

Service Manual

SERVICE PARTS & DIAGRAMS

BENDPAK

HDS18E

PRODUCT SKU
5175968

DRAWING Nº
5260604

CATEGORY
Four Post Lift

REV
Version J

DATE
08.29.2022



BendPak.

This guide is a troubleshooting reference used for maintaining and servicing your Bend Pak product. It provides comprehensive information on identifying serviceable parts and components and assists in troubleshooting problems and performing assembly /disassembly procedures.

BendPak, Inc. Corporate Office
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info@bendpak.com

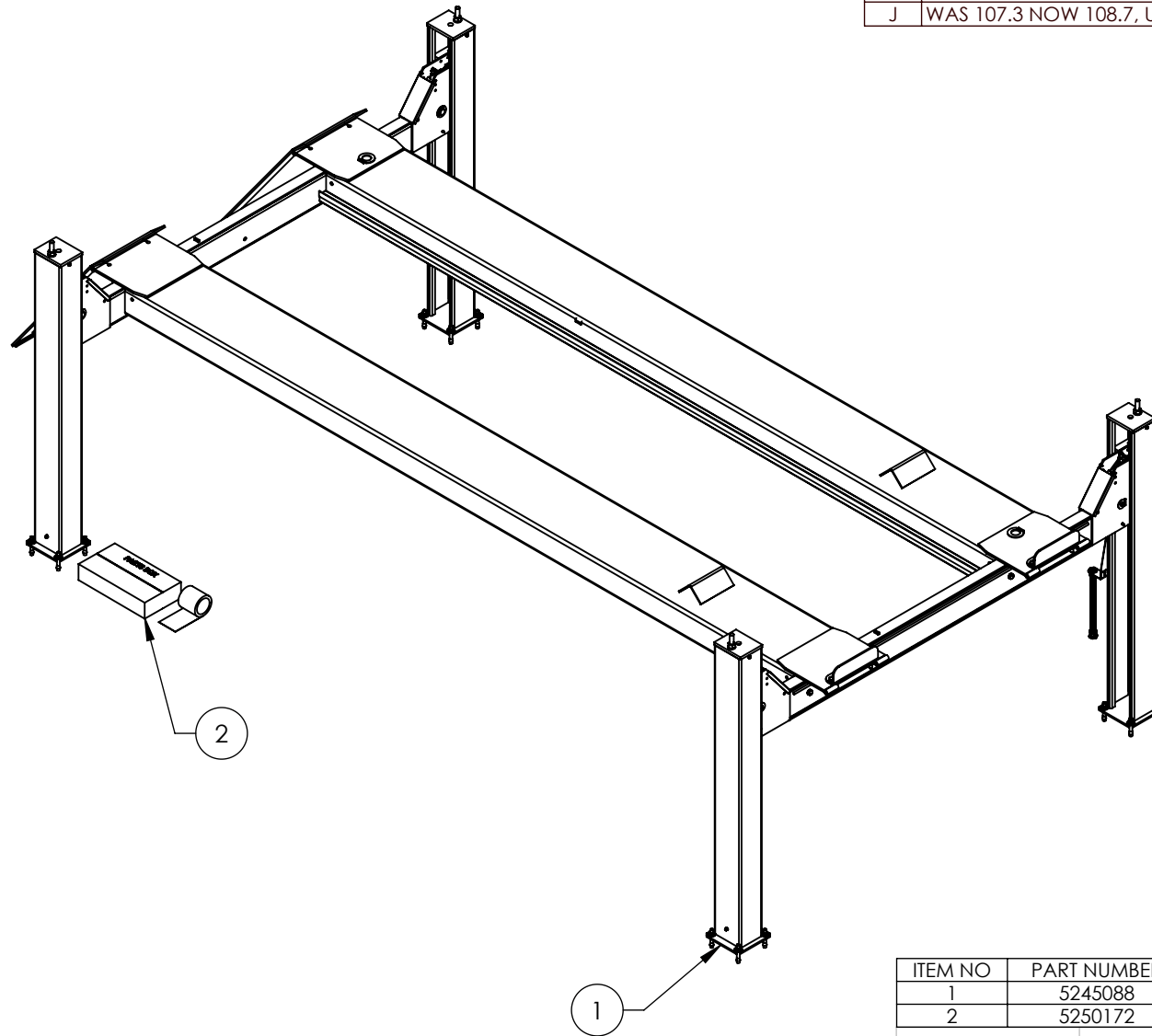
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Fax: 1-805-933-9160
bpkexports@bendpak.com

REVISION				
REV	DESCRIPTION	DATE	EDITED BY	ECO#
G	UPDATED BOM REVISION	01/11/2022	TM	01378
H	UPDATED BOM REVISIONS	05/25/2022	TM	01414
J	WAS 107.3 NOW 108.7, UPDATED BOM REVISION	08/08/2022	TM	01436

