

# ALITEC

## *POWER ATTACHMENTS*

### SKID STEER COLD PLANER

DUAL CIRCUIT VALVE

MODEL

**CP40G/P**

*EFFECTIVE SERIAL NO. 6700010403*

#### **MANUAL**

- \*Operation
- \*Maintenance
- \*Service
- \*Parts

M-CP40G/P  
(Rev. 4/30/2019)  
4/4/03



# INTRODUCTION

Thank you for your investment in Alitec attachments. We are confident that you will find that your Alitec attachment is the easiest to operate, safest, most durable, and most efficient attachment on the market.

Your Alitec attachment is equipped with high performance, heavy duty components. To ensure that these components operate properly and effectively, this manual must be followed. If any question regarding the operation or performance of this attachment exists, contact your Alitec dealer at once.

This manual contains safety instructions, guidelines for efficient operation, troubleshooting tips, and service and maintenance procedures. When applicable, the terms “right” and “left” are referenced from a sitting position facing forward in the loader.

Throughout this manual, information is provided in boxes and highlighted by the word **IMPORTANT**. This information should be read carefully. If complied with, it will improve the operating efficiency of the unit and provide directives that will minimize costly breakdowns and extend the life of the machine.



This warning symbol appears throughout this manual and indicates that a safety hazard may exist if the information given is not properly followed. When the warning signal is encountered in the manual or on the unit, Be Alert! Your personal safety is involved!

For more copies of this manual or the necessary safety decals, contact your Alitec dealer.

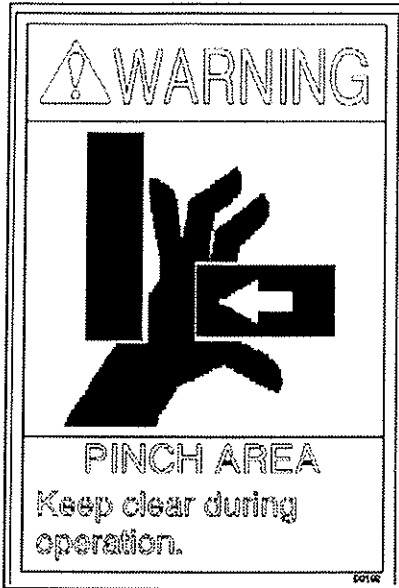
Record the attachment model and serial number, as well as the dealer from which the unit was purchased for future reference.

<b>ALITEC</b>		<b>CE</b>
<b>Power Attachments</b>		
ALITEC Corporation Brownsburg, IN, USA	Date of Manufacture:	
Pressure In Bar:	Weight (Kgs):	
Machine Model No:		
Machine Serial No:		

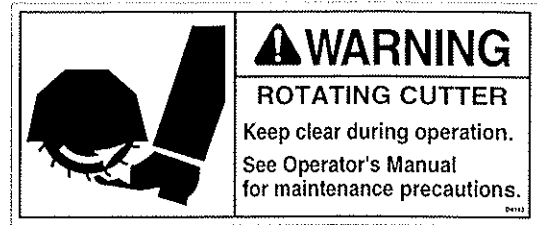
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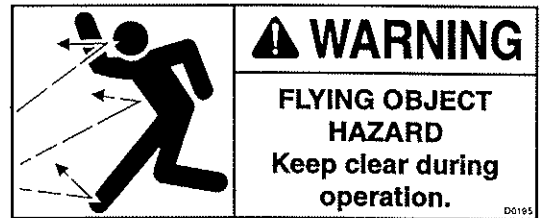
# SAFETY RULES



This decal indicates possible pinch point areas on the attachment. Stay clear of these areas during operation. Failure to observe this warning could result in serious injury and death! (D0192)





The rotating drum can snag clothing and body parts during operation. Stay clear of these areas during operation. Failure to observe this warning could result in serious injury and death! (D0193)




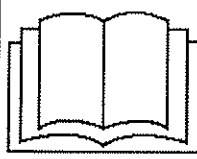
This decal indicates that flying object hazard exists while the unit is operating. Stay clear of these areas during operation. Failure to observe this warning could result in serious injury and death! (D0195)

<b>WARNING</b>	
<p><b>FALLING OFF CAN RESULT IN BEING RUN OVER.</b></p> <ul style="list-style-type: none"> <li>■ Skid steer must have ROPS and seat belt/operator restraint. Keep seat belt/operator restraint securely fastened.</li> <li>■ Never allow riders.</li> </ul> <p><b>RAISED EQUIPMENT CAN DROP AND CRUSH.</b></p> <ul style="list-style-type: none"> <li>■ Never go under raised equipment or raised skid steer lift arms. They can drop from hydraulic or mechanical failure, or moving control levers.</li> <li>■ Service work does not require going under equipment. Read manual instructions.</li> </ul> <p><b>FALLING OFF OR GOING UNDER MACHINE CAN RESULT IN SERIOUS INJURY OR DEATH.</b></p>	
<small>54519-B</small>	

