

# MAXON<sup>®</sup>

## GPTLR Series

### INSTALLATION MANUAL

GPTLR-25, GPTLR-33, GPTLR-44, & GPTLR-55



To find maintenance information for your **GPTLR Liftgate**, go to **www.maxonlift.com**. Click the **PRODUCTS**, **TUK-A-WAY** & **GPTLR** buttons. Open the **Maintenance Manual** in the **PRODUCT DOCUMENTATION** window. For parts, click on the **PARTS PORTAL**, **TUK-A-WAY** & **GPTLR** buttons.

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## SUMMARY OF CHANGES: M-16-24

PAGE	DESCRIPTION OF CHANGE
5	Removed galvanized warning decal. Added note for recommended practices for welding galvanized steel to refer to <b>AWS (American Welding Society) D19.0 Welding Zinc-Coated Steel</b> .
7	Main assembly shows new bolt-on mounting plates and horizontal power unit.
8	Added Installation Parts Box Tables A, B & C. Added new molded, toggle switch assembly, Added new 1/2" X 5/16" flat washer, 1-1/2" long self-tapping screws for control switch assembly, and 1/2" long self-tapping screws for rubber loom clamp. Added ground cable assembly, 2 GA X 48' LG.
9	Updated Decal and Manual Kit part numbers. Added Notice directing user to Maxon website for Maintenance Manual.
18	Added illustration and table showing mounting plates for various frame widths.
18-23	Updated Step 1: Weld Liftgate to Vehicle instructions. Bolt-on mounting plates are not welded to main frame.
35, 38, 83, 84	Updated power unit has no thermal switch. Fused power connection shows new 10 AMP fuse holder assembly.
87,88	Updated electrical schematics show cycle counter (if equipped).
89	Added GPTLR electrical values.
90	Updated hand-held, street side and dual control kits in the OPTIONS table. Added DOCK BUMPER, 3-1/2" X 7 X 1-1/2" (RECOMMENDED GPTLR-25/33 ONLY). Removed cold galvanize spray (16 OZ) and bright zinc spray paint (16 OZ). Removed painted step kit options.

Comply with the following **WARNINGS** and **SAFETY INSTRUCTIONS** while installing Liftgates. See Operation Manual for operating safety requirements.

## **WARNING**

- Do not stand, 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.
- 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 can become 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.
- Recommended practices for welding on steel parts are contained in the current **AWS (American Welding Society) D1.1 Structural Welding Code - Steel**. Damage to Liftgate and/or vehicle, and personal injury can result from welds that are done incorrectly.
- Recommended practices for welding galvanized steel are contained in the current **AWS (American Welding Society) D19.0 Welding Zinc-Coated Steel**. Damage to Liftgate and/or vehicle, and personal injury can result from welds that are done incorrectly.

## SAFETY INSTRUCTIONS

- 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**.
- Comply with all **WARNING** and instruction decals attached to the Liftgate.
- Keep decals clean and legible. If decals are illegible 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 or children to operate the Liftgate.
- 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 switch to stop the Liftgate.
- A correctly installed Liftgate operates smoothly and reasonably quiet. The only noticeable noise during operation comes from the power unit while the platform is raised and lowered. Listen for scraping, grating and binding noises and correct the problem before continuing to operate Liftgate.

## NOTICE

- Maxon Lift is responsible for the instructions to correctly install **MAXON** Liftgates on trucks or trailers only.
- Liftgate installers, not Maxon Lift, are responsible for reviewing and complying with all applicable Federal, State, and Local regulations pertaining to the trailer or truck.
- Installers of the liftgate should ensure that all trucks and trailers are equipped with grab handles as needed. Refer to Technology Maintenance Council (TMC) RP 1428: Entry And Egress Guidelines for Vehicles With Fold-Under Type Liftgates.

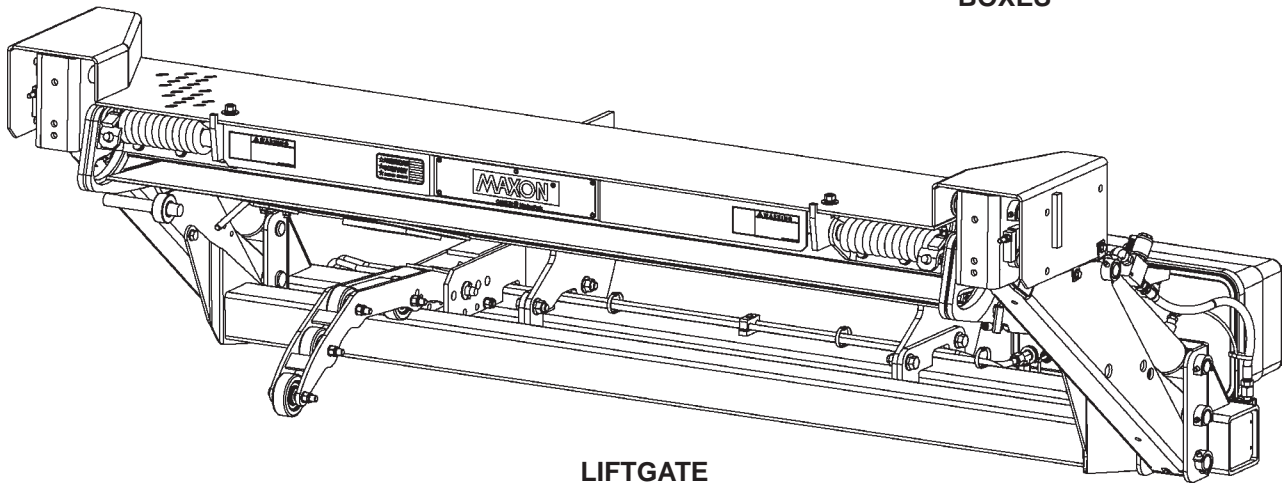
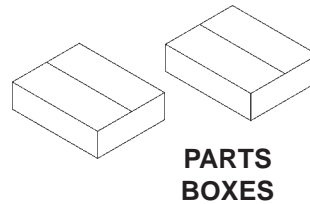
# GPTLR LIFTGATE COMPONENTS

## ⚠ CAUTION

Unpacking the Liftgate on unlevel surface may allow heavy components to slide off when shipping bands are cut. Injury and equipment damage could result. Before the shipping bands are cut, put Liftgate on level surface that will support 1500 lbs. When unpacking the Liftgate, remove heavy components carefully to avoid injury and damage.

**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 [cservice@maxonlift.com](mailto:cservice@maxonlift.com)



**GPTLR COMPONENTS**  
**FIG. 7-1**

# GPTLR-SERIES INSTALLATION PARTS BOXES

ITEM	NOMENCLATURE OR DESCRIPTION	QTY.	PART NUMBER
REF	PARTS BOX A	1	297502-01
1	SPRING CLIP, 1/2" x 1-3/8"	10	050079
2	PLASTIC TIE	2	206864
3	#10 RUBBER LOOM CLAMP	2	801681
4	CABLE ASSEMBLY, 175 AMPS, 38 FT LG.	1	264422
5	SELF-TAPPING SCREW, 10 X 1/2" LG.	2	030458
6	GROUND CABLE ASEMBLY, 2 GA X 48" LG.	1	251871-26

**PARTS BOX A WITH POWER CABLE  
TABLE 8-1**

ITEM	NOMENCLATURE OR DESCRIPTION	QTY.	PART NUMBER
REF	PARTS BOX B	1	297318-01
1	TOGGLE SWITCH ASSEMBLY	1	296855-01
2	FLAT WASHER, 1/2" X 1/16" THICK	2	902000-16
3	LOCK NUT, 1/2"-13	2	901010
4	STOP BLOCK	1	281673-01
5	SHIM, PLATFORM ADJUSTMENT, 1/8"	2	281166-02
6	SHIM, PLATFORM ADJUSTMENT, 1/16"	2	281166-01
7	SCREW, SELF TAPPING, #10-24 X 1" LG	2	900057-5
8	LUG, 2 GUAGE, COPPER, 5/16"	1	906497-02
9	SCREW, HEX HEAD, 1/2"-13 X 2-1/2" LG.	2	900035-7

**PARTS BOX B WITHOUT POWER CABLE, GROUND CABLE, OR FRAME CLIPS  
TABLE 8-2**

ITEM	NOMENCLATURE OR DESCRIPTION	QTY.	PART NUMBER
REF	PARTS BOX C	1	297502-02
1	SPRING CLIP	20	050079
2	PLASTIC TIE	4	206864
3	GROMMET, 1" DIA, 2 HOLES	1	266428-09
4	CABLE ASSY, 175 AMP 38 FT LG	1	264422
5	GROUND CABLE ASSY, 2 GA X 38FT LG	1	269191-01
6	#10 LOOM CLAMP	2	801681
7	SELF-TAPPING SCREW, 10 X 1/2" LG.	2	030458

**PARTS BOX C WITH GROUND CABLE  
TABLE 8-3**

**MAXON**<sup>®</sup> 11921 Slauson Ave. Santa Fe Springs, CA. 90670 (800) 227-4116 FAX (888) 771-7713



## GPTLR-SERIES MANUALS & DECALS

**NOTE:** To find **maintenance & parts** information for your **GPTLR Liftgate**, go to [www.maxonlift.com](http://www.maxonlift.com). Open the **Maintenance Manual** in the **PRODUCT DOCUMENTATION** window. For parts, click on the **PARTS PORTAL, TUK-A-WAY & GPTLR** buttons.

ITEM	NOMENCLATURE OR DESCRIPTION	QTY.	PART NUMBER
<b>REF</b>	DECAL & MANUAL KIT	1	297314-01 (GPTLR-25)
			297314-02 (GPTLR-33)
			297314-06 (GPTLR-25, SWG EXT)
			297314-05 (GPTLR-33, SWG EXT)
			297319-01 (GPTLR-44)
			297319-02 (GPTLR-55)
<b>1</b>	INSTALLATION MANUAL	1	M-16-24
<b>2</b>	OPERATION MANUAL	1	M-16-25
<b>3</b>	DECALS (SEE DECAL PAGES IN THIS MANUAL)	1	(ALL GPTLR'S)

**TABLE 9-1**

# VEHICLE REQUIREMENTS

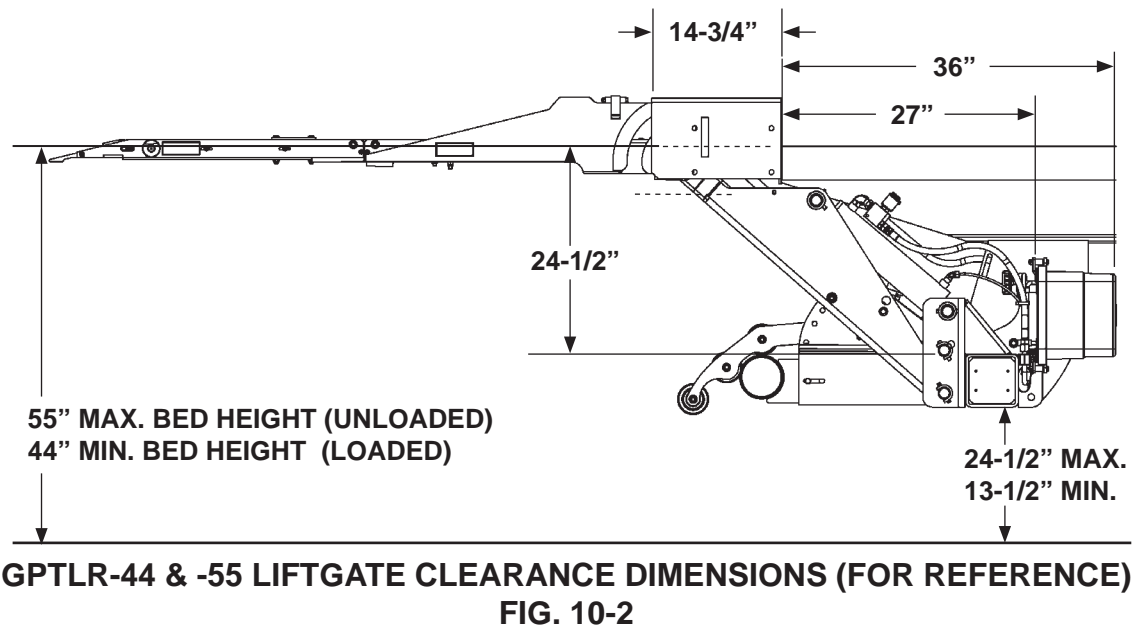
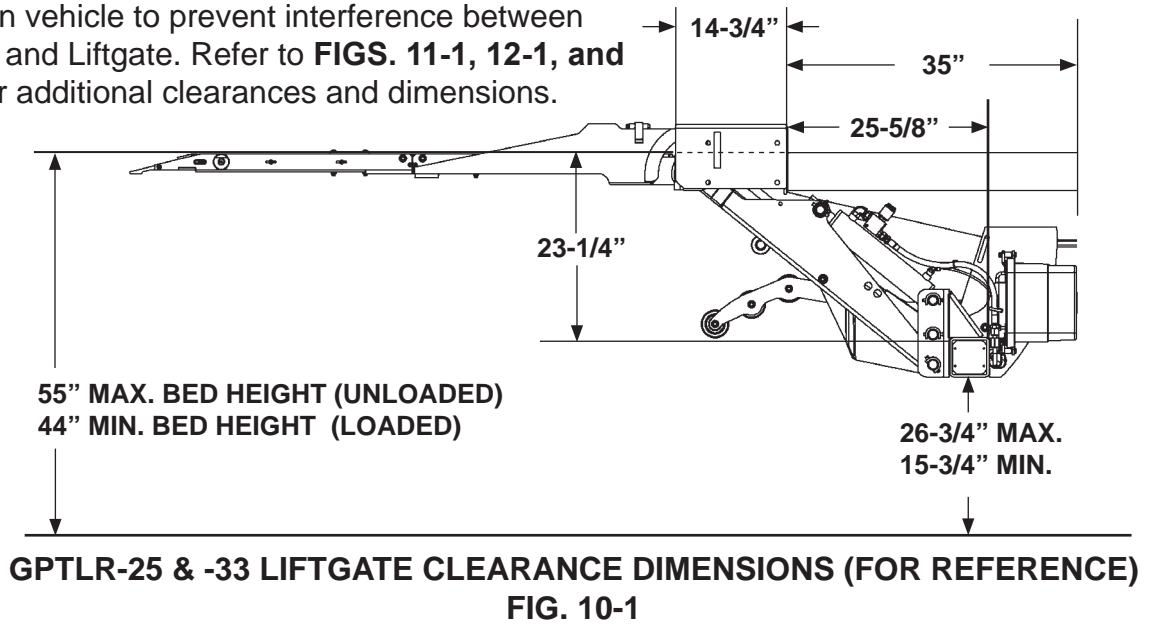
**NOTE:**

- **BODY maximum and minimum operating bed height for GPTLR-25, GPTLR-33, GPTLR-44, & GPTLR-55 with standard platform:**

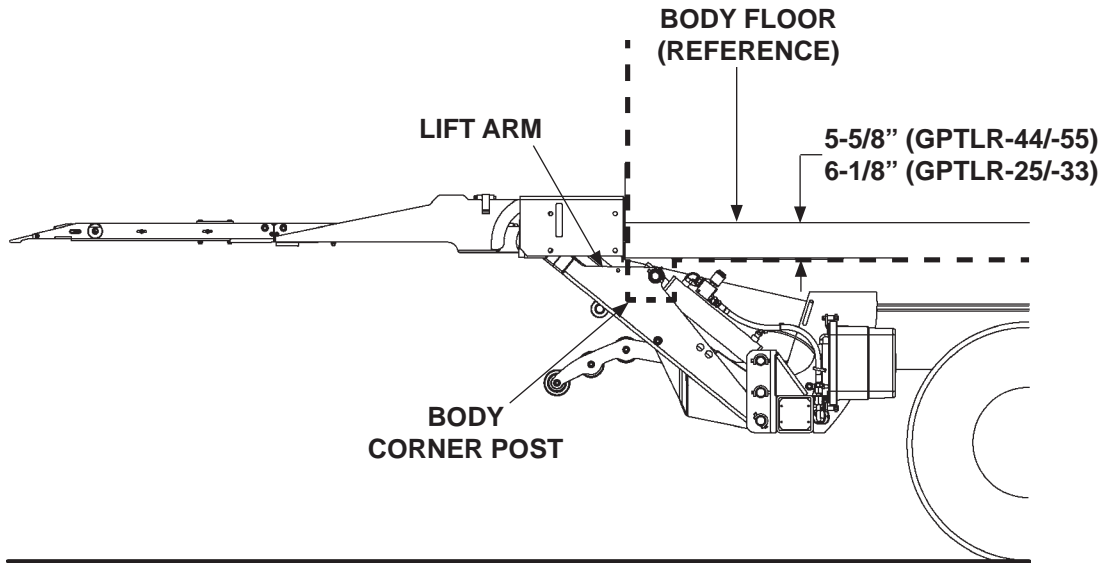
Maximum height is **55"** (Unloaded). Minimum height is **44"** (Loaded). If Liftgate is equipped with Canadian (CMVSS) underride, minimum height will be greater. Refer to Canadian underrides listed in **OPTIONS**, and underride adjustment procedure.

- Make sure vehicle is parked on level ground while preparing vehicle and installing Liftgate.
- On vehicle bodies equipped with swing open doors, the extension plate and vehicle body must be modified to install this Liftgate.
- Dimensions are provided as reference for fitting Liftgate to vehicle body.

1. Check for correct clearances (**FIGS. 10-1 and 10-2**) on vehicle to prevent interference between vehicle and Liftgate. Refer to **FIGS. 11-1, 12-1, and 12-2** for additional clearances and dimensions.



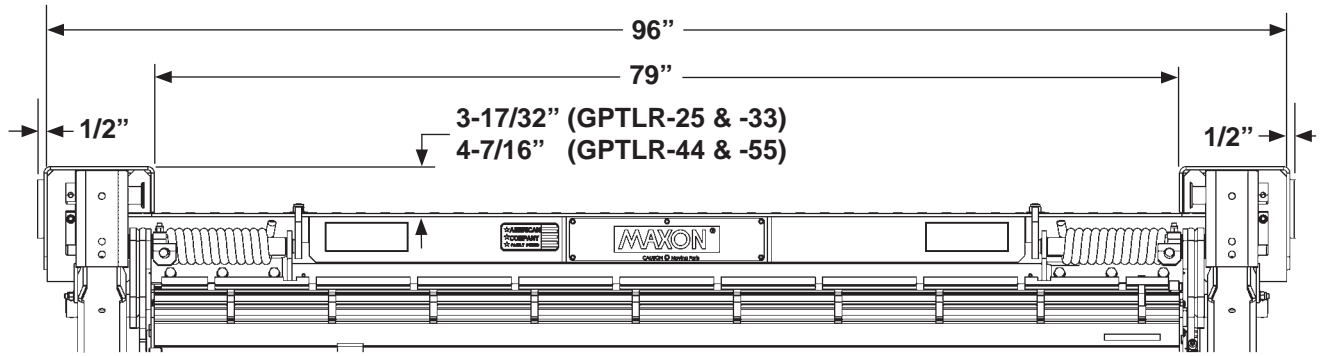
# VEHICLE REQUIREMENTS - Continued



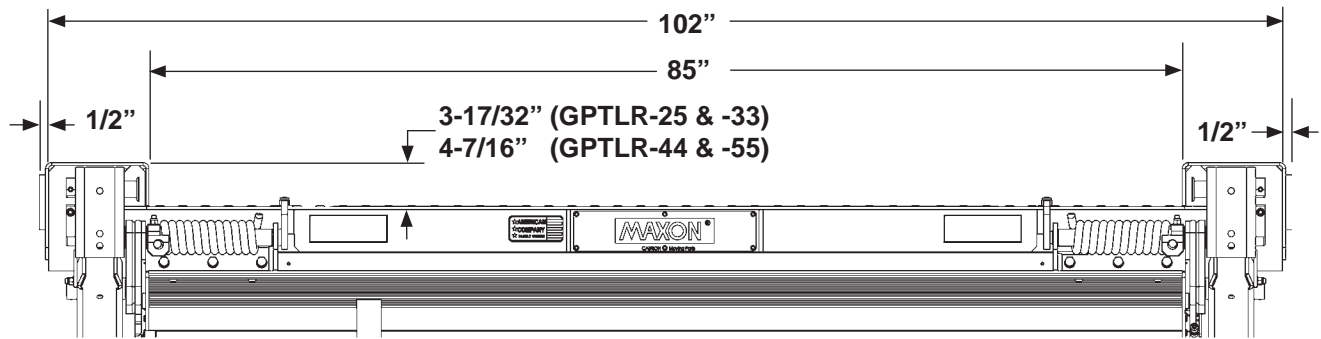
VEHICLE BODY CORNER POST CLEARANCE (FOR REFERENCE)

FIG. 11-1

# VEHICLE REQUIREMENTS - Continued



**GPTLR EXTENSION PLATE DIMENSIONS FOR 96" WIDE BODY  
FIG. 12-1**



**GPTLR EXTENSION PLATE DIMENSIONS FOR 102" WIDE BODY  
FIG. 12-2**

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## VEHICLE REQUIREMENTS - Continued

### CAUTION

- To prevent aluminum platform from being damaged, make sure vehicle frame is cut correctly and rear sills are modified if over 5" in height. If the cutouts are incorrect, platform may hit vehicle frame or underbody when stowing the Liftgate. The bottom of the platform may also hit the sill.
- Installer is responsible for ensuring that vehicle body and frame modifications do not adversely affect the integrity of the body and frame.

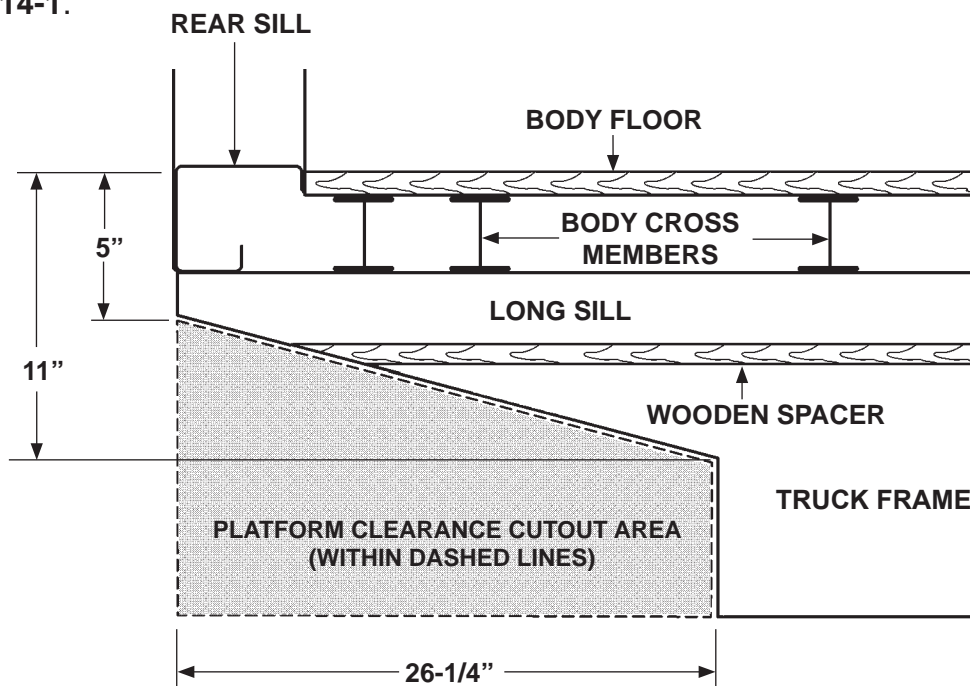
**NOTE:** The dimensions, shown in the illustration below, are maximums except as indicated.

**NOTE:** The platform cutout area shown below applies to trucks and trailers. Typical truck frame is shown. For installation on frameless trailers, kit must be selected from the **OPTIONAL COMPONENTS** section in this manual.

**NOTE:** Refer to the platform clearance cutout area in **FIGS. 13-1 and 14-1**. Remove any part of the rear sill that protrudes into this area.

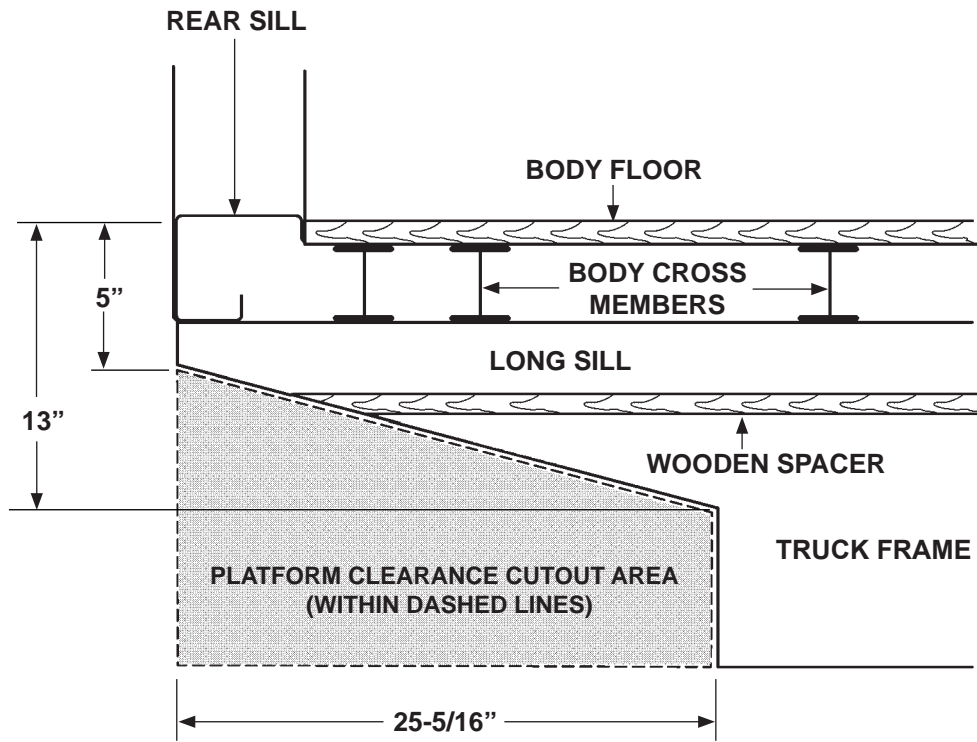
**NOTE:** For Liftgates installed on trailers, refer to **FIG. 15-1** for lift arm and platform clearances on the rear sill. If necessary, remove the interfering portions of the rear sill according to dimensions shown in **FIG. 15-1**.

2. Fit the Liftgate to vehicle body by cutting vehicle frame as shown in **FIGS. 13-1 or 14-1**.



VEHICLE FRAME CUT FOR GPTLR-25 & GPTLR-33  
FIG. 13-1

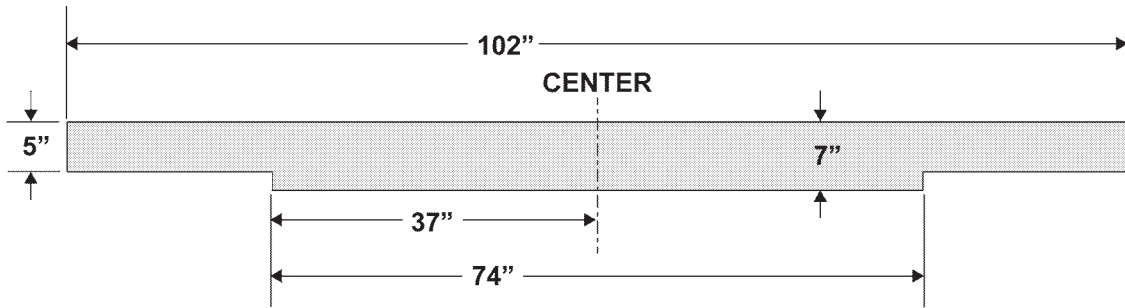
# VEHICLE REQUIREMENTS - Continued



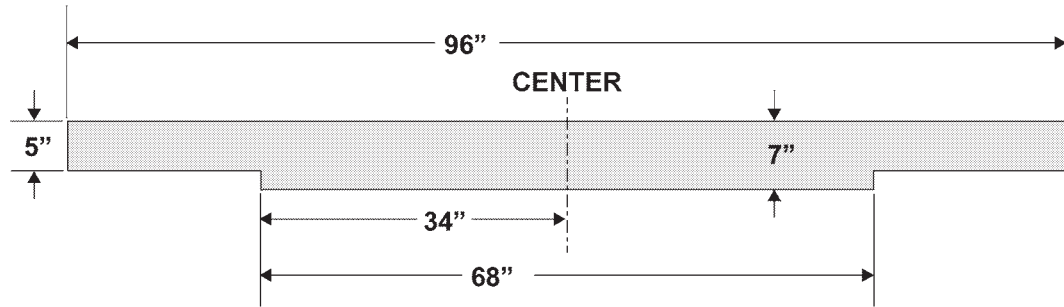
VEHICLE FRAME CUT FOR GPTLR-44 & GPTLR-55  
FIG. 14-1

# VEHICLE REQUIREMENTS - Continued

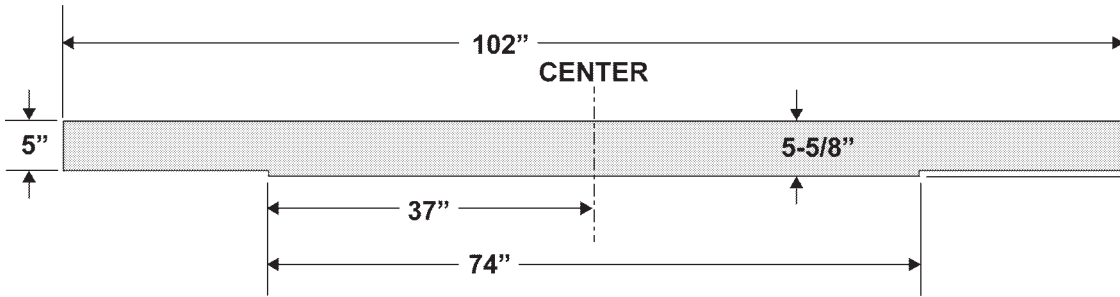
3. If necessary, cut trailer rear sill as shown in **FIG. 15-1**.



