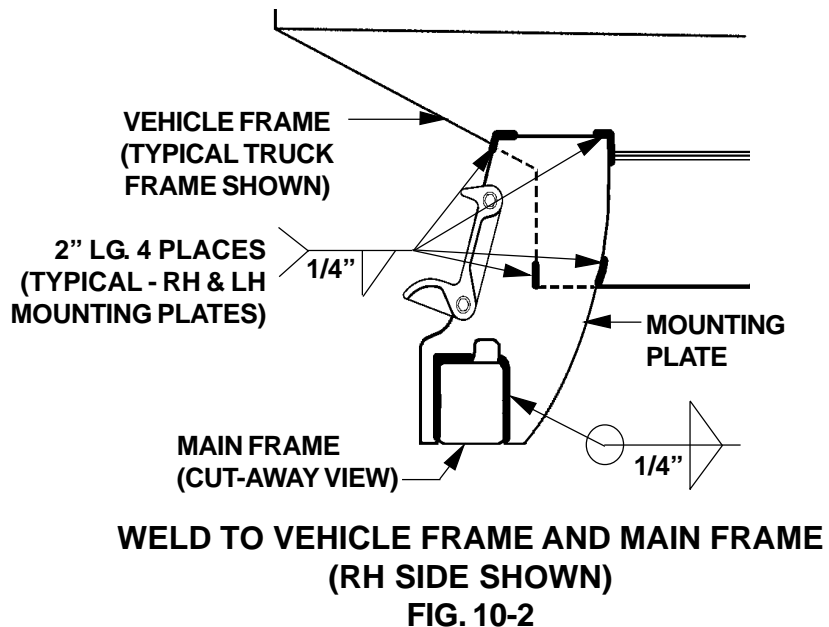
**NOTE:** Weld both Mounting Plates to vehicle frame before welding Mounting Plates to Main Frame.

5. Check if both Mounting Plates line up with the vehicle frame. If the Mounting Plates do not line up, remove the tack welds from one Mounting Plate (**FIG. 10-1**). Make sure Liftgate stays centered on vehicle. Reposition the Mounting Plate against vehicle frame.



6. Remove the Split Loom from Mounting Plate (**FIG. 10-1**). Save the Split Loom to reinstall.

7. Clamp Mounting Plate to vehicle frame. Weld the Mounting Plate to vehicle frame as shown in **FIG. 10-2**. Next, weld Mounting Plate to Main Frame (**FIG. 10-2**). Remove clamp.



8. Repeat instructions 5 through 7 for the second Mounting Plate.

## STEP 2 - WELD LIFTGATE TO VEHICLE - Continued

9. Remove clamps from forklift and Liftgate. Back out forklift (FIG. 11-1).

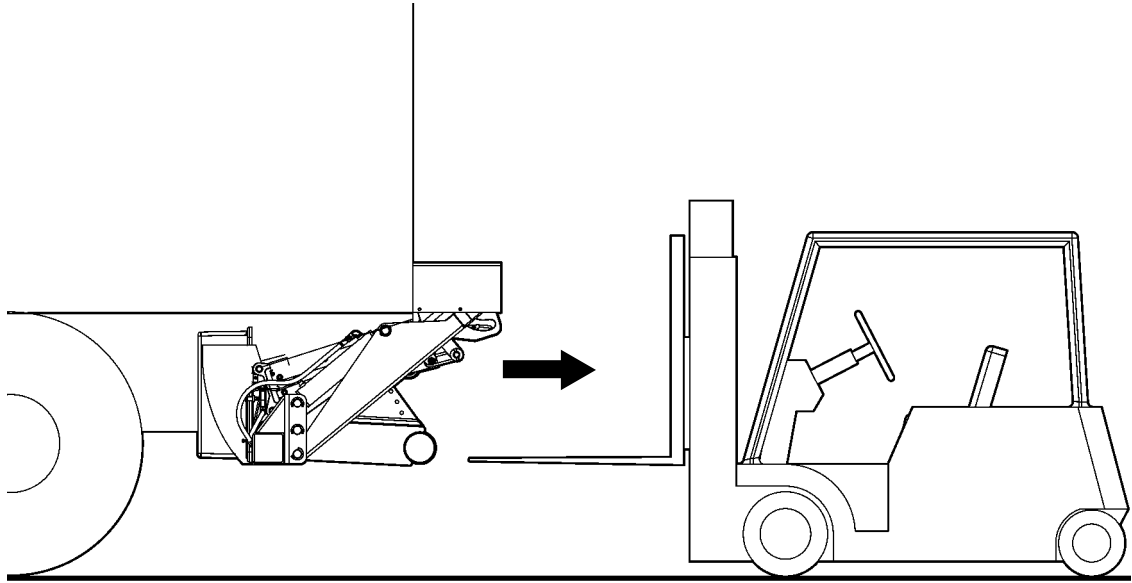


FIG. 11-1

## STEP 3 - RUN POWER CABLE

### ⚠ CAUTION

Never route an energized wire. Make sure the vehicle battery is disconnected. Always route electrical wires clear of moving parts, brake lines, sharp edges and exhaust systems. Avoid making sharp bends in wiring. Attach securely. If drilling is necessary, first check behind the drilling surface so you do not damage any fuel lines, vent lines, brake lines or wires.

Clip Fused Power Cable to vehicle chassis, with fuse nearest the vehicle battery, as shown in **FIG. 12-1**. Keep enough cable near the battery to reach the positive terminal without straining cable (after connection). Run cable to Pump Box on Liftgate.

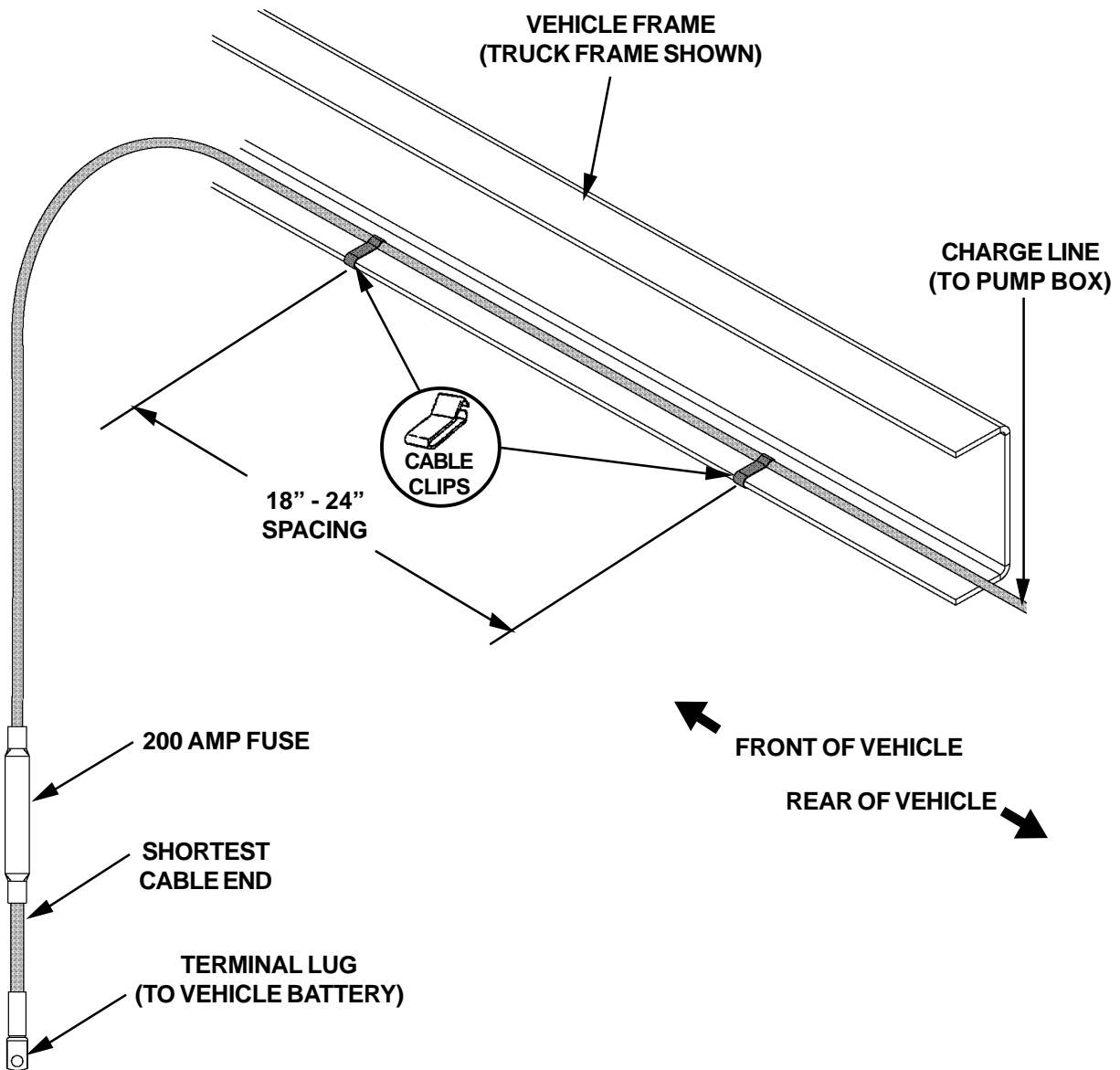


FIG. 12-1

# STEP 4 - CONNECT POWER CABLE

1. Unbolt the Pump Cover as shown in FIG. 13-1.

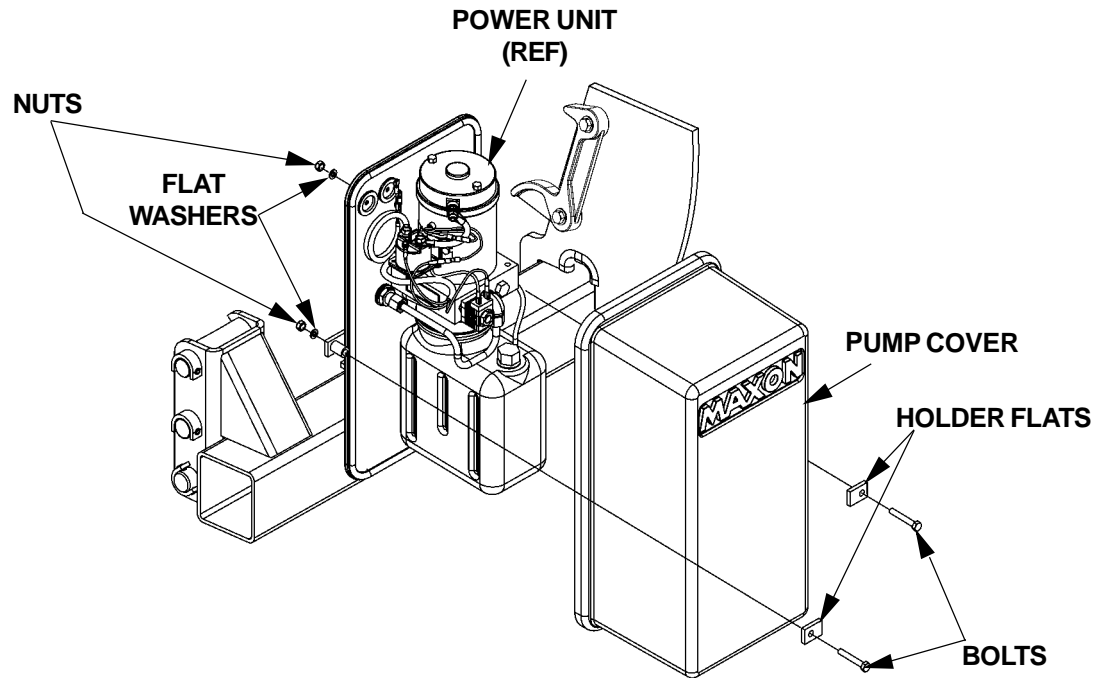
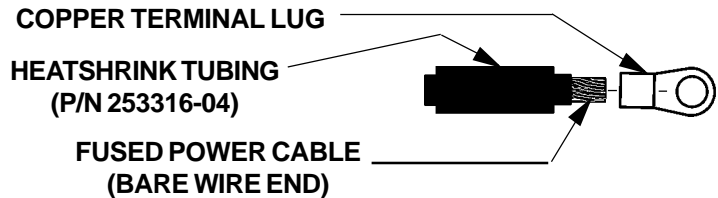


FIG. 13-1

## STEP 4 - CONNECT POWER CABLE - Continued

**NOTE:** Electrical lines must be run into Pump Box through sealing grommets (**FIG. 14-3**). to keep a good seal on hydraulic & electrical lines, never cut the sealing grommets.

- Run fused Power Cable through Grommet on Pump Mounting Plate (**FIG. 14-3**).
- On the bare wire end of Fused Power Cable, keep enough length to attach copper terminal lug and reach Motor Solenoid without putting tension on cable (after connection) (**FIG. 14-1**). Measure (if needed) and then cut excess cable from bare wire end of cable. Put heatshrink tubing (Parts Box) (**FIG. 14-1**) on the end of the cable (leave room for terminal lug). Crimp copper terminal lug (from Parts Box) on the Fused Power Cable and shrink the Heatshrink Tubing (**FIG. 14-2**).



