

PARTS & INSTALLATION MANUAL

25100-PHX(-LC)

Included in this manual:

25100-PHX(-LC)

- Stabilizer with Hydraulic Pullout and Hydraulic Legs
- Available in “Less Crosstube” (-LC) configuration

25100-PHX(-LC)

INST-25440 - 3/14/2024 (Rev: A0)

| | |
|---------------|---|
| 7607200A | SECTION 200: INSTALLATION |
| 25480 | INSTALLATION GUIDELINES |
| 25488 | ISOMETRIC VIEW - SHORT LEG |
| 25489 | OVERALL DIMENSIONS - SHORT LEG |
| 25490 | OVERALL DIMENSIONS - LONG LEG |
| 25484-2 | RECOMMENDED MOUNTING TO TRUCK FRAME |
| 25448 | SMALL PARTS IMAGE |
| 25447-1 | SELECTOR VALVE OVERVIEW |
| 25446 | HYDRAULIC MAPPING - 1 OF 2 |
| 25449 | HYDRAULIC MAPPING - 2 OF 2 |
| 25485 | DEPARTURE ANGLE, REAR-MOUNTED STABILIZERS |
| 25428-2 | MOUNTING THE LEGS |
| 25443 | LESS-CROSSTUBE ASSY - 1 OF 3 |
| 25444 | LESS-CROSSTUBE ASSY - 2 OF 3 |
| 25445 | LESS-CROSSTUBE ASSY - 3 OF 3 |
| 7607400A | SECTION 400: REPLACEMENT PARTS |
| 25442 | 25100-PHX REPLACEMENT PARTS LIST |
| 25441 | 25100-PHX REPLACEMENT PARTS DRAWING |
| 25451 | PULLOUT REPLACEMENT PARTS LIST |
| 25450 | PULLOUT REPLACEMENT PARTS DRAWING |
| 25452 | LEG REPLACEMENT PARTS LIST |
| 25453 | LEG REPLACEMENT PARTS DRAWING |
| 12-00073_VNT1 | WARRANTY PAGE |

SECTION 200

INSTALLATION



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STABILIZER INSTALLATION GUIDELINES

Read instructions completely prior to starting installation. If this unit is to be installed on a Venturo crane body, continue to the stabilizer assembly section of this manual.

Prior to mounting the stabilizer crosstube, orient the stabilizer so the longer pullout is on the crane side of the truck.

REAR MOUNTED

Crosstube should be centered at the rear of the truck and tied into the truck frame, body longills, and crane support. Installer is responsible for proper mounting brackets and hardware that will be needed during this process. If unit is to be mounted on a service body, do not attach crosstube to body sheet metal unless otherwise specified. Allow clearance between crosstube and body for the stabilizer legs to be fully retracted. Consult chassis up-fitter guide prior to installation for proper welding and bolting procedures to chassis.

See the 'RECOMMENDED MOUNTING TO TRUCK FRAME' page

Leg installation (refer to assembly section of manual) legs are adjustable to maintain proper ground penetration of 4" to 6". The stabilizer is designed to level the truck and not lift the chassis off of the ground. They are designed to work in conjunction with the chassis suspension to stabilize the unit with the bulk of the load being supported by the chassis suspension and tires. Tires must be set at the proper pressure according to the chassis manufacture, stabilizers fully extended, and legs deployed on firm, level ground prior to crane use.

IMPORTANT - When legs are fully retracted in the stowed position, a 15° degree departure angle between the bottom of the rear tire and the lowest point of the stabilizer is recommended.

See the 'DEPARTURE ANGLE' page

For hydraulic stabilizers, the control valve and selector valve are supplied in kit. It is the installer's responsibility to supply necessary hoses and fittings between these valves and stabilizer. Refer to proper hydraulic schematic for your particular stabilizer model.

IMPORTANT - The selector valve is designed to separate the crane and stabilizer hydraulic circuits. This will not allow stabilizer use while in crane mode.

FRONT MOUNTED

Front mounted crosstube will be located on top of the chassis frame and welded to body longills. Additional shear plates (installer supplied) to be welded to crosstube and bolted to chassis frame. Crosstube to be spaced away from body for leg clearance when fully retracted. See assembly section of manual for pullout and leg installation detail.



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INSTALLATION GUIDELINES

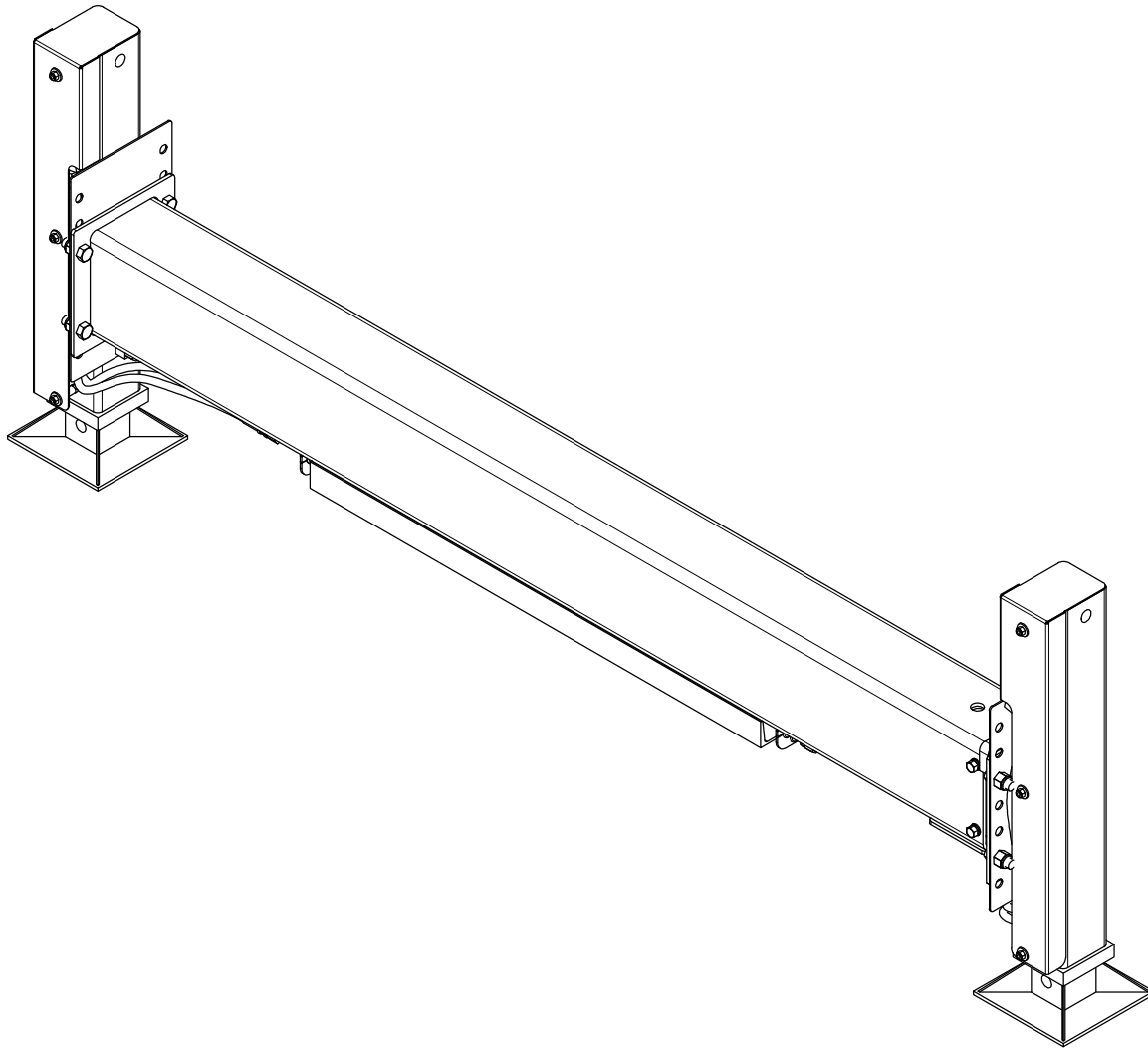
STABILIZERS

DATE
12-08-23A

SUPERSEDES
01-17-17

SECTION
C200

25480



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ISOMETRIC VIEW

25100-PHX OUTRIGGER (WITH SHORT LEGS)

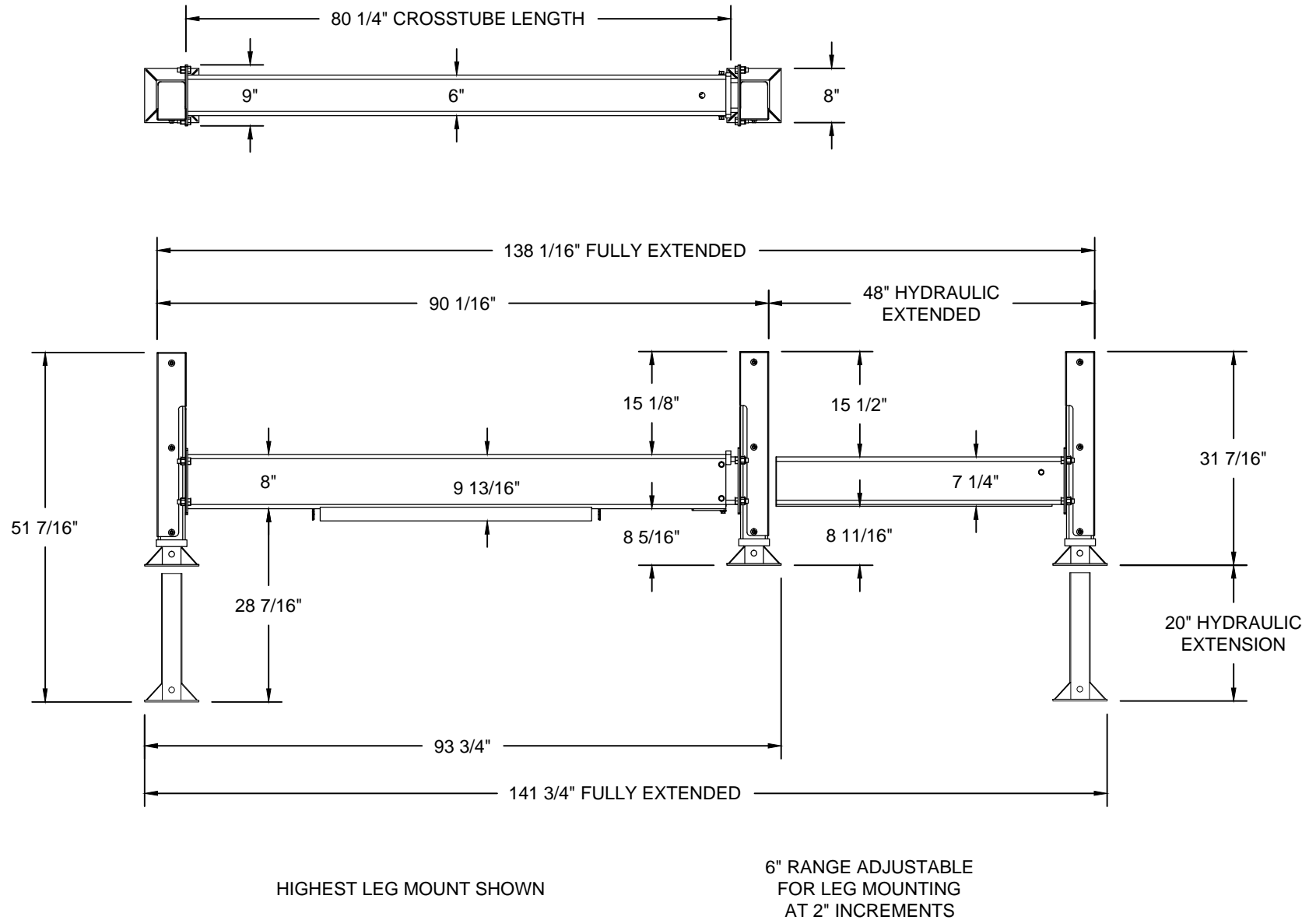
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PAGE

