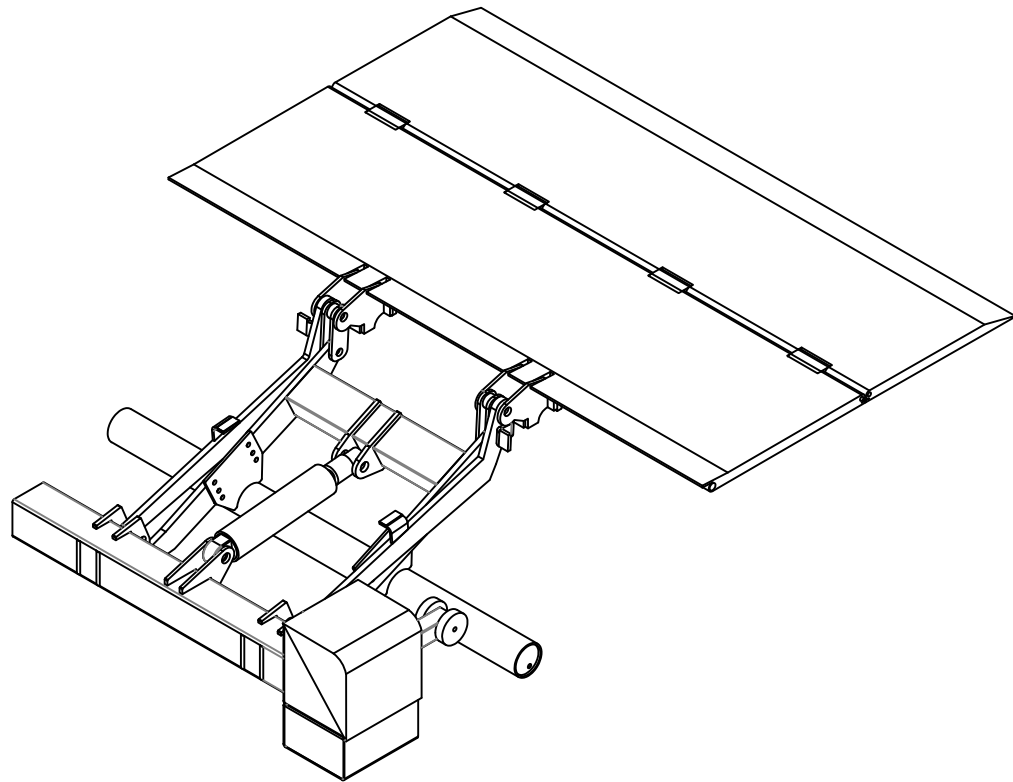


INSTALLATION INSTRUCTIONS

Tommy Gate TKL 2500 lb Capacity



Woodbine, Iowa



CAUTION

Before installing this liftgate, please observe the Vehicle Loading Limitations. These loading limitations are outlined in the Vehicle Owner's Manual and the Safety Compliance Certification Label located on the driver's door pillar.



CAUTION

TABLE OF CONTENTS

<u>Introduction</u>	Page #
To the Installer\Operator _____	3
<u>Safety Decals and Tuckunder Description</u>	
Safety Decal Location and Descriptions _____	4-5
Decal Replacement _____	5
Tuckunder Terms and Method of Operation _____	6
TKL Technical Specifications _____	7
<u>Gate Installation Process</u>	
TKL General Dimensions _____	8
Unpacking _____	9
General Installation Notes _____	10
Preparing the Truck _____	10-12
Verifying the Correct Side Step Options _____	13
Positioning the Bed Extension on the Truck _____	14-16
Positioning the Liftgate on the Truck _____	17-20
Finish Welding _____	20-21
Finishing Gate Installation _____	22
Installing Optional Rear Bumper _____	22
<u>Electrical Wiring</u>	
Routing the Power Cables _____	23
Standard Fixed Control _____	24
Optional Pendant Control _____	25
Electrical Schematic _____	26
Tommy Gate Electrical Wiring Guidelines _____	27
<u>Testing and Operation</u>	
Testing the Liftgate _____	28
Painting the Liftgate _____	28
Platform Adjustment Instructions _____	29
Reflective Tommy Gate Flags _____	30
Operator's Instructions _____	31-32

TO THE INSTALLER\OPERATOR:

Read this manual completely before using your gate. Operate and maintain your gate safely as outlined in this manual. Be sure you read and understand all operating, safety, maintenance and service information. Should you need repair or service information, contact Tommy Gate or an authorized distributor for assistance.



This is the safety alert symbol. It is used to alert you to potential personal injury hazards. Obey all safety messages that follow this symbol to avoid possible injury or death.



DANGER indicates an imminently hazardous situation which, if not avoided, will result in death or serious injury.



WARNING indicates a potentially hazardous situation which, if not avoided, could result in death or serious injury.



CAUTION indicates a potentially hazardous situation which, if not avoided, may result in minor or moderate injury.



CAUTION indicates a potentially hazardous situation which, if not avoided, may result in property damage.

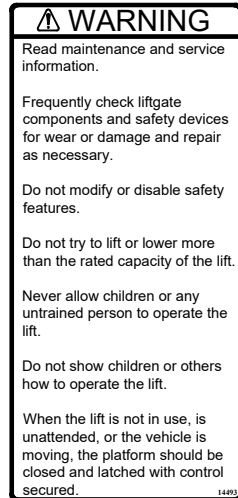
Safety is a primary concern in the design and manufacture of our products. Unfortunately, our efforts to provide safe equipment can be wiped out by a single careless act of an operator.

Accident prevention and safety are dependent upon the awareness, concern, prudence and proper training of the personnel who operate, transport, maintain and store this equipment. It is your responsibility to use good judgment in the operation of this equipment.

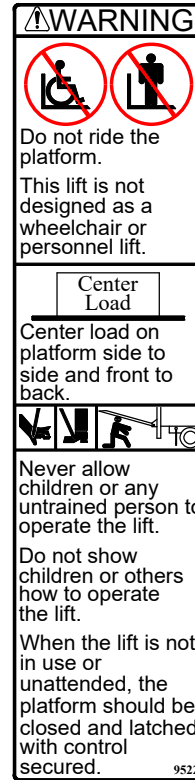
It has been said that "**the best safety device is an informed, careful operator.**" We ask you to be that kind of operator.

DECAL LOCATIONS AND DESCRIPTIONS

Locate and read all decals prior to operating gate
REPLACE IF MISSING OR NOT READABLE



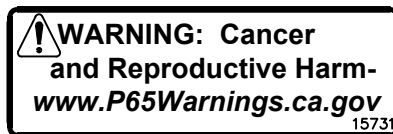
Decal No. 1
 Located on the curb side on back of main platform.



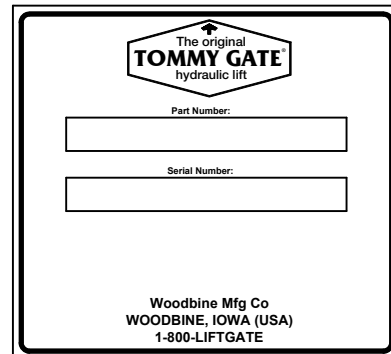
Decal No. 4
 Located on the curb side on back of main platform.



Decal No. 2
 Located on each main platform lid end.

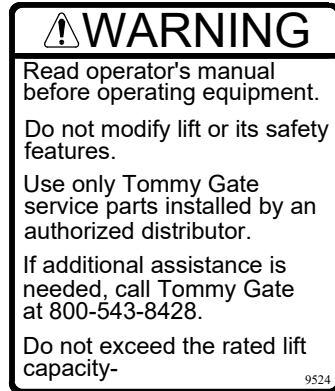


Decal No. 3
 Located on the curb side on back of main platform.

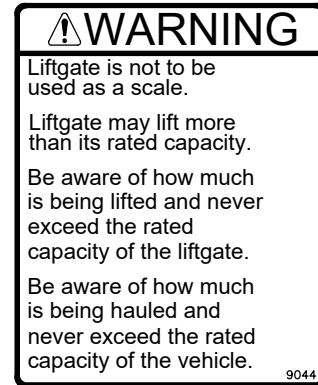


Decal No. 5
 Located in the pump box and inside of the curb side arm

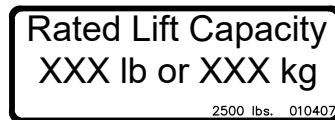
DECAL LOCATIONS AND DESCRIPTIONS



Decal No. 6
Located on the curb side on back of main platform.



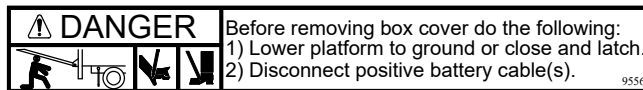
Decal No. 10
Located on the curb side on back of main platform.



Decal No. 7
Located on each main platform lid end.



Decal No. 11
Located at the arm link support.



Decal No. 8
Located on the pump cover.



Decal No. 12
Located on the curb side on back of main platform.



Decal No. 9
Located next to each coil spring.

DECAL REPLACEMENT

NOTE: When ordering Decals, please have Decal Numbers available.

To replace decal, clear area of grease and dirt with non-flammable solvent and soap and water. Allow to dry. To apply decal, peel off 1/2 of back. Hold decal squarely and apply to cleaned surface. Peel off remaining back and smooth in place. Gently rub decal with a damp rag or sponge to smooth out bubbles. (The decal has a pressure-sensitive adhesive on the back.)

If the liftgate **is** going to be painted, you need to mask the decals before painting. Remove the mask **after** painting so the decals can be read clearly.

Tuckunder Series; TKL Mounting Instructions

Tuckunder Terms and Method of Operation

Your Tommy Gate is connected to your vehicle battery. The vehicle battery powers a motor, coupled to a hydraulic pump. This motor and pump combination is called a power unit. Flow from the pump retracts a cylinder attached to the lift "H" arm assembly that lifts the gate platform. A check valve blocks return flow from the cylinder to the pump and a pressure relief valve prevents the gate from being overloaded.

!WARNING: Liftgate is not to be used as a scale. Liftgate may lift more than its rated capacity. Be aware of how much weight is being lifted and never exceed the rated capacity of the liftgate. Be aware of how much weight is being hauled and never exceed the rated capacity of the vehicle.

Placing the toggle switch into the lower position will direct the pump flow to extend the cylinder and the platform will lower.

The terms used to describe parts of the tuckunder in this manual can be found in (Figure 1).

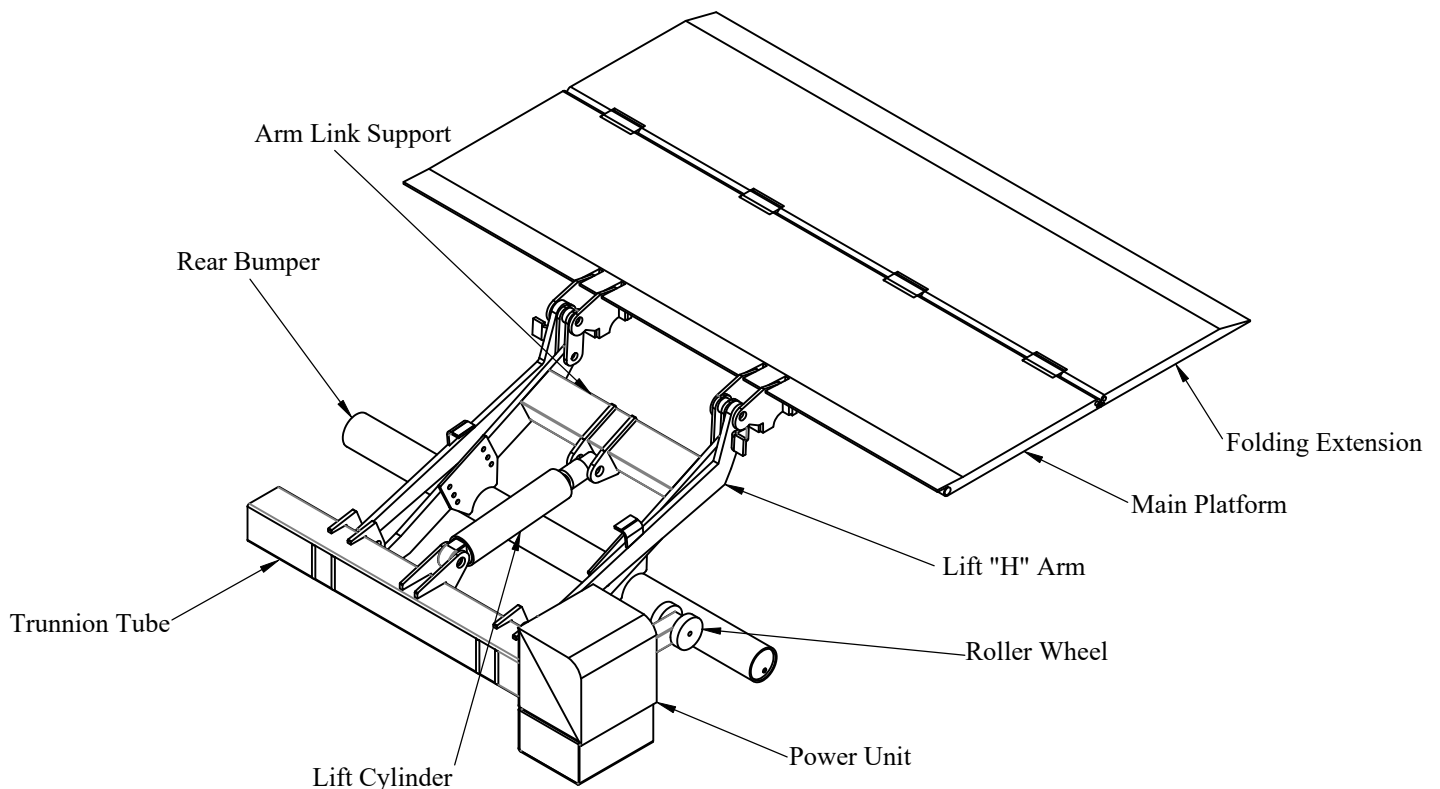


Figure 1: Tuckunder Terms.