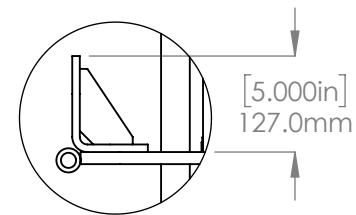
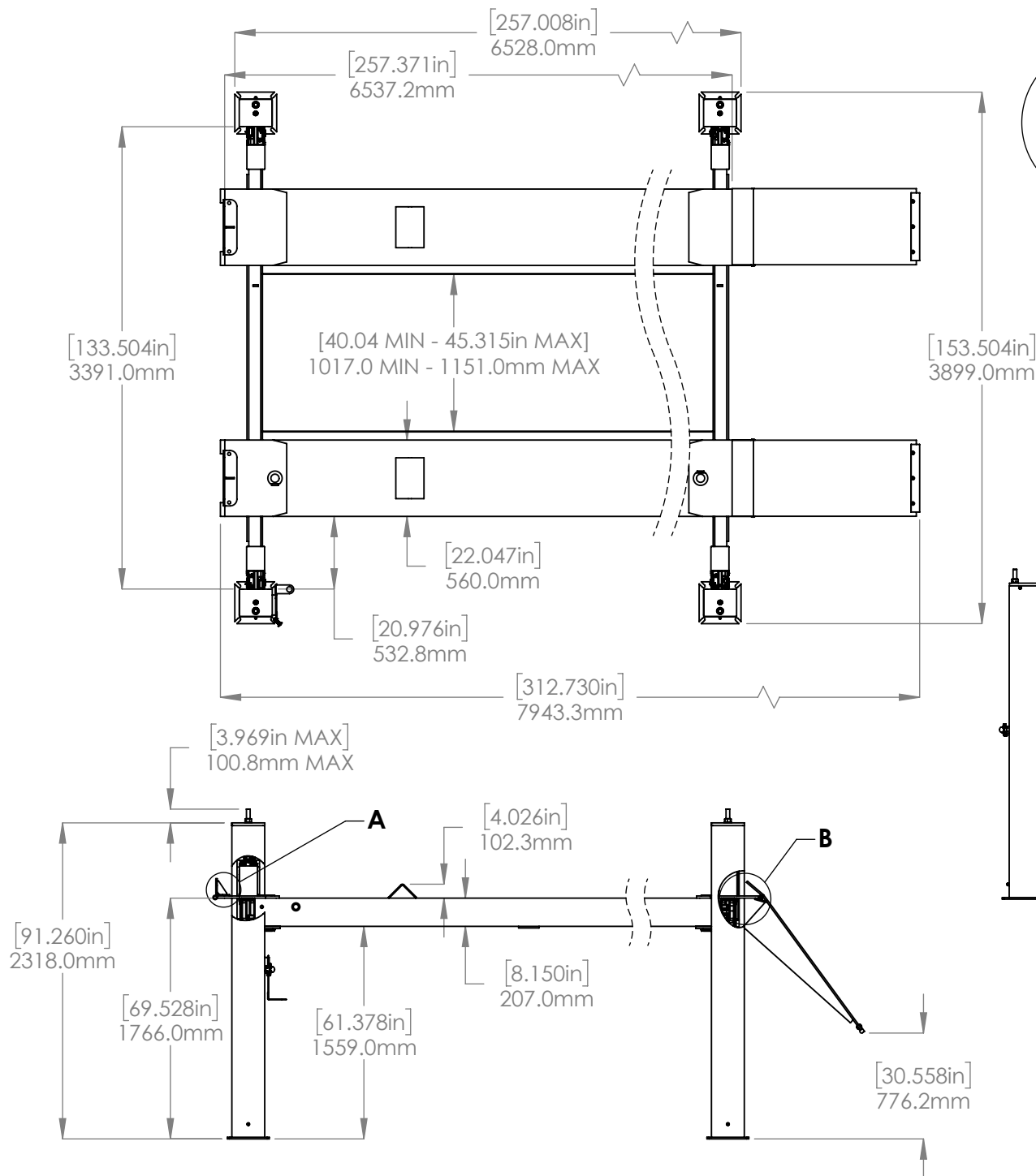


NOTE: UNLESS OTHERWISE SPECIFIED.

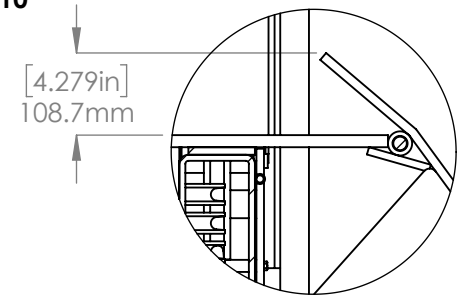
1. REFER TO MODEL FOR ADDITIONAL INFORMATION
2. SEE SHIPPING INSTRUCTIONS FOR FINAL PACKAGING
3. SEE COLORS & GRAPHICS FOR LABEL PLACEMENT

ITEM NO	PART NUMBER	DESCRIPTION	QTY	REV
1	5245088	HDS-18E LIFT SUPERSTRUCTURE	1	G
2	5250172	HDS-18E/27 PARTS BOX	1	M

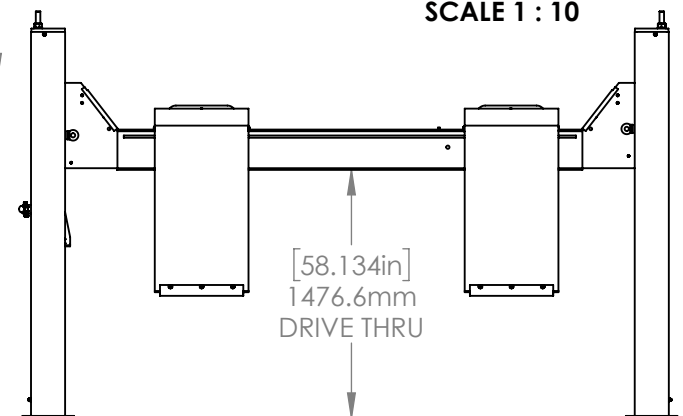
DO NOT SCALE DRAWING	NAME	DATE	 1645 LEMONWOOD DR. SANTA PAULA, CA 93060
	DRAWN	TM	
	CHECKED	OR	
DIMENSIONS ARE IN MM	THIRD ANGLE PROJECTION		TITLE: HDS-18E PRODUCTION LIFT VER D (CE CERT)
 PROPRIETARY AND CONFIDENTIAL THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF BENDPAK INC. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF BENDPAK INC. IS PROHIBITED.	SIZE	DWG. NO.	REV
	A	5260604	J
SCALE: 1:45			SHEET 1 OF 3



DETAIL A
SCALE 1 : 10



DETAIL B
SCALE 1 : 10



FRONT VIEW

BP BendPak.

