

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

- ### MAIN STRUT ERECTION PROCEDURE
- POSITION WIRE ROPE GUARD (ITEM 37) AS SHOWN IN VIEW "C" AND REEVE LUFFING JIB HOIST.
  - ATTACH LINK (ITEM 18) AND BASIC BACKSTAY PENDANT (ITEM 42) TO MAIN STRUT. ATTACH STRUT STOP TUBE ASSEMBLY (ITEM 26) TO STRUT SUPPORT BEAM ON MAIN STRUT ASSEMBLY. STRUT STOP TUBE ASSEMBLY SHOULD BE IN ITS RETRACTED POSITION WITH PIN 563912 REF. IN THE STRUT ERECTION AND POSITIONING LOCATION. (SEE VIEW "E"); ATTACH GUY LINES OR OTHER MEANS TO STRUT STOP TUBE ASSEMBLY TO AID STRUT POSITIONING DURING STRUT ERECTION.
- DANGER:**  
DO NOT STAND UNDER MAIN STRUT DURING ERECTION.
- RUN A 1.125 (29 mm) ROPE FROM DRUM 9 OVER THE TOP OF THE STRUT RAISING BRACKET (176250 REF.) ON WIRE ROPE GUIDE ASSEMBLY (ITEM 37).
  - ATTACH ROPE TO SOCKET (ITEM 4) & WEDGE (ITEM 5) AND PIN SOCKET TO RIGGING PENDANT FROM MAIN STRUT WITH PIN (ITEM 43).
  - RAISE MAIN STRUT WITH LOAD LINE WHILE PAYING OUT LUFFING JIB HOIST LINE (DO NOT ALLOW LUFFING JIB HOIST LINE TO GO INTO TENSION UNTIL MAIN STRUT IS NEAR VERTICAL).
  - WHEN MAIN STRUT HAS BEEN RAISED TO A POSITION WHERE RETRACTED STRUT STOP TUBE ASSEMBLY (ITEM 26) CONTACTS THE BOOM TOP PLATEWORK, REMOVE PIN 563912 (REF.) FROM STRUT STOP TUBE ASSEMBLY. STORE AS SHOWN IN VIEW "E". EXTEND STRUT STOP TUBE ASSEMBLY TO BOOM TOP PLATEWORK AND CONNECT USING PIN (ITEM 20).
  - SUPPORT MAIN STRUT WITH LUFFING JIB HOIST LINE AND MOVE INTO A POSITION SUPPORTED BY RETRACTED STRUT STOP TUBE ASSEMBLY (ITEM 26), AND REINSTALL PIN 563912 (REF.) IN STRUT ERECTION AND POSITIONING LOCATION (REF. VIEW "E").
  - WITH STRUT RESTING ON STRUT STOP TUBE ASSEMBLY (ITEM 26), DISCONNECT SOCKET (ITEM 4) AND PIN PENDANT TO STRUT USING PIN 563903 (REF.). SEE VIEW "F".
  - CONNECT ALL BACKSTAY PENDANTS AND LINKS. (SEE TABLES SHT. 4)
  - AFTER ALL BACKSTAY PENDANTS AND LINKS ARE IN PLACE AND BACKSTAY IS PINNED TO BACKSTAY PIN (ITEM 21) IN BOOM BUTT, REMOVE PIN 172936 (REF.) AND RAISE MAIN STRUT USING LUFFING JIB HOIST LINE UNTIL PIN HOLES IN STRUT STOP TUBE ASSEMBLY (ITEM 26) ALIGN IN OPERATING POSITION. (SEE VIEW "D")
  - INSERT PIN 172936 (REF.). RELAX LUFFING JIB HOIST LINE. DISCONNECT JIB STRUT FROM JIB, AND REMOVE AND STORE PIN 563912 (REF.). SEE VIEW "E".
  - PIN WIRE ROPE GUARD (ITEM 37) IN WORKING POSITION AS SHOWN IN VIEW "B".
  - REVERSE PROCEDURE FOR LOWERING MAIN STRUT.

NO.	DATE	DESCRIPTION
02-02-01	JMM	ADDED
05-04-01	JLU	ITEM 32 ADDED
02-03-10	JAS	UPDATED BOOM SIGN
03-10-11	JAS	01 UPDATED VIEW TO SHOW BOTH 10.00 AND 26.00 POSITION
01-01-12	JAS	UPDATED PICTURE OF PENDANT
01-01-12	JAS	ADDED ITEM 15 AND DELTA 25

195517  
SHT 1 OF 4

DATE: 10-20-00  
PATTERN NO.:  
PRIVATE LABELING REQUIREMENT TO CONFORM TO ENGINEERING SPECIFICATION 6629103794 FOR COMPONENTS LISTED IN 60500-00-006

TOLERANCE UNLESS OTHERWISE SPECIFIED		MACHINING		WELDING		FIT	
DECIMAL PLACES	FRACTIONS	10 FEET	10 FEET	10 FEET	10 FEET	10 FEET	10 FEET
(1) PLACE 0.0	1/32	±.012	±.018	±.015	±.015	±.015	±.015
(2) PLACE 0.00	1/64	±.006	±.012	±.015	±.015	±.015	±.015
(3) PLACE 0.000	1/128	±.003	±.006	±.015	±.015	±.015	±.015
ANGLES		±1.24	±1.24	±0.50	±0.50	±0.50	±0.50