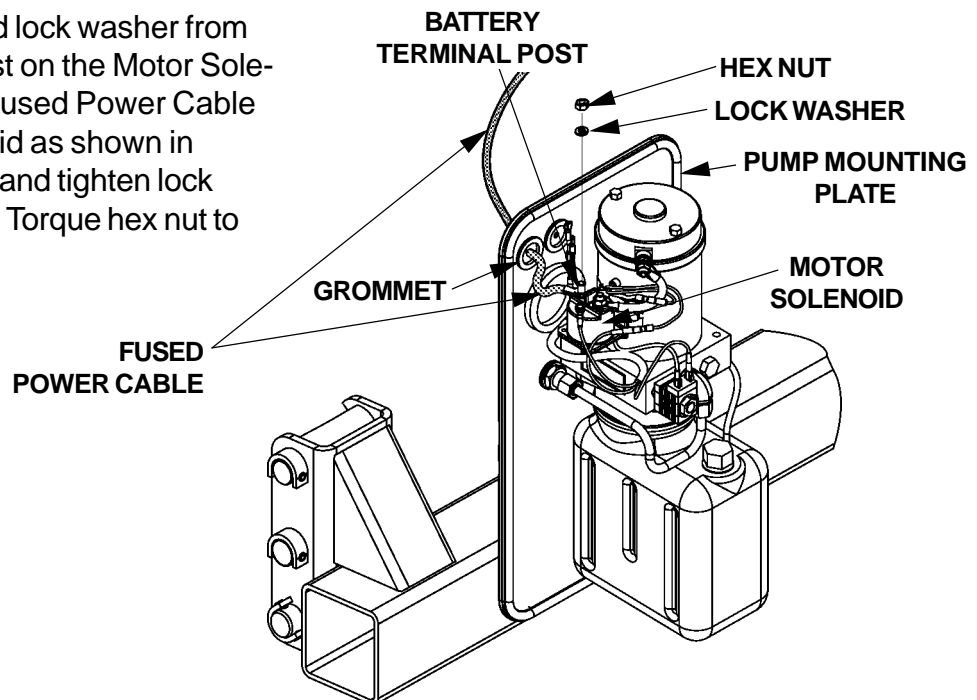
**PLACING TERMINAL LUG & HEATSHRINK TUBING ON FUSED POWER CABLE**  
**FIG. 14-1**



**TYPICAL FUSED POWER CABLE WITH TERMINAL LUG INSTALLED**  
**FIG. 14-2**

**NOTE:** MAXON recommends using dielectric grease on all electrical connections.

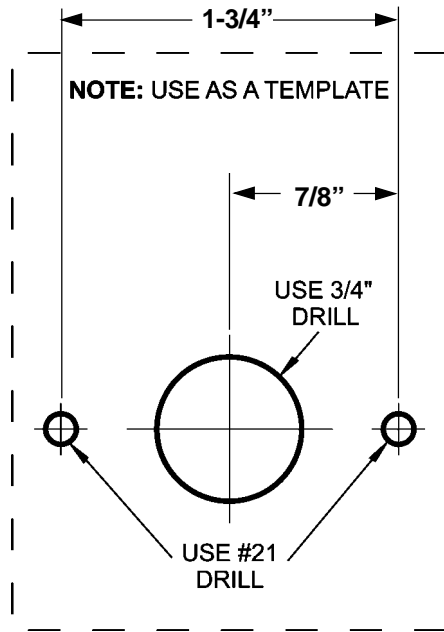
- Remove hex nut and lock washer from Battery terminal post on the Motor Solenoid. Connect the Fused Power Cable to the Motor Solenoid as shown in **FIG. 14-3**. Reinstall and tighten lock washer and hex nut. Torque hex nut to **95 LBS.-IN.**



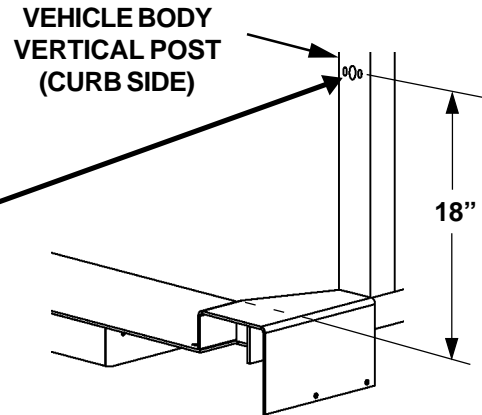
**TYPICAL FUSED POWER CABLE CONNECTION (GRAVITY DOWN PUMP SHOWN)**  
**FIG. 14-3**

## STEP 5 - INSTALL CONTROL SWITCH

1. Drill one 3/4" hole and two #21-size holes in the vertical post on curb side of vehicle body as shown in **FIG. 15-1A**. Use template shown in **FIG. 15-1B**.



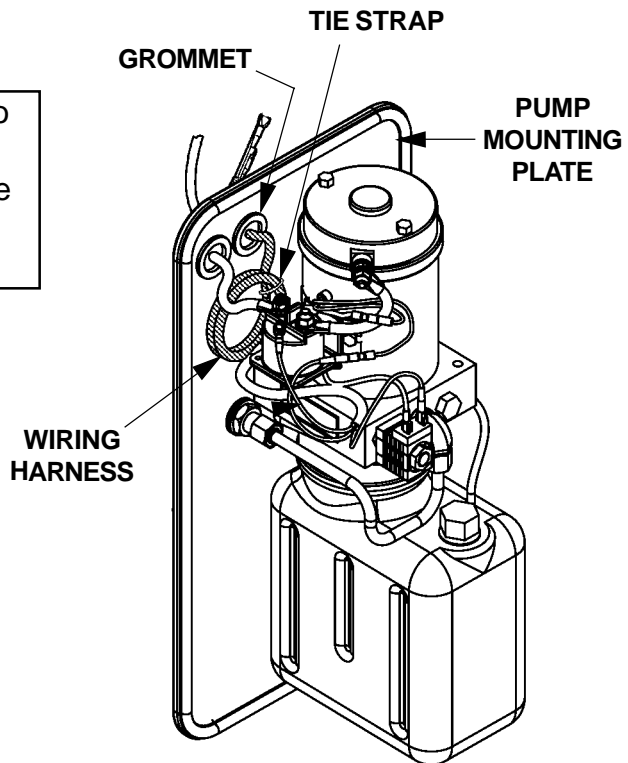
**HOLE DRILLING TEMPLATE  
FIG. 15-1B**



**RECOMMENDED POSITION FOR  
CONTROL SWITCH  
FIG. 15-1A**

**NOTE:** Electrical lines must be run into Pump Box through sealing grommets (**FIG. 15-2**). To keep a good seal on the electrical lines, never cut the sealing grommets.

2. Cut Tie Strap on coiled Wiring Harness (**FIG. 15-2**). Pull the Wiring Harness through grommet on the Pump Mounting Plate (**FIG. 15-2**).

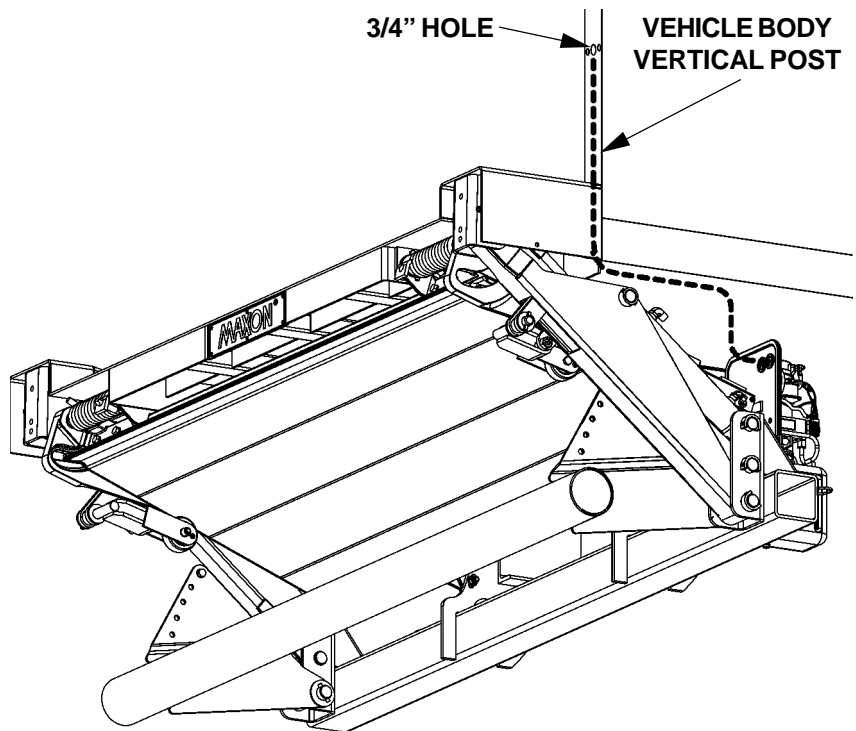


**FIG. 15-2**

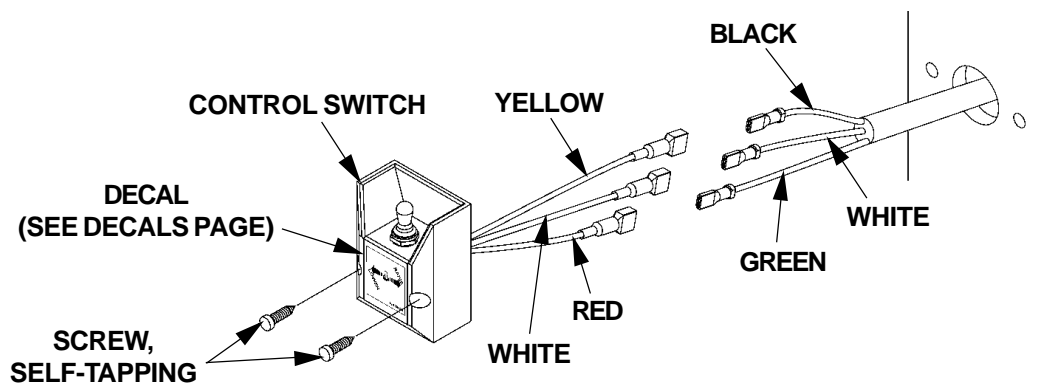
## STEP 5 - INSTALLING CONTROL SWITCH - Continued

**NOTE:** MAXON recommends using dielectric grease on all electrical connections.

3. Run wiring harness under Vehicle Body (see dashed line - FIG. 16-1) and up through inside of Vertical Post. Then pull Control Switch wiring harness out the 3/4" hole drilled in Vertical Post (FIG. 16-1). Connect the Control Switch wiring to the wiring harness as shown in FIG. 16-2. Push extended wiring back into the 3/4" hole in the Vertical Post until Control Switch touches the post. Attach the Control Switch to Vertical Post with 2 self-tapping screws (FIG. 16-2).



**ROUTING CONTROL SWITCH WIRING**  
**FIG. 16-1**



**CONTROL SWITCH WIRING CONNECTIONS**  
**FIG. 16-2**



# STEP 6 - ADD HYDRAULIC FLUID TO RESERVOIR

## CAUTION

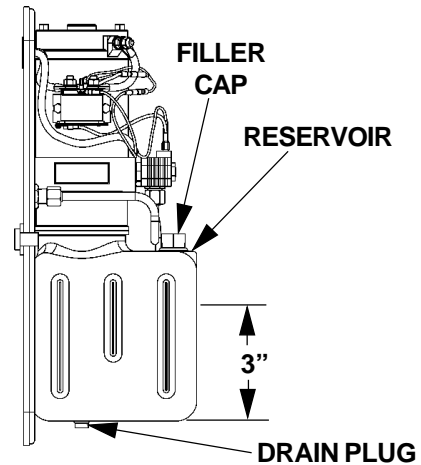
Keep dirt, water and other contaminants from entering the hydraulic system. Before opening the hydraulic fluid reservoir filler cap, drain plug and hydraulic lines, clean up contaminants that can get in the openings. Also, protect the openings from accidental contamination.

**NOTE:** Use correct grade of hydraulic fluid for your location.

- +70 to +140 Degrees F - Grade ISO 32
- +40 to +105 Degrees F - Grade ISO 15
- Below + 70 Degrees F - Grade ISO 10 or MIL-H-5606

See TABLES 18-1, 18-2, & 18-3 for recommended brands.

1. Pull out Filler Cap (no threads) shown in FIG. 17-1. Fill the Reservoir (FIG. 17-1) with Hydraulic Fluid to 3" above the bottom (FIG. 17-1).



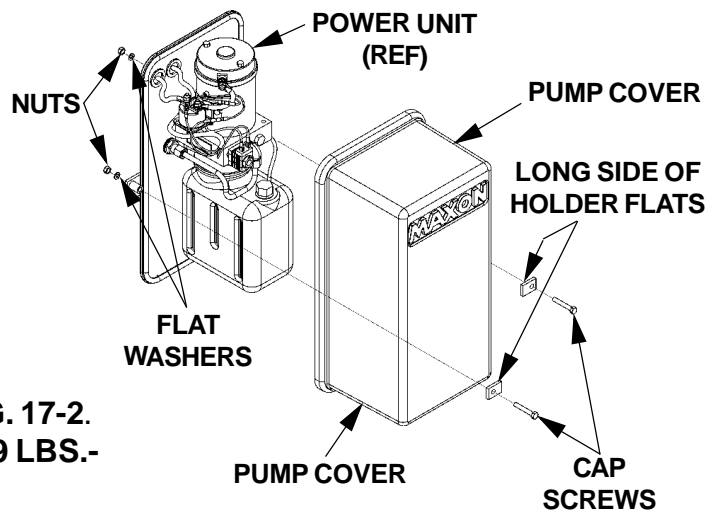
**PUMP RESERVOIR  
(GRAVITY DOWN POWER UNIT SHOWN)  
FIG. 17-1**

2. Reinstall Filler Cap (FIG. 17-1).

3. Check that electrical connections are tight and there are no leaks in hydraulic system.

## CAUTION

Pump Cover must be correctly secured to prevent it from becoming a hazard. To secure Pump Cover, the long side of the Holder Flats must be installed as shown in the illustration.