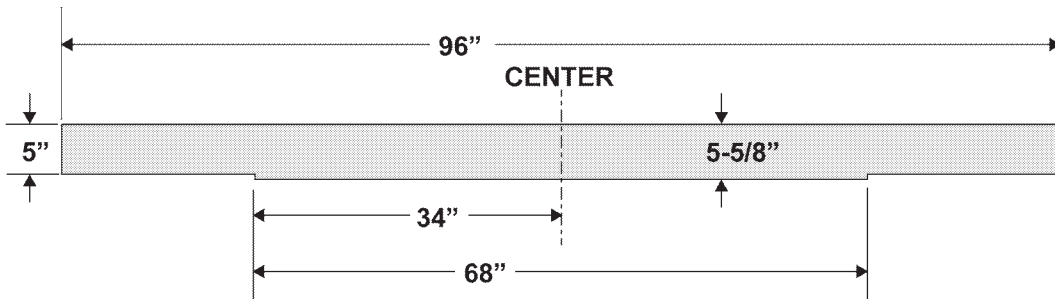
GPTLR -44 & GPTLR -55



GPTLR -44 & GPTLR -55



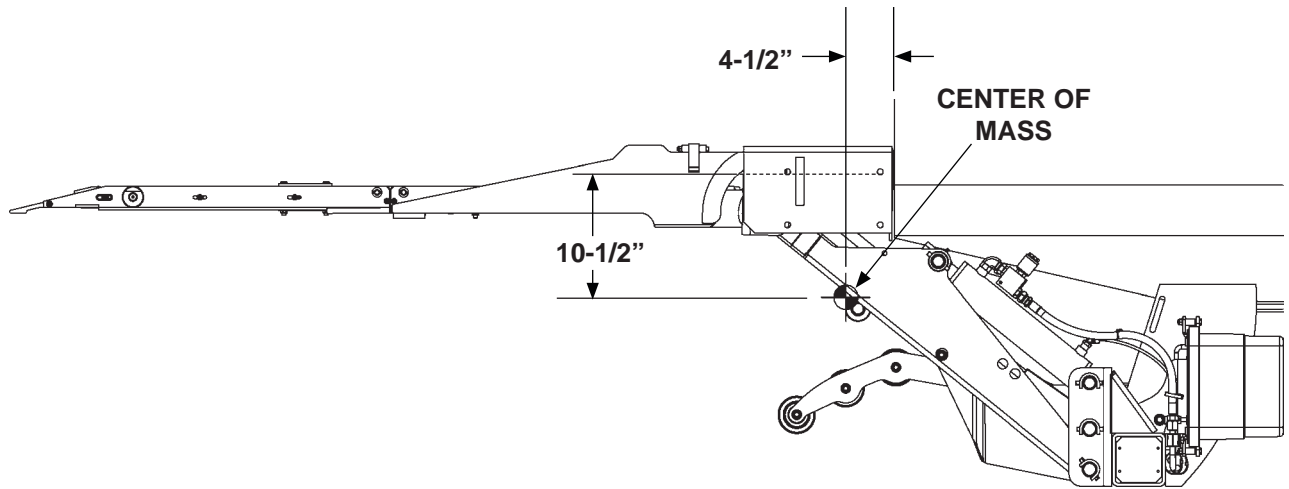
GPTLR -25 & GPTLR -33



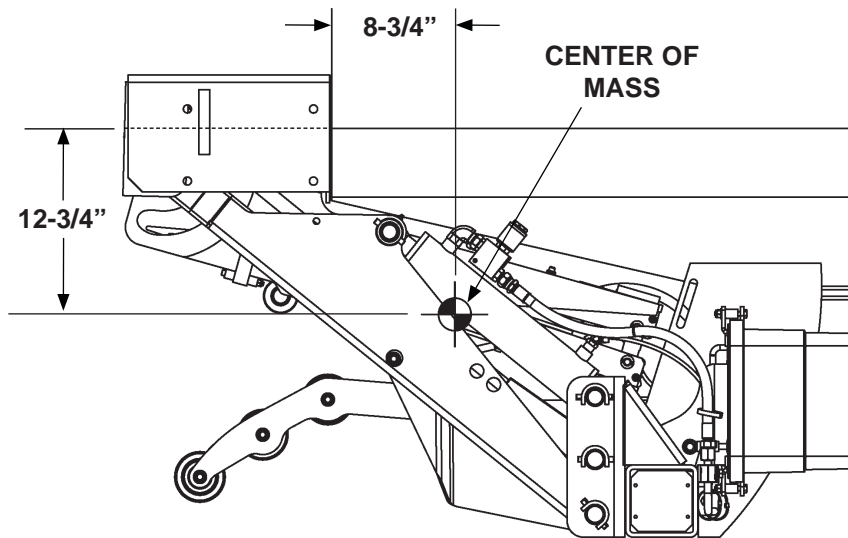
GPTLR -25 & GPTLR -33

**REAR SILL CUTS FOR ALL GPTLR LIFTGATES  
FIG. 15-1**

# CENTER OF MASS



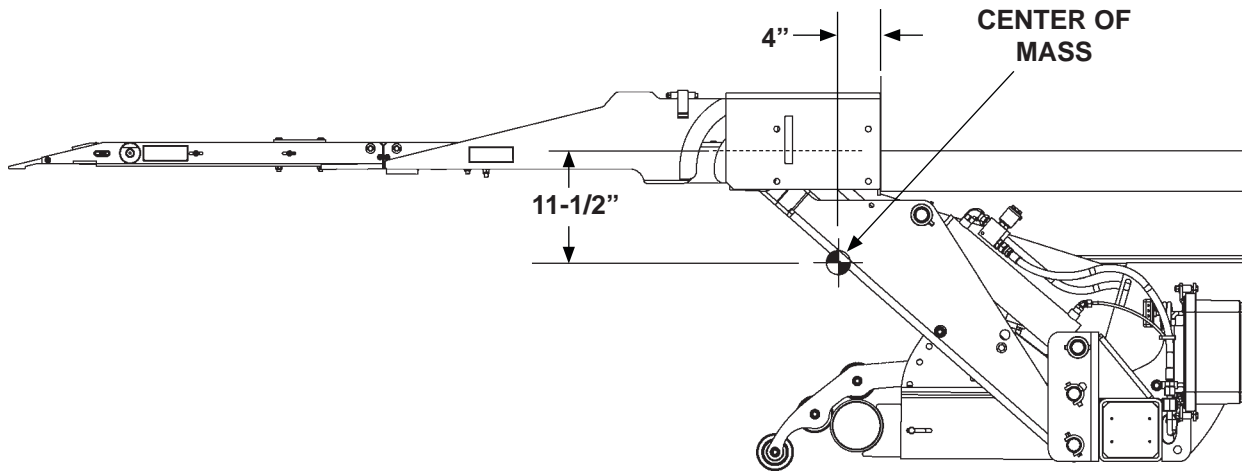
**GPTLR-25 & GPTLR-33 CENTER OF MASS  
(PLATFORM AT BED HEIGHT)  
FIG. 16-1**



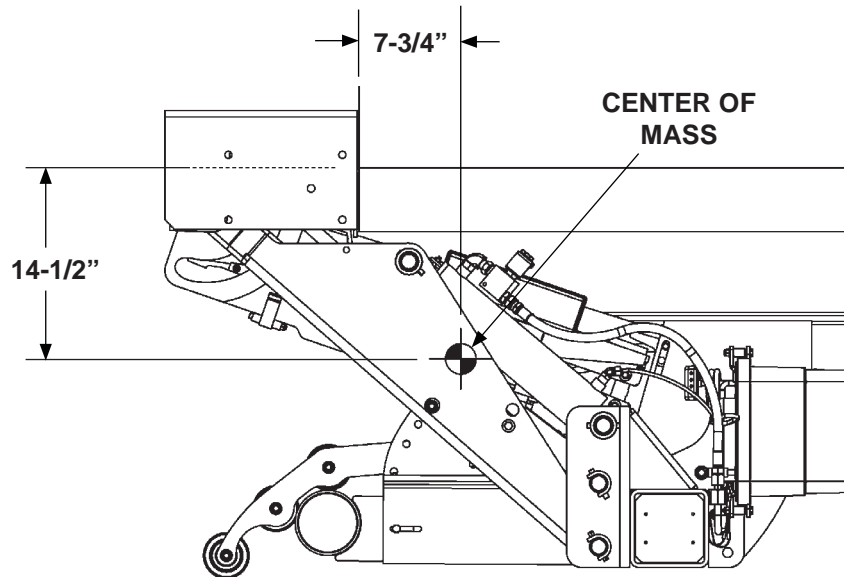
**GPTLR-25 & GPTLR-33 CENTER OF MASS  
(STOWED POSITION)  
FIG. 16-2**



# CENTER OF MASS - Continued



**GPTLR-44 & GPTLR-55 CENTER OF MASS  
(PLATFORM AT BED HEIGHT)  
FIG. 17-1**

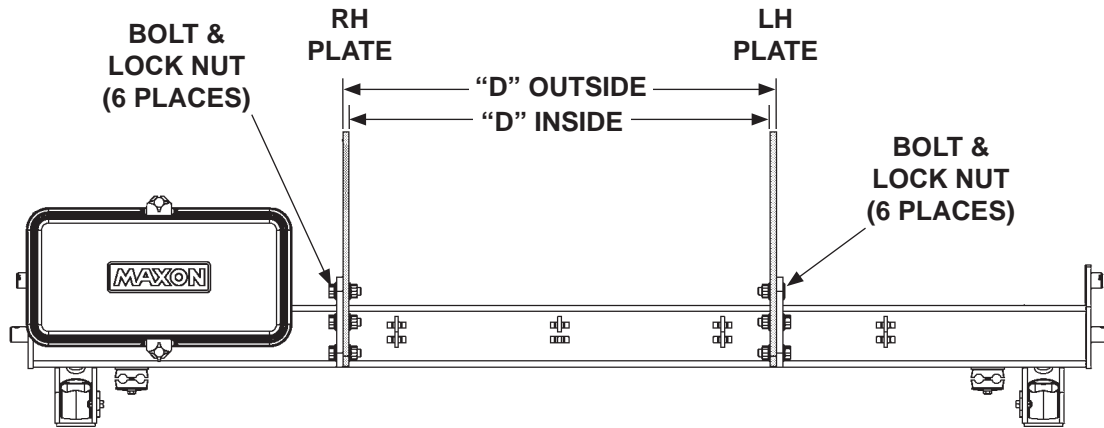


**GPTLR-44 & GPTLR-55 CENTER OF MASS  
(STOWED POSITION)  
FIG. 17-2**

# STEP 1 - WELD LIFTGATE TO VEHICLE

**NOTE:** GPTLR Liftgates are equipped with mounting plates installed at the factory. Mounting plate widths are shown based upon truck or trailer frame widths. Ensure you have the correct mounting plate kit for your application.

If it's necessary to unbolt mounting plates from main frame (**FIG 18-1**), torque mounting plate nuts and bolts **220-240 lb-ft** (GPTLR-25/GPTLR-33) or **350-375 lb-ft** (GPTLR-44/GPTLR-55).



**BOLT ON MOUNTING PLATES FOR INSTALLATION ON TRUCKS & TRAILERS  
(REAR VIEW OF LIFTGATE)  
FIG. 18-1**

LIFTGATE MODEL	"D" INSIDE	"D" OUTSIDE	APPLICATION
GPTLR-25/GPTLR-3	34-1/4"	35-1/4"	Common truck chassis width
	32-3/4"	33-3/4"	Trailer applications
	34-13/16"	35-13/16"	Trailer applications (91 cm)

**TABLE 18-1**

LIFTGATE MODEL	"D" INSIDE	"D" OUTSIDE	APPLICATION
GPTLR-44/GPTLR-55	34-1/4"	35-1/4"	Common truck chassis width
	33-1/4"	34-1/4"	Trailer applications
	34"	35"	
	34-13/16"	35-13/16"	Trailer applications (91 cm)
	37-1/4"	38-1/4"	Trailer applications

**TABLE 18-2**

# STEP 1 - WELD LIFTGATE TO VEHICLE - Continued

## ⚠ 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.

**NOTE:** This procedure contains the recommended method for lifting and supporting the Liftgate during installation. Other methods, such as hoisting the Liftgate, may be used if careful shop practices are employed.

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

1. Clamp Liftgate to forklift as shown in **FIG. 19-1A**. For GPTLR-25 and GPTLR-33 Liftgates equipped with ICC bumper, place a piece of wood between the ICC bumper and forks on the forklift for additional support as shown in **FIG. 19-1C**.

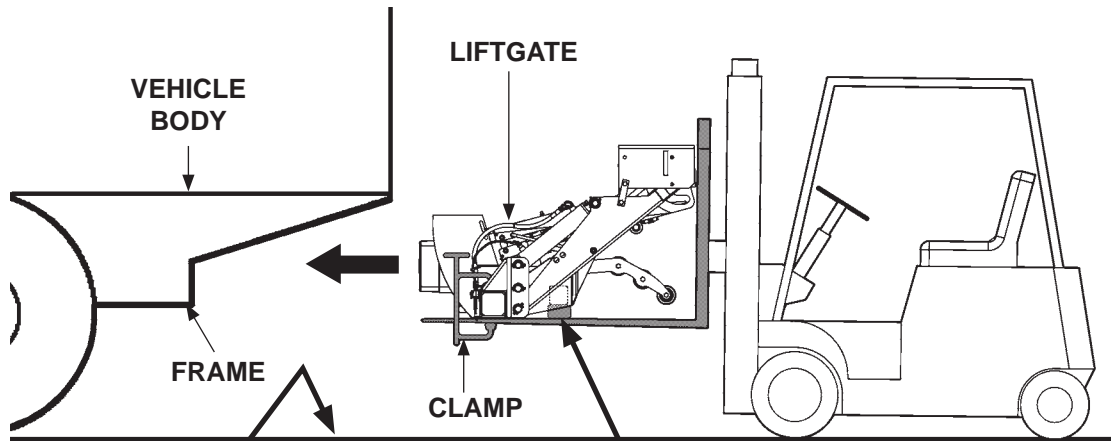


FIG. 19-1A

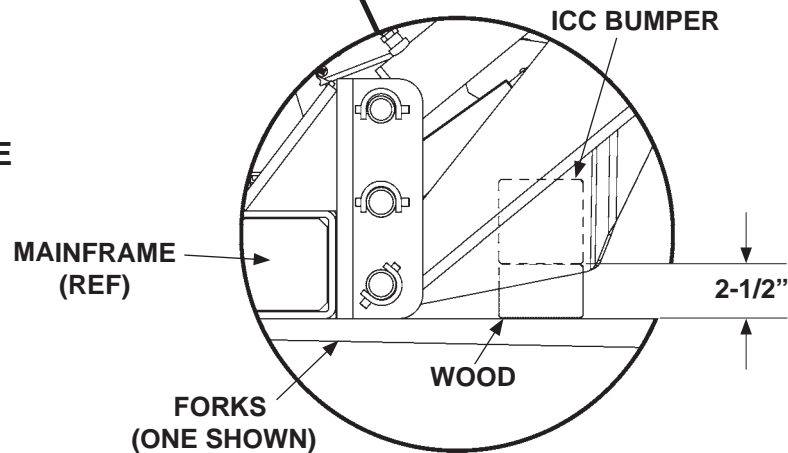
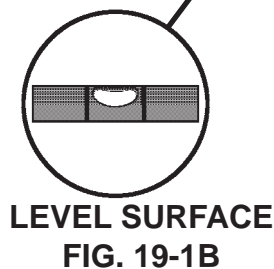
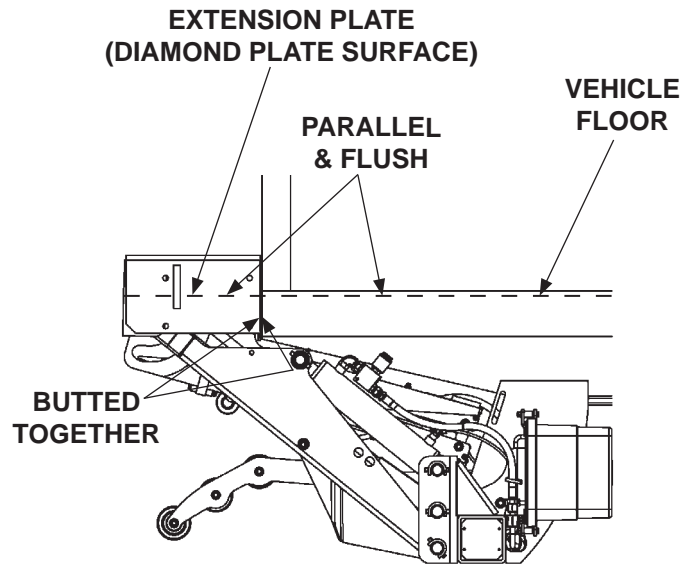


FIG. 19-1C

2. Use forklift to center the Liftgate in position on the back of the vehicle body and frame (**FIG. 19-1A**). If necessary, have 1 person operate the forklift and 1 other person check alignment of Liftgate and vehicle.

## STEP 1 - WELD LIFTGATE TO VEHICLE - Continued

3. Make sure the extension plate is butted against vehicle body (**FIG. 20-1**). Extension plate (diamond plate surface) must be parallel and flush with floor of vehicle body (**FIGS. 20-1 & 20-2**).



SIDE VIEW OF EXTENSION PLATE AND VEHICLE BODY (FORKLIFT NOT SHOWN)  
FIG. 20-1

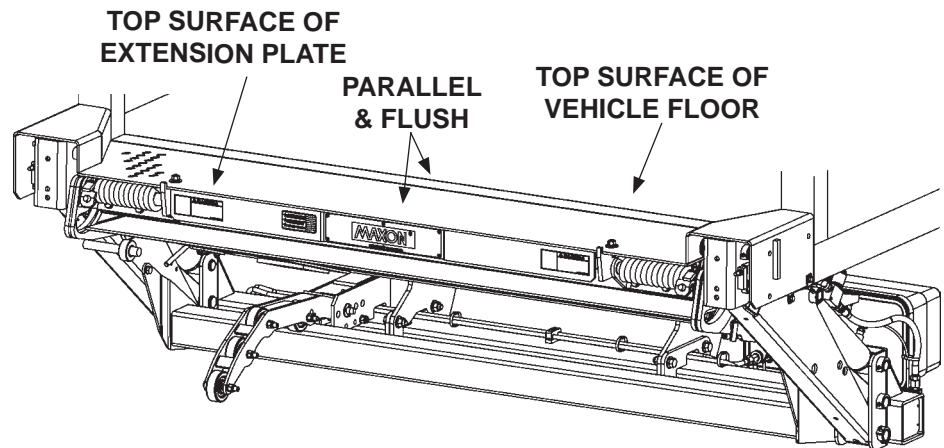


FIG. 20-2

## STEP 1 - WELD LIFTGATE TO VEHICLE - Continued

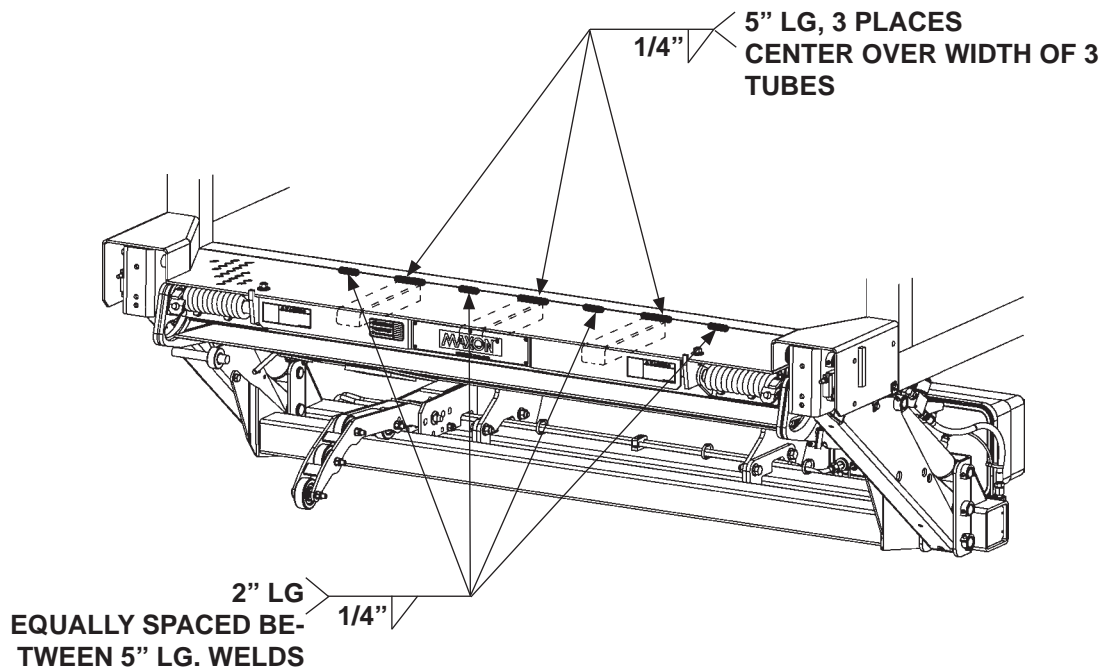
### CAUTION

When using an electric welder, connect the welder ground to one of the parts being welded, as close to the weld as possible. Failure to comply could result in damage to cylinders and electrical parts.

**NOTE:** While welding extension plate to vehicle body sill, make sure the diamond plate surface on the extension plate stays flush with the sill.

**NOTE:** For welding galvanized steel, refer to recommended practices as outlined in **AWS (American Welding Society) D19.0 Welding Zinc-Coated Steel.**

4. Weld the top of extension plate to vehicle body sill as shown in **FIG. 21-1**.



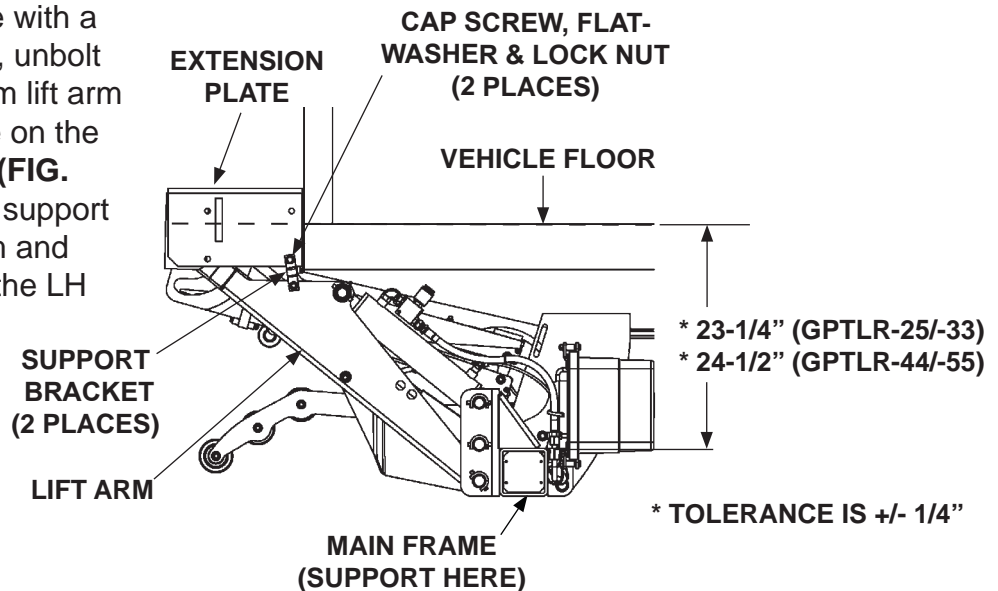
**EXTENSION PLATE WELDS - VIEWED FROM ABOVE  
(FORKLIFT NOT SHOWN)  
FIG. 21-1**

## STEP 1 - WELD LIFTGATE TO VEHICLE - Continued

### CAUTION

Correct vehicle floor clearance must be maintained when Liftgate is in position and being welded. Maintain distance between vehicle floor and top of main frame at center of main frame as shown in the instructions. Dimension tolerance is  $\pm 1/4$ ". Never apply force at the ends of the main frame tube to change the floor clearance.

5. Support main frame with a forklift or jack. Next, unbolt support bracket from lift arm and extension plate on the RH side of Liftgate (**FIG. 22-1**). Then, unbolt support bracket from lift arm and extension plate on the LH side of Liftgate.



**SIDE VIEW OF EXTENSION PLATE AND VEHICLE BODY  
(FORKLIFT NOT SHOWN)**

**FIG. 22-1**

6. Raise the Liftgate into correct position on the vehicle frame. Maintain distance between floor and top of main frame as shown in **FIG. 22-1**.

## STEP 1 - WELD LIFTGATE TO VEHICLE - Continued

### ⚠ WARNING

Liftgate is shipped from factory with mounting plates bolted to the main frame. Weld the mounting plates as shown in illustrations before operating Liftgate.

### CAUTION

Prevent damage to hydraulic hoses. Before welding next to hydraulic hoses, protect with heat-resistant cover.

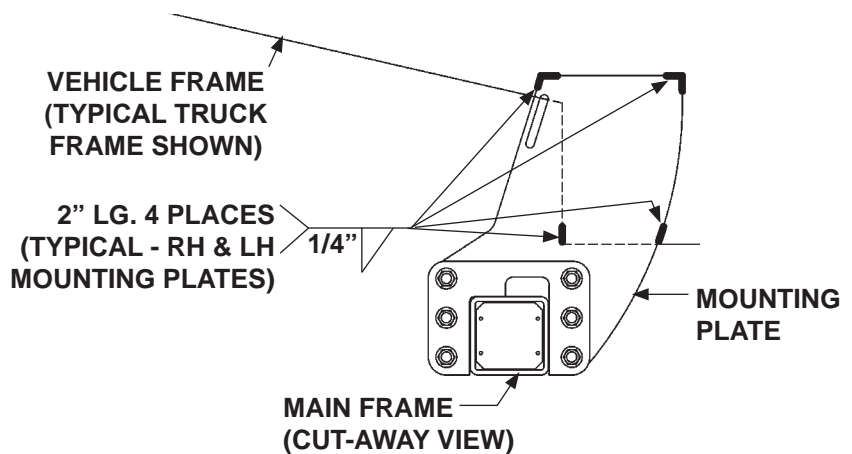
### CAUTION

When using an electric welder, connect the welder ground to one of the parts being welded, as close to the weld as possible. Failure to comply could result in damage to cylinders and electrical parts.

### CAUTION

To protect the original paint system, a 3" wide area of paint must be removed from all sides of the weld area before welding.

7. Clamp both mounting plates to outboard side of vehicle frame. Weld each mounting plate to vehicle frame as shown in **FIG. 23-1**. Remove clamps.



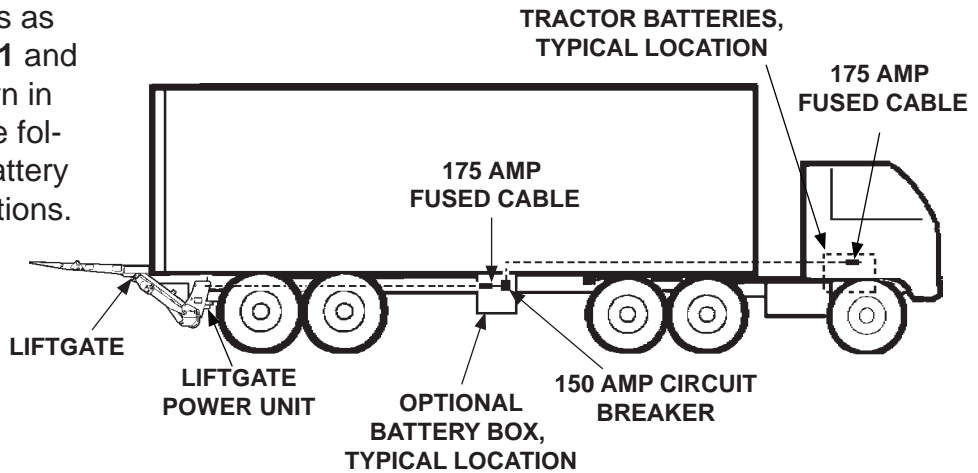
**WELD LIFTGATE TO VEHICLE FRAME  
(RH SIDE SHOWN)  
FIG. 23-1**

# STEP 2 - ATTACH OPTIONAL BATTERY BOX & FRAME TO VEHICLE (IF EQUIPPED)

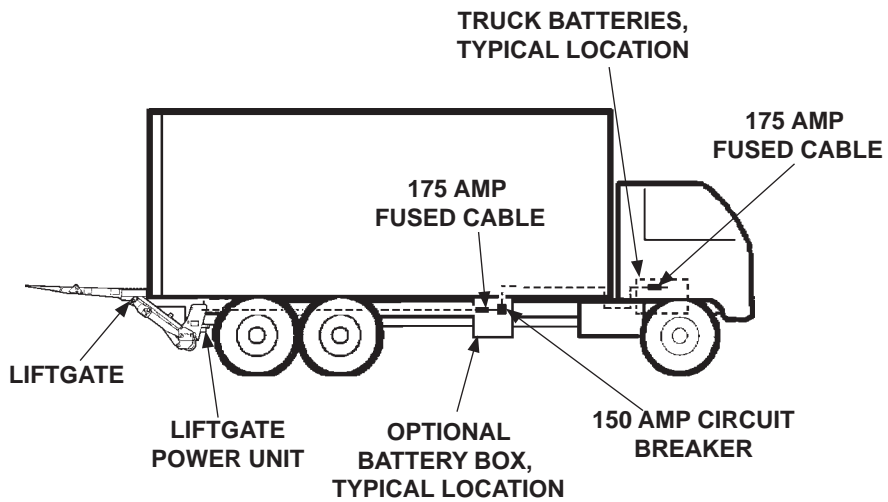
## RECOMMENDED CONFIGURATION

**NOTE:** Make sure the Liftgate power unit, and all batteries on the vehicle for the power unit, are connected correctly to a common chassis ground.

1. Liftgate and optional battery box are typically installed on trailers as shown in **FIG. 24-1** and on trucks as shown in **FIG. 24-2**. See the following page for battery and cable connections.



**RECOMMENDED LIFTGATE & OPTIONAL BATTERY BOX INSTALLATION ON TRAILER**  
**FIG. 24-1**

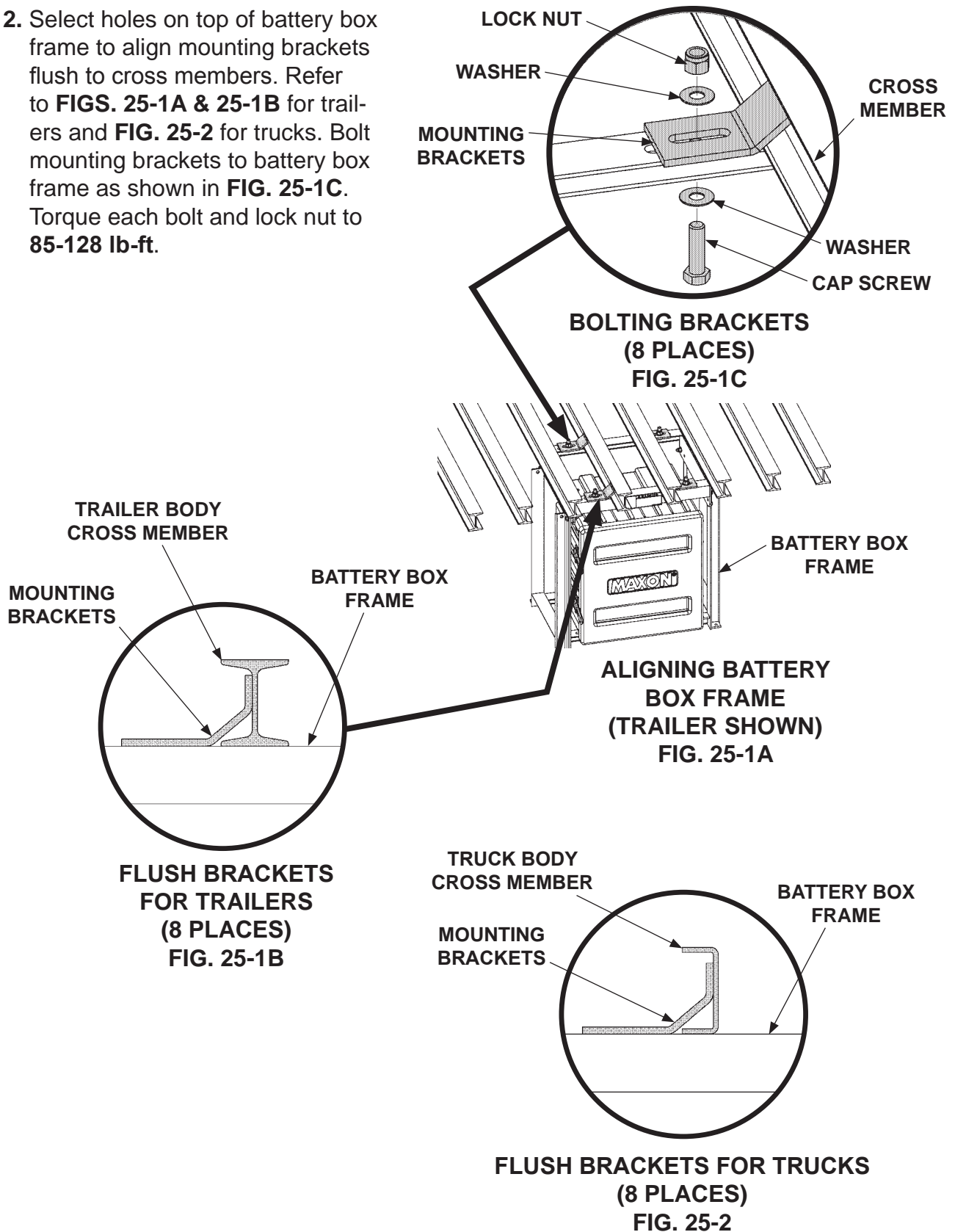


**RECOMMENDED LIFTGATE & BATTERY BOX INSTALLATION ON TRUCK**  
**FIG. 24-2**



## STEP 2 - ATTACH OPTIONAL BATTERY BOX & FRAME TO VEHICLE (IF EQUIPPED) - Continued

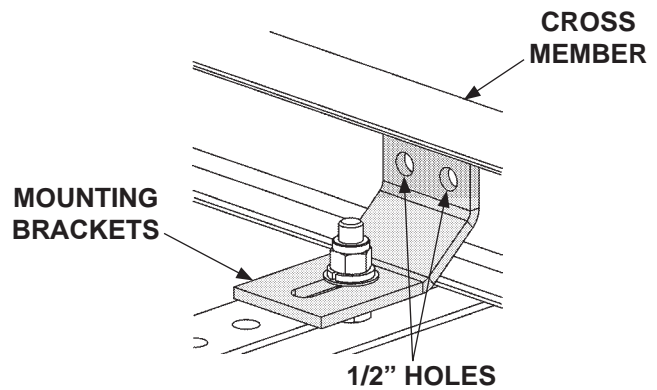
2. Select holes on top of battery box frame to align mounting brackets flush to cross members. Refer to **FIGS. 25-1A & 25-1B** for trailers and **FIG. 25-2** for trucks. Bolt mounting brackets to battery box frame as shown in **FIG. 25-1C**. Torque each bolt and lock nut to **85-128 lb-ft.**



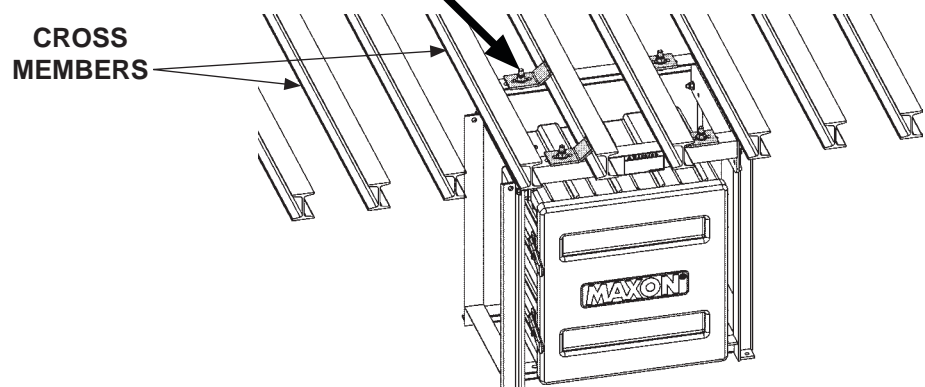
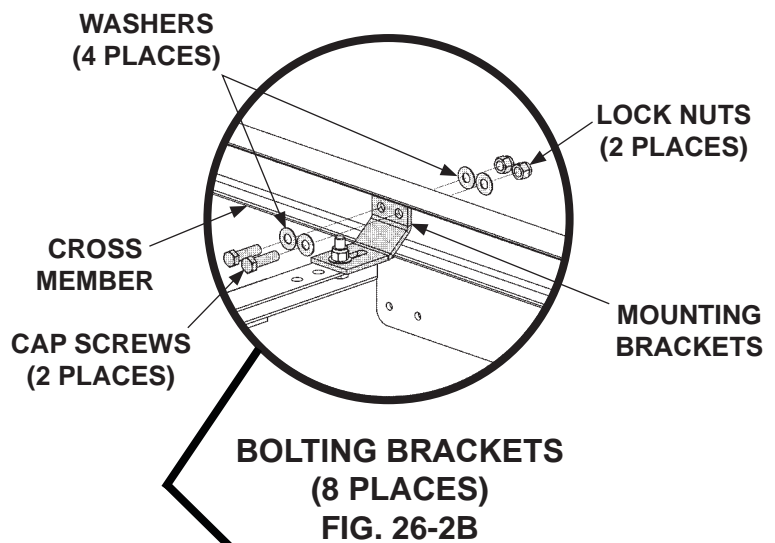
## STEP 2 - ATTACH OPTIONAL BATTERY BOX & FRAME TO VEHICLE (IF EQUIPPED) - Continued

**NOTE:** If welding mounting brackets to cross members, skip instruction 3.

- Using mounting brackets as a template mark and drill holes through cross members (**FIG. 26-1**). Bolt mounting brackets to cross members as shown in **FIGS. 26-2A and 26-2B**. Torque bolts and lock nuts to **85-128 lb-ft.**



**MARK AND DRILL BRACKET HOLES**  
**FIG. 26-1**



**BOLTING BATTERY BOX FRAME**  
**FIG. 26-2A**

## STEP 2 - ATTACH OPTIONAL BATTERY BOX & FRAME TO VEHICLE (IF EQUIPPED) - Continued

### ⚠ WARNING

Recommended practices for welding on steel parts are contained in the current AWS (American Welding Society) D1.1 Structural Welding Code - Steel. Damage to Liftgate and/or vehicle, and personal injury can result from welds that are done incorrectly.