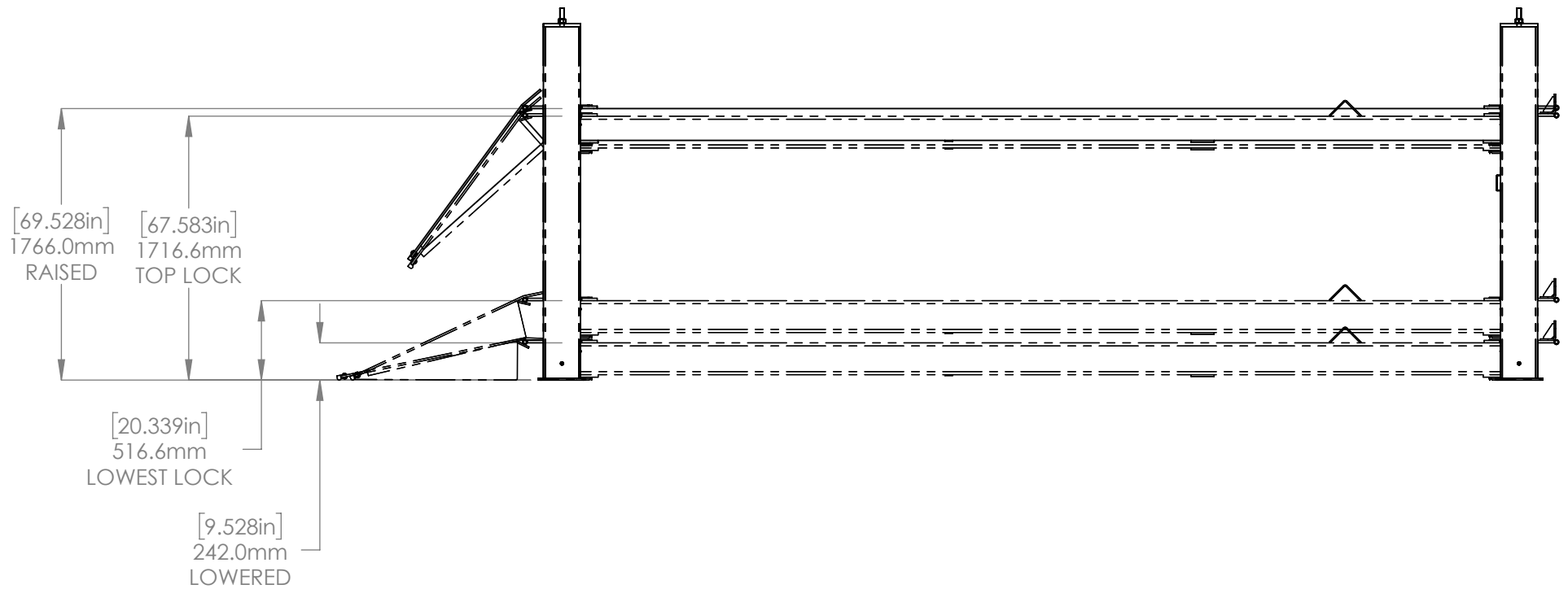
1645 LEMONWOOD DR.
SANTA PAULA, CA 93060

TITLE: HDS-18E PRODUCTION
LIFT VER D (CE CERT)

