

Guide Block & Fail-Safe Installation

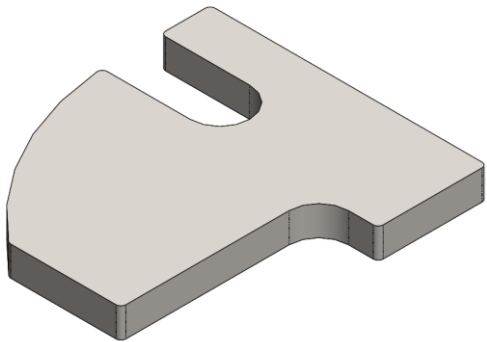
Post With Angle Design

Components Included

Fasteners Required

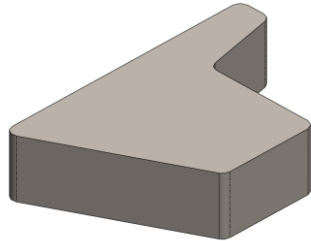
- #128044 (12) 1/4"-20 x 1/2" Long, Socket Head Screw
- #127866 (7) 3/8"-24 x 1/2" Long, Socket Head Screw
- #128039 (1) 3/8"-24 x 3/4" Long, Low-Profile Socket Head Screw

Steel Plates



#128486 (2) Lift Side

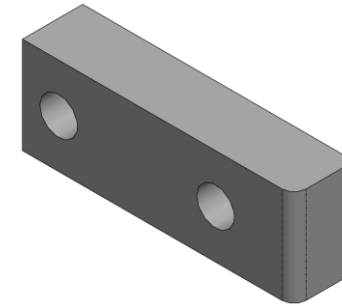
#128089 (2) Support Side



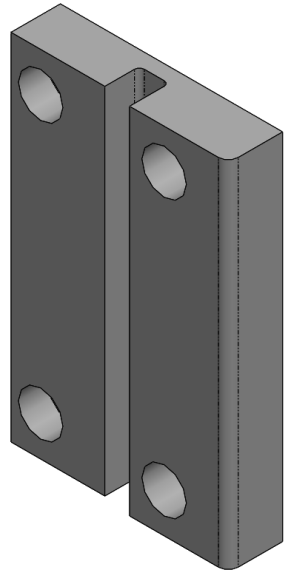
#128016 (1) Drilling Template



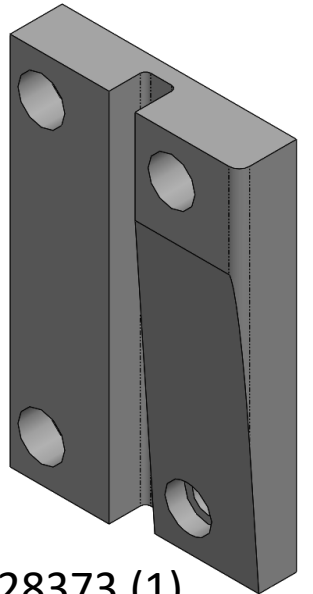
NSM Guide Blocks



#127952 (6)
"Universal"



#128372 (1)
Front Lift Side



#128373 (1)
Rear Lift Side

Instructions

1. Remove all guide blocks & safety cover plates from the lift cross-beams.
2. Examine the front lift side guide blocks. If the guide blocks match *Figure 1* below with the holes close to each other, **proceed to the next step**. If the guide blocks match *Figure 2* below with the holes spaced further apart, **contact ATC for assistance**.