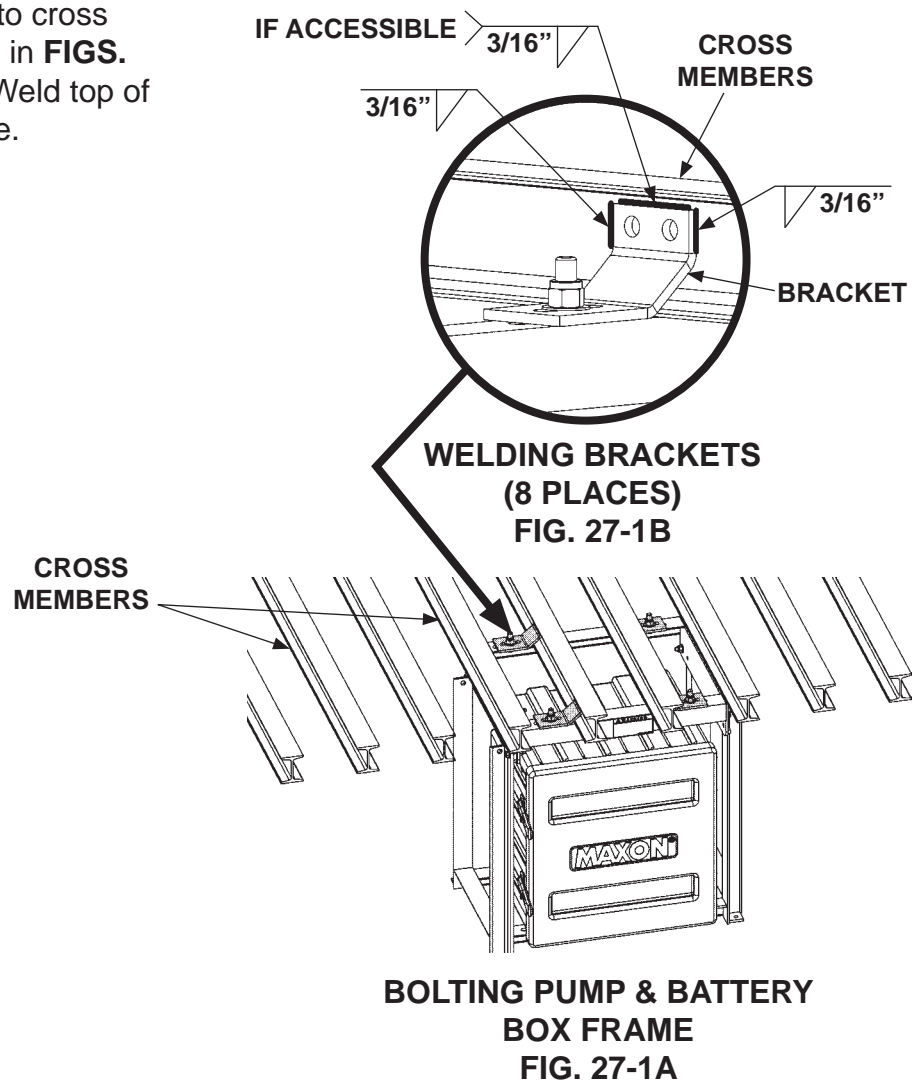
### CAUTION

To prevent pump box components from being damaged by electric current from welding, connect welder grounding cable to the part being welded.

### CAUTION

Cover pump box and optional battery box with flame-resistant covering before welding pump box frame to vehicle.

4. Weld each bracket to cross members as shown in **FIGS. 27-1A and 27-1B**. Weld top of bracket if accessible.



## STEP 2 - ATTACH OPTIONAL BATTERY BOX & FRAME TO VEHICLE (IF EQUIPPED) - Continued

### ⚠ WARNING

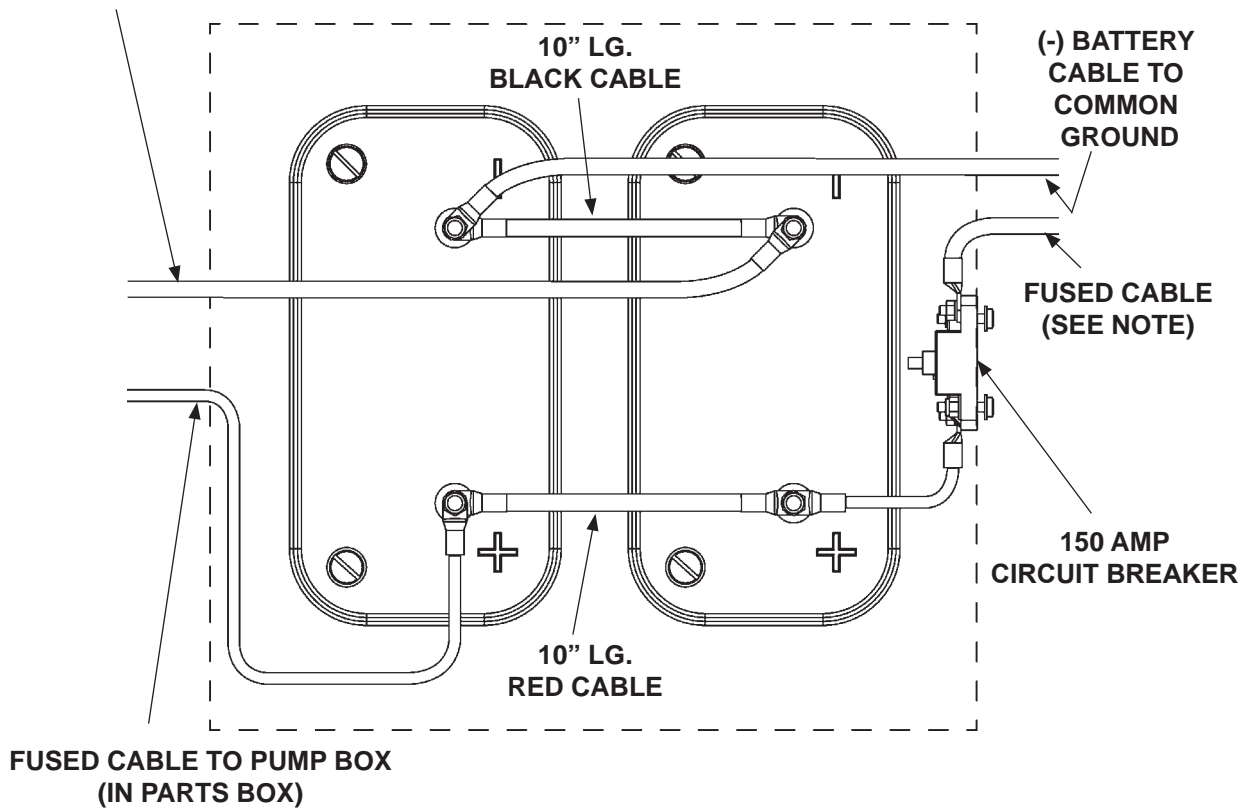
Remove all rings, watches and jewelry before doing any electrical work.

**NOTE:** Always connect fused end of power cable to battery positive (+) terminal.

**NOTE:** To connect charge lines, refer to instructions provided with each charge line kit.

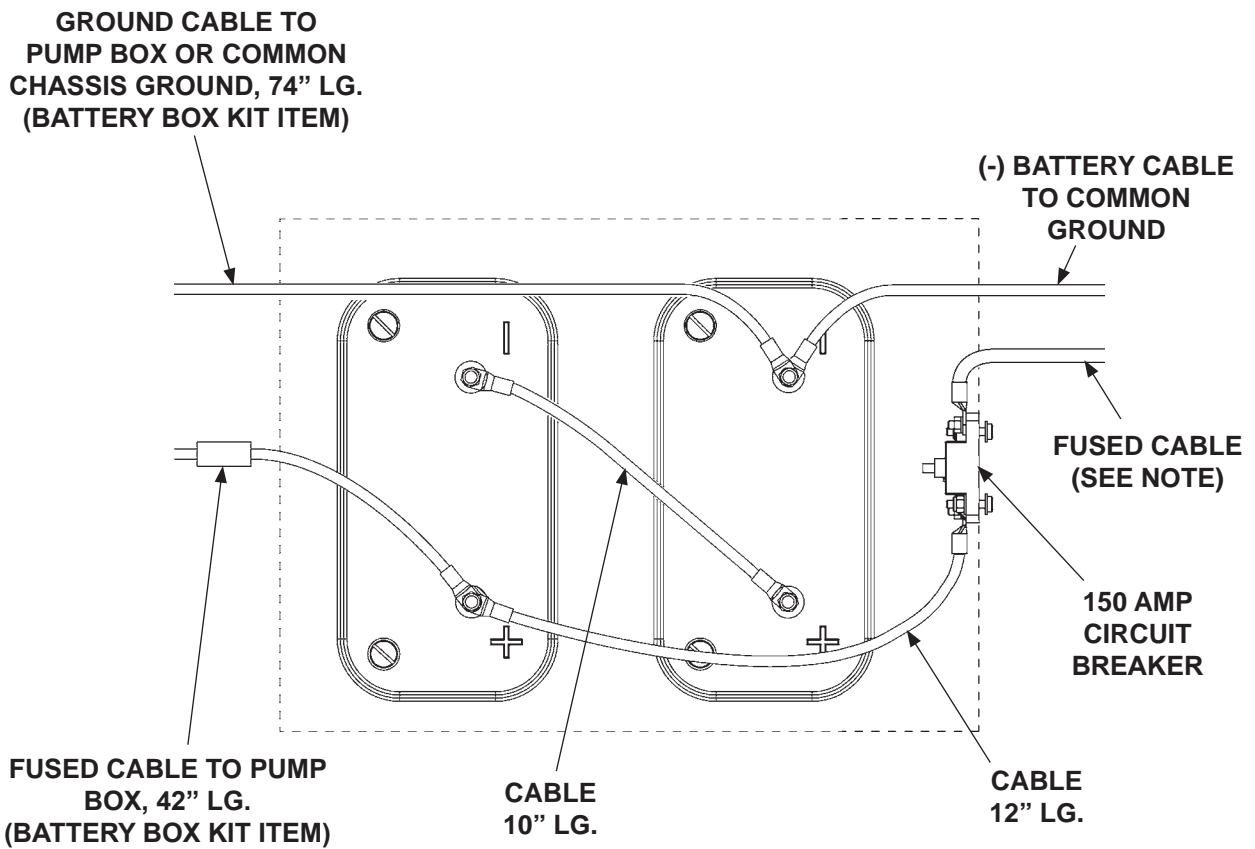
5. Connect battery cables, fused cables, and ground cables for 12 volt power as shown in **FIG. 28-1**. Refer to **FIG. 29-1** for connecting 24 volt power.

GROUND CABLE TO PUMP BOX OR COMMON CHASSIS GROUND, 74" LG. (BATTERY BOX KIT ITEM)



12 VOLT BATTERY CONNECTIONS FOR 12 VOLT POWER  
FIG. 28-1

## STEP 2 - ATTACH OPTIONAL BATTERY BOX & FRAME TO VEHICLE (IF EQUIPPED) - Continued

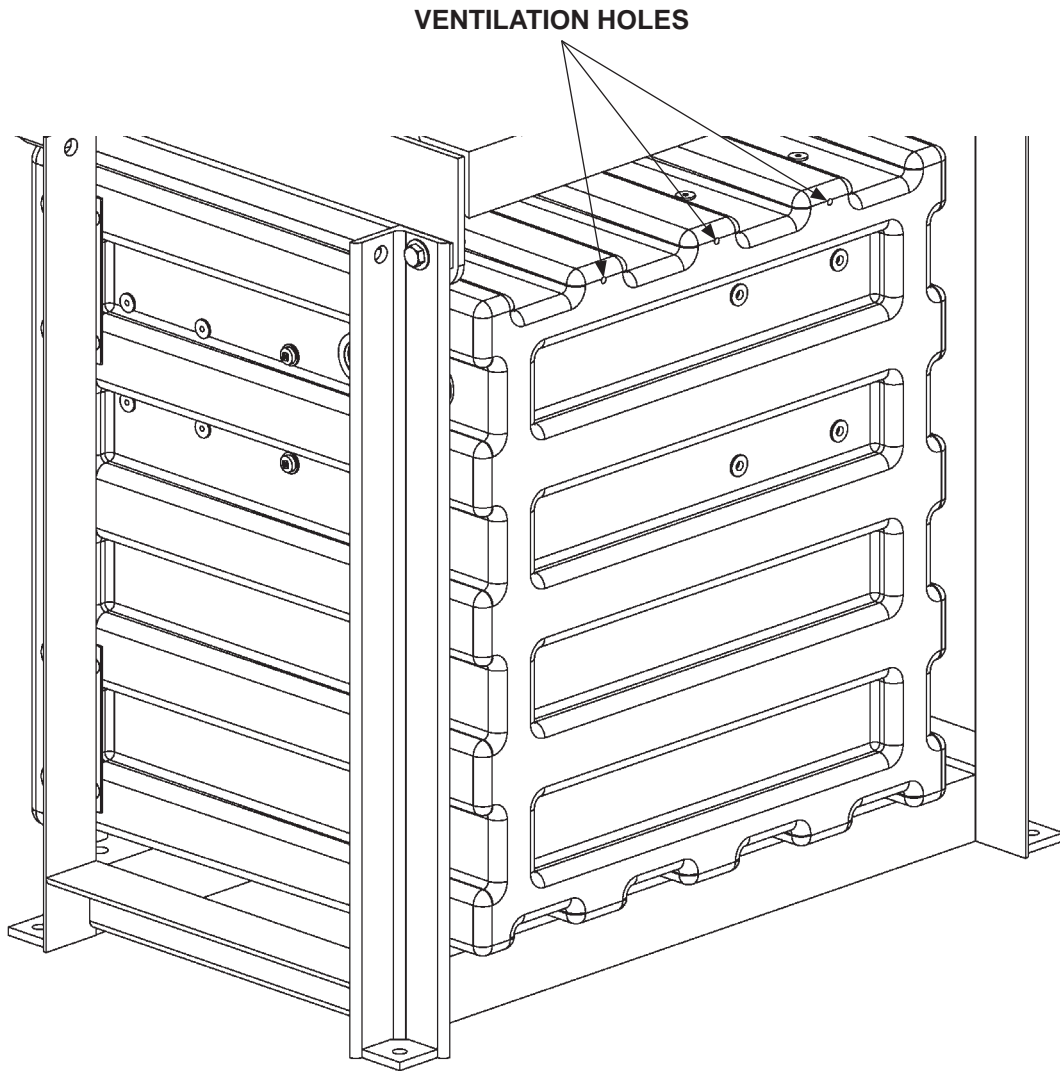


12 VOLT BATTERY CONNECTIONS  
FOR 24 VOLT POWER  
FIG. 29-1

## STEP 2 - ATTACH OPTIONAL BATTERY BOX & FRAME TO VEHICLE (IF EQUIPPED) - Continued

### **⚠ WARNING**

Explosive hydrogen gas from charging batteries can accumulate in battery box if not vented from the box. To prevent hydrogen gas from accumulating, ensure the 3 ventilation holes in battery box are not plugged or covered.



**BATTERY BOX ASSEMBLY  
(REAR VIEW SHOWN)  
FIG. 30-1**

# STEP 2 - ATTACH OPTIONAL BATTERY BOX & FRAME TO VEHICLE (IF EQUIPPED) - Continued

## BATTERY BOX ASSEMBLY

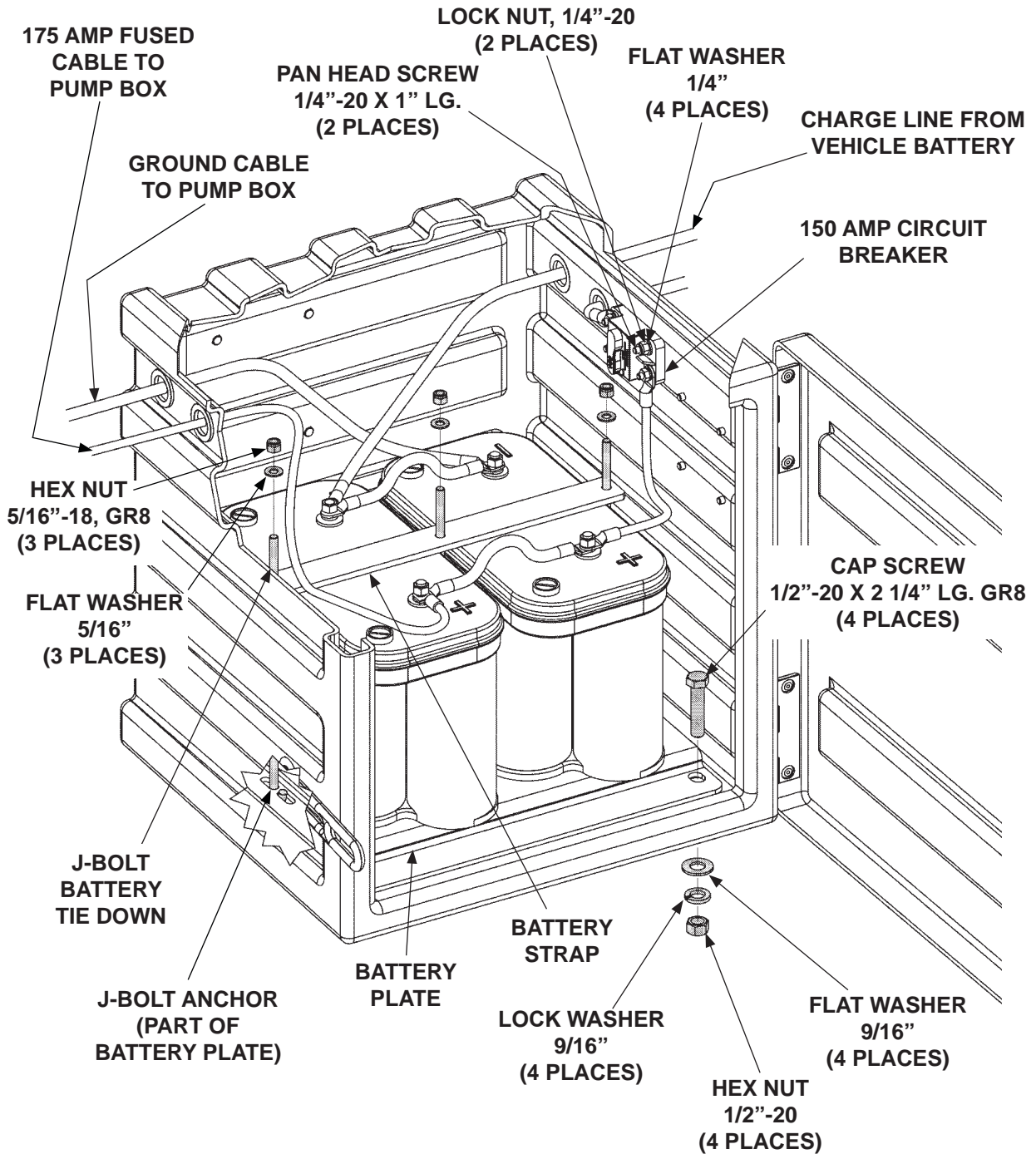


FIG. 31-1

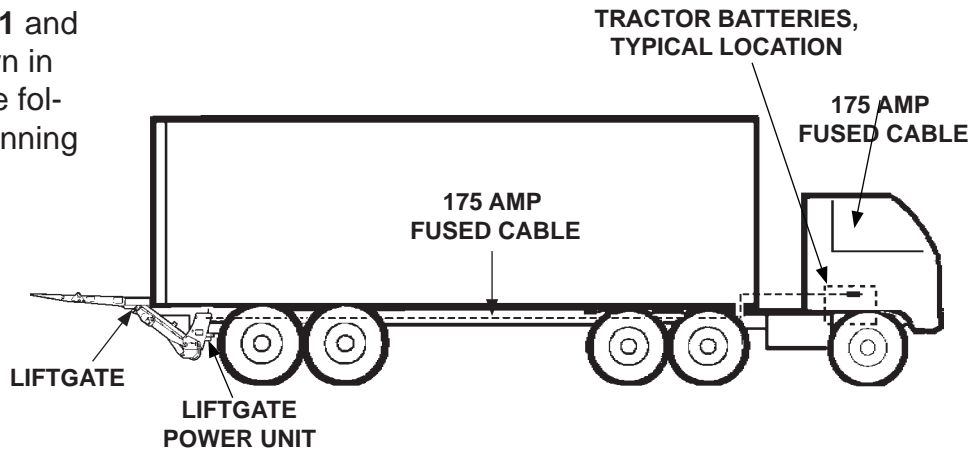
MAXON® 11921 Slauson Ave. Santa Fe Springs, CA. 90670 (800) 227-4116 FAX (888) 771-7713

## STEP 3 - RUN POWER CABLE

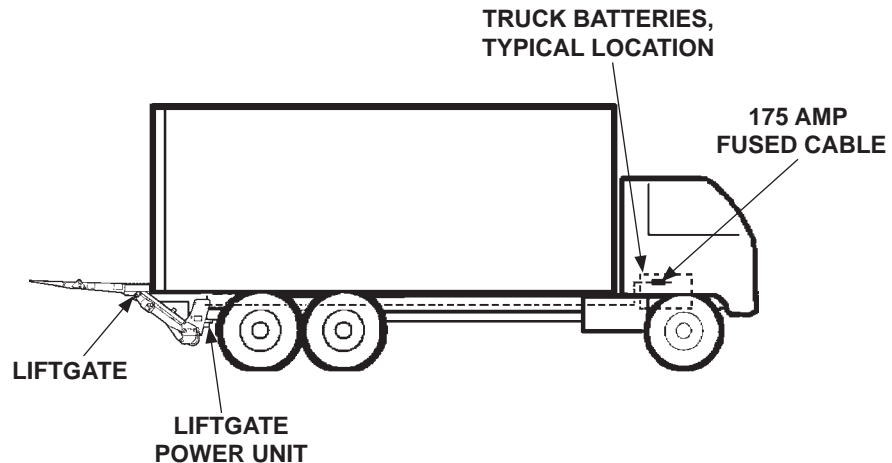
**NOTE:** Make sure the Liftgate power unit, and all batteries on the vehicle for the power unit, are connected correctly to a common chassis ground.

### RECOMMENDED CONFIGURATION

1. Liftgate powered from truck batteries is typically installed on trailers as shown in **FIG. 32-1** and on trucks as shown in **FIG. 32-2**. See the following page for running the power cable.



RECOMMENDED LIFTGATE & POWER CABLE  
INSTALLATION ON TRAILER  
FIG. 32-1



RECOMMENDED LIFTGATE & POWER CABLE  
INSTALLATION ON TRUCK  
FIG. 32-2



## STEP 3 - RUN POWER CABLE - Continued

### ⚠ 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.

2. Clip fused power cable to vehicle chassis with fuse nearest the vehicle battery, as shown in **FIG. 33-1**. Keep enough cable near the battery to reach the positive terminal without straining cable (after connection). Run cable to pump box on Liftgate.

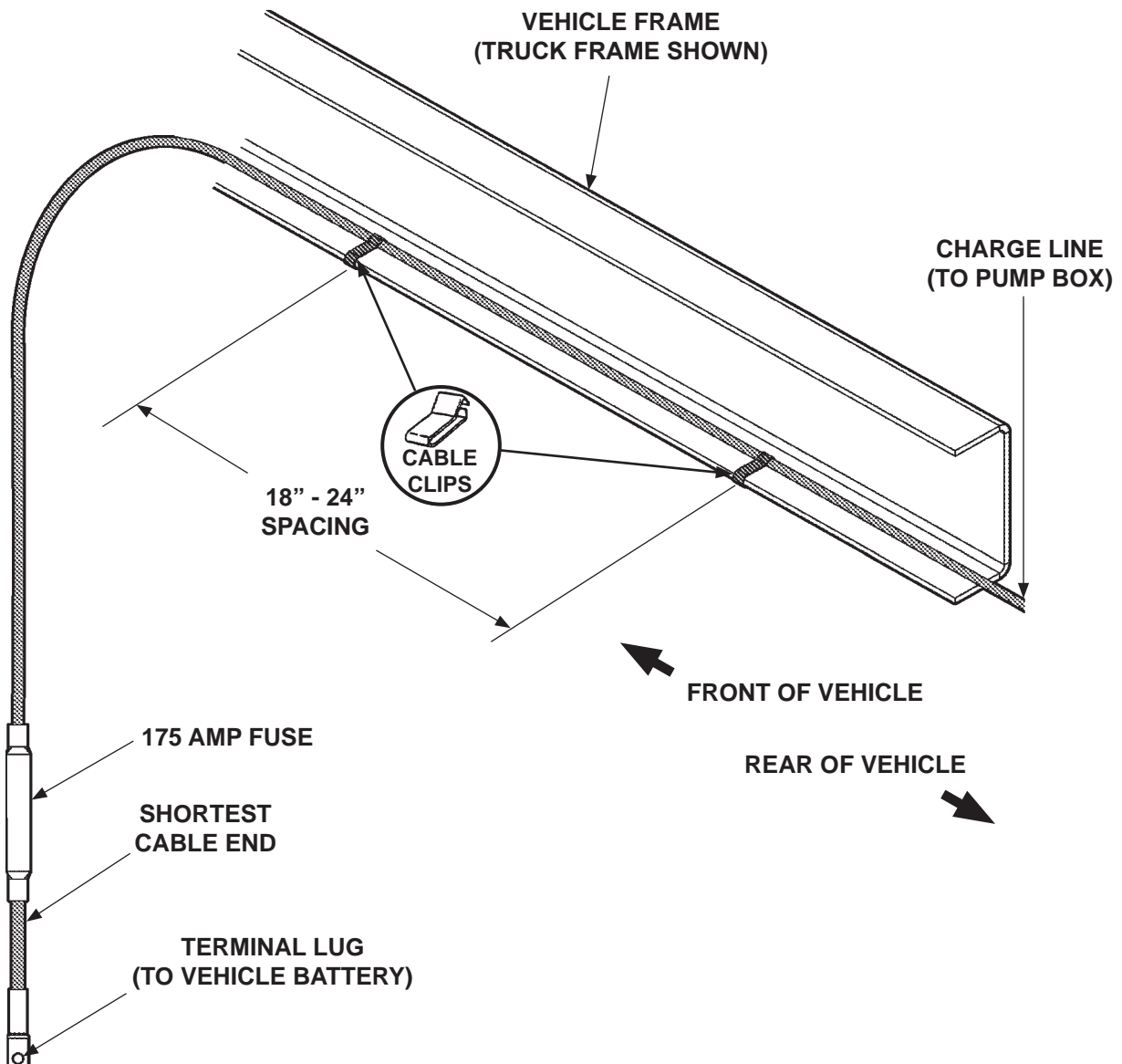
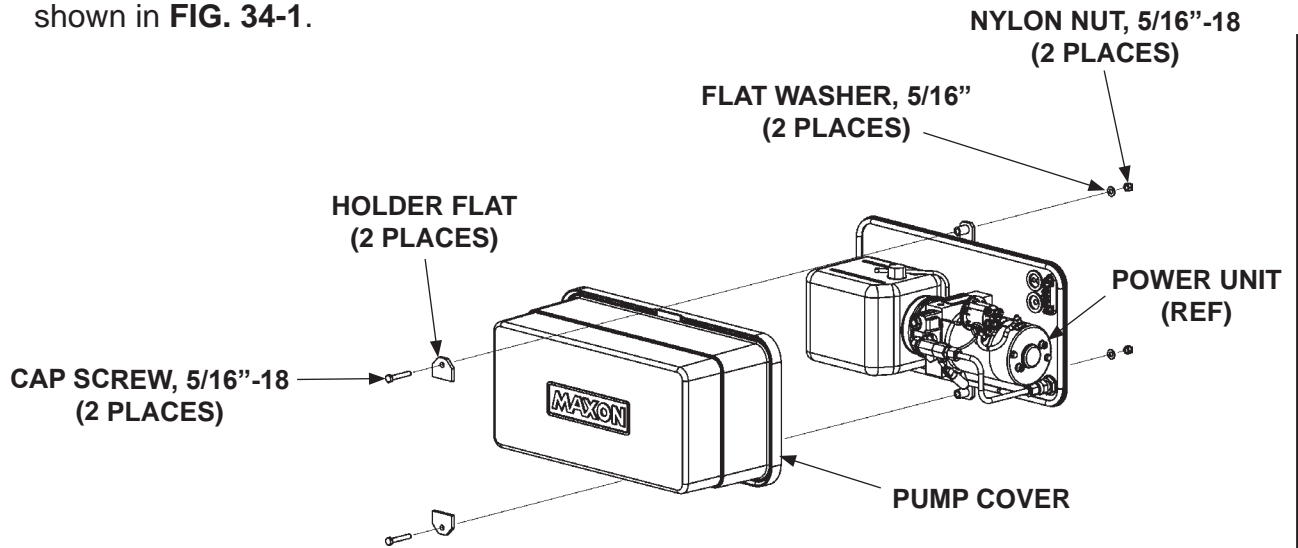


FIG. 33-1

## STEP 4 - CONNECT POWER CABLE

1. Unbolt and remove pump cover as shown in **FIG. 34-1**.



UNBOLTING PUMP COVER  
FIG. 34-1

## STEP 4 - CONNECT POWER CABLE - Continued

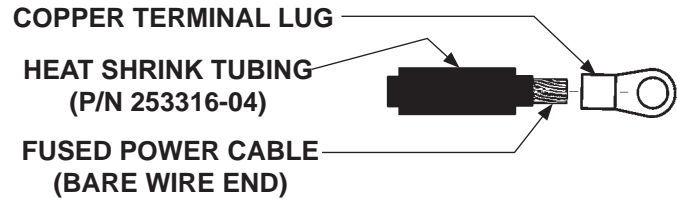
**NOTE:** Electrical lines must be run into pump box through sealing grommets (FIG. 35-3). To ensure a good seal on hydraulic & electrical lines, never cut the sealing grommets.

- Run fused power cable through grommet on pump mounting plate (FIG. 35-3).
- On the bare wire end of fused power cable, keep enough length to attach copper terminal lug and reach starter solenoid without putting tension on cable (after connection) (FIG. 35-1). Measure (if needed) and then cut excess cable from bare wire end of cable. Put heat shrink tubing (parts box) (FIG. 35-1) 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 heat shrink tubing (FIG. 35-2).

### CAUTION

Do not over-tighten the terminal nuts on starter solenoid. For the load terminals, torque nuts to 35 lb.-in. max. Torque the nuts on #10-32 control terminals 15 lb-in max.

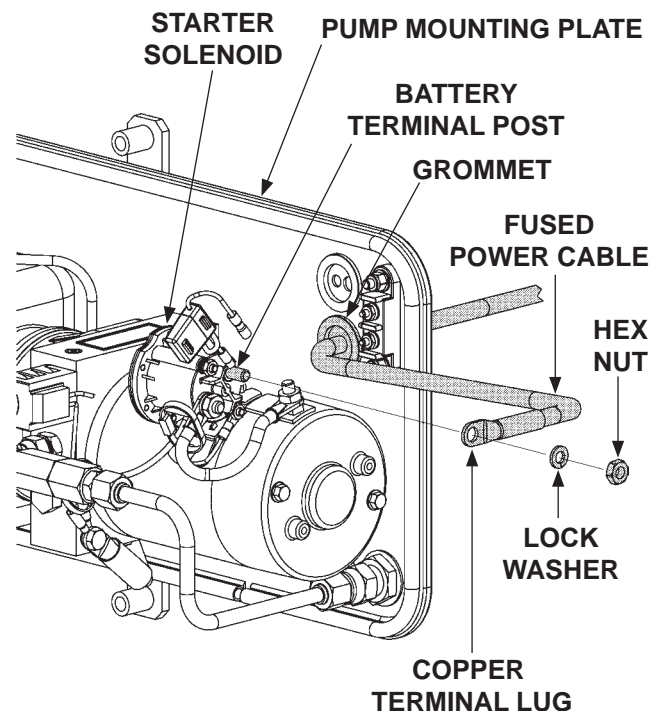
- Remove hex nut and lock washer from battery terminal post on the starter solenoid. Connect the fused power cable to the starter solenoid as shown in FIG. 35-3. Reinstall and tighten lock washer and hex nut. Torque hex nut to 35 lb-in maximum.



PLACING TERMINAL LUG & HEAT SHRINK TUBING ON FUSED POWER CABLE  
FIG. 35-1



TYPICAL FUSED POWER CABLE WITH TERMINAL LUG INSTALLED  
FIG. 35-2

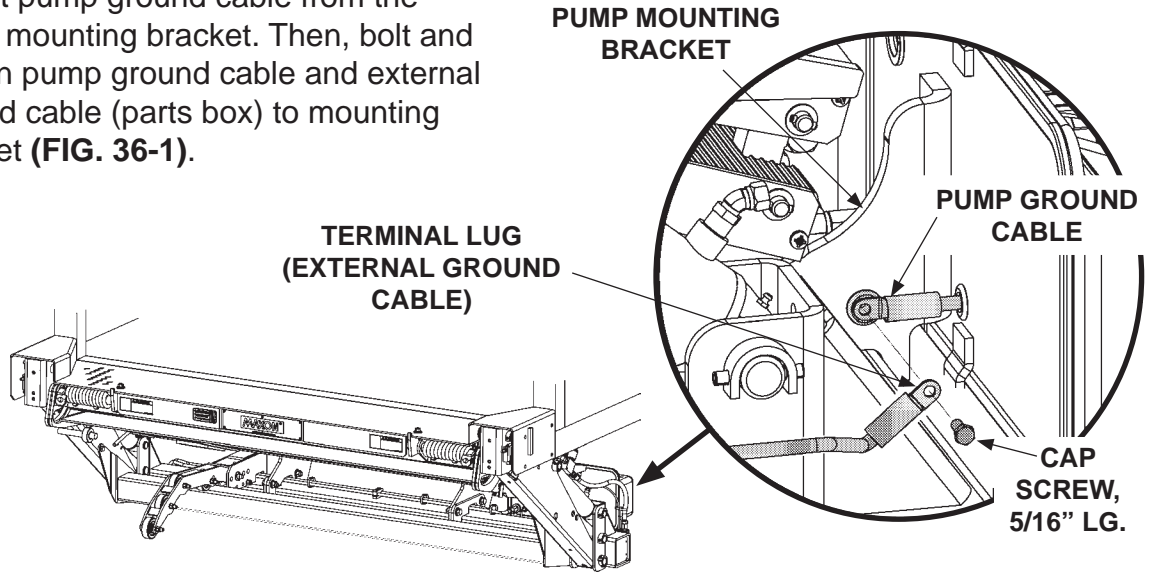


TYPICAL FUSED POWER CABLE CONNECTION (GRAVITY DOWN PUMP SHOWN)  
FIG. 35-3

# STEP 5 - CONNECT GROUND CABLE (RECOMMENDED)

**NOTE:** To ensure power unit is correctly grounded, MAXON recommends connecting 2 gauge ground cable from grounding connection on pump mounting plate to a grounding point on the frame, or negative battery terminal in the optional battery box.