SIZE	DWG. NO.	REV
A	5260604	J

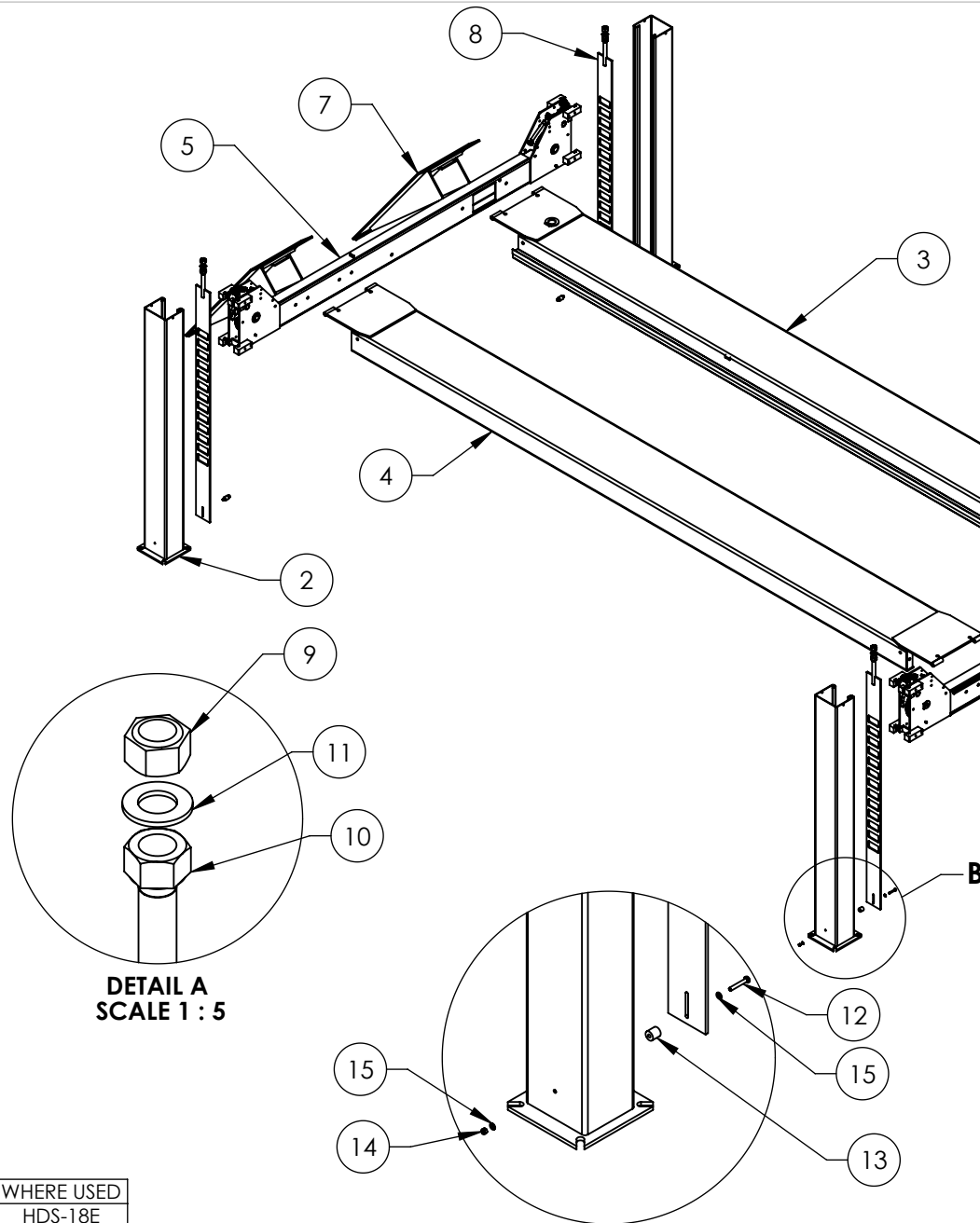
SCALE: 1:45

SHEET 2 OF 3



1. DIMENSIONS ARE WITH THE LOCK LADDER ADJUSTED ALL THE WAY UP

BP BendPak. 1645 LEMONWOOD DR. SANTA PAULA, CA 93060		
TITLE: HDS-18E PRODUCTION LIFT VER D (CE CERT)		
SIZE	DWG. NO.	REV
A	5260604	J
SCALE: 1:40		SHEET 3 OF 3



REVISION				
REV	DESCRIPTION	DATE	EDITED BY	ECO#
E	UPDATED BOM REVISION	01/11/2022	TM	01378
F	REPLACED 5215891 WITH 5216168, 5215890 WITH 5216167	05/23/2022	TM	01414
G	UPDATED BOM REVISION	08/08/2022	TM	01436

ITEM NO	PART NUMBER	DESCRIPTION	QTY	REV
1	5601143	HDS-18/27/40 POWER POST WELDMENT	1	B
2	5601141	HDS-18/27/40 POST WELDMENT	3	B
3	5215164	HDS-18E/27 POWER SIDE RAMP ASSEMBLY	1	AA
4	5601441	HDS-18E/27 OFF SIDE RAMP WELDMENT	1	B
5	5216168	HDS-18/27 CROSSTUBE ASSEMBLY, LARGE WINDOW	1	A
6	5216167	HDS-18/27 CROSSTUBE ASSEMBLY, SMALL WINDOW	1	A
7	5215161	HDS-18/27 EXTENDED DRIVE UP RAMP ASSEMBLY	2	K
8	5600875	HDS-18/27 SAFETY LADDER WELDMENT	4	C
9	5535211	NUT M27 x 3.0 NL	4	--
10	5535210	NUT M27 x 3.0	4	--
11	5545103	WASHER M27 x 50mm	4	--
12	5530046	HHB M10 x 1.5 x 65mm	4	--
13	5746088	HDS-18/27 SPACER, SAFETY LADDER, 31mm LG	4	B
14	5535013	NUT M10 x 1.5 NL	4	--
15	5545341	WASHER M10 x Ø20 FLAT	8	--

WHERE USED
HDS-18E

NOTE: UNLESS OTHERWISE SPECIFIED, SCALE 1 : 20

- REFER TO MODEL FOR ADDITIONAL INFORMATION
- FASTEN NUTS AND WASHERS TO SAFETY LADDERS IN ORDER SHOWN FOR SHIPMENT
- SEE SHIPPING INSTRUCTIONS FOR FINAL PACKAGING

NEXT ASSEMBLY
5260604

DO NOT SCALE DRAWING

NAME	DATE
DRAWN TM	12/12/2019
CHECKED OR	08/16/2022

BendPak
1645 LEMONWOOD DR.
SANTA PAULA, CA 93060

DIMENSIONS ARE IN MM

THIRD ANGLE PROJECTION



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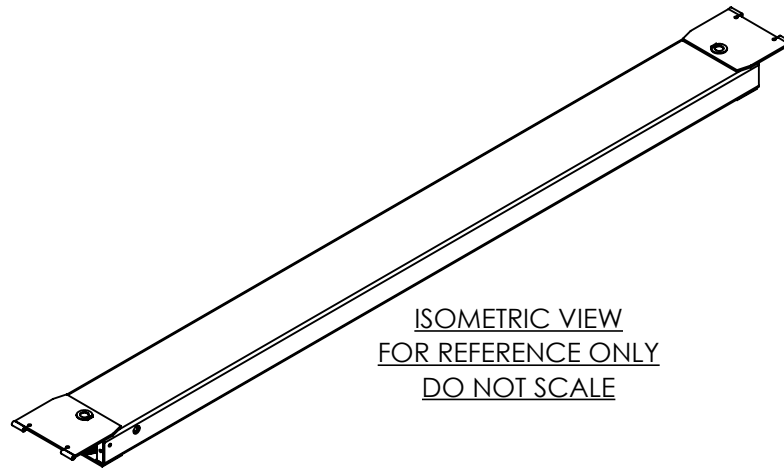
TITLE: HDS-18E LIFT
SUPERSTRUCTURE