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25488



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OVERALL DIMENSIONS

25100-PHX OUTRIGGER WITH SHORT LEGS

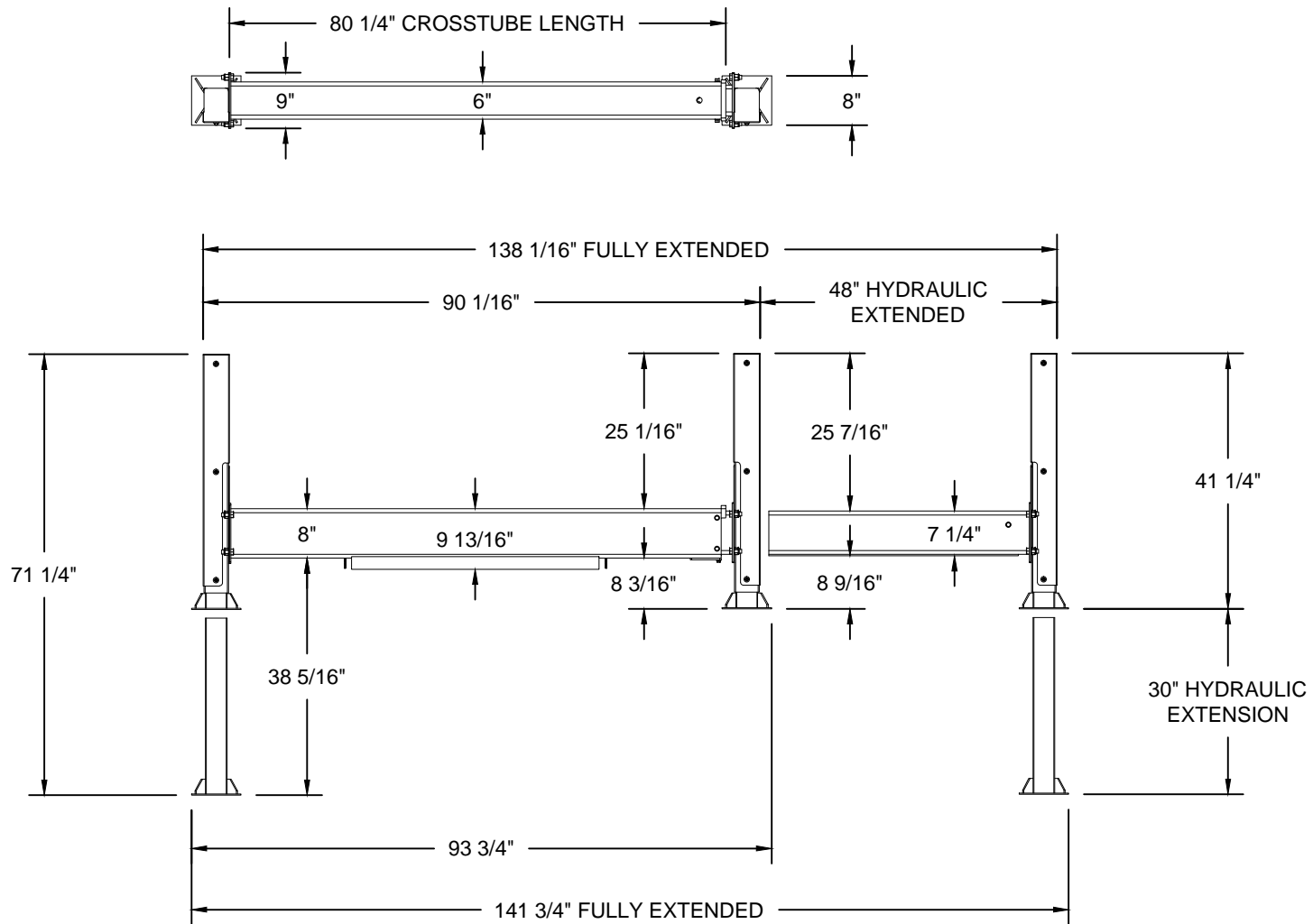
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SUPERSEDES
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PAGE

03

25489



HIGHEST LEG MOUNT SHOWN

6" RANGE ADJUSTABLE
FOR LEG MOUNTING
AT 2" INCREMENTS



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OVERALL DIMENSIONS

25100-PHX OUTRIGGER WITH LONG LEGS

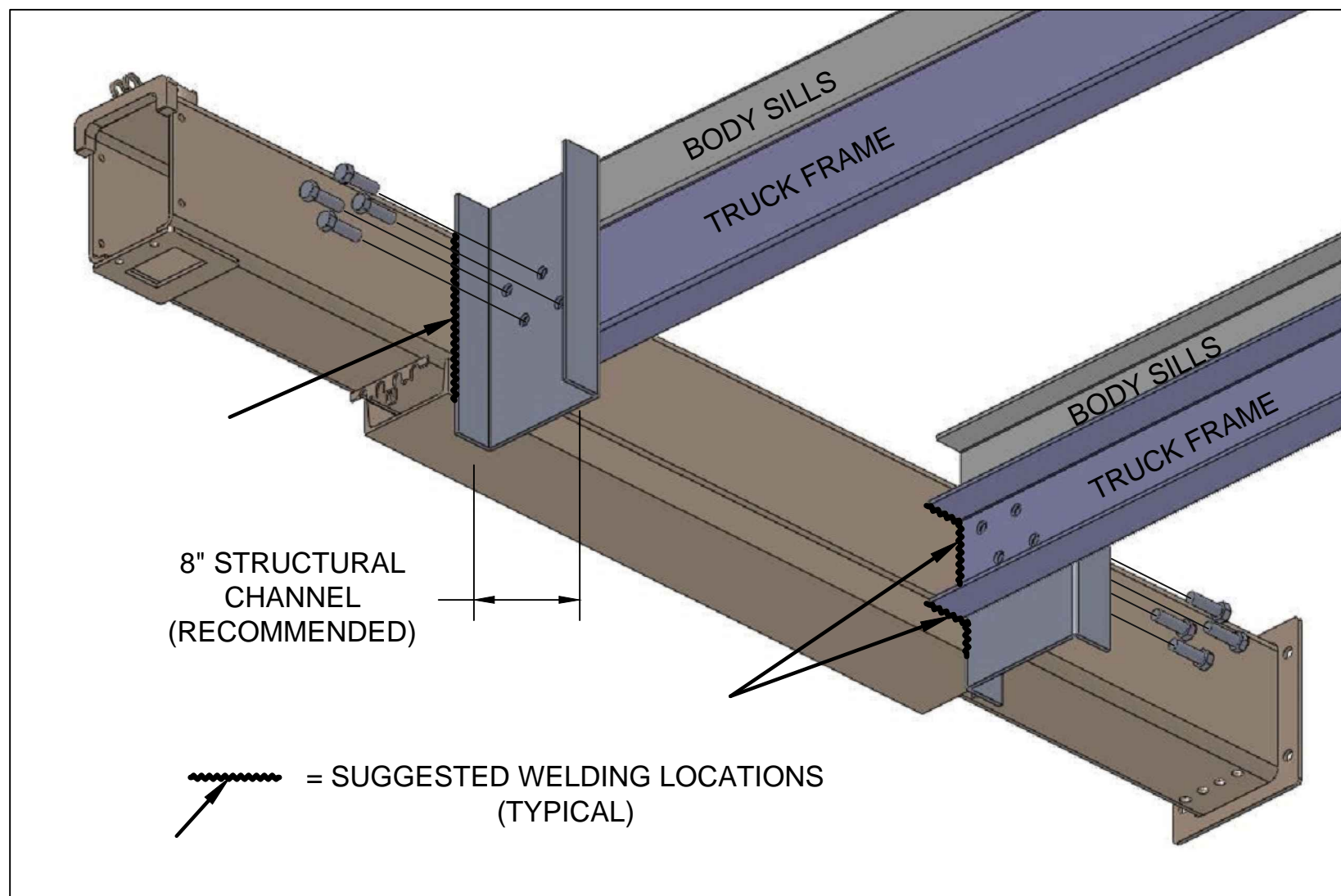
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PAGE

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25490



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RECOMMENDED MOUNTING TO TRUCK FRAME