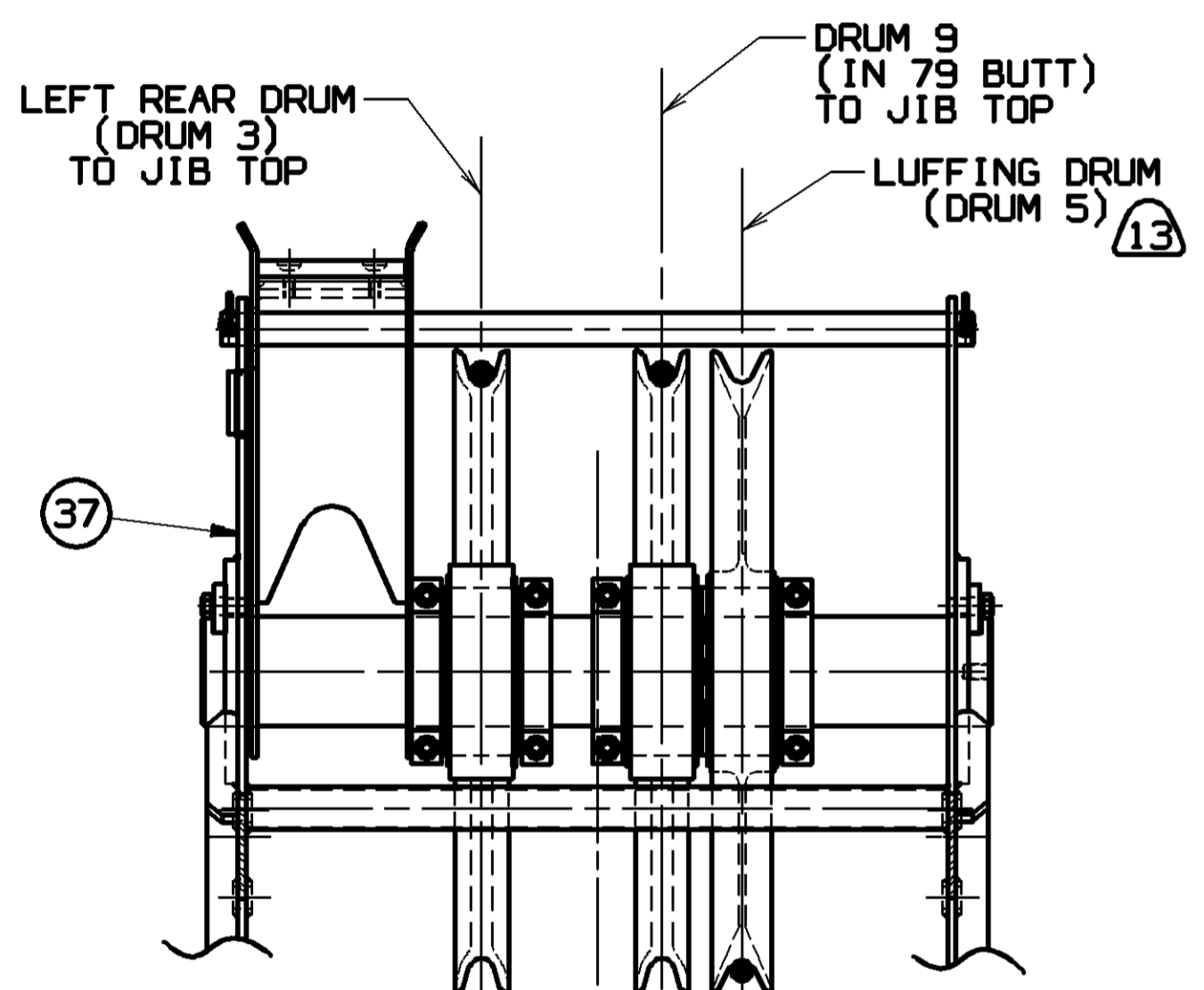