SIZE DWG. NO.	REV
A 5245088	G

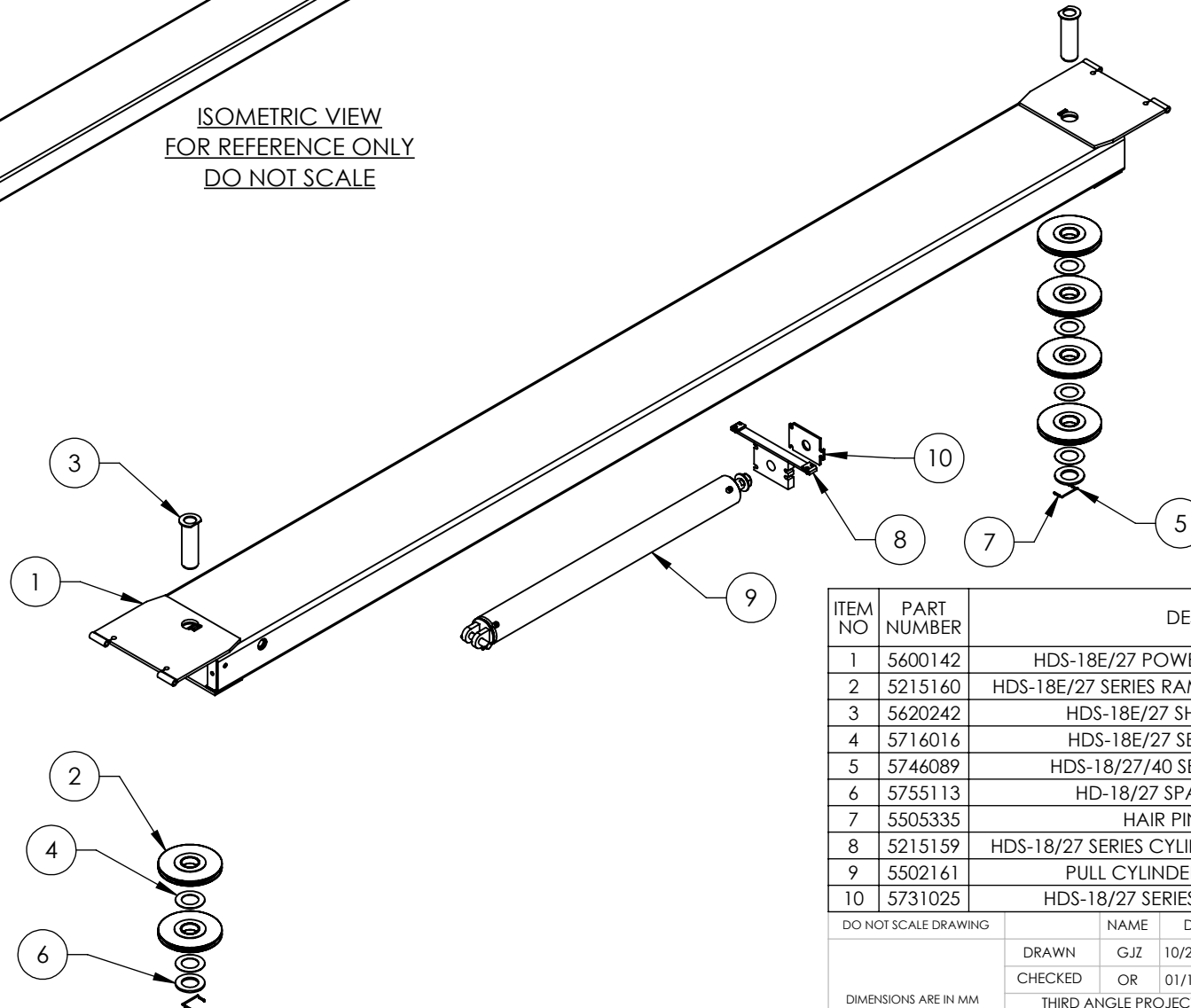
SCALE: 1:55

SHEET 1 OF 1

REVISION				
REV	DESCRIPTION	DATE	EDITED BY	ECO#
Y	UPDATED BOM REVISION	11/05/2020	CA	01227
Z	REPLACED (1) 5620197 WITH 5620242, UPDATED BOM REVISION	08/26/2021	CA	01322
AA	UPDATED BOM REVISION	01/10/2022	TM	01378



ISOMETRIC VIEW
FOR REFERENCE ONLY
DO NOT SCALE



ITEM NO	PART NUMBER	DESCRIPTION	QTY	REV
1	5600142	HDS-18E/27 POWER SIDE RAMP WELDMENT	1	K
2	5215160	HDS-18E/27 SERIES RAMP SHEAVE ROLLER ASSEMBLY	6	D
3	5620242	HDS-18E/27 SHEAVE PIN WELDMENT	2	C
4	5716016	HDS-18E/27 SERIES SHEAVE SPACER	6	C
5	5746089	HDS-18/27/40 SERIES SHEAVE SHAFT PIN	2	D
6	5755113	HD-18/27 SPACER, RAMP SHEAVE	2	B
7	5505335	HAIR PIN 3/32" x 1 5/8"	4	-
8	5215159	HDS-18/27 SERIES CYLINDER FLANGE ARM ASSEMBLY	1	H
9	5502161	PULL CYLINDER ASSEMBLY Ø5.0 x 60	1	N
10	5731025	HDS-18/27 SERIES CABLE RETAINER PLATE	1	B

WHERE USED
HDS-18E
HDS-27

NOTE: UNLESS OTHERWISE SPECIFIED.