!Caution:

Never leave the truck with the platform on the ground, partially raised, or open.

Never show children or unauthorized personnel how to operate the gate.

To prevent children or unauthorized personnel from operating the lift, be sure the gate is in the stored position and the platform is secured. Make sure the control is deactivated before leaving the truck unattended.

!Warning: The Tommy Gate is an industrial product for material handling only and is not to be used as a personnel or wheelchair lift. Do not ride on the platform and always stand clear of the platform when opening, raising or lowering.

Tuckunder Series; TKL Mounting Instructions

TKL Technical Specifications

TKL SERIES SPECIFICATIONS				
MODEL		TKL-78-25EA33	TKL-78-25EA37	TKL-78-25EA41
PLATFORM LENGTH	in	41	45	49
WEIGHT	lb	511	519	534
CAPACITY	lb	2500		
CURRENT DRAW	amp	150		
FULL LOAD RAISE SPEED	in/s	3		
FULL LOAD LOWER SPEED	in/s	5		
HYDRAULIC FLUID TANK CAPACITY	gal	1.5		
MOTOR RATED HORSEPOWER	hp	2.1		
MAX. RELIEF VALVE SETTING	psi	2538		

LOAD CAPACITY AT DISTANCE (X) FROM THE EDGE OF PLATFORM (inches)										
(X)		0" ----- 24"	26"	28"	30"	32"	34"	36"	38"	40"
TKL 25	LOAD CAPACITY (lbs)	2500	2360	2130	1910	1740	1630	1500	1400	1350

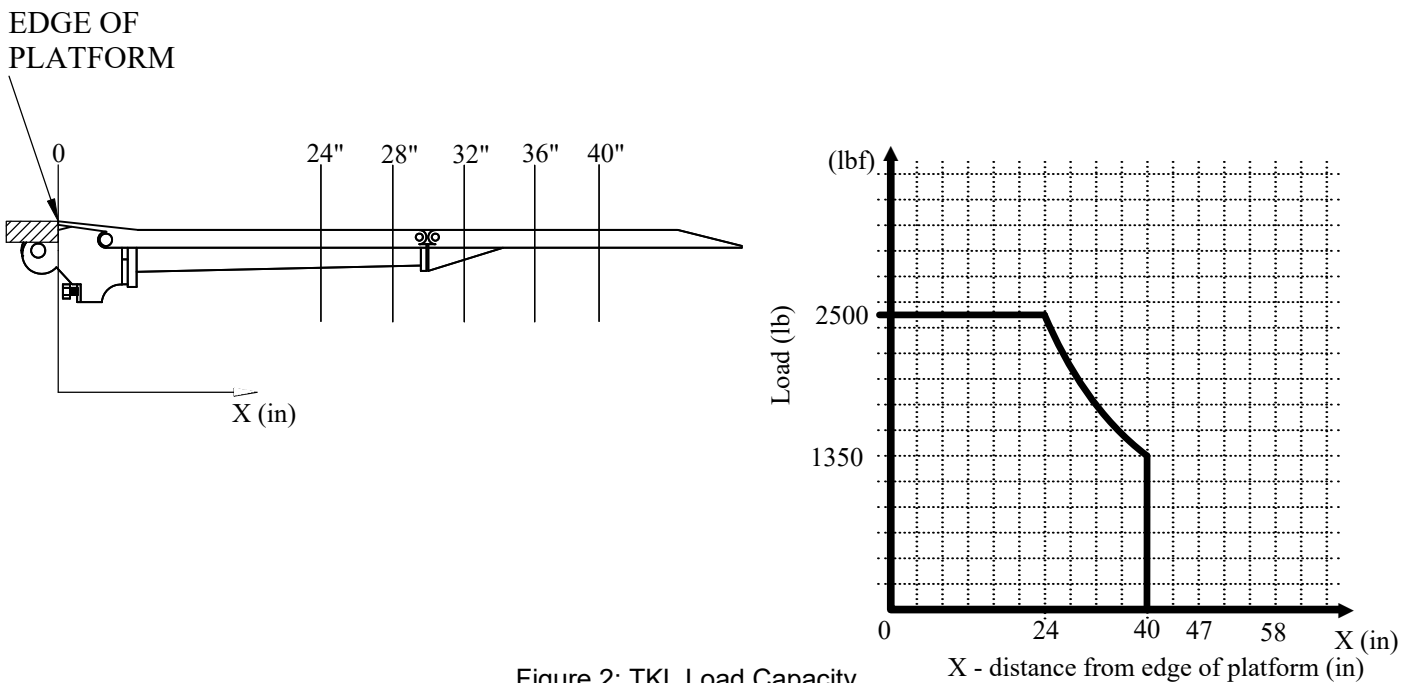


Figure 2: TKL Load Capacity.

Tuckunder Series; TKL Mounting Instructions

TKL 2500 Lbs

D- BED HEIGHT	E	F	G	G'	Le		Q	M	N	T	P	W
					max	min						
33	21.0	12	45.25	47.25	37.0	32.0	6.0	26.7	32.9	5.9	5.2	2.7
34		13	44.75	46.75								
35		14	44.25	46.25								
36		15	43.75	45.75								
37		16	43.25	45.25								
38		17	42.75	44.75								
39		18	42.25	44.25								
40		19	41.50	43.50								
41		20	40.75	42.75								
42		21										
43	21.5	21.5	39.25	41.25								
44	22.5											
45	23.5											
46	24.5											
47	25.5											

All dimensions in inches

G: distance between the platform and the end of the bracket

G': distance between the platform and the end of the power unit

H: distance between the platform and the back of the trunion. (H = G - 5")

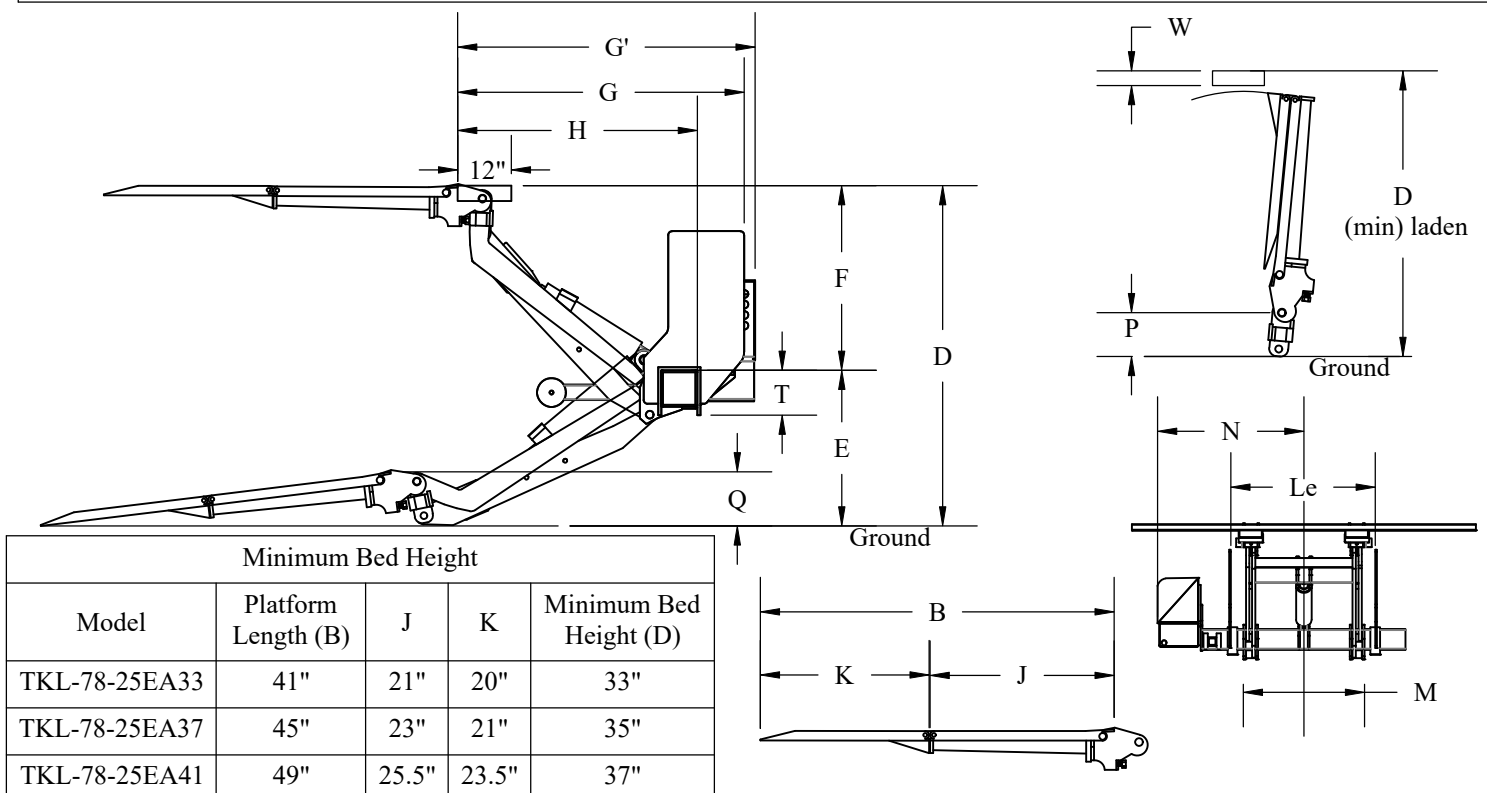


Figure 3: Liftgate General Dimensions.

Tuckunder Series; TKL Mounting Instructions

Unpacking the Liftgate

1. **Remove** any wrapping from the gate, bed extension, and box. Be careful of shifting parts.
2. Use a forklift to pick up the pallet. **DO NOT** use the top bar as a lifting point (Figure 4).
3. Use a lifting strap to raise liftgate from pallet. Carefully lift the platform using two lifting straps (Figure 5) and position horizontally with the platform on the top side (Figure 6).

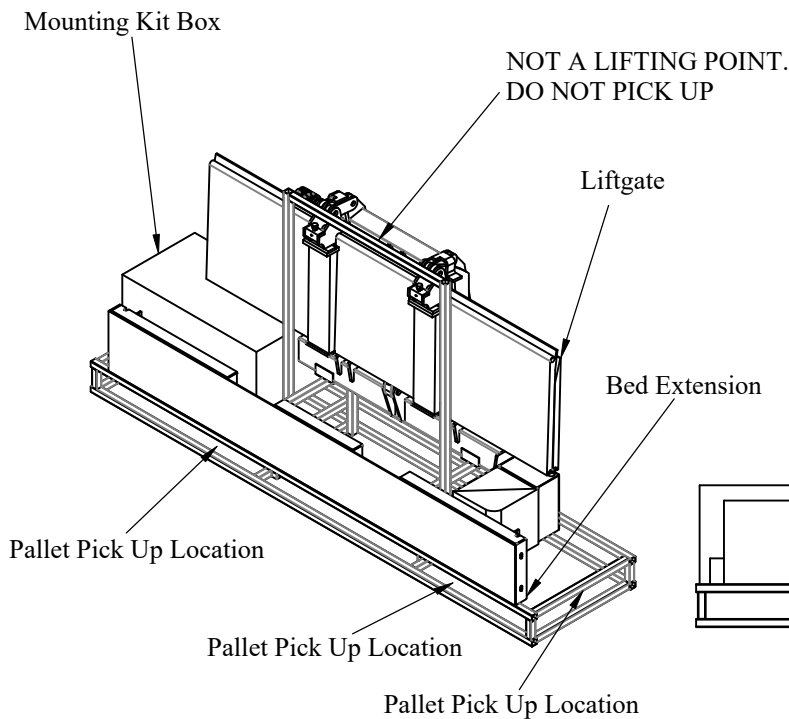


Figure 4: Pick Up Locations.

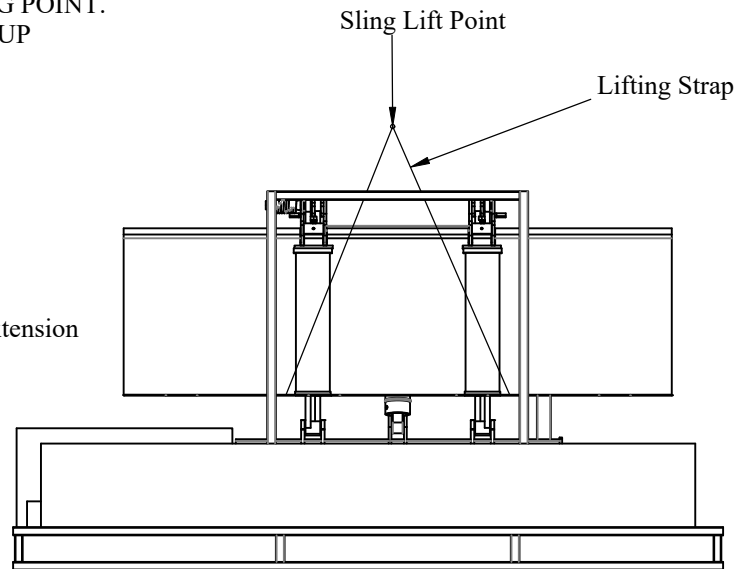


Figure 5: Sling Lift Point.