54519

 <p>19924-B</p>	 <b>WARNING</b>
	<p><b>HIGH-PRESSURE HYDRAULIC OIL LEAKS CAN PENETRATE SKIN RESULTING IN SERIOUS INJURY, GANGRENE OR DEATH.</b></p> <ul style="list-style-type: none"> <li>■ Check for leaks with cardboard; never use hand.</li> <li>■ Before loosening fittings: lower load, release pressure, and be sure oil is cool.</li> <li>■ Consult physician immediately if skin penetration occurs.</li> </ul>

19924

 <b>WARNING</b>	
 <p>D0404-A</p>	<p><b>TO AVOID SERIOUS INJURY OR DEATH:</b></p> <ul style="list-style-type: none"> <li>■ Read operator's manual and power unit manual before operating, servicing, or repairing attachment. Follow all safety rules and instructions. (Manuals are available from dealer or, in the United States and Canada, call 1-800-790-0887.)</li> <li>■ Only operate from operator's seat with seat belt/operator restraint securely fastened.</li> <li>■ Before leaving operator's seat: follow power unit manual instructions, lower lift arms and attachment to ground, stop engine, remove key, engage brakes, and remove seat belt/operator restraint.</li> <li>■ Allow no children or untrained persons to operate equipment.</li> </ul>

D0404

# SAFETY PRECAUTIONS

**ACCIDENTS ARE PREVENTABLE**  
**WITH YOUR HELP**



## WARNING

**BEFORE OPERATING THIS EQUIPMENT, THE FOLLOWING SAFETY INFORMATION SHOULD BE READ AND UNDERSTOOD. IN ADDITION, EACH INDIVIDUAL WORKING WITH THE EQUIPMENT SHOULD BE FAMILIAR WITH THE SAFETY PRECAUTIONS.**

Exercise extreme caution when hitching and removing the attachment, operating with other workers present, and servicing the unit.

Alitec always makes operator safety a priority when designing machinery. Exposed moving parts are guarded whenever possible for safety. However, not all moving parts can be shielded in order to ensure proper operation. This operator's manual and the safety decals on the machine provide important safety information when observed closely. If safety decals become difficult to read, replace them immediately (see "Safety Decals").

# MANDATORY SAFETY SHUTDOWN PROCEDURE

**BEFORE** cleaning, adjusting, lubricating, or servicing this unit, **ALWAYS** follow the **MANDATORY SAFETY SHUTDOWN PROCEDURE**:

1. Move the skid steer loader propulsion control lever to the "neutral" position.
2. Shut off the attachment by shutting off the auxiliary hydraulic output.
3. Lower the loader lift arms completely and roll the attachment forward so it is securely resting on firm ground or the shop floor.
4. Engage the loader park brake.
5. Move the loader throttle to the slow idle position, shut the engine off, and remove the ignition key.
6. Keep the key with you at all times when working on the unit so no one can start the engine without your knowledge.




## WARNING

**FAILURE TO FOLLOW THE PROCEDURES BEFORE CLEANING, ADJUSTING, LUBRICATING, OR SERVICING THIS UNIT COULD LEAD TO SERIOUS INJURY OR DEATH.**


# SAFETY

A careful operator is the best protection against accidents. Most accidents involving operators of industrial equipment are caused by failure to observe basic safety precautions. Familiarize yourself with the safety precautions listed below.

 **WARNING**


**THE FOLLOWING PRECAUTIONS MUST BE OBSERVED FOR THE SAFETY OF THE OPERATOR AND/OR SERVICE PERSONNEL.**

1. Read and observe all safety information and decals on the skid steer loader and attachment **BEFORE** operating the unit! (See Safety Decals). In addition, familiarize yourself with all loader safety devices and check daily that they are functioning properly.
2. Refer to the **SAFETY** section of your skid loader operator's manual and observe all safety recommendations set forth in that manual.
3. Never raise the attachment more than 24" off the ground. When loading, keep attachment as low to ramps and trailers as possible.
4. Always lower the loader arms fully before leaving the skid steer seat.


 **WARNING**

**NEVER CRAWL UNDER RAISED LOADER ARMS.**

5. **BE SURE** to raise the attachment totally off the ground **BEFORE** sideshifting.
6. **CAREFULLY** inspect **ALL** hydraulic hoses and connections on a routine basis. Always use a piece of cardboard when searching for leaks.
7. **BE SURE** to exercise the above **MANDATORY SAFETY SHUTDOWN** procedure **BEFORE** proceeding with any work on the attachment.