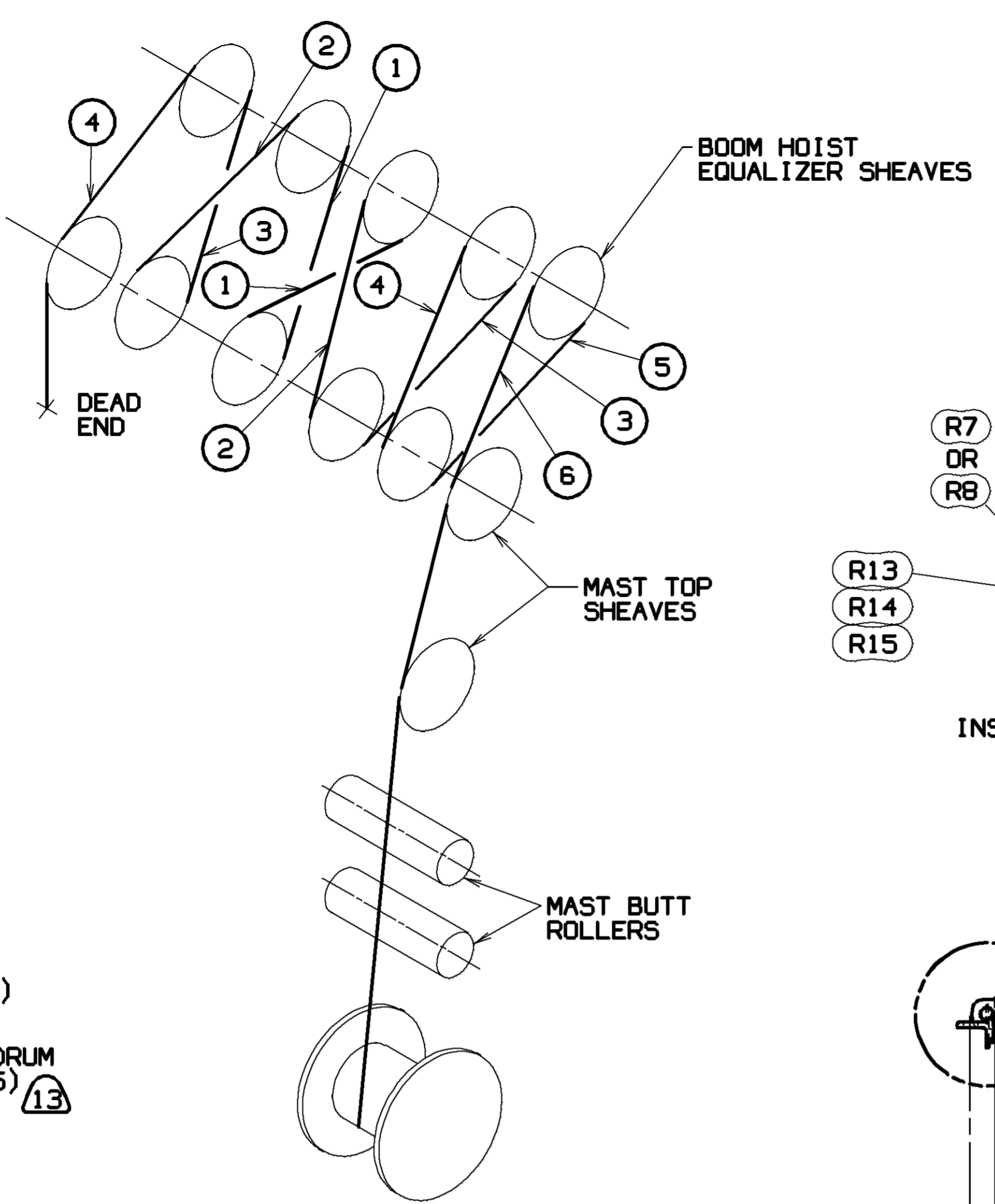


