



TRUCK MOUNTED CRANES

HT25KX

HLAAB-00**

INSTALLATION & OWNER'S MANUAL

Sold and Serviced by:

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HT25KX / Std Ctrl / No Eng Ctrls (HLAAAB-00**)

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MFG., INC.
CINCINNATI, OHIO

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4-26-06F

SUPERCEDES
4-14-06E

SECTION
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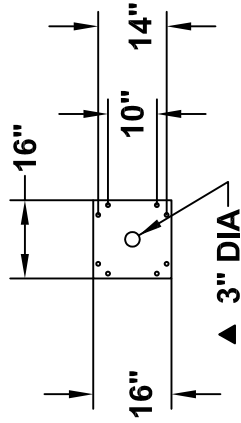
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SECTION 100

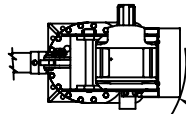
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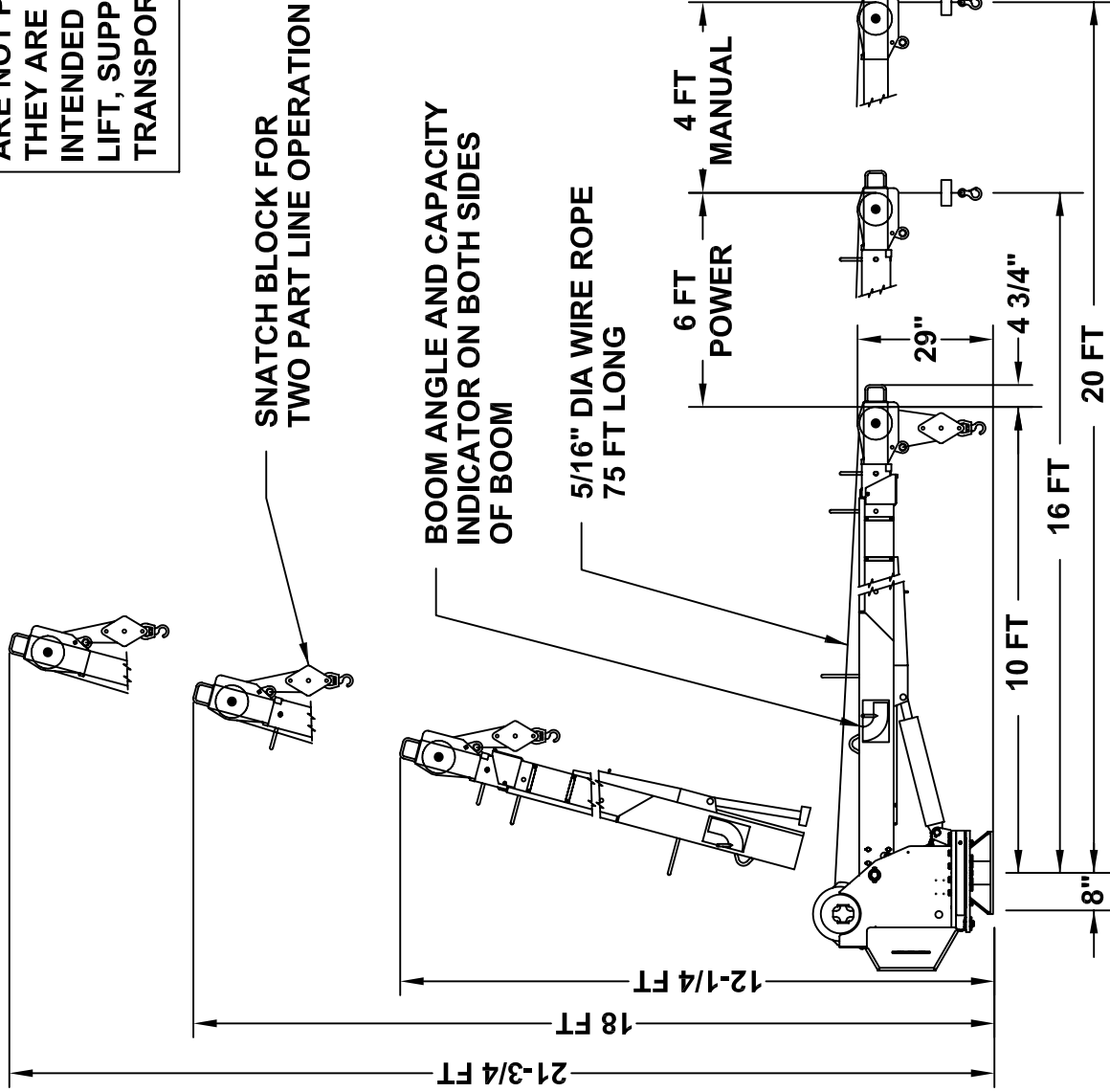
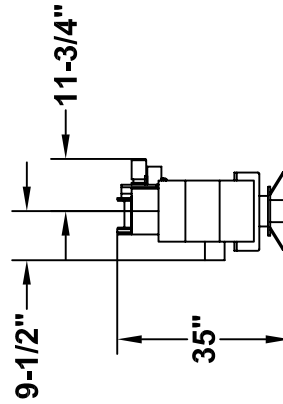
SPECIFICATIONS



BASE MOUNTING DIMENSIONS



R20-1/4" SWING RADIUS



TOTAL INSTALLED WEIGHT 1350 lbs.

WARNING: THESE PRODUCTS ARE NOT PASSENGER LIFTS. THEY ARE NOT DESIGNED OR INTENDED TO BE USED TO LIFT, SUPPORT, OR OTHERWISE TRANSPORT PERSONNEL.



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TITLE
INSTALLATION DRAWING

HT25KX - 10/16/20 BOOM

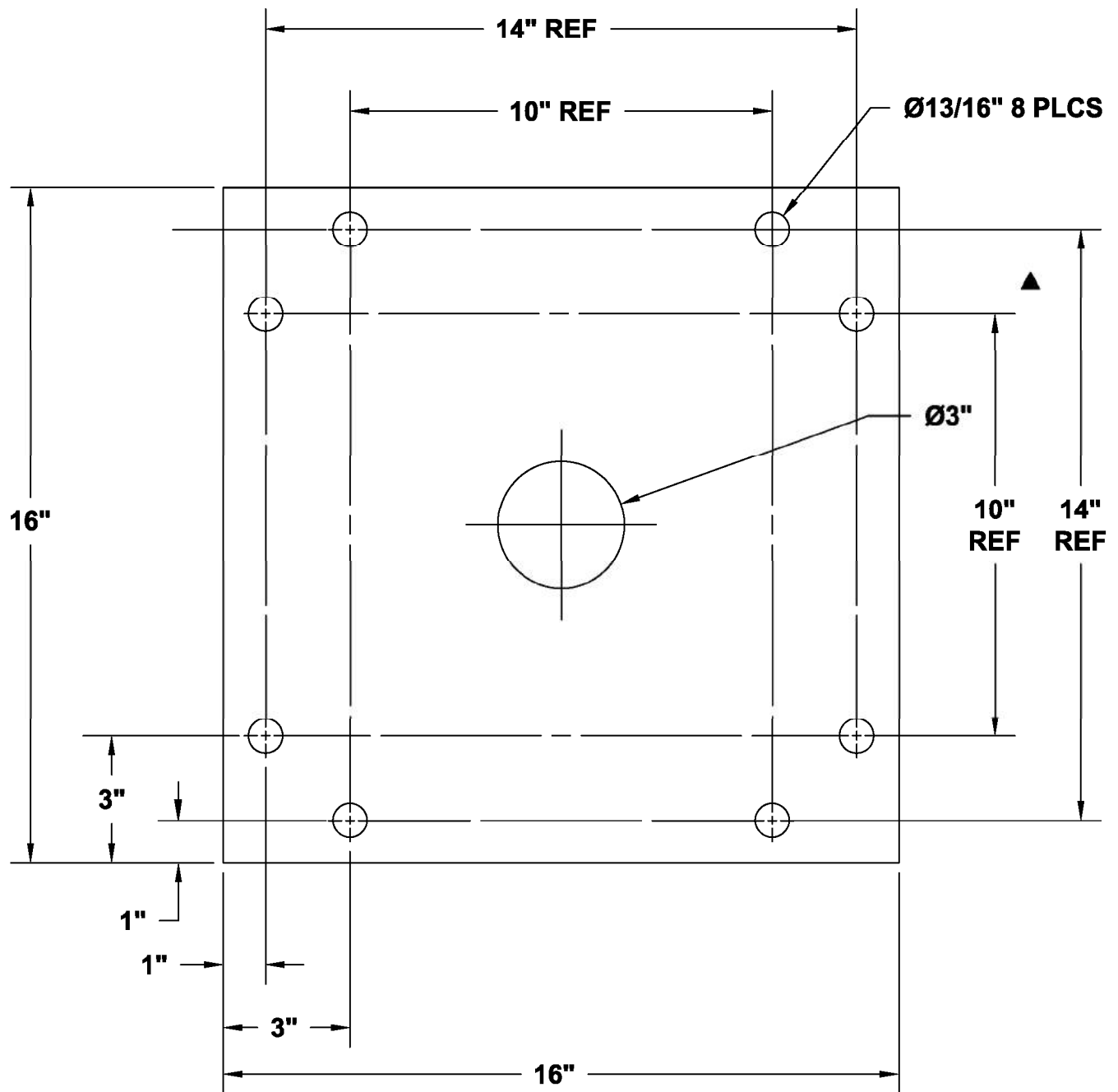
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5-20-03B

SUPERSEDES
7-22-02A

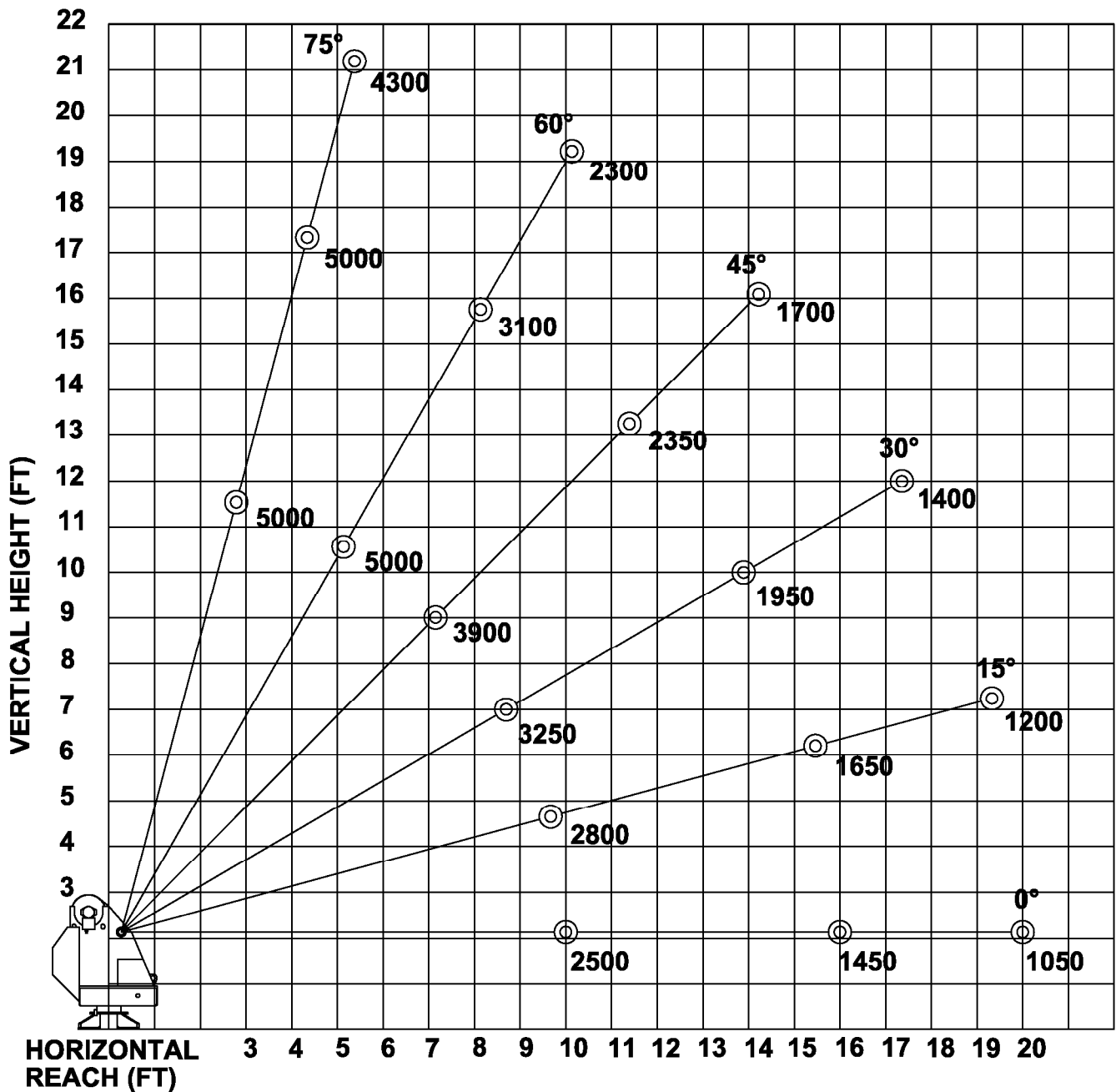
SECTION
C100

19801

▲ ET/HT18K(X) & ET/HT25K(X) BASE MOUNTING DIMENSION



ET/HT25K(X) - 10-16-20 BOOM MAXIMUM CAPACITY CHART



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TITLE
CAPACITY CHART

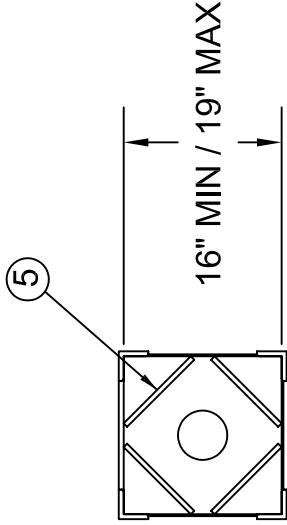
ET/HT25K(X) - 10-16-20

DATE
10-16-97A

SUPERSEDES
8-17-96

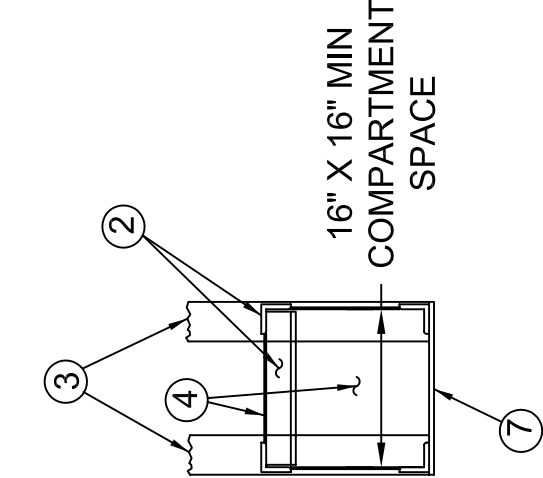
SECTION
C100

I19233

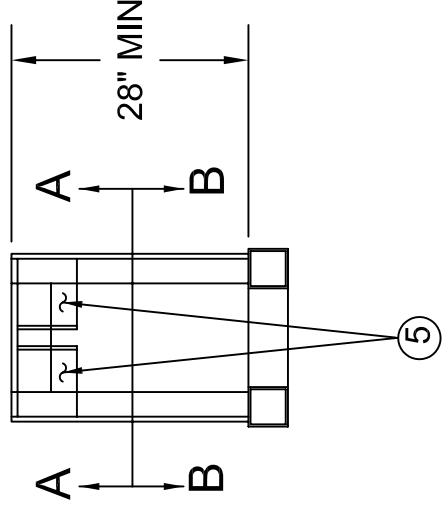
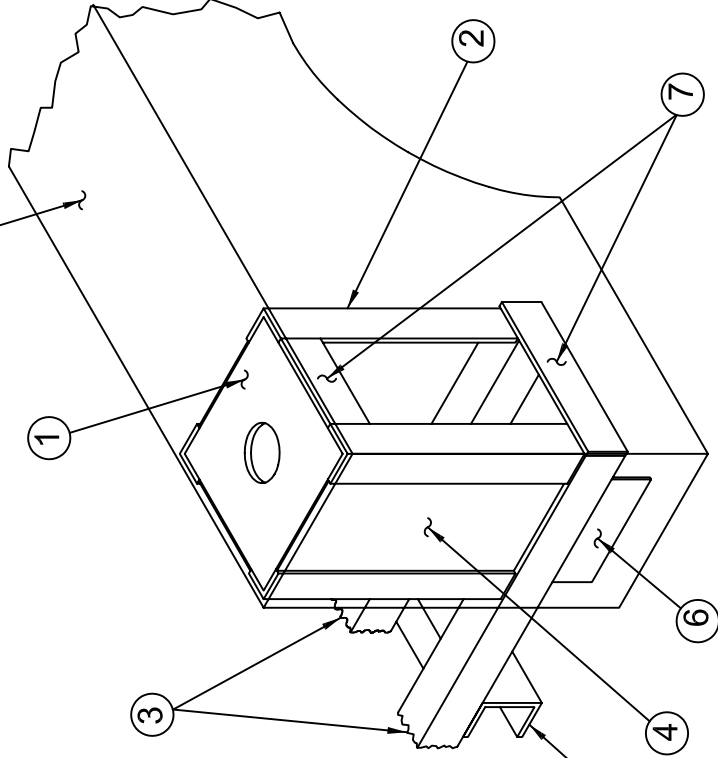


SECTION A-A

IT IS THE SOLE RESPONSIBILITY OF THE INSTALLER TO INSURE THAT THE TOTAL STRUCTURE OF CRANE, TRUCK, AND OUTRIGGERS ARE STRUCTURALLY SOUND AND THAT THE COMPLETED VEHICLE HAS SUFFICIENT STABILITY AGAINST OVERTURNING.