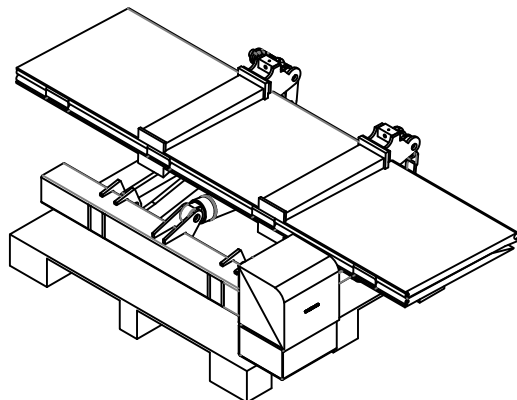


Figure 6: Position For Mounting.

Tuckunder Series; TKL Mounting Instructions

General Installation Notes

1. **Do not work under liftgate without platform being supported.**
Do not remove fork lift or overhead crane without verifying the hydraulic system has been fully pressurized.
2. Use standard AWS (American Welding Society) D1.1 welding practices for specified welding details.
3. Check truck's manufacturer technical data and guides for chassis welding.
4. See recommended torque values for fasteners (Table 1).

Table 1: Fastener Torque Values

Thread Size	Torque, ft-lb
3/8-16	37
1/2-13	90
5/8-11	179

Preparing the Truck

1. **Measure** the body opening, the overall width, and the bed height of the truck (Figure 8).
Measure the distance from the rear of the body to rear tire or rear fuel tank.
Make sure you have the correct model of liftgate for your application (Figure 3).
2. **Verify** parts list (Table 2) and inspect for missing or damaged parts (Figure 7).

Table 2: Parts List.

QTY.	DESCRIPTION
1	Liftgate
2	Trunnion Tube Mounting Plates
1	Bed Extension
2	Bed Extension Braces
2	Brace Support Mounting Plates
2	Side Steps
1	Mounting Kit Box
1	Reflective Flags Kit

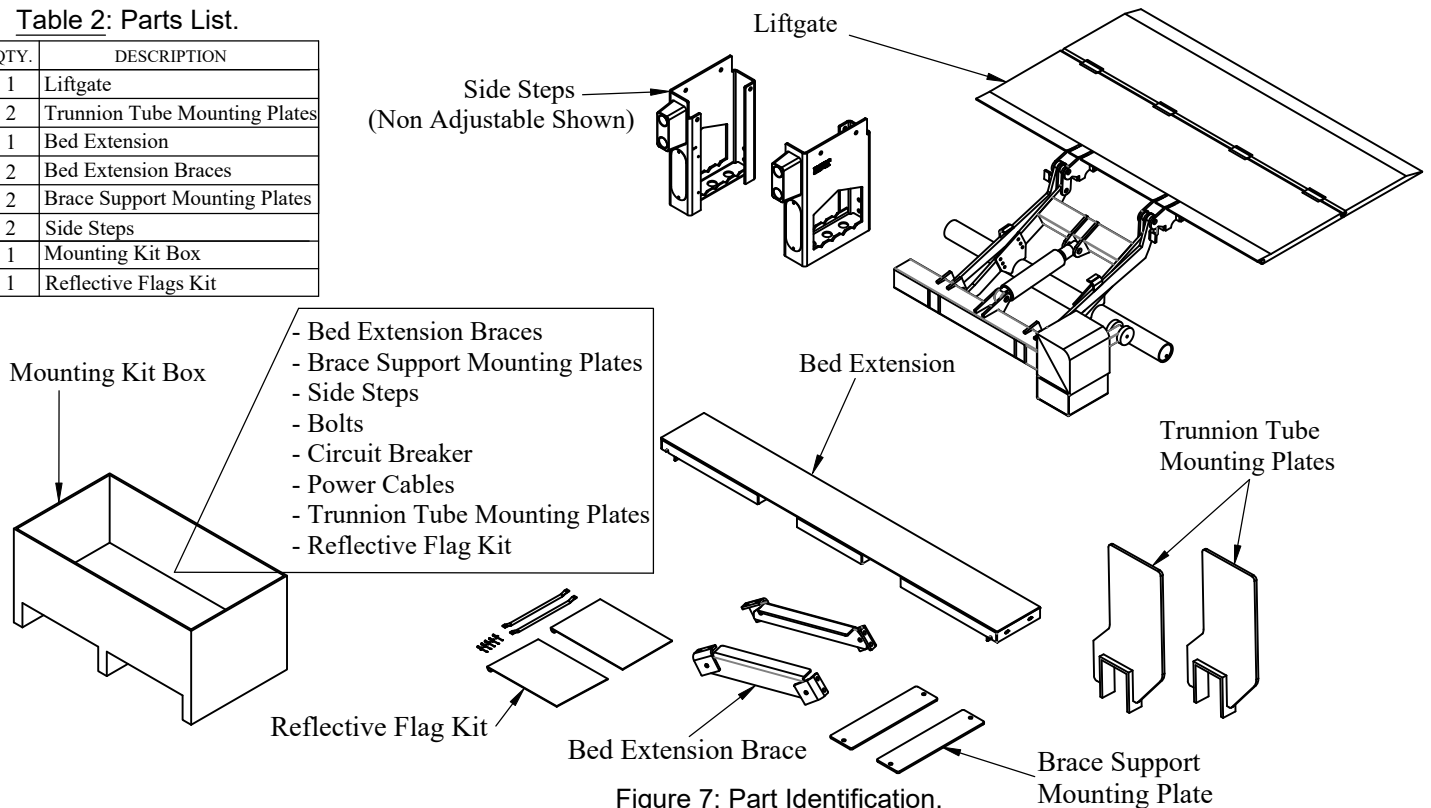


Figure 7: Part Identification.

Tuckunder Series; TKL Mounting Instructions

Preparing the Truck (continued)

Note: On installations such as a lengthened van body or rebuilt trailer, where the frame stops short of the end of the body, extra support may need to be added to minimize undesirable deflection under heavy load.

Note: Before starting work on truck's chassis frame, consult Body Builder's manual from the truck manufacturer.

3. **Park** truck on flat and level work surface for liftgate installation.
4. **Disconnect** the truck battery.
5. **Measure** the truck frame for platform folding clearance using the layout chart (Figure 9 and Table 3) to provide clearance for the Platform Support Structure (Figure 10).
6. **Prepare** the mounting surfaces of the truck frame. The surfaces should be free of paint and rust.

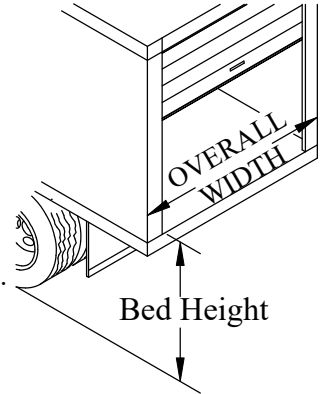


Figure 8: Body overall dimensions.

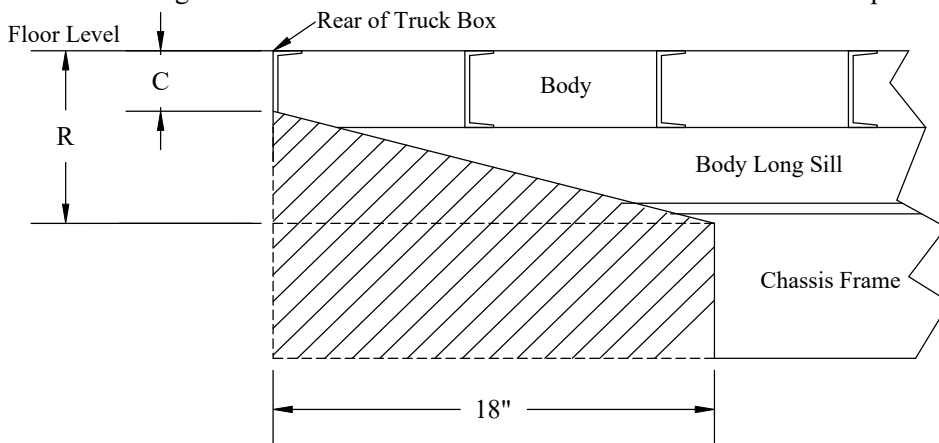


Figure 9: Frame Trim Dimensions.

Table 3: C and R Dimensions

General Dimensions for Chassis cutting		
Bed Height	C	R
33"	2.3"	4.5"
34"	2.6"	5.2"
35"	2.9"	6.2"
36"	3.2"	7.1"
37"	3.5"	8"
38"	3.8"	9.1"
39"	4.1"	10"
40"	4.4"	10.9"
41"	4.8"	11.9"
42"	5.2"	12.9"
43"	5.4"	13.5"
44"		
45"		
46"		
47"		

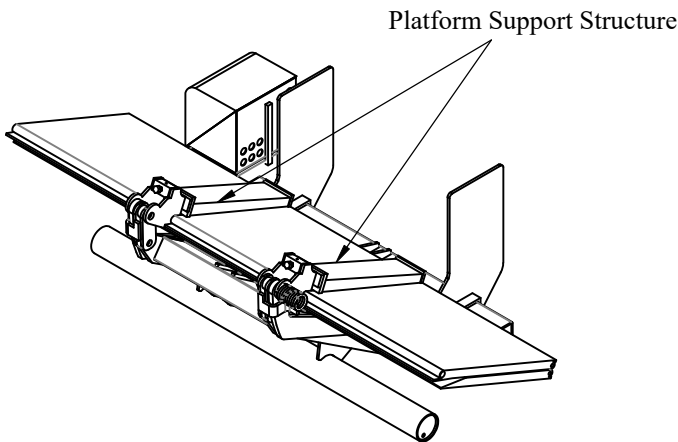


Figure 10: Platform Support Structure.

Tuckunder Series; TKL Mounting Instructions

Preparing the Truck (continued)

IMPORTANT! On Bed Heights **lower than 38"**, it may be necessary to **trim** the truck's rear sill to match the notches in the bed extension (Figure 11).

7. **Trim** the truck frame to provide platform folding clearance.

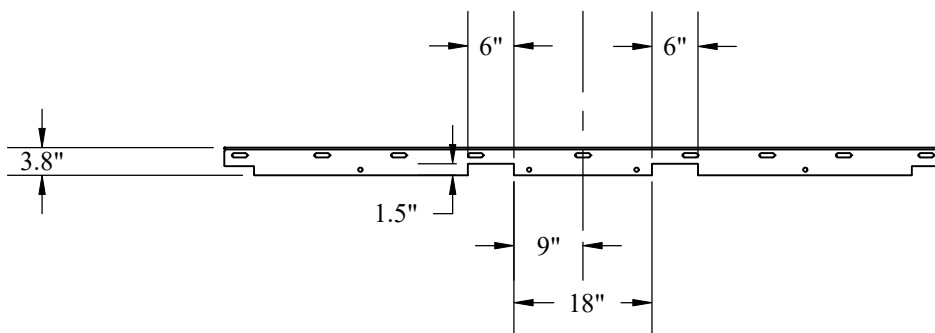


Figure 11: Bed Extension.

Tuckunder Series; TKL Mounting Instructions

Positioning the Bed Extension on the Truck: Weld-on Option

Note: Skip this section if you prefer to bolt the bed extension to the truck.

1. **Bolt** the side steps with the eight provided $\frac{1}{2}$ "x $1\frac{1}{4}$ " bolts, $\frac{1}{2}$ " flat washers, & $\frac{1}{2}$ " crown lock nuts on the bed extension.
2. **Center** the bed extension on the rear of the body.
3. **Position** the bed extension against the body with the top surface flush with the body floor and level with the ground.
4. **Tack Weld** the bed extension into position with four one inch welds (Figure 13).
The bed extension will be finish welded later.
5. **Verify** that the top surface of the bed extension is level.
6. **Install** the bed extension braces between the bed extension and the truck body.
Material may need to be added to the body to provide a location to install the top ends of the braces.
Use the optional Brace Support Mounting Plates to provide a mounting location if needed (Figure 26).

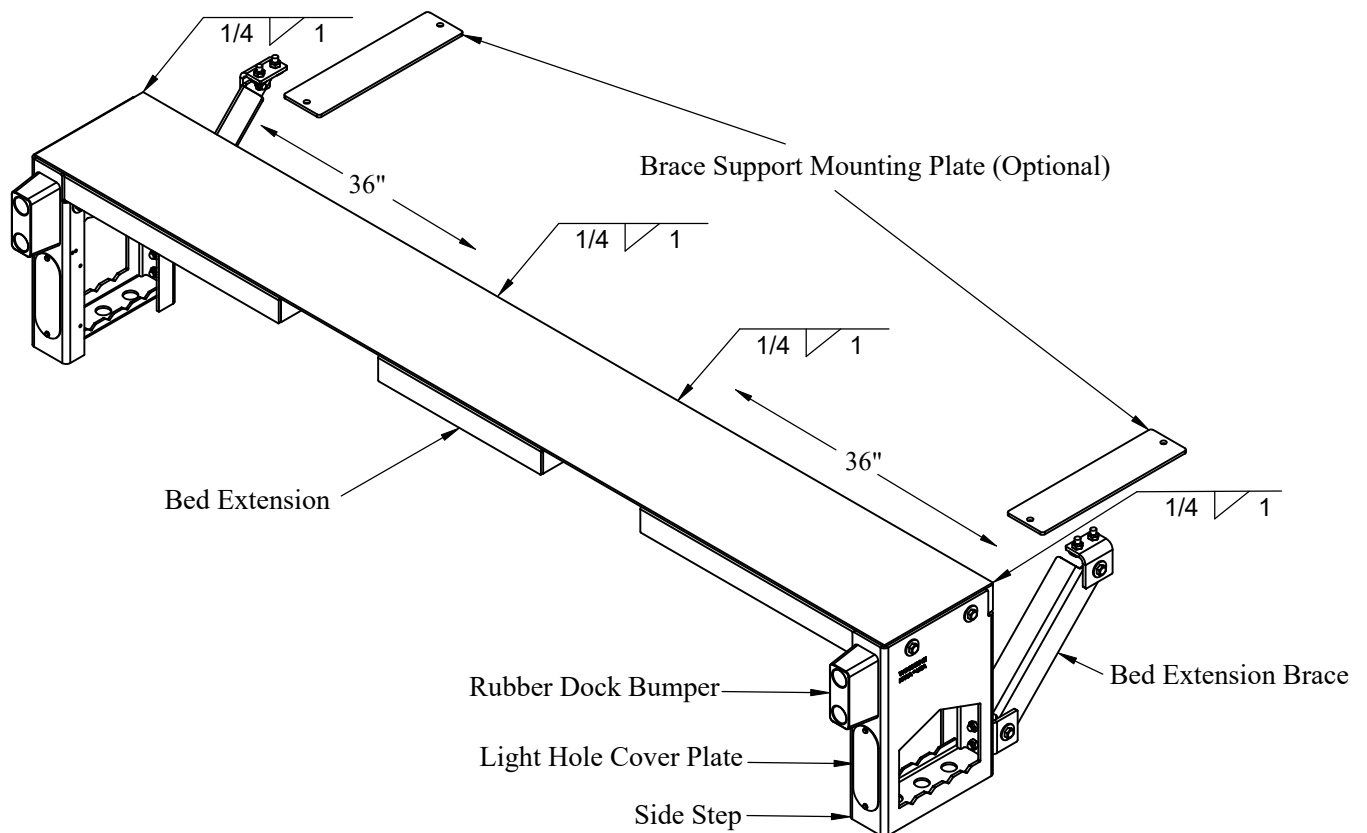


Figure 13: Bed Extension - Tacking Locations.