- REFER TO MODEL FOR ADDITIONAL INFORMATION
- SEE SHIPPING INSTRUCTIONS FOR FINAL PACKAGING
- ASSEMBLE ITEMS AS SHOWN
- VERIFY CYLINDER PORTS ARE CAPPED OFF WITH 3/8" NPT STEEL PLUG

NEXT ASSEMBLY
5245088
5245090

DO NOT SCALE DRAWING

DIMENSIONS ARE IN MM



NAME	DATE
DRAWN GJZ	10/23/2008
CHECKED OR	01/11/2022

THIRD ANGLE PROJECTION



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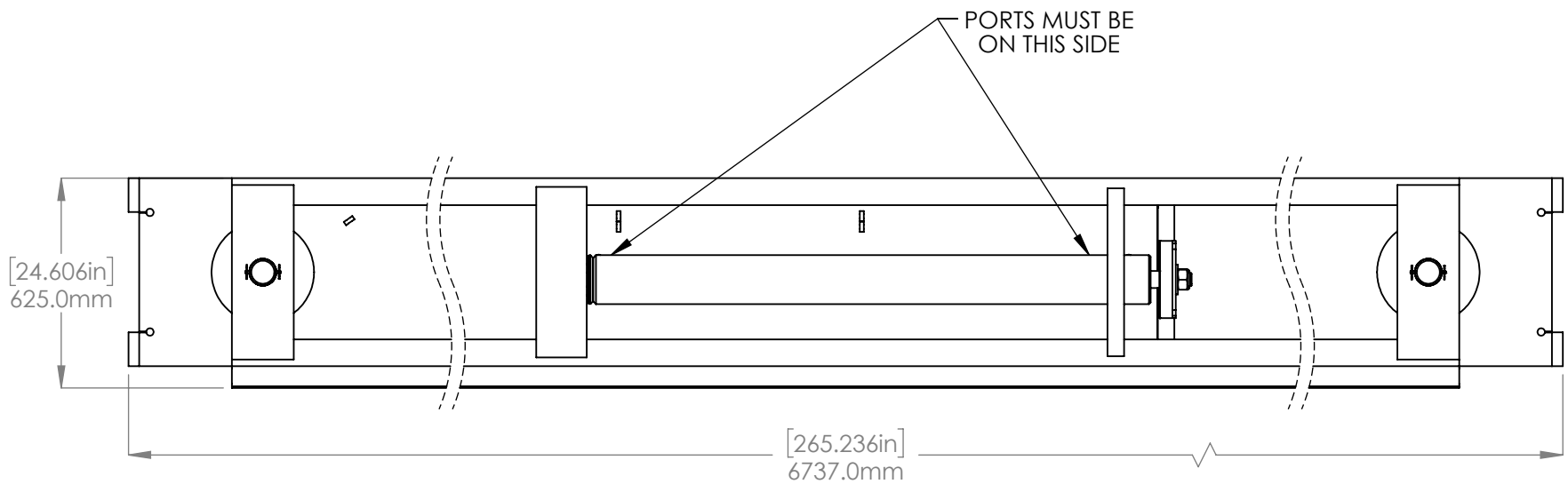
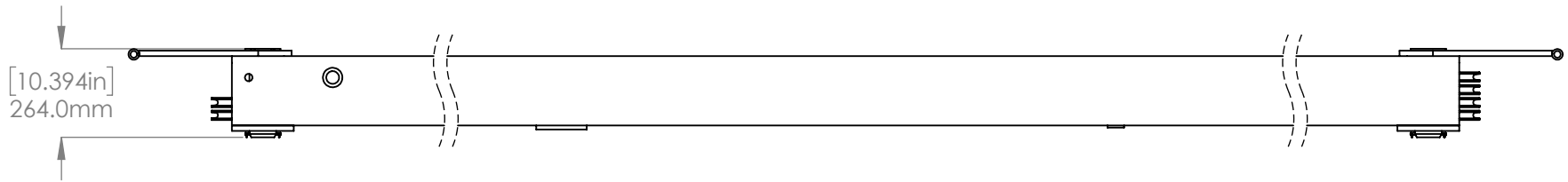
BendPak	
1645 LEMONWOOD DR. SANTA PAULA, CA 93060	