 **WARNING**

**NEVER USE YOUR HANDS AS ESCAPING FLUID UNDER PRESSURE CAN PENETRATE THE SKIN CAUSING SERIOUS INJURY. IF HYDRAULIC FLUID DOES PENETRATE THE SKIN, SEEK IMMEDIATE MEDICAL ATTENTION BY A DOCTOR FAMILIAR WITH THIS TYPE OF INJURY OR GANGRENE MAY RESULT.**

 **WARNING**

**NEVER ALLOW HANDS OR FEET NEAR ANY WORKING PART OF THE ATTACHMENT UNLESS THE MANDATORY SAFETY SHUTDOWN PROCEDURE HAS BEEN COMPLETED.**

# SETUP



## WARNING

**READ THE ENTIRE MANUAL AS WELL AS THE DECALS ON THE ATTACHMENT (See Safety Section) BEFORE ATTEMPTING ANY MAINTENANCE, SERVICE, REPAIR, OR SETUP OF THE UNIT.**

Although the Alitec attachment is supplied fully assembled, some simple checks should be performed before operation begins.

### Safety Decals

The safety decals existing on the attachment should be clearly readable and always followed. The location and description of the decals is shown in the exploded diagram. Copies of the decals are shown in “**Safety Decals**” section.

### Lubrication

All attachment wheels, as well as the sideshift bars and pivot points shown in the exploded diagram, should be greased after 40 hours. All bearings should be greased with a high temperature bearing grease after 40 hours of use. Planetary gear lubrication should be changed with EP90 gear lubrication after the first 50 hours of use and every 500 hours of operation thereafter.

### Drum Assembly

For proper operation, all picks or teeth must be installed in all holders. Inspect picks every 4 hours of operation. If any picks show excessive wear (carbide tip missing/damaged or pick body worn), **replace all worn picks.**

### Hoses / Fittings

Hydraulic fittings are used to connect all attachment hoses. All fittings should be tight and free of hydraulic leaks. Hoses must be free of crimps or cuts that might result in leakage. Check your attachment before operation to make sure all hose routings are kink-free and allow for maximum movement of all sideshift, lift/lower, and/or swing motion required during normal operation.

### Retaining Rings

The sideshift cylinder as mounted for operation is retained with three (3) one inch external retaining rings; (4) in each depth cylinder and two (2) on the tilt cylinder.

## IMPORTANT

The planer should not be operated at any time when any of these rings are damaged or missing.



# OPERATION

The planer attachment is hydraulic powered and intended for use in milling asphalt or concrete surfaces. The performance of the attachment can vary greatly depending upon how it is used and operated. Therefore, the recommended operating procedures contained within this manual should be followed at all times for maximum productivity.

As noted in the Alitec literature, the attachment requires a minimum hydraulic supply of 25 gallons per minute (90 liters per minute) at 2000 psi.

## IMPORTANT

Insufficient hydraulic power will result in poor performance.

In attaching the planer to the skid steer, ensure that all **three** hydraulic hoses are coupled securely to the quick couplers.

## IMPORTANT

Casedrain must be attached and hose pressure must not exceed 15psi. Motor seal failure will occur if the casedrain is not attached, if the hose is crimped, or if hose pressure is excessive. All hoses should be free of kinks, cuts, or abrasions for safe operation.

When using a quick attachment hookup to the skid steer, the locking pins on the loader arms should always be engaged and secured.

When engaging the hydraulic power to the attachment, the drum should **not** be in contact with the surface to be planed. Free rotation is required to prevent excess pressure spikes upon startup. As is always the case, the operator must always be seated in the host vehicle upon startup.

Engage the hydraulic power. Set the depth indicator slightly less than the desired depth. Actuate the bucket cylinder function for rollout until the planer wheels come in contact with the planing surface. Make a trial cut.

Set the depth to the desired depth. Advance the skid steer forward slowly after the desired planing depth is attained. The drum rotation will stall when the load on the planer is too high. This is most likely the result of excessive ground speed. Stop, reverse skid steer direction slightly, and proceed forward.

For maximum productivity, the planer should be operated at full engine throttle.

## IMPORTANT

For proper operation, the majority of the weight of the front of the skid steer should be placed upon the planer with the loader arms fully lowered. The transfer of skid steer weight to the attachment results in smoother, faster planing. The loader arms should never be placed in the float condition because excessive vibration will result.