1. Unbolt pump ground cable from the pump mounting bracket. Then, bolt and tighten pump ground cable and external ground cable (parts box) to mounting bracket (**FIG. 36-1**).

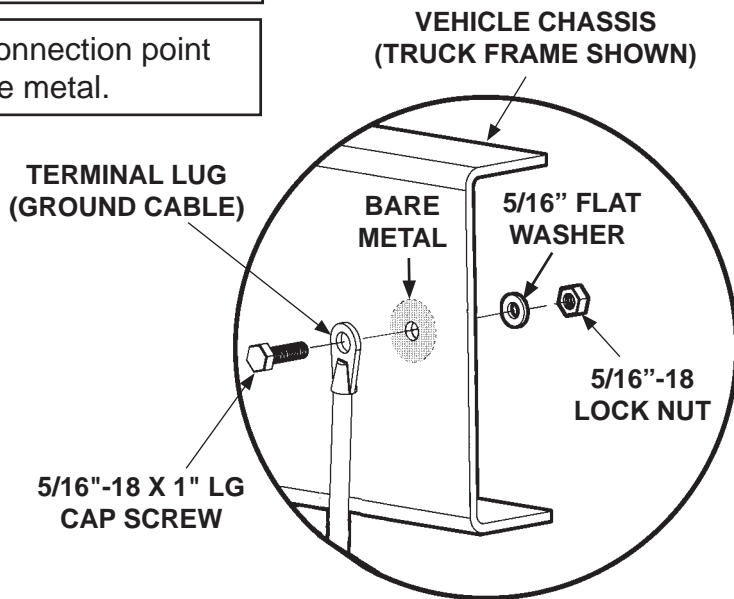


**CONNECTING EXTERNAL GROUND CABLE**  
**FIG. 36-1**

**NOTE:** If there is a grounding point on the frame, use it to connect ground cable. Then, skip the step for drilling a hole.

**NOTE:** Clean the ground cable connection point on the frame down to bare metal.

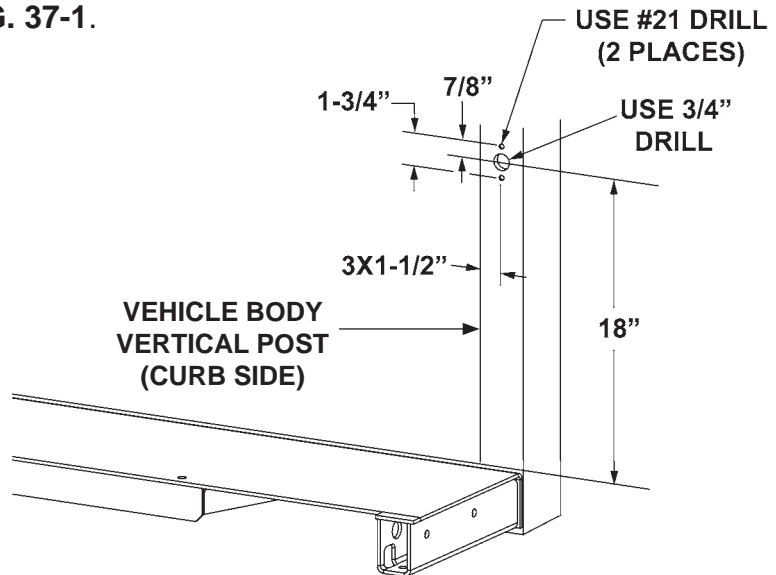
2. Extend the ground cable to reach vehicle frame (**FIG. 36-2**) without putting tension on cable (after connection). Connect to an existing grounding point if available.
3. If necessary, drill a 11/32" (0.343") hole in vehicle frame for bolting the ground cable terminal lug (**FIG. 36-2**).
4. To prevent corrosion, paint or use galvanized spray on bare metal area **FIG. 36-2**.
5. Bolt the ground cable terminal lug to vehicle frame as shown in **FIG. 36-2**.



**FIG. 36-2**

## STEP 6 - INSTALL CONTROL SWITCH

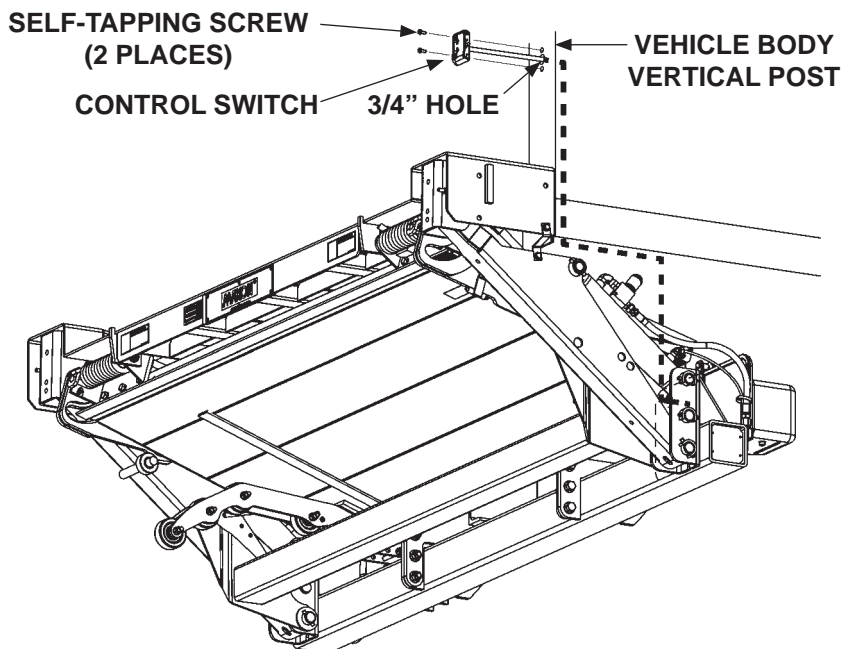
1. Measure, mark and drill one 3/4" hole and two #21-size holes in the vertical post on curb side of vehicle body as shown in **FIG. 37-1**.



**DRILLING MOUNTING HOLES  
FIG. 37-1**

2. Insert control switch wiring harness (parts box) into 3/4" hole on corner post and down the vertical post and under the vehicle body to the pump assembly. (See dashed line - **FIG. 37-2**.)

3. Push control switch and cable back into the 3/4" hole in the vertical post until control switch touches the post (**FIG. 37-2**). Attach control switch to vertical post with 2 self-tapping screws (parts box) (**FIG. 37-2**).



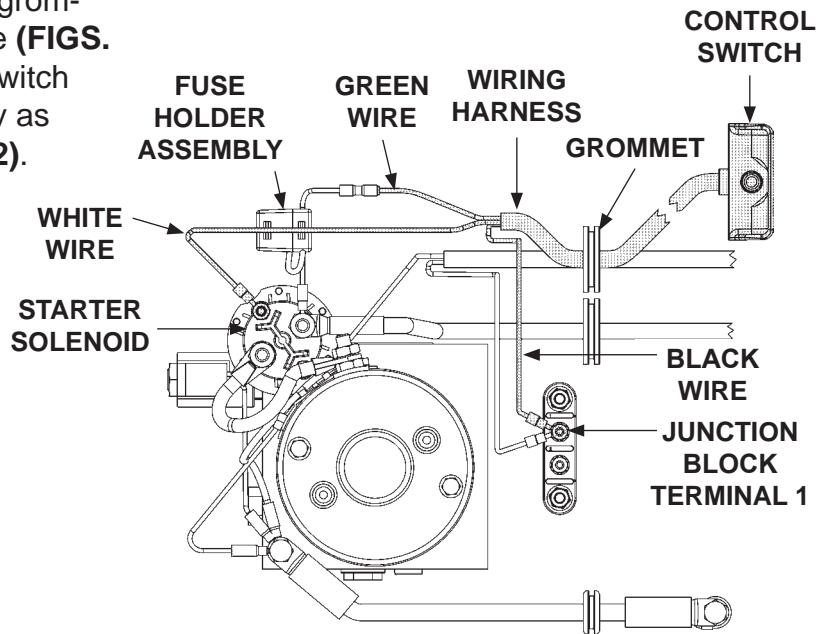
**ROUTING CONTROL SWITCH WIRING  
FIG. 37-2**

4. If necessary, use clamps and self-tapping screws (parts box) to secure switch cable to vehicle under-body and frame (**FIG. 37-2**).

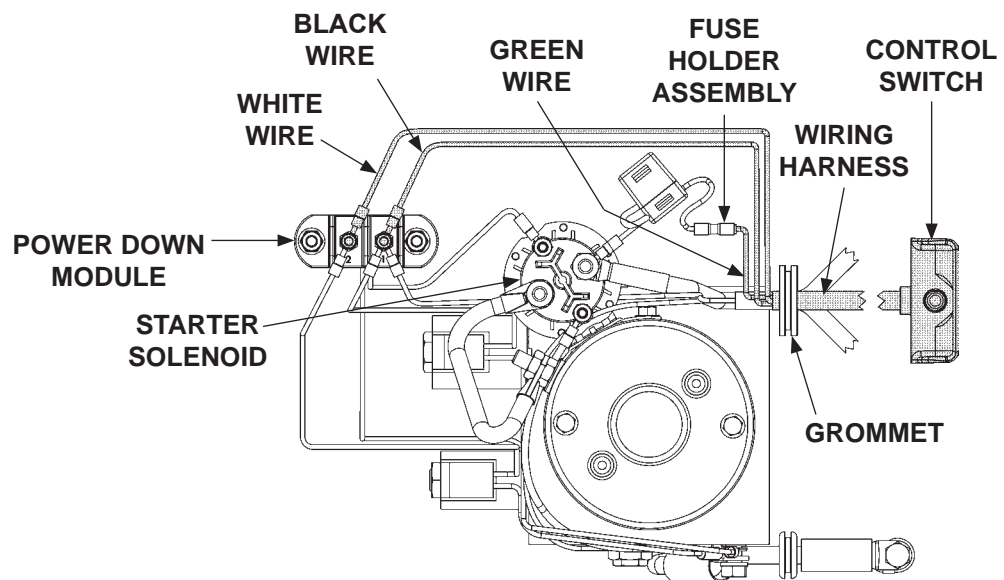
## STEP 6 - INSTALL CONTROL SWITCH - Continued

**NOTE:** Electrical lines must be run into pump box through sealing grommets (FIGS. 38-1 & 38-2). To ensure a good seal on the electrical lines, never cut the sealing grommets.

5. Insert switch wiring through grommet on pump mounting plate (FIGS. 38-1 & 38-2). Connect the switch wiring to the pump assembly as shown in (FIGS. 38-1 & 38-2).



**CONTROL SWITCH WIRING CONNECTIONS  
(GRAVITY DOWN)  
FIG. 38-1**



**CONTROL SWITCH WIRING CONNECTIONS  
(POWER DOWN)  
FIG. 38-2**

## STEP 7 - CHECKING HYDRAULIC FLUID

### 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.

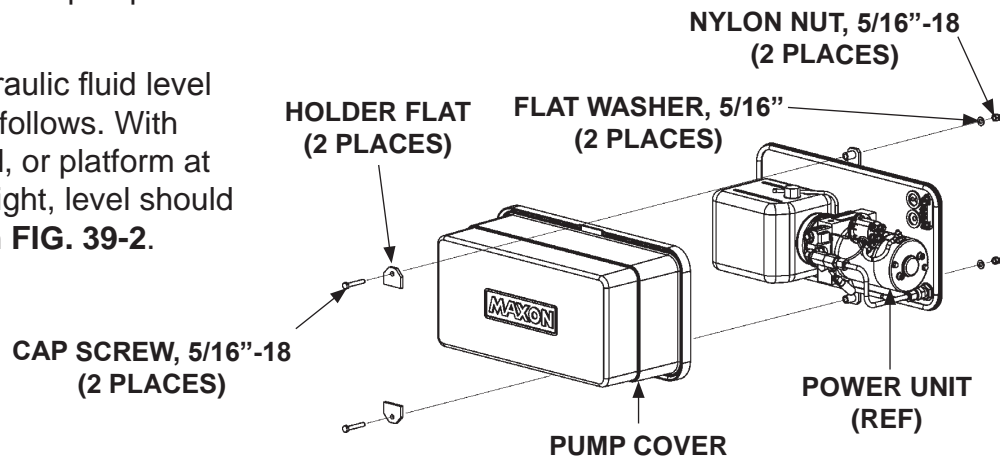
**NOTE:** Liftgate is shipped with **ISO 32** oil. Use correct oil for climate conditions.

**+50 to +120 Degrees F - Grade ISO 32**

**Below + 70 Degrees F - Grade ISO 15 or MIL-H-5606**

See **TABLES 40-1 & 40-2** for recommended brands of **ISO 32 & ISO 15 OILS**.

1. Unbolt and remove pump cover (**FIG. 39-1**).
2. Check the hydraulic fluid level in reservoir as follows. With Liftgate stowed, or platform at vehicle bed height, level should be as shown in **FIG. 39-2**.

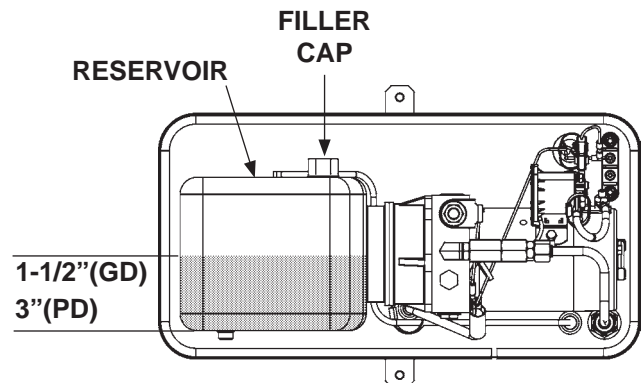


**UNBOLTING PUMP COVER**  
**FIG. 39-1**

3. If needed, add fluid to the reservoir as follows. Pull out (no threads) filler cap (**FIG. 39-2**). Fill the reservoir with hydraulic fluid to level shown in **FIG. 39-2**. Reinstall filler cap (**FIG. 39-2**).

### 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 butt against pump cover as shown in the illustration.



**POWER UNIT FLUID LEVEL**  
**FIG. 39-2**

4. Bolt on the pump cover as shown in **FIG. 39-1**. Torque the bolts (cap screws) to **10-14 lb-in.**

## STEP 7 - CHECKING HYDRAULIC FLUID - Continued

ISO 32 HYDRAULIC OIL	
RECOMMENDED BRANDS	PART NUMBER
CHEVRON	HIPERSYN 32
KENDALL	GOLDEN MV
SHELL	TELLUS S2 VX 32
EXXON	UNIVIS N-32
MOBIL	DTE-13M, DTE-24, HYDRAULIC OIL-13

**TABLE 40-1**

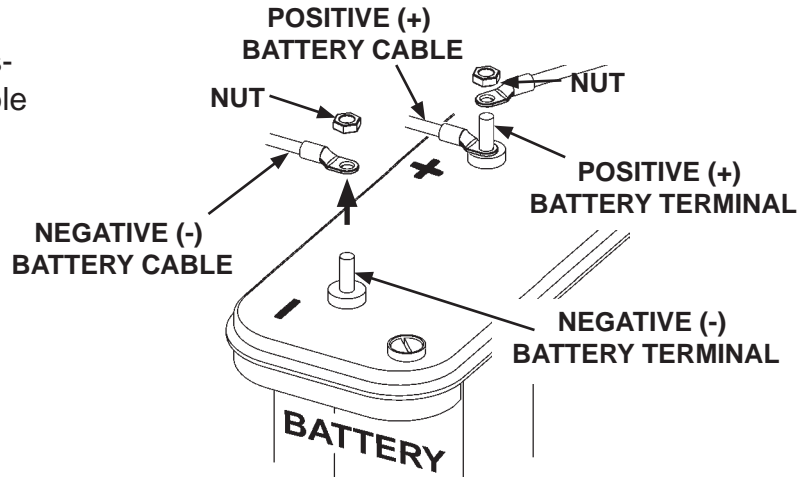
ISO 15 OR MIL-H-5606 HYDRAULIC OIL	
RECOMMENDED BRANDS	PART NUMBER
CHEVRON	FLUID A, AW-MV-15
KENDALL	GLACIAL BLU
SHELL	TELLUS S2 VX 15
EXXON	UNIVIS HVI-13
MOBIL	DTE-11M
ROSEMEAD	THS FLUID 17111

**TABLE 40-2**



## STEP 8 - CONNECT POWER CABLE TO BATTERY

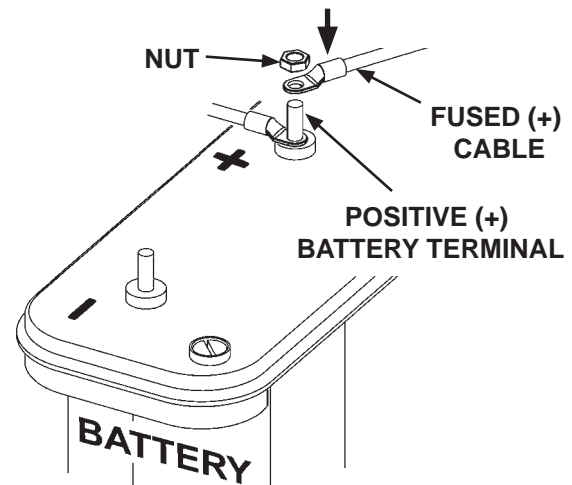
1. Remove nut from negative (-) battery terminal (FIG. 41-1). Disconnect negative (-) battery cable (FIG. 41-1).



DISCONNECTING (-) BATTERY CABLE  
FIG. 41-1

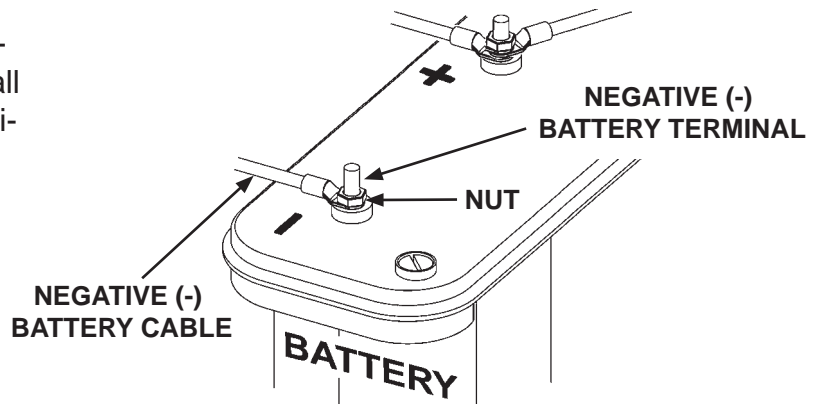
2. Remove nut from positive (+) battery terminal (FIG. 41-1).

3. Connect fused positive (+) cable to positive (+) battery terminal (FIG. 41-2). Then, reinstall nut on positive (+) battery terminal (FIG. 41-2).



CONNECTING FUSED (+) CABLE  
FIG. 41-2

4. Reconnect negative (-) battery cable to negative (-) battery terminal (FIG. 41-3). Then, reinstall nut on negative (-) battery terminal (FIG. 41-3).

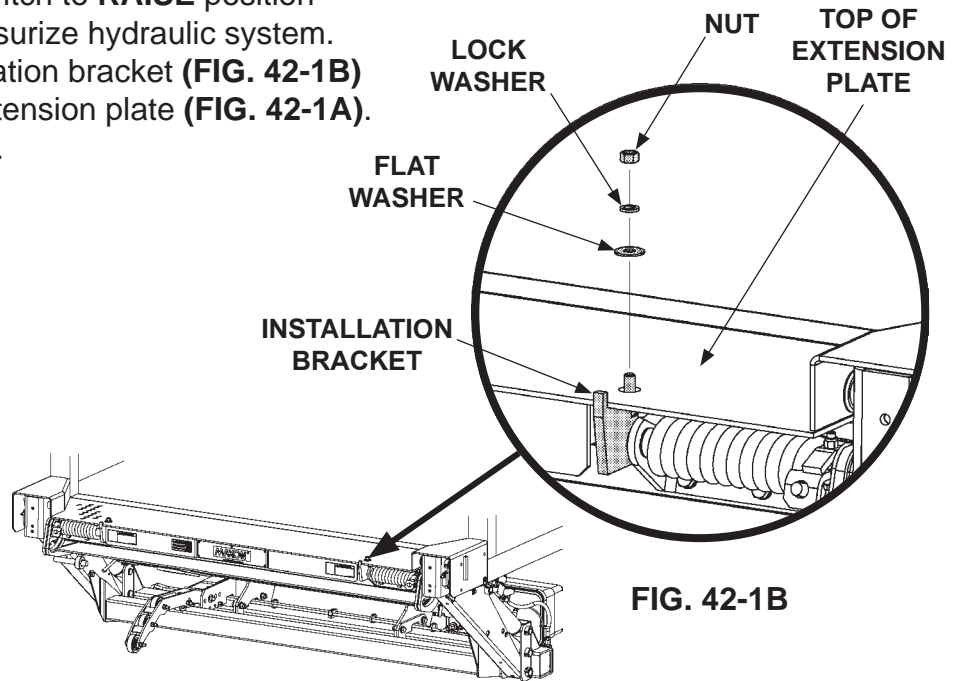


RECONNECTED BATTERY CABLES  
FIG. 41-3

## STEP 9 - REMOVE LOCKING BRACKETS

**NOTE:** To operate Liftgate, installation brackets must be removed.

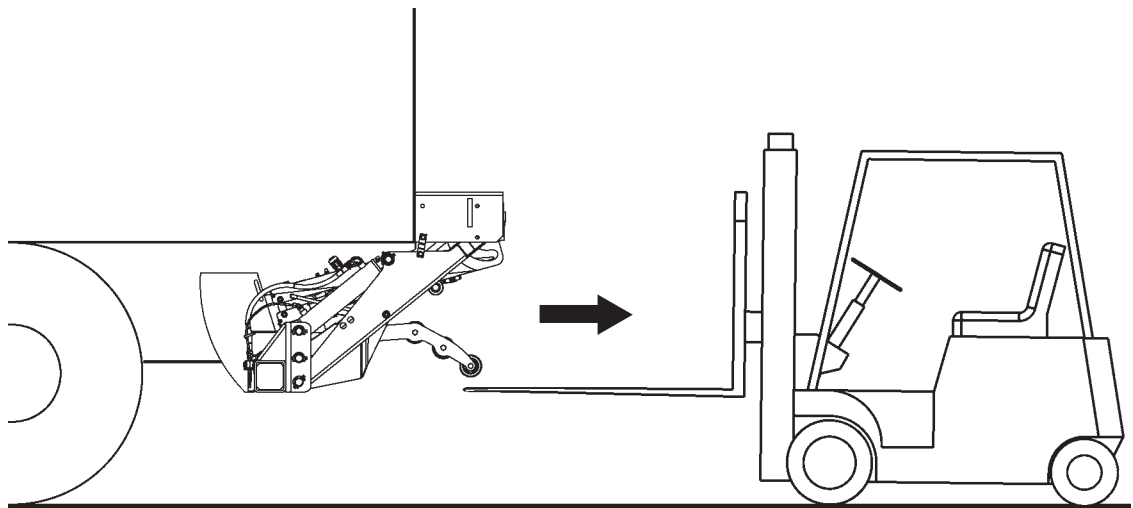
1. Push the control switch to **RAISE** position to moderately pressurize hydraulic system. Next, unbolt installation bracket (**FIG. 42-1B**) from RH side of extension plate (**FIG. 42-1A**). Repeat for LH side.



**FIG. 42-1A**

**FIG. 42-1B**

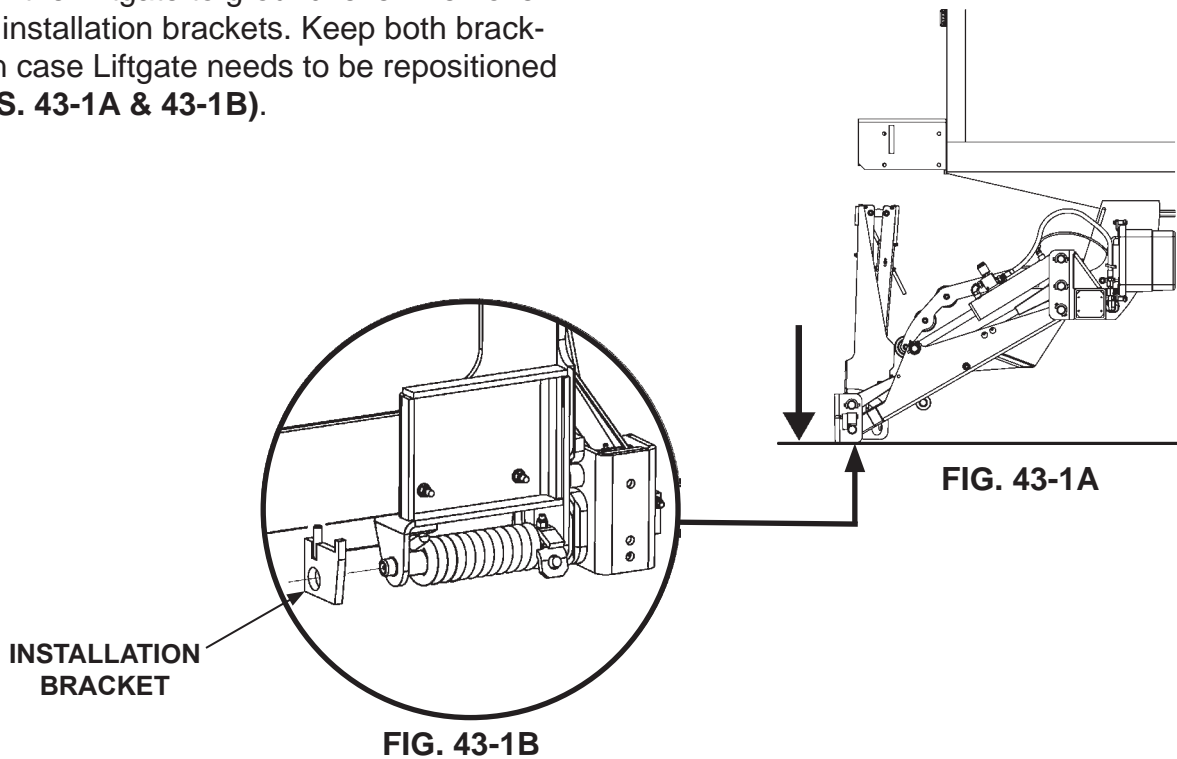
2. Remove clamps from forklift and Liftgate. If wood supports were used between forklift and ICC bumper, remove the supports. Back out forklift (**FIG. 42-2**).



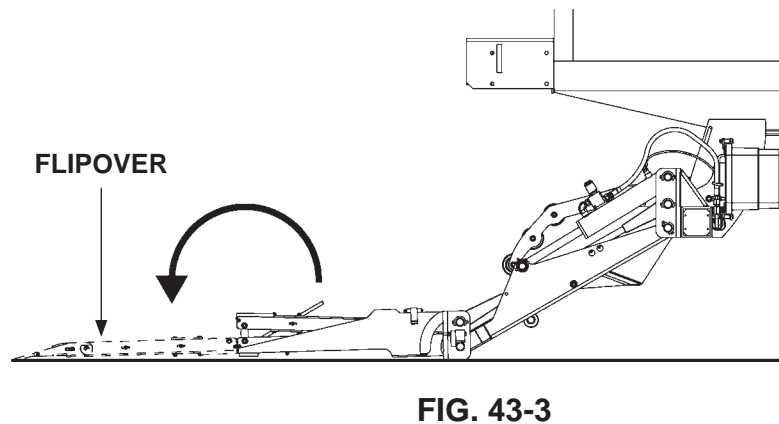
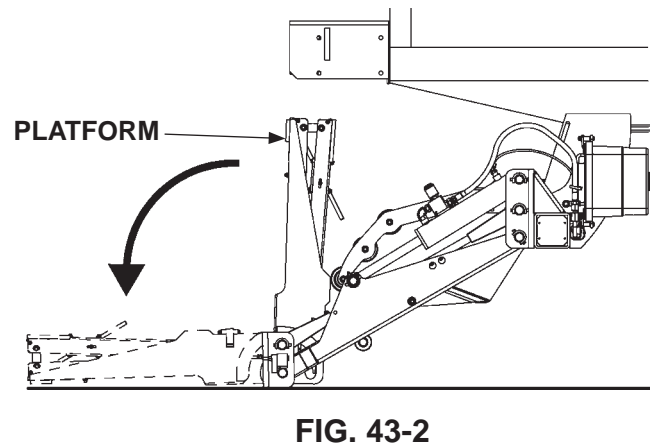
**FIG. 42-2**

## STEP 9 - 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. 43-1A & 43-1B).



4. Unfold platform (FIG. 43-2) and flipover (FIG. 43-3).



## STEP 9 - REMOVE LOCKING BRACKETS - Continued

### CAUTION

To prevent damage to Liftgate, the locking bracket on each cylinder must be removed before operating Liftgate.

5. Unbolt the locking brackets from both cylinders (**FIG. 44-1**).

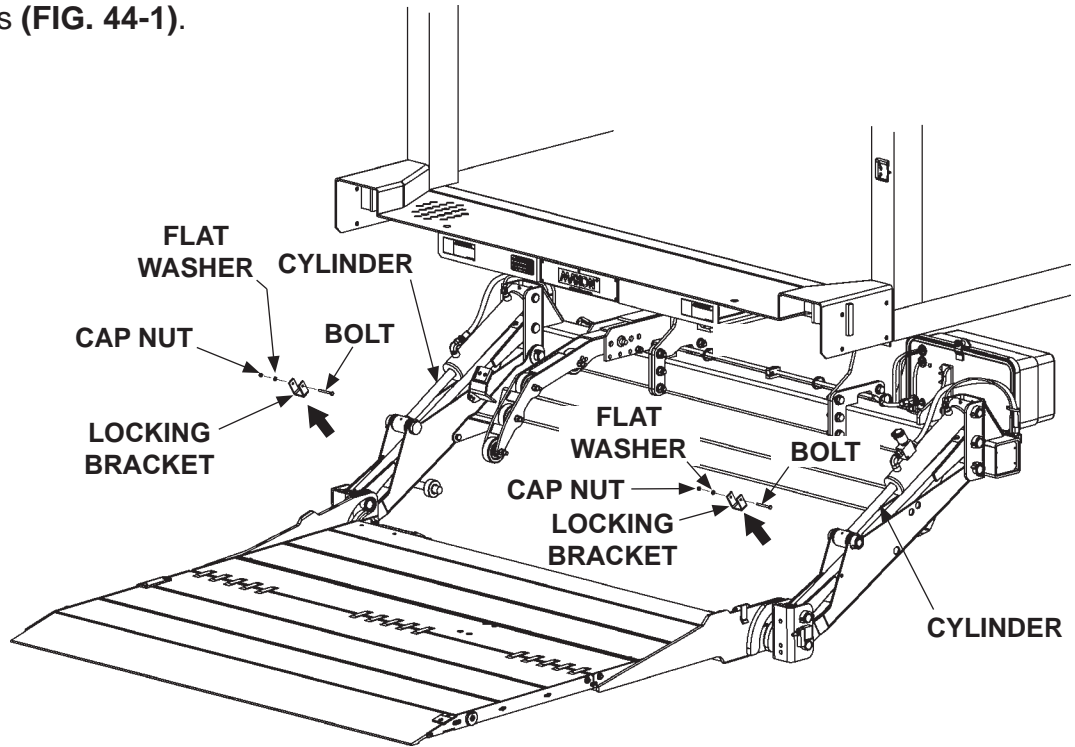
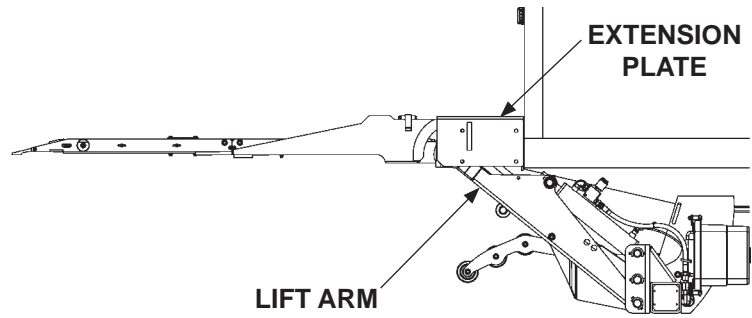


FIG. 44-1

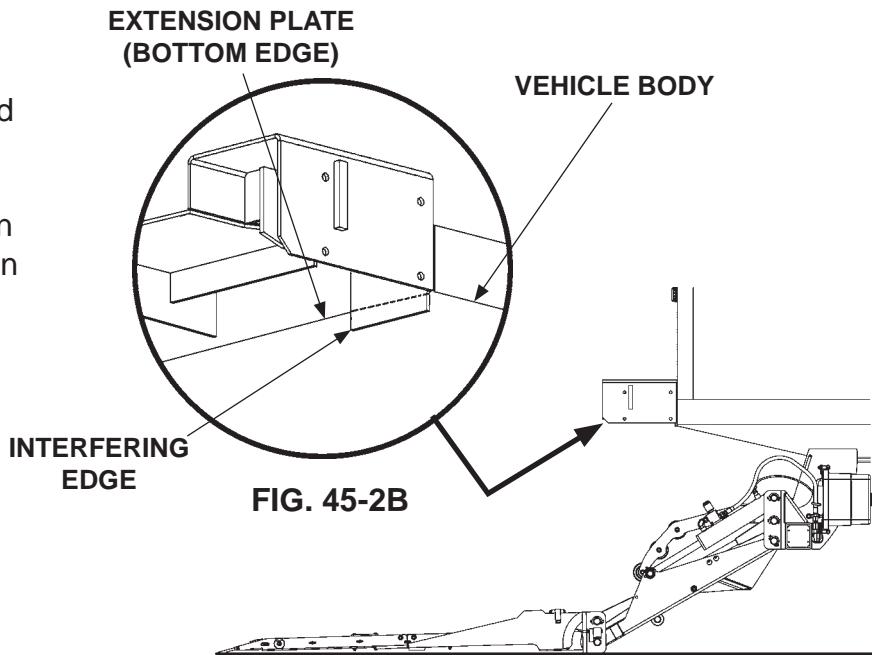
## STEP 9 - REMOVE LOCKING BRACKETS - Continued

6. Raise the Liftgate to vehicle bed height. Check if extension plate interferes with lifting arm (**FIG. 45-1**).



**FIG. 45-1**

7. Lower the Liftgate to ground level (**FIG. 45-2A**). Cut off the interfering edge on the extension plate so it is even with the bottom of extension plate (**FIG. 45-2B**). Repeat for LH side of extension plate.