SECTION B-B



TYPICAL SERVICE BODY REINFORCEMENT

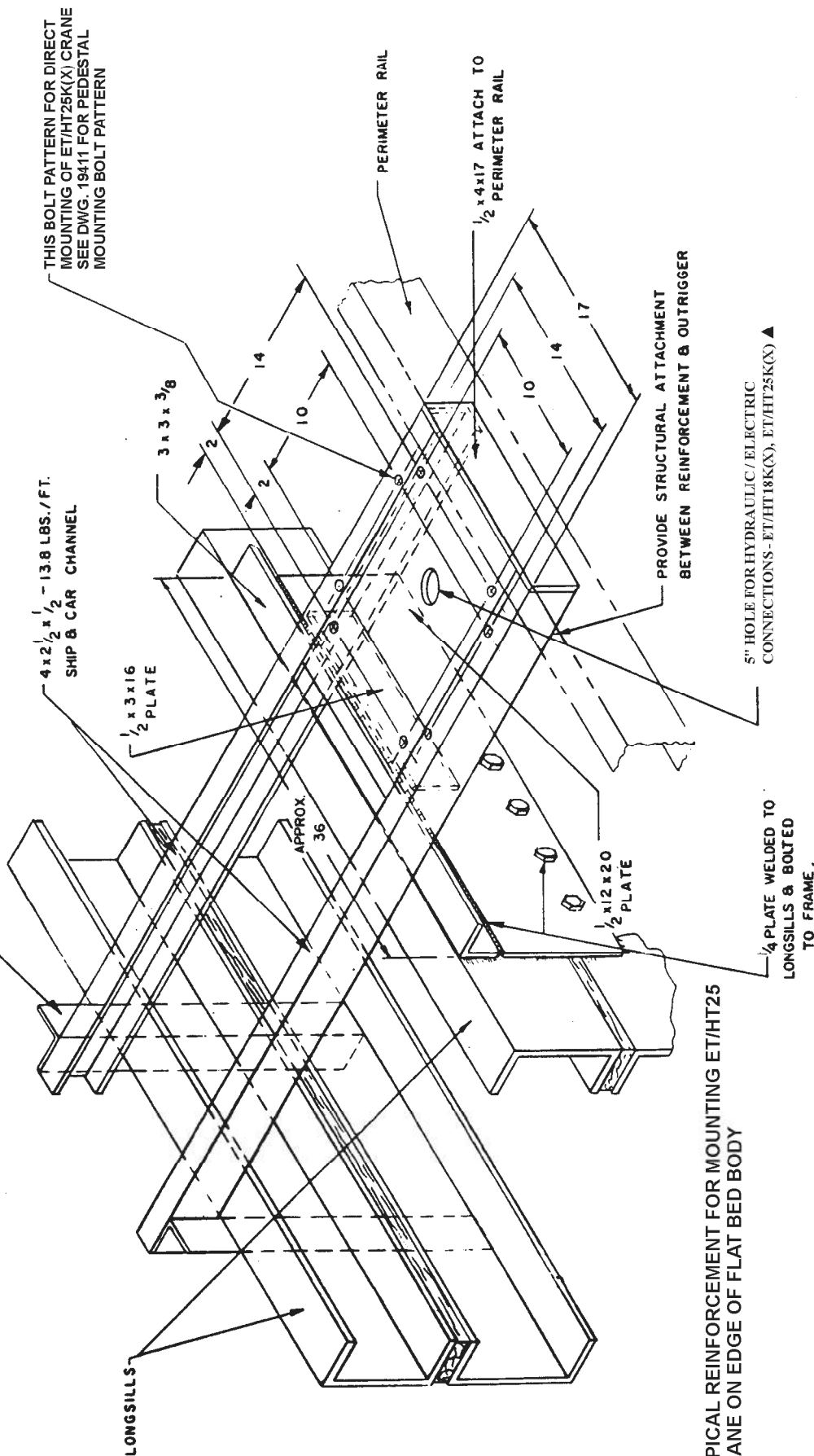
PART	DESCRIPTION	MINIMUM RECOMMENDED MATERIAL SIZE
1	TOP PLATE	1/2" STEEL ▲
2	CORNER POST	3" x 3" x 1/2" STEEL ANGLE
3	CROSS FRAME	4" x 4" x 5/16" SQUARE TUBING - SPAN FULL WIDTH
4	SHEAR WEB	3/16" STEEL PLATE
5	TOP PLATE REINFORCEMENT	1/2" x 6" OR 3/4" x 5" STEEL BAR
6	OUTRIGGER REINFORCEMENT PLATE	1/4" THICK STEEL PLATE
7	GUSSET	1/2" x 4" H.R. STEEL
8	BODY TOP REINFORCEMENT	10 GA SMOOTH OR DIAMOND PLATE WITH 1" LIP OVER SIDE OF BODY

 MANUFACTURING, INC. CINCINNATI, OHIO	TITLE	DATE	SECTION
	INSTALLATION DWG	12-20-10G	C100
ET/HT25K(X) & ET/HT18K(X)		SUPERSEDES	19288
		4-25-08F	

IT IS THE SOLE RESPONSIBILITY OF THE INSTALLER TO INSURE THAT THE TOTAL STRUCTURE OF CRANE, TRUCK, AND OUTRIGGERS ARE STRUCTURALLY SOUND AND THAT THE COMPLETED VEHICLE HAS SUFFICIENT STABILITY AGAINST OVERTURNING.

ANGLES BOLTED INTO
FRAME & LONGSILLS
2 PLACES

$3 \times 3 \times \frac{3}{8}$



TYPICAL REINFORCEMENT FOR MOUNTING ET/HT25
CRANE ON EDGE OF FLAT BED BODY

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VENTURO

TITLE
INSTALLATION DRAWING

DATE
7-29-03M

SECTION

C100

ET/HT18K(X), ET/HT25K(X) ▲

SUPERCEDES
10-11-02L

14510

SECTION 150

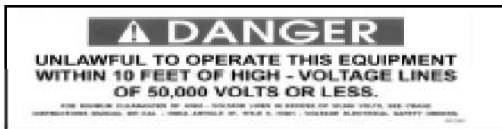
SAFETY

VEHICLE & CRANE MOUNTED ELECTRICAL HAZARD SIGN APPLICATION & INFORMATION

ET & HT CRANE SERIES



▲ SIGN NO. 15393A DISPLAYS THE INTERNATIONAL SYMBOL FOR ELECTRICITY AND WARNS OF DANGER FROM AN ELECTRICALLY CHARGED VEHICLE, CRANE, OR LOAD. FOUR ARE RECOMMENDED (ONE FOR EACH SIDE AND ONE FOR EACH END OF VEHICLE) TO BE APPLIED IN LOCATIONS WHICH ARE READILY VISIBLE TO GROUND PERSONNEL.



▲ SIGN NO. 15401 PROVIDES ADDITIONAL WARNING OF LEGAL REQUIREMENTS WHEN OPERATING NEAR HIGH VOLTAGE LINES. THIS SIGN IS PLACED ON THE CONTROL PENDANT SIDE OF BOOM.

REQUIRED MINIMUM CLEARANCES REFERRED TO ON SIGN NO. 15401

REQUIRED CLEARANCES FROM OVERHEAD HIGH-VOLTAGE LINES

NOMINAL VOLTAGE (kV) (PHASE TO PHASE)	MINIMUM REQUIRED CLEARANCE (FEET) *
0 - 50	10
over 50 - 200	15
over 200 - 350	20
over 350 - 500	25
over 500 - 750	35
over 750 - 1000	45

REQUIRED CLEARANCES FROM ENERGIZED HIGH-VOLTAGE CONDUCTORS (WHILE IN TRANSIT)

NOMINAL VOLTAGE (kV) (PHASE TO PHASE)	MINIMUM REQUIRED CLEARANCE (FEET) *
0 - 0.75	4
over 0.75 - 50	6
over 50 - 345	10
over 345 - 750	16
over 750 - 1000	20

* NOTE: ENVIRONMENTAL CONDITIONS SUCH AS FOG, SMOKE, OR PRECIPITATION MAY REQUIRE INCREASED CLEARANCES



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TITLE
INSTALLATION DWG

ET & HT CRANE SERIES

DATE
5-15-02H

SUPERCEDES
5-13-97G

SECTION
C150

15394

CRANE SAFETY AND HAZARDS

HT25KX, HT40KX, HT50KX

CAUTIONS

1. INSPECT VEHICLE AND CRANE, INCLUDING OPERATION, PRIOR TO USE DAILY.
2. DO NOT USE THIS EQUIPMENT EXCEPT ON SOLID, LEVEL SURFACE WITH CRANE MOUNTED ON FACTORY-RECOMMENDED TRUCK.
3. BEFORE OPERATING THE CRANE, REFER TO MAXIMUM LOAD (CAPACITY) CHART ON CRANE FOR OPERATING (LOAD) LIMITATIONS.
4. DO NOT OPERATE, WALK, OR STAND BENEATH BOOM OR A SUSPENDED LOAD.
5. ATTACH PENDANT CORD SUPPORT SNAP TO ATTACHMENT POINT BEFORE PLUGGING IN PENDANT.
6. UNPLUG PENDANT AND DISENGAGE PTO SYSTEM WHEN CRANE NOT IN USE.
7. FOR TRAVEL, BOOM MUST BE IN STOWED POSITION.

DANGER

- THIS CRANE IS NOT A PASSENGER LIFT
- IT IS NOT DESIGNED OR INTENDED TO BE USED TO LIFT, SUPPORT, OR OTHERWISE TRANSPORT PERSONNEL.

YOU MUST NOT OPERATE THIS CRANE UNLESS

1. YOU HAVE BEEN TRAINED IN THE SAFE OPERATION OF THIS CRANE
AND
2. YOU KNOW AND FOLLOW THE SAFETY AND OPERATING RECOMMENDATIONS CONTAINED IN THE MANUFACTURER'S MANUALS, YOUR EMPLOYER'S WORK RULES, AND APPLICABLE GOVERNMENT REGULATIONS. AN UNTRAINED OPERATOR SUBJECTS HIMSELF AND OTHERS TO DEATH OR SERIOUS INJURY.

ELECTROCUTION HAZARD

- THIS MACHINE IS NOT INSULATED.
- MAINTAIN SAFE CLEARANCES FROM ELECTRICAL LINES AND APPARATUS.
- YOU MUST ALLOW FOR BOOM SWAY, ROCK OR SAG, AND ELECTRICAL LINE AND LOADLINE SWAYING.
- THIS LIFTING DEVICE DOES NOT PROVIDE PROTECTION FROM CONTACT WITH OR PROXIMITY TO AN ELECTRICALLY CHARGED CONDUCTOR.
- YOU MUST MAINTAIN A CLEARANCE OF AT LEAST 10 FEET BETWEEN ANY PART OF THE CRANE, LOADLINE, OR LOAD, AND ANY ELECTRICAL LINE OR APPARATUS CARRYING UP TO 50,000 VOLTS. ADDITIONAL CLEARANCE IS REQUIRED FOR VOLTAGES IN EXCESS OF 50,000 VOLTS. REFER TO DRAWING 15394 FOR ADDITIONAL INFORMATION.
- **DEATH OR SERIOUS INJURY** WILL RESULT FROM CONTACT OR INADEQUATE CLEARANCE.



MFG., INC.
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TITLE

INSTALLATION DWG

DATE

5-13-97A

SECTION

C150

HYDRAULIC CRANES

SUPERCEDES

6-12-92

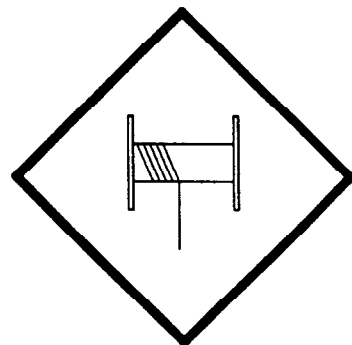
920612

WINCH SAFETY WARNINGS



DANGER

**DO NOT DISENGAGE
WINCH UNDER LOAD**



DANGER

**THE LAST FIVE
WRAPS OF WIRE ROPE
MUST BE LEFT ON
THE DRUM TO ASSIST
THE WIRE ROPE CLAMP IN
HOLDING THE LOAD**



WARNING

**WINCHES ARE NOT
TO BE USED FOR
THE LIFTING OR
MOVING OF
PERSONS**



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**TITLE
INSTALLATION DWG**

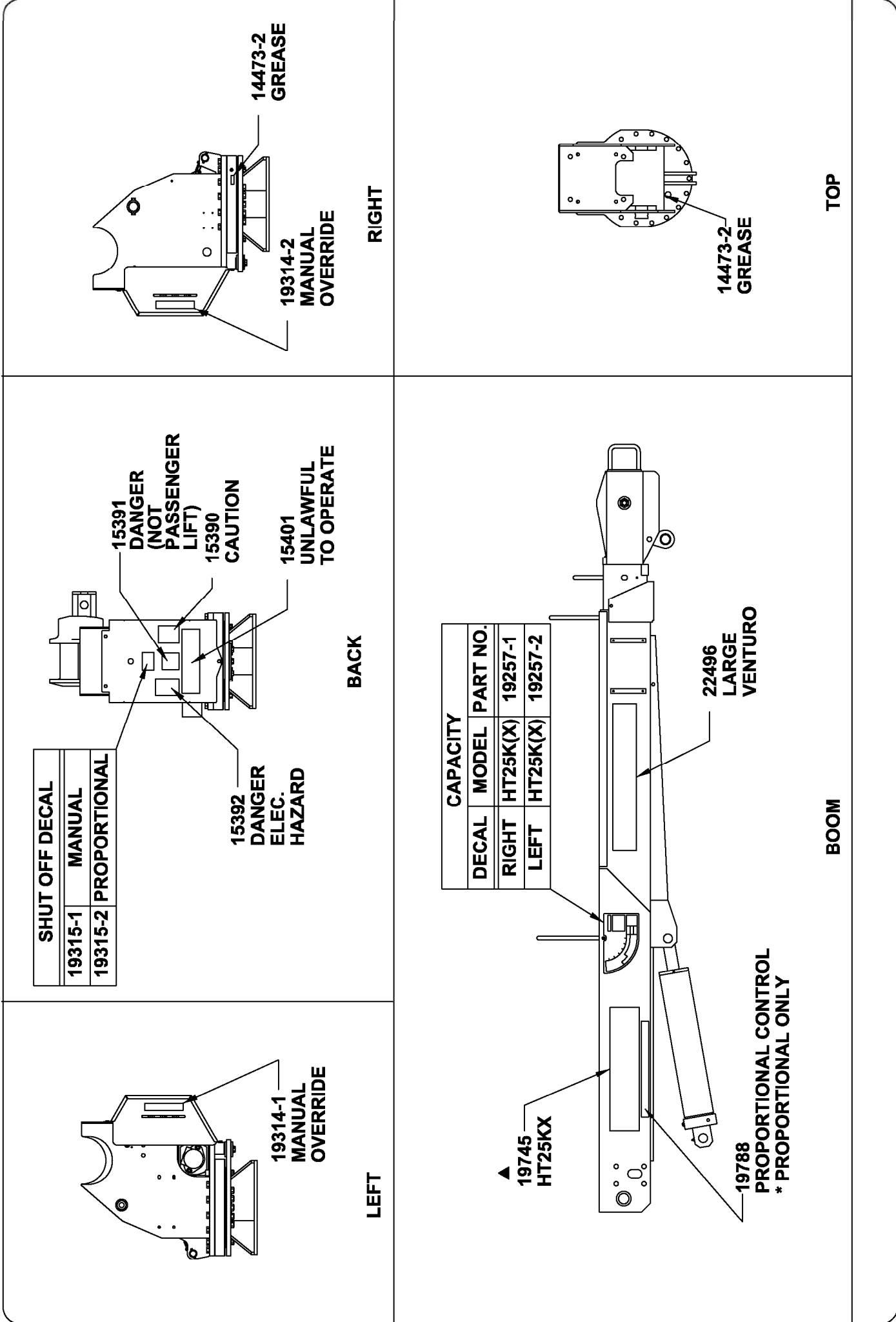
HT CRANES

**DATE
5-26-98B**

**SUPERCEDES
10-17-97A**

**SECTION
C150**

119217



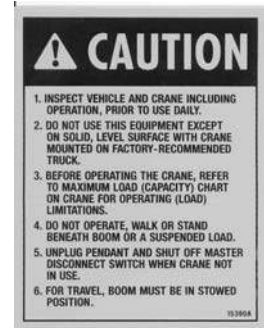
PART NO.: 15390

DECAL: CAUTION - INSPECT VEHICLE & CRANE

FUNCTION: To inform the operator of key operating requirements.