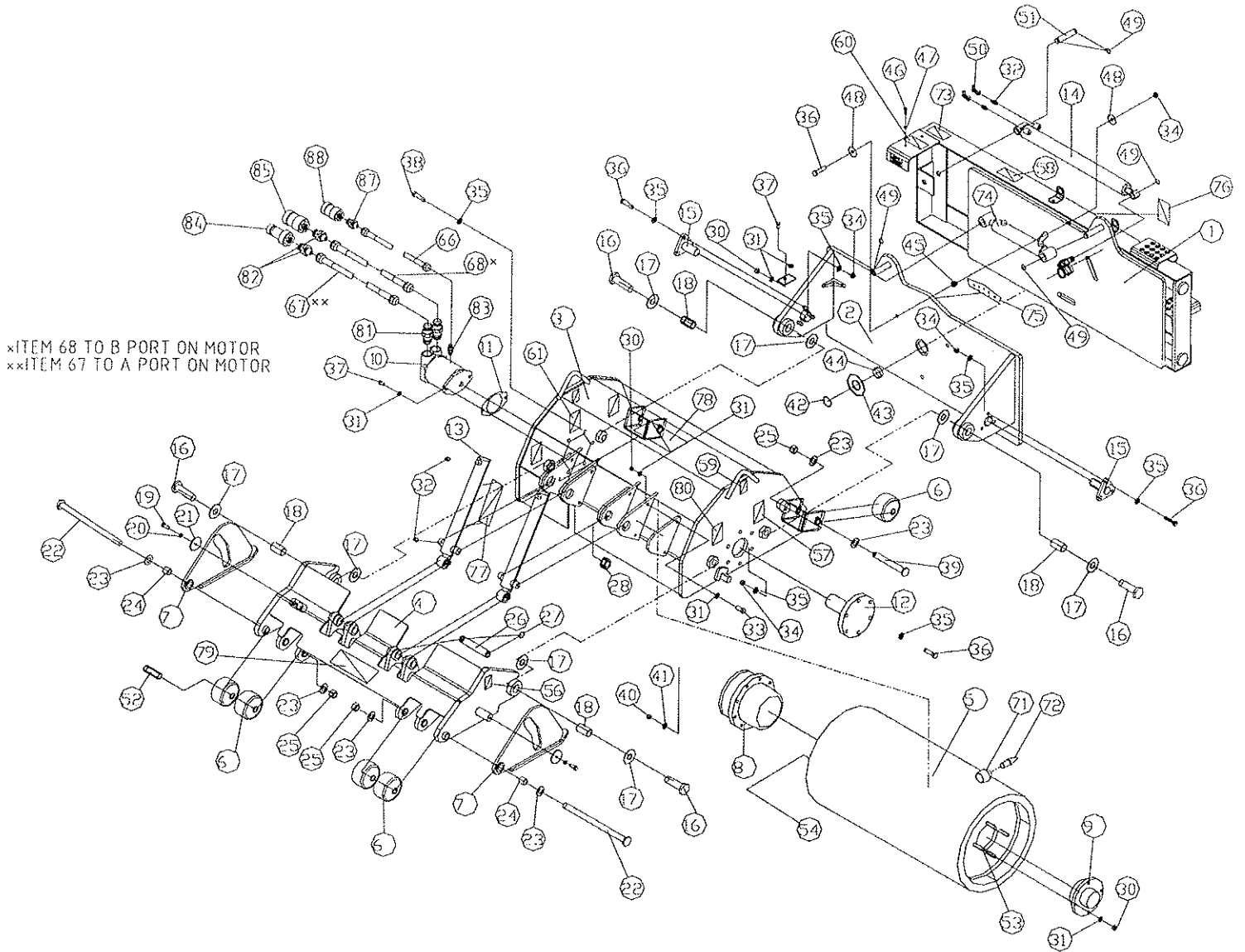
With the rear gauge wheel(s) set for acceptable planing depth, the bucket function should be used for lifting or lowering during operation.

## IMPORTANT

The bucket cylinder function should never be used to stop operation due to the existence of secondary reliefs on some skid steer bucket cylinder.