25100/26100 SERIES STABILIZERS

DATE
12-08-23A

SUPERSEDES
01-20-17

SECTION
C200

25484-2



REFERENCE PAGE 15 FOR ITEM NUMBERS

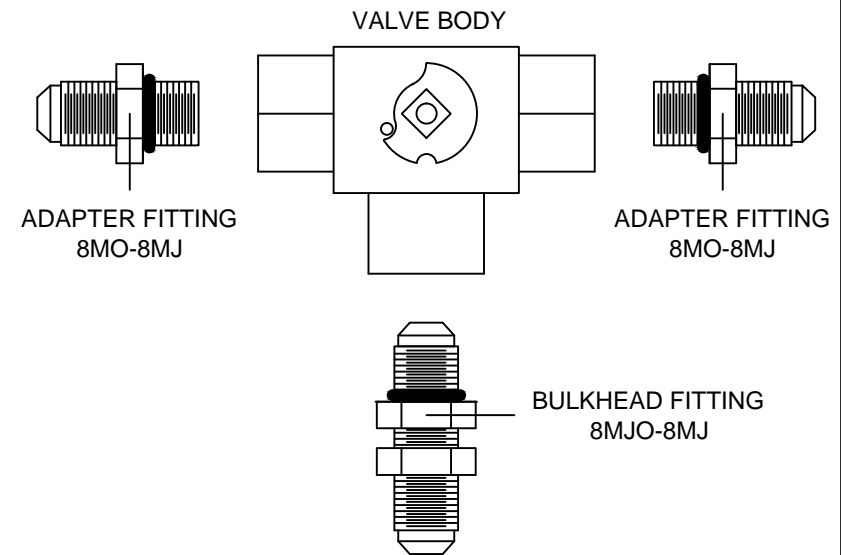
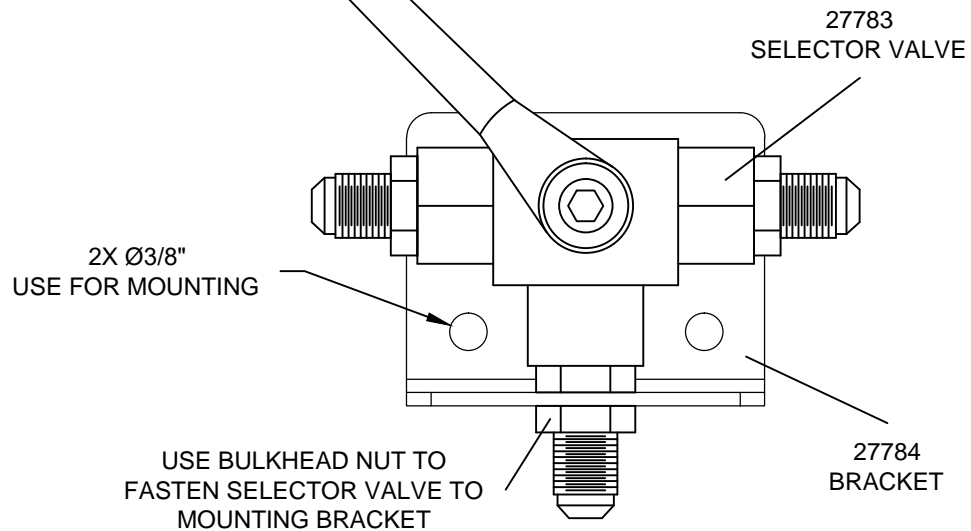
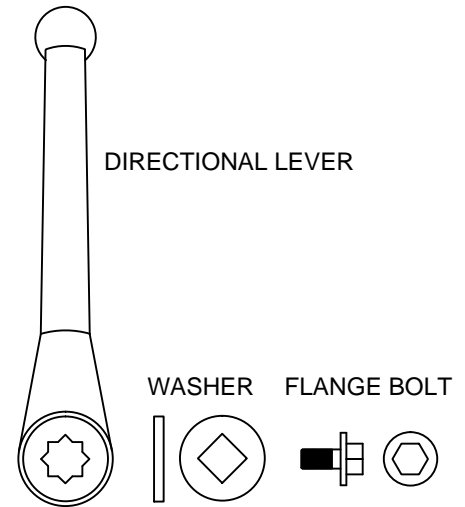
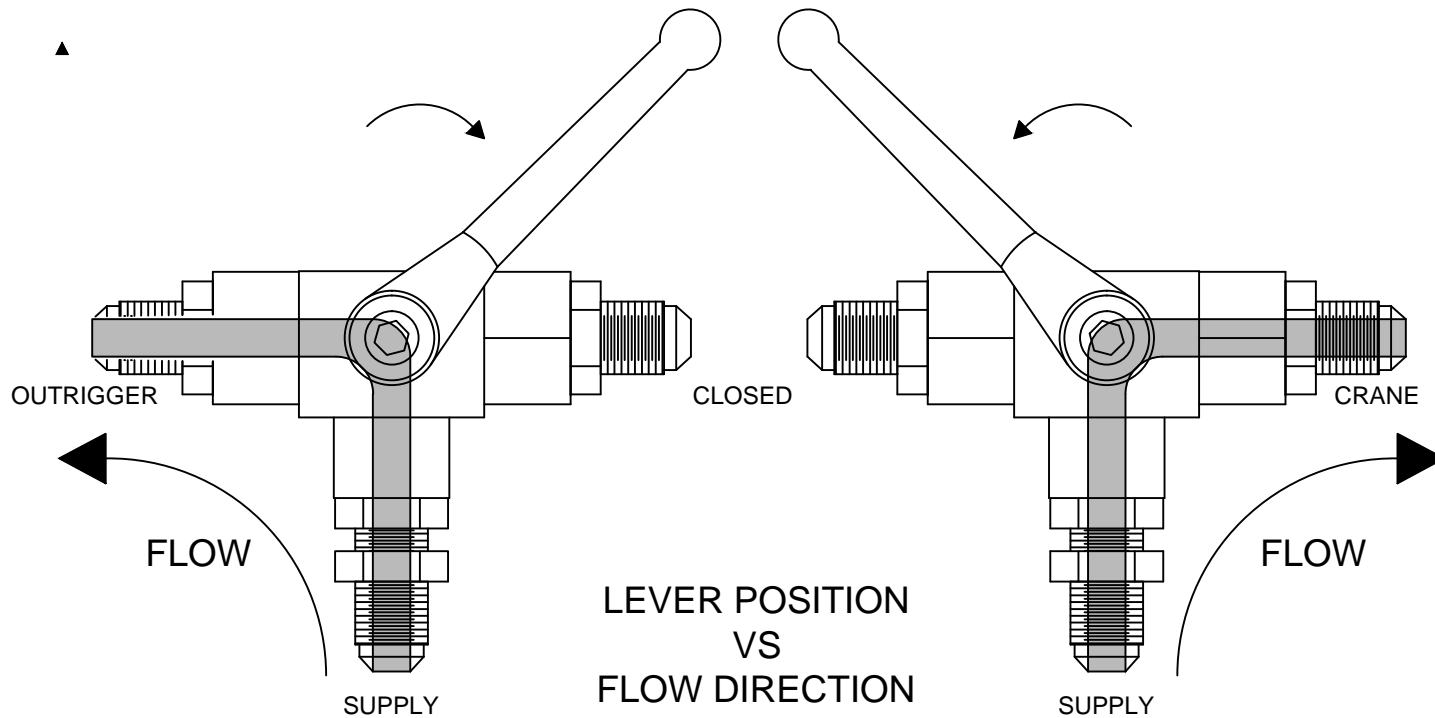


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SMALL PARTS IMAGE

25100-PHX OUTRIGGERS

| | | | |
|---|------------|-------|---|
| ▲ | DATE | PAGE | ▲ |
| | 01-20-17A | 06 | |
| ▲ | SUPERSEDES | | |
| | 03-11-16 | 25448 | |