Tuckunder Series; TKL Mounting Instructions

Side Step Adjustment when Available

1. **Adjust** side step height to desired position (Figure 14).
2. **Bolt** the steps with the provided (2) 1/2"x2-1/2" bolts, 1/2" flat washers, and 1/2" crown lock nuts for the bumper side and (2) 1/2"x1-1/2" bolts, 1/2" flat washers, and 1/2" crown lock nuts for the truck side on the side step body.

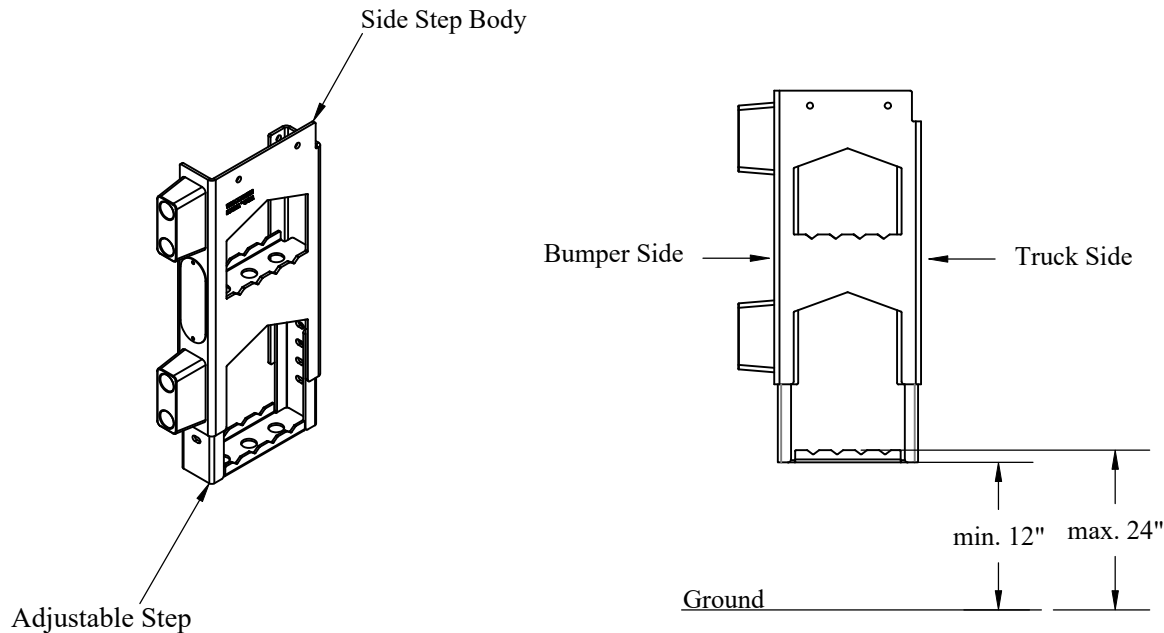


Figure 14: Side Steps Height Adjustment.

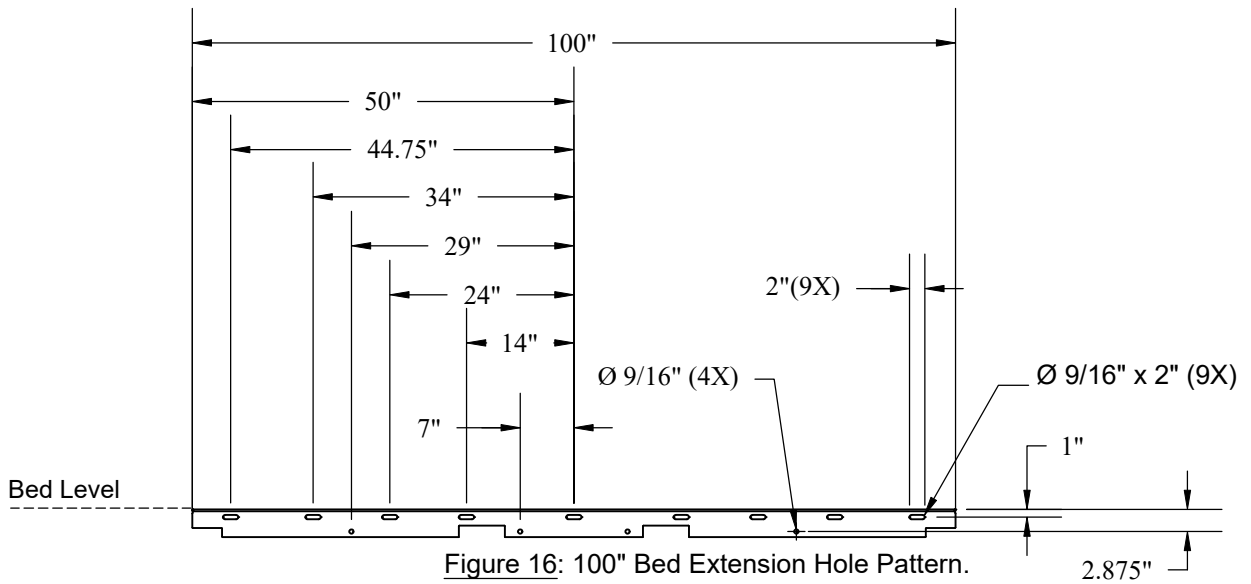
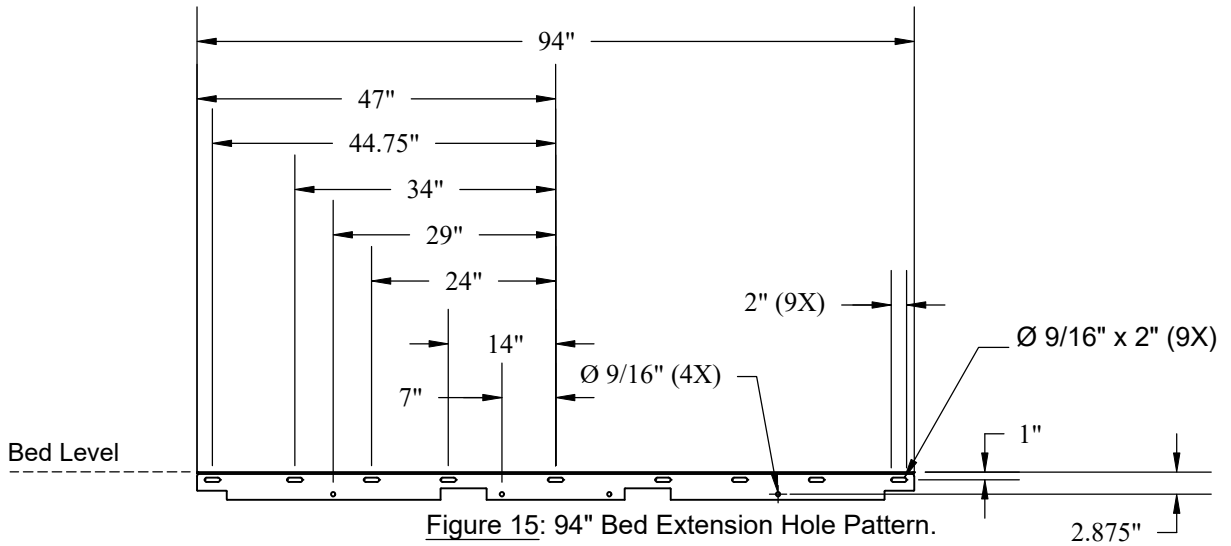
Positioning the Bed Extension on the Truck: Bolt-on Option (Fasteners Not Included)

Note: Skip this section if you prefer to weld the bed extension to the truck.

1. **Bolt** the side steps to the bed extension with the (8) provided 1/2"x1-1/4" bolts, 1/2" flat washers, & 1/2" crown lock nuts.
2. **Mark** center on the rear of the body.
3. **Check** for obstructions before drilling.
4. **Drill** 9/16" mounting holes using patterns shown (Figures 15 or 16).
5. **Position** the bed extension against the body with the top surface flush with the body floor and level with the ground.
6. **Fasten** bed extension to body using 1/2" bolts, not provided. Do not fully tighten at this time.
7. **Verify** that the top surface of the bed extension is level.
8. **Install** the bed extension braces between the bed extension and the truck body.
If the body has a sill depth other than 4", drill for mounting using the brace as a template.
Material may need to be added to the body to provide a location to fasten the top ends of the braces (Figure 26).
9. **Tighten** 1/2" fasteners to 90 ft-lb (Table 1).

Tuckunder Series; TKL Mounting Instructions

Positioning the Bed Extension on the Truck: Bolt-on Option (continued)



Tuckunder Series; TKL Mounting Instructions

Positioning the Liftgate on the Truck

1. **Prepare** the mounting surfaces of the truck frame for welding or bolting. The surfaces should be free of paint and excess rust for welding.
2. **Tighten** the adjusting screws equally, leaving a couple of turns before they tighten and bottom out (Figure 17).
3. **Attach** 12 volts from a battery to the liftgate power cables (no battery chargers). The negative cable is designated with a black stripe.
4. **Power** the control on as described on page 31.

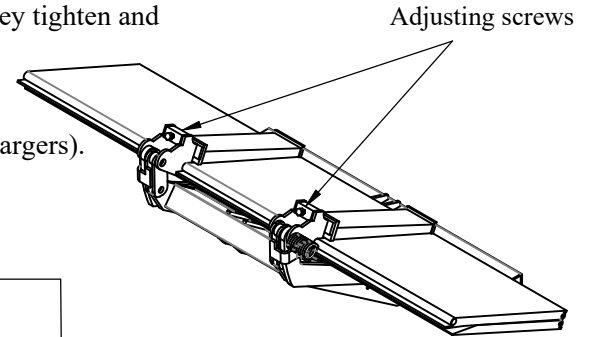


Figure 17: Adjusting Screws Location.

Caution:

Always keep the power unit leveled with the ground. Unleveling the power unit at this moment may cause oil leakage from the system.

5. **Raise** the liftgate using the toggle switch to make sure the liftgate is completely raised. The purpose of this step is to ensure there is no slack in the mechanism and the platform reaches bed height in the following mounting procedure.
6. **Power** the control off and disconnect from battery.
7. **Unfold** the platform.
8. **Insert** the two trunnion mounting plates onto the trunnion tube (Figure 19).
9. **Loosen** the set screw and the adjusting ring nut of the lifting cylinder to allow forgiveness in positioning the liftgate in later steps (Figure 18).