**ALITEC**

# EXPLODED VIEW- CP40G/P



# PARTS LIST - CP40G/P

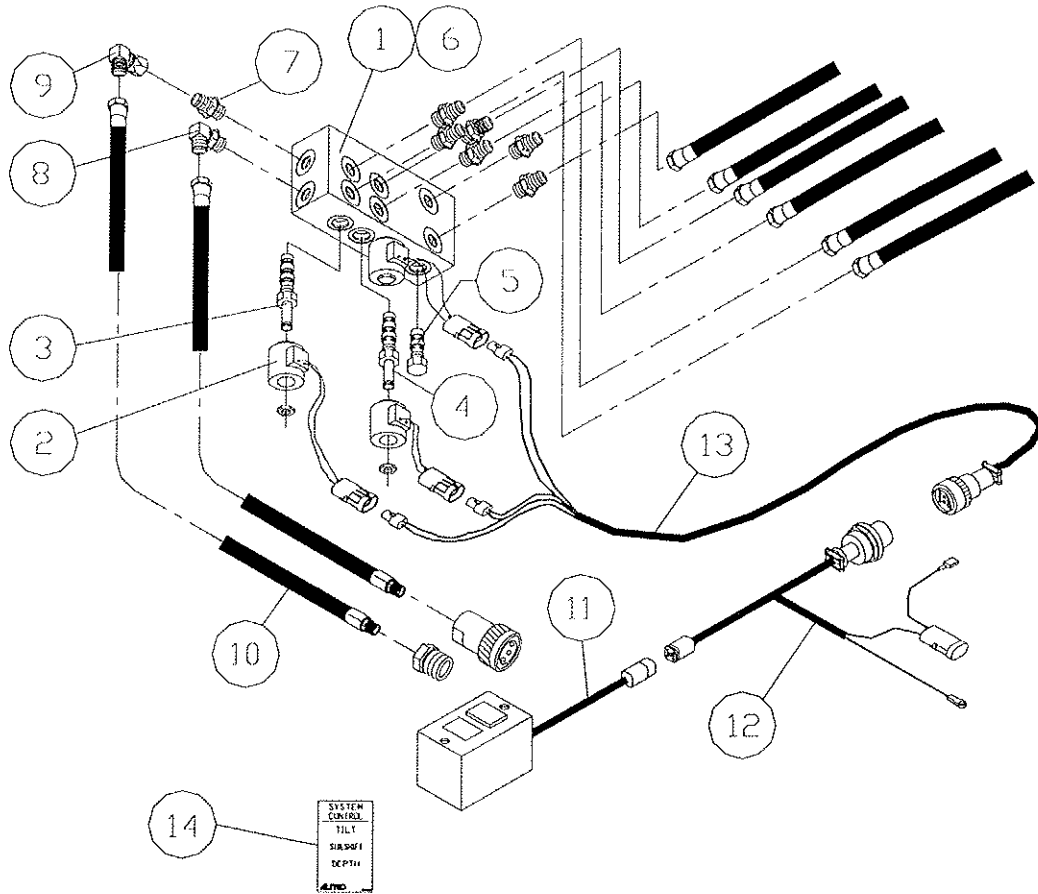
ITEM #	DESCRIPTION	PART #
1	ATTACH FRAME	106798
2	BACKPLATE, PIVOT	102435
3	CHASSIS	102407
4	FRONT WHEEL BRACKET	102428
5	DRUM	102599
6	WHEEL	100604
7	FRONT WHEEL SKID PLATES	102469
8	HUB, PLANETARY (HIGH FLOW)	HC440
	(HIGH PRESSURE)	HC439
9	BEARING, DRUM	BB001
10	MOTOR, SAUER-DANFOSS M44	HC551
	SHAFT SEAL	S01-00013
11	GASKET	M0009
12	DEADSHAFT, CHASSIS	102711
13	CYLINDER, DEPTH	3038344
14	CYLINDER, SIDESHIFT	C2201
15	DEADSHAFT, PIVOT ARM	102438
16	BOLT, 1.25" X 4.5" -7 GR8 HEX	B2005
17	WASHER, 2" FLAT GR8 PLT	B3221
18	BUSHING, 1.5625" X 1.295" X 2.625"	BB134
19	BOLT, 1/2" X 1.5" -13 GR8 PLT	B0801
20	WASHER, 1/2" LOCK	B0821
21	SPACER, WHEEL BRACKET PIVOT ARM	102167
22	BOLT, 1" X 16" UNC GR8 PLT	B1633
23	WASHER, 1" FLAT SAE PLT HRD	B1620
24	BUSHING, 1.25" X 1.01" X 1.13"	T1006
25	NUT, 1" -8 GR5 PLT NYLOK	B1615
26	PIN, 1.25" X 7.13" SNAP RING 6.5	T1088
27	RING, RETAINING 1.25"	M0030
28	BOSS, DEPTH CYLINDER MOUNT	102145
29	BRACKET, CYLINDER RETAINING	102913
30	NUT, 1/2" -20 STOVER GR5 PLT	B0816
31	WASHER, 1/2" FLAT SAE HRD	B0820
32	FITTING, 6OM X 6SLM ST	F1407
33	BOLT, 1/2" X 1.75" -20 GR5 PLT	B0828
34	NUT, 5/8" -11 STOVER UNC GR5	B1015
35	WASHER, 5/8" SAE PLT HRD	B1020
36	BOLT, 5/8" X 2.5" -11 GR8 PLT	B1001
37	BOLT, 1/2" X 1.5" -13 GR8 PLT	B0801
38	BOLT, 5/8" X 2" -11 W/VIBER TITE	B1004
39	BOLT, 1" X 8" UNC GR8	B1605
40	NUT, 9/16" -18 STOVER GR5 PLT	B0915
41	WASHER, 9/16" FLAT SAE PLT HRD	B0920
42	RING, RETAINING 2" EXT PLT	M0042
43	WASHER, 2" FLAT GR8 PLT USS	B3221
44	BUSHING, PIVOT 2" X 2.5" X .625"	100601
45	BUSHING, 1" X .66" X .685"	BB135
46	BOLT, 3/8" X 1" -16 GR5 HEX	B0611
47	WASHER, 3/8" FLAT SAE PLT HRD	B0621
48	WASHER, 5/8" FLAT USS PLT HRD	B1020
49	RING, RETAINING 1"	M0003
50	FITTING, 6SLF X 6SLM 90°	F1387
51	PIN, 1" X 5.17" SNAP RING 4.5	T1035