**PLATFORM AT GROUND LEVEL  
(RH SIDE SHOWN)  
FIG. 45-2A**

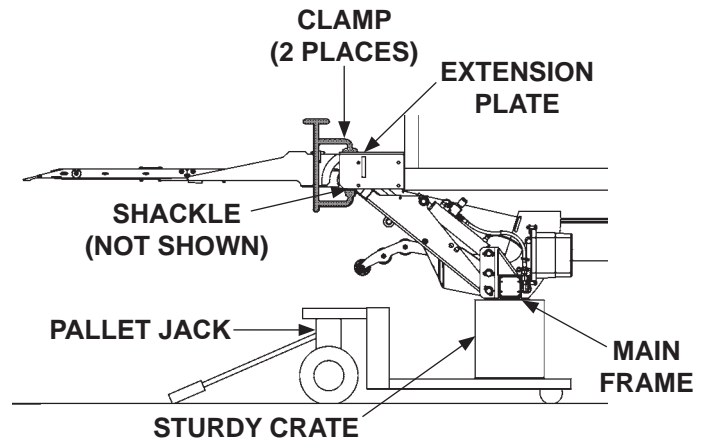
# STEP 10 - FINISH WELDING EXTENSION PLATE

## CAUTION

When using an electric welder, connect the welder ground to one of the parts being welded, as close to the weld as possible. Failure to comply could result in damage to cylinders and electrical parts.

1. RAISE the platform to bed level under moderate hydraulic pressure (FIG. 46-1).

2. Support the main frame with pallet jack (FIG. 46-1).



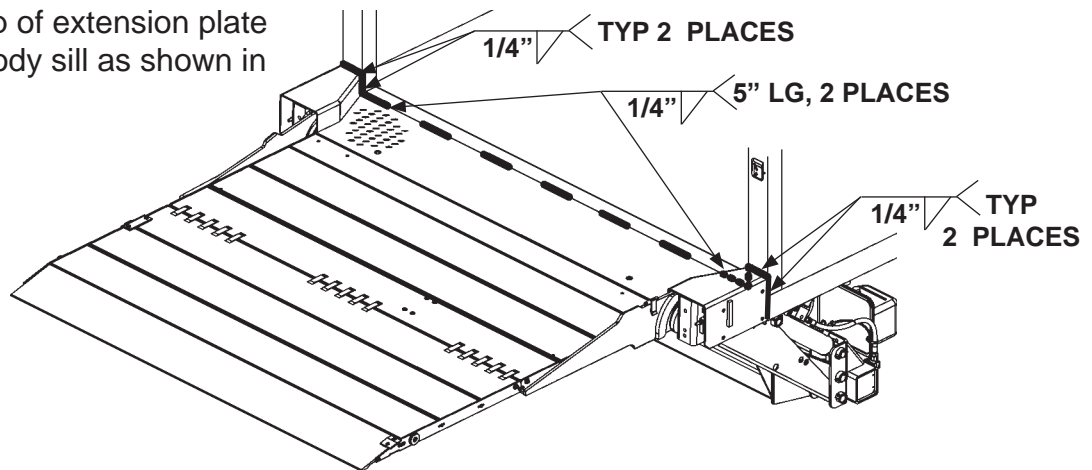
SUPPORTING PLATFORM & MAIN FRAME  
(GPTLR-25 SHOWN)  
FIG. 46-1

3. Clamp the shackles to extension plate (FIG. 46-1).

## CAUTION

To protect the original paint system, a 3" wide area of paint must be removed from all sides of the weld area before welding.

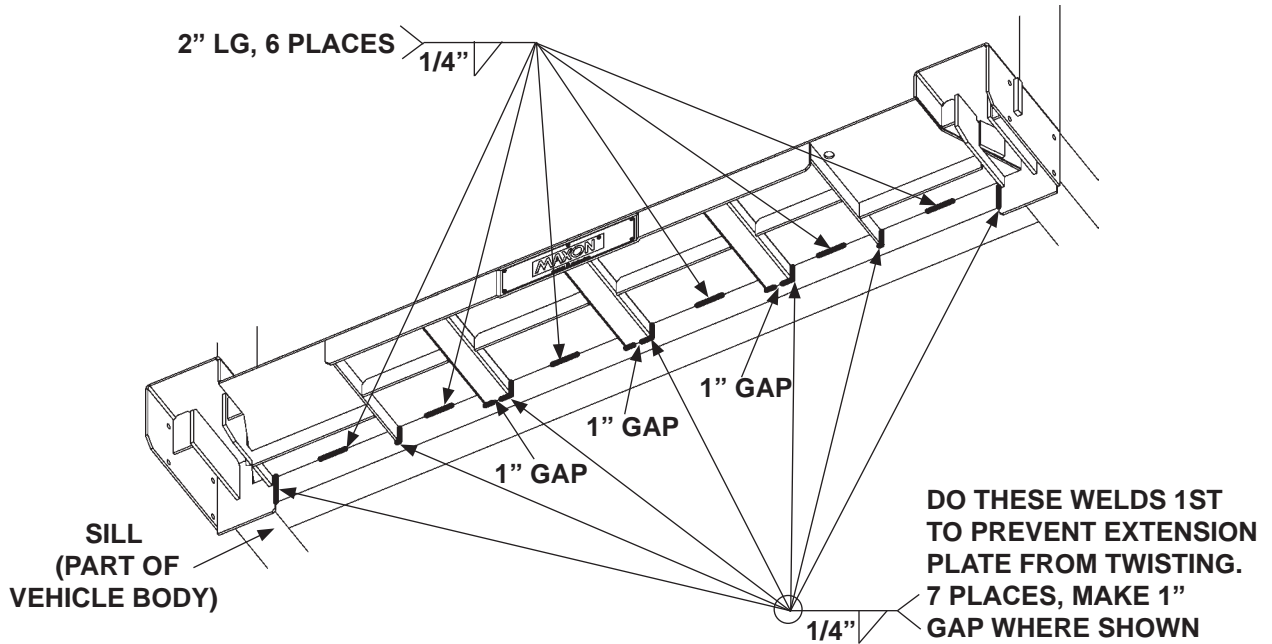
4. Weld the top of extension plate to vehicle body sill as shown in FIG. 46-2.



EXTENSION PLATE WELDS - VIEWED FROM ABOVE  
(FORKLIFT NOT SHOWN)  
FIG. 46-2

# STEP 10 - FINISH WELDING EXTENSION PLATE - Continued

5. Weld the bottom of extension plate to vehicle body sill as shown in **FIG. 47-1**.



**EXTENSION PLATE WELDS - VIEWED FROM UNDERNEATH  
(PLATFORM NOT SHOWN)  
FIG. 47-1**

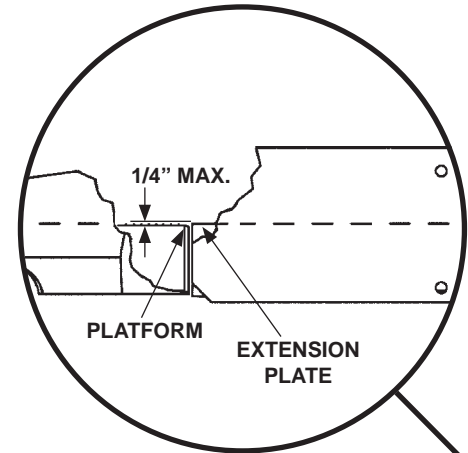
## STEP 11 - ADJUST PLATFORM (IF REQUIRED)

**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. Adjust the platform only if required.

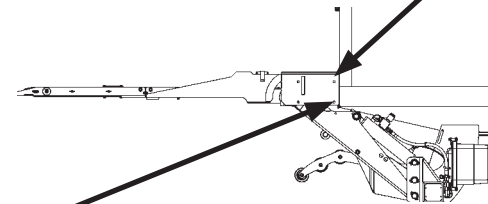
**NOTE:** Before doing the following procedure, make sure vehicle is still parked on level ground.

- 1. RAISE** platform to bed height. Check the platform as follows. Inboard edge on top of platform must be no more than 1/4" from diamond plate surface on top of extension plate (**FIGS. 48-1A & 48-1B**). The maximum allowable horizontal gap between inboard edge of platform and adjacent edge of extension plate is 1/4" (**FIGS. 48-1A & 48-1C**). **LOWER** platform to ground level. Shackles and tip of flipover should touch the ground at the same time (**FIG. 48-2**). Tip of flipover must not be higher than 1/4" above the ground. If all indications are correct (**FIGS. 48-1A, 48-1B, 48-1C, & 48-2**), Liftgate is installed correctly and no adjustment is needed. If the tip of flipover is too high above the ground, if shackles are off the ground, or if there is too much gap between platform and extension plate, continue doing this procedure.

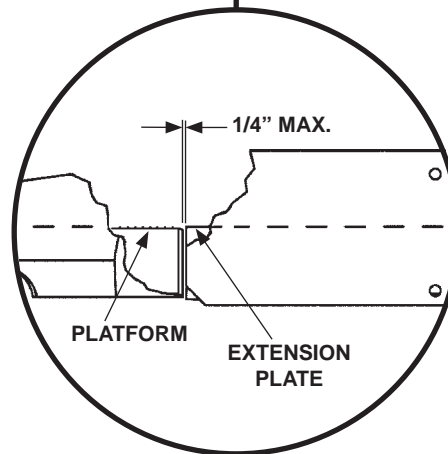
**NOTE:** If the shackles do not touch the ground (see **FIG. 49-1**), do instruction 2. If the tip of the flipover is more than 1/4" above the ground (see **FIG. 48-2**), skip instructions 2 - 5 and do instruction 6. If there is too much vertical space (**FIG. 48-1B**) or horizontal space (**FIG. 48-1C**) between platform and extension plate, start with instruction 7 to remove and reinstall Liftgate.



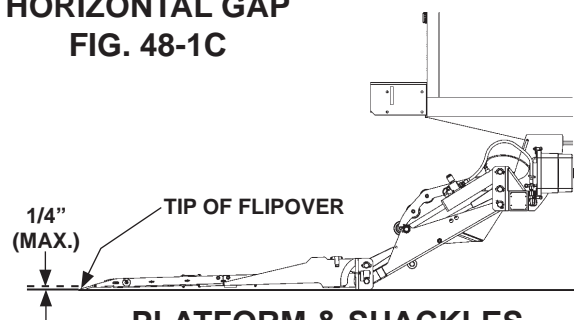
**VERTICAL GAP  
FIG. 48-1B**



**PLATFORM AT  
BED LEVEL  
FIG. 48-1A**



**HORIZONTAL GAP  
FIG. 48-1C**



**PLATFORM & SHACKLES  
TOUCH GROUND  
FIG. 48-2**



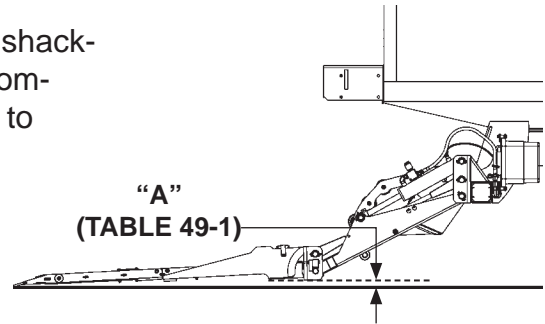
# STEP 11 - ADJUST PLATFORM (IF REQUIRED)

## - Continued

2. Make sure platform is still at ground level. If the shackles are not touching the ground, measure and compare distance "A" (FIG. 49-1) with TABLE 49-1 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 49-1



SHACKLES DO NOT TOUCH GROUND  
FIG. 49-1

3. Fold the flipover and platform. Then, raise the platform to position shown in FIG. 49-2A.

**CAUTION**  
To protect the original paint system, a 3" wide area of paint must be removed from all sides of the weld area before welding.

**CAUTION**  
When using an electric welder, connect the welder to one of the parts being welded, as close to the weld as possible. Failure to comply could result in damage to cylinders and electrical parts.

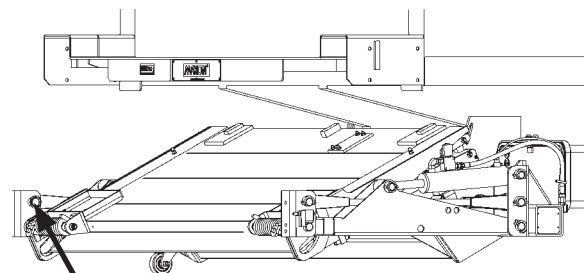


FIG. 49-2A

4. Use TABLE 49-1 to select the correct size shim from the parts box. Weld shim to pin as shown in FIG. 49-2B.

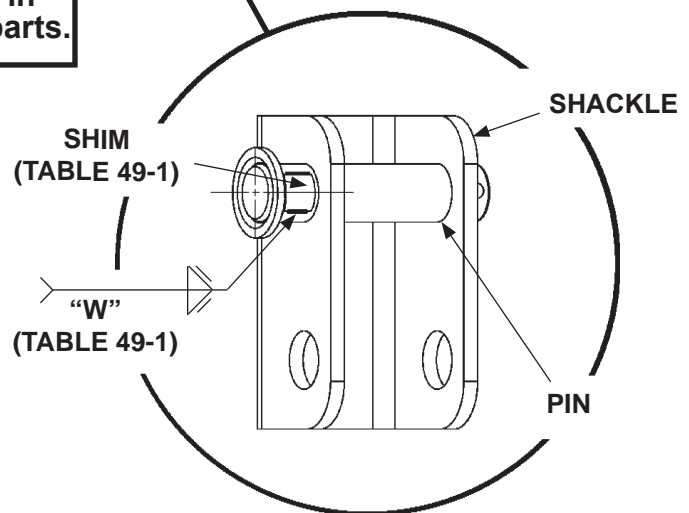
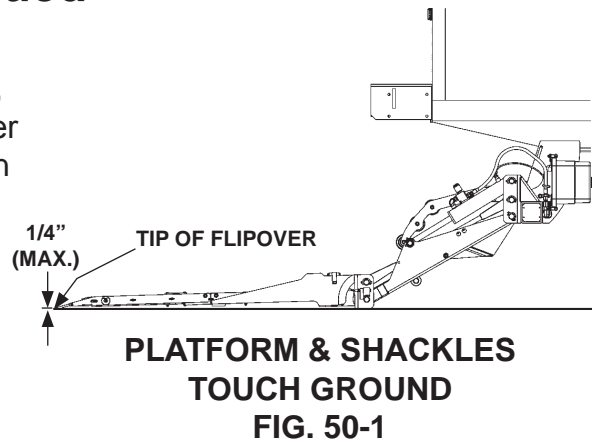


FIG. 49-2B

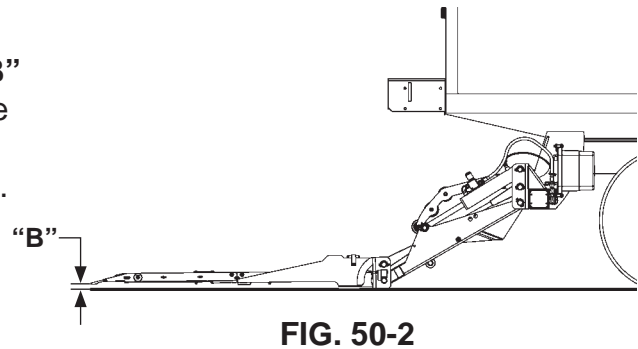
## STEP 11 - ADJUST PLATFORM (IF REQUIRED) - Continued

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. 50-1**. Tip of flipover must not be higher than 1/4" above the ground.



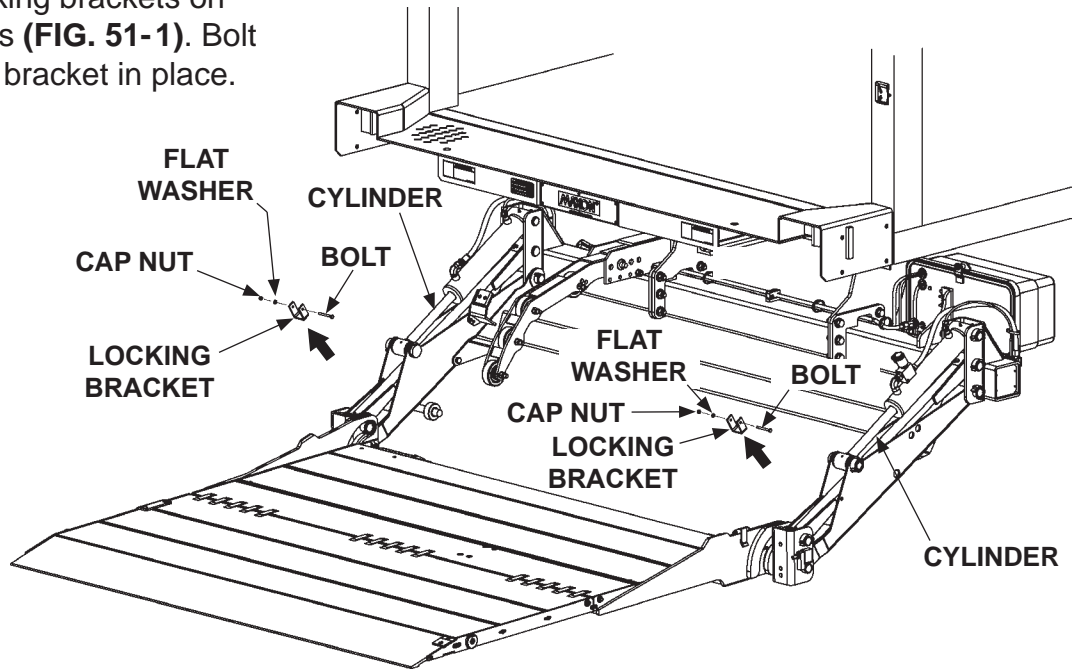
**NOTE:** For an aluminum platform & flipover equipped with retention ramp, 2" of ground clearance is acceptable at the tip of flipover.

6. If the tip of flipover is more than 1/4" above the ground (**FIG. 50-2**), note the distance "B" above ground level. See the exception in the **NOTE** above. Distance "B" will be used for adjusting the platform later in this procedure.



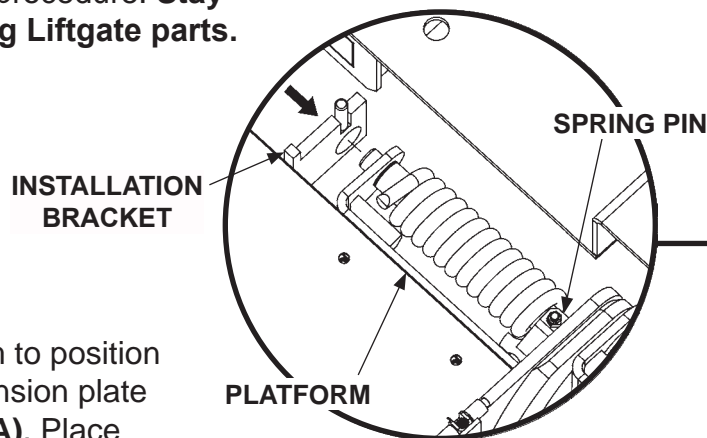
# STEP 11 - ADJUST PLATFORM (IF REQUIRED) - Continued

7. Reinstall locking brackets on both cylinders (FIG. 51-1). Bolt each locking bracket in place.



REINSTALLING LOCKING BRACKETS  
FIG. 51-1

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. 51-2B

9. **RAISE** platform to position just below extension plate (see FIG. 51-2A). Place an installation bracket on the spring pin on the RH side of platform (FIG. 51-2B) and on the spring pin on the LH side of platform.

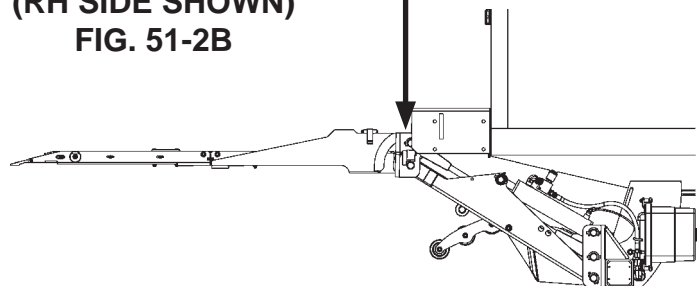
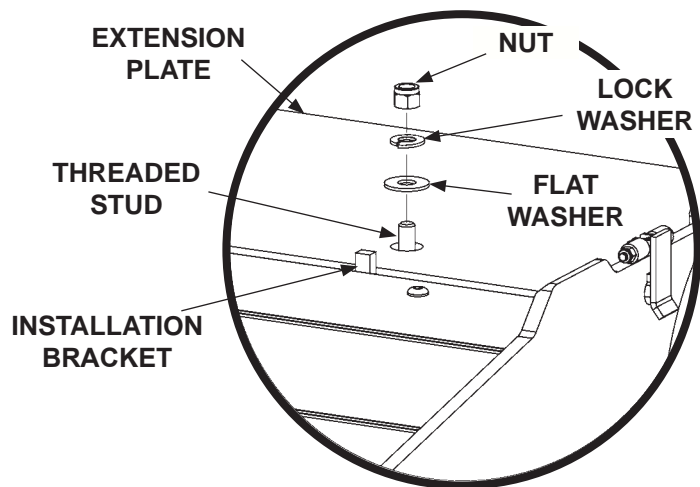


FIG. 51-2A

## STEP 11 - 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. 52-1**). Bolt the installation bracket (**FIG. 52-1**) to extension plate. Torque nut from **80 to 90 lb-ft**. Repeat for bolting and torquing the installation bracket on the LH side.

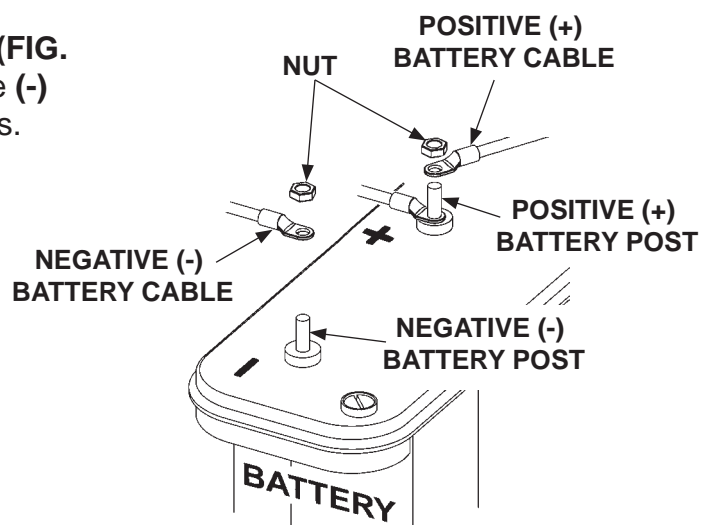


**INSTALLATION BRACKET  
(RH SIDE SHOWN)  
FIG. 52-1**

### ⚠ **WARNING**

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

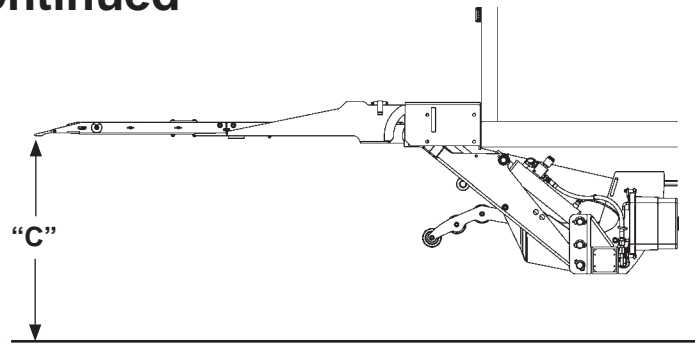
11. Disconnect power to the pump by disconnecting negative (-) and positive (+) cables from battery (**FIG. 52-2**). Reinstall nuts on negative (-) and positive (+) battery terminals.



**DISCONNECTING BATTERY POWER  
FIG. 52-2**

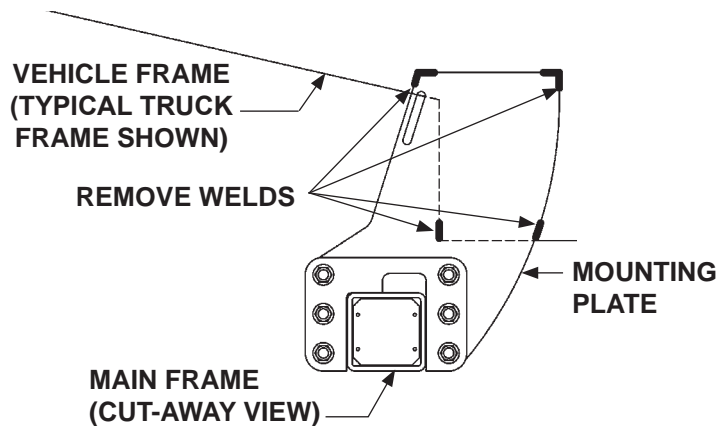
## STEP 11 - ADJUST PLATFORM (IF REQUIRED) - Continued

12. Support the Liftgate under main frame with a floor jack (not shown).
13. Measure distance “C” from the tip of the flipover to ground level (FIG. 53-1). Next, subtract the distance “B” measured in instruction 6. The result is distance “D” for the platform adjustment (FIG. 53-3). For example, if you measured 50” for “C” and 1” for “B”, the calculated distance “D” for the platform adjustment is 49”.



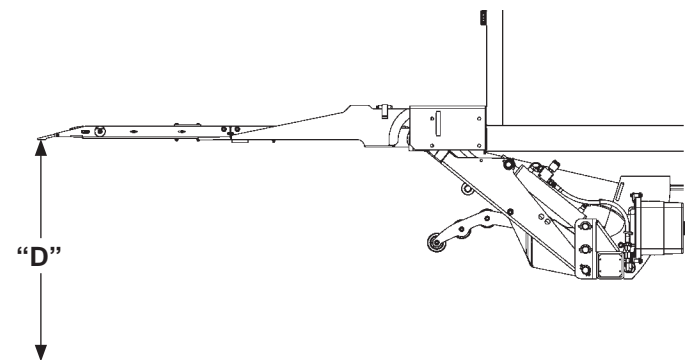
LIFTGATE CLEARANCE DIMENSIONS  
FIG. 53-1

14. Remove welds from RH side and LH side mounting plates (FIG. 53-2).



REMOVING WELDS FROM MOUNTING PLATE  
(RH SIDE SHOWN)  
FIG. 53-2

15. Raise or lower the floor jack to adjust distance “D” between tip of flipover and ground level (FIG. 53-3). Use the distance “D” calculated in instruction 13.



LIFTGATE CLEARANCE DIMENSIONS  
FIG. 53-3

## STEP 11 - ADJUST PLATFORM (IF REQUIRED) - Continued

### CAUTION

When using an electric welder, connect the welder ground to one of the parts being welded, as close to the weld as possible. Failure to comply could result in damage to cylinders and electrical parts.

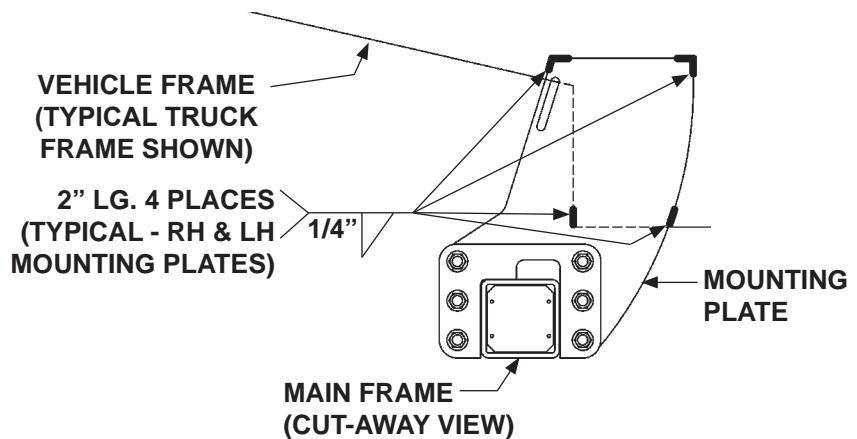
### CAUTION

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

### CAUTION

To protect the original paint system, a 3" wide area of paint must be removed from all sides of the weld area before welding.

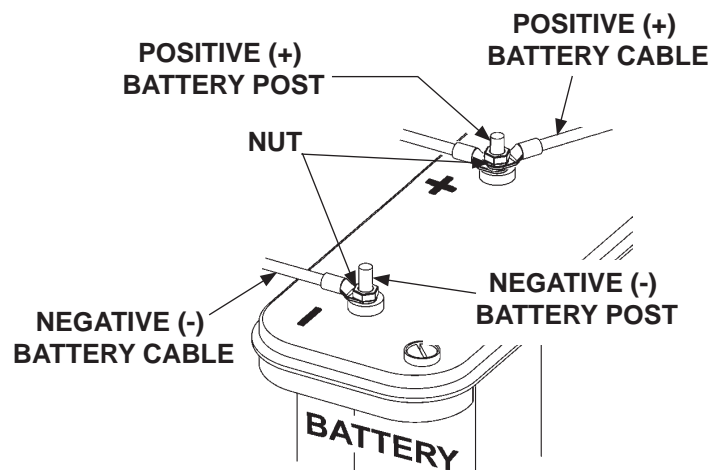
16. Clamp the RH side and LH side mounting plates to vehicle frame. Weld the mounting plates to vehicle frame as shown in **FIG. 54-1**. Remove clamps.



**WELD TO VEHICLE FRAME AND MAIN FRAME  
(RH SIDE SHOWN)**

**FIG. 54-1**

17. Reconnect power to the pump by reconnecting positive (+) and negative (-) cables to battery (**FIG. 54-2**). Reinstall and tighten nut when each battery cable is reconnected.



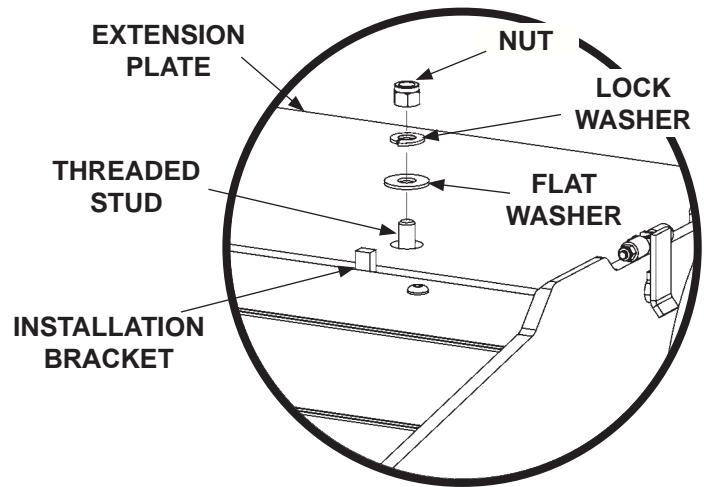
**RECONNECTING POWER**

**FIG. 54-2**

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

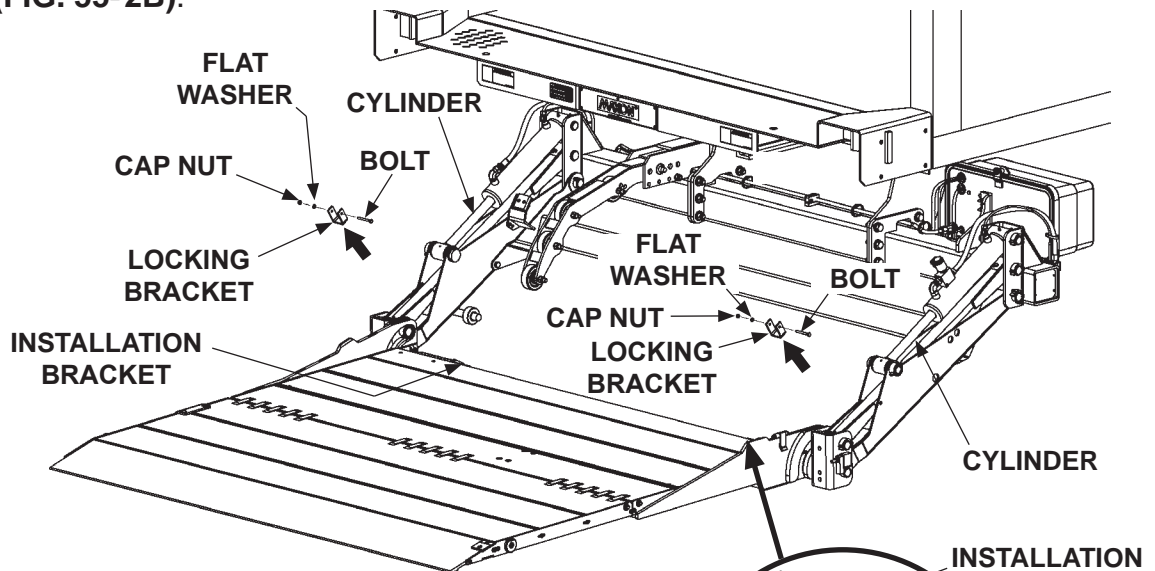
# STEP 11 - ADJUST PLATFORM (IF REQUIRED) - Continued

19. Unbolt the installation brackets (FIG. 55-1) from RH side and LH side of extension plate.



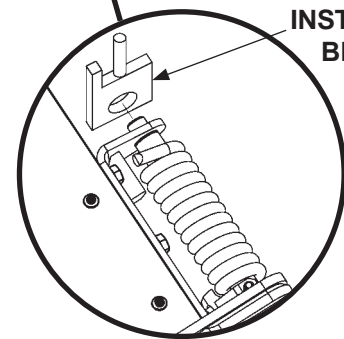
**INSTALLATION BRACKET  
(RH SIDE SHOWN)  
FIG. 55-1**

20. LOWER the Liftgate to ground level (FIG. 55-2A). Remove the installation brackets from RH side and LH side of platform (FIG. 55-2B).



**REMOVING LOCKING BRACKETS  
FIG. 55-2A**

21. Unbolt the locking brackets from both cylinders (FIG. 55-2A). Remove the locking brackets.



**REMOVING INSTALLATION  
BRACKET (RH SIDE SHOWN)  
FIG. 55-2B**

# STEP 12 - FINISH WELDING LIFTGATE TO VEHICLE

## ⚠ WARNING

Liftgate is shipped from factory with mounting plates bolted to the main frame. Weld the mounting plates as shown in illustrations before operating Liftgate.

## CAUTION

When using an electric welder, connect the welder ground to one of the parts being welded, as close to the weld as possible. Failure to comply could result in damage to cylinders and electrical parts.