BILL OF MATERIAL				
ITEM NO.	QTY.	DESCRIPTION	UNIT	MATERIAL CODE NO. OR DIM. NO.

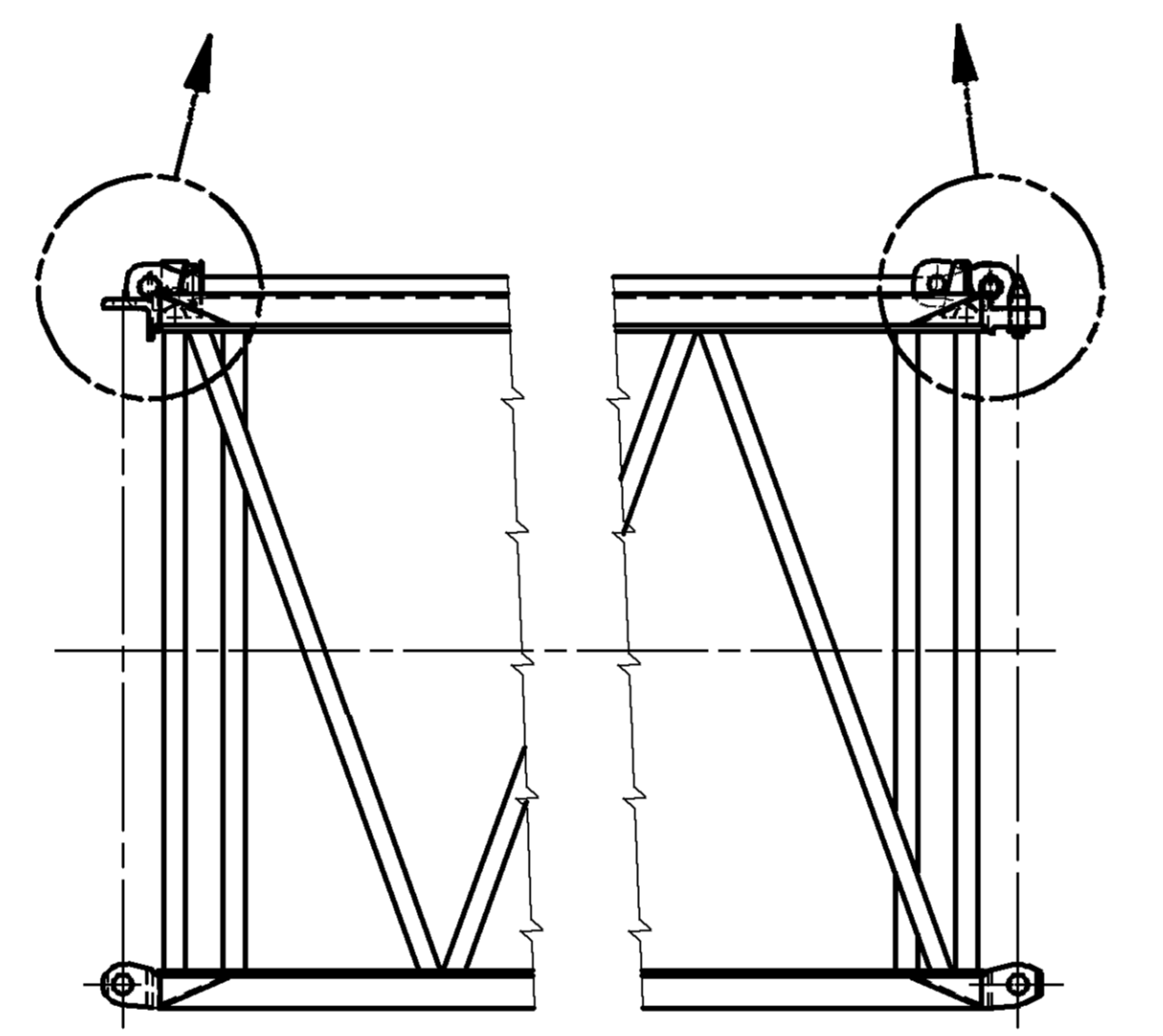