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SELECTOR VALVE OVERVIEW

HYDRAULIC CRANES & STABILIZERS

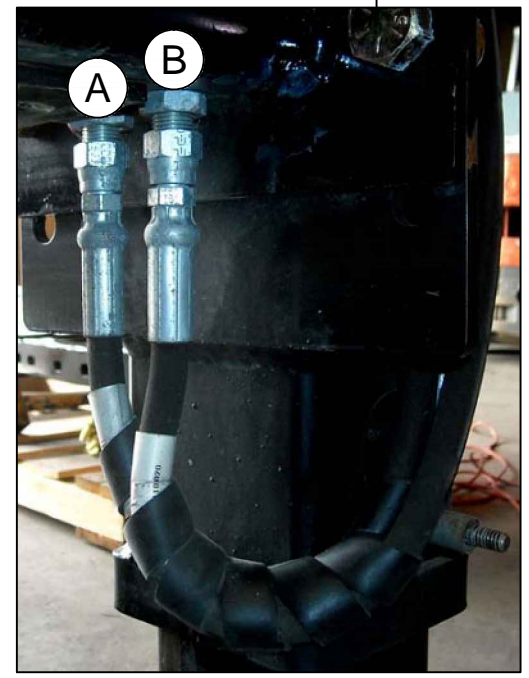
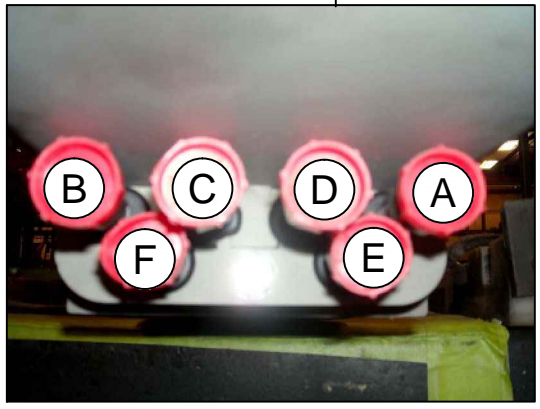
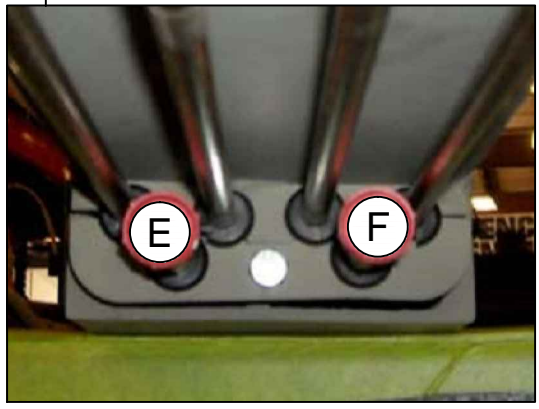
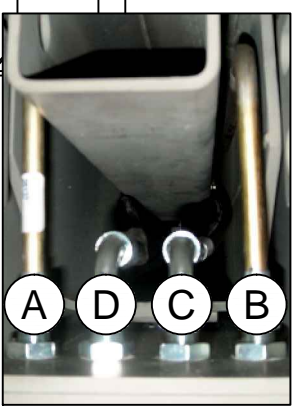
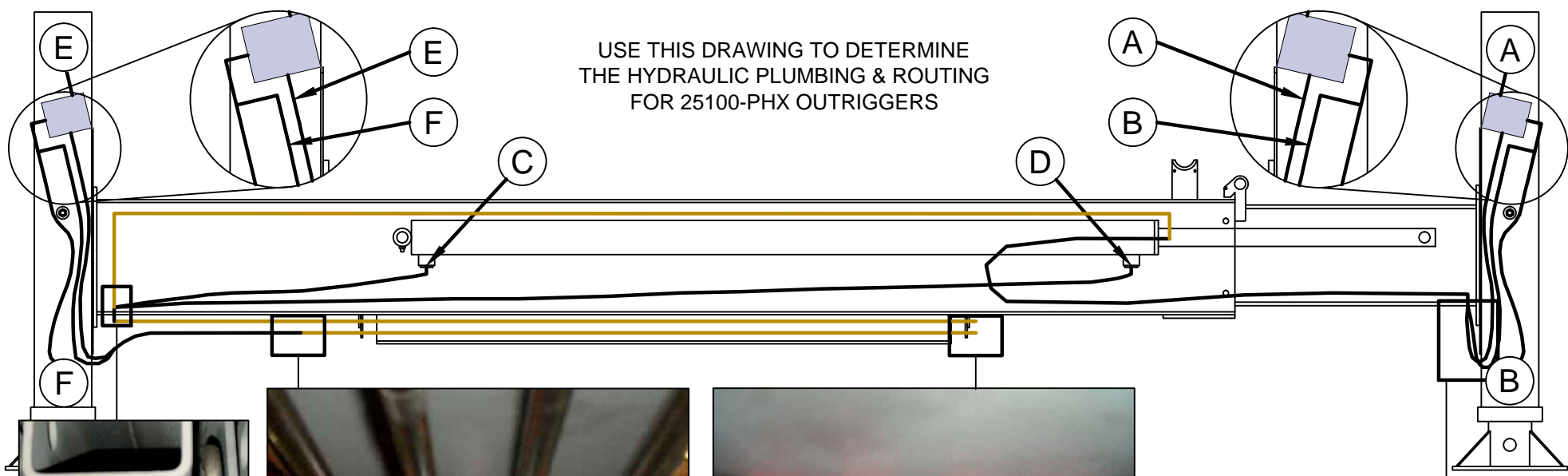
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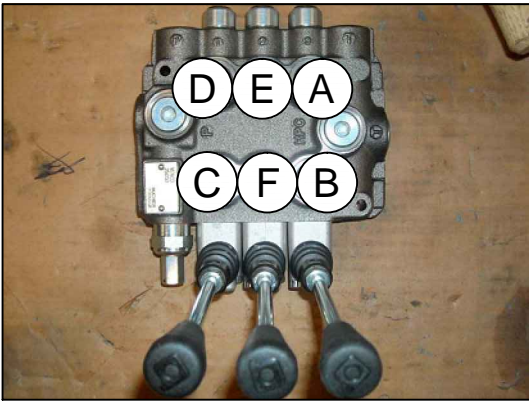
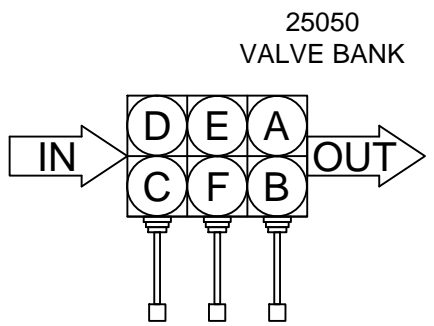
25447-1

USE THIS DRAWING TO DETERMINE
THE HYDRAULIC PLUMBING & ROUTING
FOR 25100-PHX OUTRIGGERS



OUTRIGGER FUNCTIONS

- A = RIGHT LEG DOWN
- B = RIGHT LEG UP
- C = PULLOUT OUT
- D = PULLOUT IN
- E = LEFT LEG DOWN
- F = LEFT LEG UP



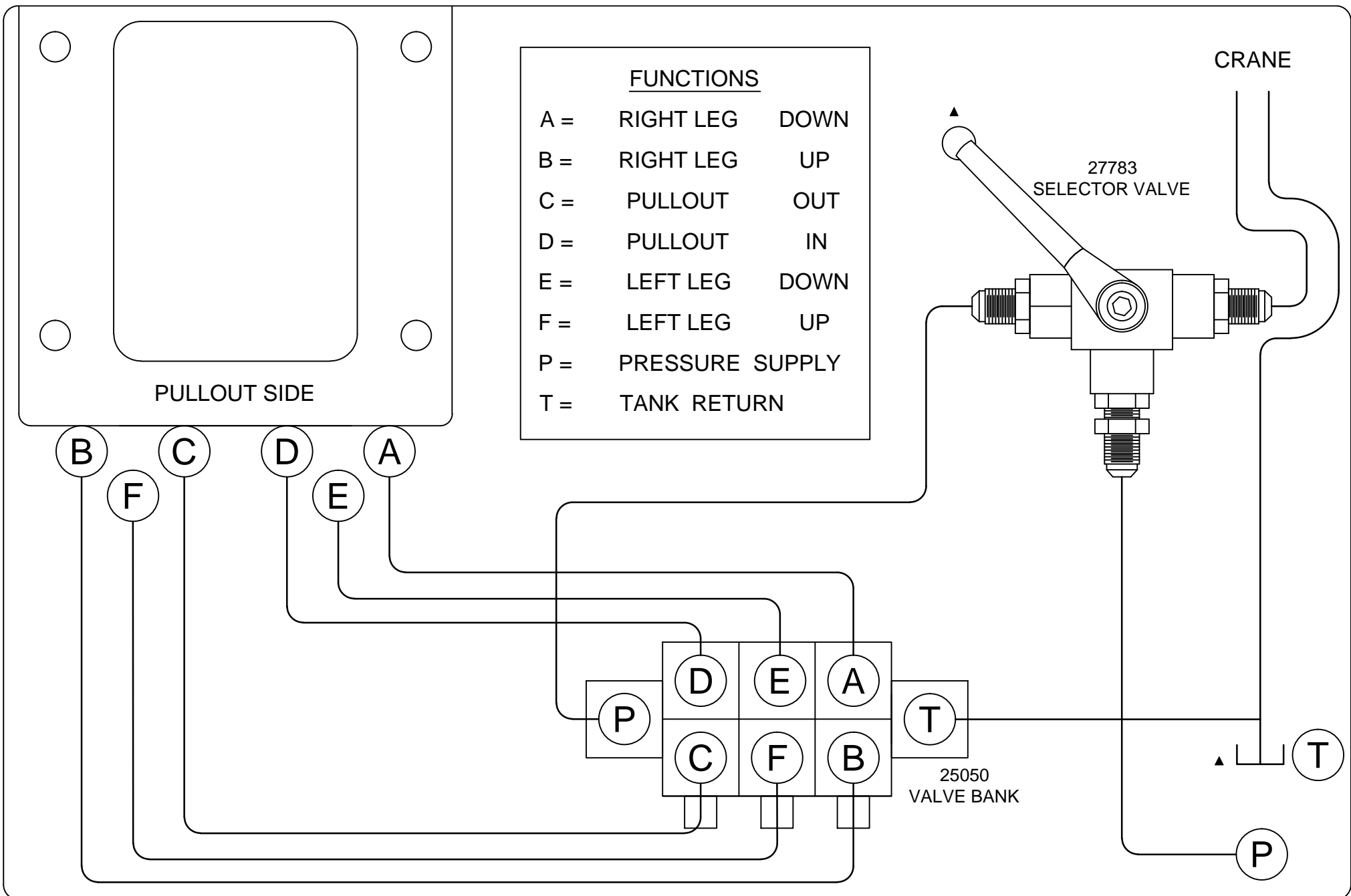
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HYDRAULIC MAPPING, 1 OF 2