**UNBOLTING / BOLTING PUMP COVER  
FIG. 17-2**

4. Bolt on the Pump Cover as shown in FIG. 17-2. Torque the 5/16"-18 cover bolts 20 to 29 LBS.-FT.

## STEP 6 - ADD HYDRAULIC FLUID TO RESERVOIR - Continued

ISO 32 HYDRAULIC OIL	
RECOMMENDED BRANDS	PART NUMBER
AMSOIL	AWH-05
CHEVRON	HIPERSYN 32
KENDALL	GOLDEN MV
SHELL	TELLUS T-32
EXXON	UNVIS N-32
MOBIL	DTE-13M, DTE-24, HYDRAULIC OIL-13

**TABLE 18-1**

ISO 15 HYDRAULIC OIL	
RECOMMENDED BRANDS	PART NUMBER
AMSOIL	AWF-05
CHEVRON	FLUID A, AW-MV-15
KENDALL	GLACIAL BLU
SHELL	TELLUS T-15
EXXON	UNVIS HVF-13
MOBIL	DTE-11M

**TABLE 18-2**

ISO-10 OR MIL-H-5606 HYDRAULIC FLUID	
RECOMMENDED BRANDS	PART NUMBER
AMSOIL	N/A
CHEVRON	FLUID A, FLUID G
KENDALL	GLACIAL BLU
SHELL	AEROSHELL FLUID-41
EXXON	UNVIS HVF-13
MOBIL	AERO HFA

**TABLE 18-3**

## STEP 7 - CONNECT POWER CABLE TO BATTERY

**NOTE:** MAXON recommends using dielectric grease on all electrical connections.

Remove nut from positive (+) battery terminal connector. Connect Power Cable to the positive (+) battery terminal connector (**FIG. 19-1**). Reinstall and tighten nut.

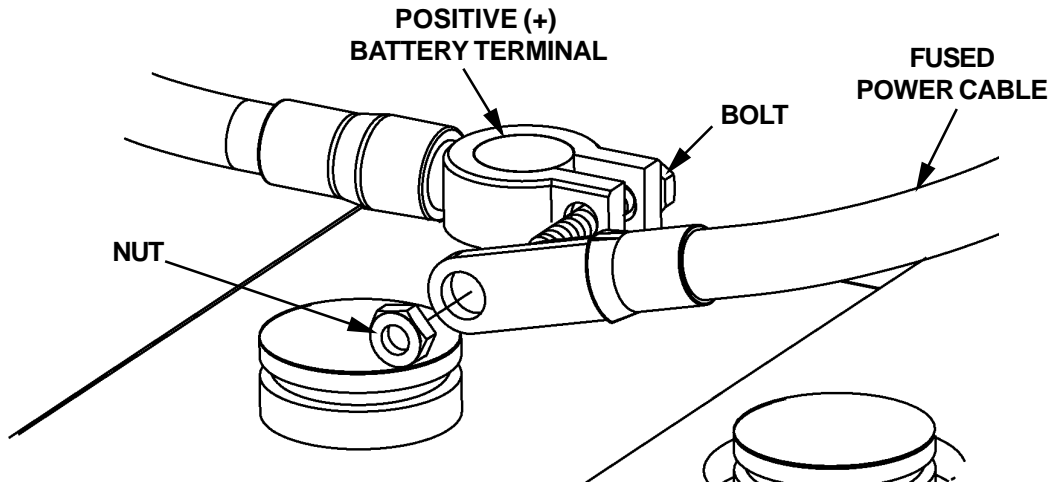


FIG. 19-1

## STEP 8 - REMOVE LOCKING BRACKETS

### **⚠ WARNING**

To prevent possible injury, never work in the area under the Platform. Get access to the Locking Angle from the back of the Liftgate.

**NOTE:** To operate Liftgate, Locking Bracket must be removed.

1. Push the Control Switch to **RAISE** position to pressurize Hydraulic System. Unbolt Installation Bracket (**FIG. 20-1B**) from Right Hand (RH) side of Extension Plate (**FIG. 20-1A**). Repeat for LH side.

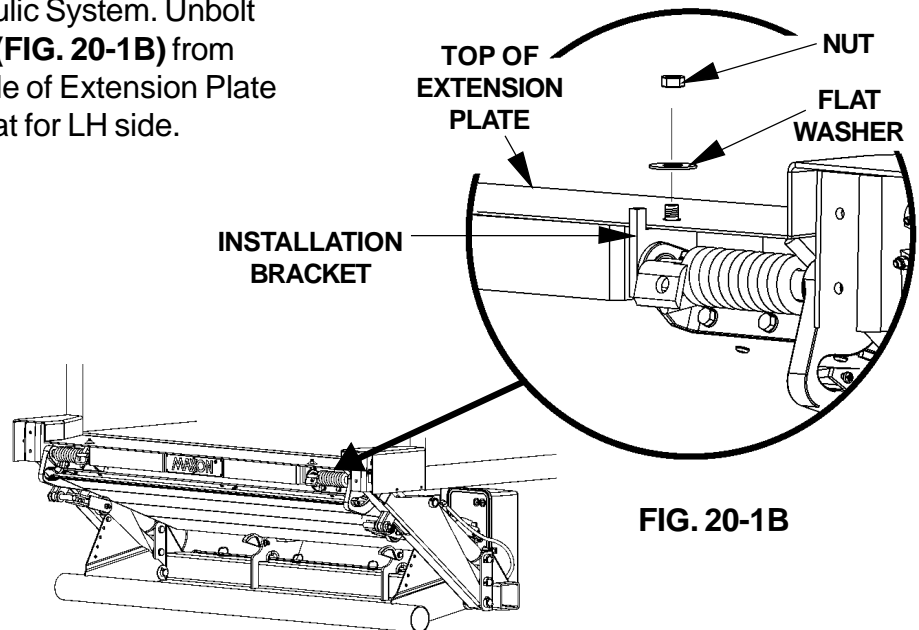
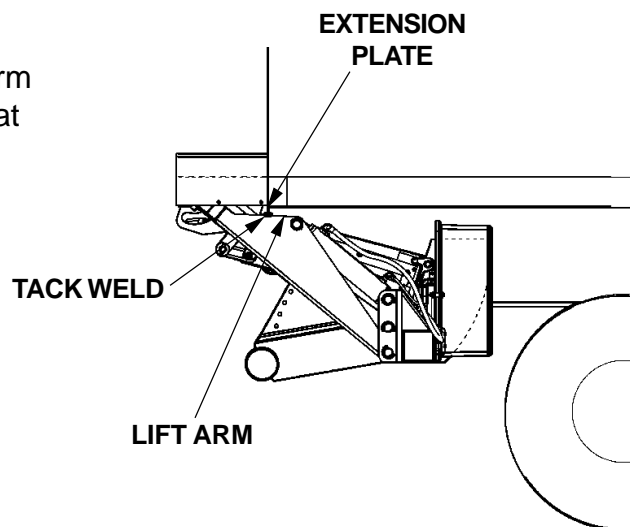


FIG. 20-1A

FIG. 20-1B

2. Remove tack weld between each Lift Arm and Extension Plate (**FIG. 20-2**). Repeat for LH Side of Liftgate.



REMOVING TACK WELD  
(RH SIDE OF LIFTGATE SHOWN)  
FIG. 20-2

## STEP 8 - REMOVE LOCKING BRACKETS - Continued

3. Lower the Liftgate to ground level. Remove both Installation Brackets. Keep both Brackets in case Liftgate needs to be repositioned (FIGS. 21-1A & 21-1B).

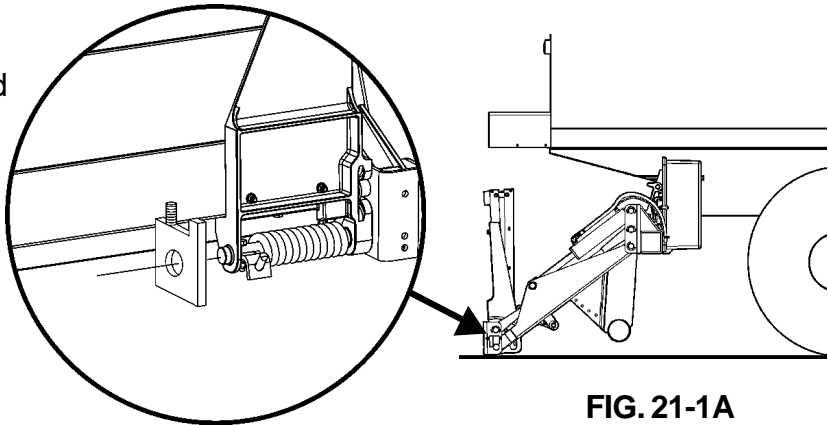


FIG. 21-1B

FIG. 21-1A

4. Unfold Platform and Flipover (FIG. 21-2).

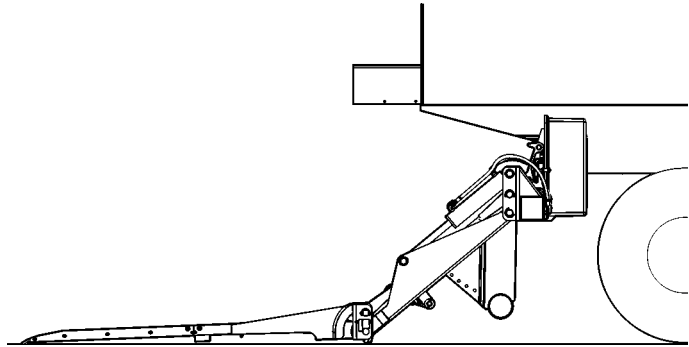


FIG. 21-2

5. Unbolt the Locking Brackets from both Cylinders (FIG. 21-3).

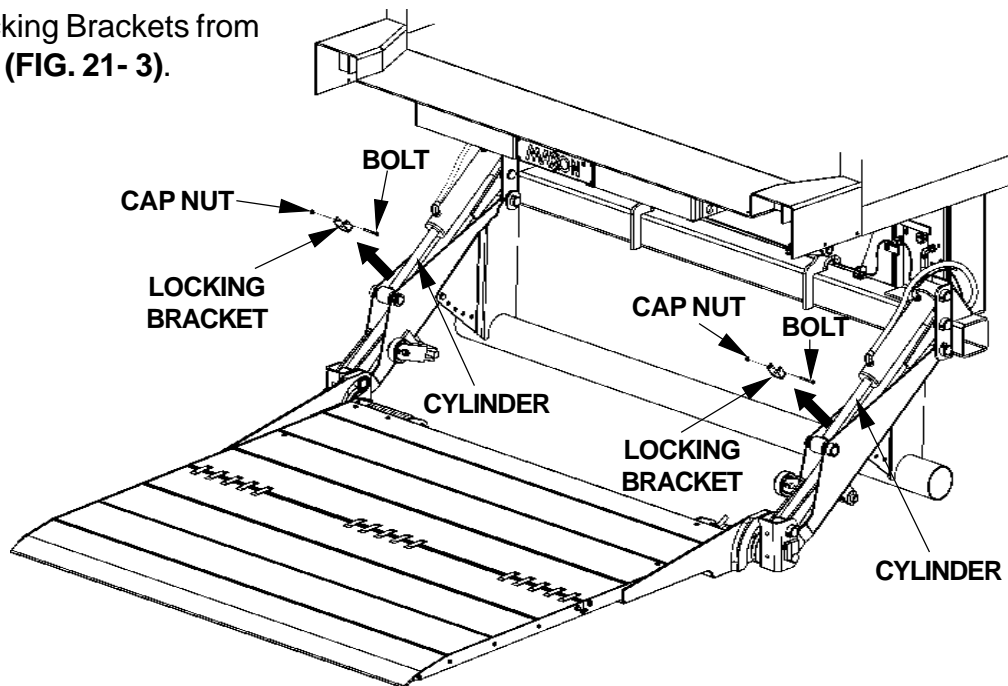
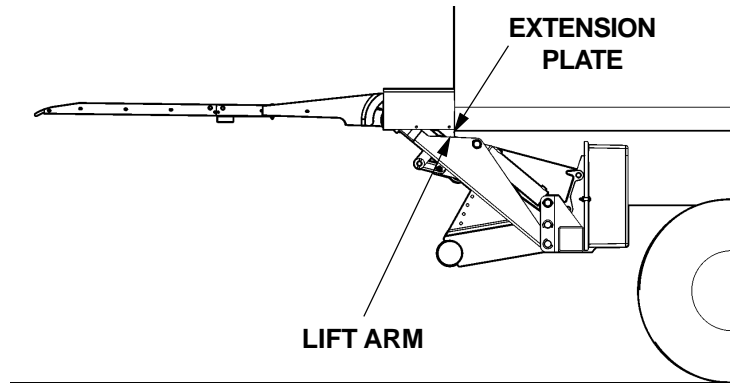


FIG. 21-3

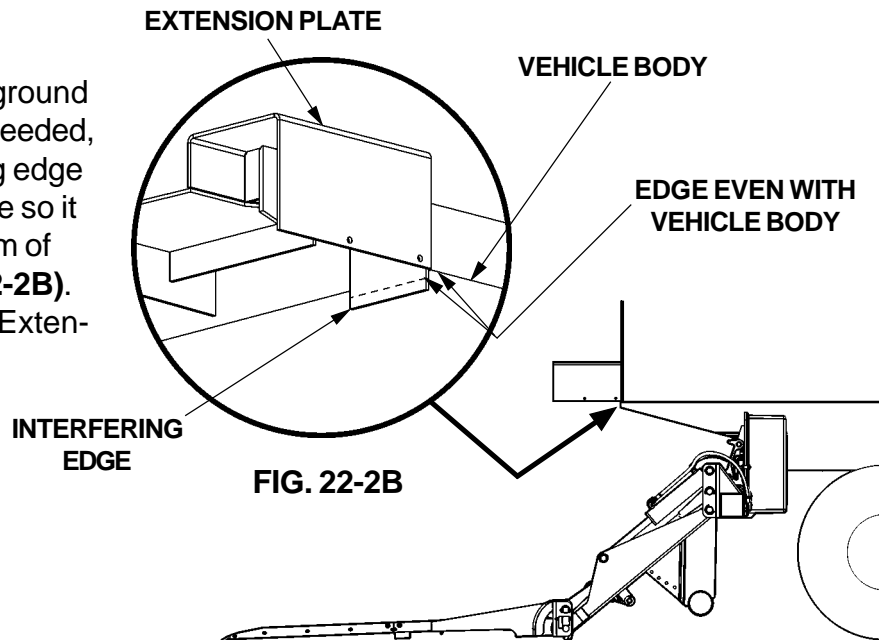
## STEP 8 - REMOVE LOCKING BRACKETS - Continued

6. Raise the Liftgate to Vehicle Bed Height. Check if Extension Plate interferes with Lifting Arm (**FIG. 22-1**).



**FIG. 22-1**

7. Lower the Liftgate to ground level (**FIG. 22-2A**). If needed, remove the interfering edge on the Extension Plate so it is even with the bottom of Vehicle Body (**FIG. 22-2B**). repeat for LH Side of Extension Plate.