**ALITEC**

# PARTS LIST- CP40G/P, CONT'D

<u>ITEM #</u>	<u>DESCRIPTION</u>	<u>PART #</u>
52	BUSHING, WHEEL GUIDE	101218
53	STUD, BEARING MOUNT	M0165
54	STUD, PLANETARY MOUNT	M0153
55	FITTING, 6OM X 6SLM X 6SLM	F1459
56	DECAL, PINCH POINT	D0192
57	DECAL, ROTATING CUTTER	D0193
58	DECAL, READ MANUAL	D0404
59	DECAL, LIFT POINT	D0158
60	DECAL, NO STEP	D0209
61	DECAL, PANETARY OIL	D0042
62	HOSE, DEPTH CONTROL #4 X 90" 6SLFX6SLF R2	H1633
63	HOSE, DEPTH CONTROL #4 X 20" 6SLFX6SLF 90° R1	H1609
64	HOSE, SIDESHIFT #4 X 20" 6SLFX6SLF 90° R1	H1609
65	HOSE, AUXILLARY #4 X 135" 6SLFX6SLF 90° R1	H1632
66	HOSE, MOTOR CASEDRAIN #6 X 70" 6SLFX6SLF R1	H1631
67	HOSE, MOTOR RETURN #12 X 70" 16SLFX16SLF R1	H1630
68	HOSE, MOTOR PRESSURE #16 X 70" 16SLFX16SLF 5000PSI	H1629
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71	PICK HOLDER	100256
72	PICK (87)	102572
73	DECAL, CASEDRAIN	D0323
74	CYLINDER, TILT	C0802
75	DECAL, TILT ANGLE	D0108
76	DECAL, TIE DOWN	D0157
77	DECAL, DEPTH	D0272
78	DECAL, CP40	D0444
79	DECAL, ALITEC	D0119
80	DECAL, FLYING OBJECTS	D0195
81	FITTING, 12OM X 16SLM 90°	F1480
82	FITTING, 12OM X 16SLM 45°	F1471
83	FITTING, 10 OM X 6SLM	F1465
84	PLUG, FITTING 16SLM	F1474
85	PLUG, FITTING 16SLM	F1474
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87	FITTING, 8OM X 6SLM ST	F1442
	MANUAL, SERVICE/PARTS	M-CP40G/P

# 3-STAGE VALVE



## PARTS LIST - 3 STAGE VALVE

ITEM #	DESCRIPTION	PART #	"XT" FACE SEAL
1	VALVE ASSEMBLY	HC222	
2	COIL, SOLENOID	S01-00089	
3	SOLENOID CARTRIDGE, C1 PORT	HC081	
4	SOLENOID CARTRIDGE, C2, C3 PORT	HC214	
5	CHECK VALVE	HC254	
6	VALVE BODY FOR HC222	HC255	
7	FITTING, 6OM-6FLM ST	F1044	
8	FITTING, 6OM-6SLM ST	F1071	F1407
9	FITTING, 6OM-6FLM 90	F1057	F1327
	FITTING, 6FLF-6FLM 90		
	FITTING, 6SLF-6SLM 90		F1387
10	HOSE, AUXILIARY	H1017	
11	TRACTOR HARNESS	E0064	
12	INTERMEDIATE HARNESS	E0063	
13	ATTACHMENT HARNESS	E0065	
14	DECAL, SYSTEM CONTROL	D0251	
	HARNESS ASSEMBLY (ITEMS 11,12,13)	E0066	
	OPTIONAL HARNESS ASSEMBLY	E0146	

# MAINTENANCE

Proper maintenance of the attachment will result in longer life and the most productive and cost effective operation. There are two basic categories of maintenance required, pick/holder replacement and component lubrication. For proper operation, the picks should be checked each four (4) hours and lubricated daily to ensure that they can freely rotate in their holders.

**Pick Replacement** - As regular use takes place, normal wear of the carbide picks will occur with the outer most picks wearing first. The pick tool included with the planer should be used to remove the picks from the cast holders. In the event the pick tool is not available, any hardened punch or tool allowing access to the bottom of the holders can be used.



## WARNING

**NEVER DRIVE THE PICK IN BY STRIKING IT DIRECTLY ON THE END AS THIS CAN CAUSE THE PICK TO CHIP AND CAUSE INJURY OR CREATE SMALL STRESS FRACTURES IN THE PICK RESULTING IN PREMATURE WEAR.**

A length of pipe with a ¾ to 1 inch inside diameter can be placed over the pick to protect it from a direct hit. Striking a small piece of wood placed on the pick to absorb the shock will prevent damage.



## WARNING

**ALWAYS WEAR SAFETY GLASSES WHEN PERFORMING THIS OPERATION. HARDENED TOOLS AND PICKS CAN SHATTER CAUSING INJURY.**

## IMPORTANT

To prevent the picks from seizing in the holders, the picks should be sprayed with diesel fuel at the end of each day. This will break down the asphalt build-up in the holders and prevent premature wear by allowing the picks to rotate in the holders. Excess diesel fuel should be caught in a collection pan and properly disposed.

**Lubrication** Lubricate the grease points daily on all planer wheels as well as the drum bearings.

The lubricant in the gear case of the planetary must be changed within the first 50 hours of operation. After that, the lubricant need only be changed once per year or every 1000 hours which ever occurs first.