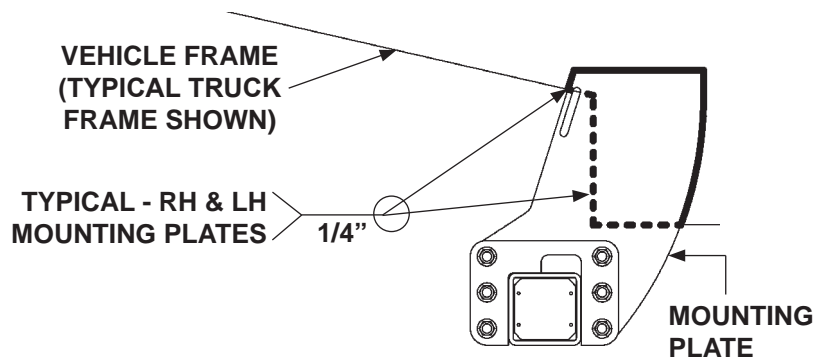
## CAUTION

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

## CAUTION

To protect the original paint system, a 3" wide area of paint must be removed from all sides of the weld area before welding.

Weld the mounting plates to vehicle frame as shown in **FIG. 56-1**.



WELD TO VEHICLE FRAME (RH SIDE SHOWN)  
FIG. 56-1



## STEP 13 - WELD TRUCK BODY TO FRAME (TRUCKS ONLY)

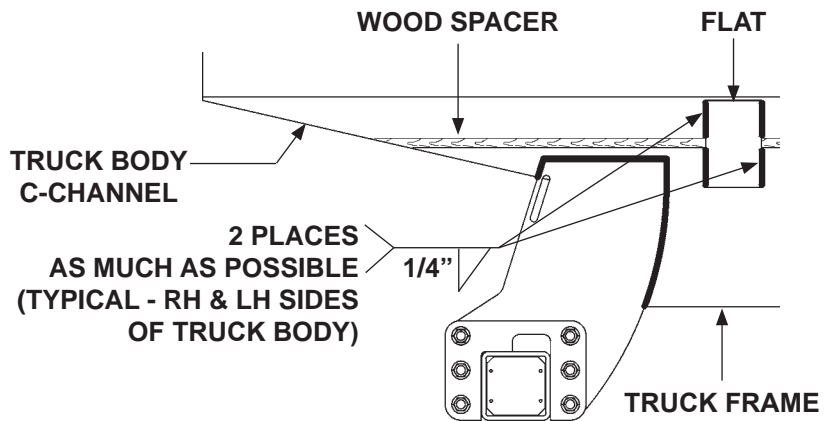
### CAUTION

When using an electric welder, connect the welder to one of the parts being welded, as close to the weld as possible. Failure to comply could result in damage to cylinders and electrical parts.

### CAUTION

To prevent truck body from moving out of position, weld the C-channels on each side of truck body to truck frame.

1. Fabricate two flats, from 1/4" thick x 4" wide steel, that will fit in the area on the truck frame shown in **FIG. 57-1**.



**WELDING TRUCK BODY TO FRAME  
(RH SIDE SHOWN)  
FIG. 57-1**

### CAUTION

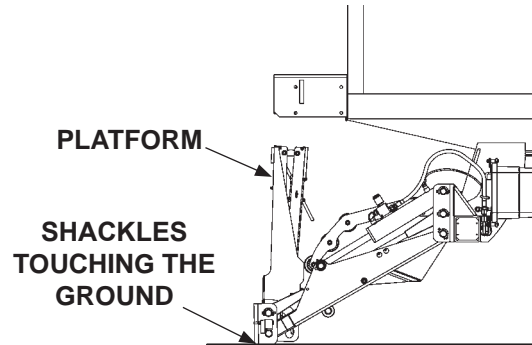
To protect the original paint system, a 3" wide area of paint must be removed from all sides of the weld area before welding.

2. Weld flat to the truck frame and the C-channel on the RH side of truck body as shown in **FIG. 57-1**. Ensure welds on flat are the same length above and below the wood spacer (**FIG. 57-1**). Repeat for the LH side of the truck body.

## STEP 14 - ADJUST OPENER (IF REQUIRED)

**NOTE:** The platform must always stow and unfold without hitting underside of vehicle. Platform should unfold as close as possible to position shown in **FIG. 58-1**, but must never be positioned so it falls open.

1. The **MAXON-recommended** procedure for repositioning the opener is as follows. Lower the platform from stowed position (**FIG. 58-1**).

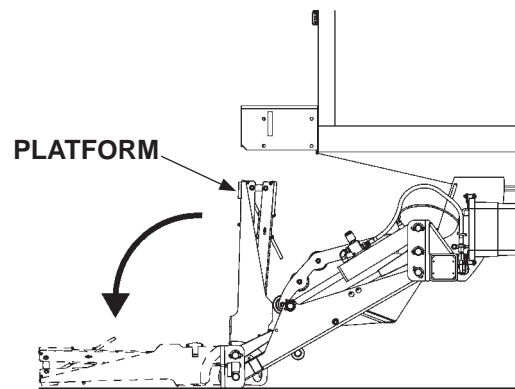


**PLATFORM LOWERED FROM STOWED POSITION (RH SIDE VIEW)**  
**FIG. 58-1**

### **⚠ CAUTION**

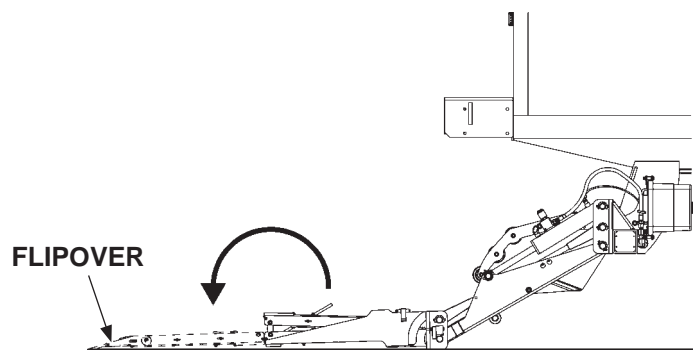
To prevent injury, unfold platform before repositioning opener.

2. Unfold the platform (**FIG. 58-2**).



**UNFOLDING PLATFORM**  
**FIG. 58-2**

3. Unfold the flipover (**FIG. 58-3**).



**UNFOLDING FLIPOVER**  
**FIG. 58-3**

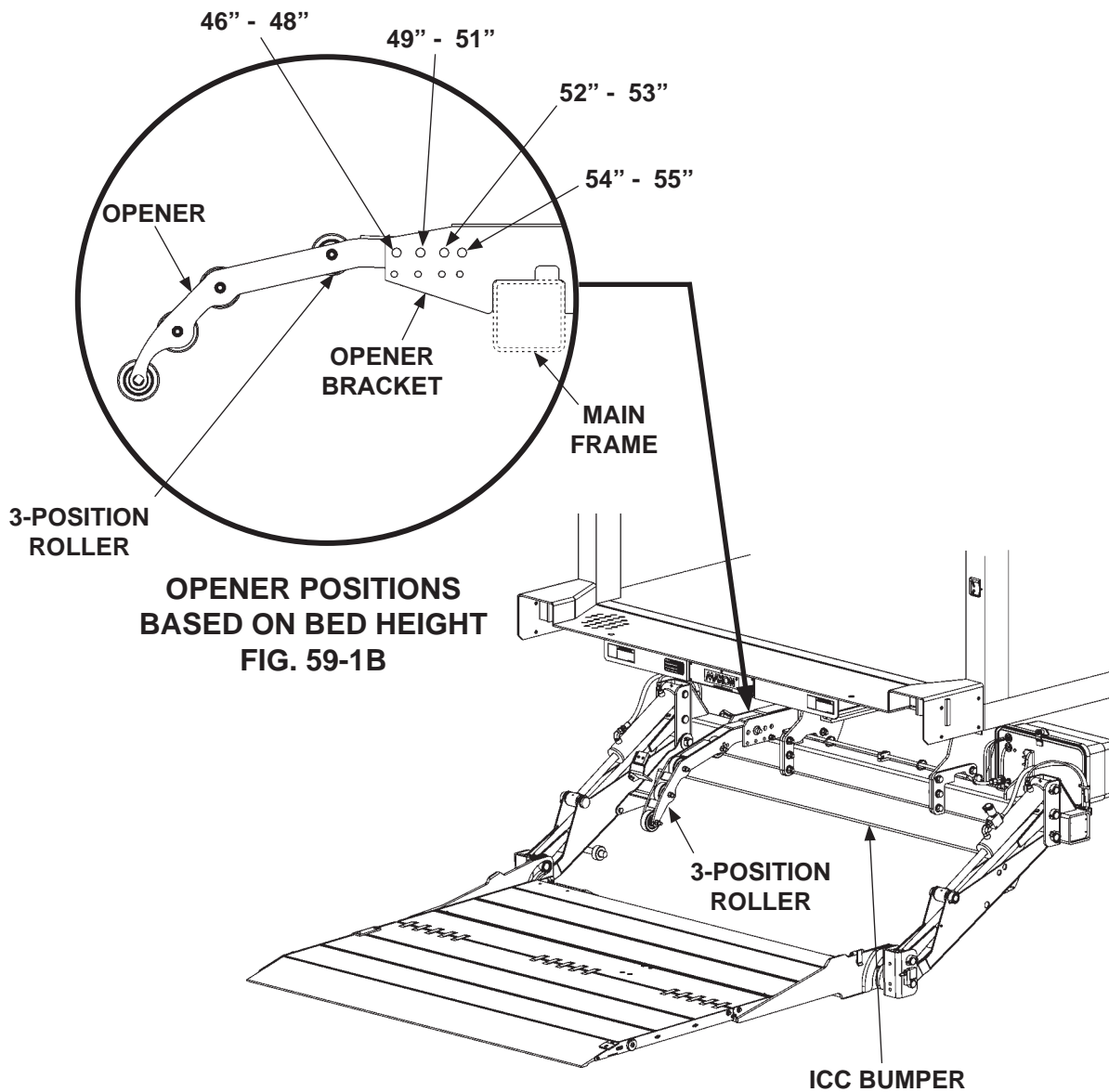
4. Measure vehicle bed height. Then move the opener, as required, to the matching bed height position for your Liftgate as shown in **FIG. 59-1B** and **FIG. 60-1B**.

# STEP 14 - ADJUST OPENER (IF REQUIRED) - Continued

## CAUTION

To prevent damage to ICC bumper, opener must not rub against bumper. Ensure the 3-position roller remains in contact with ICC bumper at first contact and through the full range of motion to highest position. Bolt roller in one of the 3 hole positions that best maintains contact between roller and bumper.

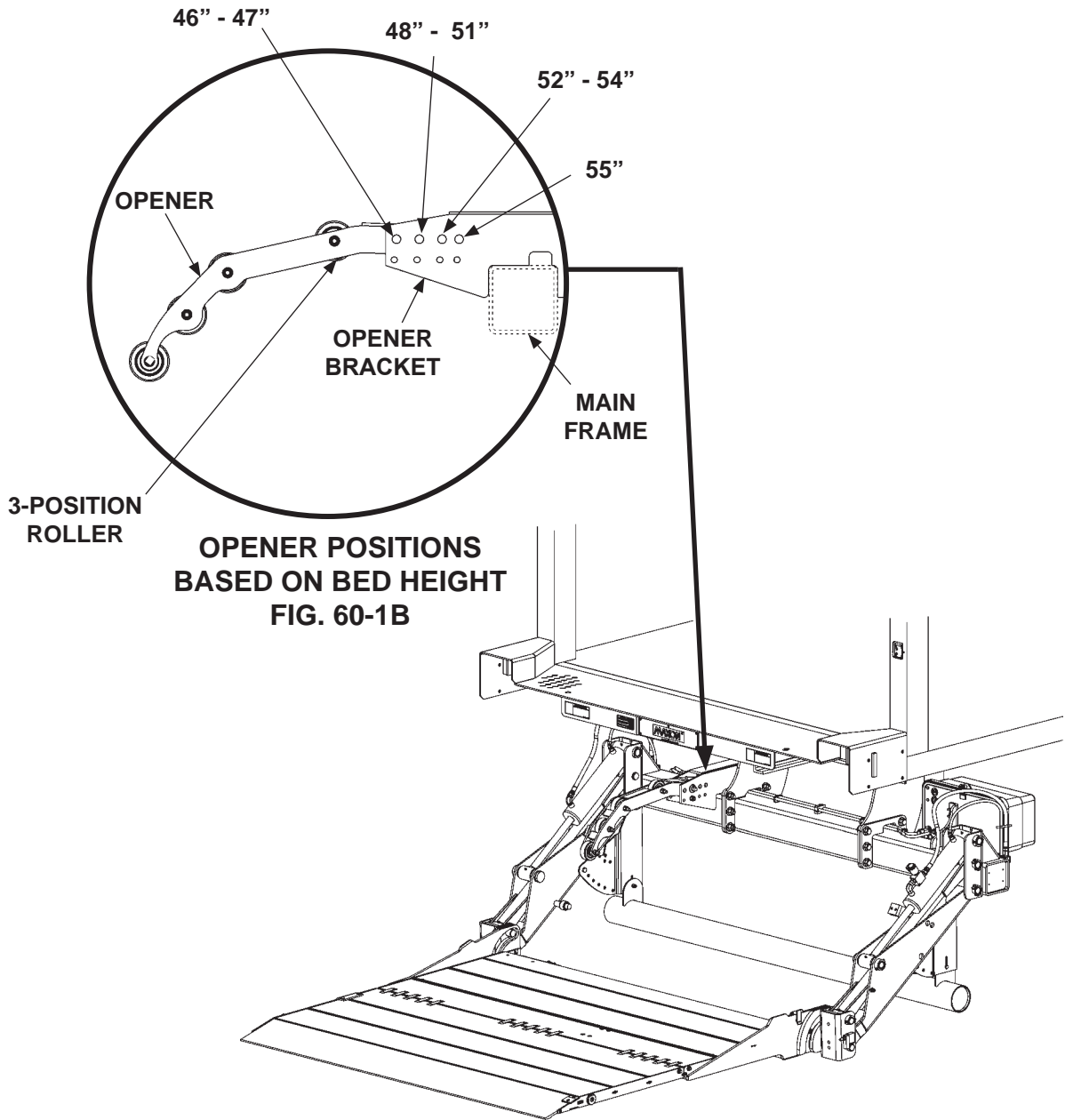
**NOTE:** Opener can be repositioned to best open the platform when vehicle bed heights are 44" to 55". The platform must always stow and unfold without hitting underside of vehicle. Platform should unfold as close as possible to position shown in **FIG. 58-2**, but must never be positioned so it falls open.



GPTLR-25 OR GPTLR-33  
FIG. 59-1A

# STEP 14 - ADJUST OPENER (IF REQUIRED) - Continued

**NOTE:** Opener can be repositioned to best open the platform when vehicle bed heights are 44" to 55". The platform must always stow and unfold without hitting underside of vehicle. Platform should unfold as close as possible to position shown in **FIG. 58-2**, but must never be positioned so it falls open.



**OPENER POSITIONS  
BASED ON BED HEIGHT  
FIG. 60-1B**

**GPTLR-44 & GPTLR-55  
FIG. 60-1A**

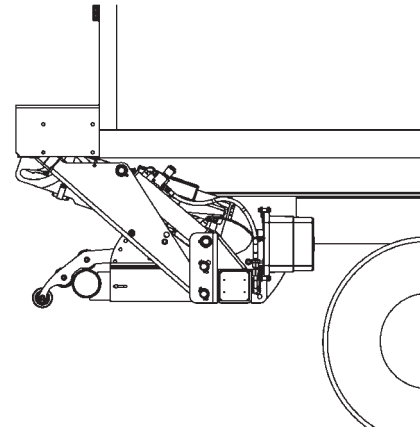
**MAXON**<sup>®</sup> 11921 Slauson Ave. Santa Fe Springs, CA. 90670 (800) 227-4116 FAX (888) 771-7713

# STEP 15 - BOLT ON STOP BLOCK

## CAUTION

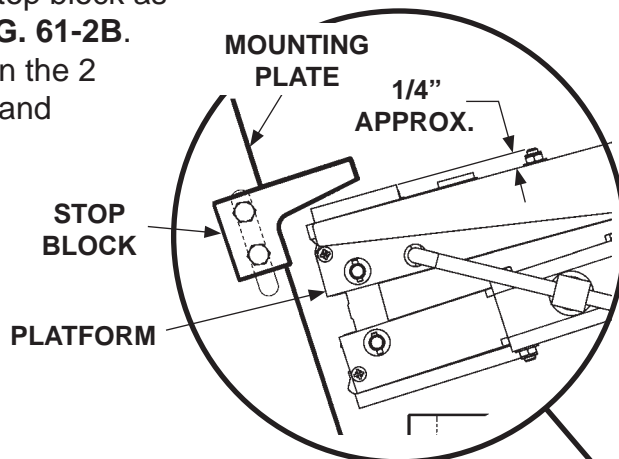
The opener adjustment in STEP 15 must be done (if required) before installing and adjusting the stop block. If the opener is not adjusted before the stop block is installed, the platform can become damaged when stowing Liftgate.

1. Stow the platform under hydraulic pressure (FIG. 61-1).

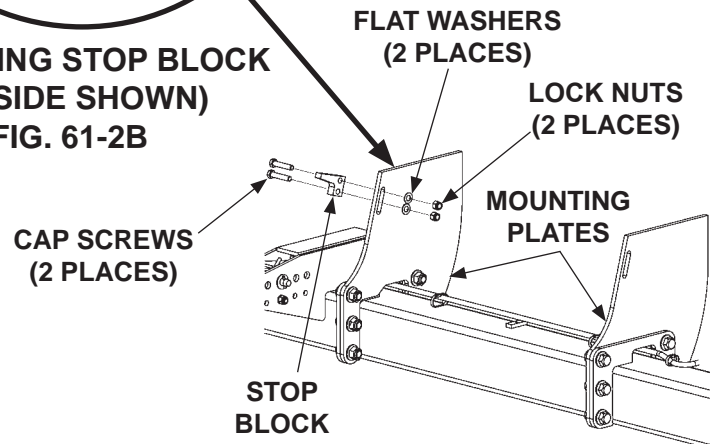


PLATFORM STOWED  
FIG. 61-1

2. Bolt the stop block (part box item) to the LH mounting plate (FIGS. 61-2A & 61-2B). Leave the cap screws and lock nuts loose. Adjust the stop block as shown in FIG. 61-2B. Then, tighten the 2 cap screws and lock nuts.



ADJUSTING STOP BLOCK  
(LH SIDE SHOWN)  
FIG. 61-2B



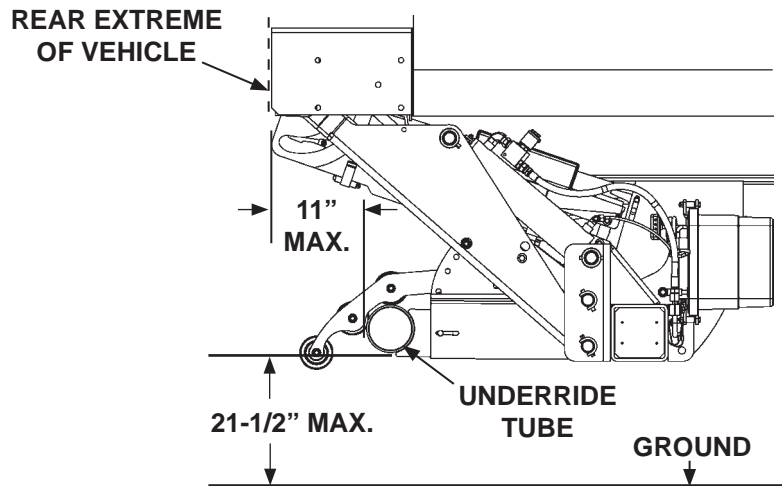
BOLTING ON STOP BLOCKS  
FIG. 61-2A

## STEP 16 - ADJUST UNDERRIDE (IF REQUIRED)

**NOTE:** This underride adjustment procedure is for:

- GPTLR-25 & GPTLR-33 with Federal Motor Vehicle Safety Standard (FMVSS) optional underride
- GPTLR-44 & GPTLR-55 with standard FMVSS underride
- GPTLR-44 & GPTLR-55 with Canadian Motor Vehicle Safety Standard (CMVSS) underride

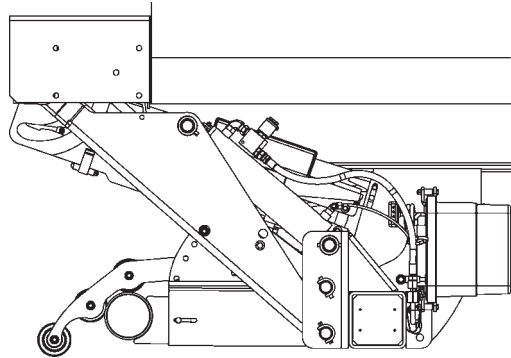
**NOTE:** For 5" tubular underride to meet applicable FMVSS and CMVSS regulations, ground clearance must not exceed 21-1/2" from the bottom of the tube. Also, the rear-facing part of the underride tube must not exceed 11" from the rear extreme of the vehicle. Refer to **FIG. 62-1**.



**GPTLR-44 OR GPTLR-55 LIFTGATE, EQUIPPED  
WITH STANDARD UNDERRIDE, SHOWN WITH  
MAXIMUM ALLOWABLE CLEARANCES  
FIG. 62-1**

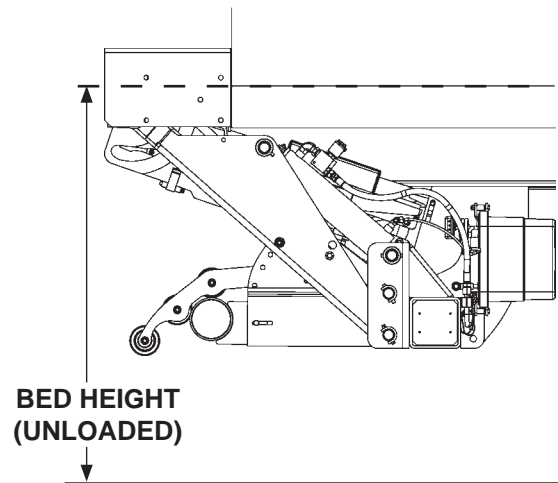
## STEP 16 - ADJUST UNDERRIDE (IF REQUIRED) - Continued

1. Stow the Liftgate under hydraulic pressure (**FIG. 63-1**).



**LIFTGATE WITH PLATFORM STOWED  
(STANDARD UNDERRIDE SHOWN )  
FIG. 63-1**

2. Measure vehicle bed height (**FIG. 63-2**).

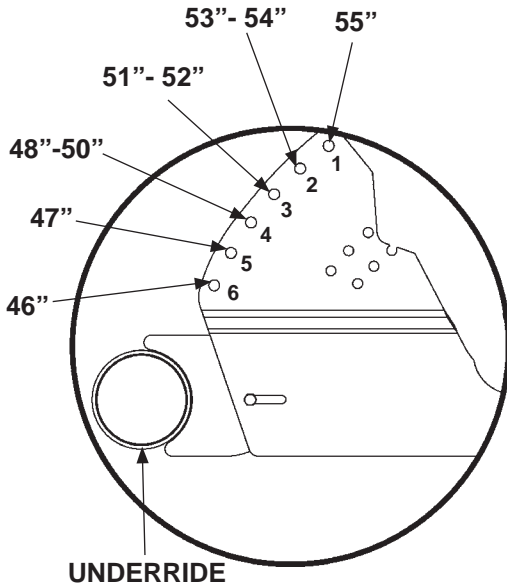


**MEASURING BED HEIGHT  
(STANDARD UNDERRIDE SHOWN)  
FIG. 63-2**

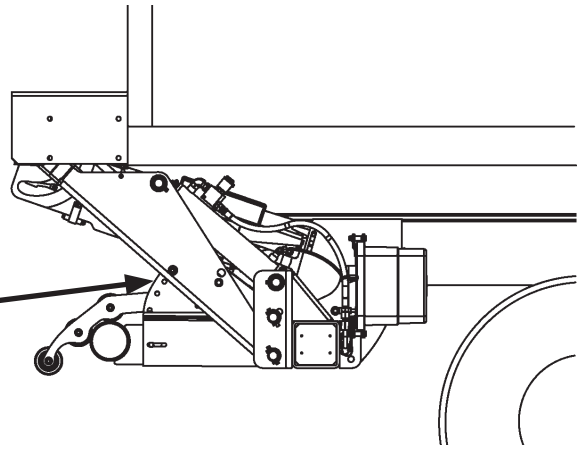
**NOTE:** If underride is already bolted in correct position for your bed height, and if tube position is adjustable, go to the instructions for **ADJUSTING UNDERRIDE TUBE**.

3. Refer to **FIGS. 64-1B, 64-2B, and 65-1B** to find the hole position that matches your model of Liftgate, underride, and bed height.

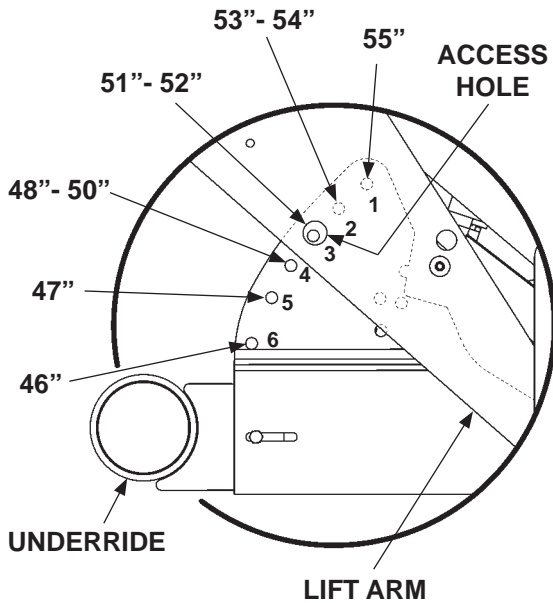
# STEP 16 - ADJUST UNDERRIDE (IF REQUIRED) - Continued



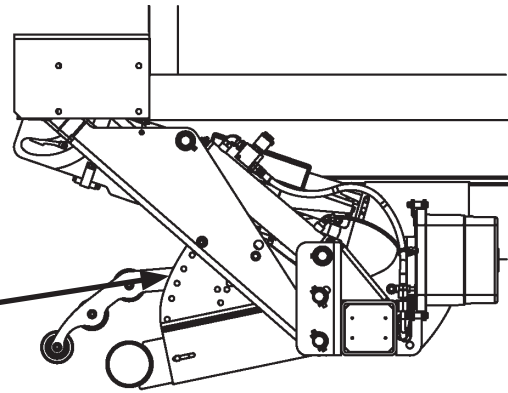
**GPTLR-25 & GPTLR-33 FMVSS  
UNDERRIDE BRACKET SETTINGS  
BASED ON BED HEIGHT  
(RH BRACKET SHOWN)  
FIG. 64-1B**



**GPTLR-25 & GPTLR-33  
OPTIONAL FMVSS UNDERRIDE  
FIG. 64-1A**



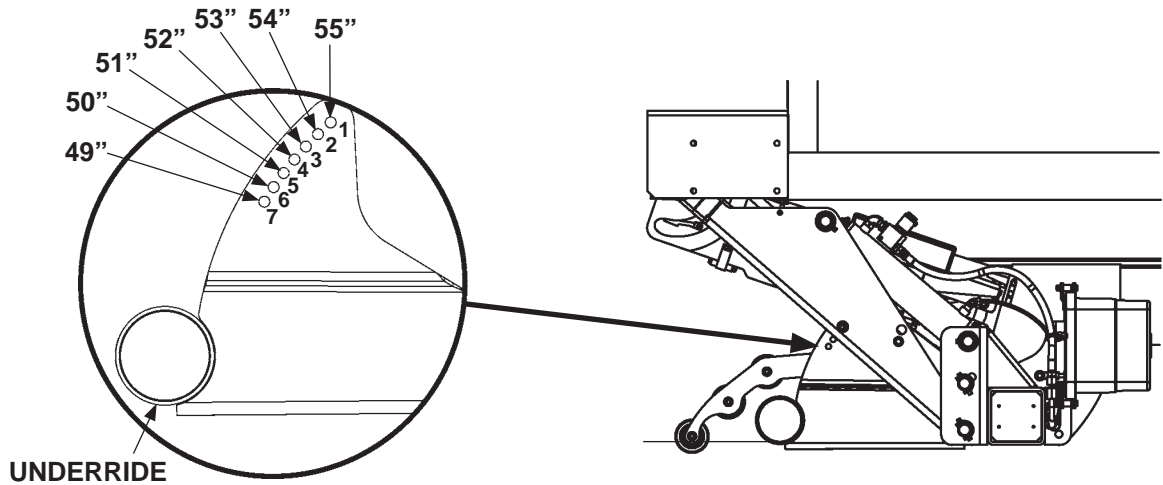
**GPTLR-44 & GPTLR-55 FMVSS  
UNDERRIDE BRACKET SETTINGS  
BASED ON BED HEIGHT  
(RH BRACKET SHOWN)  
FIG. 64-2B**



**GPTLR-44 & GPTLR-55  
STANDARD FMVSS UNDERRIDE  
FIG. 64-2A**



# STEP 16 - ADJUST UNDERRIDE (IF REQUIRED) - Continued



**GPTLR-44 & GPTLR-55 CMVSS  
UNDERRIDE BRACKET SETTINGS  
BASED ON BED HEIGHT  
(RH BRACKET SHOWN)  
FIG. 65-1B**

---

**GPTLR-44 & GPTLR-55  
OPTIONAL CMVSS UNDERRIDE  
FIG. 65-1A**

**MAXON**<sup>®</sup> 11921 Slauson Ave. Santa Fe Springs, CA. 90670 (800) 227-4116 FAX (888) 771-7713

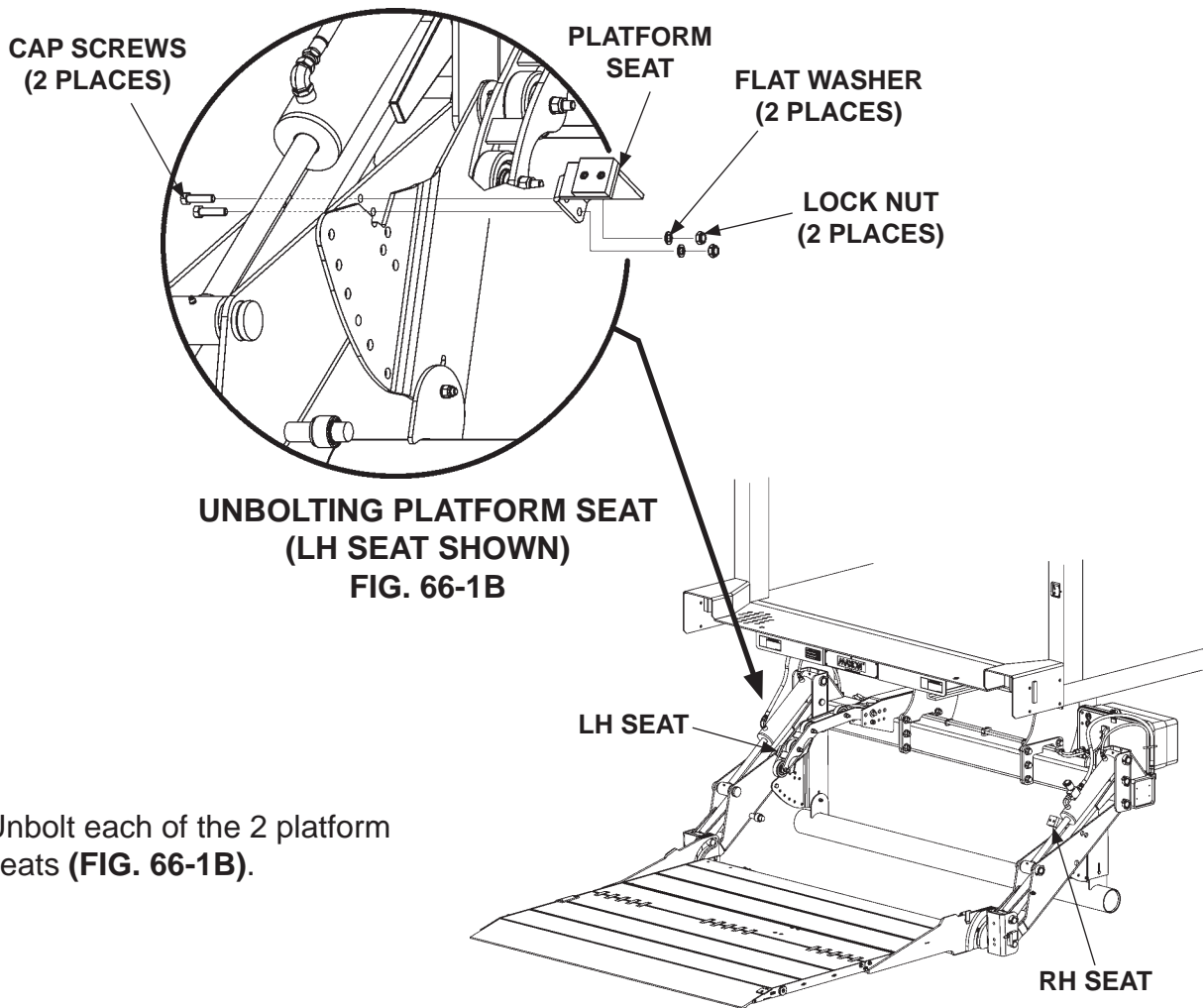
# STEP 16 - ADJUST UNDERRIDE (IF REQUIRED) - Continued

**NOTE:** If your underride is not in the correct position for bed height of vehicle, perform the following procedure

## ADJUSTING UNDERRIDE ASSEMBLY

**NOTE:** Platform seats must be removed from lift arms to adjust position of underride assembly. Seats must be reinstalled after adjusting position.