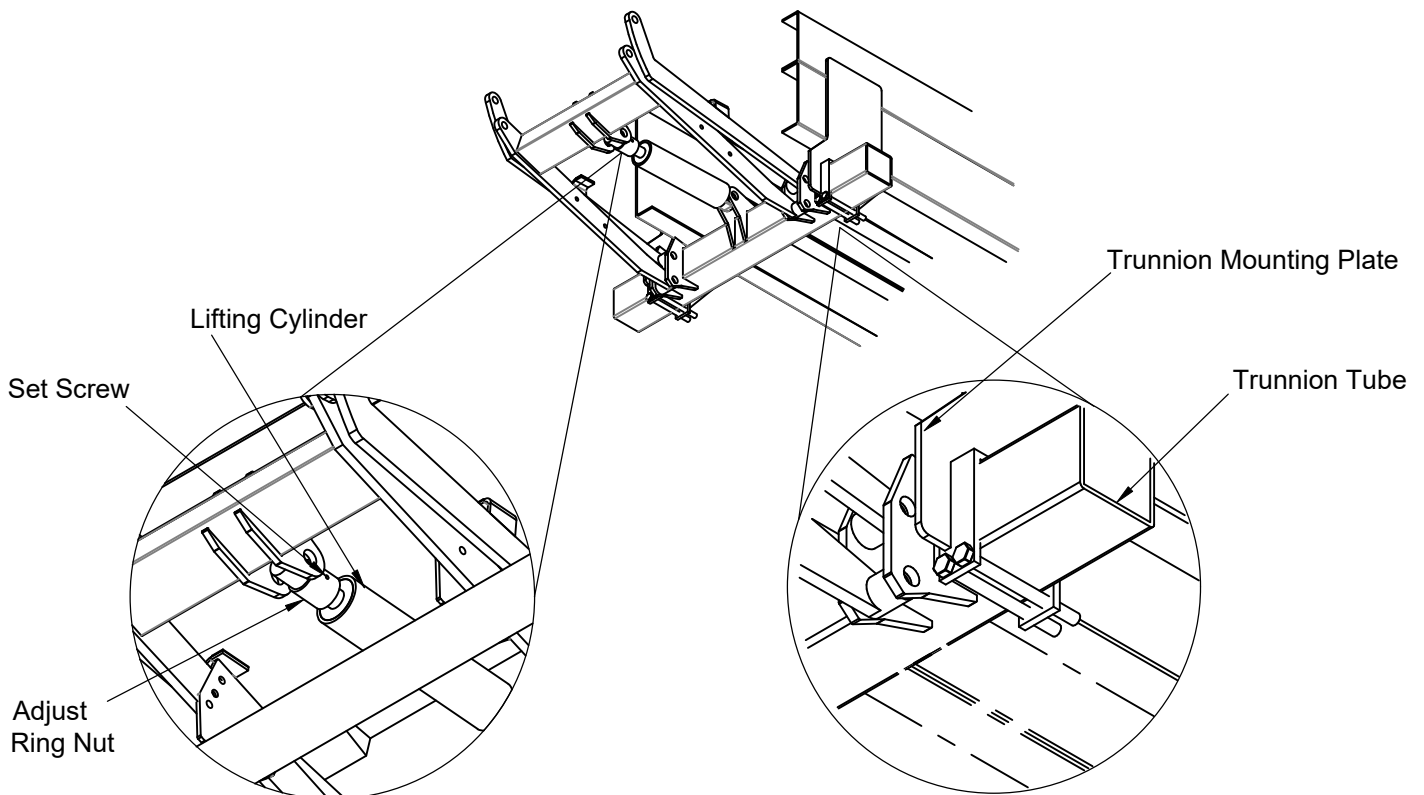


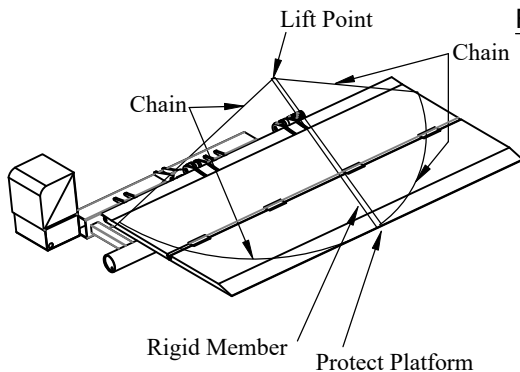
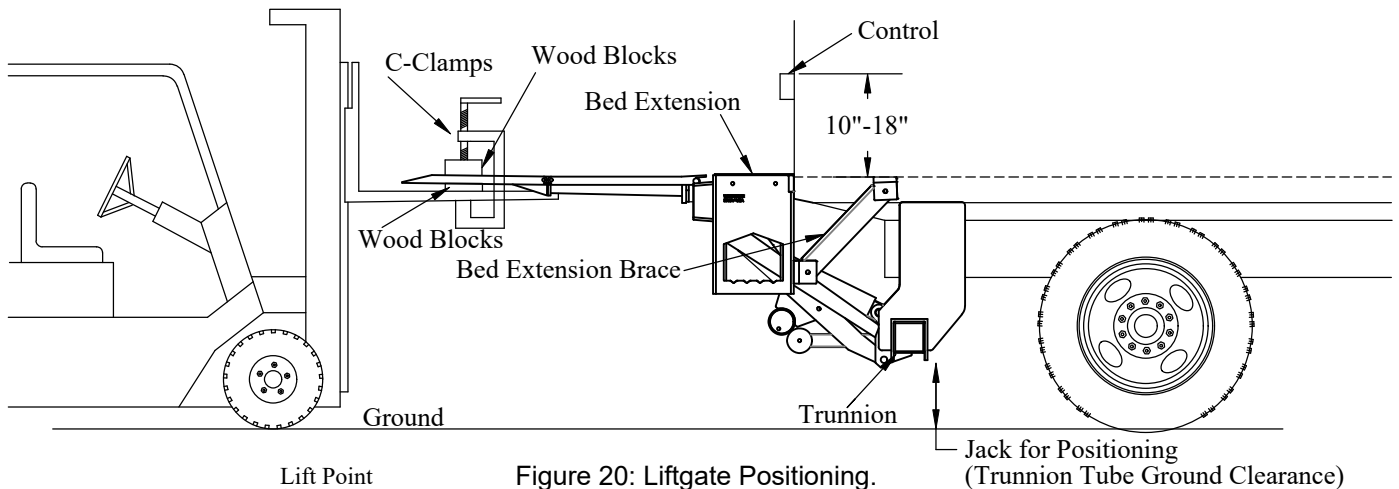
Figure 18: Adjusting Ring Nut.

Figure 19: Trunnion Mounting Plates.

Tuckunder Series; TKL Mounting Instructions

Positioning the Liftgate on the Truck (continued)

10. If using a fork lift, position the liftgate as shown (Figure 20).
If using an overhead lift see Figure 21.
Attach the platform to the forks, make sure the forks have passed the hinge point, use C-clamps with wood blocks to provide support and prevent damage to the platform edge.
 11. **Position** the liftgate platform against the rear of the bed extension, centered and flush with the top surface. See General Dimensions (Figure 3).
 12. **Position** the liftgate so that the trunnion tube is square with the ground.
- Note: For trucks with bed heights of 42" or less, operate the liftgate lowering function to obtain the "E" dimension from Figure 3. To keep the trunnion level, blocks may need to be temporarily clamped between the trunnion and the frame.
13. **Place** a jack under the trunnion tube to aid in positioning the liftgate (Figure 20). Do not apply excessive pressure with the jack; it will introduce slack into the mechanism.
 14. **Position** the trunnion mounting plates outside of the truck frame and on the trunnion tube.
 15. **Temporarily Lock** the trunnion mounting plates by tightening the clamps. Do not tighten completely at this time (Figure 19).
 16. **Cover and Protect** hydraulic hoses, wiring, and painted surfaces from welding heat and sparks in the next step.
 17. **Tack Weld** on the trunnion tube mounting plates to the truck frame using 3/8" fillet welds, 1" long in locations A, B, & C (Figure 25).
 18. **Lock** the plates by tightening the provided (4) M16x140 bolts to 125 ft-lb torque.
 19. **Remove** the forklift or overhead lift.



Tuckunder Series; TKL Mounting Instructions

Positioning the Liftgate on the Truck (continued)

20. **Adjust** the platform slope using the adjusting screws so the platform front taper stays 1"-2" higher than the rear of the platform. This allows for liftgate deflection when fully loaded. After finding the right position, lock the set screws. The screws must be adjusted, so they support the platform evenly (Figure 22).
21. **Fold** the folding extension and main platform.
22. **Raise** the liftgate into stowed position, checking for clearance between platform and truck frame.
23. **Deploy** platform and raise to bed height.
24. **Tighten** the threaded ring nut on the lifting cylinder providing a mechanical stop for it.
25. **Lock** the threaded ring nut in place by tightening the set screw (Figure 23).

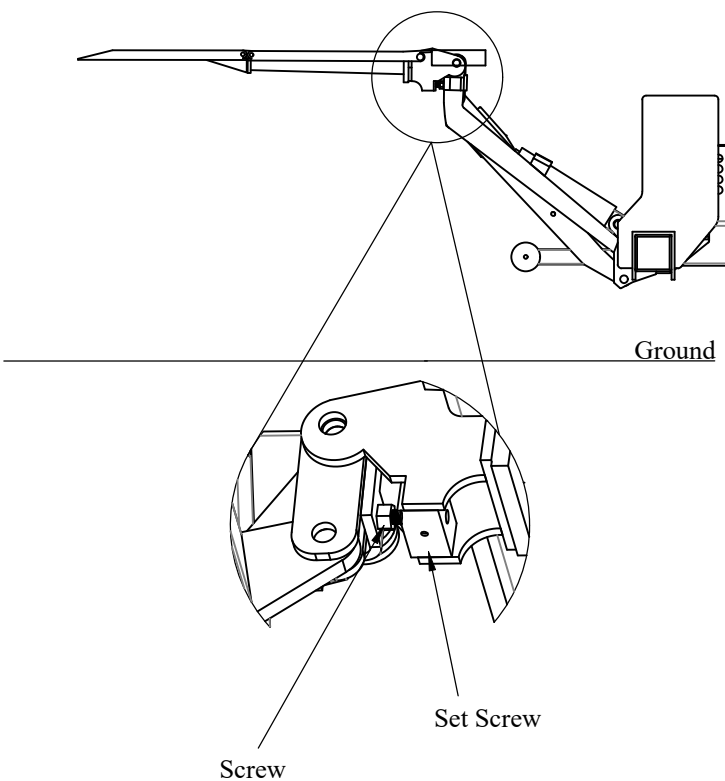


Figure 22: Adjusting Screws.

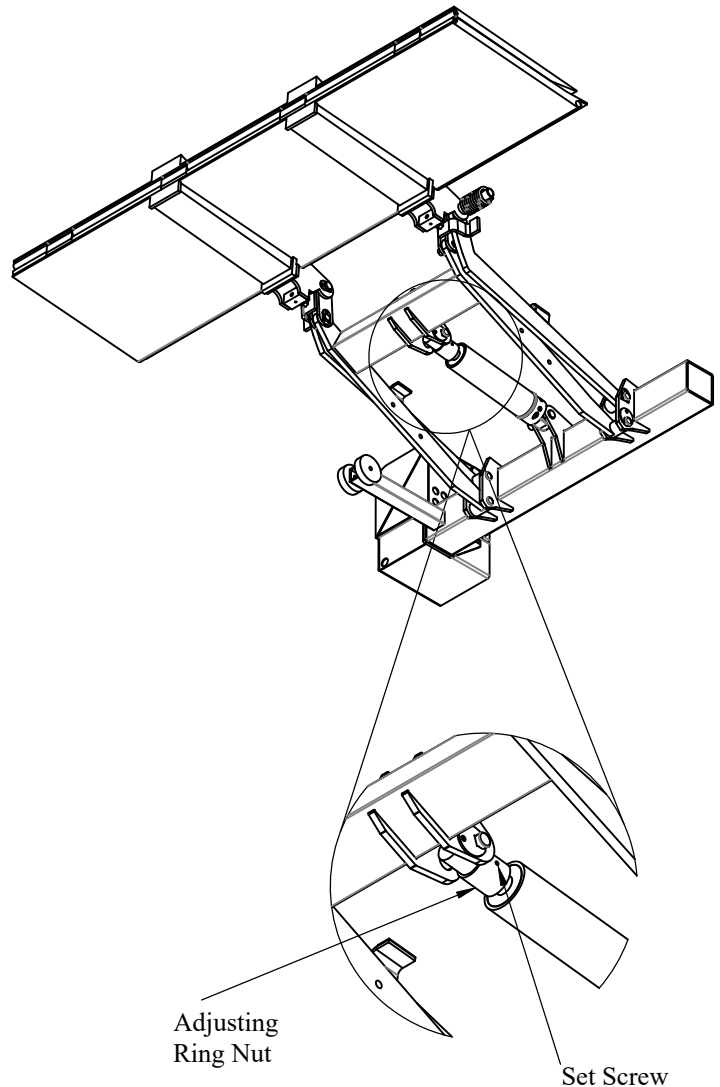


Figure 23: Adjusting Ring Nut.

Tuckunder Series; TKL Mounting Instructions

Positioning the Liftgate on the Truck (continued)

- 26. Adjust** the roller wheel arm to make the platform easier to manually unfold by sliding it in and out until the platform angle θ is short of vertical. Be careful the platform does not fall open when the truck is on an incline (Figure 24).
- 27. Raise** the liftgate into stowed position again to make sure that the new adjustment of the roller wheel arm is not causing the gate to hit anywhere when going into or out of the stowed position.
- 28. Open and Close** platform several times to make sure it's working properly.

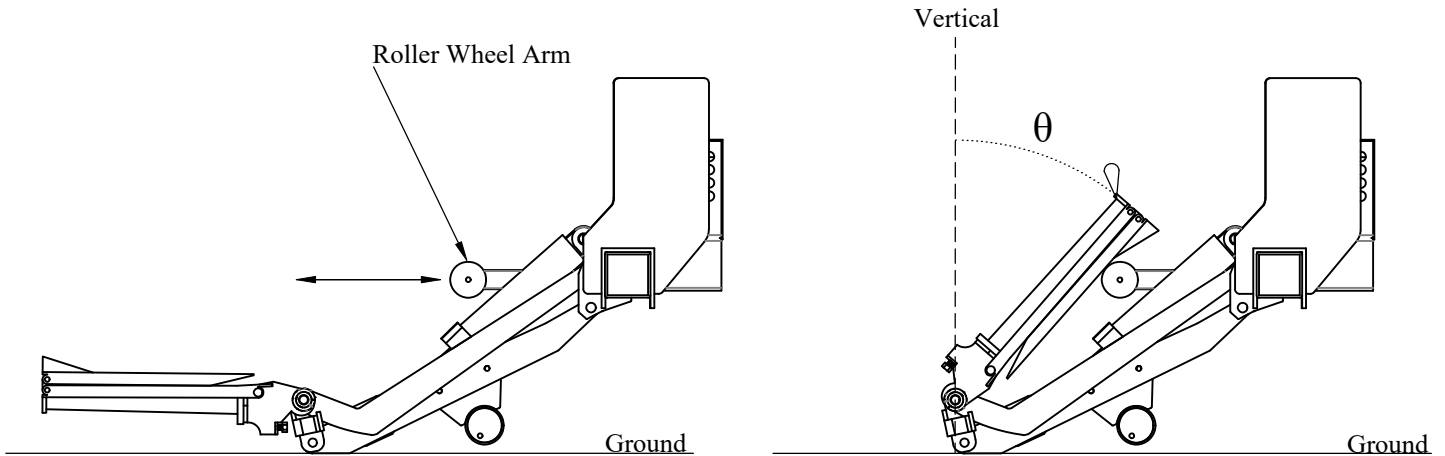


Figure 24: Roller Wheel Arm Adjustment.