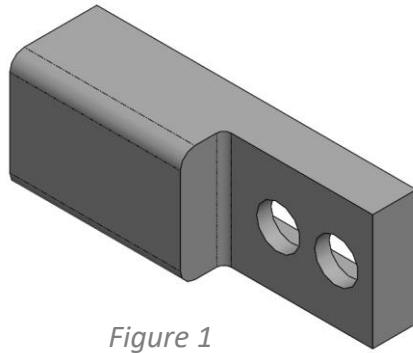


Figure 1

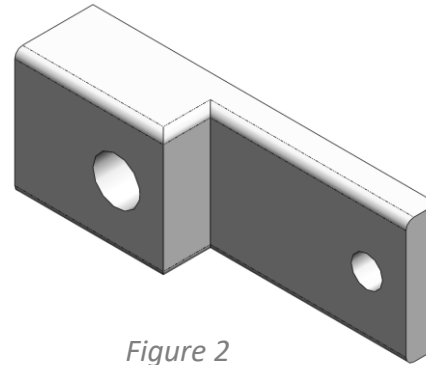


Figure 2

3. Drill a 1" hole to create an access holes through the front lift side post channel and angle & the rear lift side post channel and angle approximately 16" from the floor and 1" from the front face of the angle as shown in *Figure 3*.
4. Repeat step 3 on the backside of the front lift side post channel & rear lift side post channel side without the angle. The hole should 3/4" from the front face of the channel as shown in *Figure 3*.
5. Drill a 1" hole to create an access holes through both sides of the front support side post channel & the rear support side post channel approximately 16" from the floor and 3/4" from the front face of the channel as shown in *Figure 4*.

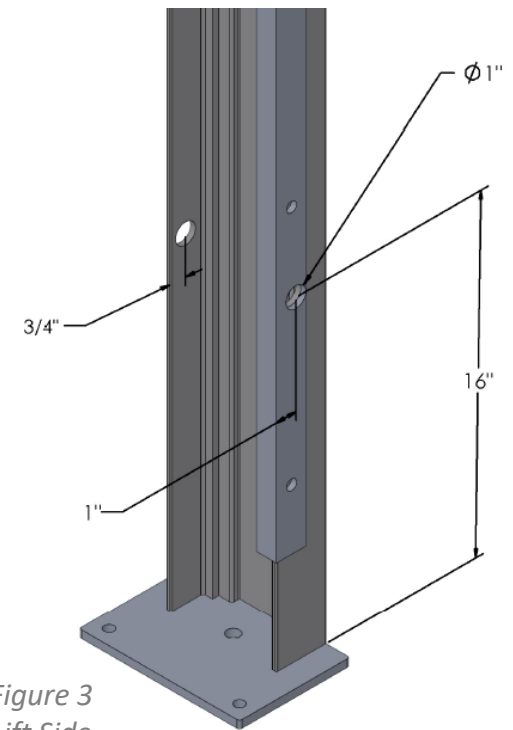


Figure 3
Lift Side

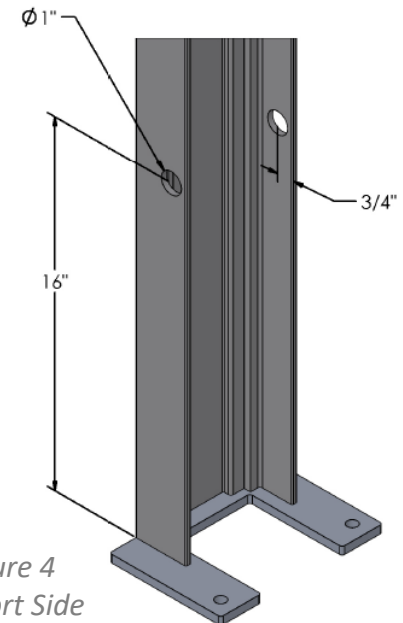


Figure 4
Support Side

6. Fasten the drilling template to the front plate of the front lift side cross-beam as shown in *Figure 5* using the (2) $\frac{1}{4}$ " tapped holes furthest away from the post.
7. Lift or lower the platform so that one of the holes in the drilling template is visible through the access hole in the post.
8. Use a #7 drill bit to drill through the cross-beam plate using the template as a guide.
9. Lift or lower the platform so that the other hole in the drilling template is visible through the access hole in the post.
10. Use a #7 drill bit to drill through the cross-beam plate using the template as a guide.
11. Repeat steps 6-10 on the rear plate of the front lift side cross-beam, the front plate of the rear lift side cross-beam, and the rear plate of the rear lift side cross-beam.
12. Fasten the drilling template to the front plate of the front support side cross-beam as shown in *Figure 6* using the (2) $\frac{1}{4}$ " tapped holes furthest away from the post.
13. Lift or lower the platform so that the top hole in the drilling template is visible through the access hole in the post.
14. Use a #7 drill bit to drill through the cross-beam plate using the template as a guide.
15. Repeat steps 12-14 for the front plate of the rear support side cross-beam.
16. Fasten the drilling template to the rear plate of the front support side cross-beam as shown in *Figure 7* using the (2) $\frac{1}{4}$ " tapped holes furthest away from the post.
17. Lift or lower the platform so that the bottom hole in the drilling template is visible through the access hole in the post.
18. Use a #7 drill bit to drill through the cross-beam plate using the template as a guide.
19. Repeat steps 16-18 for the rear plate of the rear support side cross-beam.