QUANTITY: 1

PLACEMENT: Rear cover.



PART NO.: 15391

DECAL: DANGER - NOT PASSENGER LIFT

FUNCTION: To inform the operator not to lift, support or transport personnel, and to ensure that crane operator is adequately trained.

QUANTITY: 1

PLACEMENT: Rear cover.



PART NO.: 15392

DECAL: DANGER - ELECTROCUTION HAZARD

FUNCTION: To inform the operator that the machine (crane) represents an electrocution hazard should it come close to or in contact with electrical voltage source.

QUANTITY: 1

PLACEMENT: Rear cover.



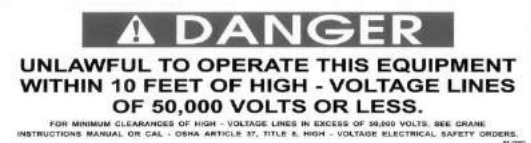
PART NO.: 15401

DECAL: UNLAWFUL TO OPERATE

FUNCTION: To inform the operator of proper operation in vicinity of power lines.

QUANTITY: 1

PLACEMENT: Right side of housing.



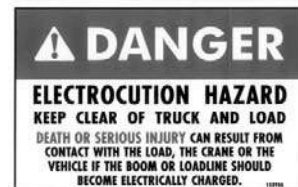
PART NO.: 15393A

DECAL: DANGER - ELECTROCUTION HAZARD

FUNCTION: Warns of danger from electrically charged vehicle, crane or lead.

QUANTITY: 4

PLACEMENT: One on each side and each end of vehicle.



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TITLE
SAFETY DECALS

CRANES

DATE
8-10-09B

SUPERSEDES
5-6-08A

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C150

21353

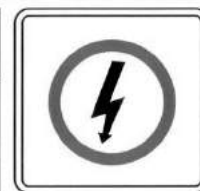
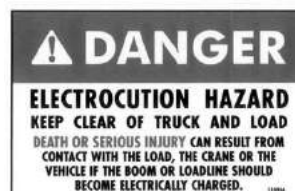
PART NO.: 15393A

DECAL: DANGER - ELECTROCUTION HAZARD

FUNCTION: Warns of danger from electrically charged vehicle, crane or lead.

QUANTITY: 4

PLACEMENT: One on each side and each end of vehicle.



PART NO.: 15513

DECAL: MASTER DISCONNECT SWITCH

FUNCTION: To inform the operator of location and operation of master disconnect switch.

QUANTITY: 1

PLACEMENT: On master disconnect switch bracket.



MFG., INC.
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TITLE

SAFETY DECALS

CRANES

DATE

8-10-09A

SUPERSEDES

4-26-06

SECTION

C150

21384

PART NO.: 14473-2

DECAL: GREASE

FUNCTION: To show the operator where to apply grease.

QUANTITY: Varies

PLACEMENT: Near grease fittings.



PART NO.: 19314-1

DECAL: MANUAL OVERRIDE

FUNCTION: To inform the operator of manual override locations.

QUANTITY: 1

PLACEMENT: Left side of rear cover.



PART NO.: 19314-2

DECAL: MANUAL OVERRIDE

FUNCTION: To inform the operator of manual override locations.

QUANTITY: 1

PLACEMENT: Right side of rear cover.



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TITLE

SHUT OFF & OVERRIDE DECALS

DATE

3-9-11A

SECTION

C150

HT CRANES

SUPERSEDES

9-6-05

21355A

PART NO.: 19315-1

DECAL: MANUAL OVERRIDE (NON-PROPORTIONAL)

FUNCTION: To show the operator how to
override master shut off valve.

QUANTITY: 1

PLACEMENT: Rear cover.



PART NO.: 19315-2

DECAL: MANUAL OVERRIDE (PROPORTIONAL)

FUNCTION: To show the operator how to
override proportional valve.

QUANTITY: 1

PLACEMENT: Rear cover.



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TITLE
SHUT OFF & OVERRIDE DECALS

DATE
9-6-05

SECTION
C150

HT CRANES

SUPERSEDES
-

21355B

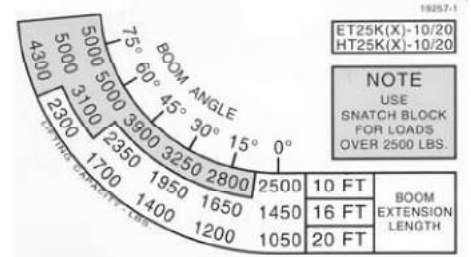
PART NO.: 19257-1 & 19257-2 (OPPOSITE)

DECAL: CRANE CAPACITY

FUNCTION: To show the operator the operating capacities of crane.

QUANTITY: 1 each

PLACEMENT: One on each side of boom.



PART NO.: 19745

DECAL: MODEL NUMBER

FUNCTION: To show the model of the crane.

QUANTITY: 2

PLACEMENT: One on each side of boom.

HT25KX



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TITLE
MODEL & CAPACITY DECALS

DATE
9-7-05

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C150

HT25KX

SUPERSEDES
-

21359

SECTION 200

INSTALLATION



CRANE INSTALLATION

HT25KX

BODY REINFORCEMENT

The truck body must be reinforced and outriggers provided to withstand the combined loads resulting from lifting and the weight of the crane and boom.

The maximum combined overturning moment for the HT25KX is 27,000 ft. lbs.

The maximum vertical load is 6500 lbs.

CRANE MOUNTING

The crane base plate or mounting pedestal must be bolted to the body reinforcing plate with eight (8) grade five (5) bolts of 3/4" dia. with either coarse or fine threads. A 4.5" dia. hose clearance hole must be cut in this plate to allow the hoses to swing and coil freely.

ROTATION POSITIONING

The HT cranes are shipped with the boom rotated to the middle of the 400 degree rotation travel limit. The location of this middle position relative to the center line of the truck must be decided prior to mounting. It can be in any position that pleases the users since the boom can always reach the storage and travel position by rotating one way or the other.

HYDRAULIC CONNECTIONS

The crane is furnished with a pressure and a return hose that come down through the center of the housing. Included in the installation kit are two hydraulic swivels and two more hoses.

These hoses and swivels are to be arranged in the compartment or pedestal below the crane as shown on drawing 20691 using the angle bulkhead fittings furnished in the installation kit.

These hoses are to be connected in a relaxed position as shown on 20691, while the crane is at the midpoint of the 400 degree rotation range as received -- regardless of the final position of the boom during storage/travel.

The bulkhead fittings may be located on any side of the compartment relative to the middle of rotation position.

The crane pressure and return hoses have different sizes of SAE 37 degree flare swivel fittings. The smaller swivel is on the pressure hose which has a 3/8" flare. The larger swivel is on the return hose which has a 1/2" flare.

- ▲ NOTE: If you purchased one of Venturo's hydraulic packages (P/N 19294-X.XXX), you will have received our pressure gauge kit. This kit includes a gauge, hose and bulkhead "T" fitting and should be installed on the pressure hose as shown on drawing 20691.



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TITLE
INSTALLATION DWG

HT25KX

DATE
12-22-04A

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10-10-02

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C200

20690

ELECTRICAL CONNECTIONS

- ▲ A 25 ft. electrical power lead - intended for 12V DC only - also comes down through the center of the housing with the hoses. This lead should be looped in the compartment so that it remains relaxed throughout the 400 degree rotation of the crane.

A 15amp circuit breaker is mounted on the crane and protects the crane's internal wiring and solenoid coils. The 15amp circuit breaker does not protect the 25 foot electrical power lead. For added protection, the 25 ft. lead can be connected to a 15-20 amp protected circuit that, if possible, is powered only when the vehicle engine is running

HYDRAULIC FLUID

<u>Average Climate</u>	<u>Type of Oil</u>
Cold to Moderate	ISO Grade AW 46
Warm to Hot	ISO Grade AW 68

The fluid should have the highest anti-wear characteristics and treated to inhibit rust and oxidation.

HYDRAULIC HOSES & LINES

The minimum sizes for lines and hoses are as follows:

PRESSURE	1/4"
RETURN	3/8"
SUCTION	3/4"

RESERVOIR

The PTO reservoir should have a capacity of 8 gallons fitted with 100 mesh suction screen, 10 micron return line filter, and filler/breather cap.

PTO PUMP

For standard (non-proportional) cranes, the PTO pump should be sized to provide 2.0 gpm (or 1.5 gpm for more delicate control of loads) at 3000 psi when engine is at desired idle speed.

For proportional cranes, the PTO pump should be sized to provide 4.0 gpm at 3000 psi when engine is at desired idle speed.

PTO START-UP

Before connecting the PTO system to the crane pressure and return hoses, connect the PTO pressure and return lines together at the bulkhead. Operate the PTO system for about two (2) minutes per gallon of reservoir capacity (in this case 16 minutes) to flush out the lines and filter all the fluid several times.

ENGINE START/STOP & THROTTLE CONTROL

If your crane was purchased with optional engine start/stop and throttle control, refer to drawing 22615 in the replacement parts section for further information.



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CINCINNATI, OHIO

TITLE
INSTALLATION DWG

HT25KX

DATE
6-17-02E

SUPERCEDES
4-24-02D

SECTION
C200

119212b

CRANE OPERATION AND MAINTENANCE INSTRUCTIONS

HT25KX

SAFETY

Before operating this crane, read and understand these instructions, the 920612 Crane Safety and Hazards Information Sheet, and review all safety & instruction labels on the crane.

CRANE INSPECTION

Before operating this crane, inspect for wear, damage, or oil leakage. After the wire rope has been run out, check for wear, kinks, and broken strands. Check the hook and safety latch for damage. Correct any problems before using the crane.

CAPACITY

Before operating this crane, review the capacity charts on the sides of the boom to relate the load to be lifted to the boom length and angle. The boom angle is shown by a gravity arrow.

SNATCH BLOCK

If the load exceeds 2500 lbs. or reduced winching speed for better control of smaller loads is required, use the snatch block to rig the crane for two part line operation.

CONTROLS

This crane is operated by a remote control pendant. The pendant should be unplugged and stored in a compartment when the crane is not in use.

Before plugging the pendant in, inspect the plug, socket, cord, pendant head, and switches for damage. Actuate all four switches both ways to verify that they all have the same feel and sound and that they return to the center position.

PTO SYSTEM

Check the hydraulic fluid level in the PTO system reservoir. Engage PTO and set the engine idle speed to provide a hydraulic flow rate per the PTO system instructions. A lower idle setting may be used for more delicate spotting of loads if required.

CRANE OPERATION

Use "Winch Down" to release tension on the wire rope to unhook it from the storage tie down position.

Use "Boom Up" to elevate the boom from the boom rest position.

Avoid repeated rapid reversals of the control switches. This can cause the load to swing.

Check all control functions to see that they are working as described in the following section

CONTROL FUNCTIONS

WINCH "UP" and "DOWN" - Raises and lowers the load with the winch.

BOOM "UP" and "DOWN" - Raises and lowers the boom elevation angle. The boom elevates from 8 degrees below horizontal to 75 degrees above horizontal.

BOOM "OUT" and "IN" - Extends and retracts the boom. The boom hydraulic extension stroke is 6 ft.



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TITLE
INSTALLATION DWG

HT25KX

DATE
6-17-02

SUPERCEDES
-

SECTION
C200

20435A

ROTATION "L" and "R" - Controls the left and right direction of the crane rotation. The crane rotation is limited to 400 degrees.

POWER (Non Proportional Systems with Engine Controls) - Energizes safety shutoff valve. See page 22328 for detailed operating instructions and warnings.

TRIGGER (Proportional Systems Only) - Varies the flow rate delivered to the crane valve. The farther the trigger is pulled, the faster the selected crane function operates.

OVERLOAD SENSING SYSTEM

This crane is equipped with an Overload Sensing System. If the capacity of the crane is exceeded, the "Winch Up", "Boom Down", and "Boom Out" functions will be shut down. The "Winch Down", "Boom Up", and "Boom In" functions will continue to operate and can be used to relieve the overload condition. The "Rotation" function also will continue to operate.

The Overload system is inoperative if the boom elevation is at the bottom or top limit of travel. To relieve this condition, raise or lower the boom slightly before lifting the load.

TWO-BLOCK SENSING SYSTEM

This crane is equipped with an anti two-block device that is mounted at the tip of the boom. If the snatch block/overhaul weight contacts the device the "Winch Up", "Boom Down", and "Boom Out" functions are disabled. The "Winch Down", "Boom Up", and "Boom In" functions will continue to operate and can be used to relieve the two-block condition. Refer to Drawing 19050 for parts breakdown and configuration information.

MANUAL TELESCOPIC BOOM

The 10 to 20 ft. boom has a 4 ft. manual telescoping section in addition to the 6 ft. power extension. A pin locks the manual extension into either the extended or retracted position.

TRUCK SETUP & OUTRIGGERS

1. The truck should be parked on ground that is as level and as firm as possible when using the crane.
2. The center of the crane should be positioned close enough to the job so that it can be operated at a reach that puts the load within the rated capacity of the crane.
3. Set the vehicle parking brake and put the vehicle transmission in "park" if it is an automatic.
4. Deploy the outriggers to help stabilize the vehicle against rocking or overturning when lifting with the crane.

PREPARATION FOR TRAVEL

1. Return the outriggers to the stowed position. Install and secure all pins.
2. Stow the crane boom in the boom support.
3. Hook the winch line to the tie down point on the boom and apply light tension.
4. Disengage the PTO pump and idle speed control.
5. Unplug the control pendant and store in a body compartment or the cab.



MFG., INC.
CINCINNATI, OHIO

TITLE	INSTALLATION DWG
	HT25KX

DATE	6-17-02
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SUPERCEDES	-
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SECTION	C200
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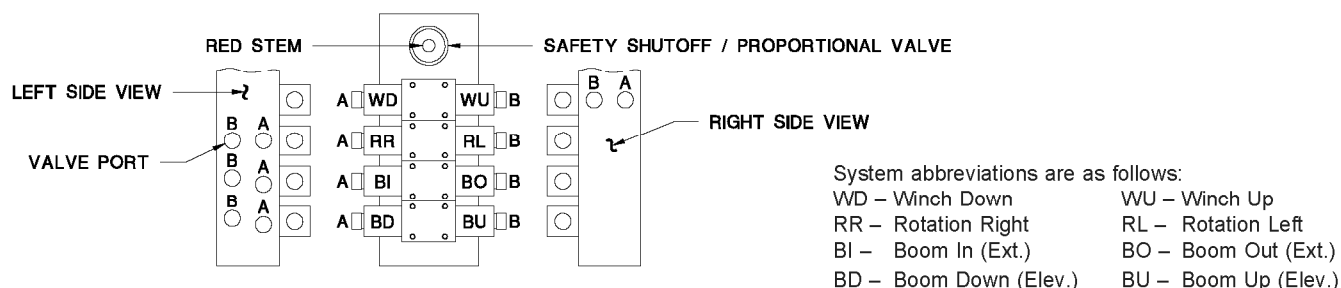
	20435B
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EXPLANATION OF HYDRAULIC VALVE SYSTEM

OVERVIEW

Venturo's hydraulic cranes are available in two general configurations: Proportional and Non-proportional. The **Non-proportional** configuration utilizes a safety shutoff valve which, when **not** actuated, allows hydraulic fluid to bypass the valve bank and return to tank; the crane will not function when the safety shutoff valve is not actuated. When the safety shutoff valve is actuated (control pendant energizes the coil or the coil is manually overridden), hydraulic fluid cycles through the valve bank and allows the crane to function. The **Proportional** configuration utilizes a proportional valve which in its fully closed and fully opened positions functions similarly to the safety shutoff valve, but adds the ability to operate the crane at any speed in between these two extremes.

In both the Non-proportional and Proportional configurations, the four crane functions (winch, rotation, boom elevation, and boom extension) are controlled by four separate valve sections. Each valve section has two solenoid coils (and two manual overrides) which control the direction that the function operates (e.g. winch up vs. winch down). For a given crane function and direction (e.g. winch up) the solenoid coil and the associated manual override lie on the same side of the valve bank (both "push").



MANUAL OVERRIDE SYSTEM

Should an electrical failure occur, your Venturo crane can be operated manually. **The manual overrides are intended for emergency use only and should not be used for normal operation.**

To operate in manual override mode:

- (1) Override the safety shutoff or proportional valve by turning the red stem on the valve as stated below.

Non-proportional system:

For override operation, press stem in and rotate counterclockwise until it stops.

To return to normal operation, press stem in and rotate clockwise until it stops.

Proportional system:

For override operation, rotate stem clockwise (the farther the stem is turned the faster the crane will operate).

To return to normal operation, rotate the stem counterclockwise until it stops.