## IMPORTANT

Type of lubricant should be 80W-90 gear lube, with an EP(extreme pressure) rating of GL-5 minimum. Nineteen (19) ounces is required for each change.

The lubricant can be changed by removing the drain plug located on the planetary gear box flange between the chassis and the drum. Rotate the drum until the plug is at its lowest position and remove the plug (it may be necessary to temporarily remove the drive motor to allow the drum to rotate). Allow lubricant to drain. Rotate drum until the drain hole is aligned with the inspection hole in the side of the chassis. Refill gear case with nineteen (19) ounces EP-90 gear lubricant. Reinstall drain plug. Reinstall drive motor if it was removed.



# SERVICE



## WARNING

**BEFORE SERVICING THIS UNIT, THE MANDATORY SAFETY SHUTDOWN PROCEDURE MUST BE COMPLETED. SEE "SAFETY" SECTION.**

### Drum Removal

1. With the attachment resting on a hard, flat surface, loosen the two set screws which fix the inner bearing race to the dead shaft.
2. Remove the dead shaft by removing the three bolts and nuts and pulling the dead shaft from the bearing and out of the planer head.
3. Remove the drive motor assembly by removing the two mounting bolts.
4. Remove the planetary mounting bolts.
5. Return to the skid steer operator's seat and check to see that all personnel are clear of the work area. Insert the key in the ignition and start the skid steer.
6. Sideshift the planer head slightly to the left (from the operator's viewpoint) to remove the planetary pilot from the planer head.
7. Raise the attachment with the host vehicle and the drum should remain on the floor.

8. Shut the engine off and remove the ignition key.



## WARNING

**IF DRUM DOES NOT REMAIN ON FLOOR, LOWER THE PLANER, SHUT THE ENGINE OFF, REMOVE THE IGNITION KEY AND REVIEW STEPS 1 THRU 4. DO NOT ATTEMPT TO DISLodge THE DRUM WHILE THE PLANER FRAME IS IN THE RAISED POSITION. NEVER PLACE HANDS OR ANY PART OF YOUR BODY IN, AROUND, OR UNDER THE DRUM AS IT MAY FALL CAUSING SERIOUS INJURY.**



## WARNING

**USE EXTREME CAUTION DURING THIS OPERATION TO PREVENT PLANETARY FROM TIPPING AND FALLING.**

### Planetary Removal

1. Remove the drum from the attachment as described on the previous page.
2. Fully support the planetary with hoist and remove the planetary flange mounting nuts.
3. Slide the planetary from the drum with a hoist or similar device rated for more than 250 lbs. capacity (550 kg.).

### Sideshift Cylinder Removal

1. Complete the Mandatory Safety Shutdown Procedure.
2. With the attachment on a level surface, remove all three one inch retaining rings from cylinder mounting pins.
3. Pull the cylinder evenly from both mounting pins. Remove the pin on the left-hand side and slide the rod end off the backplate.

## **IMPORTANT**

Remove any residual pressure in the cylinder by cycling the loader auxiliary control from side to side with the skid steer engine off.

### Sideshift Frame Removal

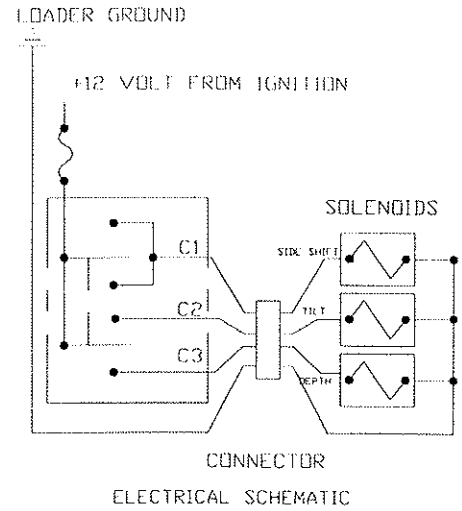
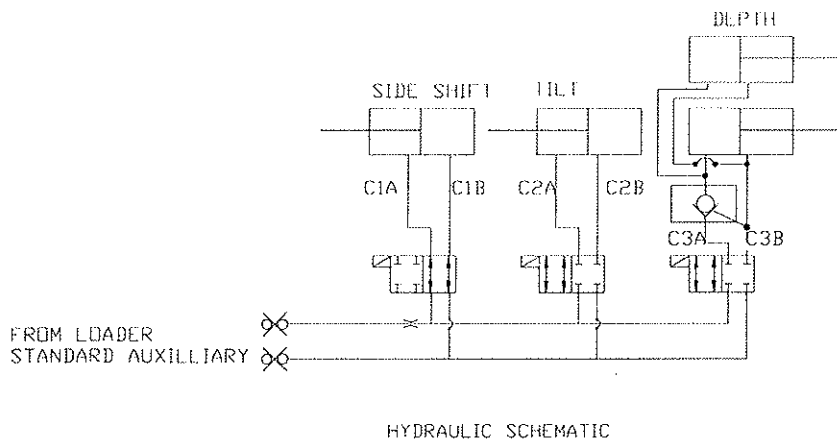
1. Disconnect the drive motor hoses.
2. Remove sideshift cylinder as described above.
3. Remove three backplate clamp nuts and bolts and main pivot retaining ring.
4. Attach the planer to the skid steer and slowly separate the sideshift frame from the chassis.