25100-PHX OUTRIGGERS

DATE
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SUPERSEDES
03-17-16A

PAGE
08
25446



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HYDRAULIC MAPPING, 2 OF 2

25100 / 26100-PHX STABILIZERS ▲

DATE
12-08-23C

SUPERSEDES
01-23-17B

SECTION
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25449

RECOMMENDED DEPARTURE ANGLE



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RECOMMENDED DEPARTURE ANGLE

REAR MOUNTED OUTRIGGERS

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08-25-22A

SUPERSEDES
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PAGE

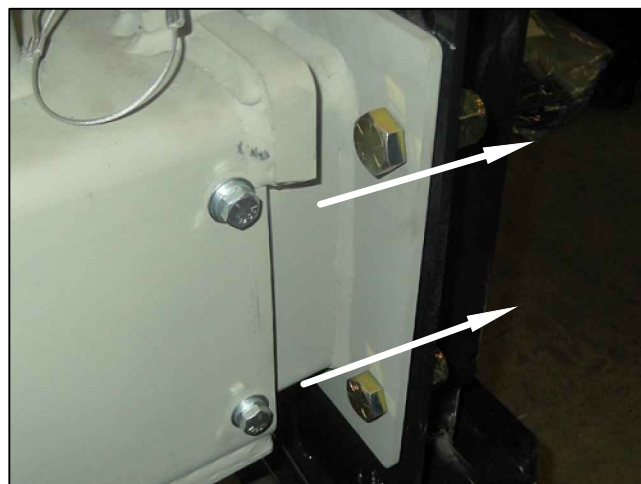
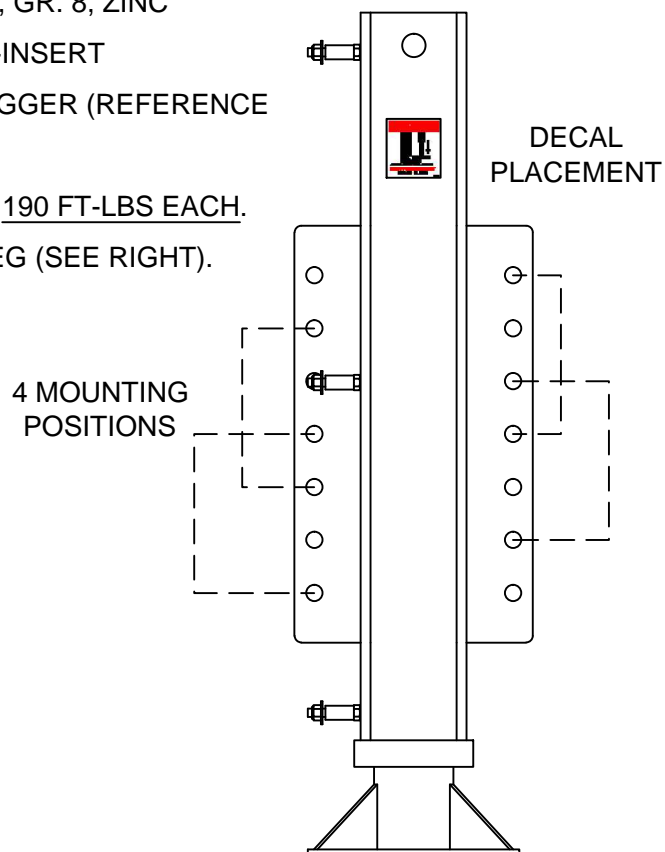
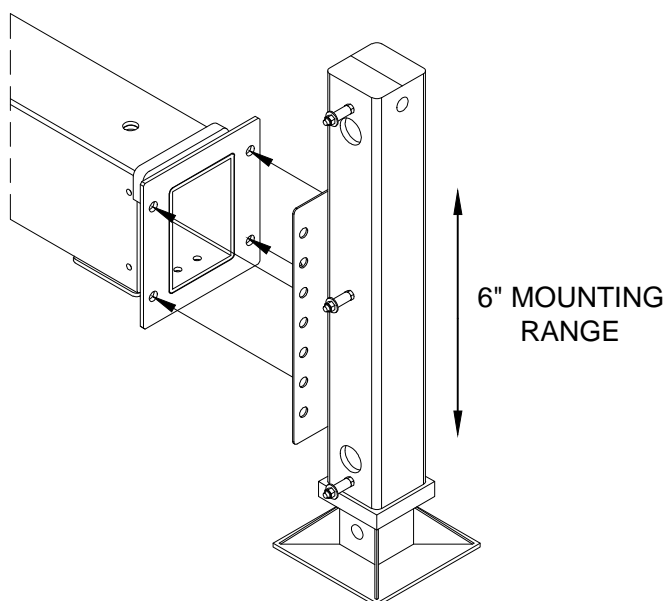
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25485

MOUNTING THE OUTRIGGER LEGS, 25100 SERIES OUTRIGGERS

FOLLOW INSTRUCTIONS FOR MOUNTING 25100 SERIES OUTRIGGER LEGS.

- ▲ 1. DETERMINE PLACEMENT OF OUTRIGGER LEGS. REFER TO MODEL SPECIFIC 'OVERALL DIMENSIONS' PAGE.
2. USE HARDWARE & FASTENERS PROVIDED (REFERENCE IMAGE BELOW):
 - [8] HEX HEAD CAP SCREW; 5/8-11 X 1-1/2", GR. 8, ZINC
 - [8] LOCK NUT; 5/8-11, GR. 8, ZINC, NYLON-INSERT
3. INSERT BOLTS POINTING AWAY FROM OUTRIGGER (REFERENCE IMAGE BELOW).
4. TORQUE OUTRIGGER LEG BOLTS & NUTS TO 190 FT-LBS EACH.
5. PLACE 24964 DANGER DECAL, [1] ON EACH LEG (SEE RIGHT).



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MOUNTING THE LEGS

25100 SERIES OUTRIGGERS

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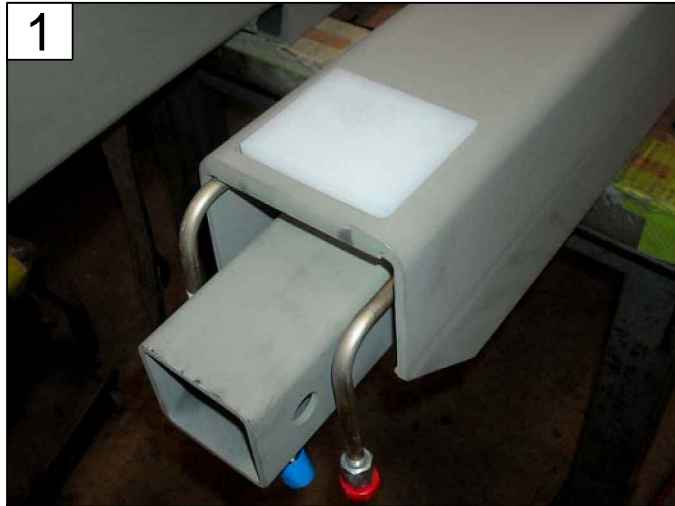
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PAGE

11

25428-2

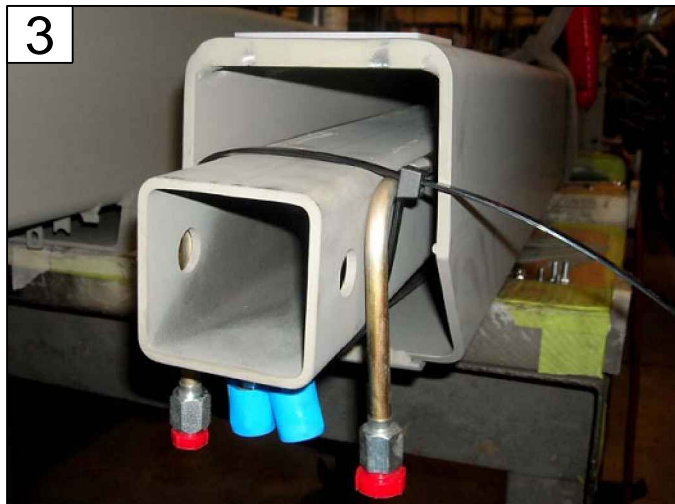
ASSEMBLY OF 25100-PHX OUTRIGGER WITH LESS-CROSSTUBE CONFIGURATION



PLACE [1] UHMW PAD ON PULLOUT
PAGE 15 - ITEM 1



PLACE [1] UHMW PAD IN CROSSTUBE
PAGE 15 - ITEM 1



ENSURE PULLOUT CYLINDER HOUSING
& PLUMBING ARE TIED



SLIDE PULLOUT INTO CROSSTUBE



FASTEN 25065 NUT BAR RETAINERS IN CROSSTUBE
PAGE 15 - ITEMS 2, 7, 8, & 9



FASTEN 25077 NUT BAR RETAINER IN CROSSTUBE
PAGE 15 - ITEMS 3, 4, 5, & 6



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LESS-CROSSTUBE ASSY

25100-PHX OUTRIGGERS

DATE
01-23-17A

SUPERSEDES
03-11-16

PAGE
12

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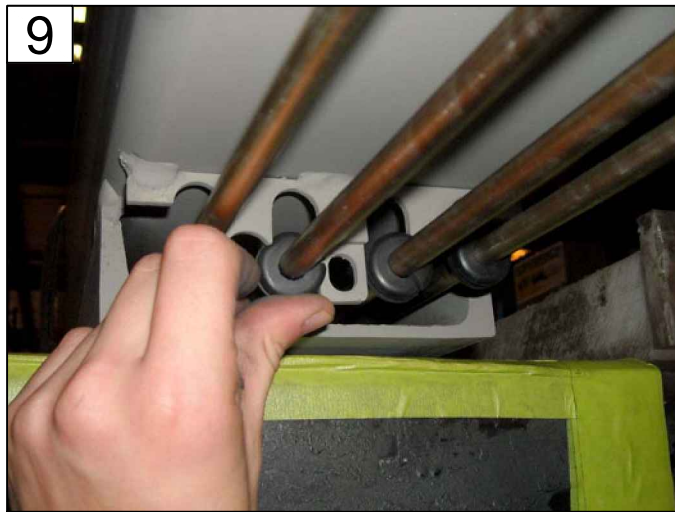
ASSEMBLY OF 25100-PHX OUTRIGGER WITH LESS-CROSSTUBE CONFIGURATION



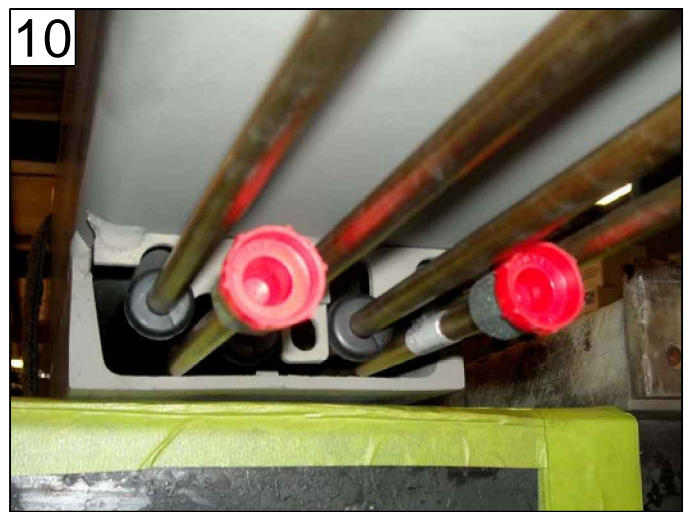
FASTEN BULKHEADS - SEE NEXT STEP'S IMAGE
PAGE 15 - ITEM 12



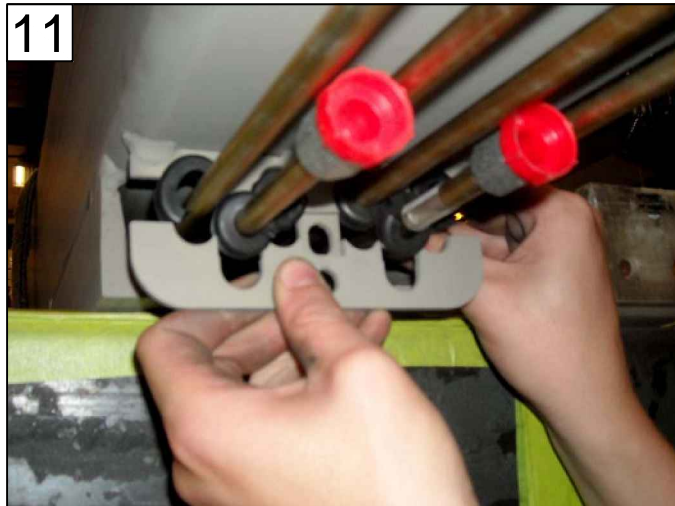
FASTEN 25138 TUBES TO BULKHEADS
PAGE 15 - ITEM 13