- (2) Determine the coil/override associated with the function you wish to operate, then insert a small diameter object (an allen wrench works well) into the detent on the end of the valve stem and press firmly inward. For example, pushing the stem labeled A on the first bank (refer to the illustration) will actuate winch down.

WARNING! For normal crane operation, the safety shutoff or proportional valve must be in the "normal" position (as described above). Test the crane before each use by placing the power toggle switch or trigger in the "OFF" position and testing each crane function *using the manual overrides*. If any crane function operates, verify that the red stem on the safety shutoff or proportional valve is in the normal position then retest.

EMERGENCY STOP

In the unlikely event that a function of the crane does not stop once the function's toggle switch is released, the **Non-proportional** crane can be stopped by simply toggling the power switch to the off (emergency stop) position and the **Proportional** crane can be stopped by releasing the trigger.



MFG., INC.
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TITLE
HYDRAULIC SYSTEM

▲HT18, HT25, HT40/50

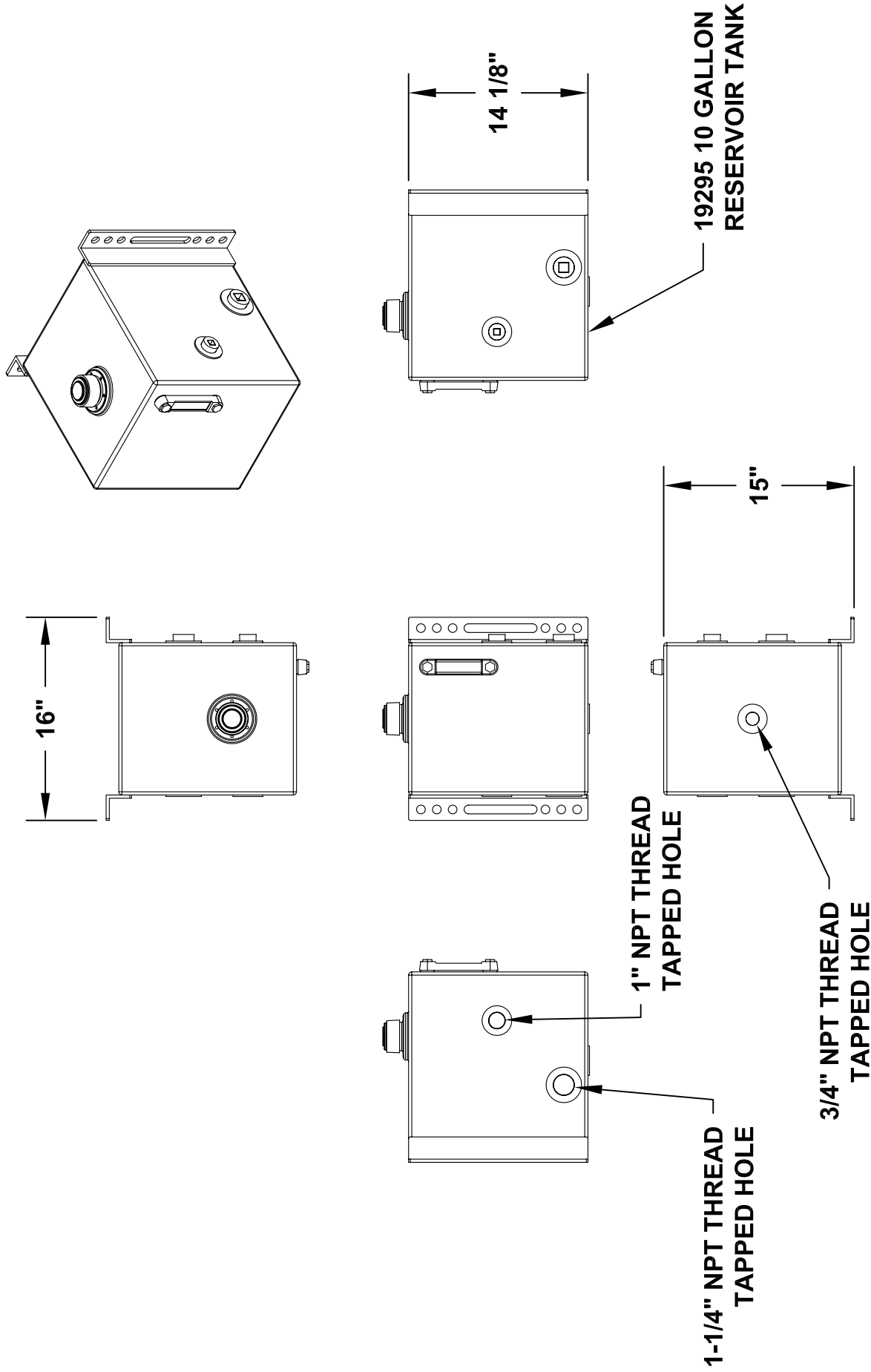
DATE
9-24-03B

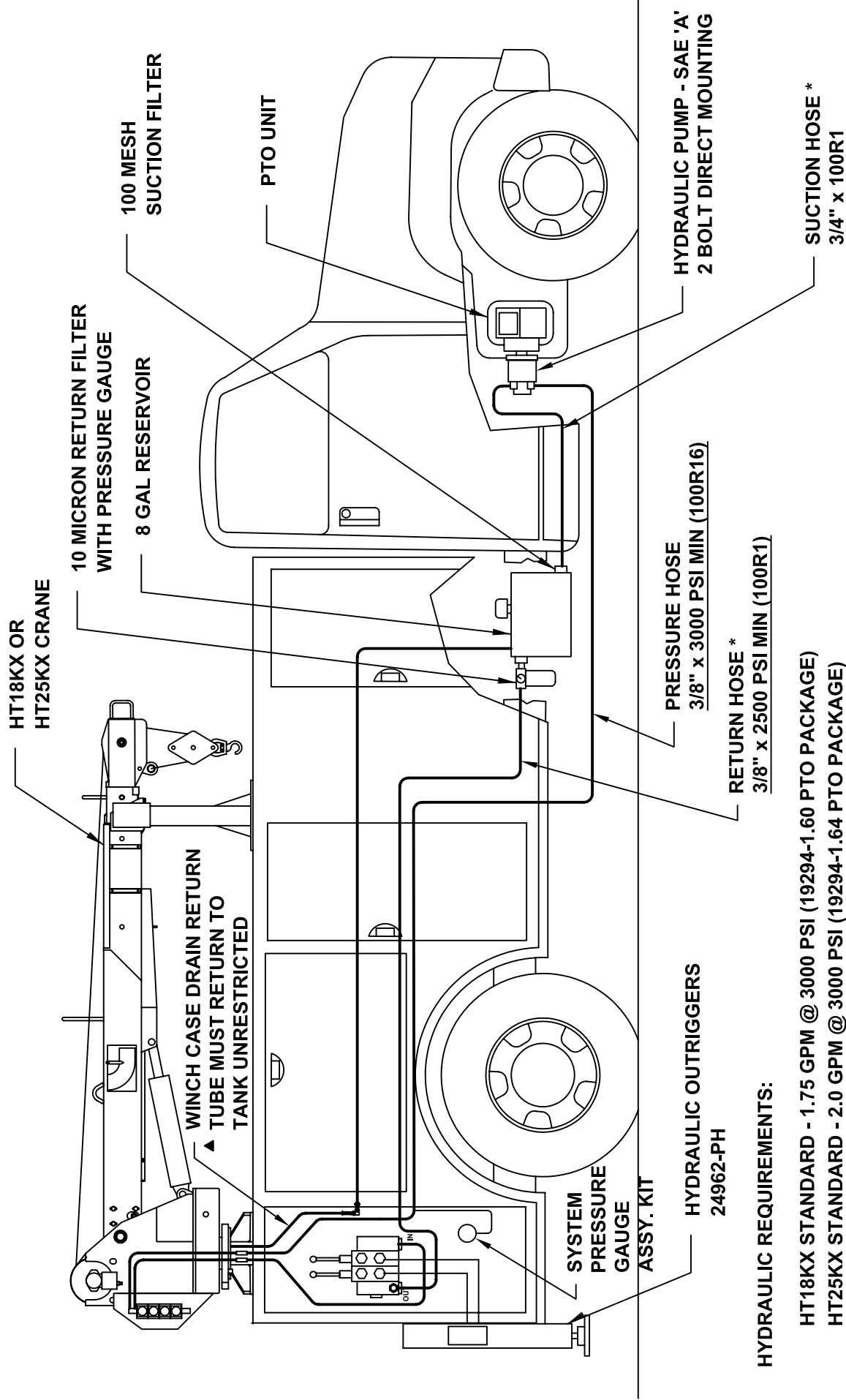
SUPERCEDES
5-1-98A

SECTION
C200

22328

19295 10 GALLON HYDRAULIC TANK





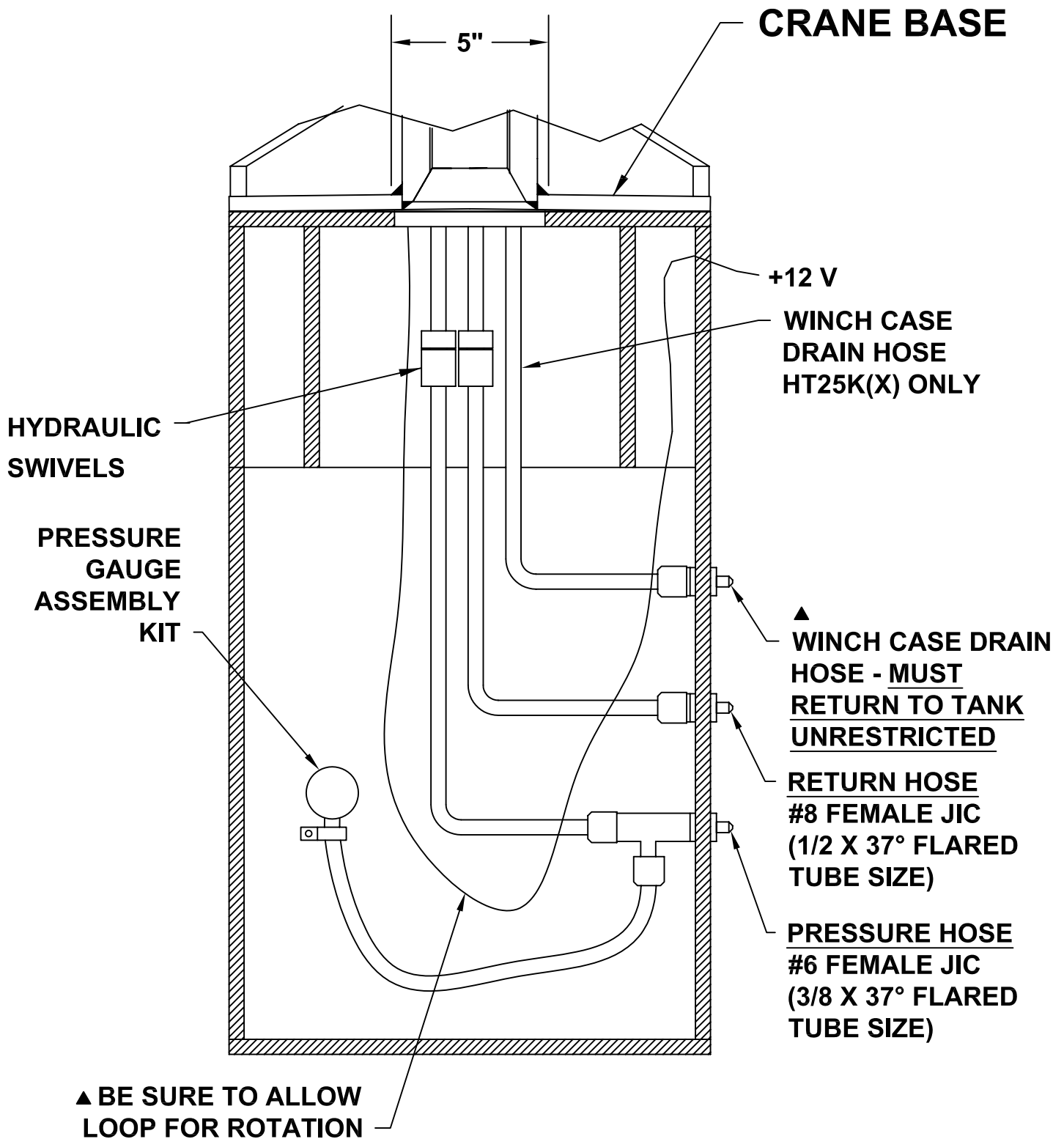
HYDRAULIC REQUIREMENTS:

- HT18KX STANDARD - 1.75 GPM @ 3000 PSI (19294-1.60 PTO PACKAGE)
- HT25KX STANDARD - 2.0 GPM @ 3000 PSI (19294-1.64 PTO PACKAGE)
- HT18KX PROPORTIONAL - 3.5 GPM @ 3000 PSI (19294-3.68 PTO PACKAGE)
- HT25KX PROPORTIONAL - 4.0 GPM @ 3000 PSI (19294-3.68 PTO PACKAGE)

SEE INSTALLATION INSTRUCTIONS I19212 (2 PAGES).

* HOSES OR FITTINGS BETWEEN PUMP, RESERVOIR, AND CRANE NOT INCLUDED.

CRANE AND HOSE INSTALLATION HT18KX / HT25KX



MFG., INC.
CINCINNATI, OHIO

TITLE
INSTALLATION DWG

HT18KX / HT25KX

DATE
3-20-08D

SUPERSEDES
7-20-07C

SECTION
C200

20691

WIRE ROPE INSTALLATION

STEP 1: UNWIND COIL OF WIRE ROPE BY 'ROLLING' ALONG THE FLOOR. THIS WILL PREVENT 'KINKING'.

STEP 2: INSERT WIRE ROPE END THROUGH ANTI-TWO-BLOCK WEIGHT.

STEP 3: INSERT WIRE ROPE END INTO POCKET OPENING ON WINCH AND THROUGH WEDGE POCKET AS SHOWN IN (FIG 1).

CAUTION: IF THE WIRE ROPE IS NOT INSTALLED FOR THE CORRECT DRUM ROTATION, THE WINCH BRAKE VALVE WILL NOT HOLD THE LOAD.

CAUTION: THERE MUST ALWAYS BE AT LEAST (3) TURNS OF WIRE ROPE ON THE WINCH DRUM WHILE UNDER LOAD.

NOTE:  SOME WINCHES WILL BE SUPPLIED WITH A HEX NUT IN LIEU OF A WEDGE FOR INSTALLING THE WIRE ROPE.