# SPECIFICATIONS

## CP40G/P

Planing Width	40"
Planing Depth	0-10"
Hyd. Horsepower Required	30-60 hp
Sideshift Capability	22 inches
Number of Carbide Picks	87
Tilt Capability	$\pm 10^{\circ}$
Hydraulic Flow Required	25-40 gpm
Hydraulic Pressure Required	2000-5000 psi
Operating Weight	2600 lb.
Planetary gearbox capacity	19 oz.
Planetary Lubricant	80W-90 GL5 Gear Lube

# HYDRAULIC/ELECTRICAL SCHEMATIC



# TROUBLESHOOTING CHART

Symptom	Problem Cause	Corrective Action
1. Planer loses power	Relief setting in aux. system lower than standard 2400 psi or Loader circuit pump or auxiliary pump failure	Remove/clean, or replace solenoid cartridge or replace O-rings. Check reliefs in the following sequence-loader valve, standard auxiliary valve. Reset or replace any relief below 2200psi. The flow should be no less than 25 gpm. If pump output is 20% less than rated pump specification, the pump may require repair. Consult loader service manual.
2. Tilt function is jumpy and erratic.	Tilt clamp bolts set too tight or rusted plate.	Loosen tilt clamp bolts to provide .015 clearance or grease between plates.
3. Planer drive motor leaks at shaft seal	Excess motor case drain pressure	The maximum case drain pressure allowed is 25 psi at full engine throttle. Replace shaft seal.
4. No functions work	No power to controller	Check fuse and power lead connections.
5. One function doesn't work	Check power to coil	If coil has power and pulls, cartridge is defective; replace cartridge. If coil doesn't pull, check for power to coil or replace coil.
6. Bearing failure of motor or output bearing.	Improper lubrication of bearing. Pick holder replacement-welder not grounded through drum.	Re-grease outboard bearing each 4-8 hours. During holder replacement, ground welder directly to drum (see Maintenance section).

# WARRANTY

## Purpose of Policy

This policy covers correction of defects in workmanship and/or materials that are called to the attention of the authorized dealer within a 365 day period from the date of sale and subject to all conditions of the **Alitec** warranty.

## Statement of Policy

**Alitec Corporation** warrants its products, when used correctly under normal operating conditions, will be free from defects in material and workmanship. **Alitec** makes no other warranty express or implied. This warranty shall be effective for a period of 365 days from the date of purchase, providing proof of purchase is supplied to **Alitec**. This warranty shall not apply to any products which have been altered, changed or repaired in any manner whatsoever, except by an authorized **Alitec** repair facility; nor any product which has been subject to misuse, neglect, or accident. The exclusive and sole remedy for breach of contract shall be limited to repair, modification, or replacement at the sole discretion of **Alitec**. **Alitec Corporation** shall not, in any event, be liable for the cost of any special, direct, or consequential damages to anyone.

**Alitec Corporation** reserves the right to make changes or improvements in design or construction of any part without incurring the obligation to install such changes on any unit previously delivered.

<p><b>Alitec Corporation</b> makes no warranty of any kind with regard to its printed material; including, but not limited to, implied warranties or fitness for a particular purpose. <b>Alitec Corporation</b> shall not be liable for errors contained herein or for incidental or consequential damages in connection with the performance or use of its printed material.</p>
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# WARRANTY POLICIES & PROCEDURES

## CLAIM ADMINISTRATION POLICIES & PROCEDURES

- Alitec Corporation must be contacted immediately for authorization to proceed when a warranty problem is suspected. Always have the serial number of the unit available to give to the Case/Alitec representative.
- Hydraulic components (pumps, motors, planetary gear boxes) are not to be disassembled when performing possible warranty work. Unauthorized disassembly of these components will void warranty.
- A Returned Goods Authorization number (RGA) must be obtained and the defective part returned immediately with the RGA number marked on the shipping box before any warranty consideration can be determined. Return these components prepaid via UPS ground to Alitec for examination.
- Warranty will not be allowed against failure due to the following:
  - Normal wear & tear
  - Abuse or accident
  - Excessive pressure & flow
  - Modification of original equipment
  - Improper service or maintenance
- Labor will be credited at 75% of the published dealer labor rate for authorized warranty work performed.
- Travel times or mileage to and from the job site are not covered under warranty.
- Overnight or other special freight charges will not be authorized in connection with warranty claims.
- All claims must be submitted within 30 days of service on a Alitec warranty claim form (Form 30) with the internal dealer work order attached.
- All repair parts orders will require a purchase order and will be billed at normal net prices. Credit will be issued when warranty is approved.
- All credit will be issued in credit memo form. No cash payments will be made.