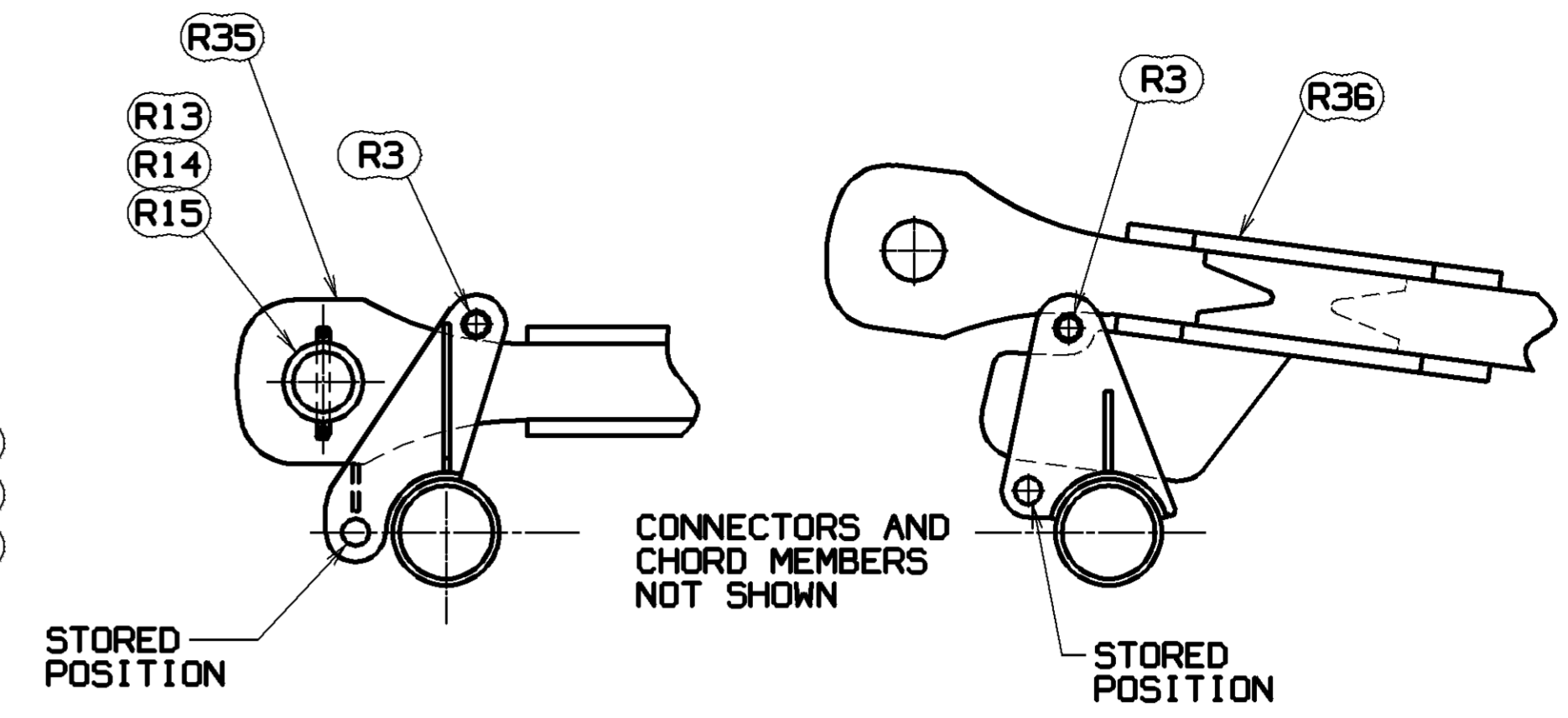
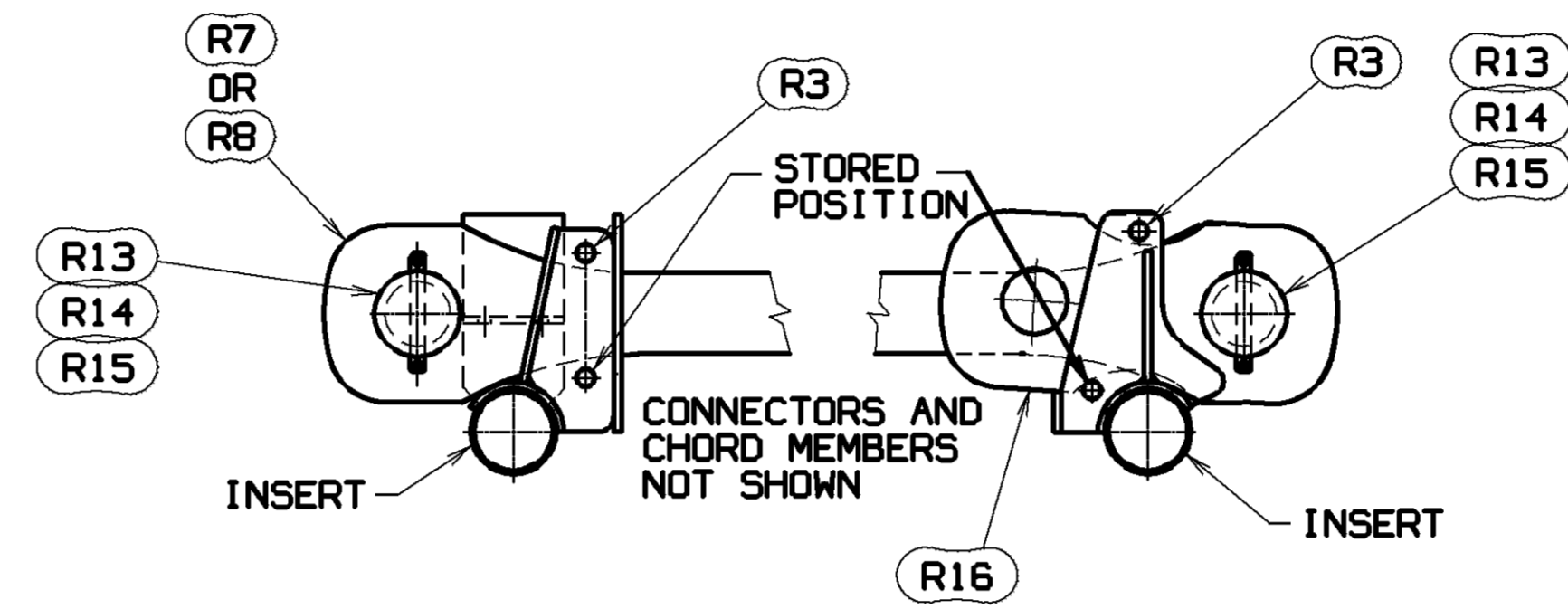
ASSEMBLIES USED ON