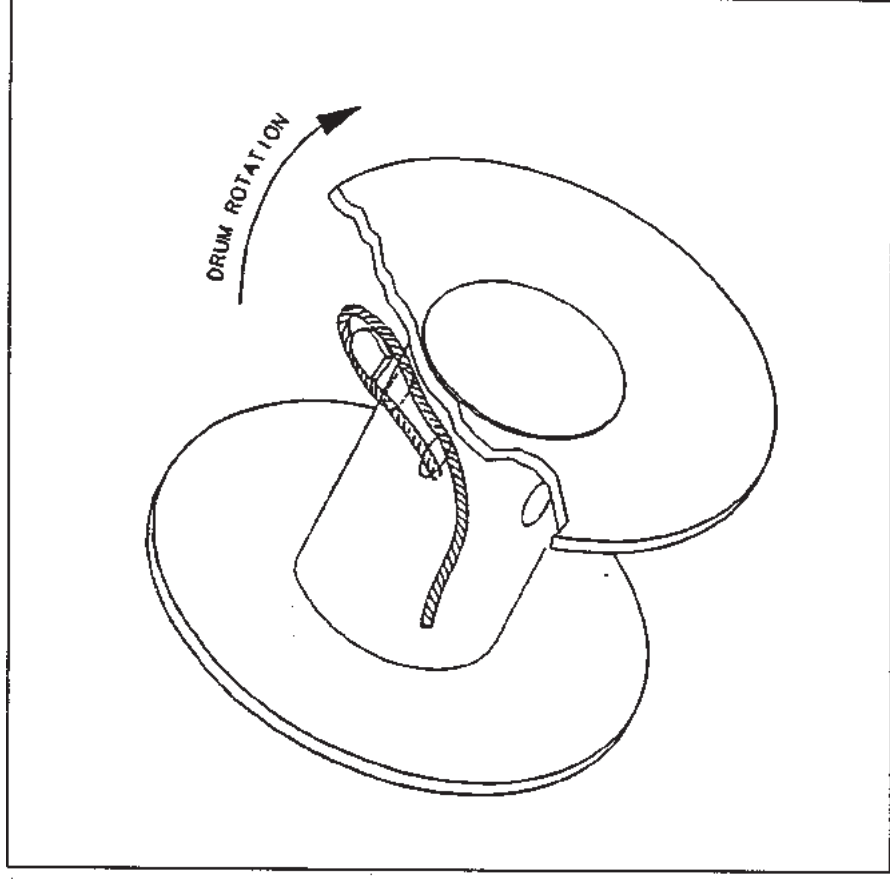
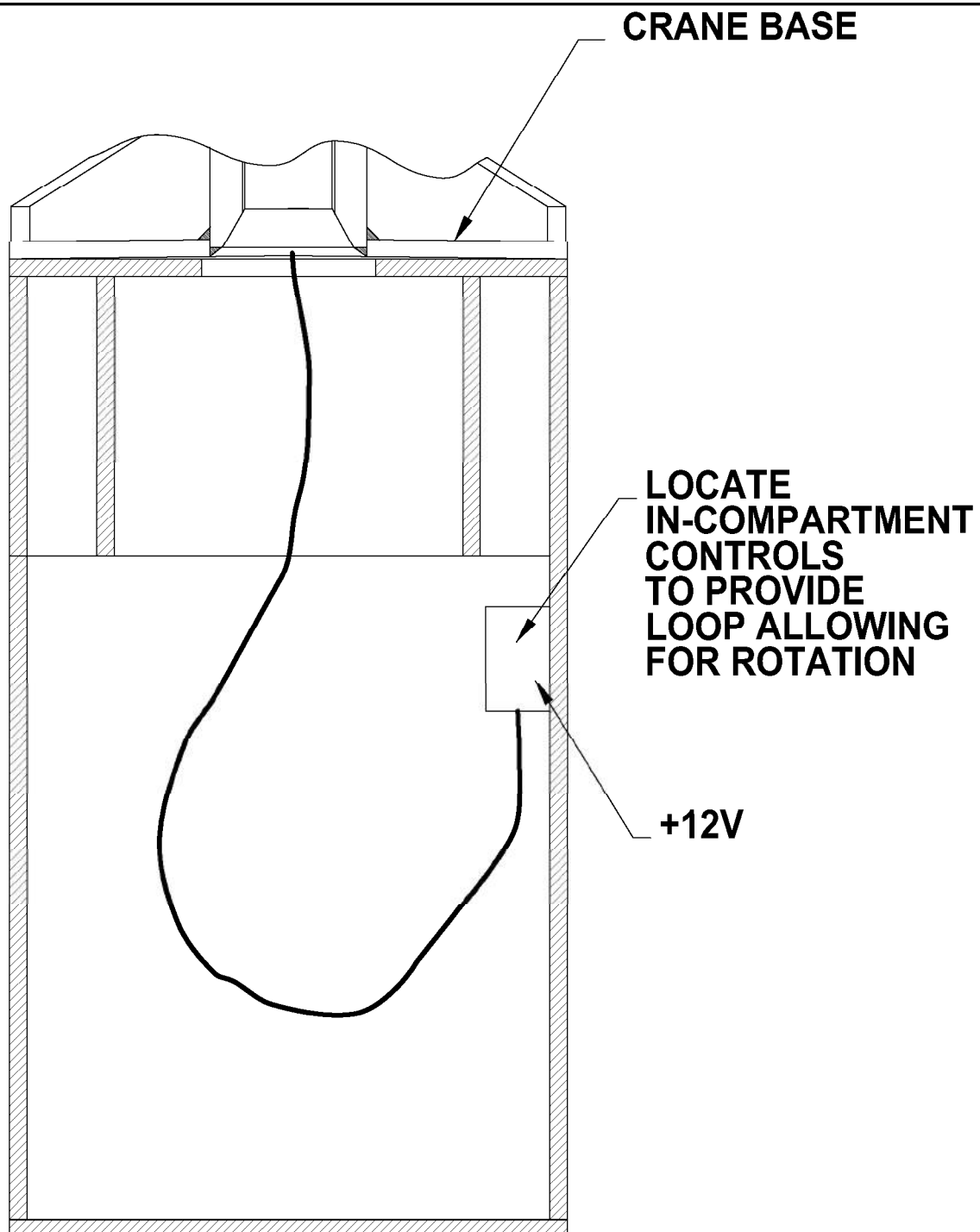


FIG 1

IN-COMPARTMENT CONTROLS INSTALLATION HT18KX / HT25KX ▲

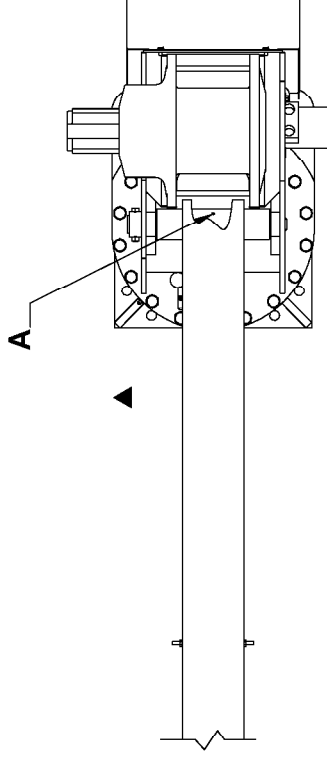
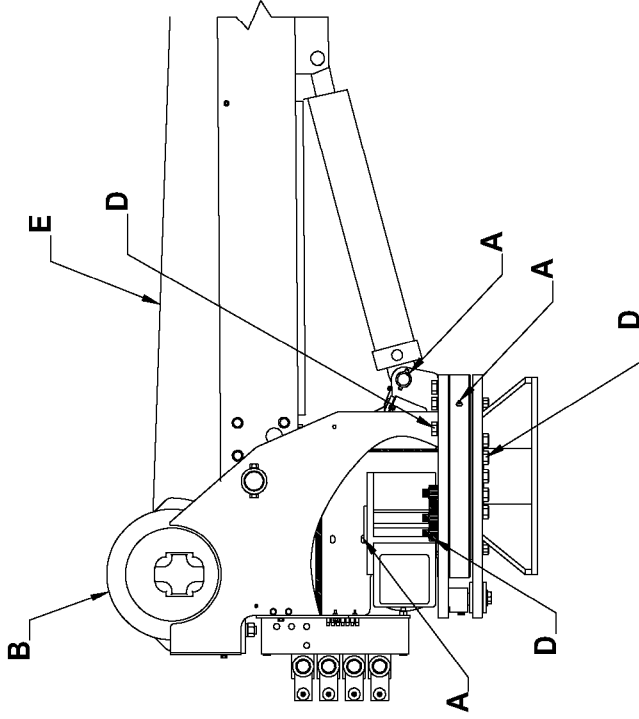


SECTION 300

MAINTENANCE

&

SERVICE



Location	Service Required	Note	Service Interval
A	Grease fitting With Pressure Grease Gun	Use Lithium Based Grease	Time of Truck Service
B	Fill Cable Drum to Side Relief Valve Port (Approx 1/2 Full)	Use SAE 90 Gear Lubricant	Time of Truck Service
D	Check Torque of bolts	Bolts should be torqued to 190 ft-lbs	Time of Truck Service
E	Check Wire Rope and Hook	Rope should be free of kinks and fraying	Time of Truck Service



MANUFACTURING, INC.
CINCINNATI, OHIO

TITLE

LUBRICATION & MAINTENANCE CHART

SECTION

DATE
12-1-03C

SUPERSEDES

11-18-03B

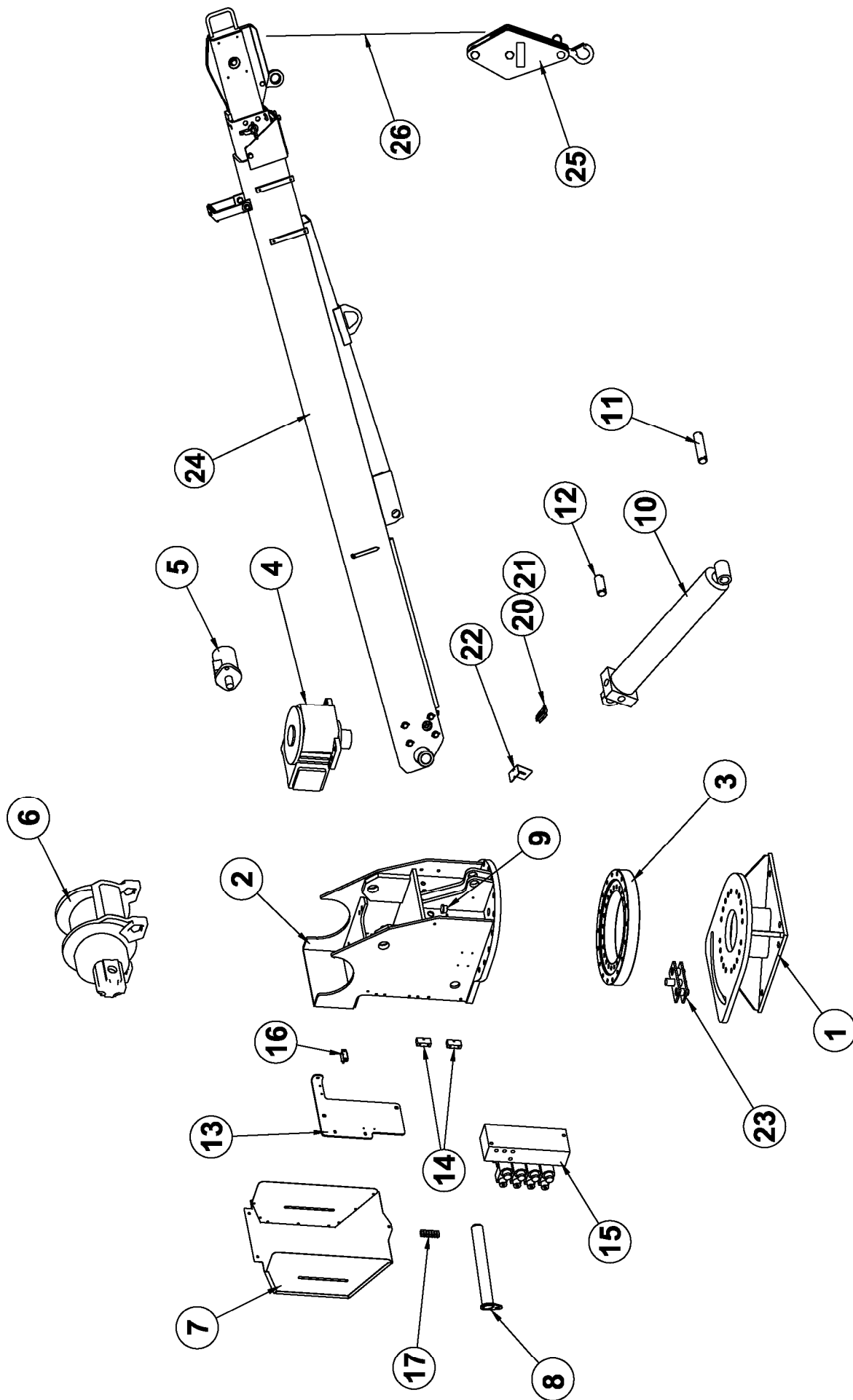
HT25K(X)

20531

SECTION 400

PARTS





VENTURO MANUFACTURING, INC. CINCINNATI, OHIO	TITLE REPLACEMENT PARTS DRAWING	DATE 6-18-04 SUPERSEDES -	SECTION - 21036
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HT25KX

ITEM #	PART #	DESCRIPTION	ITEM #	PART #	DESCRIPTION
1	19806	STATIC BASE ASSEMBLY			
2	19807	HOUSING ASSEMBLY - ET/HT 25KX			
3	19808	SWING BEARING			
4	19811	SPEED REDUCER			
5	19916	HYDRAULIC ROTATION MOTOR			
6	19814	HYDRAULIC WINCH			
7	19901	CRANE COVER ASSEMBLY			
8	21012	BOOM PIVOT PIN			
9	RL-466	PLASTIC PLUG			
10	21742 ▲	ELEVATION CYLINDER			
11	18761	PIVOT PIN - 1-1/4 DIA.			
12	18762	PIVOT PIN - 1-1/4 DIA.			
13	19809	BACK PANEL - ET/HT25K(X)			
14	19824	MOUNTING BLOCK HT25 REAR PANEL			
15	22501	VALVE MANIFOLD W/ 4 3POS 4 WAY VALVES			
16	15683-15A	CIRCUIT BREAKER - 15 AMP			
17	19187	BARRIER STRIP 7 SETS OF 2			
18	19849 ▲	BASIC HYDRAULIC UNIT			
19	19850 ▲	BASIC ELECTRICAL UNIT			
20	19917	BOOM SHUT OFF SWITCH BRACKET			
21	19918	BOOM SHUT OFF SWITCH			
22	20497	SWITCH BRACKET			
23	19810	ROTATION LIMITING SLIDER ASSEMBLY			
24	19950	BOOM FINAL ASSEMBLY			
25	23169	SWIVEL SNATCH BLOCK ASSEMBLY			
26	25810-5/16-80	WIRE ROPE ASSEMBLY - 5/16" X 80 FT (10/20 FT BOOM)			
		FOR REPLACEMENT PARTS DWG REF 21036			
		▲ ITEM NOT SHOWN ON REPLACEMENT PARTS DRAWING			

 VENTURO MANUFACTURING, INC. CINCINNATI, OHIO		TITLE		REPLACEMENT PARTS		DATE	SECTION
		HT25K(X)				3-27-09A	-
						SUPERCEDES	
						6-18-04	21037

FASTENER LIST FOR HT25KX

PART NUMBER	DESCRIPTION	QTY	LOCATION/FUNCTION
12534	WASHER - I.D. 0.63"	38	SLEWING RING
!HHCS06311200	HEX HEAD CAP SCREW - 5/8"-11 x 2"	35	SLEWING RING
!SHCS06311150	SOCKET HEAD CAP SCREW-5/8-11 X 1-1/2"	3	SLEWING RING
!LWSH-050-HC	LOCK WASHER 1/2" - HI COLLAR	2	HYDRAULIC ROTATION MOTOR
!SHCS05013125	SOCKET HEAD CAP SCREW 1/2-13 X 1-1/4"	2	HYDRAULIC ROTATION MOTOR
!LWSH-050-ISTAR	LOCK WASHER 1/2" STAR INTERNAL HD	6	SPEED REDUCER
!SHCS05011150	SOCKET HEAD CAP SCREW 1/2-13 X 1-1/2"	6	SPEED REDUCER
!LWSH-025	LOCK WASHER - 1/4"	6	HYDRAULIC PANEL BLOCK
!HHCS02520075	HEX HEAD CAP SCREW 1/4-20 X 3/4" LONG	6	HYDRAULIC PANEL BLOCK
!LWSH-025	LOCK WASHER - 1/4"	1	BOOM UP LIMIT SWITCH BRACKET
!HHCS02520050	HEX HEAD CAP SCREW - 1/4-20 X 1/2" LG	1	BOOM UP LIMIT SWITCH BRACKET
!HHCS02520050	HEX HEAD CAP SCREW - 1/4-20 X 1/2" LG	3	REAR COVER
!LWSH-025	LOCK WASHER - 1/4"	3	REAR COVER
!HHCS02520063	HEX HEAD CAP SCREW 1/4-20 X 5/8" LG	1	BOOM PIVOT PIN
!LWSH-025	LOCK WASHER - 1/4"	1	BOOM PIVOT PIN
!SRNG-125	SNAP RING - 1-1/4"	4	ELEVATION CYLINDER CLEVIS PINS
!FWSH-031	FLAT WASHER - 5/16"	1	GROUNDING LUG
!HHCS-3118100	HEX HEAD CAP SCREW 5/16-18 X 1" LONG	1	GROUNDING LUG
!FWSH-031	FLAT WASHER - 5/16"	1	HYDRAULIC PANEL
!LWSH-031	LOCK WASHER - 5/16"	1	HYDRAULIC PANEL
!HHCS03118100	HEX HEAD CAP SCREW 5/16-18 X 1" LONG	1	HYDRAULIC PANEL
!HNUT-03118	HEX NUT 5/16-18	1	HYDRAULIC PANEL
!LWSH-038-HC	LOCK WASHER 3/8" - HI COLLAR	2	HYDRAULIC MANIFOLD
!SHCS03816350	SOCKET HEAD CAP SCREW 3/8-16 X 3-1/2"	2	HYDRAULIC MANIFOLD
!HNUT-03816	HEX NUT 3/8-16	2	HYDRAULIC MANIFOLD
!PHCS#1024050	PAN HEAD CAP SCREW - #10-24 X 1/2" LG	2	CIRCUIT BREAKER
!LWSH-#10	LOCK WASHER - #10	2	CIRCUIT BREAKER
!HNUT-#1024	HEX NUT - #10-24	2	CIRCUIT BREAKER
!LWSH-#10	LOCK WASHER - #10	2	BOOM LIMIT SWITCH
!PHCS#1024038	PAN HEAD CAP SCREW - #10-24 X 3/8" LG	2	BOOM LIMIT SWITCH
!HNUT-#1024	HEX NUT - #10-24	2	BOOM LIMIT SWITCH
!PHCS#0632100	PHILLIPS HEAD CAP SCREW 6-32 X 1" LG	2	BARRIER STRIP
!LWSH-#06	LOCK WASHER - #6	2	BARRIER STRIP
!HNUT-#0632	HEX NUT - #06-32 ▲	2	BARRIER STRIP
▲ !HHCS05013175	HEX HEAD CAP SCREW 1/2-13 X 1-3/4 LG	4	WMCH
▲ !LWSH-050	LOCK WASHER - 1/2 ▲	4	WMCH
▲ !HNUT05013	HEX NUT - 1/2-13 ▲	4	WMCH



MFG., INC.
CINCINNATI, OHIO

TITLE
REPL. FASTENERS LIST
HT25KX

DATE
5-10-05A
SUPERCEDES
6-18-04

SECTION
C400
21038

The drawing consists of two views of a mechanical assembly. The top view shows a long rectangular component with various internal features and labels A, B, and C. The bottom view shows a similar component with labels A, D, and C. Numerous numbered callouts (1-37) point to specific parts of the assembly.