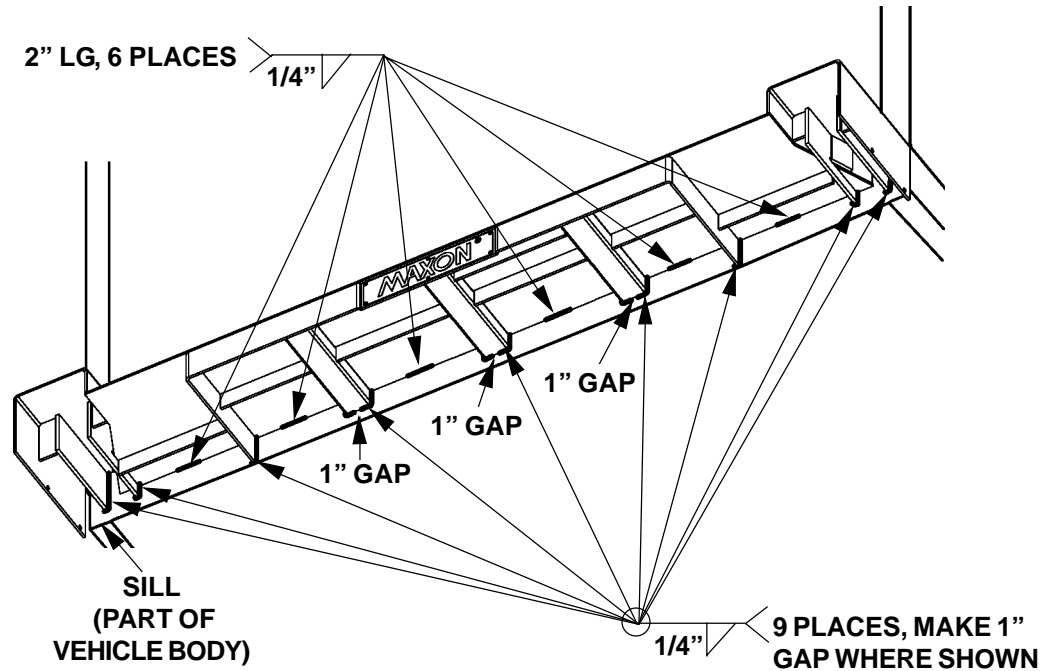
**FIG. 22-2B**

**PLATFORM AT GROUND LEVEL  
(RH SIDE SHOWN)**

**FIG. 22-2A**

# STEP 9 - FINISH WELDING EXTENSION PLATE

Weld the bottom of Extension Plate to Vehicle Body Sill as shown in FIG. 23- 1.



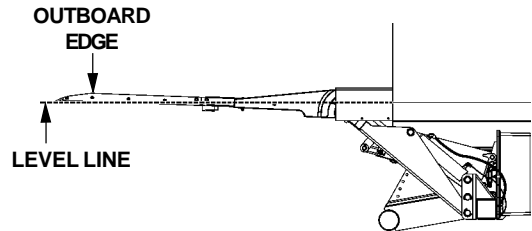
EXTENSION PLATE WELDS - VIEWED FROM UNDERNEATH  
FIG. 23-1

# STEP 10 - ADJUST PLATFORM (IF REQUIRED)

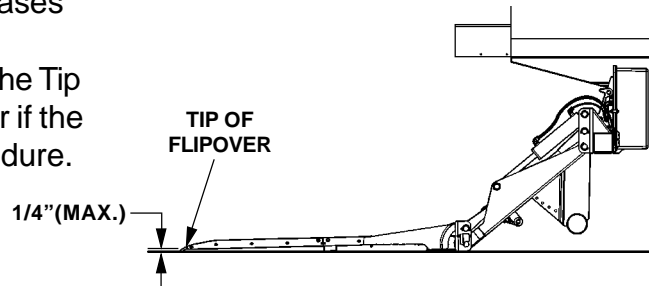
**NOTE:** In most cases, if Liftgate is installed according to the instructions in this manual, Platform will not require adjustment. Use the following instructions to check the Platform. Then adjust the Platform only if required.

**NOTE:** Before doing the following procedure, make sure vehicle is still parked on level ground.

- 1. RAISE** Platform to bed height. Outboard edge on top of Flipover should be above bed level (**FIG. 24-1**). **LOWER** Platform to ground level. Shackles and tip of Flipover should touch the ground at the same time (**FIG. 24-2**). Tip of Flipover must not be higher than 1/4" above the ground. If indications are correct in both cases (**FIGS. 24-1 & 24-2**), Liftgate is installed correctly and no adjustment is needed. If the Tip of Flipover is too high above the ground or if the Shackles are off the ground, do this procedure.



**PLATFORM EDGE ABOVE  
BED LEVEL  
FIG. 24-1**



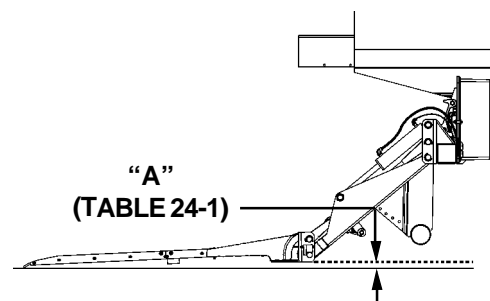
**PLATFORM & SHACKLES  
TOUCH GROUND  
FIG. 24-2**

**NOTE:** If Shackle does not touch the ground (**FIG. 24-3**), do instruction 2. If the Tip of the Flipover is more than 1/4" above the ground (**FIG. 1-2**), skip instructions 2 - 5 and do instruction 6.

- 2.** Make sure Platform is still at ground level. If the Shackle is not touching the ground, measure and compare distance "A" (**FIG. 24-3**) with **TABLE 24-1** to determine the correct shim.

RAISE TIP OF FLIPOVER THIS DISTANCE "A"	REQUIRED SHIM THICKNESS	WELD SIZE "W"
1"	1/16"	1/32"
2"	1/8"	1/16"

**TABLE 24-1**

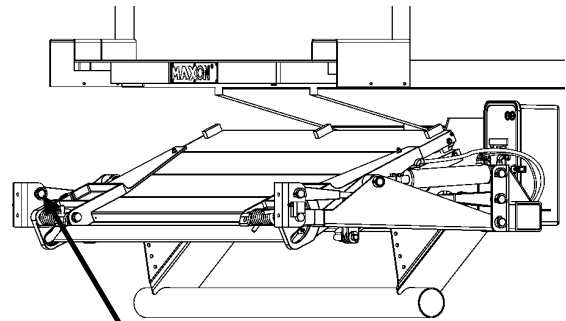


**SHACKLES DO NOT  
TOUCH GROUND  
FIG. 24-3**



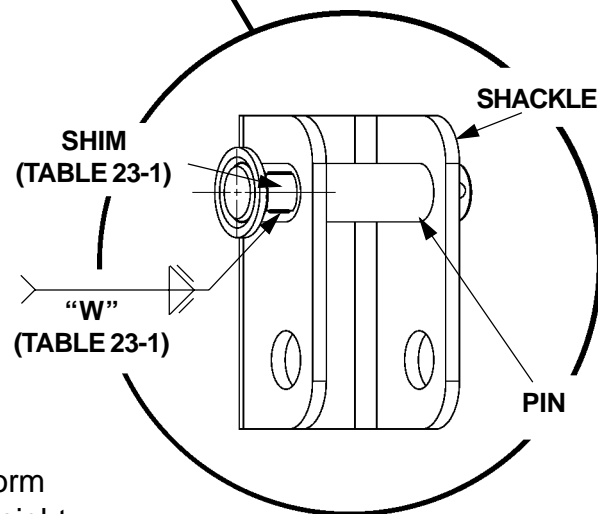
## STEP 10 - ADJUST PLATFORM (IF REQUIRED) - Continued

3. Fold the Flipover and Platform. Then raise the Platform to position shown in **FIG. 25-1A**.



**FIG. 25-1A**

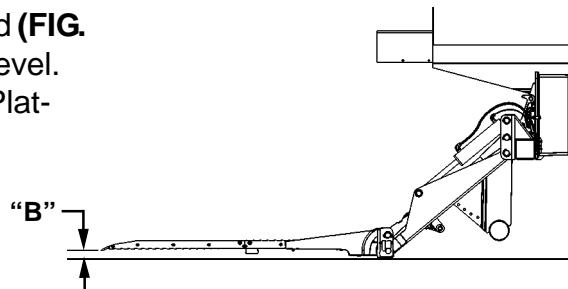
4. Use **TABLE 23-1** to select the correct size shim and refer to **TABLE 23-1** for the correct shim to get from the Parts Box. Weld shim to Pin as shown in **FIG. 25-1B**.



**FIG. 25-1B**

5. Lower Platform to the ground. Unfold Platform and Flipover. **RAISE** the Platform to bed height, then **LOWER** it to the ground. The tip of Flipover and Shackle should touch the ground as shown in **FIG. 23-1**.

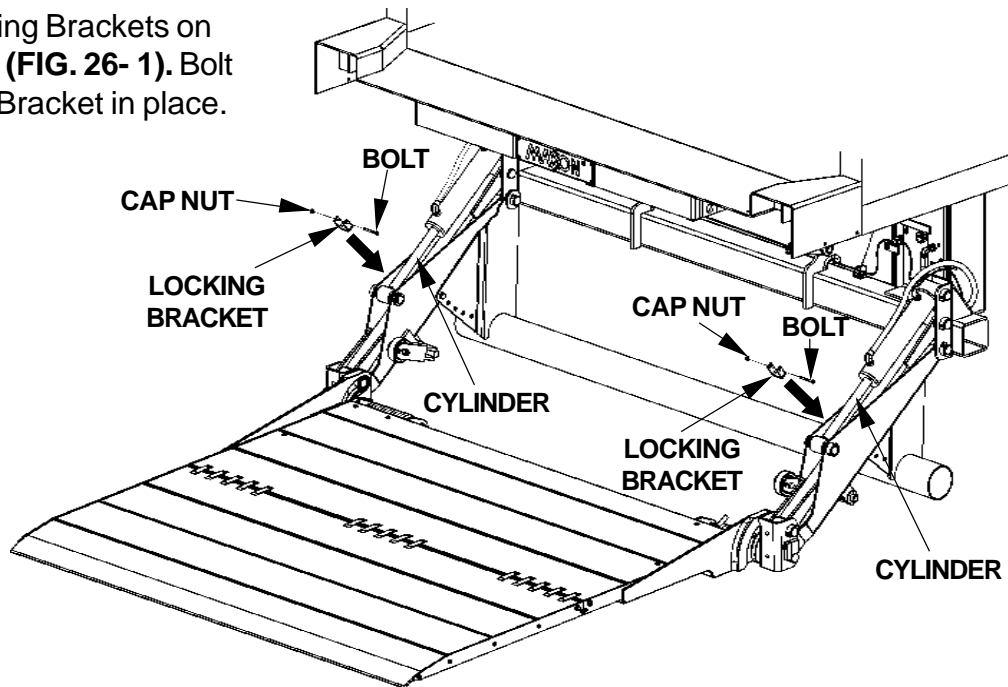
6. If the tip of Flipover is not touching the ground (**FIG. 25-2**), note the distance "**B**" above ground level. Distance "**B**" will be used for adjusting the Platform later in this procedure.



**FIG. 25-2**

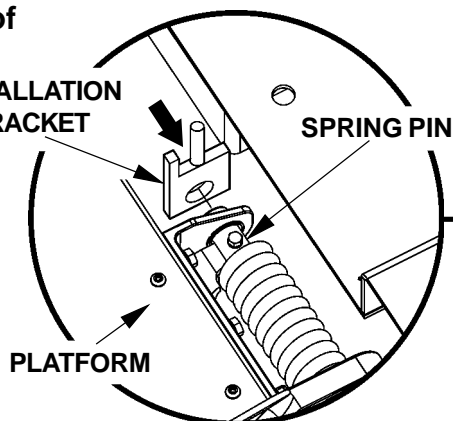
## STEP 10 - ADJUST PLATFORM (IF REQUIRED) - Continued

7. Reinstall Locking Brackets on both Cylinders (**FIG. 26- 1**). Bolt each Locking Bracket in place.



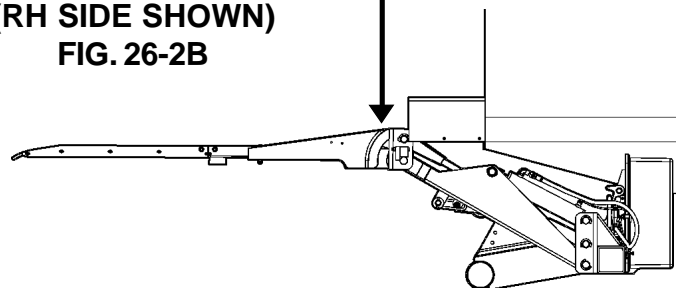
**REINSTALLING LOCKING BRACKETS  
FIG. 26-1**

8. Review the **WARNING** page at the front of this manual before continuing this procedure. **Stay clear of moving Liftgate parts.**



**INSTALLATION BRACKET  
(RH SIDE SHOWN)  
FIG. 26-2B**

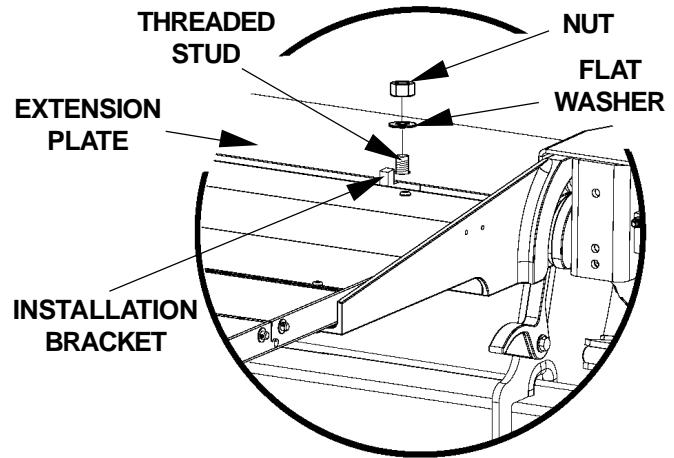
9. **RAISE** Platform to position just below Extension Plate (**see FIG. 26-2A**). Place an Installation Bracket on the Spring Pin on the RH Side of Platform (**FIG. 26-2B**) and on the Spring Pin on the LH Side of Platform.