4. Lower platform to the ground. Then, unfold platform and flipover (**FIG. 66-1A**).



**UNBOLTING PLATFORM SEAT  
(LH SEAT SHOWN)  
FIG. 66-1B**

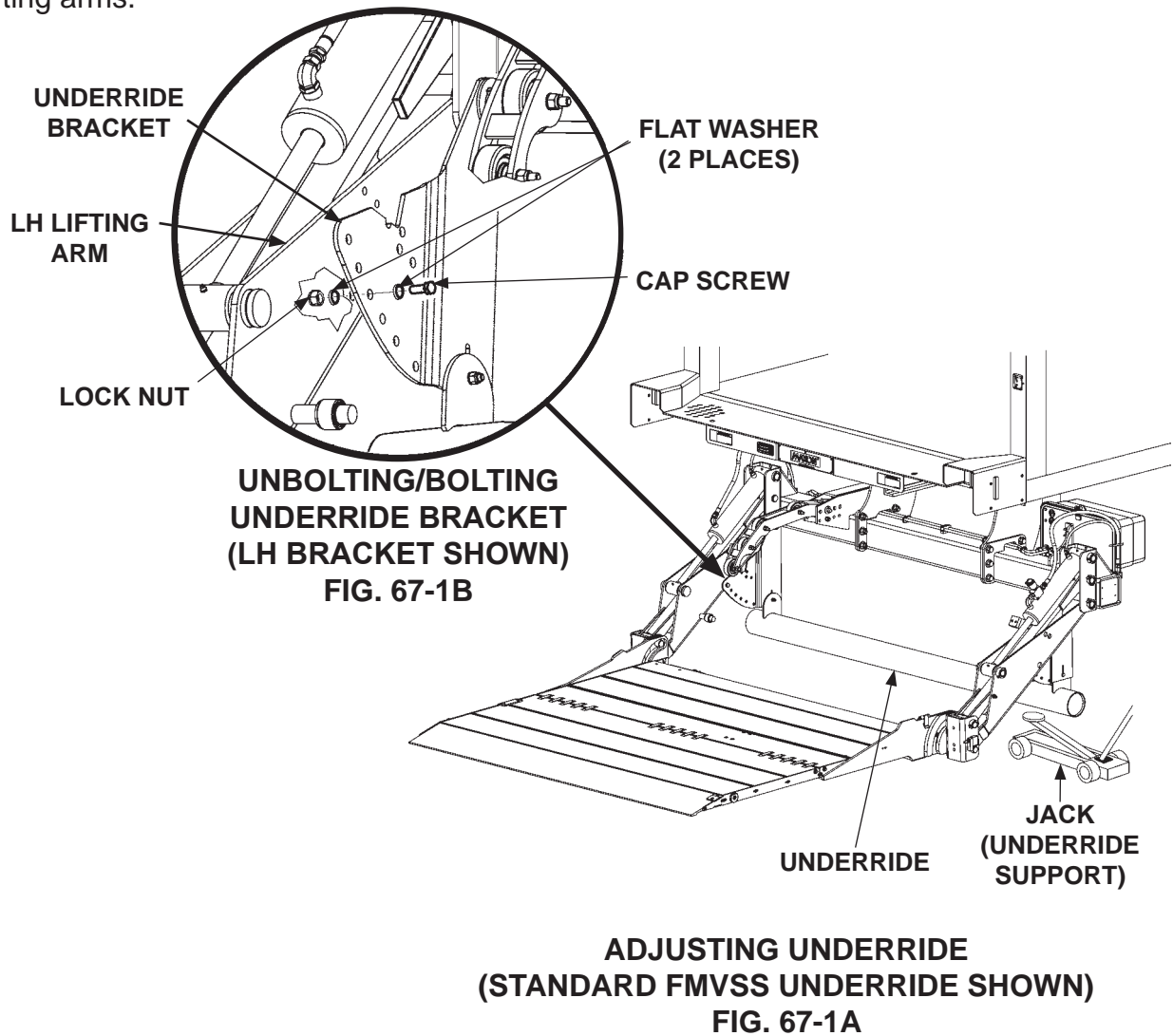
5. Unbolt each of the 2 platform seats (**FIG. 66-1B**).

**LIFTGATE WITH PLATFORM ON THE GROUND  
(STANDARD FMVSS UNDERRIDE SHOWN)  
FIG. 66-1A**

## STEP 16 - ADJUST UNDERRIDE (IF REQUIRED) - Continued

**NOTE:** At the lowest bed heights, underride may have too little ground clearance for a jack. If necessary, raise the platform up to 6" to get a jack in position to support the underride.

- Adjust position of the underride assembly as follows. Support underride with floor jack (**FIG. 67-1A**). Next, unbolt LH underride bracket (**FIG. 67-1B**) and RH underride bracket from lifting arms.



- Swing the underride to the hole setting observed in **FIGS. 64-1B, 64-2B or 65-1B**. Bolt the underride brackets in the new position (**FIG. 67-1B**). Torque the 1/2"-13 cap screws to **85 lb-ft**.
- Lower and remove floor jack (**FIG. 67-1A**).

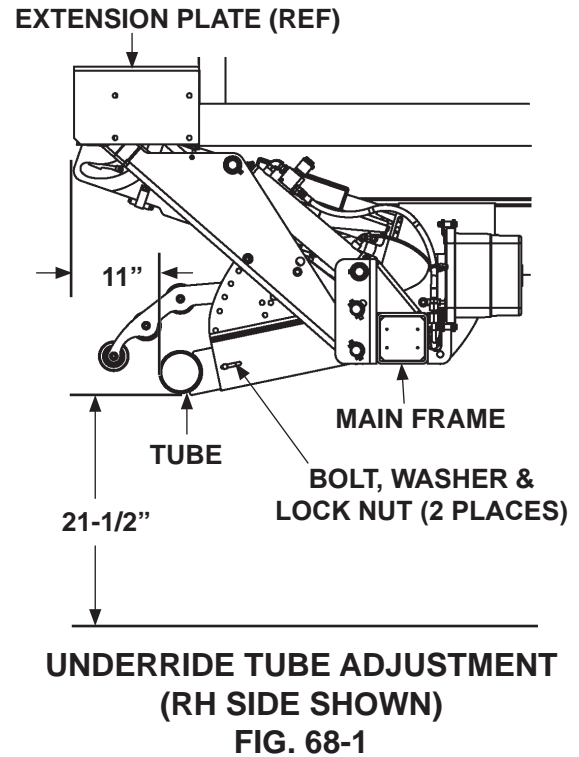
## STEP 16 - ADJUST UNDERRIDE (IF REQUIRED) - Continued

**NOTE:** The only models with an adjustable underride tube are

- Optional FMVSS underride (GPTLR-25 & GPTLR-33)
- Standard FMVSS underride (GPTLR-44 & GPTLR-55).

### ADJUSTING UNDERRIDE TUBE

9. Stow the platform. Refer to **FIG. 68-1**. Loosen bolt and lock nut, at each end of tube, just enough to move underride tube (**FIG. 68-1**). Rotate the tube up or down, and slide the tube outward or inward to the dimensions shown in **FIG. 68-1**. Tighten bolts and lock nuts to secure tube in correct position.



## STEP 16 - ADJUST UNDERRIDE (IF REQUIRED) - Continued

### CAUTION

When using an electric welder, connect the welder to one of the parts being welded, as close to the weld as possible. Failure to comply could result in damage to cylinders and electrical parts.

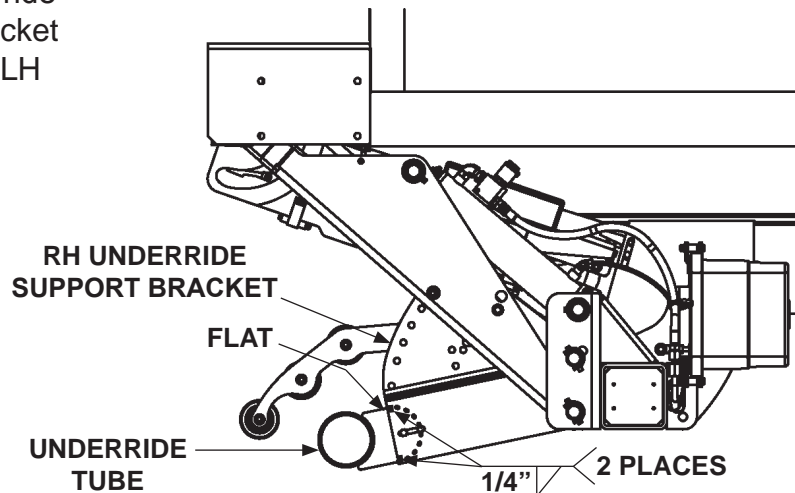
### CAUTION

To protect the original paint system, a 3" wide area of paint must be removed from all sides of the weld area before welding.

### CAUTION

Prevent the date of manufacture decal from being damaged. Cover decal when welding underside support brackets.

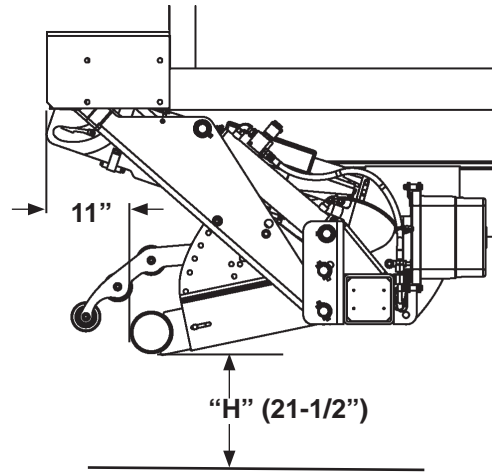
10. Tack weld flat, on underside tube, to RH support bracket (FIG. 69-1). Repeat for LH support bracket.



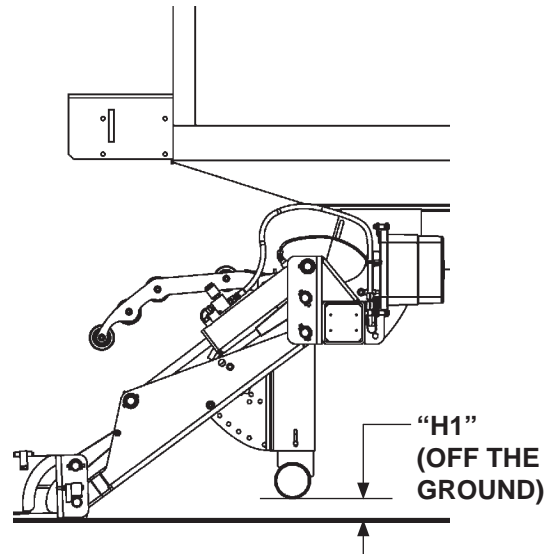
**TACK WELDING FLATS TO SUPPORT  
BRACKETS (RH SIDE SHOWN)  
FIG. 69-1**

# STEP 16 - ADJUST UNDERRIDE (IF REQUIRED) - Continued

11. With platform stowed, measure and record ground clearance "H" (FIG. 70-1). Then, lower the platform to the ground to measure ground clearance "H1" (FIG. 70-2). Compare measurements with TABLES 71-1, 72-1 and 72-2.



STANDARD FMVSS UNDERRIDE  
FIG. 70-1



STANDARD FMVSS UNDERRIDE  
FIG. 70-2

## STEP 16 - ADJUST UNDERRIDE (IF REQUIRED) - Continued

**NOTE:** The bed height dimensions, for each underride hole shown below, apply to an unloaded vehicle.

<b>RECOMMENDED BOLTED HOLE POSITIONS FOR OPTIONAL FMVSS UNDERRIDE INSTALLED ON GPTLR-25 &amp; GPTLR-33</b>			
<b>BED HEIGHT</b>	<b>UNDERRIDE HOLE NO.</b>	<b>“H” EXPECTED UNDERRIDE GROUND CLEARANCE (PLATFORM STOWED)</b>	<b>“H1” EXPECTED UNDERRIDE GROUND CLEARANCE &amp; MAX SPRING DEFLECTION OF VEHICLE WITH LOAD (PLATFORM ON THE GROUND)</b>
55”	1	21.5”	6.3”
54”	2	21.5”	5.5”
53”	2	21.5”	4.7”
52”	3	21.5”	4.0”
51”	3	21.5”	3.4”
50”	4	21.5”	2.9”
49”	4	21.5”	2.4”
48”	4	21.5”	2.0”
47”	5	21.5”	1.7”
46”	6	21.5”	1.4”

**TABLE 71-1**

## STEP 16 - ADJUST UNDERRIDE (IF REQUIRED) - Continued

**NOTE:** The bed height dimensions, for each underride hole shown below, apply to an unloaded vehicle.

<b>RECOMMENDED BOLTED HOLE POSITIONS FOR STANDARD FMVSS UNDERRIDE INSTALLED ON GPTLR-44 &amp; GPTLR-55</b>			
BED HEIGHT	UNDER-RIDE HOLE NO.	“H” EXPECTED UNDERRIDE GROUND CLEARANCE (PLATFORM STOWED)	“H1” EXPECTED UNDERRIDE GROUND CLEARANCE & MAX SPRING DEFLECTION OF VEHICLE WITH LOAD (PLATFORM ON THE GROUND)
55”	1	21.5”	3.6”
54”	2	21.5”	2.9”
53”	2	21.5”	2.3”
52”	3	21.5”	1.8”
51”	3	21.5”	1.3”
50”	4	21.5”	0.9”
49”	4	21.5”	0.6”
48”	4	21.5”	0.3”
47”	5	21.5”	0.1”
46”	6	21.5”	0”

**TABLE 72-1**

<b>RECOMMENDED BOLTED HOLE POSITIONS FOR OPTIONAL CMVSS UNDERRIDE INSTALLED ON GPTLR-44 &amp; GPTLR-55</b>			
BED HEIGHT	UNDER-RIDE HOLE NO.	“H” EXPECTED UNDERRIDE GROUND CLEARANCE (PLATFORM STOWED)	“H1” EXPECTED UNDERRIDE GROUND CLEARANCE & MAX SPRING DEFLECTION OF VEHICLE WITH LOAD (PLATFORM ON THE GROUND)
55”	1	21.35”	4.16”
54”	2	21.36”	3.37”
53”	3	21.38”	2.70”
52”	4	21.40”	2.17”
51”	5	21.41”	1.75”
50”	6	21.42”	1.44”
49”	7	21.42”	1.24”

**TABLE 72-2**



## STEP 16 - ADJUST UNDERRIDE (IF REQUIRED) - Continued

### CAUTION

When using an electric welder, connect the welder to one of the parts being welded, as close to the weld as possible. Failure to comply could result in damage to cylinders and electrical parts.

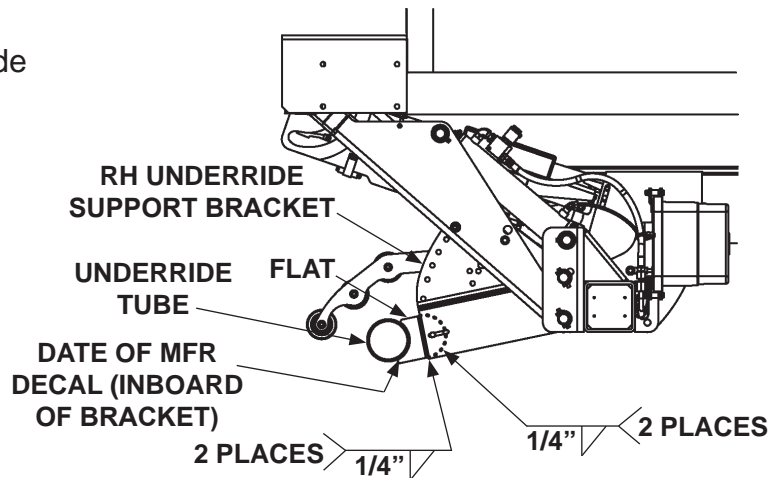
### CAUTION

To protect the original paint system, a 3" wide area of paint must be removed from all sides of the weld area before welding.

### CAUTION

Prevent the date of manufacture decal from being damaged. Cover decal when welding underside support brackets.

12. When the underride is in correct position, weld the flats on the tube to the RH and LH underride support brackets as shown in FIG. 73-1.



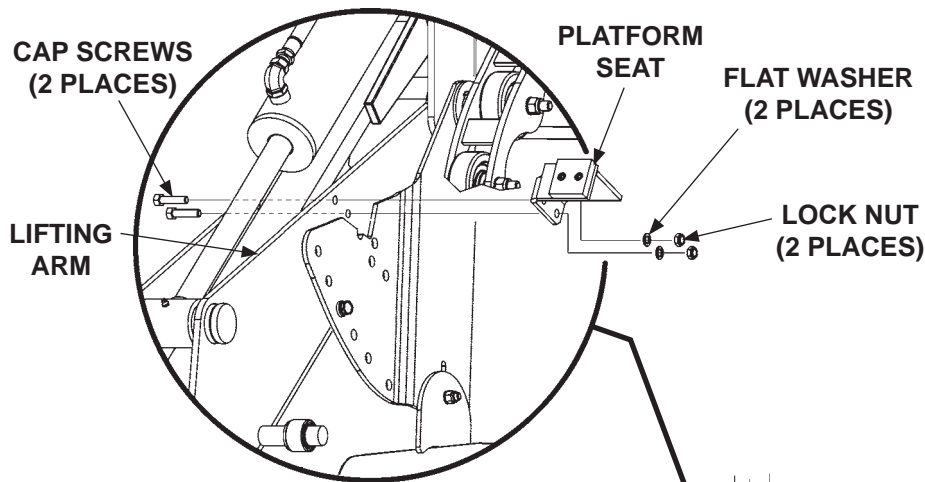
WELDING FLATS TO SUPPORT  
BRACKETS (RH SIDE SHOWN)

FIG. 73-1

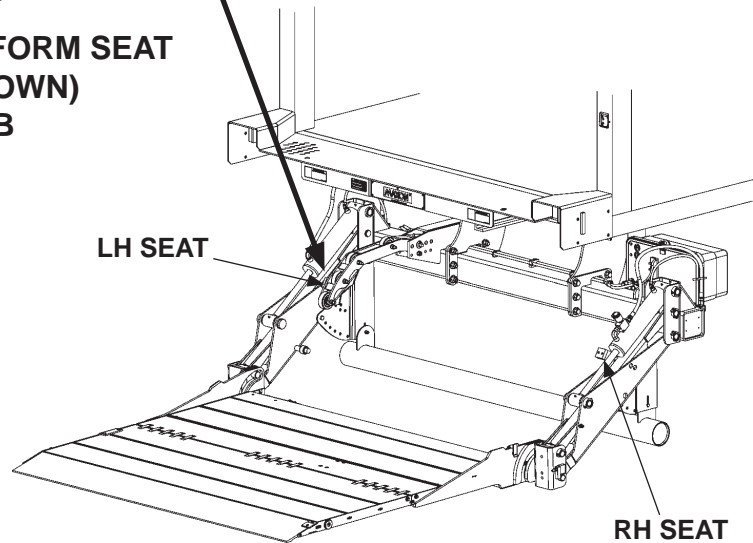
## STEP 16 - ADJUST UNDERRIDE (IF REQUIRED) - Continued

**NOTE:** For some bed heights, platform seat may be bolted against the underride bracket.

13. Lower platform to the ground (**FIG. 74-1A**). Then, bolt the LH platform seat (**FIG. 74-1B**) and the RH platform seat in position. Torque the cap screws and lock nuts to **42 lb-ft**.



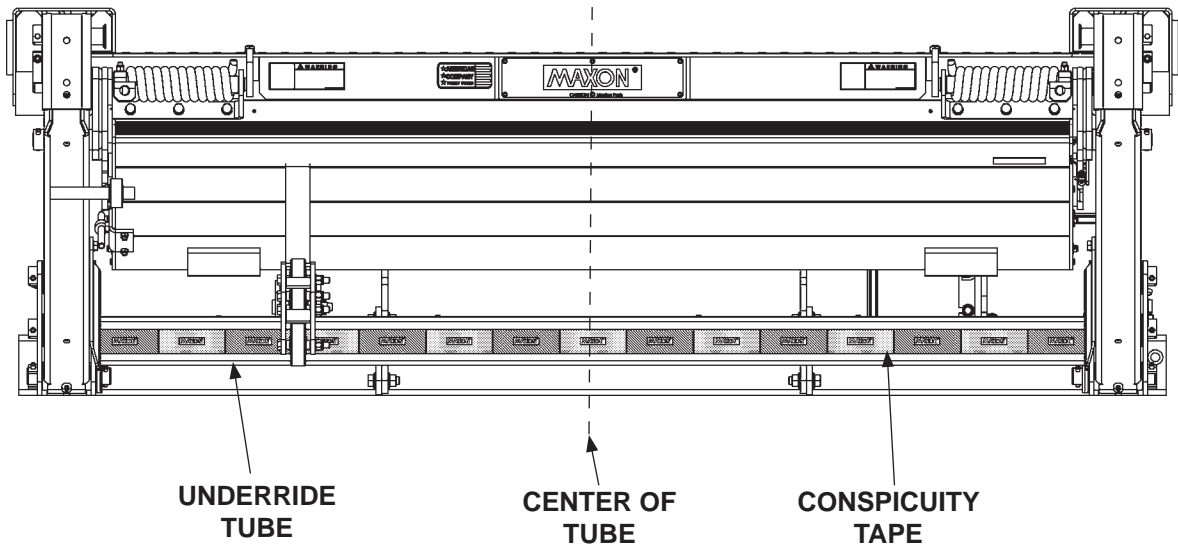
**BOLTING ON PLATFORM SEAT  
(LH SEAT SHOWN)  
FIG. 74-1B**



**LIFTGATE WITH PLATFORM ON THE GROUND  
(STANDARD FMVSS UNDERRIDE SHOWN)  
FIG. 74-1A**

## STEP 16 - ADJUST UNDERRIDE (IF REQUIRED) - Continued

14. Stow platform (**FIG. 75-1**). Next, center conspicuity (reflective) tape on the underride tube as shown in **FIG. 75-1**. Remove backing from tape. Then, attach tape to underride (**FIG. 75-1**).

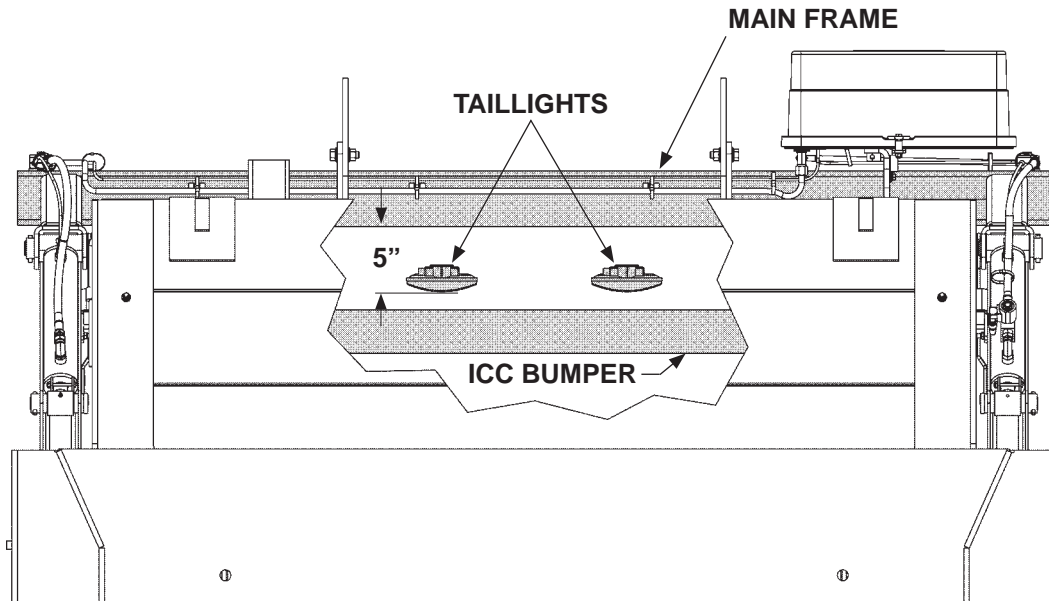


**ATTACH CONSPICUITY TAPE  
FIG. 75-1**

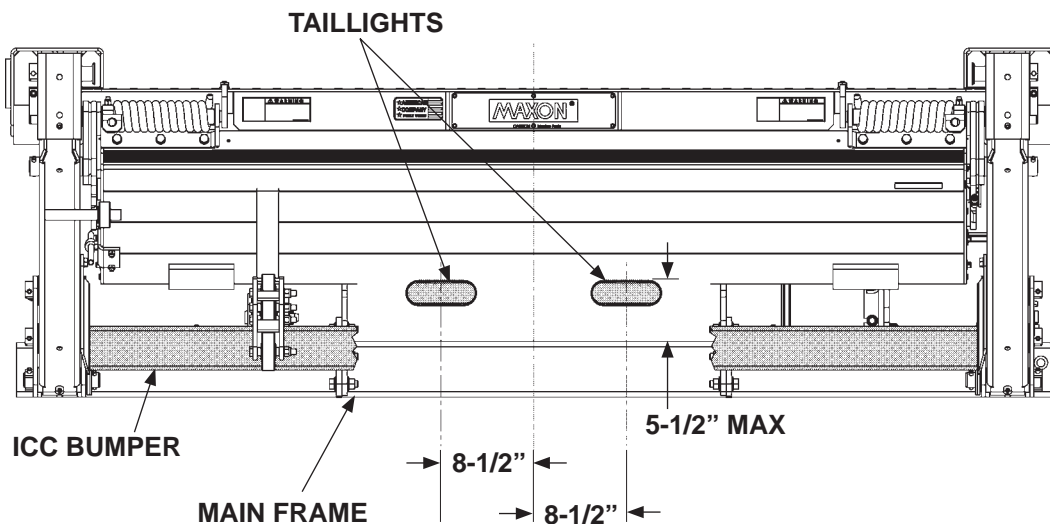
# STEP 17 - VEHICLE TAILLIGHT POSITIONING (IF REQUIRED)

## LIFTGATES WITH STANDARD ICC BUMPER

**NOTE:** Positions are based on using oval taillights of 2-1/4" height by 6-1/2" width. Larger taillights may interfere with Liftgate. Taillights and attaching hardware are not provided with the Liftgate.



**TAILLIGHTS POSITION (TOP VIEW OF GPTLR-25)**  
**FIG. 76-1**

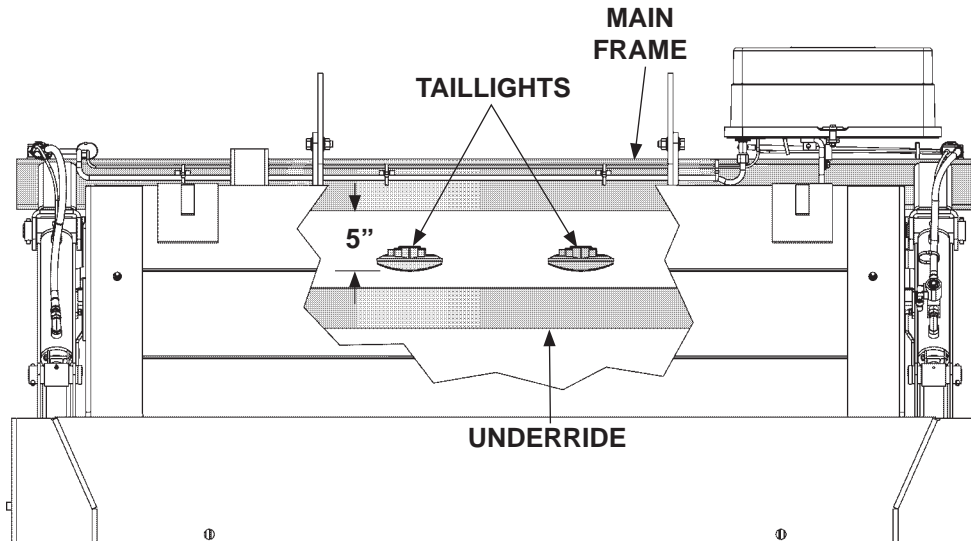


**TAILLIGHTS SPACING (FRONT VIEW OF GPTLR-25)**  
**FIG. 76-2**

# STEP 17 - VEHICLE TAILLIGHT POSITIONING (IF REQ'D) - Continued

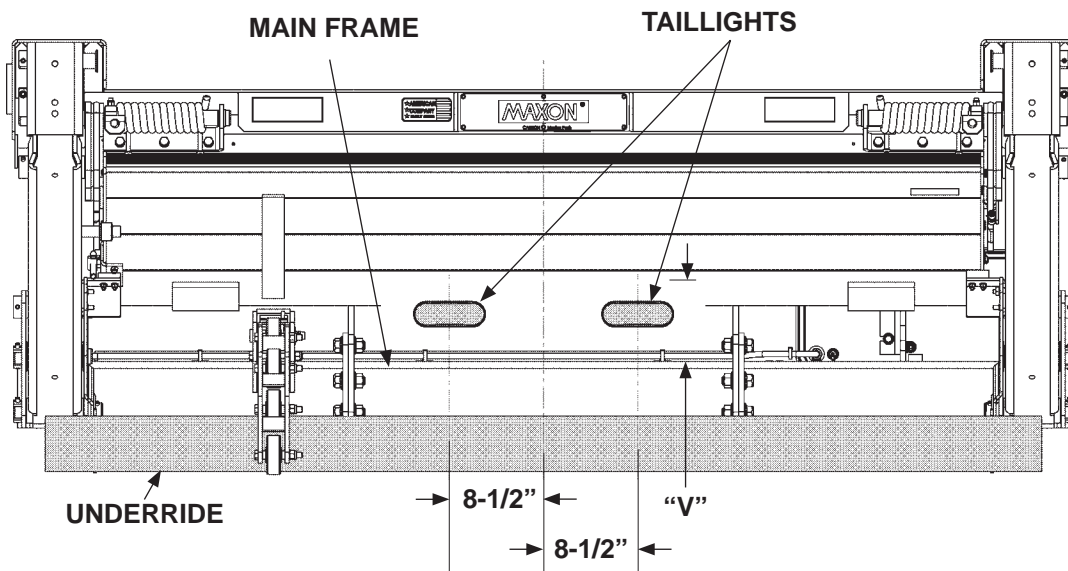
## LIFTGATES WITH STANDARD AND OPTIONAL UNDERRIDE

**NOTE:** Positions are based on using oval taillights of 2-1/4" height by 6-1/2" width. Larger taillights may interfere with Liftgate. Taillights and attaching hardware are not provided with the Liftgate.



**TAILLIGHTS POSITION (TOP VIEW OF GPTLR-44)  
FIG. 77-1**

**NOTE:** Dimension "V" is variable. Position the taillights to a height with the best visibility. The underride and other Liftgate parts must not cover the lights when platform is stowed.



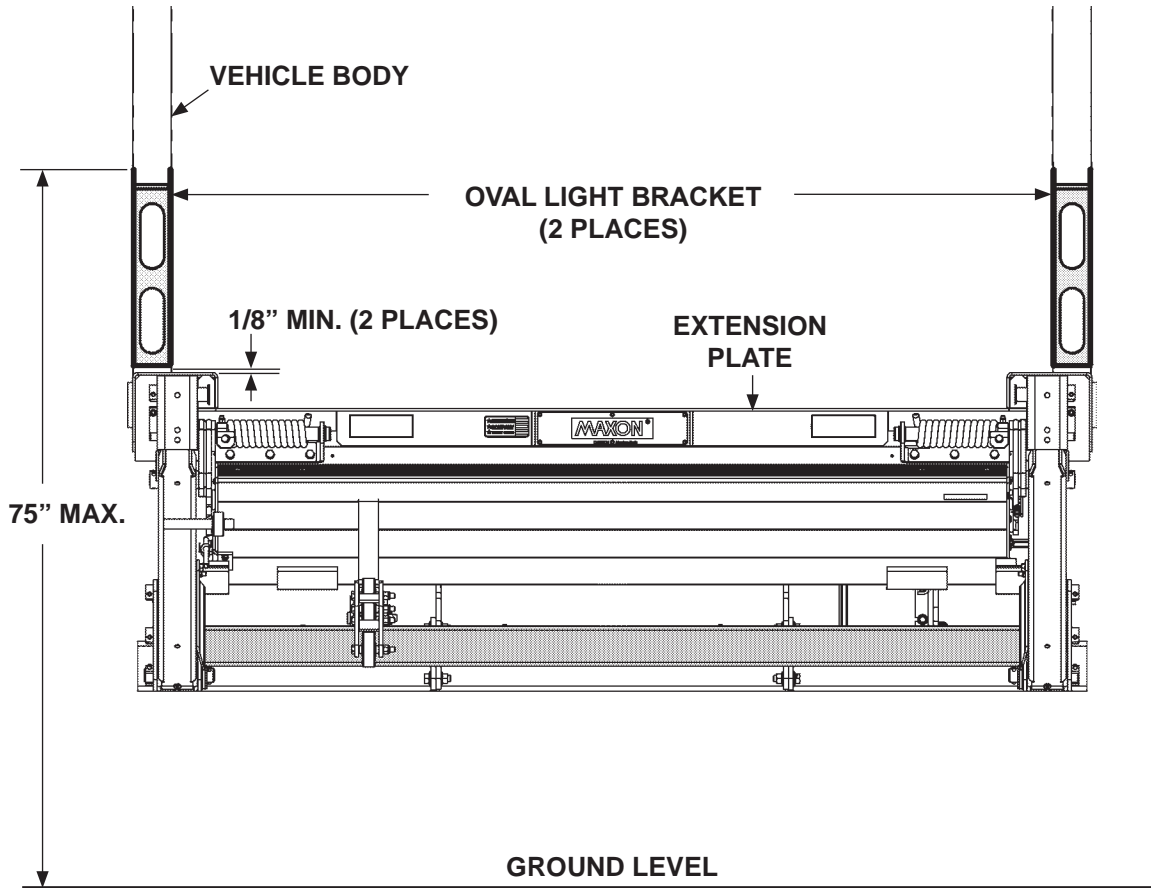
**TAILLIGHTS SPACING (FRONT VIEW OF GPTLR-44)  
FIG. 77-2**

# STEP 17 - VEHICLE TAILLIGHT POSITIONING (IF REQ'D)

## - Continued

### OVAL LIGHT BRACKETS

To simplify taillight installation, **MAXON** recommends the optional oval light brackets kit, P/N 282372-01G. Each kit contains 2 light brackets (**FIG. 78-1**), to mount on vehicle body, and installation instructions. Oval taillights are not included.



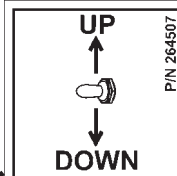
TAILLIGHT BRACKET POSITIONS (GPTLR-25 SHOWN)  
FIG. 78-1

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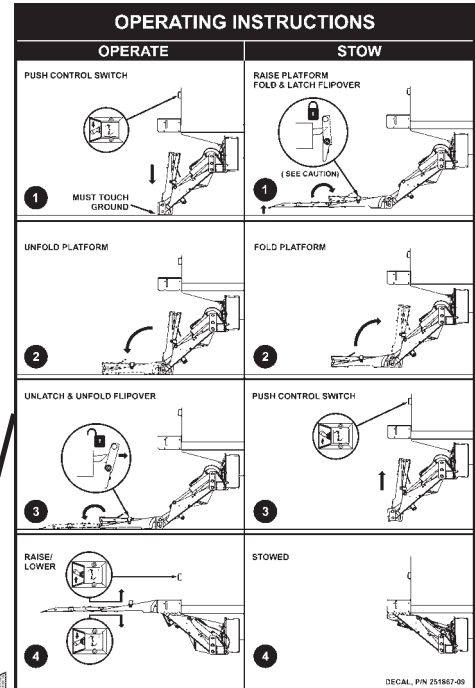
# ATTACH DECALS

**NOTE:** Preferred decal layout is shown, Decals on the Liftgate are attached at the factory. If vehicle does not permit this layout, decals in the manual and decal kit must be applied so that they are easily visible when approaching vehicle to operate Liftgate. Use good common sense when locating these decals on vehicle.