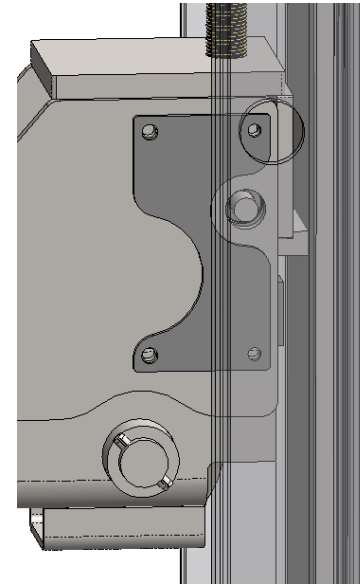


Figure 5
Lift Side

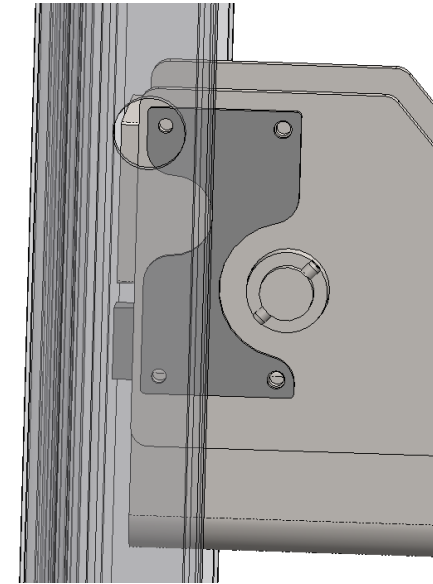


Figure 6
Support Side Front Plate

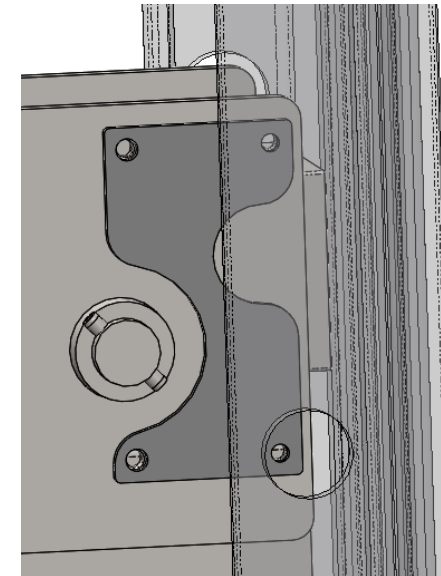


Figure 7
Support Side
Rear Plate

20. Lift or lower the platform so that the top hole on the front plate of the front support side cross-beam is exposed as show in *Figure 8*.
21. Use a ¼"-20 tap to tap the top hole inside the post.
22. Repeat steps 20-21 for the front plate of the rear support side cross-beam
23. Lift or lower the platform so that the bottom hole on the rear plate of the front support side cross-beam is exposed as show in *Figure 9*.
24. Use a ¼"-20 tap to tap the bottom hole inside the post.
25. Repeat steps 23-24 for the rear plate of the rear support side cross-beam
26. Lift or lower the platform so that the bottom hole on the rear plate of the front lift side cross-beam is exposed as show in *Figure 10*.
27. Use a ¼"-20 tap to tap the bottom hole inside the post.
28. Repeat steps 26-27 for the rear plate of the rear lift side cross-beam.