**FIG. 26-2A**

## STEP 10 - ADJUST PLATFORM (IF REQUIRED) - Continued

10. Carefully **RAISE** the Platform to Vehicle Bed Height. Make sure threaded stud on each Installation Bracket comes up through hole in Extension Plate (**FIG. 27-1**). Bolt the Installation Bracket (**FIG. 27-1**) to Extension Plate. Torque nut from **39 to 59 LBS.-FT.** Repeat for bolting and torquing the Installation Bracket on the LH Side.

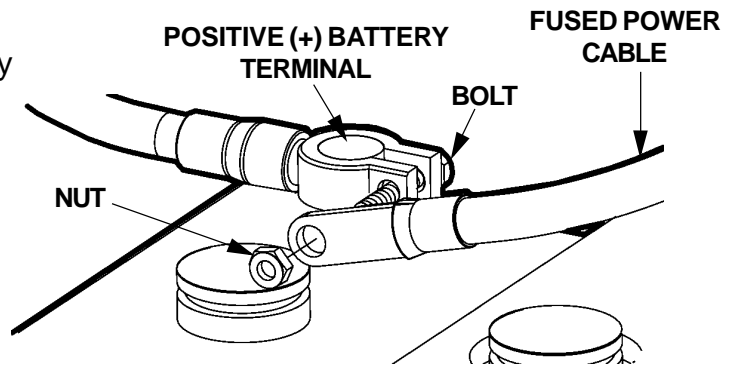


**INSTALLATION BRACKET  
(RH SIDE SHOWN)  
FIG. 27-1**

### **⚠ WARNING**

To prevent accidental personal injury and equipment damage, make sure power is disconnected from Liftgate while installing parts.

11. Disconnect power from Liftgate by removing nut from positive (+) battery terminal connector and disconnect Power Cable (**FIG. 27-2**). Reinstall nut on positive (+) battery terminal connector.

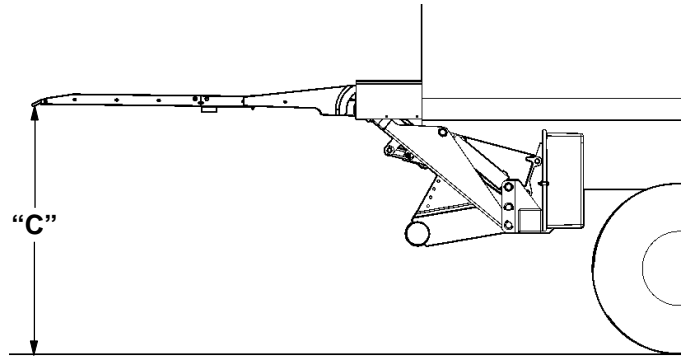


**DISCONNECTING BATTERY  
FIG. 27-2**

## STEP 10 - ADJUST PLATFORM (IF REQUIRED) - Continued

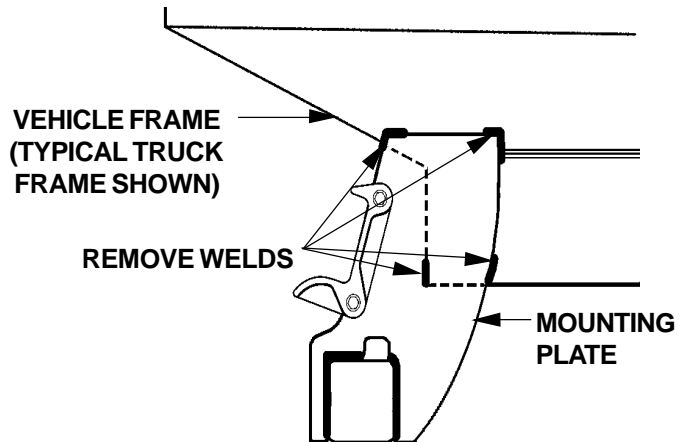
12. Support the Liftgate under Main Frame with a floor jack.

13. Measure distance “C” from the tip of the Flipover to ground level (FIG. 28-1). Then subtract the distance “B” measured in instruction 6. The result is distance “D” for the Platform adjustment (FIG. 28-3). For example, if you measured 50” for “C” and 1” for “B”, the calculated distance “D” for the Platform adjustment is 49”.



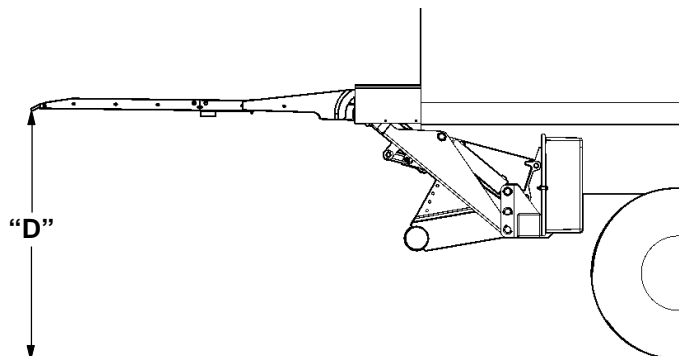
**LIFTGATE CLEARANCE DIMENSIONS  
FIG. 28-1**

14. Remove welds from RH Side Mounting Plate (FIG. 28-2). Repeat for LH Side Mounting Plate.



**REMOVING WELDS FROM MOUNTING PLATE  
(RH SIDE SHOWN)  
FIG. 28-2**

15. Raise or lower the floor jack to adjust distance “D” between tip of Flipover and ground level (FIG. 28-3). Use the distance “D” calculated in instruction 12.



**LIFTGATE CLEARANCE DIMENSIONS  
FIG. 28-3**

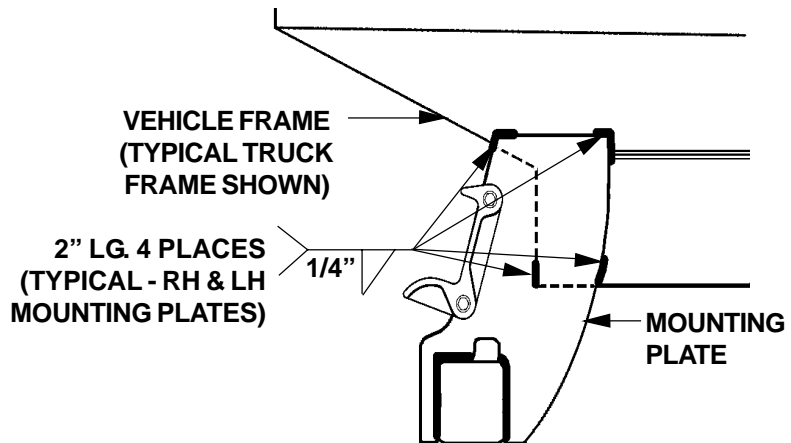
# STEP 10 - ADJUST PLATFORM (IF REQUIRED)

## - Continued

### CAUTION

Prevent damaged hydraulic hoses and saddles. Before welding next to hydraulic hoses and saddles, protect the hoses and saddles with a heat-resistant cover.

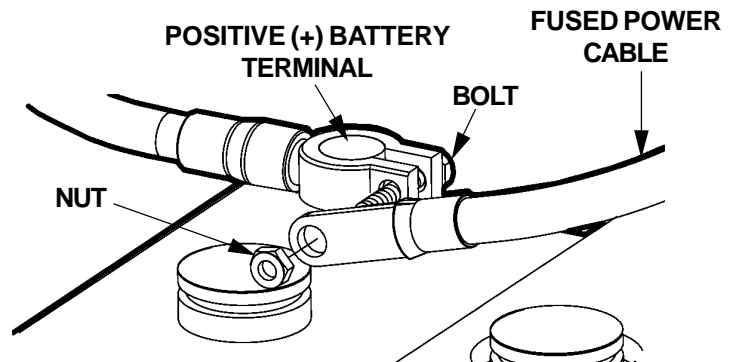
16. Clamp Mounting Plate to vehicle frame. Weld the Mounting Plate to vehicle frame as shown in **FIG. 29-1**. Remove clamp.



**WELD TO VEHICLE FRAME AND MAIN FRAME  
(RH SIDE SHOWN)**  
**FIG. 29-1**

17. Repeat instruction 15 for the Mounting Plate on the LH Side.

18. Connect power to Liftgate by removing nut from positive (+) battery terminal connector and connect Power Cable (**FIG. 29-2**). Reinstall and tighten nut on positive (+) battery terminal connector.

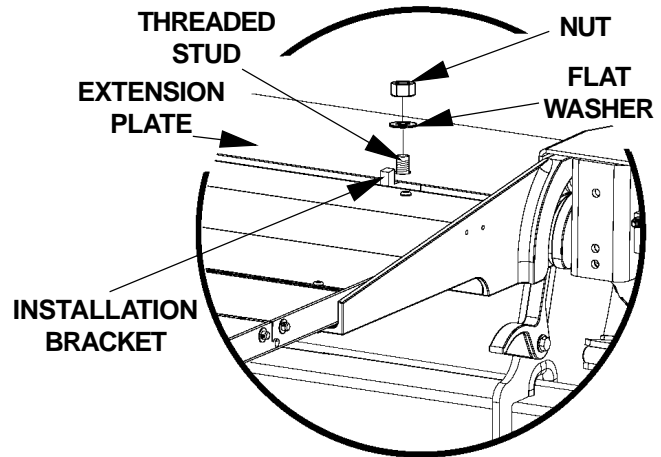


**RECONNECTING BATTERY**  
**FIG. 29-2**

19. Lower the floor jack and move it away from the Liftgate.

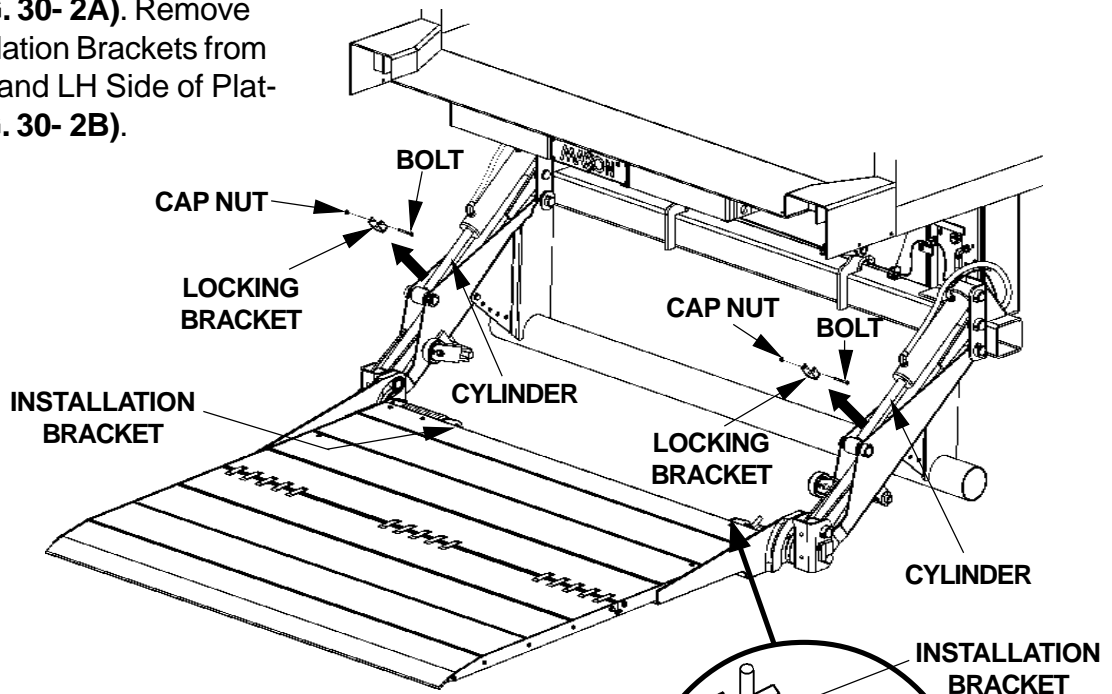
## STEP 10 - ADJUST PLATFORM (IF REQUIRED) - Continued

20. Unbolt the Installation Brackets (FIG. 30-1) from RH Side and LH side of Extension Plate.



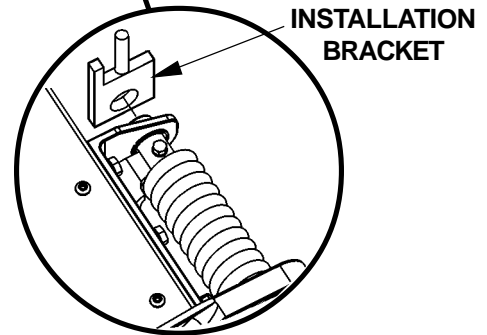
**INSTALLATION BRACKET  
(RH SIDE SHOWN)  
FIG. 30-1**

21. **LOWER** the Liftgate to ground level (FIG. 30- 2A). Remove the Installation Brackets from RH Side and LH Side of Platform (FIG. 30- 2B).