TITLE: HDS-18E/27 POWER SIDE
RAMP ASSEMBLY

SIZE	DWG. NO.	REV
A	5215164	AA

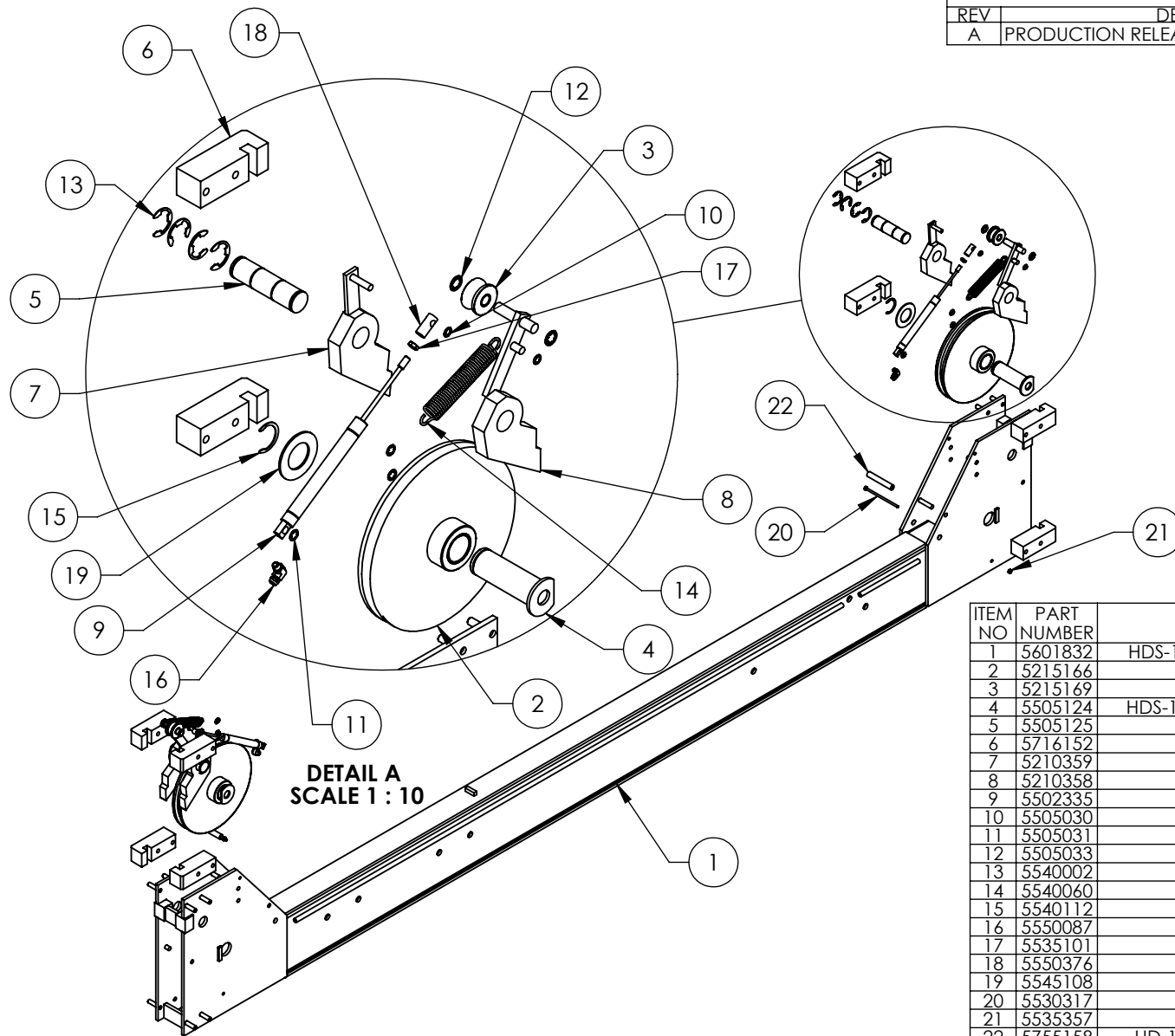
SCALE: 1:32

SHEET 1 OF 2



		
1645 LEMONWOOD DR. SANTA PAULA, CA 93060		
TITLE: HDS-18E/27 POWER SIDE RAMP ASSEMBLY		
SIZE	DWG. NO.	REV
A	5215164	AA
SCALE: 1:20		SHEET 2 OF 2

REVISION		DATE	EDITED BY	ECO#
REV	DESCRIPTION			
A	PRODUCTION RELEASE, DERIVED FROM 5215890	05/02/2022	TM	01414



ITEM NO	PART NUMBER	DESCRIPTION	QTY	REV
1	5601832	HDS-18/27 CROSSTUBE WELDMENT, SMALL WINDOW	1	A
2	5215166	HDS-18/27 CROSSTUBE SHEAVE ASSEMBLY	2	D
3	5215169	HDS-18/27 SAFETY ROLLER ASSEMBLY	2	D
4	5505124	HDS-18/27/40 CROSSTUBE SHEAVE SHAFT WELDMENT	2	G
5	5505125	HDS-18/27/40 SAFETY PIN	2	E
6	5716152	HDS-18/27 POLYETHYLENE SLIDE BLOCK	8	G
7	5210359	HDS-18/27/40 SAFETY WELDMENT #1	2	D
8	5210358	HDS-18/27/40 SAFETY WELDMENT #2	2	E
9	5502335	AIR CYLINDER, Ø.75 x 4.0" STROKE	2	-
10	5505030	PUSH-ON CLIP Ø10mm SS	4	-
11	5505031	ROTOR CLIP Ø12mm SS	6	-
12	5505033	PUSH-ON CLIP Ø16mm SS	4	-
13	5540002	E RING Ø1.375" OD TRUARC X5133-137	8	-
14	5540060	SPRING Ø29 x 178mm, SLACK SAFETY	2	A
15	5540112	SNAP RING; TRUARC 5103-175	2	-
16	5550087	FTG ELB -04 COMP x -02 NPT	2	-
17	5535101	3/8-16 HEX NUT JAM	2	-
18	5550376	HDS-18/27/40 ADAPTER, 1" AIR CYLINDER	2	D
19	5545108	WASHER M45 x 80 FLAT	2	-
20	5530317	HHB M6 x 1 x 136	2	-
21	5535357	NUT M6 x 1.0 NL	2	-
22	5755158	HD-18/27/40 CROSSTUBE SPACER Ø16 x Ø10 x 102	2	B

WHERE USED
HDS-18 SERIES
HDS-27 SERIES

NOTE: UNLESS OTHERWISE SPECIFIED.

1. REFER TO MODEL FOR ADDITIONAL INFORMATION
2. SEE SHIPPING INSTRUCTIONS FOR FINAL PACKAGING
3. ASSEMBLE ITEMS AS SHOWN

NEXT ASSEMBLY
5245086
5245087
5245088
5245089
5245090

DO NOT SCALE DRAWING

DIMENSIONS ARE IN MM



NAME	DATE
DRAWN	TM 05/02/2022
CHECKED	

THIRD ANGLE PROJECTION



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1645 LEMONWOOD DR. SANTA PAULA, CA 93060