PUSH GROMMETS AROUND TUBES
PAGE 15 - ITEM 15



PLACE 25139 TUBES
PAGE 15 - ITEM 14



CLAMP AROUND GROMMETS
PAGE 15 - ITEM 16



FASTEN CLAMP, PAGE 15 - ITEMS 4 & 17
REPEAT STEPS 9 TO 11 FOR OPPOSITE CLAMP



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LESS-CROSSTUBE ASSY

25100-PHX OUTRIGGERS

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01-23-17A

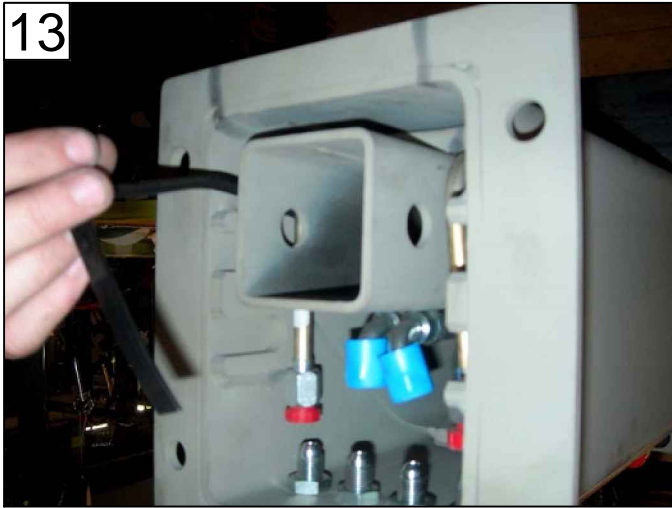
SUPERSEDES
03-11-16

PAGE
13

25444

ASSEMBLY OF 25100-PHX OUTRIGGER WITH LESS-CROSSTUBE CONFIGURATION

13



UNTIE PULLOUT CYLINDER HOUSING & PLUMBING

14



SEE HYDRAULIC MAPPING
PAGES 8 & 9

15



INSERT SHAFT & COLLARS INTO CYLINDER HOUSING

16



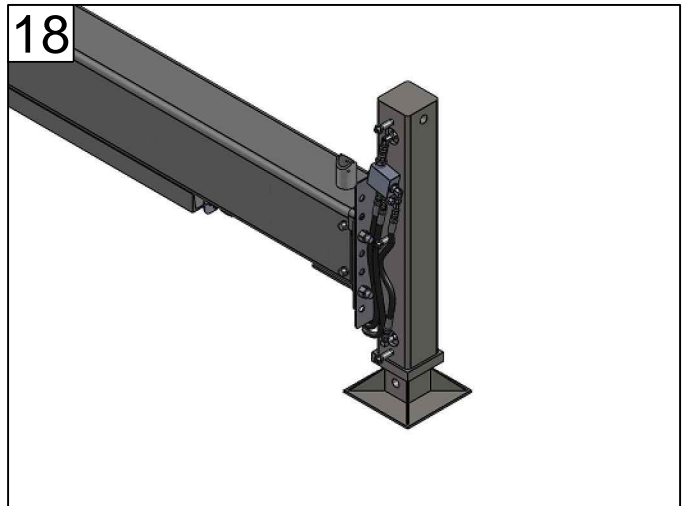
PUSH SHAFT INTO TOP SLOT OF CROSSTUBE

17



WITH CYLINDER HOUSING CENTERED
LOCTITE & FASTEN COLLARS FLUSH

18



PROCEED TO MOUNTING OF LEGS
& HYDRAULICS



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LESS-CROSSTUBE ASSY

25100-PHX OUTRIGGERS

DATE
01-23-17A

SUPERSEDES
03-11-16

PAGE

14

25445

SECTION 400

REPLACEMENT PARTS



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PARTS BREAKDOWN, 25100-PHX OUTRIGGERS (LESS-CROSSTUBE PARTS INCLUDED)

| 25100-PHX OUTRIGGERS PARTS BREAKDOWN | | SHORT LEGS | LONG LEGS | LESS-CROSSTUBE PARTS INCLUDED |
|---|---|------------|-----------|----------------------------------|
| # | DESCRIPTION | QTY | | PART # |
| 1 | UHMW PAD; 3-1/8 X 3-1/2 X 3/8 | 2 | 2 | 25081 |
| 2 | NUT BAR RETAINER | 2 | 2 | 25065 |
| 3 | NUT BAR RETAINER | 1 | 1 | 25077 |
| 4 | HEX HEAD CAP SCREW; 5/16-18 X 3/4, GR. 5 | 4 | 4 | !HHCS03118075 |
| 5 | LOCK WASHER; 5/16, GR. 5 | 2 | 2 | !LWSH-031 |
| 6 | FLAT WASHER; 5/16, GR. 5 | 2 | 2 | !FWSH-031 |
| 7 | HEX HEAD CAP SCREW; 3/8-16 X 5/8, GR. 5 | 4 | 4 | !HHCS03816063 |
| 8 | LOCK WASHER; 3/8, GR. 5 | 4 | 4 | !LWSH-038 |
| 9 | FLAT WASHER; 3/8, GR. 5 | 4 | 4 | !FWSH-038SAE |
| 10 | HEX HEAD CAP SCREW; 5/8-11 X 1-1/2, GR. 8 | 8 | 8 | !HHCS06311150-8 |
| 11 | LOCK NUT; 5/8-11, GR. 8, NYLON INSERT | 8 | 8 | !LNUT063111-8 |
| 12 | ADAPTER FITTING; 90° BULKHEAD, 6MJ-6MJ | 4 | 4 | H2701-0606 |
| 13 | HYDRAULIC TUBE, 60" | 4 | 4 | 25138 |
| 14 | HYDRAULIC TUBE, 47" | 2 | 2 | 25139 |
| 15 | GROMMETS, HYDRAULIC TUBES | 12 | 12 | 14883 |
| 16 | CROSSTUBE CLAMP PLATE | 2 | 2 | 25157 |
| 17 | LOCK NUT; 5/16-18, GR.5, NYLON INSERT | 2 | 2 | !LNUT03118 |
| 18 | SHAFT COLLARS | 2 | 2 | 00210 |
| 19 | SHAFT, CYLINDER HOUSING | 1 | 1 | 25051 |
| 20 | DECAL; DANGER, CRUSHING INJURY | 2 | 2 | 24964 |
| 21 | HYDRAULIC LEG; SHORT, LEFT, 25100 O.R. | 1 | - | SEE PAGES 19 & 20 |
| 22 | HYDRAULIC LEG; SHORT, RIGHT, 25100 O.R. | 1 | - | SEE PAGES 19 & 20 |
| 23 | HYDRAULIC LEG; LONG, LEFT, 25100 O.R. | - | 1 | SEE PAGES 19 & 20 |
| 24 | HYDRAULIC LEG; LONG, RIGHT, 25100 O.R. | - | 1 | SEE PAGES 19 & 20 |
| 25 | VALVE BLOCK, 3-SPOOL | 1 | 1 | 25050 |
| 26 | ADAPTER FITTING; STRAIGHT, 8MJ-8MO | 2 | 2 | H6400-0808 |
| 27 | ADAPTER FITTING; STRAIGHT, 6MJ-8MO | 6 | 6 | H6400-0608 |
| 28 | SELECTOR VALVE | 1 | 1 | 27783 |
| 29 | BRACKET, SELECTOR VALVE | 1 | 1 | 27784 |
| 30 | OUTRIGGER & ACCESSORIES MANUAL | 1 | 1 | INST-21024 |
| 31 | CROSSTUBE; 25100 SERIES OUTRIGGERS | 1 | 1 | 25085-2 ▲ |