Finish Welding the Liftgate on the Truck

- 1. Cover and Protect** hydraulic hoses, wiring, and painted surfaces from welding heat and sparks in the next steps.
- 2. Finish Weld** the trunnion tube mounting plates to the truck frame with 3/8" fillets (Figure 25).

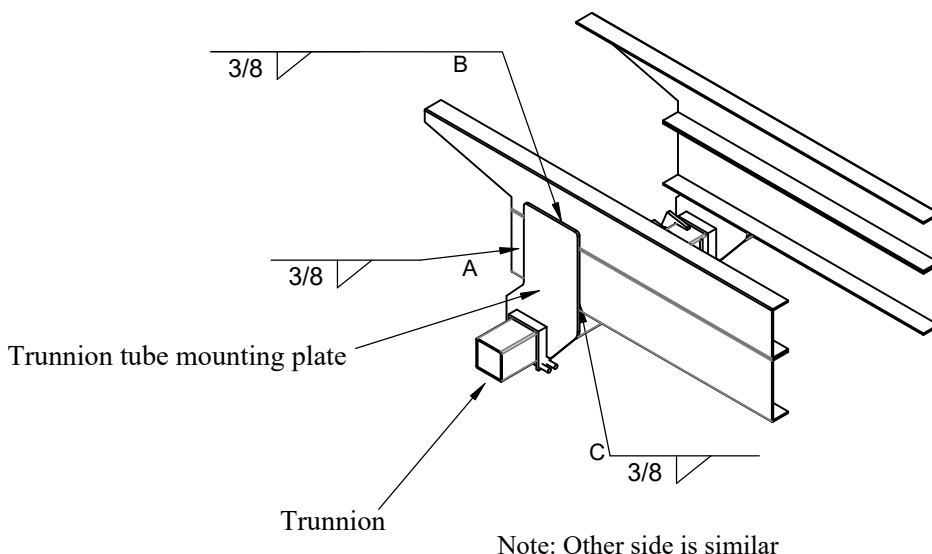


Figure 25: Finish Weld Locations.

Tuckunder Series; TKL Mounting Instructions

Finish Welding the Liftgate on the Truck (continued)

3. **Finish Weld** the bed extension with 3" long 1/4" fillet welds every 18" across width (Figure 26).

Do not complete this step if the bed extension is bolted on.

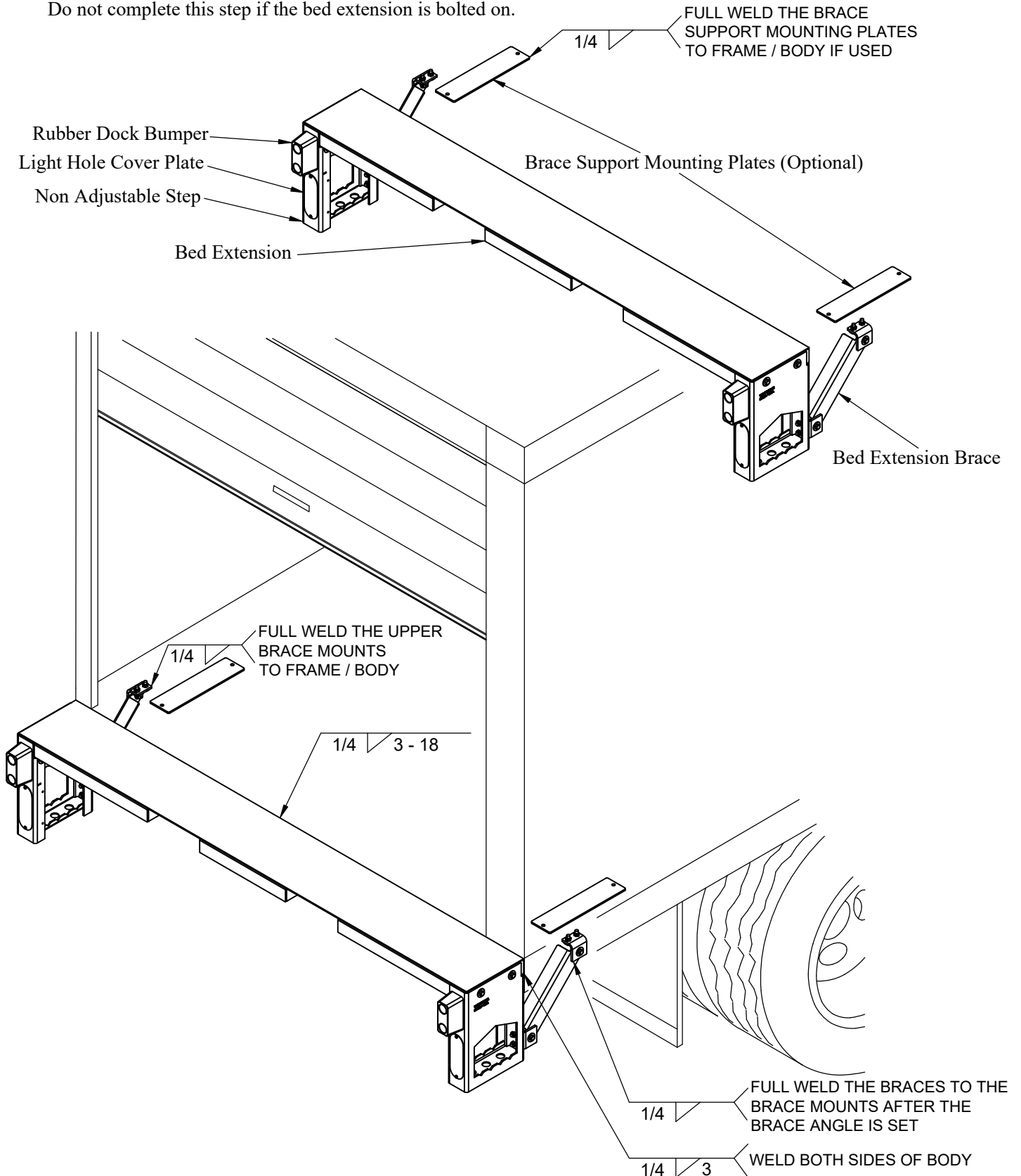


Figure 26: Bed Extension - Finish Weld Locations.

Tuckunder Series; TKL Mounting Instructions

Finishing Gate Installation

1. **Weld** bed extension braces into position (Figure 26).
2. **Verify** that all bolted joints on the bed extension are tight.
3. **Route** the control wire from the pump box (on the driver side) to mounting location on the rear of the truck (on the passenger side) (Figure 27).
4. **Bolt** the control to the body (on the passenger side) using the provided drill template as a guide to mount it.

Note: The hydraulic system has already been filled with the proper amount of hydraulic oil so do not add any oil at this time.

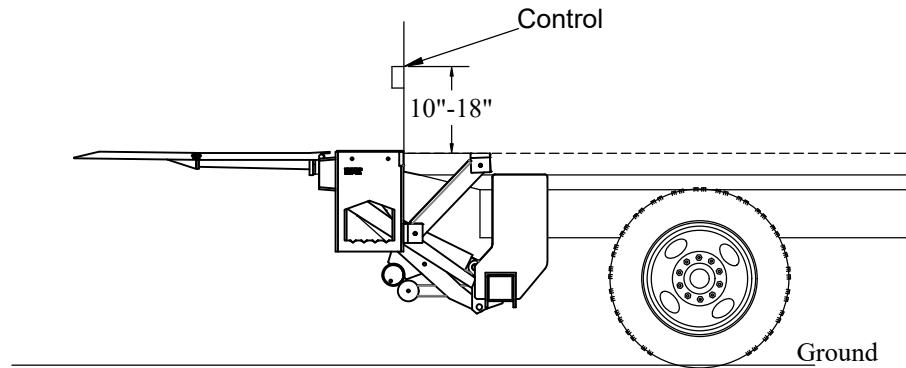


Figure 27: Control Positioning.

Installing the Optional Rear Bumper

1. **Choose** one of the three positions available for the rear bumper, make sure the rear bumper does not touch the ground when the platform reaches the ground.
2. **Use** the (4) provided 1/2"x1-1/2" bolts and 1/2" nuts to bolt the bumper in the selected position (Figure 28).

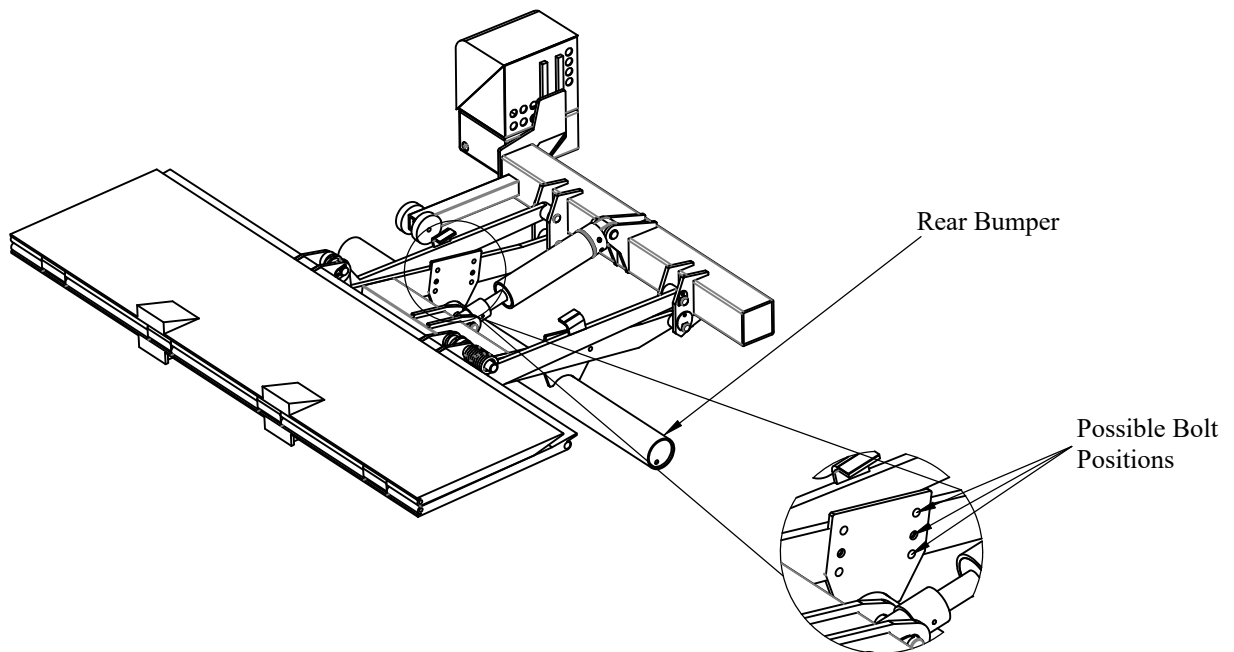


Figure 28: Rear Bumper Installation.

Tuckunder Series; TKL Mounting Instructions

Routing the Power Cables

1. **Attach** 12 volts from a battery to the liftgate power cables (no battery chargers). The negative cable is designated with a black stripe.
 2. **Lower** the liftgate to the ground.
 3. **Disconnect** the power from the liftgate.
 4. **Remove** the short 4GA power cables attached to the power unit.
 5. **Install** the 4GA power cable from the mounting kit on the power unit.
 6. **Route** the power cables along the frame to the battery. Follow the *Tommy Gate Recommended Electrical Wiring Guidelines*.
 7. **Install** the circuit breaker within 18" of the battery, leaving enough room for the power cables to be installed and so that the circuit breaker can easily be reset.
 8. **Pull** the excess cable beyond the battery.
 9. **Separate** the positive (+) and negative (-) leads.
 10. **Cut** the positive (+) lead to the length required to reach the auxillary (AUX) terminal of the circuit breaker.
 11. **Cut** the remaining positive (+) lead long enough to reach from the circuit breaker battery (BAT) terminal to the positive (+) battery terminal.
 12. **Cut** the negative (-) lead to the length required to reach the negative battery terminal.
- IMPORTANT: The Pump and motor unit for this lift can require significant electrical power at 12 volts D.C.
Be sure that the negative (-) ground lead is connected to the negative (-) terminal of the vehicle battery.
13. **Install** the copper lugs and shrink tubing on all required ends.
 14. **Connect** the circuit breaker and battery as outlined in the *Tommy Gate Recommended Electrical Wiring Guidelines* and wiring diagram (Figure 29 or Figure 30).

ELECTRICAL WIRING DIAGRAM - Standard Fixed Control - Tuckunder

!!! PLEASE READ AND FOLLOW ALL DIRECTIONS BEFORE PROCEEDING !!!



NOTE !!! IF GATES ARE NOT WIRED IN ACCORDANCE WITH THIS DIAGRAM YOUR WARRANTY WILL BE VOID.



WELDING NOTE !!! DISCONNECT ALL BATTERY CABLES. ALWAYS DISCONNECT THE GROUND CABLE FIRST. ATTACH THE WELDING GROUND TO THE TRUCK RATHER THAN THE LIFTGATE.