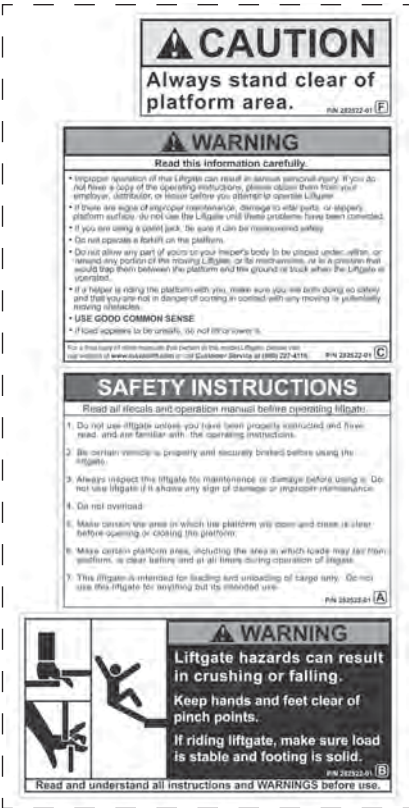
**NOTE:** Ensure there is no residue, dirt or corrosion where decals are attached. If necessary, clean this surface before attaching decals.



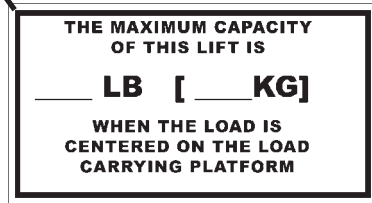
**CONTROL SWITCH  
DECAL  
P/N 264507**



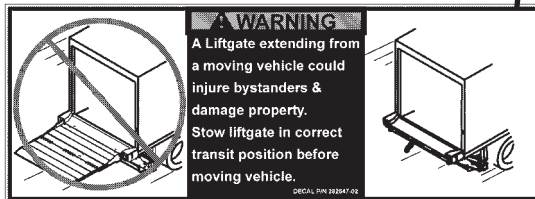
**INSTRUCTION DECAL  
P/N 251867-09**



**DECAL SHEET  
(SMALL, WARNING & CAUTION)  
P/N 282522-01**



**CAPACITY DECAL  
(SEE TABLE 79-1)**



**STOW WARNING DECAL  
P/N 282847-02**

CAPACITY DECALS	
CAPACITY	PART NO.
2500 LBS.	220382
3300 LBS.	220388-02
4400 LBS.	253155
5500 LBS.	253161

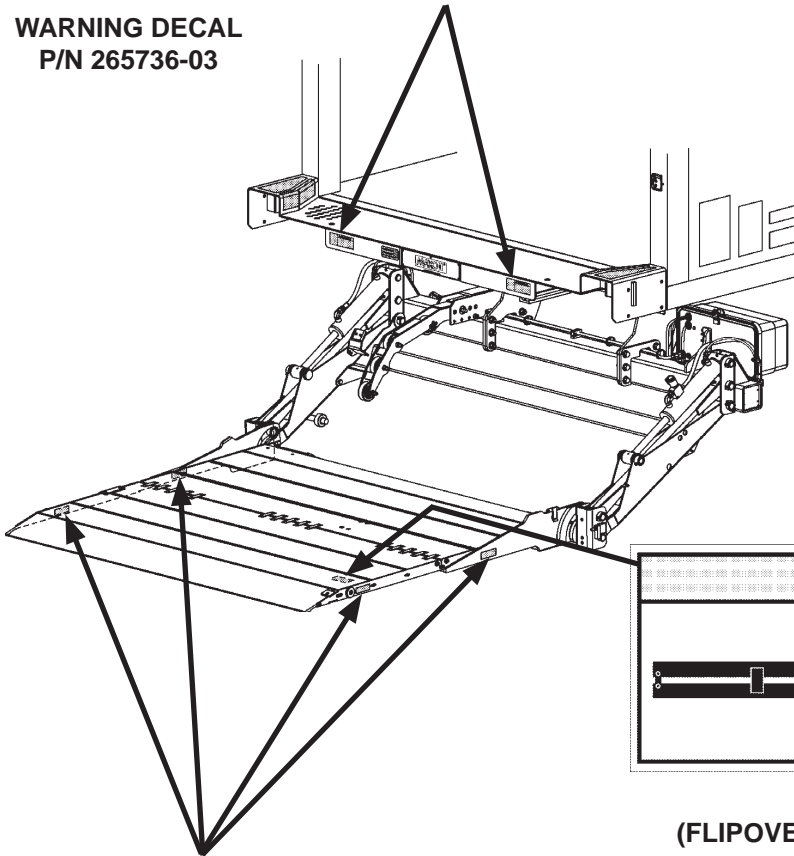
**TABLE 79-1**

**FIG. 79-1**

# DECALS & PLATES



**WARNING DECAL**  
 P/N 265736-03



**CAUTION DECAL**  
 (FLIPOVER EQUIPPED WITH LATCH ONLY)  
 P/N 267694-01



**WARNING DECAL**  
 P/N 265736-02

**FIG. 80-1**

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# ATTACH NONSKID & SAFETY STRIPING

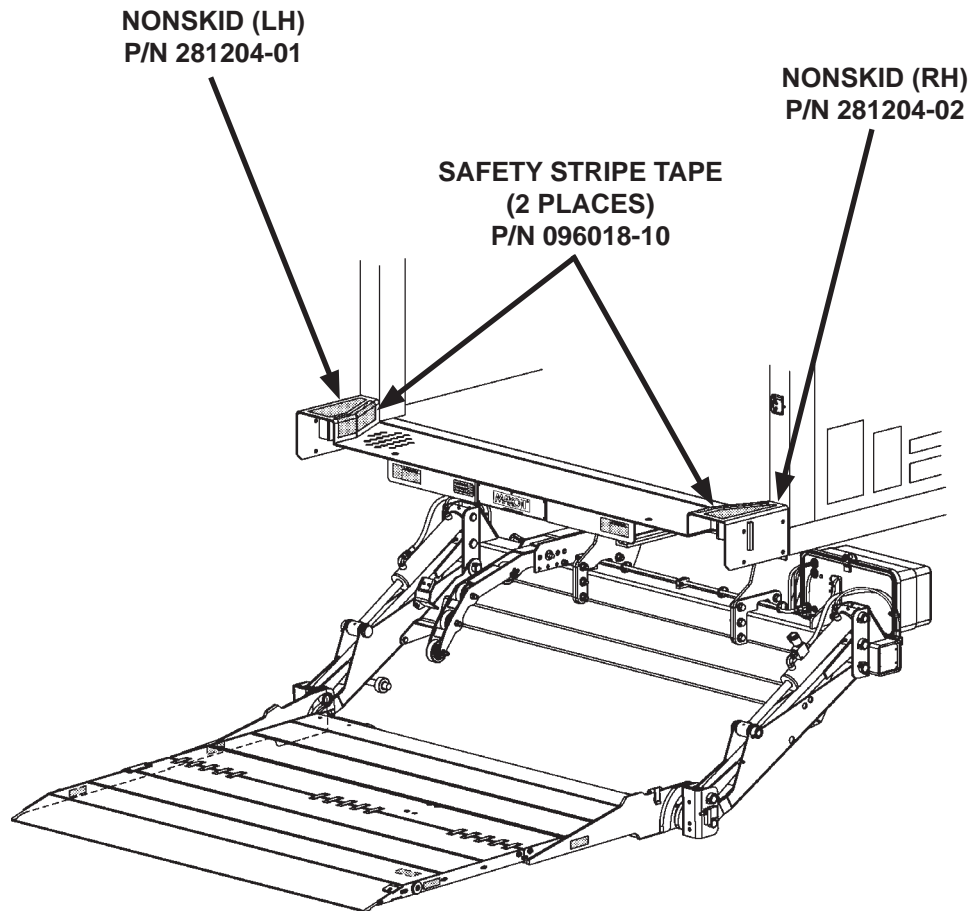


FIG. 81-1

## TOUCHUP PAINTED OR GALVANIZED FINISH

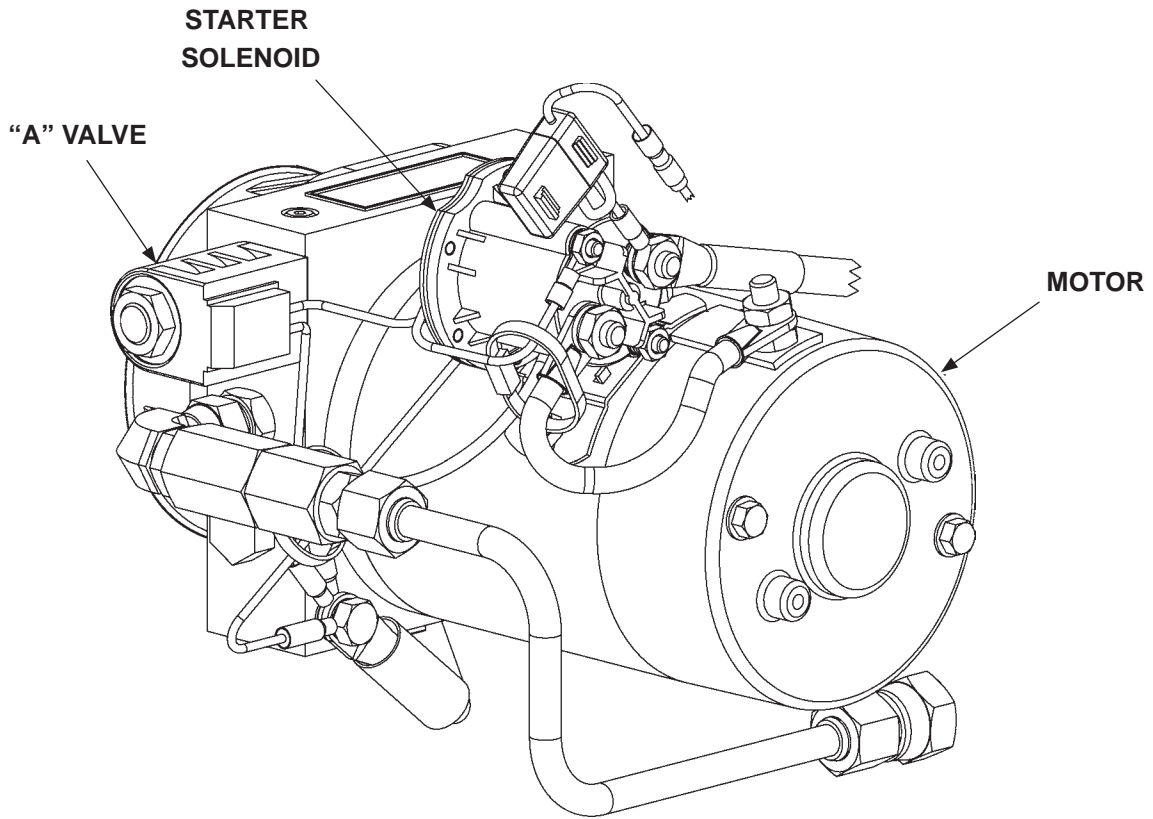
### CAUTION

Damaged cylinder seals and contaminated hydraulic fluid can result from painting the polished portion of the cylinder rod. To prevent damage, protect the exposed polished portion of the cylinder rod while painting.

- If bare metal or primer is exposed on the painted portions of the Liftgate, touch up the paint. To maintain the protection provided by the original paint system, **MAXON** recommends aluminum primer touchup paint.
- If bare metal is exposed on galvanized portions of the Liftgate, touch up the galvanized finish. To maintain the protection provided by the original galvanized finish, MAXON recommends cold galvanize spray.

# SYSTEM DIAGRAMS

## PUMP & MOTOR SOLENOID OPERATION (GRAVITY DOWN)

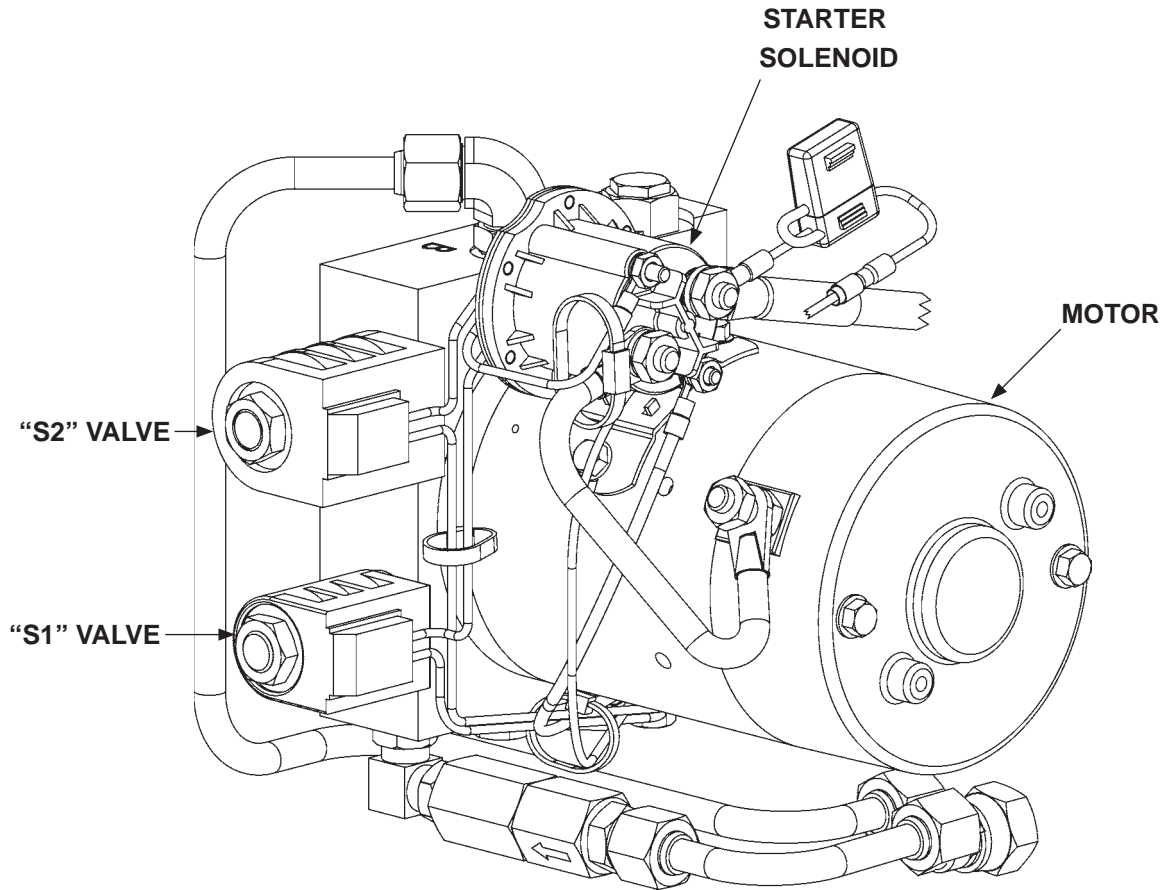


**GRAVITY DOWN POWER UNIT  
FIG. 83-1**

POWER UNIT MOTOR & SOLENOID OPERATION				
LIFTGATE FUNCTION	PORT	SOLENOID OPERATION (✓ MEANS ENERGIZED)		
		MOTOR	VALVE "A"	LOCK VALVE
RAISE	A	✓	-	-
LOWER	VENT	-	✓	✓
REFER TO VALVES SHOWN ON HYDRAULIC SCHEMATIC				

**TABLE 83-1**

## PUMP & MOTOR SOLENOID OPERATION (POWER DOWN)



**POWER DOWN POWER UNIT  
FIG. 84-1**

POWER UNIT MOTOR & SOLENOID OPERATION					
LIFTGATE FUNCTION	PORT	SOLENOID OPERATION (✓ MEANS ENERGIZED)			
		MOTOR	VALVE "S2"	VALVE "S1"	LOCK VALVE
RAISE	A	✓	-	✓	-
LOWER	B	✓	✓	-	✓
REFER TO VALVES SHOWN ON HYDRAULIC SCHEMATIC					

**TABLE 84-1**

# HYDRAULIC SCHEMATIC (GRAVITY DOWN)

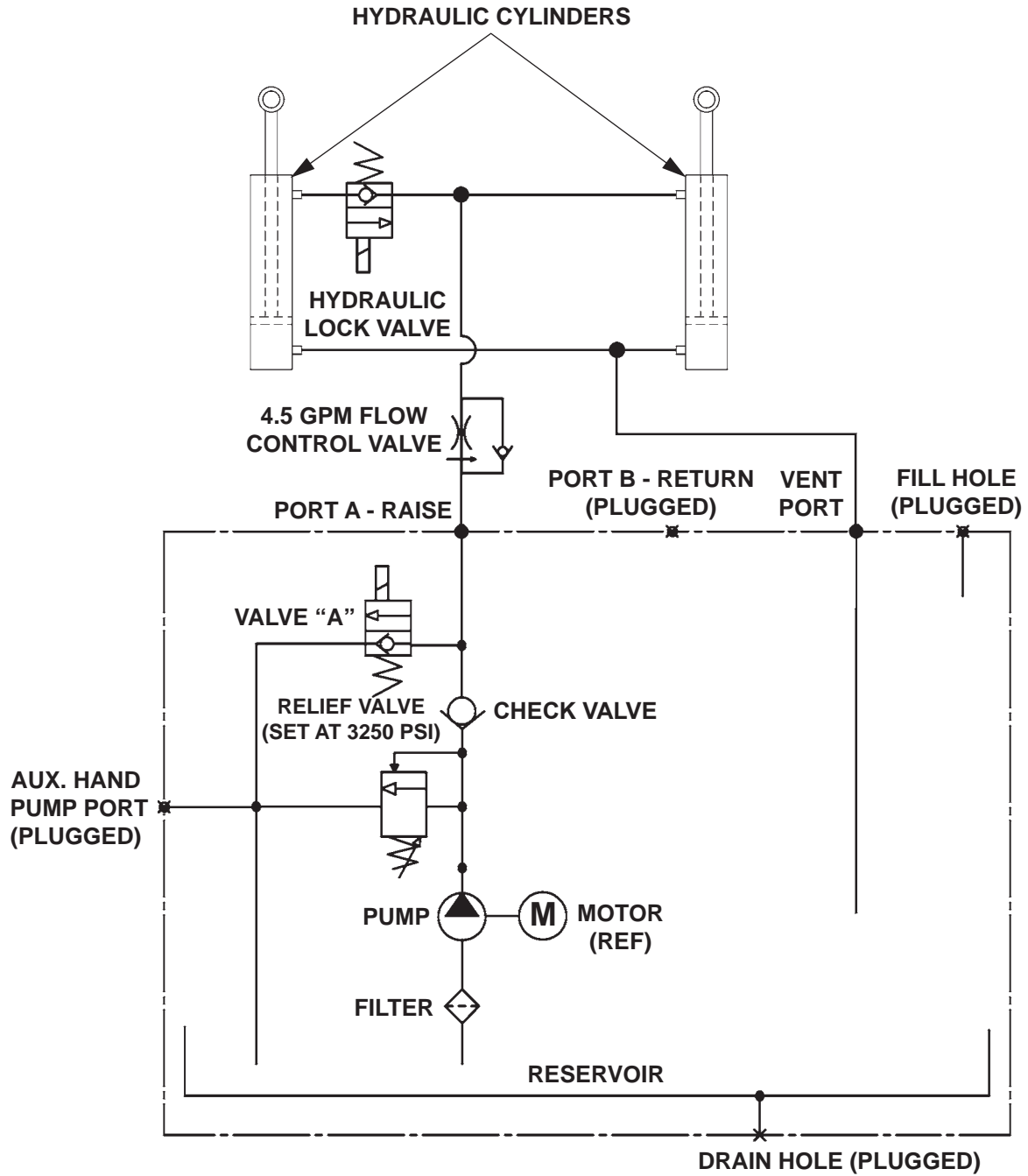


FIG. 85-1

# HYDRAULIC SCHEMATIC (POWER DOWN)

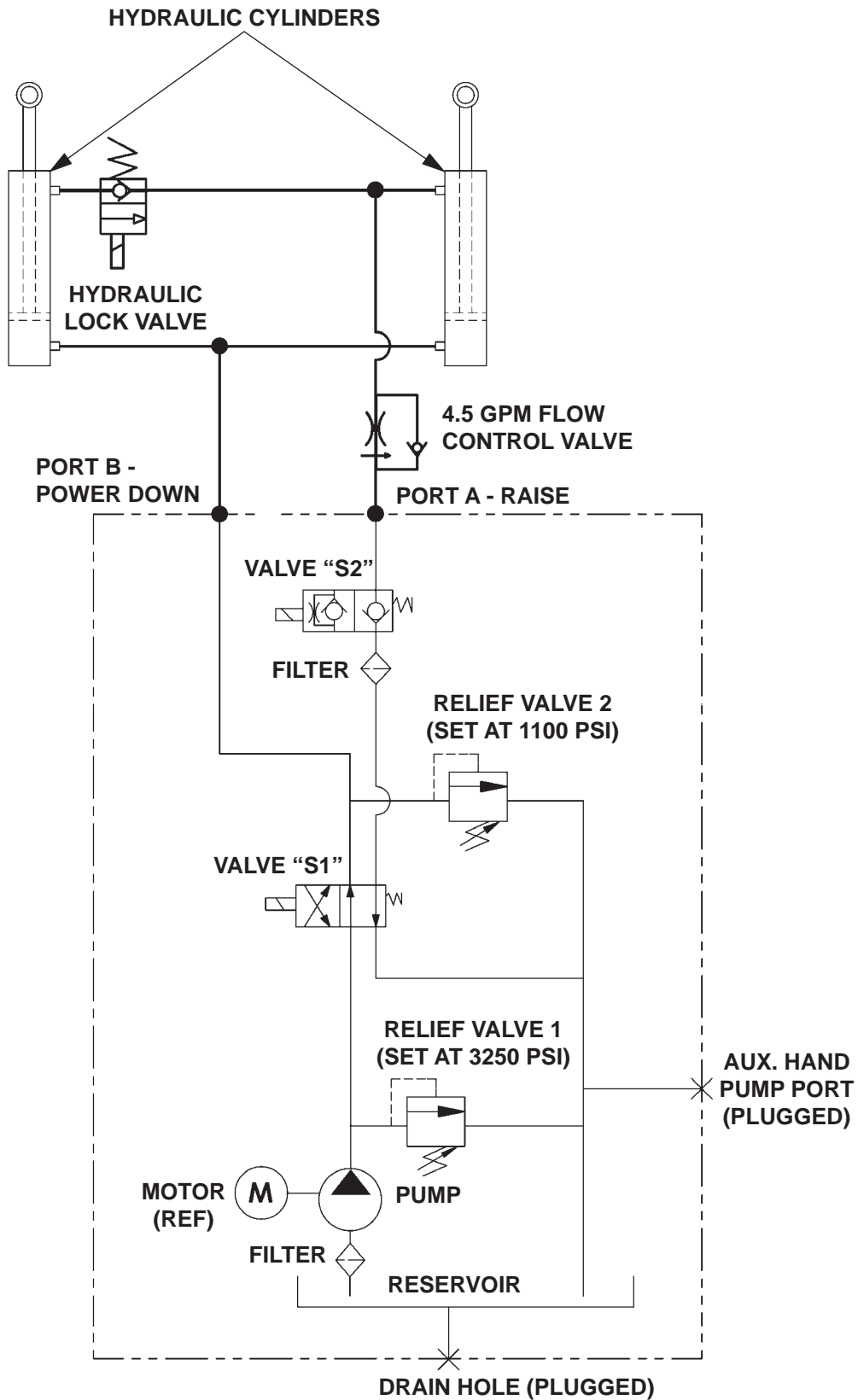


FIG. 86-1

# ELECTRICAL SCHEMATIC (GRAVITY DOWN)

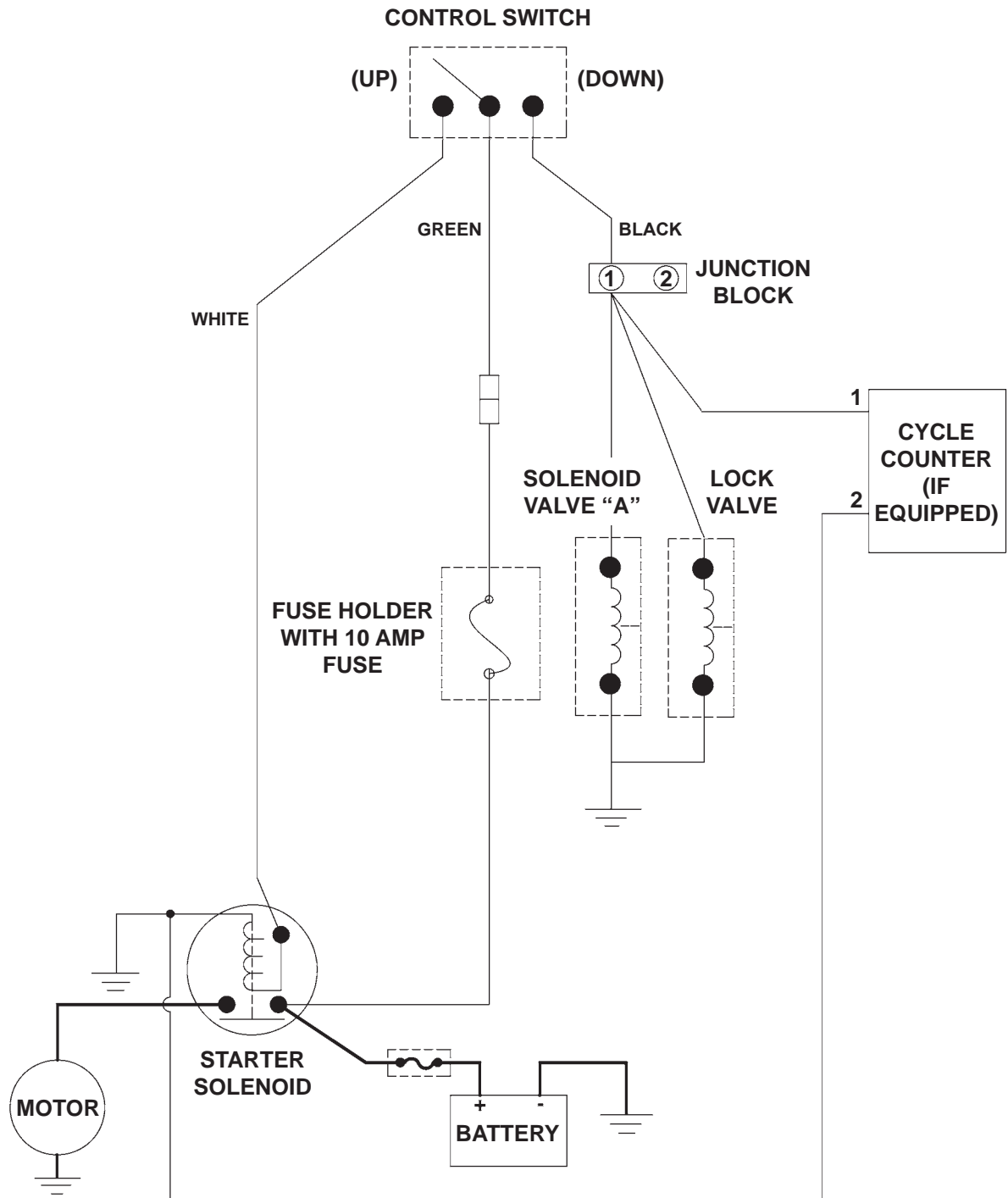


FIG. 87-1

# ELECTRICAL SCHEMATIC (POWER DOWN)

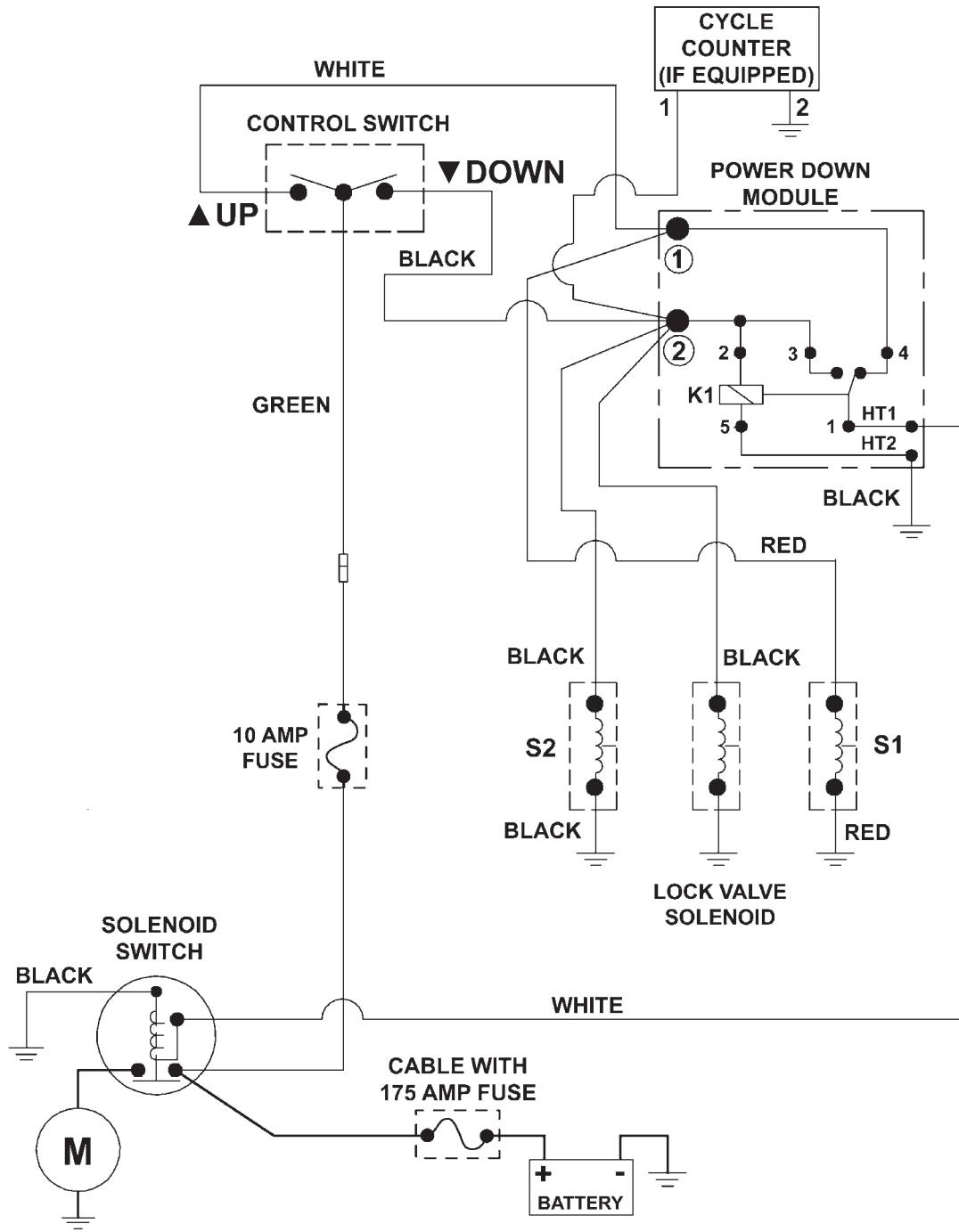


FIG. 88-1



## SYSTEM DIAGRAMS GPTLR ELECTRICAL VALUES

Solenoid Switch	12V	24V
Coil Resistance:	5.4Ω @70°F. ±15%	20.1Ω @70°F. ±15%
Ampere:	2.2A	1.2A
Coil terminal torque: <b>10-15 lb-in</b> max.		
Contact terminal torque: <b>30-35 lb-in</b> max.		
<b>Solenoid Valves (A, S1, &amp; S2)</b>		
Coil Resistance:	6.6Ω @ 70°F. ±15%	26.7Ω @ 70°F. ±15%
Ampere:	1.8A	0.9A
Coil terminal torque: <b>15-45 lb-in</b> max.		
Valve cartridge torque: <b>25-30 lb-ft</b> max.		
Coil nut torque: <b>15-45 lb-in</b>		
<b>Solenoid Lock Valve</b>		
Coil Resistance:	8.0Ω @ 70°F. ±15%	30Ω @ 70°F. ±15%
Ampere:	1.5A	0.8A
Coil terminal torque: <b>3-4.5 lb-ft</b> max.		
Valve cartridge torque: <b>18.5-22 lb-ft</b> max.		
<b>Ground Cable</b>		
Cap Screw Torque: <b>24 lb-ft</b> max.		

TABLE 89-1

## OPTIONS

### OPTIONAL LIFTGATE COMPONENTS

MISCELLANEOUS KITS	PART NO.
IN CAB ON-OFF SWITCH	250477
FRAMELESS TRAILER, GPTLR-25/33 (WORKS WITH NEW OPENER)	282561-01
FRAMELESS TRAILER, GPTLR-25/33, GALVANIZED	282561-01G
FRAMELESS TRAILER, GPTLR-44/55 (WORKS WITH NEW OPENER)	282562-01
FRAMELESS TRAILER, GPTLR-44/55, GALVANIZED	282562-01G
CIRCUIT BREAKER (150 AMP)	251576
TRAFFIC CONES	268893-01
FRAME MOUNTING BRACKET FOR 2 OVAL LIGHTS	282372-01
HAND PUMP, GPTLR, GRAVITY DOWN	287369-01
<b>EXTRA CONTROLS &amp; CONTROL KITS</b>	
HAND HELD CONTROL, TUK-A-WAY	280570-07
STREET SIDE CONTROL, TUK-A-WAY	297116-01
DUAL CONTROL, TUK-A-WAY	297115-01
<b>STEP KITS</b>	
DUAL STEP, GPTLR-25/33, GALVANIZED	281312-01G
DUAL STREET SIDE STEP GPTLR-25/33 GALVANIZED	281312-02G
DUAL CURB SIDE STEP, GPTLR-25/33 GALVANIZED	281312-03G
DUAL STEP, GPTLR-44/55, GALVANIZED	281311-01G
FOLD DOWN STEP ALL GPTLR'S (1 KIT PER SIDE)	267835-01

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