**REMOVING LOCKING BRACKETS  
FIG. 30-2A**

22. Unbolt the Locking Brackets from both Cylinders (FIG. 30- 2). Remove the Locking Brackets.



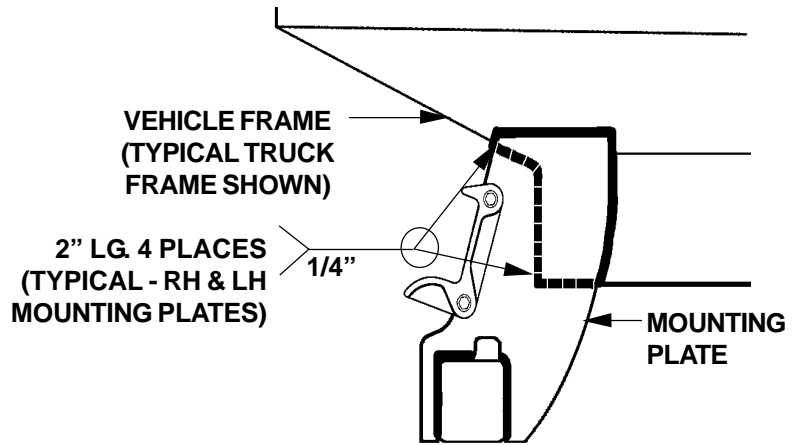
**REMOVING INSTALLATION  
BRACKET (RH SIDE SHOWN)  
FIG. 30-2B**

# STEP 11 - FINISH WELDING LIFTGATE TO VEHICLE

## CAUTION

Prevent damaged hydraulic hoses and saddles. Before welding next to hydraulic hoses and saddles, protect the hoses and saddles with a heat-resistant cover.

1. Clamp Mounting Plate to vehicle frame. Weld the Mounting Plate to vehicle frame as shown in **FIG. 31-1**. Remove clamp.



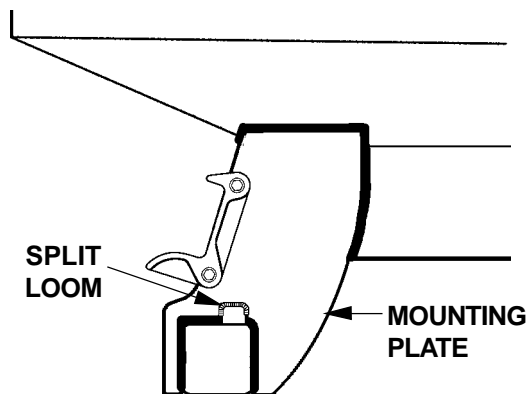
WELD TO VEHICLE FRAME (RH SIDE SHOWN)  
FIG. 31-1

2. Repeat instruction 1 for the LH Side Mounting Plate.

## ⚠ CAUTION

To prevent injury and damaged parts, let Mounting Plate cool off from welding before reinstalling split Loom.

3. Reinstall the Split Loom on RH Side Mounting Plate (**FIG. 31-2**). Repeat for LH Side Mounting Plate.

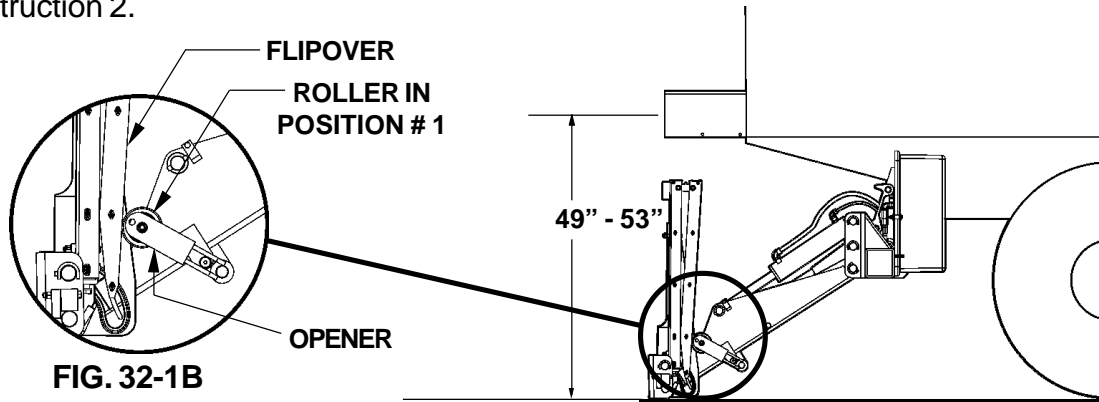


REINSTALLING SPLIT LOOM (RH SIDE SHOWN)  
FIG. 31-2

## STEP 12 - ADJUST OPENER (IF REQUIRED)

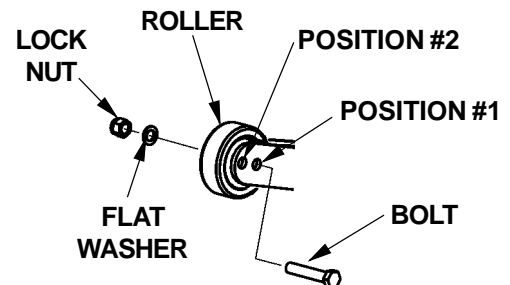
**NOTE:** Platform Openers are set at the factory for Vehicle Bed Heights of 49"-53". If your Vehicle Bed Height is 49"-53", no adjustment needed.

1. The illustrations in **FIGS. 32-1A and 32-1B** show the Roller in Position #1 for 49"-53" Vehicle Bed Height. If your Vehicle Bed Height is 44"-49", do instruction 2.

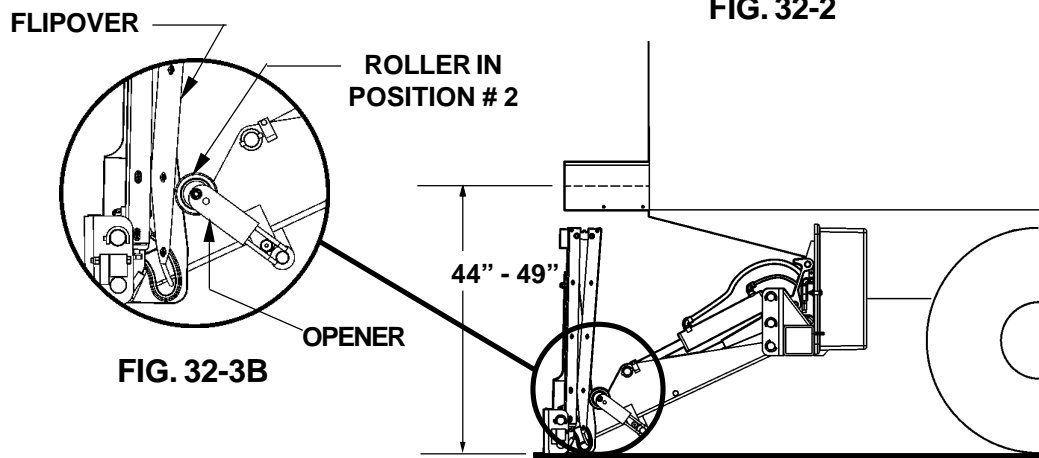


**ROLLER POSITION FOR 49" - 53" BED HEIGHT (LH SIDE SHOWN)**  
**FIG. 32-1A**

2. Unbolt Roller from Opener (**FIG. 32-2**). Move Roller to position #2 (**FIG. 32-2**). Bolt Roller to Opener. Torque the 1/2"-13 opener bolt from **85 LBS.-FT.**



**BOLTING/UNBOLTING ROLLER**  
**(LH SIDE SHOWN)**  
**FIG. 32-2**



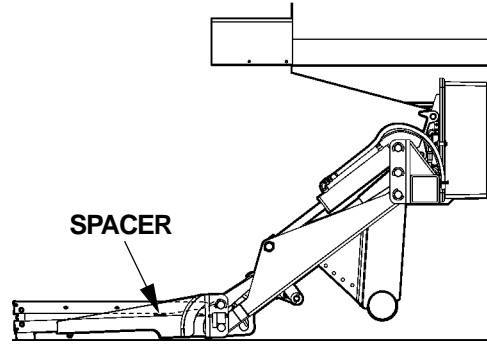
**ROLLER POSITION FOR 44" - 49" BED HEIGHT**  
**(LH SIDE SHOWN)**  
**FIG. 32-3A**

3. Repeat instruction 2 for RH Side Opener.



## STEP 13 - ADJUST SADDLES

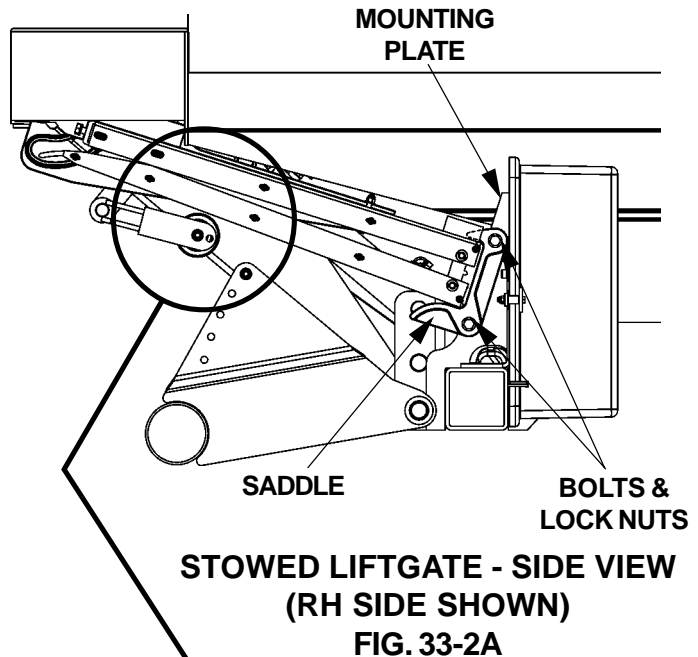
1. Fold the Flipover on Platform.  
Place 1/4" Spacer between tip of Flipover and Platform on RH side and LH side (**FIG. 33-1**).



**FIG. 33-1**

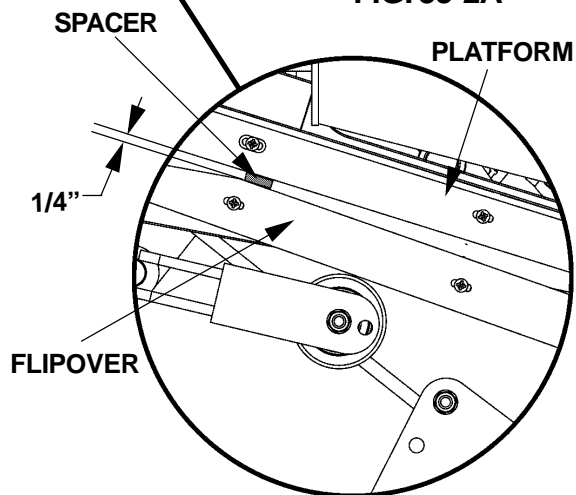
2. Stow Liftgate under hydraulic pressure (**FIG. 33-2A**). Make sure 1/4" Spacers are still in place (**FIG. 33-2B**).

3. Loosen the 2 bolts and lock nuts on RH side Mounting Plate (**FIG. 33-2A**). Repeat for Saddle on LH side. Butt each Saddle against Platform, and tighten lock nuts. Torque lock nuts to **85 LBS.-FT.**



**STOWED LIFTGATE - SIDE VIEW  
(RH SIDE SHOWN)  
FIG. 33-2A**

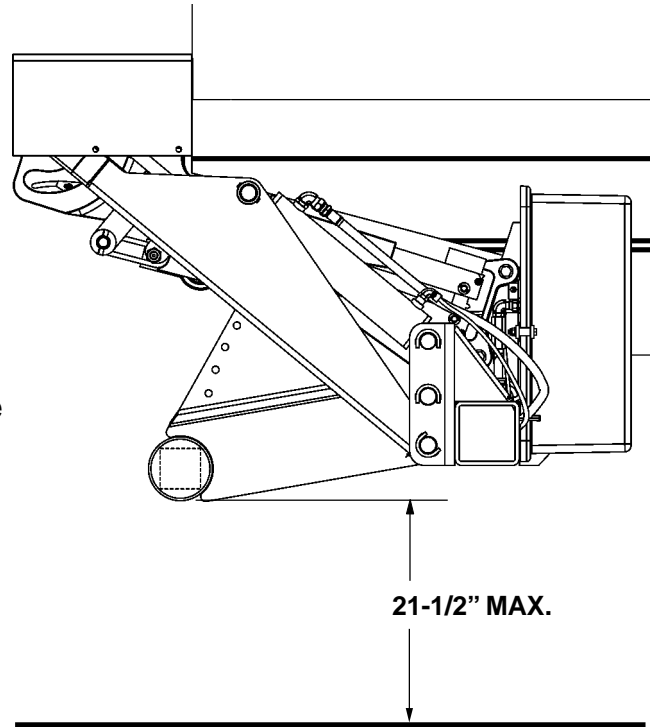
4. Lower the Liftgate. Then unfold Platform and Flipover. Remove the 1/4" Spacers.