REVISIONS

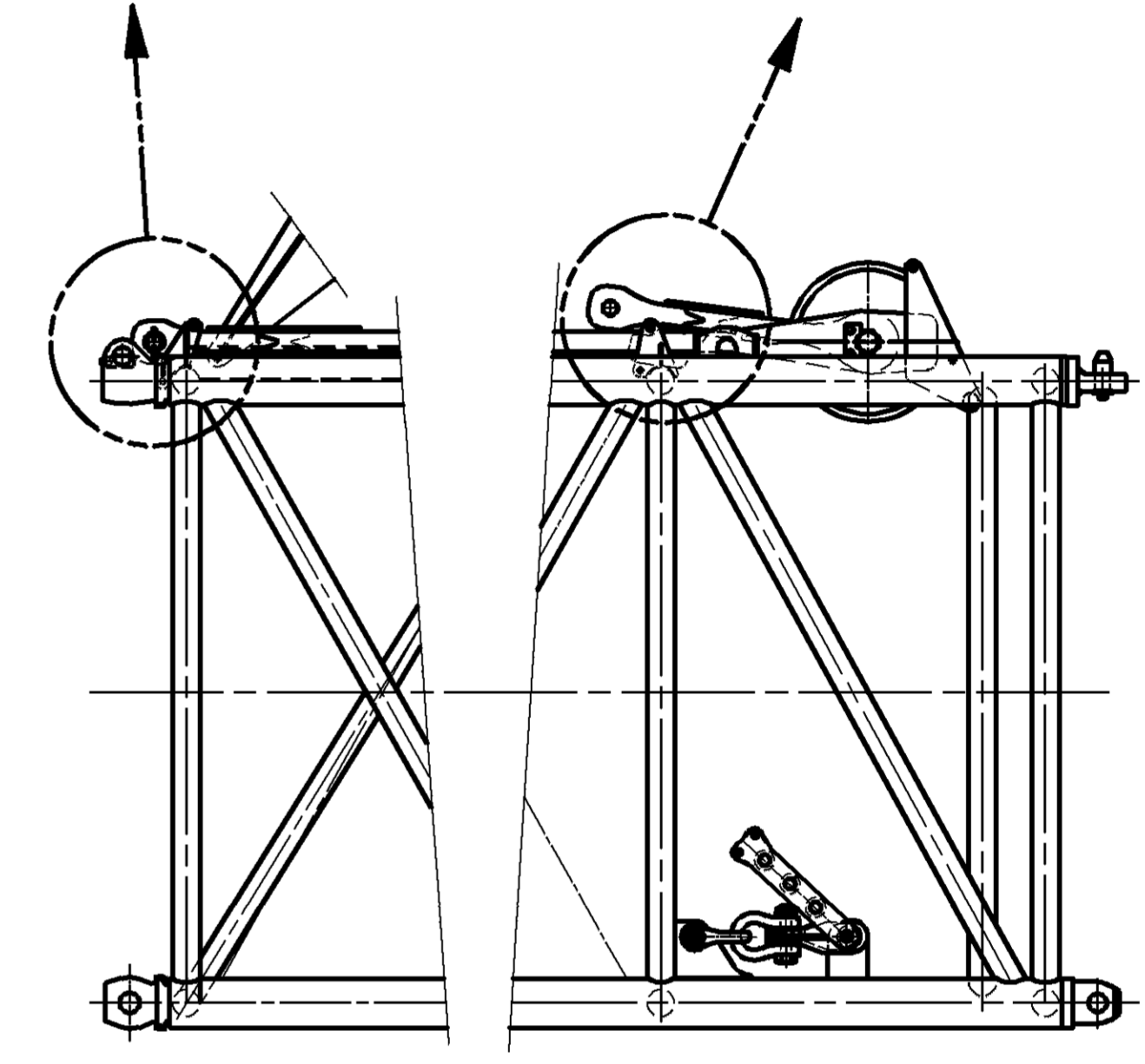
REFERENCE: SEE 194363  
**BOOM HOIST REEVING DIAGRAM FOR 10 PART LINE**  
 2600 FEET OF 1.125" PYTHON 1960 GRADE, RIGHT HAND REGULAR LAY (719416) - B.S. 176,800 LBS. (80,195 kg)  
 OR  
 ALTERNATE WIRE ROPE  
 2600 FEET OF 1.125" BRIDON, DYFORM 34LR, 1960 GRADE (719375) - B.S. 154,900 LBS. (70,261 kg)



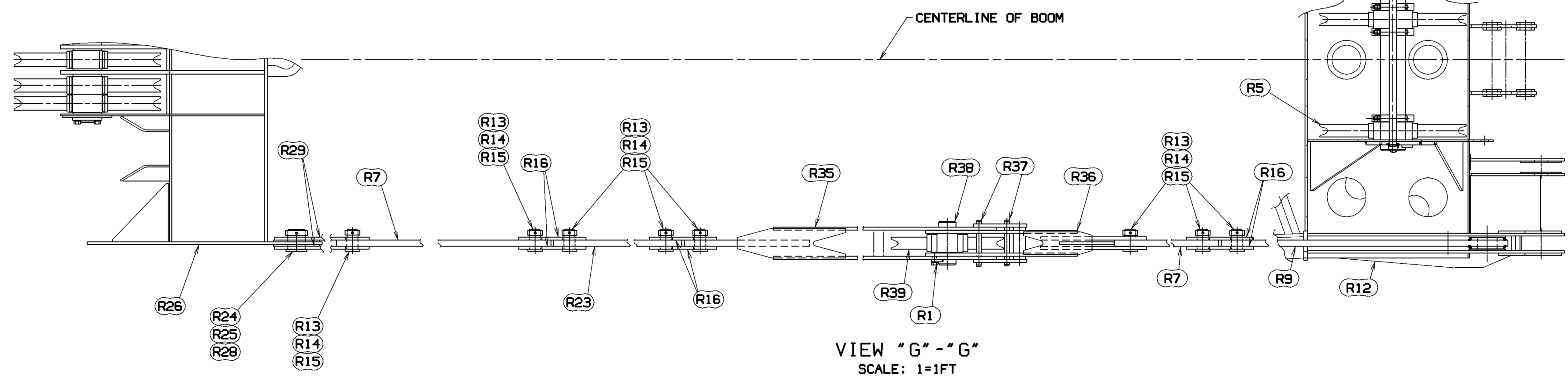
SECTION H-H  
 SCALE: 1.50=1FT



PENDANT STRAP STOWAGE  
 (TYP ON 20 OR 40 FT INSERTS  
 #44 OF #79 BOOM)