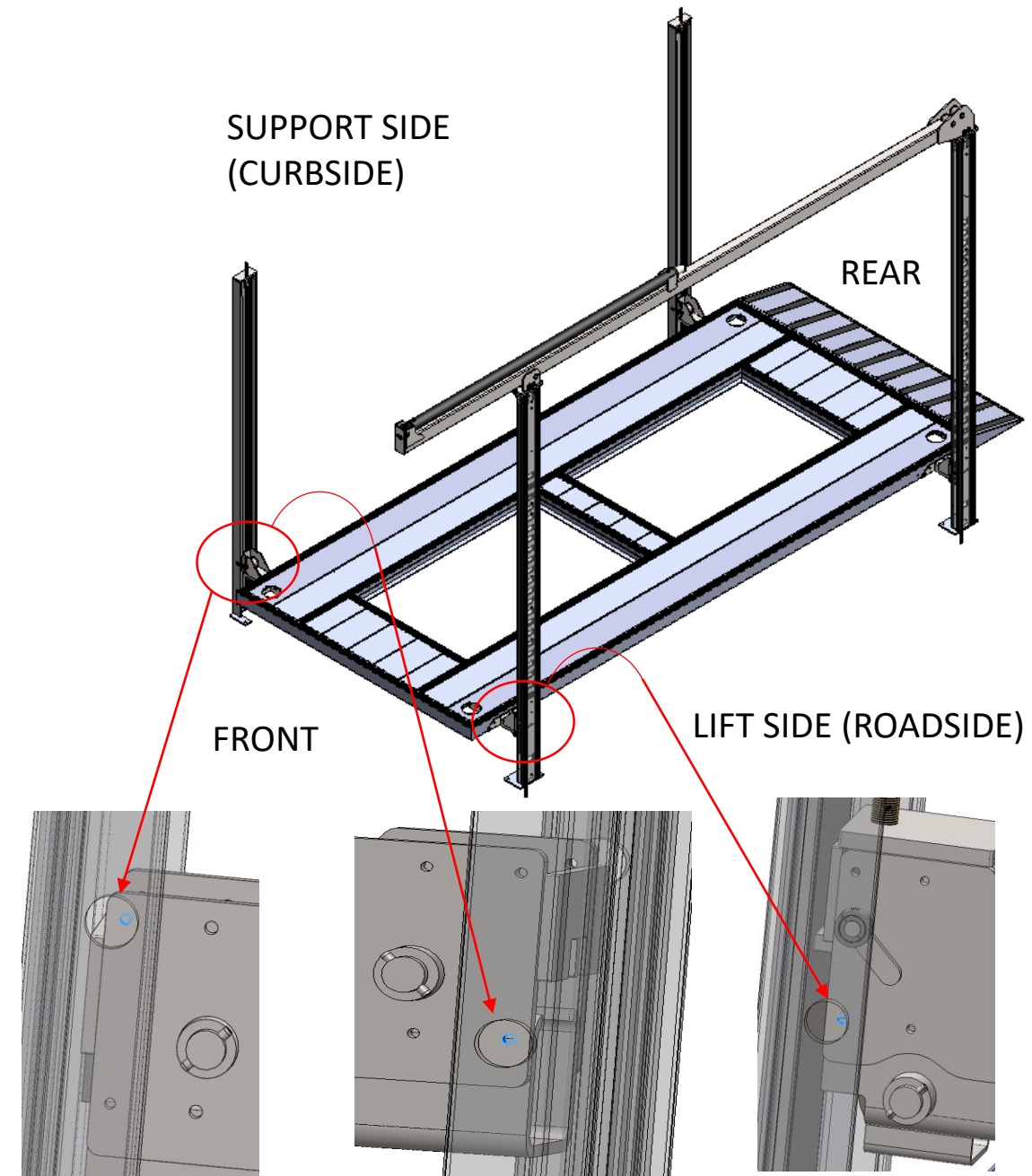


Figure 8
Support Side Front Plate

Figure 9
Support Side Rear Plate

Figure 10
Lift Side Rear Plate

29. Lift or lower the platform so that the bottom hole in the front plate of the front cross-beam is exposed through the post access hole as shown in *Figure 11*.
30. Use a “Q” drill bit to enlarge the diameter of the front side hole shown in *Figure 11*.
 - Then Tap this hole using a 3/8”-24 ***fine thread*** tap.
31. Lower the platform so that the top hole in the front cross-beam is exposed through the post access hole as shown in *Figure 12*.