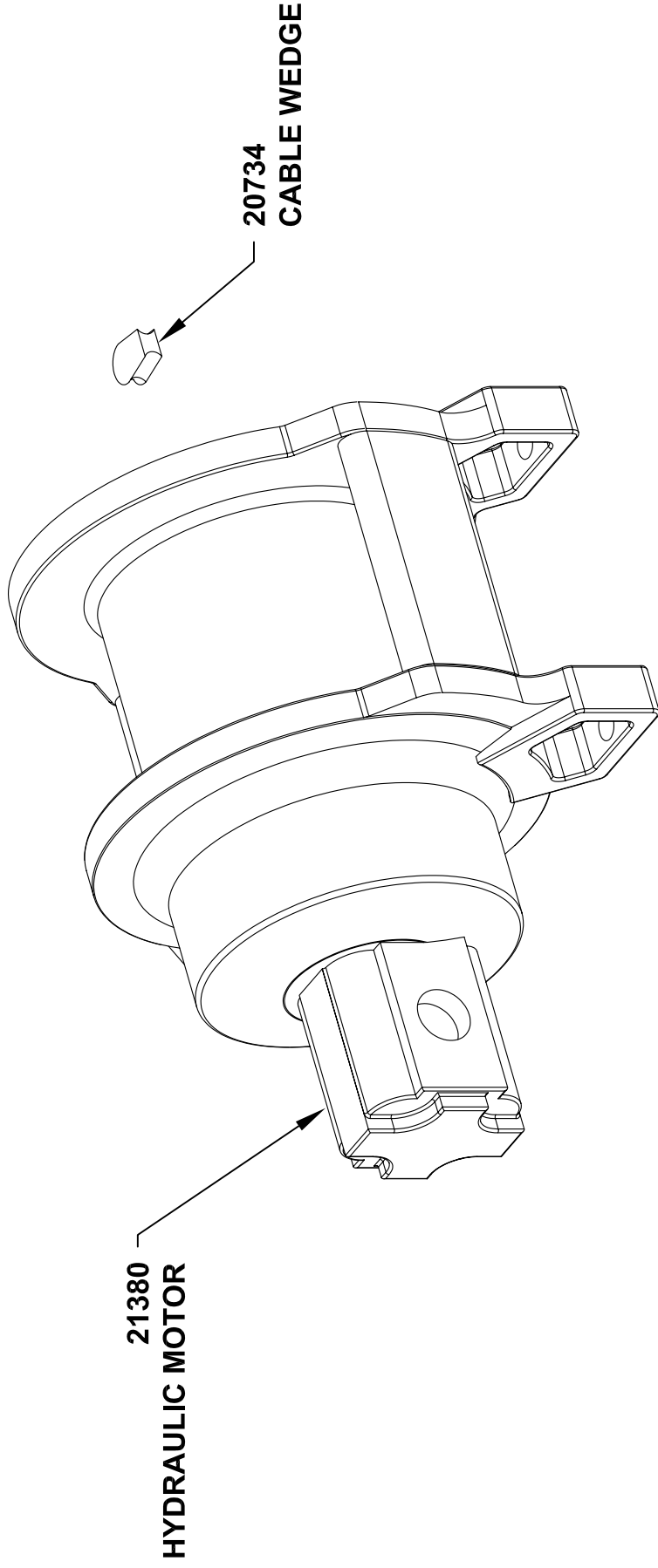
Top View Labels: A, B, C, 1, 2, 3, 4, 5, 6, 7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 24, 25, 26, 27, 28, 29, 30, 31, 32, 33, 34, 35, 36, 37.

Bottom View Labels: A, D, C, 1, 2, 3, 4, 5, 6, 7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 24, 25, 26, 27, 28, 29, 30, 31, 32, 33, 34, 35, 36, 37.



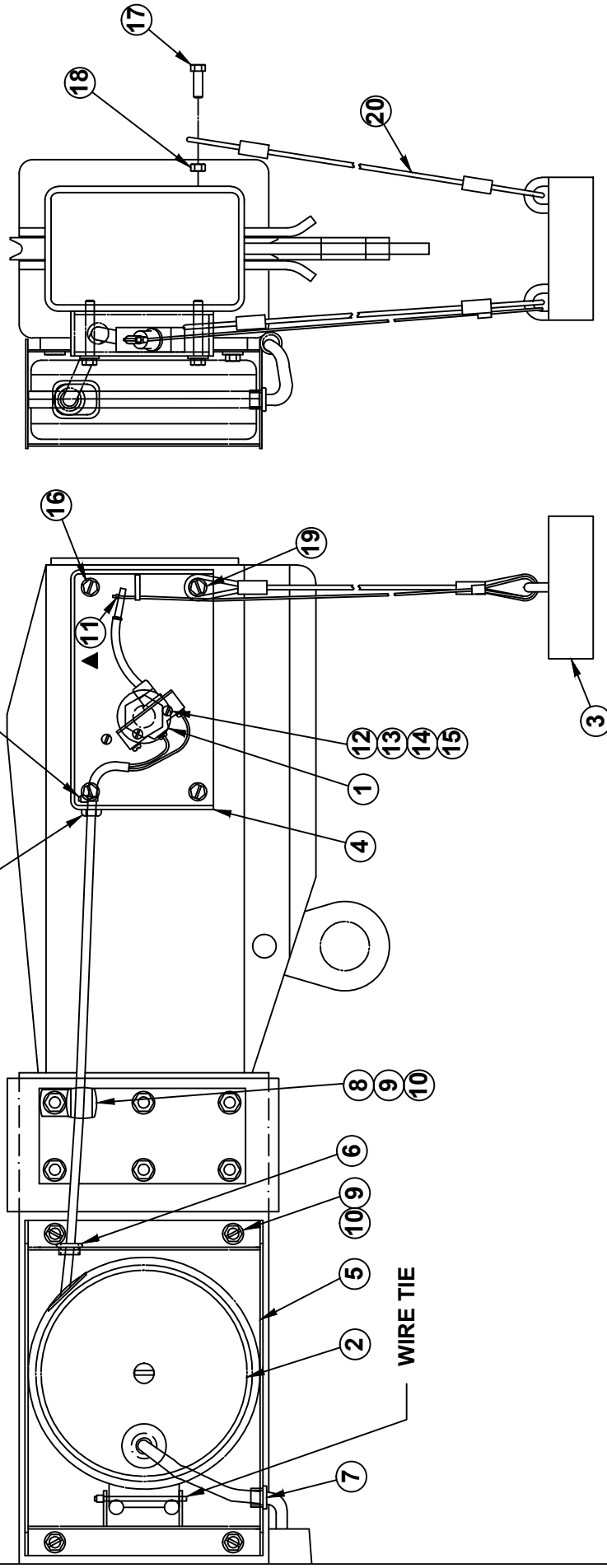
 MANUFACTURING, INC. CINCINNATI, OHIO	TITLE	DATE	SECTION
	19950 BOOM PARTS DRAWING	12-4-03D	-
	ET/HT25KX	SUPERSEDES 9-16-03C	19996

REPLACEMENT PARTS 19814 WINCH



NOT SHOWN ON DRAWING:
21381 - WINCH SEAL KIT
21382 - MOTOR SEAL KIT

WIRE TIE
CABLE & CUT
OFF STEM

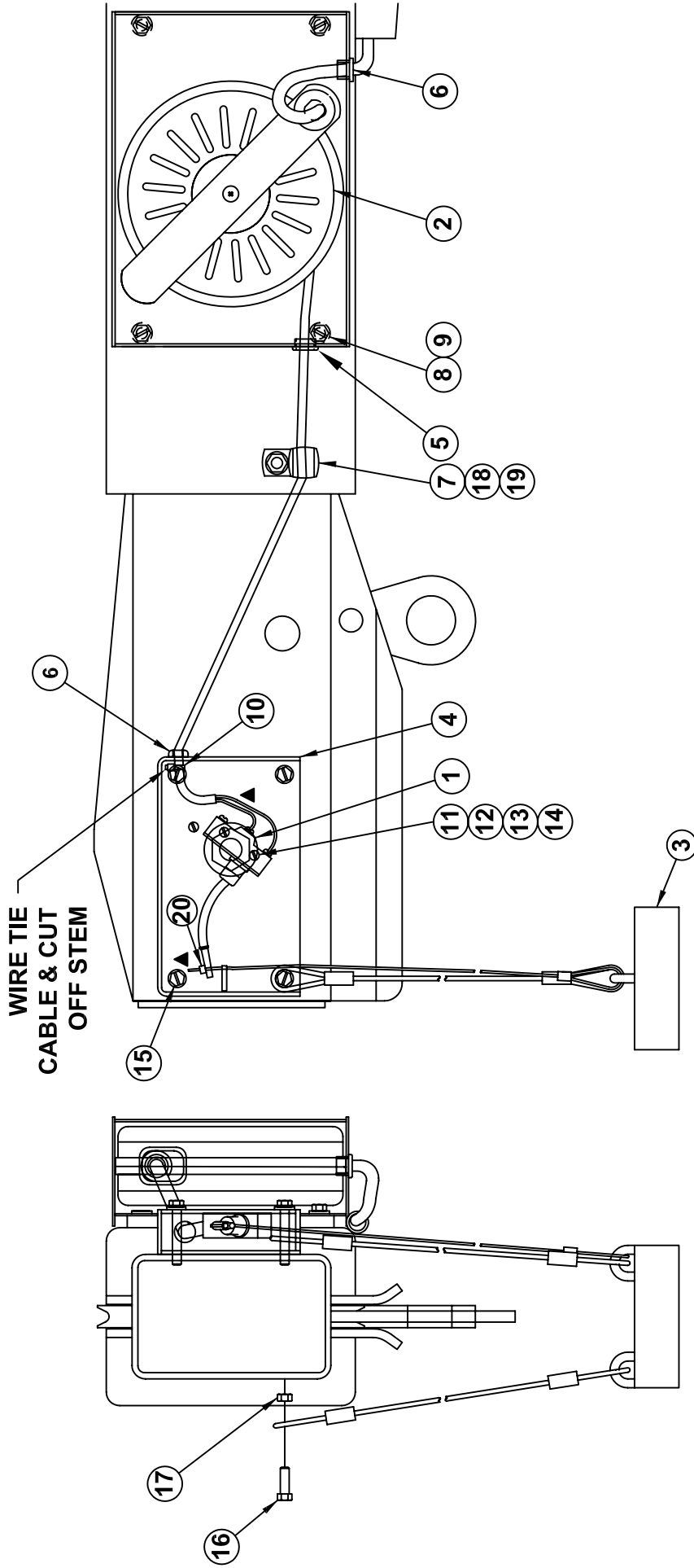


ITEM	QTY	PART NO.	DESCRIPTION
11	1	19302	SET COLLAR - 3/32"
10	5	ILWSH-031	LOCK WASHER - 5/16"
9	5	IHHCS03118050	HEX HEAD CAP SCREW - 5/16-18 x 1/2"
8	1	19275	CABLE CLAMP - 3/4" x 13/32" HOLE
7	2	19270	SNAP BUSHING - 3/8" I.D.
6	1	19063	SNAP BUSHING - 1/2" I.D.
5	1	19058	COVER - CORD REEL
4	1	20839	ANTI TWO-BLOCK HOUSING ASSEMBLY
3	1	19377-2	CABLE WEIGHT ASSY
2	1	22388-1	CORD REEL ASSY
1	1	19376	LIMIT SWITCH
12	2	IPHMS#632125	PAN HEAD MACHINE SCREW - #6-32 x 1 1/4"
13	2	IHNUT-#0632	HEX NUT - #6-32
14	2	IFWSH-#06	FLAT WASHER - #6
15	2	ILWSH-#06	LOCK WASHER - #6
16	3	IHHCS02520175	HEX HEAD CAP SCREW - 1/4-20 x 1 3/4"
17	1	IHHCS02520075	HEX HEAD CAP SCREW - 1/4-20 x 3/4"
18	1	IHNUT-02520	HEX NUT - 1/4-20
19	1	IHHCS02520150	HEX HEAD CAP SCREW - 1/4-20 x 1 1/2"
20	2	20951-2	HANGER CABLE

TITLE		DATE	SECTION
REPLACEMENT PARTS DRAWING		08-01-16G	C400
19197-2 ANTI-TWO-BLOCK SYSTEM		SUPERSEDES	20197-2
06-03-08F			



MANUFACTURING, INC.
CINCINNATI, OHIO



ITEM		QTY		PART NO.		DESCRIPTION	
20	1	19302	SET COLLAR - 3/32"	10	1	TIE-WRAP	9" TIE-WRAP
19	1	ILWSH-025	LOCK WASHER - 1/4"	9	4	ILWSH-031	LOCK WASHER - 5/16"
18	1	IANUT-02520	ACORN NUT - 1/4-20	8	4	ISHCS03118050-5	SOCKET HEAD CAP SCREW - 5/16-18 x 1 1/2"
17	1	!HNUT-02520	HEX NUT - 1/4-20	7	1	19275	CABLE CLAMP - 3/4" x 13/32" HOLE
16	1	!HHCS02520075-5	HEX HEAD CAP SCREW - 1/4-20 x 3/4" GR. 5	6	2	19270	SNAP BUSHING - 3/8" I.D.
15	4	!HHCS02520175	HEX HEAD CAP SCREW - 1/4-20 x 1 3/4"	5	1	19063	SNAP BUSHING - 1/2" I.D.
14	2	!LWSH-#06	LOCK WASHER - #6	4	1	21291	ANTI TWO-BLOCK HOUSING ASSEMBLY
13	2	!FWSH-#06	FLAT WASHER - #6	3	1	19377-2	CABLE WEIGHT ASSY
12	2	!HNUT-#0632	HEX NUT - #6-32	2	1	22683	CORD REEL ASSY
11	2	!PHMS#632125	PAN HEAD MACHINE SCREW - #6-32 x 1 1/4"	1	1	19376	LIMIT SWITCH