**SPACER BETWEEN PLATFORM &  
OPENER  
FIG. 33-2B**

## STEP 14 - ADJUST UNDERRIDE (IF REQUIRED)

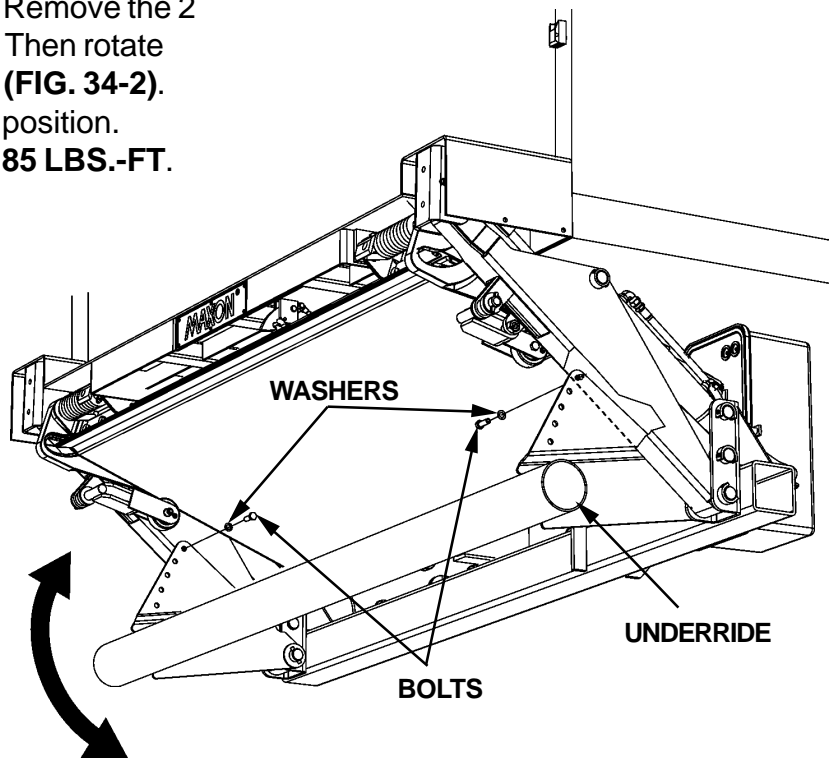
1. Stow the Liftgate under hydraulic pressure (**FIG. 34-1**).



**FIG. 34-1**

2. Check the Underride clearance dimensions shown in **FIG. 34-1**. If the Underride needs adjustment, do instruction 2.

3. Stow the Platform (**FIG. 34-2**). Support the Underride with forklift or jack. Remove the 2 adjuster bolts and 2 washers. Then rotate Underride to desired position (**FIG. 34-2**). Bolt the Underride in the new position. Torque the 1/2"-13 bolts from **85 LBS.-FT.**

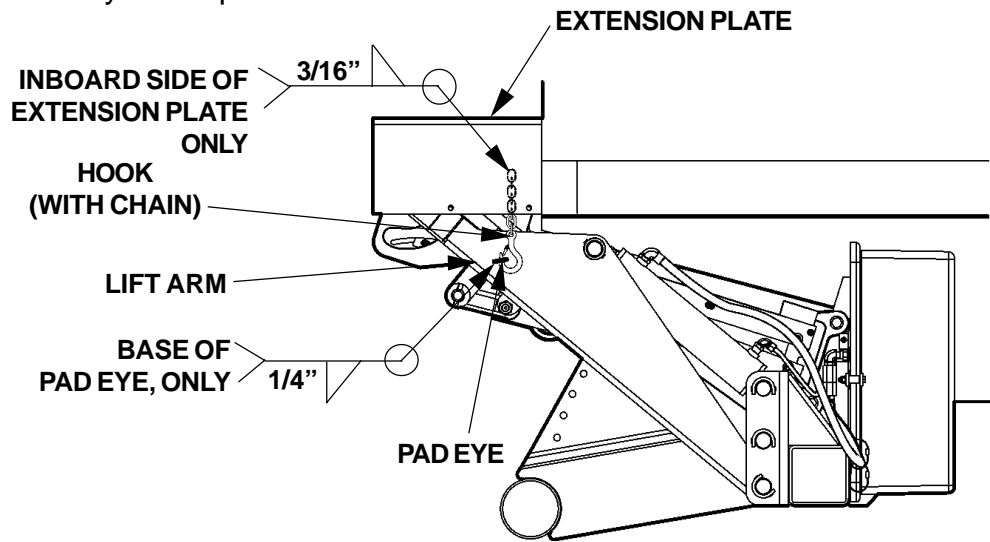


**FIG. 34-2**

4. Remove forklift or jack.

## STEP 15 - WELD HOOK AND EYE TO LIFTGATE

1. Stow the Liftgate under hydraulic pressure (FIG. 35-1).

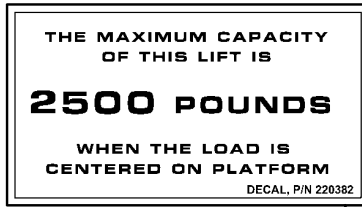


2. Weld the Pad Eye (from Installation Parts Bag) to Lift Arm as shown in FIG. 35-1.

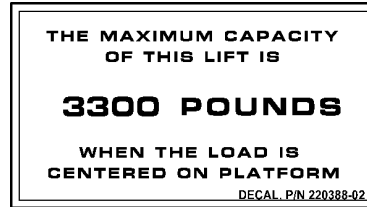
**RH SIDE VIEW OF STOWED LIFTGATE  
FIG. 35-1**

3. Insert the Safety Hook through the Pad Eye (FIG. 35-1). Next position the Safety Hook Chain on the Extension Plate as shown in FIG. 35-1. Leave enough slack in the Chain to hook and unhook from the Pad Eye. Then weld the free end of Chain to the inboard side of the Extension Plate.

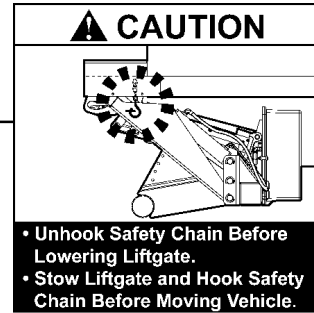
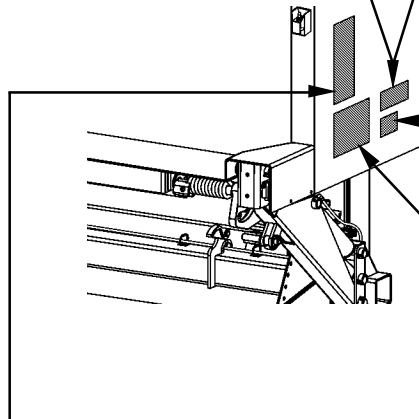
# STEP 16 - DECALS



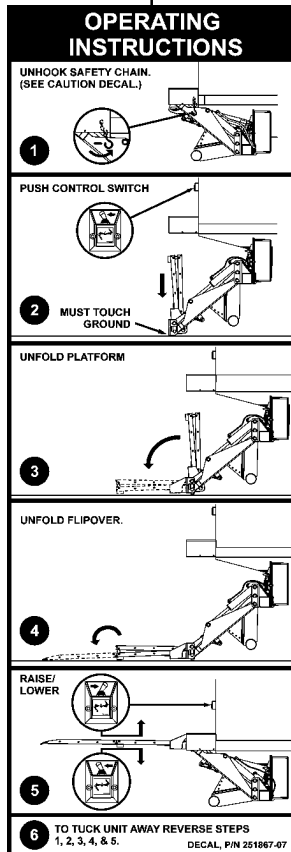
**CAPACITY DECAL (GPT-25 ONLY)**  
P/N 220382



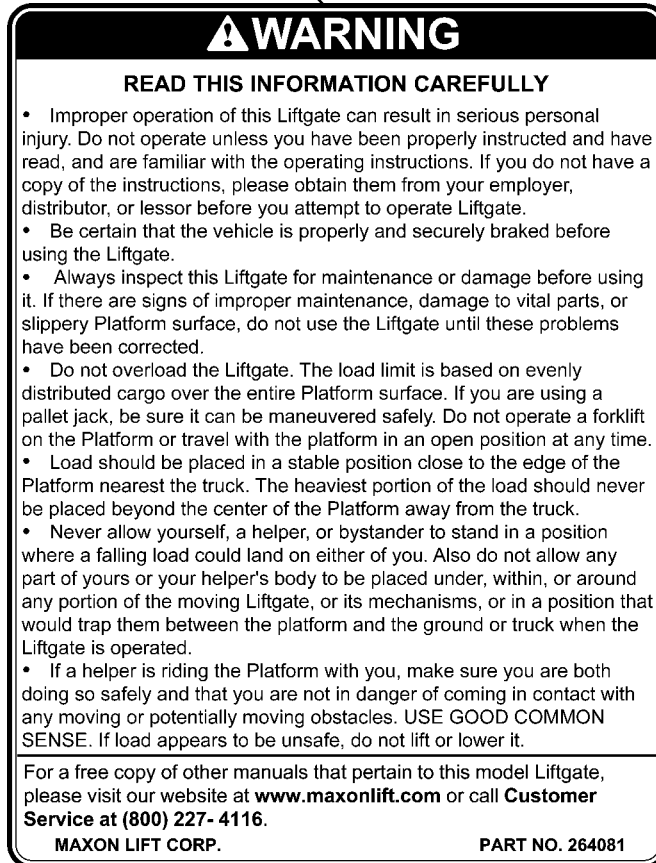
**CAPACITY DECAL (GPT-33 ONLY)**  
P/N 220388-02



**CHAIN HOOK DECAL**  
P/N 263998-01



**INSTRUCTION DECAL**  
P/N 251867-07



**WARNING DECAL**  
P/N 264081

**FIG. 36-1**

# STEP 16 - DECALS - Continued

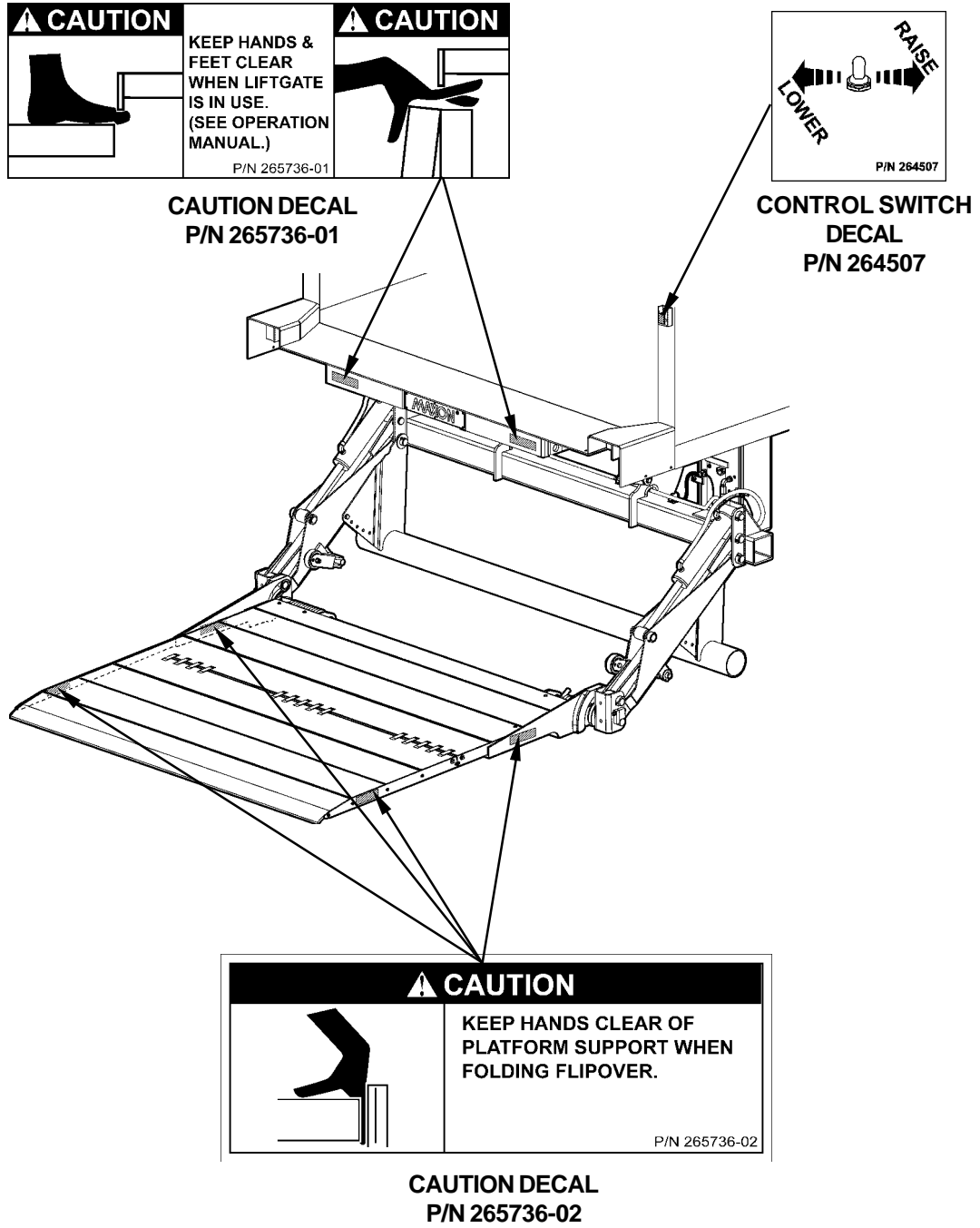
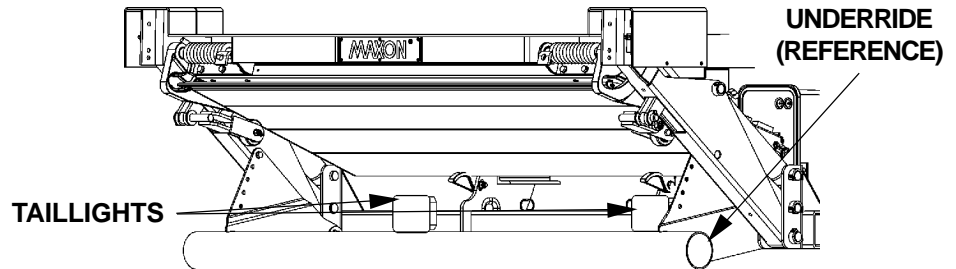