32. Use a “Q” drill bit to enlarge the diameter of the front side hole shown in *Figure 12*.
 - Then Tap this hole using a 3/8”-24 ***fine thread*** tap.
33. Use a “Q” drill bit to enlarge the diameter of the 2 holes outside the post shown in *Figure 13*.
 - Then Tap these holes using a 3/8”-24 ***fine thread*** tap.
34. Repeat steps 29-33 for the front plate of the rear lift side cross-beam.

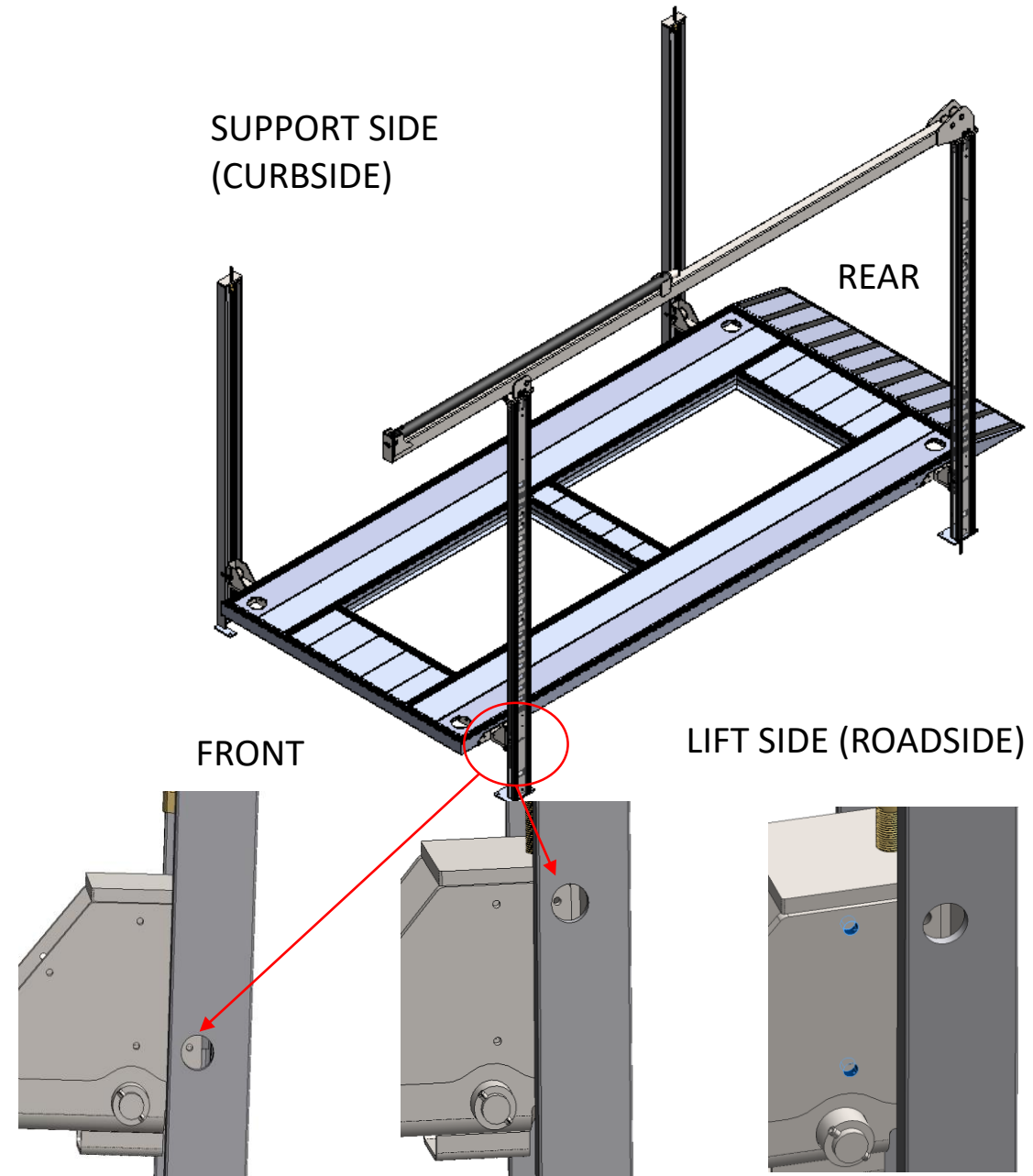
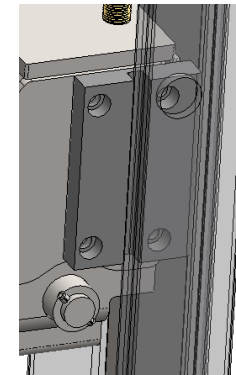