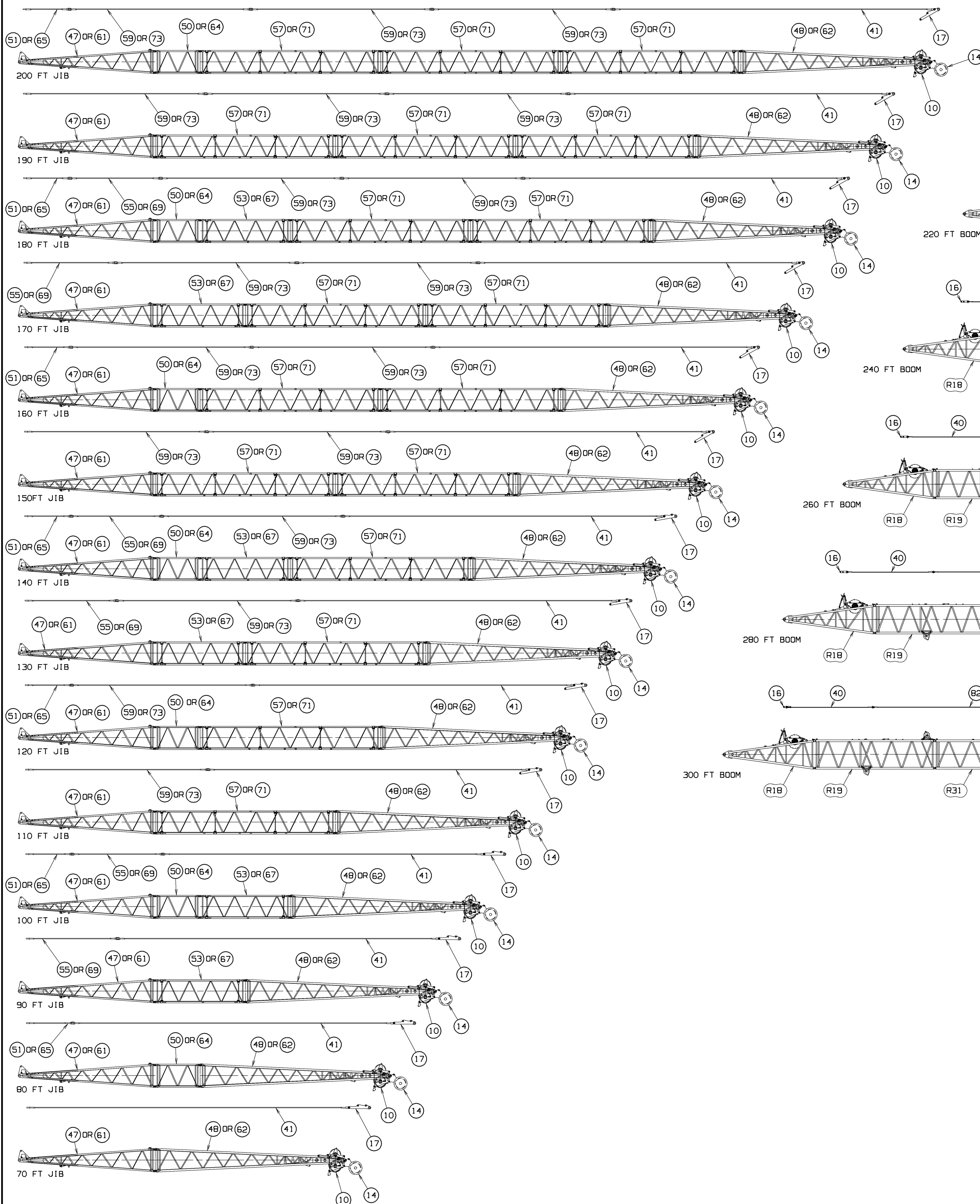


PENDANT STRAP STOWAGE  
 (15 FT #79/#44 INSERT)