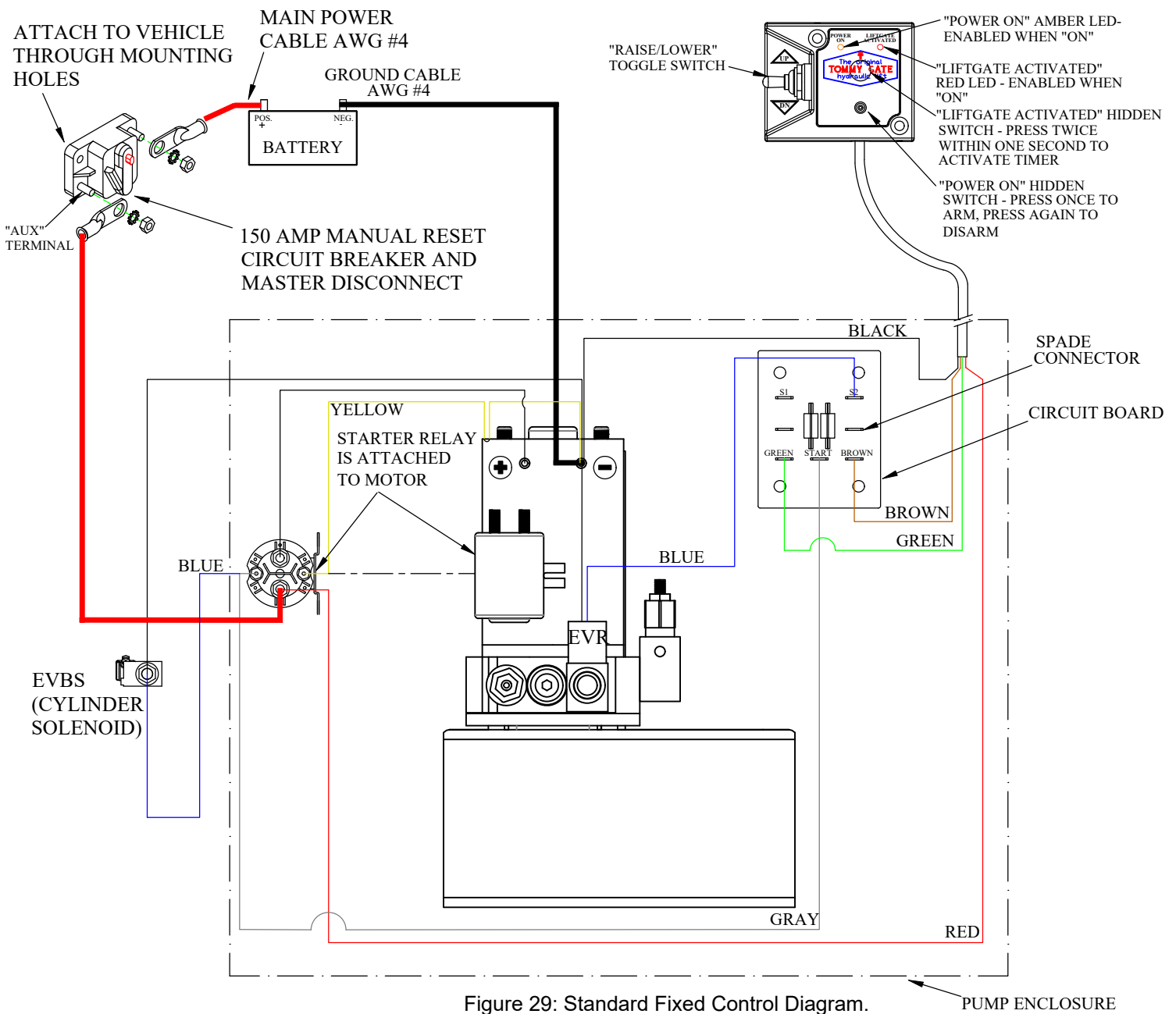


Figure 29: Standard Fixed Control Diagram.

PUMP ENCLOSURE

Electrical Schematic - TKL

Circuit schematic of the Tommy Gate TKL Liftgate wiring and Power Unit Control Circuit.

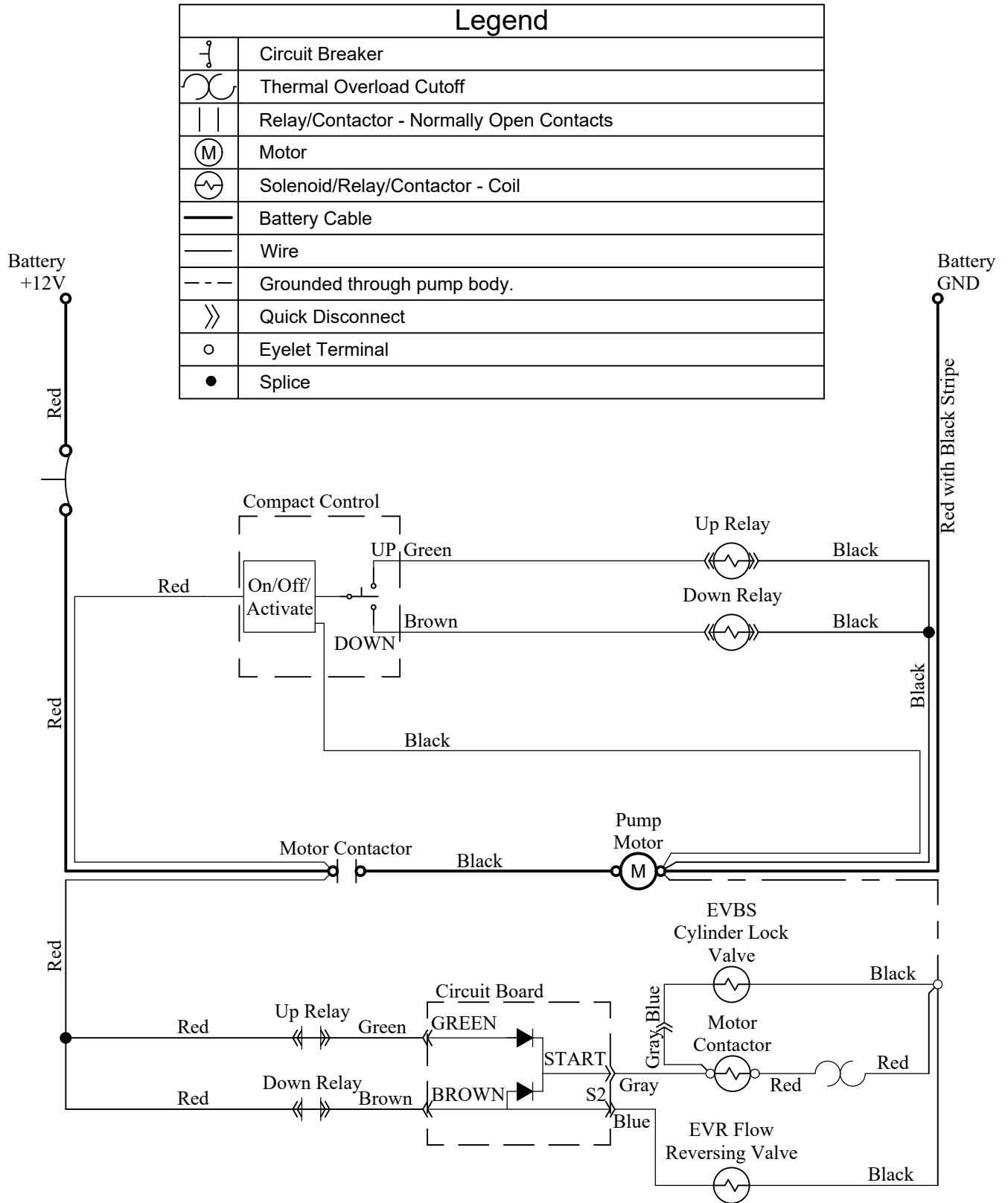


Figure 31: Electrical Schematic.

Tuckunder Series; TKL Mounting Instructions

Tommy Gate Recommended Electrical Wiring Guidelines

WIRE ROUTING

- (1) When routing wires, avoid heat (above 180°F), abrasion, vibration, metal edges, screws, and trim fasteners. If such routings are not possible, protective devices must be used. If wires must cross a metal edge, the edge should be covered with a protective shield and the wiring fastened within 3 inches on each side of the edge.
- (2) Grommets must be used where wires pass through holes in sheet metal, castings, and / or frame rails. Do not bend wires in a radius smaller than 10 times the wire diameter.
- (3) Routing wires into areas exposed to wheel wash should be avoided. If this cannot be avoided protective shields are required to protect the wires from stones, ice, salt and water damage. Provide a drip loop to prevent moisture from being conducted into switches, relays, circuit breakers, and fuses.
- (4) Wires should be supported every 18 inches with plastic zip ties or rubber-lined clips.
- (5) Wires must be routed to clear moving parts by at least 3 inches unless positively fastened or protected by a conduit. If wiring must be routed between two members where relative motion can occur, the wiring should be secured to each member, with enough wire slack to allow flexing without damage to the wire.
- (6) Maintain at least a 6 inch clearance from exhaust system components. If this is not possible, high temperature insulation and heat shields are required. Existing OEM heat shields, insulation, and wire shielding must be maintained.
- (7) Do not route or attach electrical wires to fuel lines. Route electrical wires at least 1-1/2 inches away from the engine.

BATTERY, WIRE, TERMINALS, AND CONNECTORS

- (1) Wire attachments at the battery must be protected from tension loads so there is no undue strain on the battery terminals. Wires should be routed down rather than horizontally from the terminals with no sharp bends adjacent to the connections.
- (2) Battery power for your Tommy Gate should come directly from the battery through the supplied circuit breaker or fuse. The circuit breaker or fuse should be installed as close to the battery as possible.
- (3) Do not splice battery cables. If splicing is necessary, the most durable splice joint will be bare metal barrel crimped, flow-soldered and covered with adhesive lined heat shrink tubing. Strip the wire ends making sure that individual conductor strands are not damaged. Use only rosin core solder, proper crimping tools, and wire with a gauge at least equivalent to the circuit being lengthened. Do not use electrical tape.
- (4) Battery cable terminals will be bare metal barrel crimped or flow-soldered and covered with adhesive lined heat shrink tubing.
- (5) Use wire connectors with locking features such as positive locking, inertia locking, bolt together, and soft mold-over with locking external retainers.

GENERAL

- (1) All frame contact areas must be wire brushed to bare metal, free of paint, dirt, and grease. Frame connections must be made using hardened flat washers under the bolt head and lock nuts. Corrosion preventive grease or compound is to be applied to the terminal area of the frame connection.
- (2) Frame cross members are not recommended as part of the ground return.
- (3) All circuit breakers and fuses should be located in one easily serviceable location with a means provided for identification of circuit function and current rating. Do not put circuit breakers or fuses in the vehicle cab.
- (4) Before welding to the chassis disconnect the battery. Also disconnect the power train, engine, valve, and transmission control modules.
- (5) Do not alter vehicle ignition, starting, and / or charging systems. Do not reroute engine compartment wiring.
- (6) Full copper circuitry and standardized polarity grounds are recommended.
- (7) Never increase the rating of a factory installed fuse or circuit breaker.
- (8) Disconnect the battery negative (ground) wire prior to any vehicle modification.

Following the above guidelines will provide you with years of trouble free service. Failing to incorporate the above guidelines will result in a voided warranty. Non-compliance with the guidelines above may result in a failure of electrical components, shutdown of engines, loss of backup brake systems, and the possibility of fire.

Tuckunder Series; TKL Mounting Instructions

Testing the Operation of the Liftgate

CAUTION: Keep all foreign objects (body parts, tools, load weights, etc) away from the liftgate main assembly and away from pinch points at all times when operating the liftgate.

1. **Check** operation of the safety control for proper lift operation. Be sure the control shuts off automatically after 5 minutes (or 90 seconds for pendant control) if not being used.
2. **Raise** and lower the unloaded platform on a flat surface looking for proper operating speed and alignment with the ground.
3. **Load** the platform with the rated capacity and **Measure** the time necessary to raise the platform. The platform should raise at roughly 3-4 inches per second.
4. **Examine** the platform for any downward creep.
5. **Time** the lowering operation with the platform still loaded. The platform should descend at roughly 5-6 inches per second.
6. **Remove** the load from the platform and **Examine** the liftgate and vehicle for any problems such as hydraulic oil leaks, loose wiring, etc.
7. **Reinstall** the pump box cover.
8. **Close** the platform folding extension.
9. **Store** the liftgate.
10. **Place** Owner's / Operator's Manual in the vehicle.

Painting the Liftgate (if needed)

No additional paint is required unless shipping or installation damage or outdoor storage exposure has deteriorated the Tommy Gate paint. **Tommy Gate will not be responsible for shipping or installation damage or outdoor storage exposure that has marred or otherwise deteriorated the Tommy Gate paint.**

If you need to refinish the painted surfaces of the liftgate you should do the following.

1. **Remove** any dirt, oil, grease, salt, or other contamination by washing with a mild detergent solution.
2. **Rinse** thoroughly with fresh water and allow to dry.
3. Lightly **Scuff Sand** the Tommy Gate topcoat.
4. **Sand** and **Spot Prime** any area of the Tommy Gate paint that shows signs of damage or deterioration.
5. **Mask** off all safety decals, cylinder shafts and vents before painting.

WARNING: Paint overspray on the cylinder shaft(s) or vent(s) will damage the cylinder seals and void warranty.

6. After proper cleaning and surface preparation, **Apply** desired finish coat per paint manufacturer's recommendations.
7. **Remove** the masking from the safety decals and cylinders.
8. **Check** to ensure that all decals are clean and legible. Additional decals are available from the factory, if needed.

Tuckunder Series; TKL Mounting Instructions

Platform Adjustment Instructions

If the platform is no longer at the desired angle at the ground, it may need adjustment. These instructions will aid you in adjusting the platform angle.