MANUFACTURING, INC.
CINCINNATI, OHIO

REPLACEMENT PARTS DWG

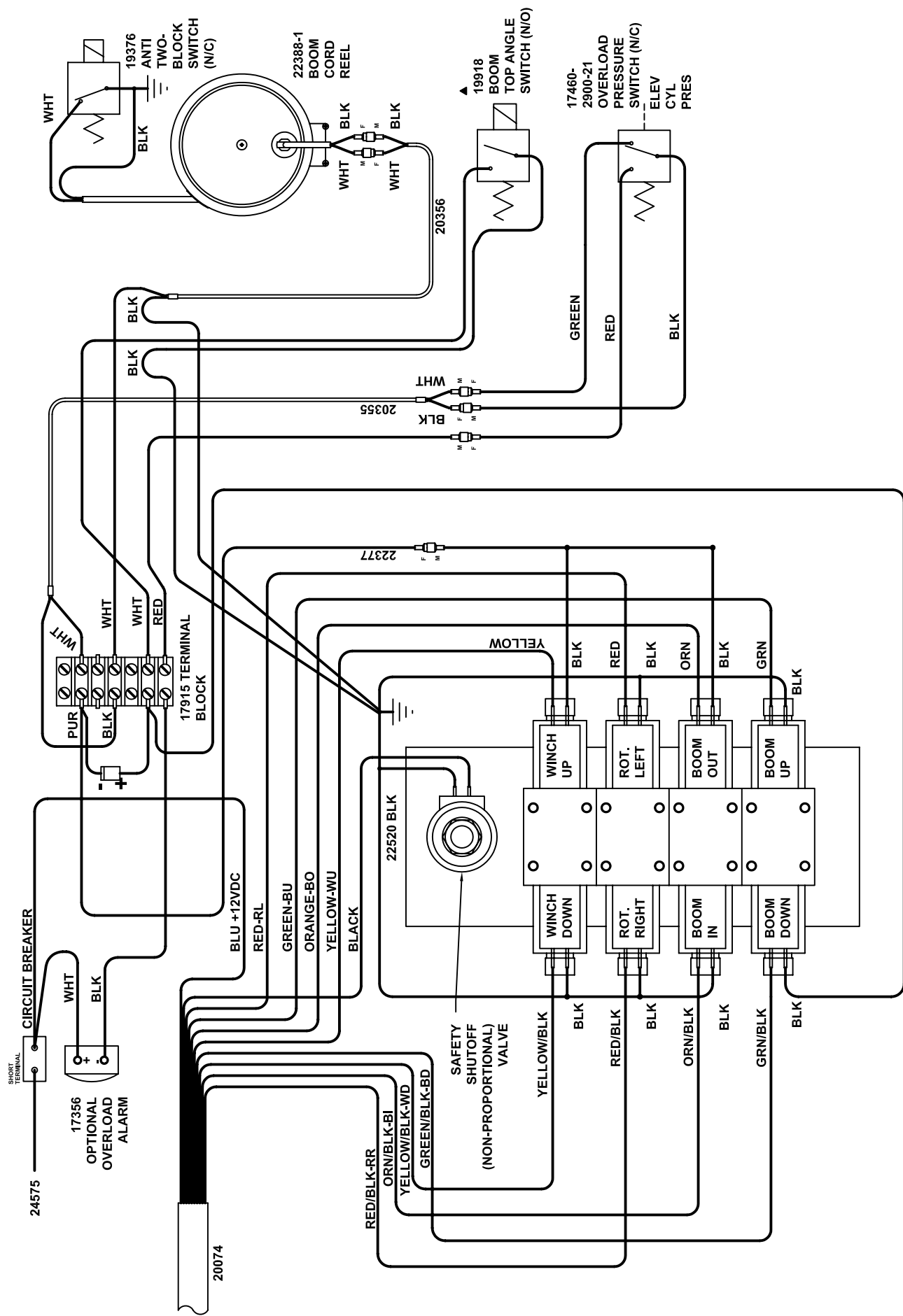
21276 ANTI-TWO-BLOCK SYSTEM

DATE
10-7-09D

SUPERSEDES
4-23-08C

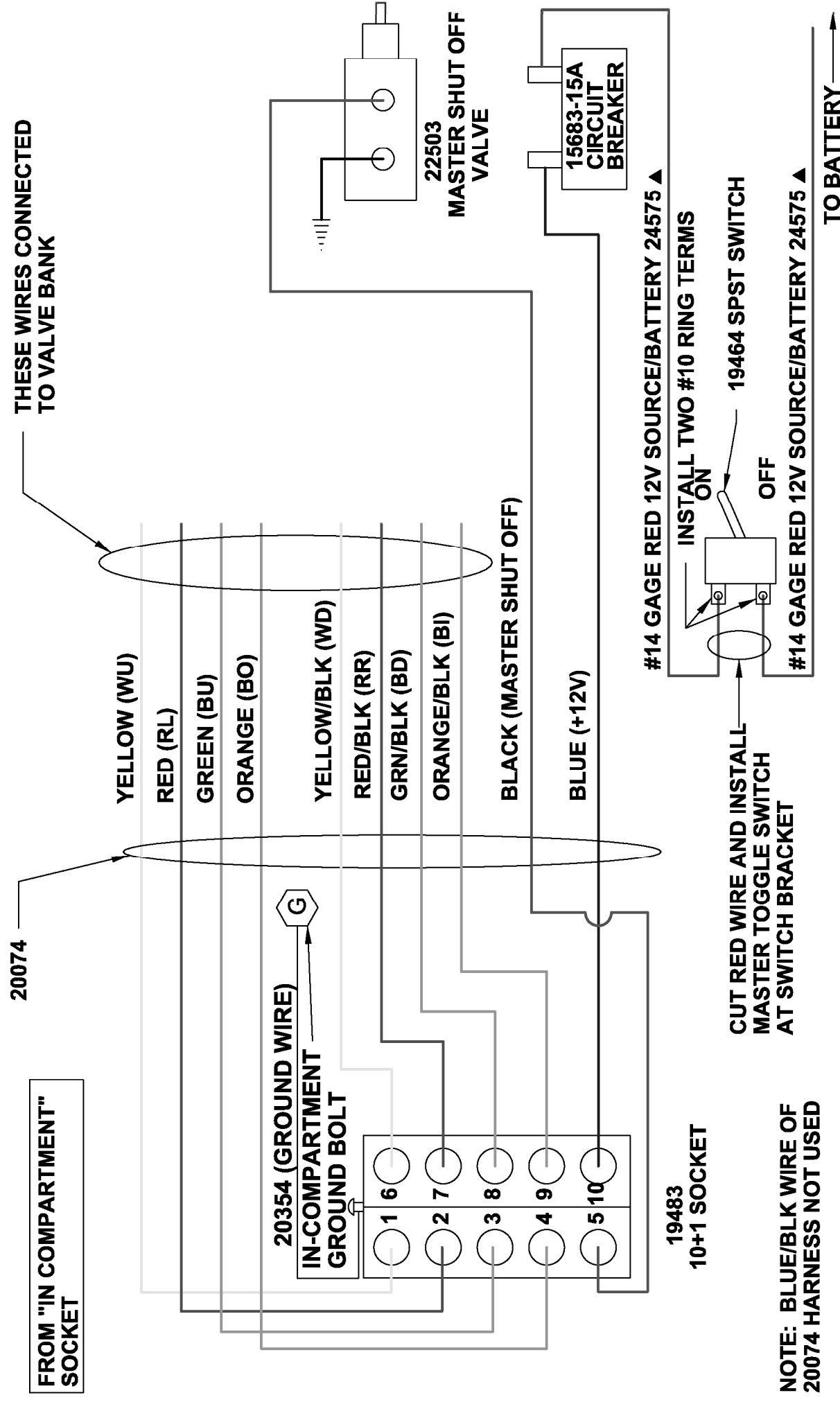
SECTION
C400

21275



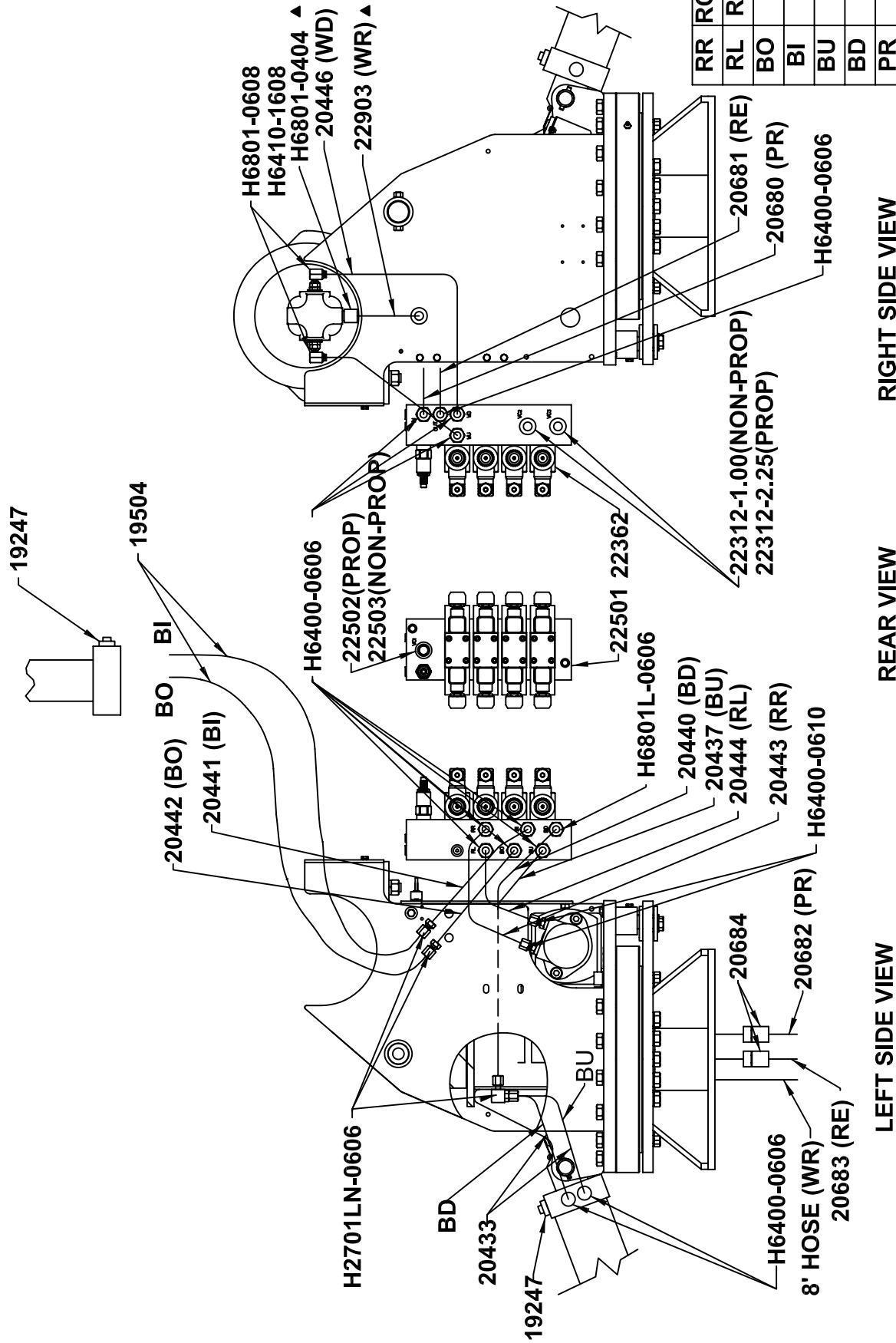
 MANUFACTURING, INC. CINCINNATI, OHIO	TITLE WIRING DIAGRAM		SECTION C400
	DATE 6-2-06C		SUPERSEDES 4-15-05B
	HT25/30KX - 4 FUNCTION STD		

NON-PROPORTIONAL IN-COMPARTMENT CONTROLS



**MANUFACTURING, INC.
CINCINNATI, OHIO**

TITLE	DATE	SECTION
NON-PROP W/ IN-COMPARTMENT CTRLS	4-12-05F	-
HT18/25/40/50 CRANES	SUPERSEDES 11-24-04E	20350



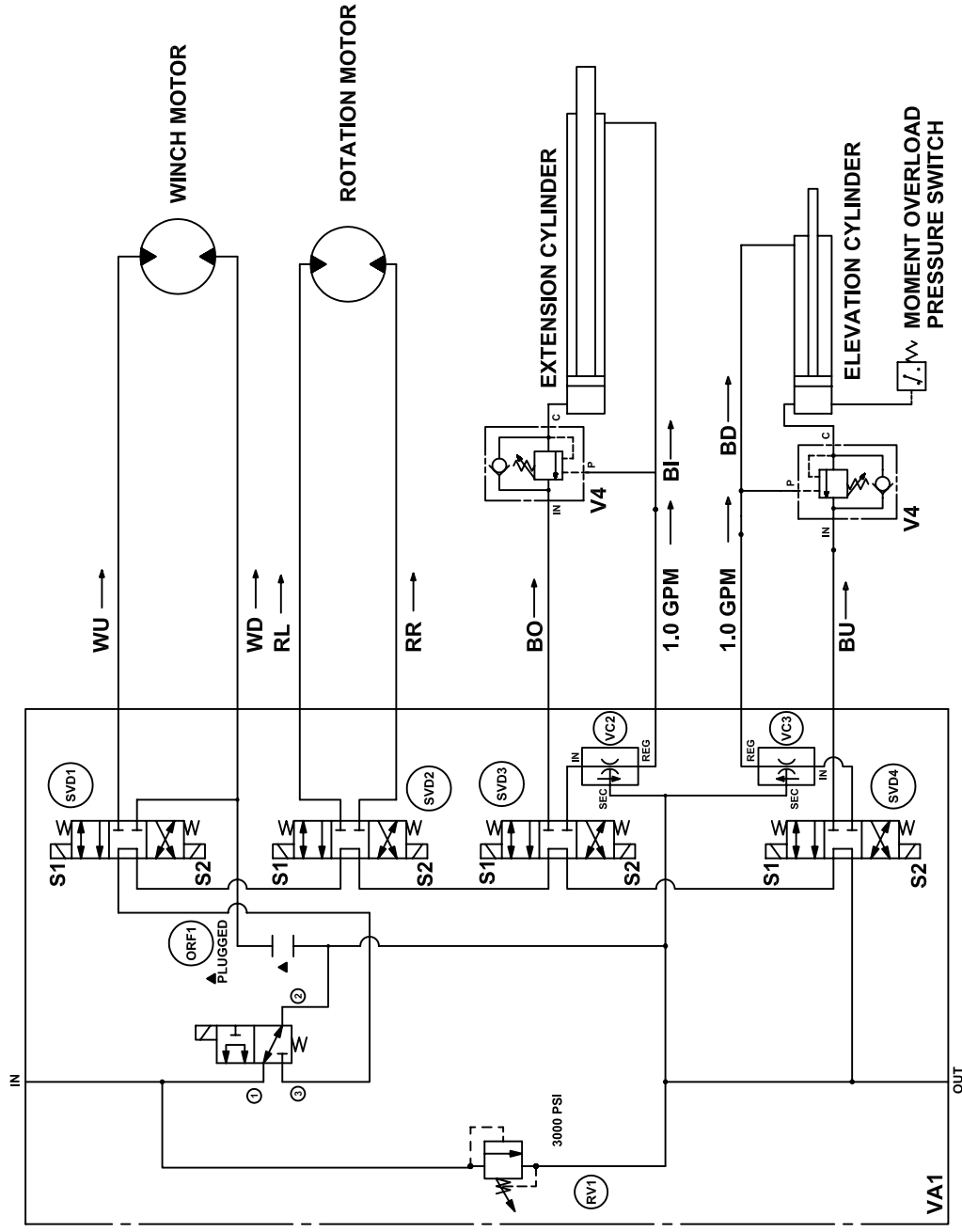
LEFT SIDE VIEW

REAR VIEW

RIGHT SIDE VIEW

RR	ROTATION RIGHT
RL	ROTATION LEFT
BO	BOOM OUT
BI	BOOM IN
BU	BOOM UP
BD	BOOM DOWN
PR	PRESSURE
RE	RETURN
WU	WINCH UP
WD	WINCH DOWN
WR	WINCH RELIEF

VENTURO MANUFACTURING, INC. CINCINNATI, OHIO	TITLE	DATE	SECTION
	REPLACEMENT PARTS DRAWING HT25KX HYDRAULIC COMPONENTS	7-21-08F 4-13-06E	C400 20692

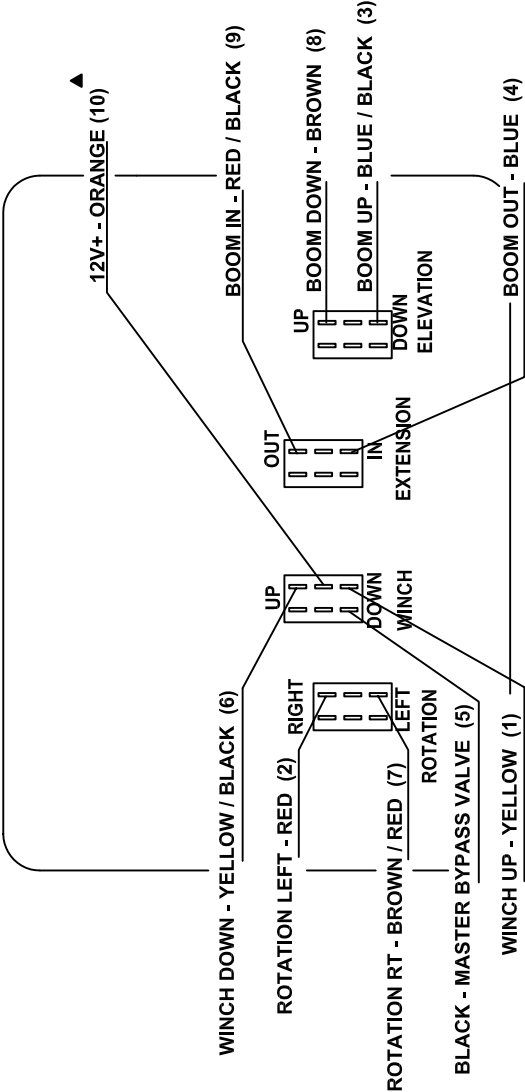


- | | |
|------|---|
| VA1 | CONTROL VALVE ASSY |
| RV1 | INLET RELIEF VALVE (3000 PSI) |
| SVD1 | 3 POSITION-4 WAY VALVE |
| SVD2 | 3 POSITION-4 WAY VALVE |
| SVD3 | 3 POSITION-4 WAY VALVE |
| SVD4 | 3 POSITION-4 WAY VALVE |
| VC1 | COUNTERBALANCE CARTRIDGE VALVE |
| VC2 | PROPORTIONAL CONTROL VALVE (SIMPLIFIED REP) |
| VC3 | PRIORITY FLOW REGULATOR VALVE |
| VC4 | PRIORITY FLOW REGULATOR VALVE |

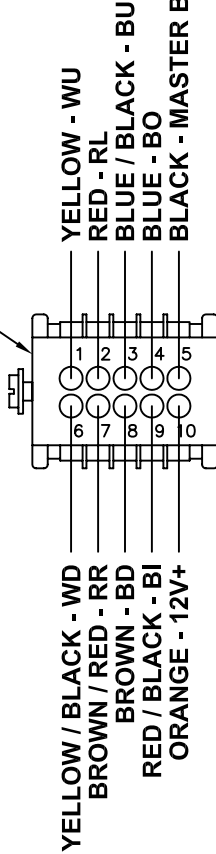
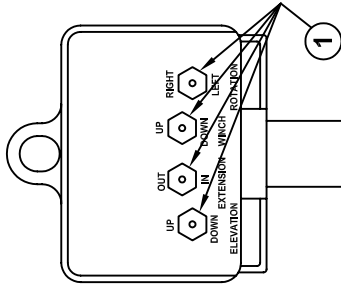
 MANUFACTURING, INC. CINCINNATI, OHIO	TITLE		HYDRAULIC SYSTEM DIAGRAM	
	DATE	7-21-08B	SECTION	C400
	SUPERSEDES	7-5-06A		19496
HT25KX WITH SAFETY SHUTOFF VALVE				

CORD REPLACEMENT INSTRUCTIONS

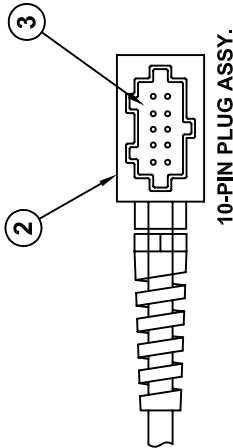
(INSIDE VIEW OF PENDANT CONTROL W/ REAR COVER REMOVED)



- NOTE 1)
WIRE TERMINALS TO BE INSTALLED 'AFTER'
ROUTING REPLACEMENT CORD ASSY THROUGH
PENDANT HEAD AND PLUG HOUSING.
- NOTE 2)
TOGGLE SWITCH JUMPER WIRES
NOT SHOWN FOR CLARITY.
- NOTE 3)
STOW OR CUT-BACK UNUSED WIRES.