Figure 11

Figure 12

Figure 13

35. Install the new guide blocks provided starting with the Front Lift Side & Rear Lift Side guide blocks as shown in *Figure 13*.
 - Please note that the Rear Lift Side guide block should have a Chamfered face.
 - Use the 3/8"-24 x 3/4" Low-Profile screw for the Rear Lift Side guide block in the bottom hole inside the post with the chamfered face.
 - Use the 3/8"-24 x 1/2" screws in the remaining holes to fasten the blocks to the cross-beam.
36. Install the Universal guide blocks on the **back plates** of the Front Lift Side, Rear Lift Side, Front Support Side, & Rear Support Side into the **bottom** holes as shown in *Figure 14*.
 - Use the 1/4"-20 x 1/2" Screws to fasten the blocks to the cross-beam.
37. Install the remaining Universal guide blocks on the **front plates** of the Front Support Side & Rear Support Side into the **top** holes as shown in *Figure 15*.
 - Use the 1/4"-20 x 1/2" Screws to fasten the blocks to the cross-beam.
38. Verify all fasteners are tightened and the guide blocks sit flush against the cross-beam.



Front

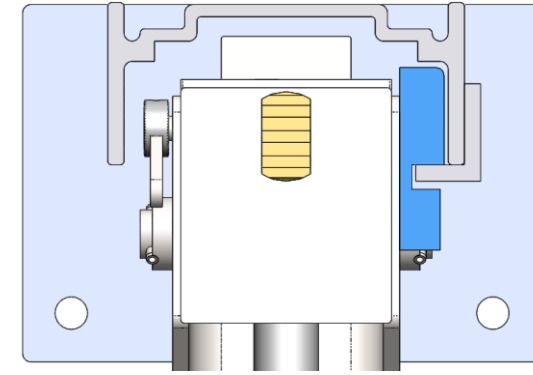
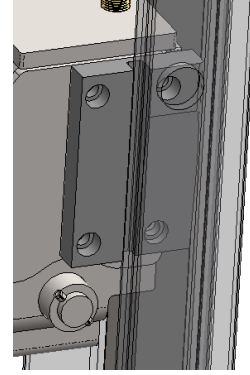
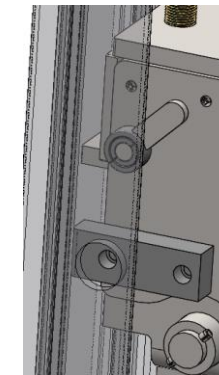


Figure 13



Rear



Back Lift Side

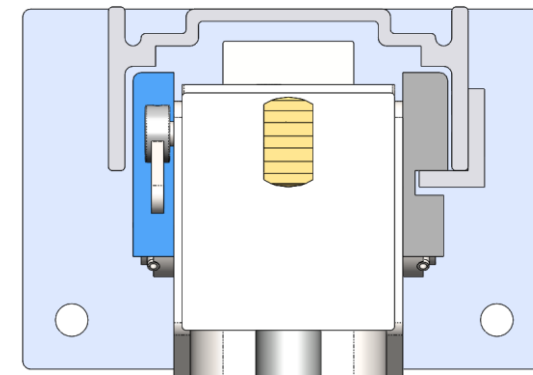
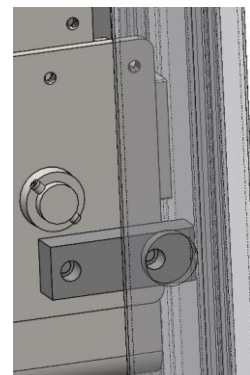