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PARTS BREAKDOWN

25100-PHX OUTRIGGERS

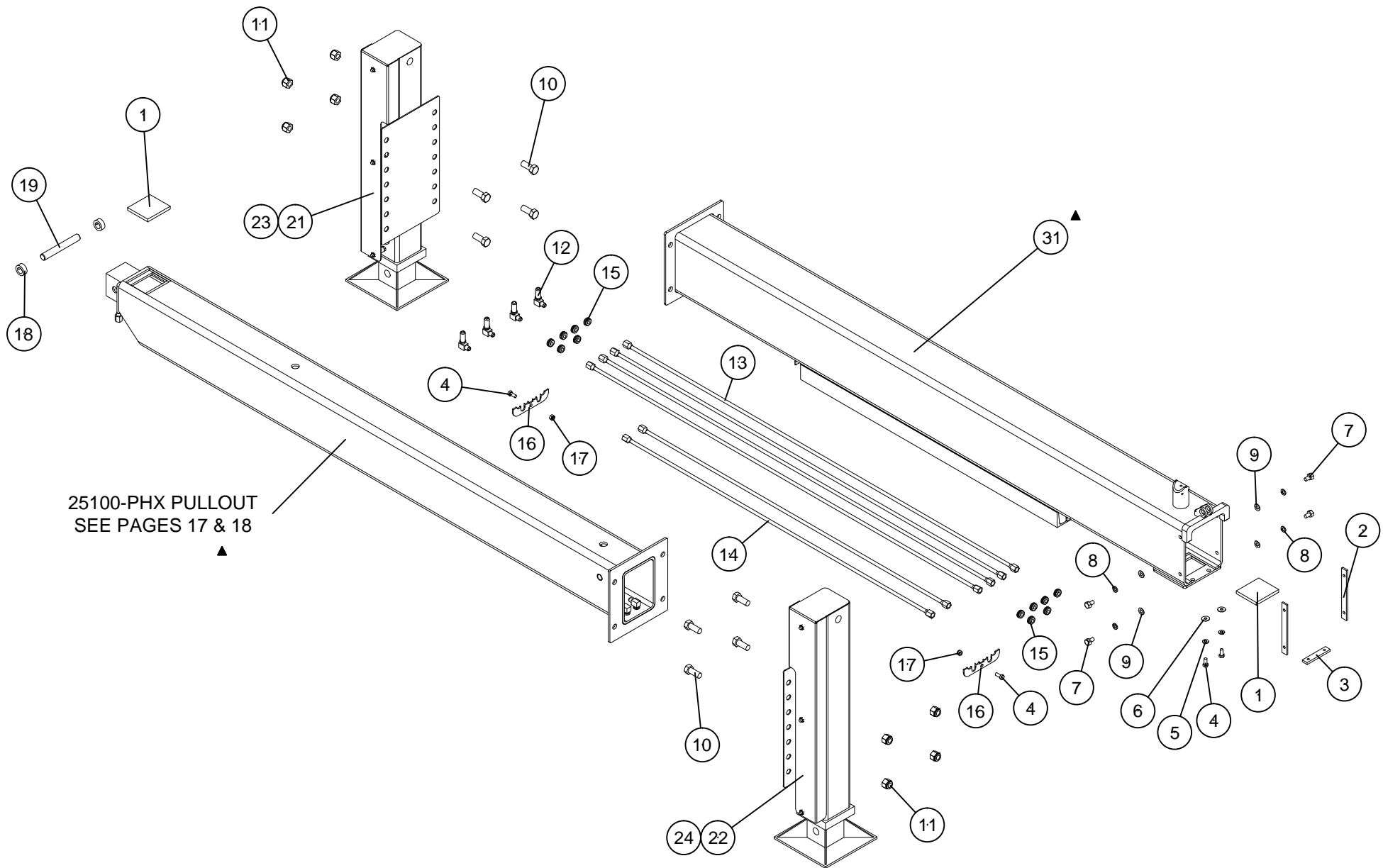
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PAGE

15

25442



REFERENCE PAGE 15 FOR ITEM NUMBERS ▲



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PARTS BREAKDOWN (LESS-CROSSTUBE PARTS INCLUDED) ▲

25100-PHX OUTRIGGERS ▲

DATE
01-23-17A

SUPERSEDES
03-11-16

PAGE

16

25441

| 25100-PHX PULLOUT ASSEMBLY PARTS BREAKDOWN | | | |
|--|--|-----|--------------|
| # | DESCRIPTION | QTY | PART # |
| 1 | PULLOUT; 4', 25100-PHX OUTRIGGERS | 1 | 25087-2 |
| 2 | EXTENSION CYLINDER; 4', 25100-PHX | 1 | 25086 |
| 3 | HOUSING; EXTENSION CYLINDER BASE-END | 1 | 25088 |
| 4 | HYDRAULIC TUBE; RIGHT LEG, DOWN | 1 | 25137 |
| 5 | HYDRAULIC TUBE; RIGHT LEG, UP | 1 | 25136 |
| 6 | HOSE ASSEMBLY; RIGHT LEG, UP & DOWN | 2 | 25149 |
| 7 | HOSE ASSEMBLY; CYLINDER, OUT | 1 | 25154 |
| 8 | HOSE ASSEMBLY; CYLINDER, IN | 1 | 25155 |
| 9 | SHAFT; CYLINDER & HOUSING, BASE-END | 1 | 25049 |
| 10 | SNAP RING; 3/4", PLATED | 2 | !SRNG-075 |
| 11 | SHAFT; CYLINDER & PULLOUT, ROD-END | 1 | 25052 |
| 12 | LOCK COLLARS; 3/4" I.D., 1-1/4" O.D. | 4 | 00210 |
| 13 | BULKHEAD FITTINGS; 90°, 6MJ-6MJ, L-NUT | 2 | H2701LN-0606 |



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PARTS BREAKDOWN

25100-PHX PULLOUT ASSY

DATE

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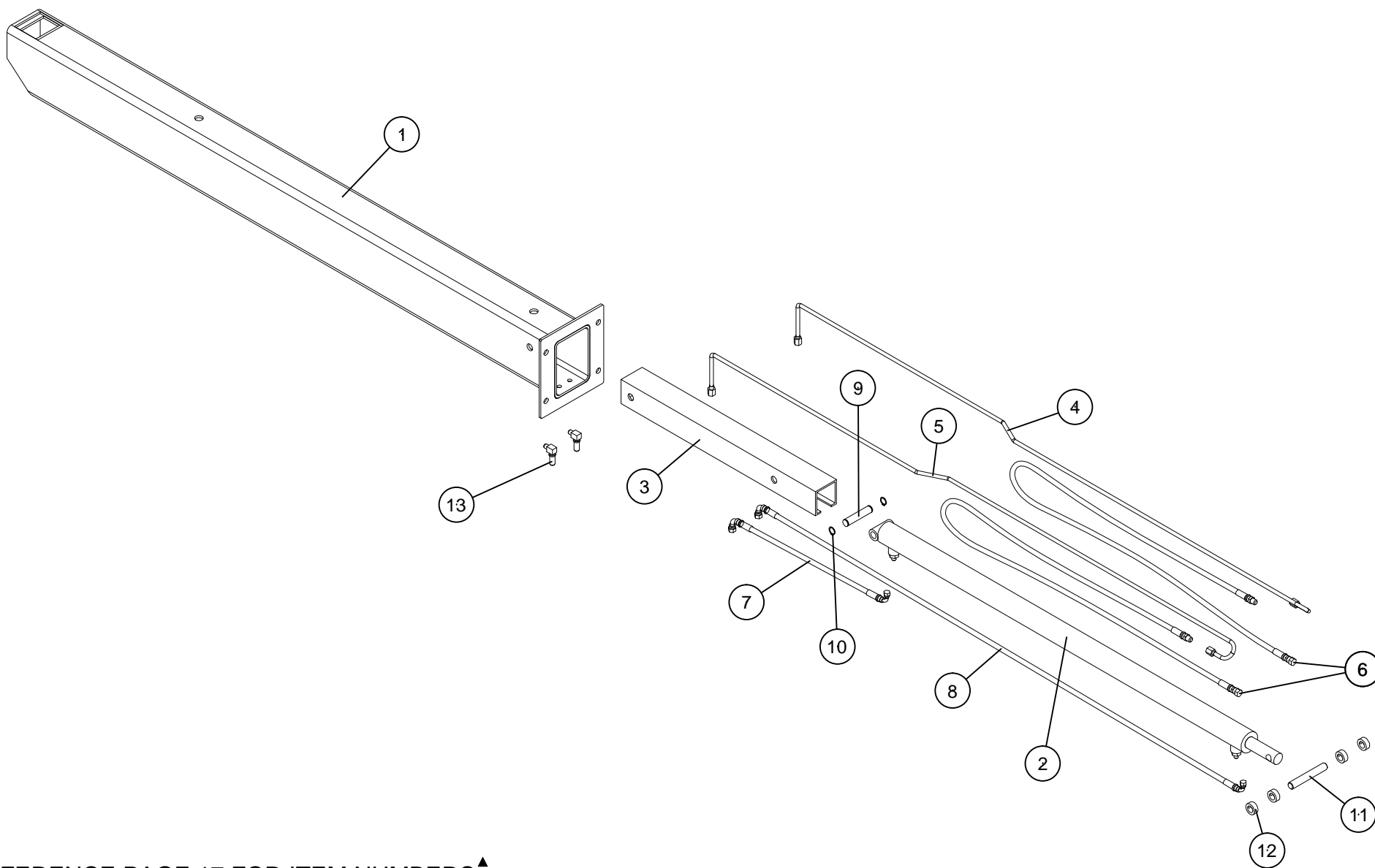
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03-11-16

PAGE

17

25451



REFERENCE PAGE 17 FOR ITEM NUMBERS ▲



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PARTS BREAKDOWN

25100-PHX PULLOUT ASSEMBLY

| | | | |
|---|------------|-------|---|
| ▲ | DATE | PAGE | ▲ |
| | 01-23-17A | 18 | |
| | SUPERSEDES | | |
| | 03-11-16 | 25450 | |