1. **Position** the liftgate so that the lift arms are touching the ground, but the platform is still folded (Figure 32).
2. **Support** the platform so that it cannot fall while performing the next step.
3. **Loosen** set screw.
4. **Screw / unscrew** the adjusting screws to raise or lower the platform.
5. **Unfold** the platform and folding extension.
6. **Verify** that the angle of the platform is acceptable.
7. **Tighten** set screws.
8. **Store** the liftgate.

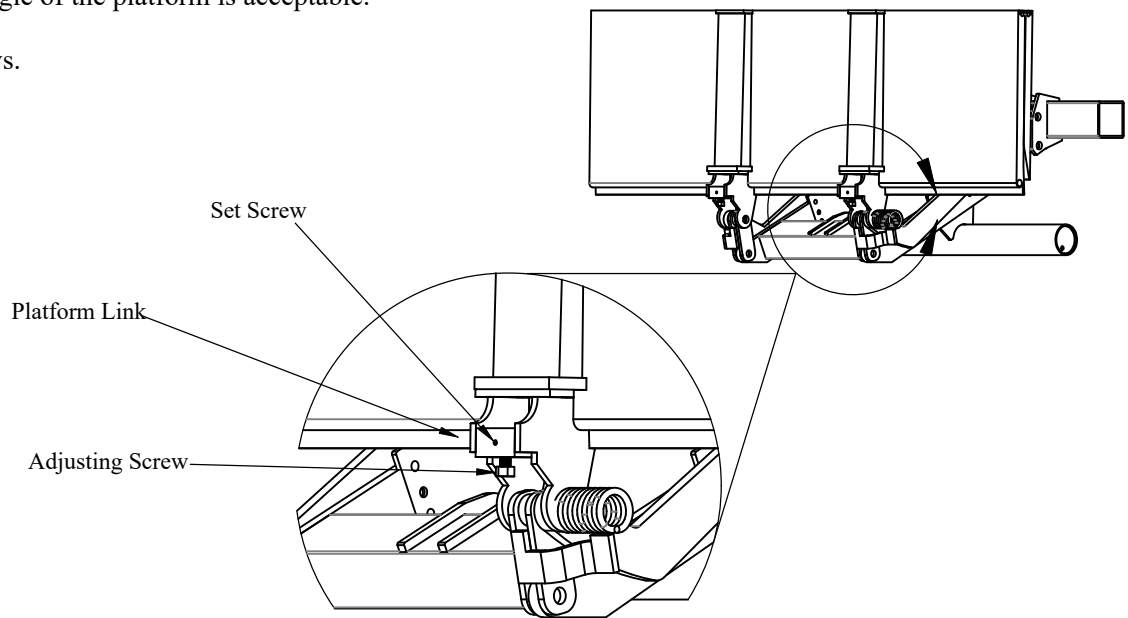


Figure 32: Platform Adjustment.

Tuckunder Series; TKL Mounting Instructions

Reflective Tommy Gate Flags Installation

1. **Insert** the aluminum bar into the reflective flag.
2. **Identify** the four (4) holes on the platform (Figure 33).

Note: Before riveting the flags, make sure they have the Tommy Gate logo facing the platform and the blank side facing up (Figure 33).

3. **Rivet** the aluminum bar to the platform using the provided rivets.
4. **Ensure** that the reflective side of the flags is in the correct position (reflective side facing the taper end of the platform) when the liftgate is deployed.

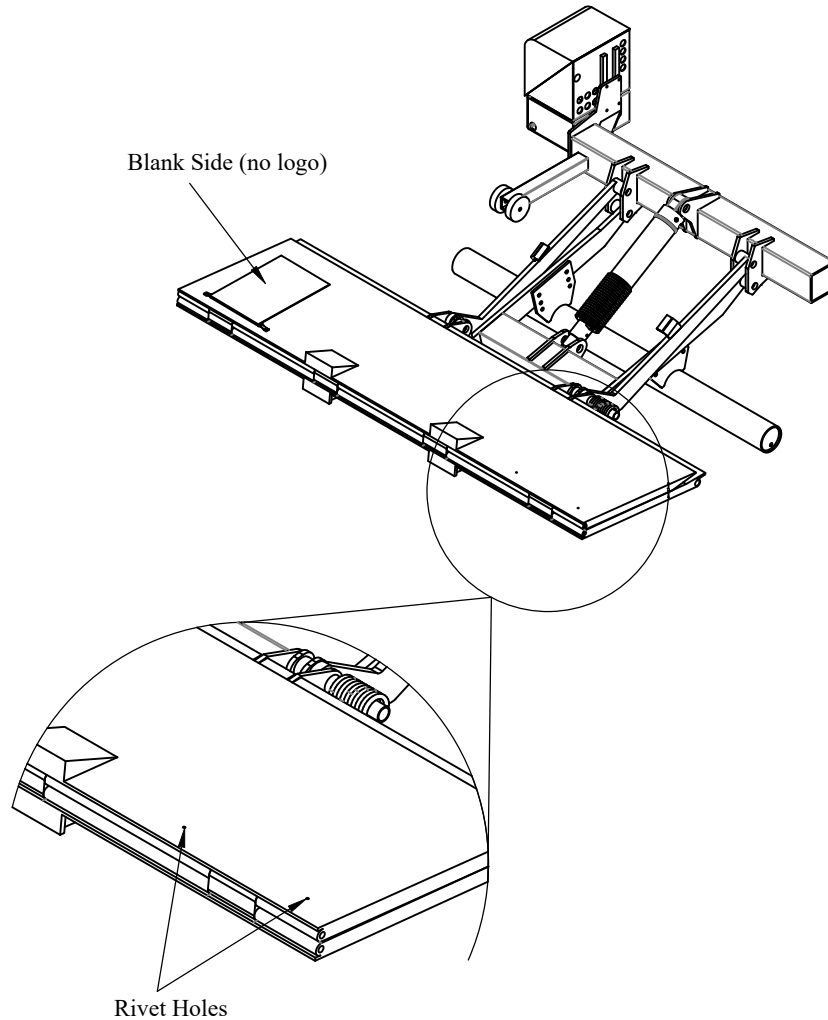


Figure 33: Platform Reflective Flags.

Operator's Instructions

1. Never show children or unauthorized personnel how to operate the liftgate.
2. Clear away obstructions that could damage the platform while the load is being raised or lowered.
3. Do not ride on the Platform. Be sure to stand to the side of the lift, not behind it when opening the platform.

4. To turn the control power on, press the "POWER ON" hidden switch once, marked with white rings or circles (located below the Tommy Gate logo). You should see the amber LED "POWER ON" light when the control is armed. To disarm the control press the "POWER ON" hidden switch again. Terms used for the control are shown in (Figure 34).

To activate the control, press the "LIFTGATE ACTIVATED" hidden switch twice within one second (located under the Tommy Gate logo). You should see the red "LIFTGATE ACTIVATED" light when the control is activated. To lower the platform, push the control toggle switch down. To raise the platform, push the control toggle switch up. When you remove pressure from the control toggle switch, the operation will stop.

After you have activated the control by pressing the "LIFTGATE ACTIVATED" hidden switch twice within one second (located under the Tommy Gate logo), you have approximately 5 minutes to use the gate. If the gate is not used for approximately 5 minutes, the "LIFTGATE ACTIVATED" time deactivates the control.

If the gate is used during the 5 minutes, the "LIFTGATE ACTIVATED" timer automatically resets for an additional 5 minutes. To reactivate the timer, press the "LIFTGATE ACTIVATED" hidden button twice.

Note: If your gate includes a pendant control, the operation of the pendant will be the same but the "LIFTGATE ACTIVATED" timer will be 90 seconds.

5. To lower the liftgate, stand off to the side, well clear of the liftgate, and **push down** on the control toggle. The platform will rotate under the truck as the liftgate is lowered.
6. With the liftgate arms touching the ground, stand off to the side, and **unfold** the platform (Figure 35).

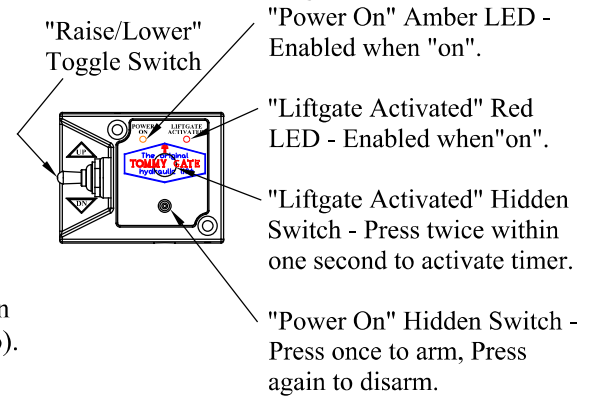
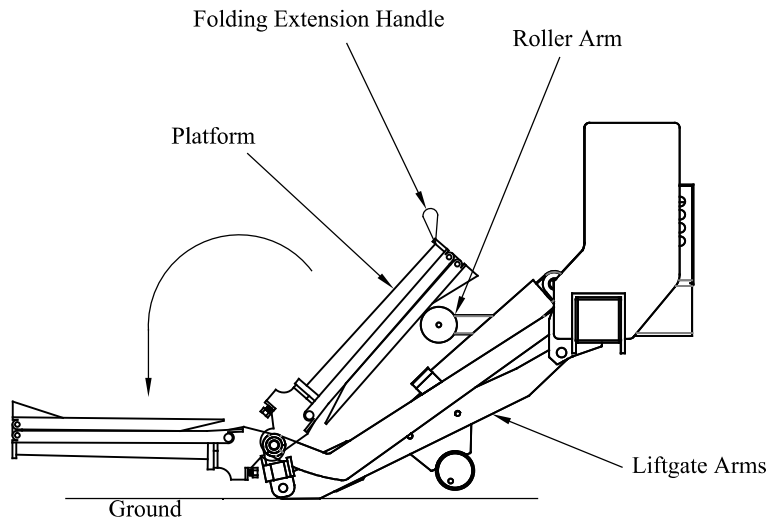


Figure 34: Control Terms.

Figure 35: Step 6.

Tuckunder Series; TKL Mounting Instructions

Operator's Instructions (continued)

- Stand off to the side and **unfold** the platform folding extension (Figure 36).
- To load and use the liftgate, **center** the load on the platform side to side and front to back (Figure 38). Put heavier loads as close to the front of the platform (near truck) as possible. Platform cart stops may be actuated at this time, if equipped.

Note: Liftgate capacity depends on both the weight and location of the load. Loads placed closer to the taper may reduce lifting capacity or damage the liftgate. See [Figure 2: TKL Load Capacity](#) on Page 7.

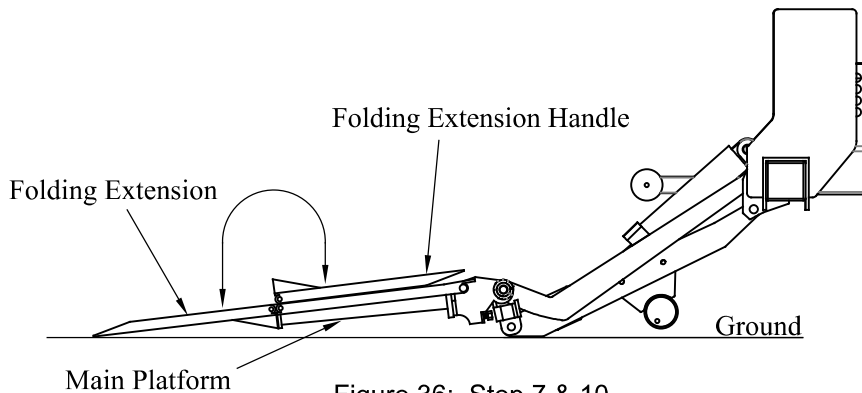


Figure 36: Step 7 & 10.

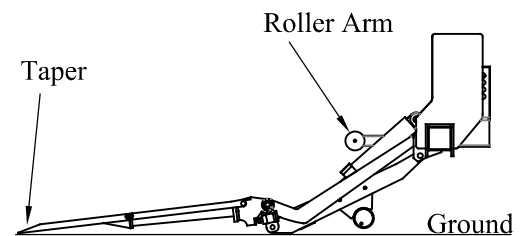


Figure 37: Step 9.

- To raise (or lower) the load, stand off to the side, well clear of the platform and **push up** (or down) on the control toggle switch until the load has reached the desired position. Do not allow the pump and motor to continue to run after the platform has reached its maximum height or after it has reached an obstruction (Figure 37).
- To close the platform, stand to the side of the platform, not under or behind the platform. With the liftgate lowered, **close** and **lock** the platform cart stops, if so equipped, then **fold** the folding extension by lifting on the handle (Figure 36).
- With the liftgate arms touching the ground, stand to the side of the platform, and **fold** the platform closed until it rests on the roller arm (Figure 39).
- Raise** the liftgate by pushing up on the control toggle. The platform will rotate under the truck into the stowed position.
- Always **deactivate** the control when not in use.

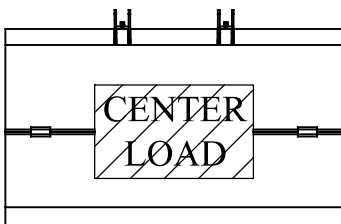


Figure 38: Step 8.

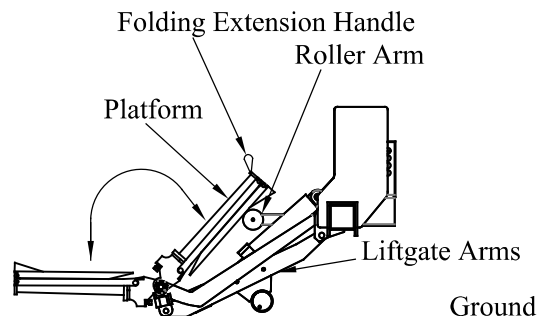


Figure 39: Step 11.