Figure 14



Back Support Side

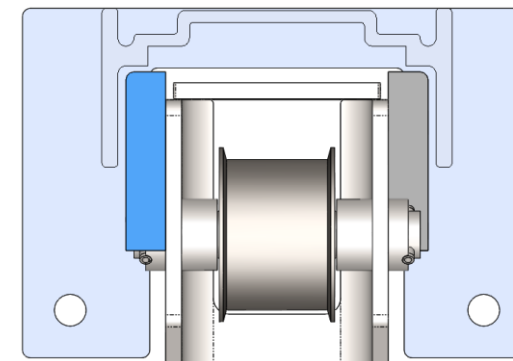
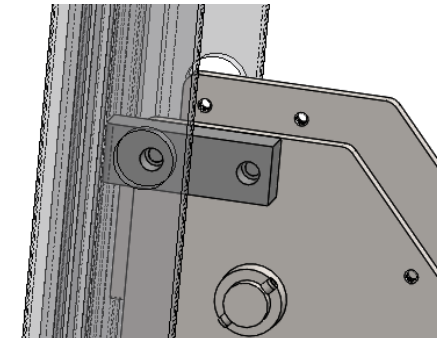


Figure 15



Front Support Side

39. Test fit the support side stop plate on the back plate of the front support side cross-beam as shown in *Figure 16*. The top of the stop plate should be approximately $1 \frac{1}{4}$ " down from the top of the cross-beam plate, and the face parallel with the post channel should be $\frac{3}{16}$ " away from the post as shown in *Figure 17*. Mark the outline of the support side stop plate.
40. Use a Bandfile or an angle grinder to remove the powder coat around the marks from the support side stop plates on the back plate of the front support side cross-beam to prep the surface for welding.
41. **With the platform lowered to the floor**, install the support side stop plates in the same location shown in *Figure 17* by welding the top, around the outside vertical edge, and the bottom of the stop plate.
42. Repeat steps 39-41 for the rear support side cross-beam.