PARTS BREAKDOWN, 25100 SERIES HYDRAULIC LEGS ASSEMBLY

| 25100 SERIES OUTRIGGERS HYDRAULIC LEGS ASSEMBLY PARTS BREAKDOWN | | SHORT | | LONG | | |
|---|--|----------|-------|------|-------|--------------|
| | | LEFT | RIGHT | LEFT | RIGHT | |
| # | DESCRIPTION | QUANTITY | | | | PART # |
| 1 | HYDRAULIC LEG; SHORT, LEFT-SIDE | 1 | - | - | - | 25064-1 |
| 2 | HYDRAULIC LEG; SHORT, RIGHT-SIDE | - | 1 | - | - | 25064-2 |
| 3 | HYDRAULIC LEG; LONG, LEFT-SIDE | - | - | 1 | - | 25055-1 |
| 4 | HYDRAULIC LEG; LONG, RIGHT-SIDE | - | - | - | 1 | 25055-2 |
| 5 | COVER; SHORT LEG, LEFT-SIDE | 1 | - | - | - | 25069-1 |
| 6 | COVER; SHORT LEG, RIGHT-SIDE | - | 1 | - | - | 25069-2 |
| 7 | COVER; LONG LEG, LEFT-SIDE | - | - | 1 | - | 25068-1 |
| 8 | COVER; LONG LEG, RIGHT-SIDE | - | - | - | 1 | 25068-2 |
| 9 | HOSE ASSY KIT (INCLUDES HOSE AND FITTING) | 1 | 1 | - | - | 25193-KIT |
| 10 | HOSE ASSEMBLY; 25-3/8", 4FX-4FX, LONG LEG, RETURN | - | - | 1 | 1 | 25061 |
| 11 | HOSE ASSEMBLY; 47", 4FX-6MJ, SHORT LEG, LEFT-SIDE | 2 | - | - | - | 25151 |
| 12 | HOSE ASSEMBLY; 27", 4FX-6FX, SHORT LEG, RIGHT-SIDE | - | 2 | - | - | 25147 |
| 13 | HOSE ASSEMBLY; 54", 4FX-6MJ, LONG LEG, LEFT-SIDE | - | - | 2 | - | 25153 |
| 14 | HOSE ASSEMBLY; 37", 4FX-6FX, LONG LEG, RIGHT-SIDE | - | - | - | 2 | 25152 |
| 15 | VALVE BLOCK; CHECK BODY & CARTRIDGE | 1 | 1 | 1 | 1 | 22765 |
| 16 | SPACER; HYDRAULIC LEG COVERS | 3 | 3 | 3 | 3 | 25070 |
| 17 | FLAT WASHER; 5/16, GR. 5, ZINC | 3 | 3 | 3 | 3 | IFWSH-031 |
| 18 | LOCK NUT; 5/16-18, GR. 5, ZINC, NYLON-INSERT | 3 | 3 | 3 | 3 | ILNUT-03118 |
| 19 | ADAPTER FITTING; 90° ELBOW, 6MO-6MJ | 1 | 1 | 1 | 1 | H6801L-0606 |
| 20 | ADAPTER FITTING; COUPLING SWIVEL, 6FJX-6FJX | 1 | 1 | 1 | 1 | H6565-0606 |
| 21 | ADAPTER FITTING; ADAPTER, 6MJ-8MP | 1 | 1 | 1 | 1 | H2404-0608 |
| 22 | ADAPTER FITTING; 90° ELBOW, 6MO-4MJ | 1 | 1 | 1 | 1 | H6801-0406 |
| 23 | ADAPTER FITTING; T-SHAPE, 4MJ-4FJX-4MJ | 1 | 1 | 1 | 1 | H6602-040404 |
| 24 | ADAPTER FITTING; CONNECTOR, 6MO-4MJ | 1 | 1 | 1 | 1 | H6400-0406 |
| 25 | ADAPTER FITTING; 90° ELBOW, 4MJ-4FX | 1 | 1 | 1 | 1 | H6500-0404 |
| 26 | ADAPTER FITTING; 90° ELBOW, 4MO-4MJ | - | - | 1 | 1 | H6801LL-0404 |
| | | | | | | |

REFERENCE 25453 PARTS DRAWING ▲



VENCO VENTURO INDUSTRIES LLC
CINCINNATI, OHIO

PARTS BREAKDOWN

25100 SERIES HYD. LEGS

DATE
05-23-23B

SUPERSEDES
01-23-17A

PAGE
19

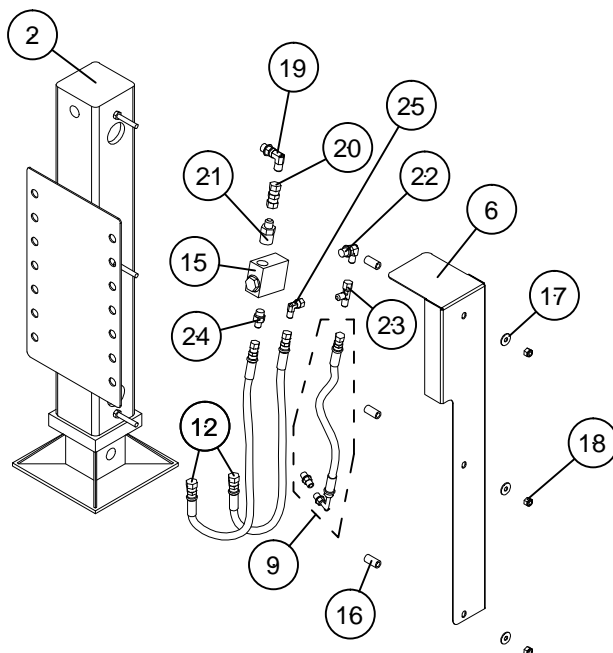
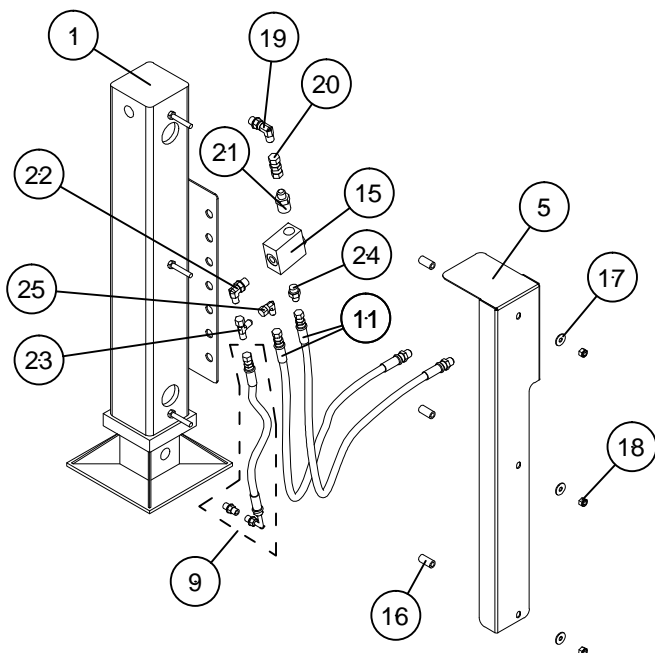
25452

PARTS BREAKDOWN, 25100 SERIES HYDRAULIC LEGS ASSEMBLY

LEFT

SHORT LEGS

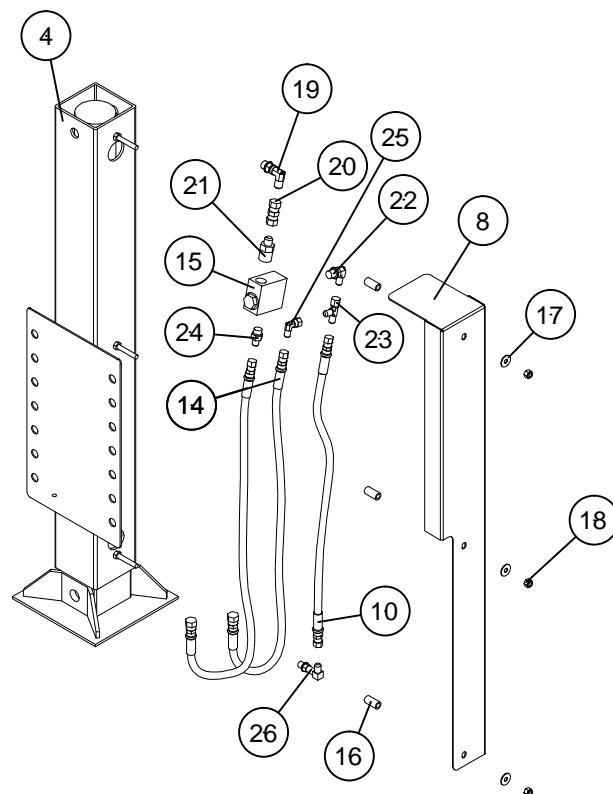
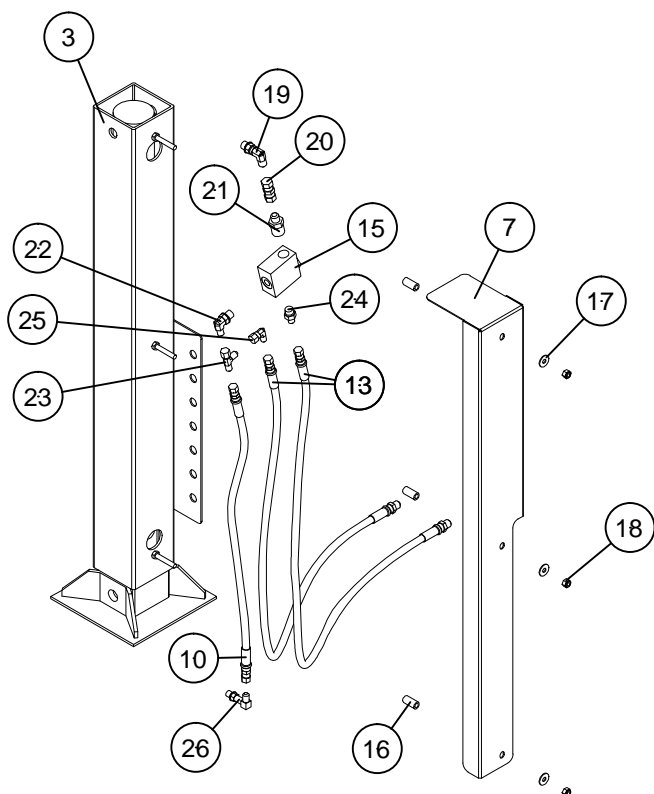
RIGHT



LEFT

LONG LEGS

RIGHT



REFERENCE 25452 PARTS LIST ▲



VENCO VENTURO INDUSTRIES LLC
CINCINNATI, OHIO

PARTS BREAKDOWN

25100 SERIES HYD. LEGS

DATE
05-23-23B

SUPERSEDES
01-23-17A

PAGE

20

25453



VENTURO CRANES LIMITED WARRANTY POLICY

Venturo products are built to last...we guarantee them.

As a purchaser of any new Venturo product covered by warranty, you will receive 1 year of the most complete coverage available...and, at no added cost to you.

1-Year Limited Warranty Policy

This limited policy warrants new products of Venturo to be free from defects in material and workmanship for a period of one (1) year from date of original installation. OEM products or accessories purchased by Venturo as part of or offered with our product will carry the OEM manufacturer's respective warranty. Our 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. There is no warranty of merchantability, fitness for a particular purpose, warranty arising from course of dealing or usage of trade, or any other implied or expressed warranty, except as made specifically herein. This warranty supersedes all previous warranties, written or implied.

Warranty Claims

Venco Venturo Industries LLC 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 ensure the installation is completed according to the manufacturer's recommendations, ensure 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 product without the expressed written consent of Venco Venturo Industries LLC. Installation 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 be instructed as to the safe operation at time of delivery. Maintenance, service, operation and safety warning decals are available on request from Venco Venturo Industries LLC.

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