FIG. 37-1

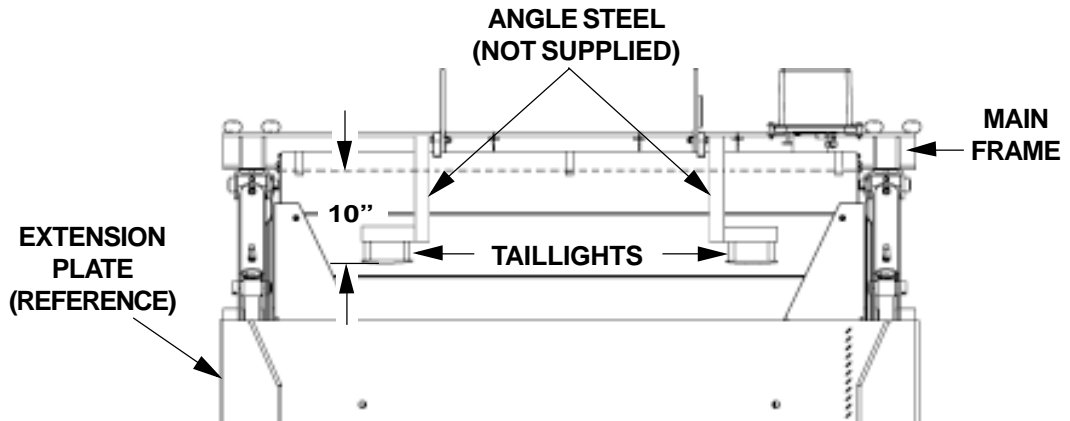
# STEP 17 - VEHICLE TAILLIGHT POSITIONING (IF REQUIRED)

**NOTE:** Positions are based on using taillights of 6-3/4" height by 5-3/4" width. Larger taillights may interfere with Liftgate. Taillights and attaching hardware are not provided with the Liftgate.

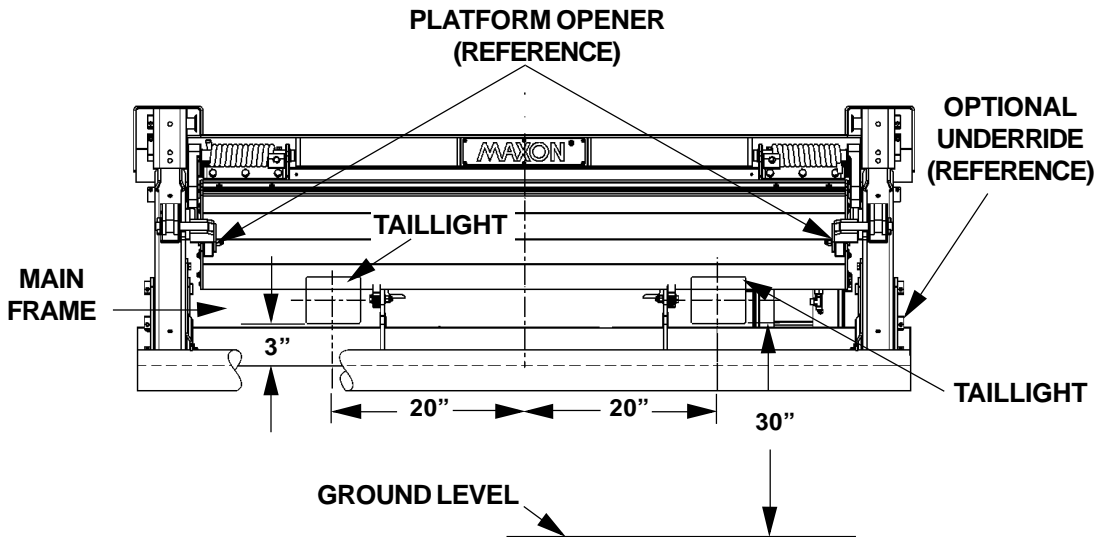
Install vehicle taillights (FIG. 38-1) as shown in FIG. 38-2 and FIG. 38-3.



**VEHICLE TAILLIGHTS INSTALLED ON LIFTGATE  
FIG. 38-1**



**TAILLIGHTS POSITION (TOP VIEW)  
FIG. 38-2**

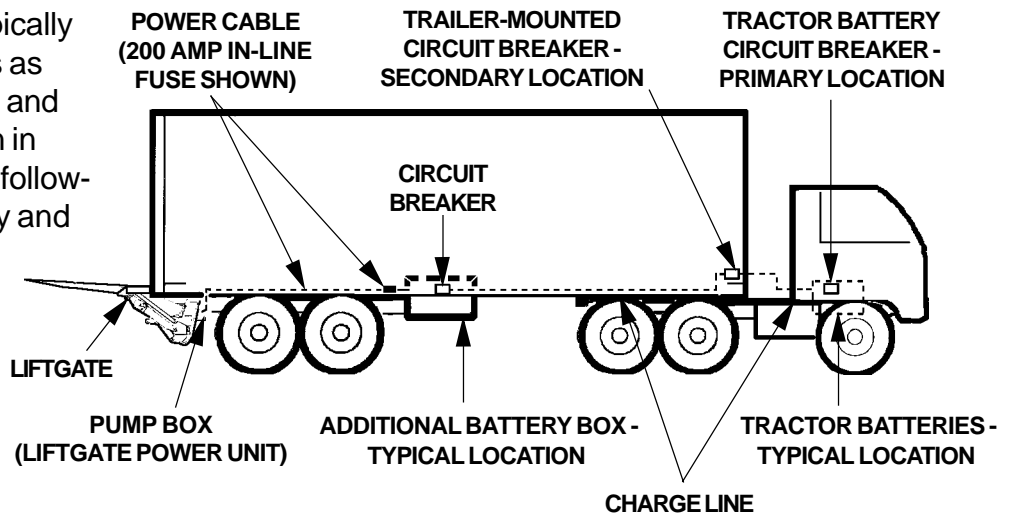


**TAILLIGHTS HORIZONTAL SPACING (FRONT VIEW)  
FIG. 38-3**

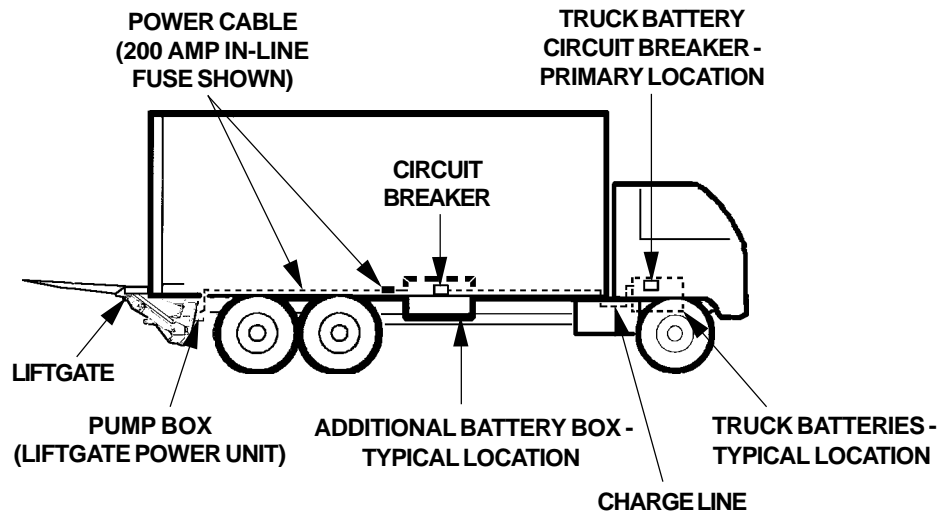
# OPTIONS

## RECOMMENDED LIFTGATE POWER CONFIGURATION

1. Liftgate and additional Battery Box are typically installed on trailers as shown in **FIG. 39-1** and on trucks as shown in **FIG. 39-2**. See the following page for battery and cable connections.



**RECOMMENDED LIFTGATE & BATTERY BOX  
INSTALLATION ON TRAILER  
FIG. 39-1**



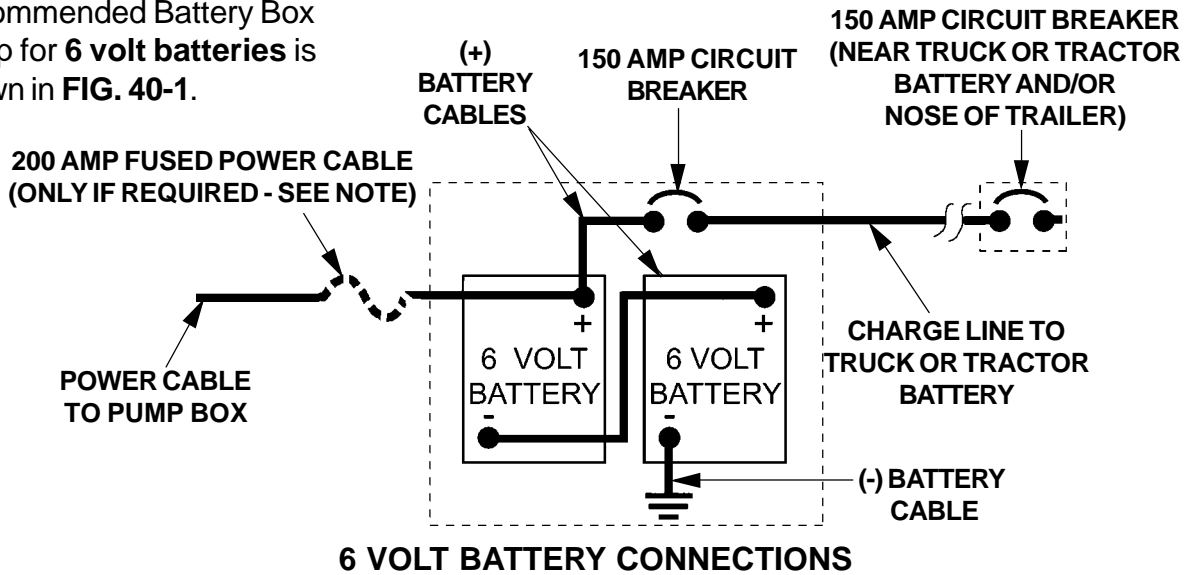
**RECOMMENDED LIFTGATE & BATTERY BOX  
INSTALLATION ON TRUCK  
FIG. 39-2**

# OPTIONS

## RECOMMENDED LIFTGATE POWER CONFIGURATION - Continued

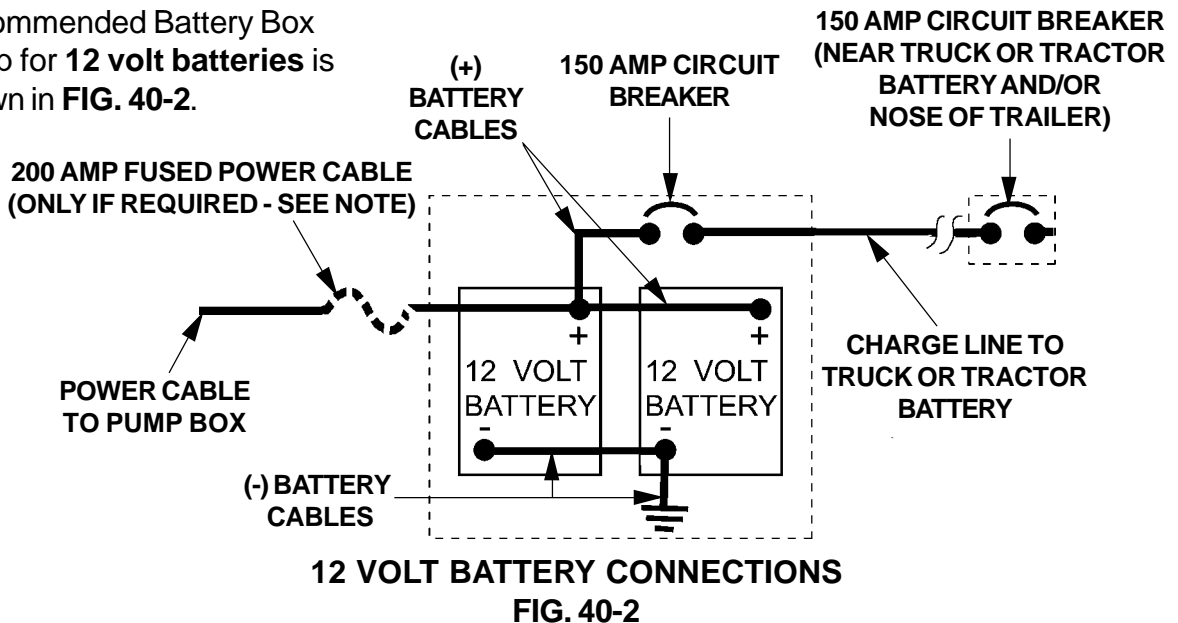
**NOTE:** If more than 10' of cabling is required to connect Battery Box batteries to Liftgate Power Unit, and/or if cable is run through/along vehicle body crossmembers, use **200 Amp Fused Power Cable** from Liftgate Parts Box. Always connect fused end of Cable to Battery.

2. Recommended Battery Box setup for **6 volt batteries** is shown in **FIG. 40-1**.



**NOTE:** If more than 10' of cabling is required to connect Battery Box batteries to Liftgate Power Unit, and/or if cable is run through/along vehicle body crossmembers, use **200 Amp Fused Power Cable** from Liftgate Parts Box. Always connect fused end of Cable to Battery.

3. Recommended Battery Box setup for **12 volt batteries** is shown in **FIG. 40-2**.



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