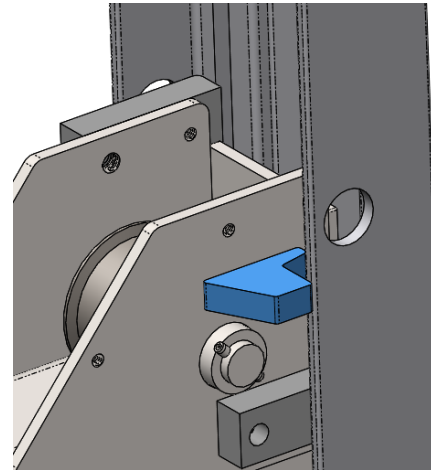


Figure 16

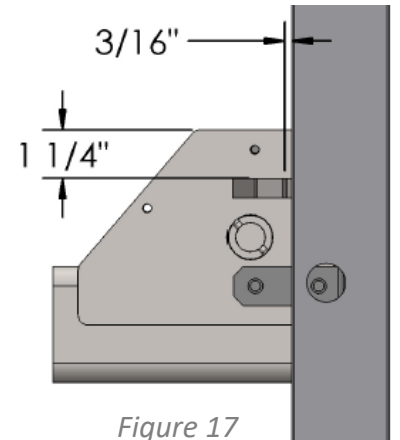


Figure 17

42. Loosen the top chain anchor 5/8" nut on the front lift side cross-beam as shown in *Figure 18*.
43. Test fit the lift side stop plate on the top plate of the front support side cross-beam by tilting the plate up inside the post and then sliding it down with the slot around the anchor as shown in *Figure 19*. Mark the outline of the lift side stop plate around the large radius edge and the slot, then remove the plate.
44. Use a Bandfile or an angle grinder to remove the powder coat from the top face of the top plate around the marks on the front lift side cross-beam to prep the surface for welding.
45. Re-install the lift side stop plate on the front lift side cross-beam. Place the stop plate so that the edges highlighted in *Figure 19* are flush with the existing top plate.
46. Verify that the edges of the lift side stop plate do not extend past the guide block as shown in *Figure 20*, so that the block always contacts the post before the plate. Then tighten the 5/8" nut on top of the stop plate.
47. With the lift side stop plate in position, weld around the highlighted edges shown in *Figure 21*.
48. Repeat steps 42-47 for the rear lift side cross-beam.
49. Clean the steel stop plates and around the welded surfaces. Finish by painting the steel stop plates and touch up other surfaces as needed.

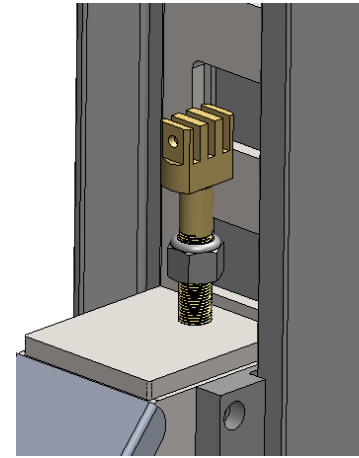


Figure 18

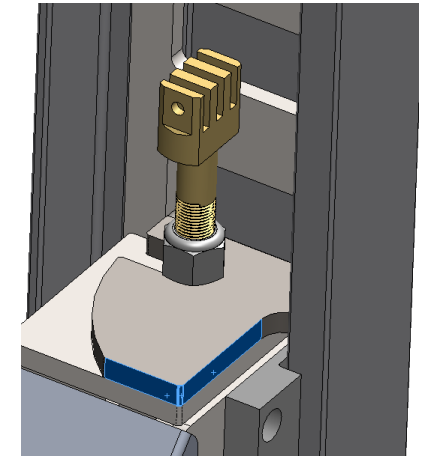


Figure 19

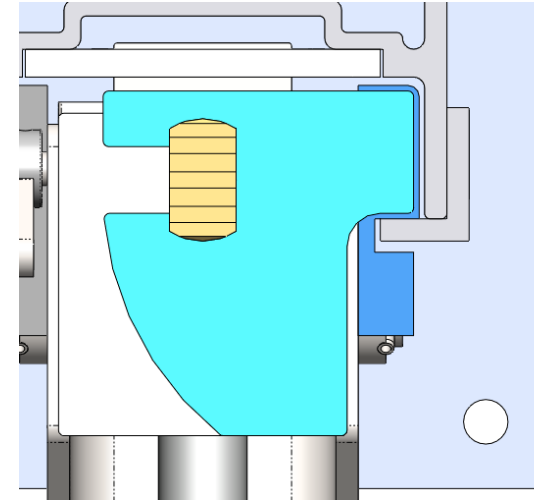


Figure 20

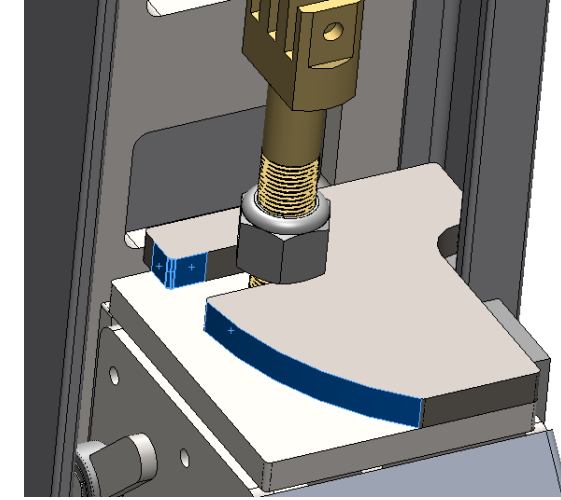


Figure 21