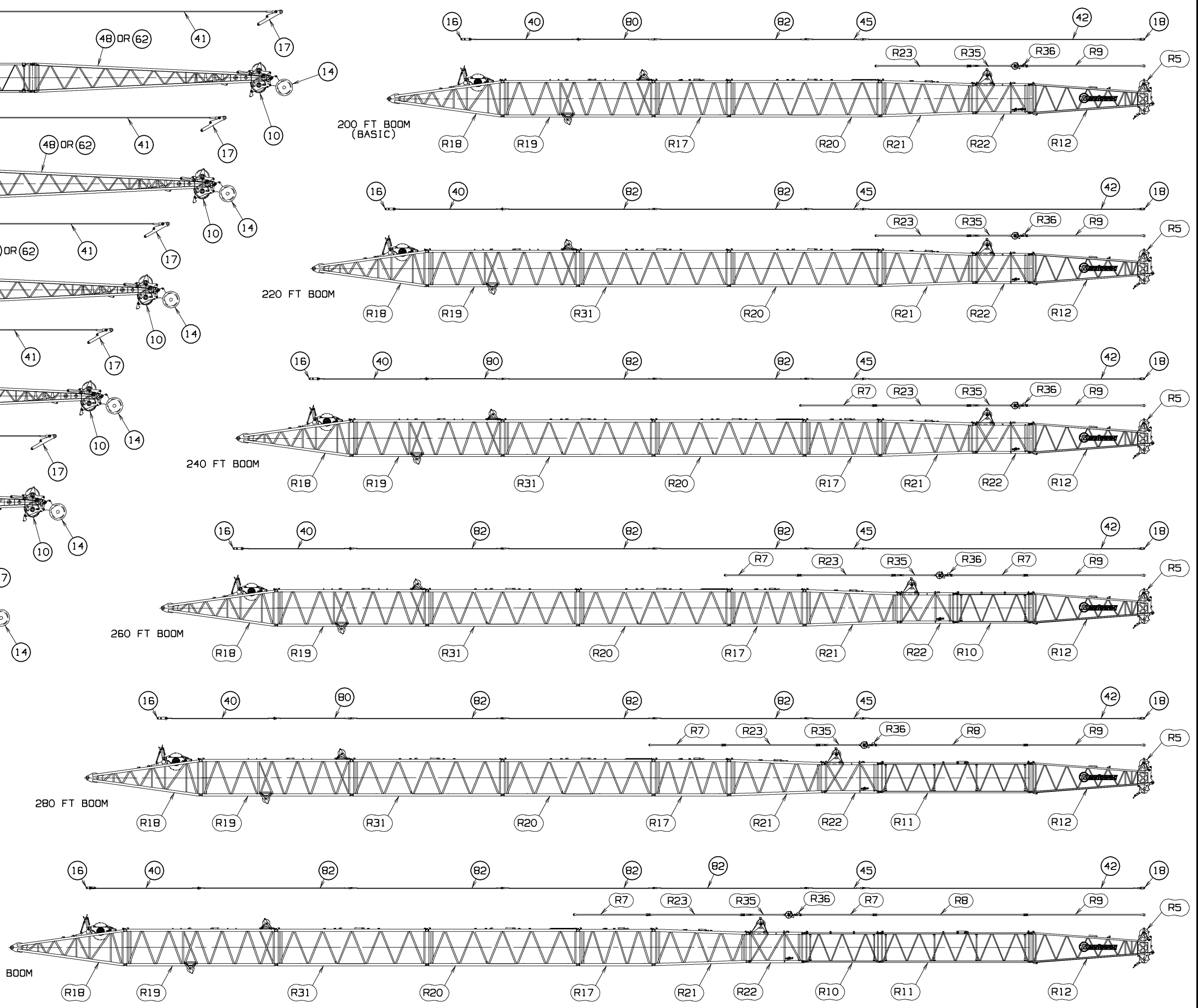


VIEW "G"-"G"  
 SCALE: 1=1FT

THIS PRINT REMAINS THE PROPERTY OF MANITOWOC CRANES, INC. ALL INFORMATION CONTAINED THEREIN IS CONFIDENTIAL. IT IS LOANED, SUBJECT TO RETURN UPON DEMAND, AND ON EXPRESS CONDITION THAT IT IS NOT TO BE COPIED OR USED DIRECTLY OR INDIRECTLY IN ANY MANNER WHATSOEVER DETRIMENTAL TO OUR INTERESTS.	TOLERANCE UNLESS OTHERWISE SPECIFIED			DATE 10-20-00 PATTERN NO. 195517 195517	<b>Manitowoc Cranes, Inc.</b> Manitowoc, Wisconsin MODEL 2250 MAXER 2000 WITH #133 OR #133A JIB	<b>LUFFING JIB RIGGING ASSEMBLY</b> #79/#44 BOOM COMBO
	DECIMAL PLACES	FABRICATION	MACHINING			
	(1) PLACE 0.0	≤ 10 FEET > 10 FEET	±.030			
	(2) PLACE 0.00	±.080 ±.120	±.015 ±.025			
(3) PLACE 0.000	±1°30'	±0°30'	DATE: 10-20-00	DATE: 10-20-00	DATE: 10-20-00	



LUFFING JIB ASSEMBLY



BOOM ASSEMBLY

THIS PRINT BEING THE PROPERTY OF MANITOWOC CRANES, INC. ALL INFORMATION CONTAINED THEREIN IS CONFIDENTIAL. IT IS LOANED, SUBJECT TO RETURN UPON DEMAND, AND ON EXPRESS CONDITION THAT IT IS NOT TO BE COPIED OR USED DIRECTLY OR INDIRECTLY IN ANY MANNER DETRIMENTAL TO OUR INTERESTS.	TOLERANCE UNLESS OTHERWISE SPECIFIED		DATE 10-20-00	SCALE 10'-0" FT	MODEL 2250 MAXER 2000	MANITOWOC CRANES, INC. Manitowoc, Wisconsin	LUFFING JIB RIGGING ASSEMBLY #79/#44 BOOM COMBO WITH #133 OR #133A JIB	
	DECIMAL PLACES	FABRICATION						MACHINING
	(1) PLACE 0.0 ±.12 ±.18 ±.03 (2) PLACE 0.00 ±.06 ±.12 ±.015 (3) PLACE 0.000 ±.003 ±.005 ANGLES 1:20	1:20						1:20