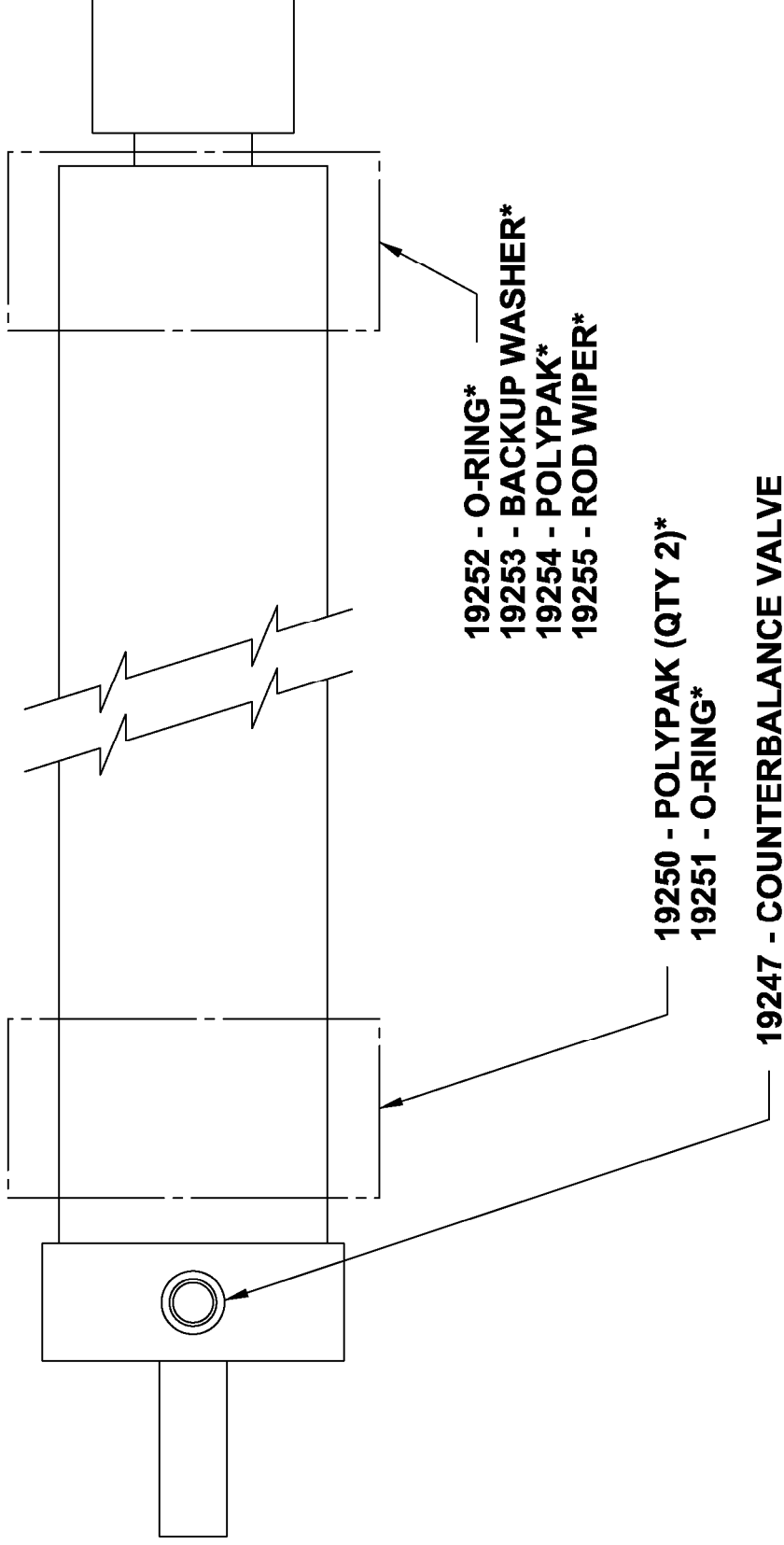
PLUG - BACKSIDE VIEW



ITEM	QTY	PART NO.	DESCRIPTION
4	1	22135	CORD ASSY. KIT
3	1	19427	MALE INSERT - 10 + 1 POLE
2	1	19426	PLUG CASE - 10 + 1 POLE
1	4	22152	DPDT MOMENTARY SWITCH

TITLE	DATE	SECTION
REPLACEMENT PARTS DRAWING	10-6-11C	C400
22062 PENDANT (STANDARD CTRL)	8-15-11B	SUPERSEDES
		22078

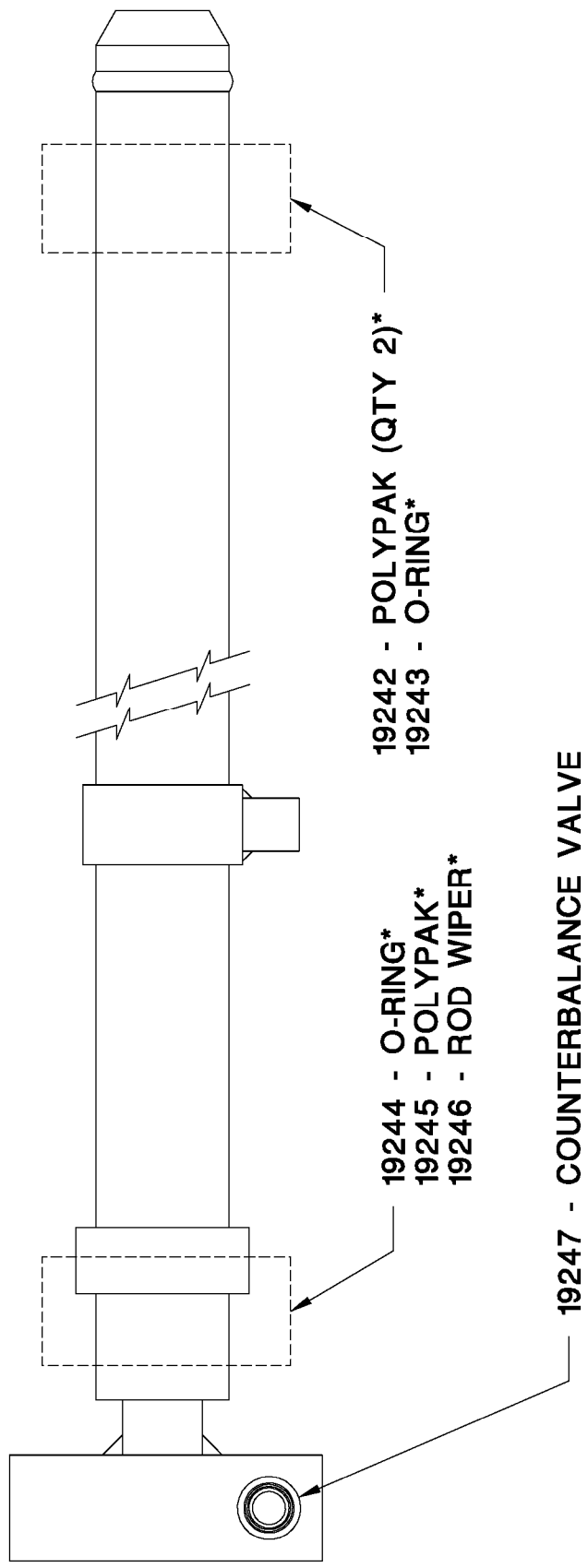
18930-1 ELEVATION CYLINDER



* ITEMS INCLUDED IN 18930-1-SK SEAL KIT

 MANUFACTURING, INC. CINCINNATI, OHIO	TITLE ELEVATION CYLINDER		DATE 10-15-97A	SECTION C400
	ET/HT25KX		SUPERSEDES 9-21-96	I19249

19886-1 EXTENSION CYLINDER

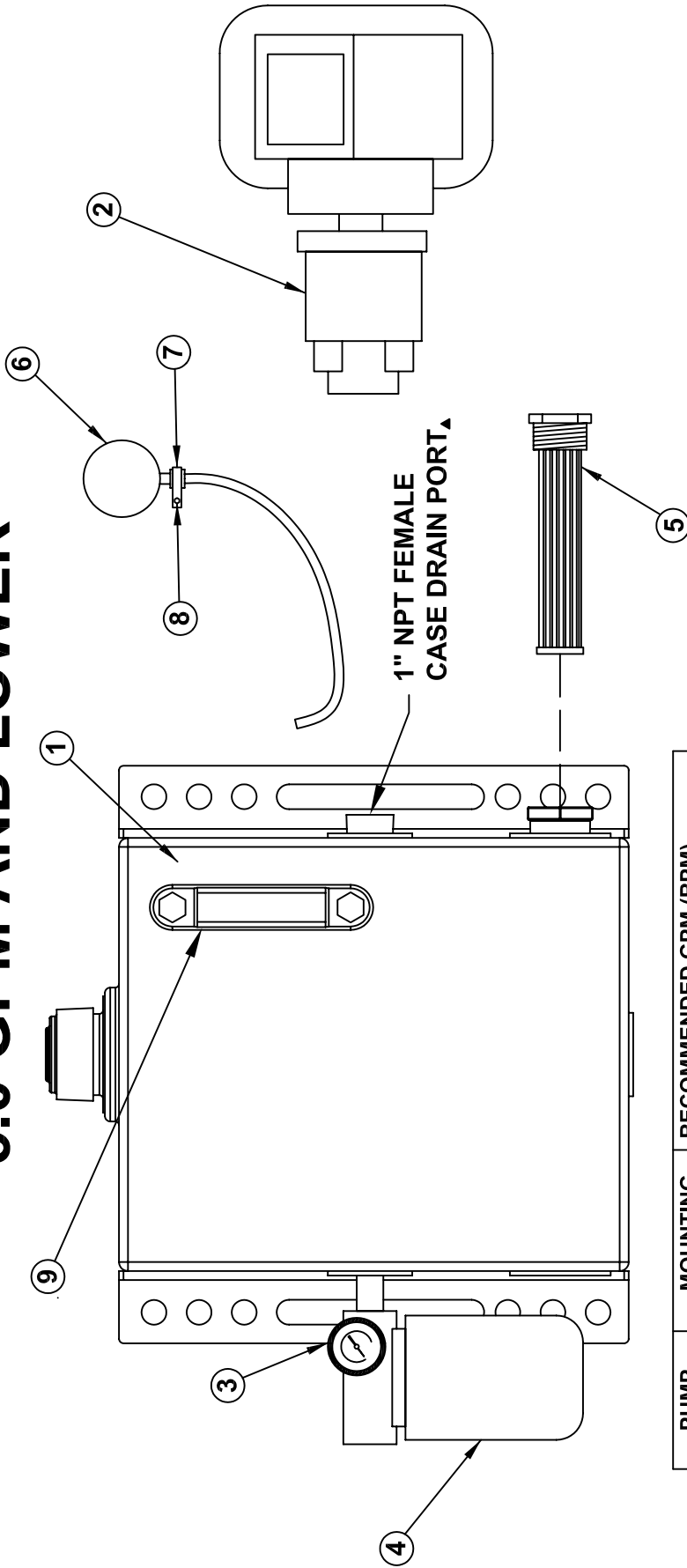


* ITEMS INCLUDED IN 19887 SEAL KIT

 VENTURO MANUFACTURING, INC. CINCINNATI, OHIO	TITLE EXTENSION CYLINDER		DATE 7-6-01	SECTION C400
	ET/HT25KX		SUPERSEDES -	19908

19294 PTO PACKAGES

5.0 GPM AND LOWER



PUMP	MOUNTING	RECOMMENDED GPM (RPM)
19296-1.60	SAE "A" 9 TOOTH SPLINED SHAFT	HT18 - STD. - 1.75 GPM (1110 RPM)
19296-2.64		HT25 - STD. - 2.00 GPM (1250 RPM)
19296-4.00		HT40 - STD. - 2.6 GPM (1000 RPM)
		HT50 - STD. - 3.0 GPM (1150 RPM)
		HT18 - PROP. - 3.5 GPM (875 RPM)
		HT25 - PROP. - 4.0 GPM (1000 RPM)

9	1	22184	SIGHT GLASS
8	1	!HWHS02520075-F	HEX WASHER HEAD 1/4-20 X 3/4 SELF TAPPING CLAMP
7	1	19275	
6	1	192730	PRESSURE GAUGE ASSEMBLY
5	1	19300	SUCTION SCREEN - 100 MESH
4	1	19298	FILTER ASSY, RETURN - 10 MICRON
3	1	19297	PRESSURE GAUGE - RETURN
2	1	SEE CHART	PTO PUMP - HT18/25/40/50KX
1	1	19295	RESERVOIR TANK - 10 GALLON
ITEM	QTY	PART NO.	DESCRIPTION

 MANUFACTURING, INC. CINCINNATI, OHIO	TITLE		DATE	SECTION
	REPLACEMENT PARTS DWG		11-5-08B	C400
	PTO KIT - HT18/25/40/50KX		SUPERSEDES 6-28-05A	22744

20668 DECAL KIT

PART NO.	QTY.	DESCRIPTION
14473-2	2	DECAL, GREASE
19314-1	1	DECAL, VALVE BANK LEFT
19314-2	1	DECAL, VALVE BANK RIGHT
22496	2	DECAL, VENTURO - LARGE
15401	1	DECAL, UNLAWFUL TO OPERATE
19257-1	1	DECAL, BOOM CAPACITY ET/HT25K(X) RIGHT
19257-2	1	DECAL, BOOM CAPACITY ET/HT25K(X) LEFT
19745	2	DECAL, MODEL NAME DECAL
15392	1	DECAL, DANGER ELECTROCUTION HAZARD
15391	1	DECAL, CRANE NOT PASSENGER LIFT
19315-1	1	DECAL, SAFETY SHUT OFF HYD BANK
15390	1	DECAL, CAUTION, INSTRUCTIONS
20346	1	INST. DWG DECAL PLACEMENT
20051	1	DECAL, ROTATION STOP LOCATION
20174	1	DECAL, GROUND CABLE ATTACH TO TRUCK FRAME



LIMITED WARRANTY POLICY

This limited policy warrants new products of Venturo be free from defects in material and workmanship for a period of one (1) year from date of original installation. This warranty covers:

- ◆ ***Repair or replacement of product***
- ◆ ***Labor to repair or replace product***
- ◆ ***Freight to return and/or replace product***

We shall not be liable for any contingent liabilities arising out of the improper function of any products. Warranty shall become void if the product is improperly installed, modified, damaged, abused or used for application other than intended use.

WARRANTY CLAIMS

Venturo Manufacturing, Inc. will make a good faith effort for prompt correction or other adjustment with respect to any product, which proves to be defective after our inspection and within the warranty period. Before any repairs are attempted or before returning any product, your Venturo Distributor is required to obtain a warranty claim number. This number is necessary for any claim to be considered. To obtain a warranty claim number, Venturo requires the model and serial number. Only authorized Venturo Distributors can perform warranty. For the name and address of your local Venturo Distributor call the **Warranty Claim Department – 513-772-8448**.

WARNING – It is the responsibility of the installer to insure the installation is completed according to the manufacturer's recommendations, insure the ultimate user understands how to operate product in a safe manner and understands the need for regular service and maintenance by an authorized Venturo Distributor. No modifications or alterations may be made to any Venturo products without the expressed written consent of the manufacturer. Reinstallation of any Venturo product must be done by an authorized Venturo Distributor, to the standards of the industry including maintenance, service and affixing of all instruction, safety and warning decals. Users should again be instructed as to the safe operation at time of delivery. Maintenance, service, operation and safety warning decals are available on request from Venturo Manufacturing, Inc.

VENTURO MANUFACTURING, INC

DIVISION OF COLLINS ASSOCIATES, INC
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