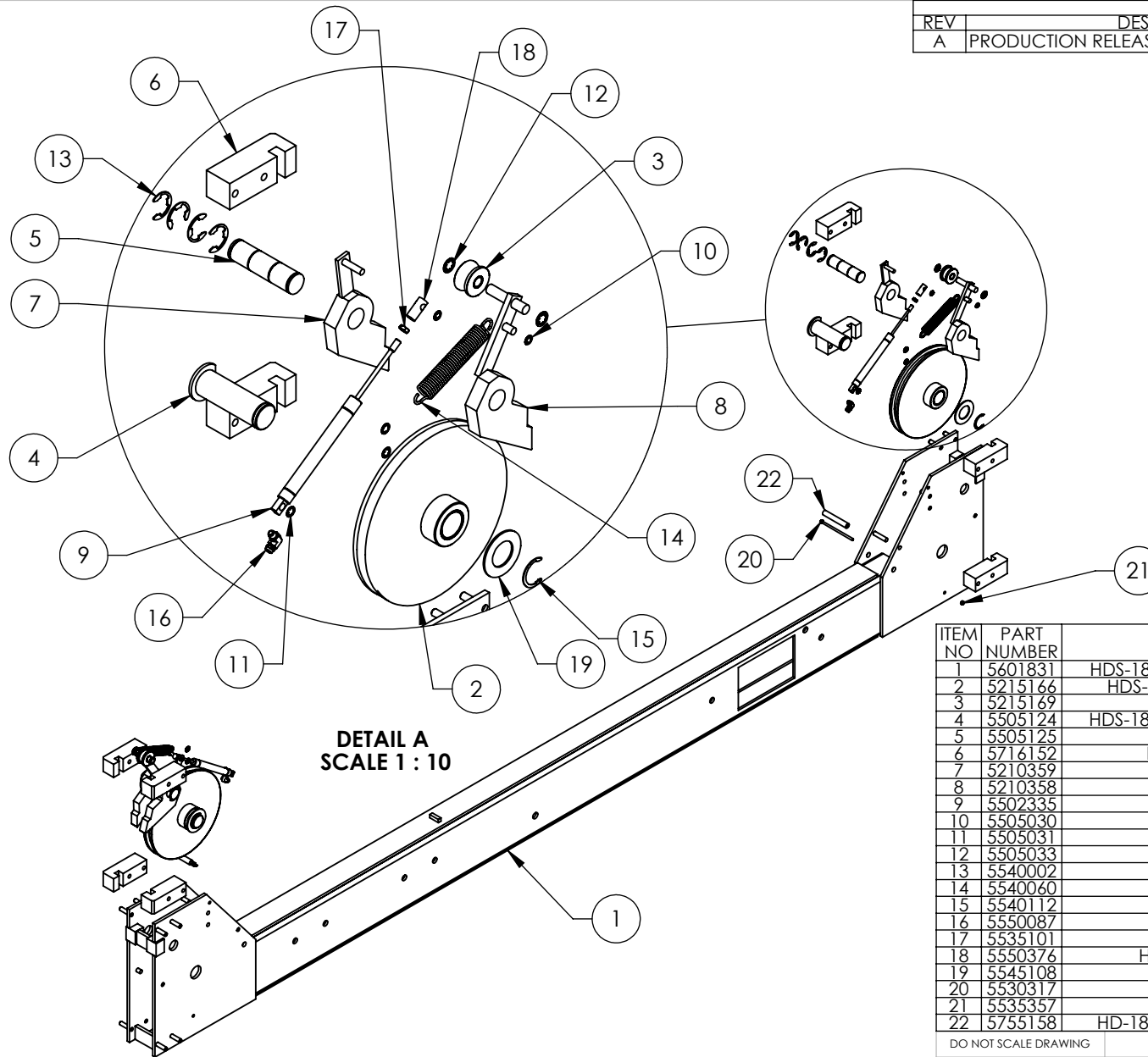
TITLE: HDS-18/27 CROSSTUBE ASSEMBLY, SMALL WINDOW

SIZE	DWG. NO.	REV
A	5216167	A

SCALE: 1:20

SHEET 1 OF 1

REV	DESCRIPTION	REVISION	DATE	EDITED BY	ECO#
A	PRODUCTION RELEASE, DERIVED FROM 5215891		05/02/2022	TM	01414



DETAIL A
SCALE 1 : 10

ITEM NO	PART NUMBER	DESCRIPTION	QTY	REV
1	5601831	HDS-18/27 CROSSTUBE WELDMENT, LARGE WINDOW	1	A
2	5215166	HDS-18/27 SERIES CROSSTUBE SHEAVE ASSEMBLY	2	D
3	5215169	HDS-18/27 SAFETY ROLLER ASSEMBLY	2	D
4	5505124	HDS-18/27/40 CROSSTUBE SHEAVE SHAFT WELDMENT	2	G
5	5505125	HDS-18/27/40 SAFETY PIN	2	E
6	5716152	HDS-18/27 POLYETHYLENE SLIDE BLOCK	8	G
7	5210359	HDS-18/27/40 SAFETY WELDMENT #1	2	D
8	5210358	HDS-18/27/40 SAFETY WELDMENT #2	2	E
9	5502335	AIR CYLINDER, Ø.75 x 4.0" STROKE	2	-
10	5505030	PUSH-ON CLIP Ø10mm SS	4	-
11	5505031	ROTOR CLIP Ø12mm SS	6	-
12	5505033	PUSH-ON CLIP Ø16mm SS	4	-
13	5540002	E RING Ø1.375" OD TRUARC X5133-137	8	-
14	5540060	SPRING Ø29 x 178mm, SLACK SAFETY	2	A
15	5540112	SNAP RING; TRUARC 5103-175	2	-
16	5550087	FTG ELB -04 COMP x -02 NPT	2	-
17	5535101	3/8-16 HEX NUT JAM	2	-
18	5550376	HDS-18/27/40 ADAPTER, 1" AIR CYLINDER	2	D
19	5545108	WASHER M45 x 80 FLAT	2	-
20	5530317	HHB M6 x 1 x 136	2	-
21	5535357	NUT M6 x 1.0 NL	2	-
22	5755158	HD-18/27/40 CROSSTUBE SPACER Ø16 x Ø10 x 102	2	B

WHERE USED
HDS-18 SERIES
HDS-27 SERIES

NOTE: UNLESS OTHERWISE SPECIFIED.

1. REFER TO MODEL FOR ADDITIONAL INFORMATION
2. SEE SHIPPING INSTRUCTIONS FOR FINAL PACKAGING
3. ASSEMBLE ITEMS AS SHOWN

NEXT ASSEMBLY
5245086
5245087
5245088
5245089
5245090

DO NOT SCALE DRAWING

DIMENSIONS ARE IN MM



NAME DATE

DRAWN TM 05/02/2022

CHECKED

THIRD ANGLE PROJECTION



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1645 LEMONWOOD DR.
SANTA PAULA, CA 93060

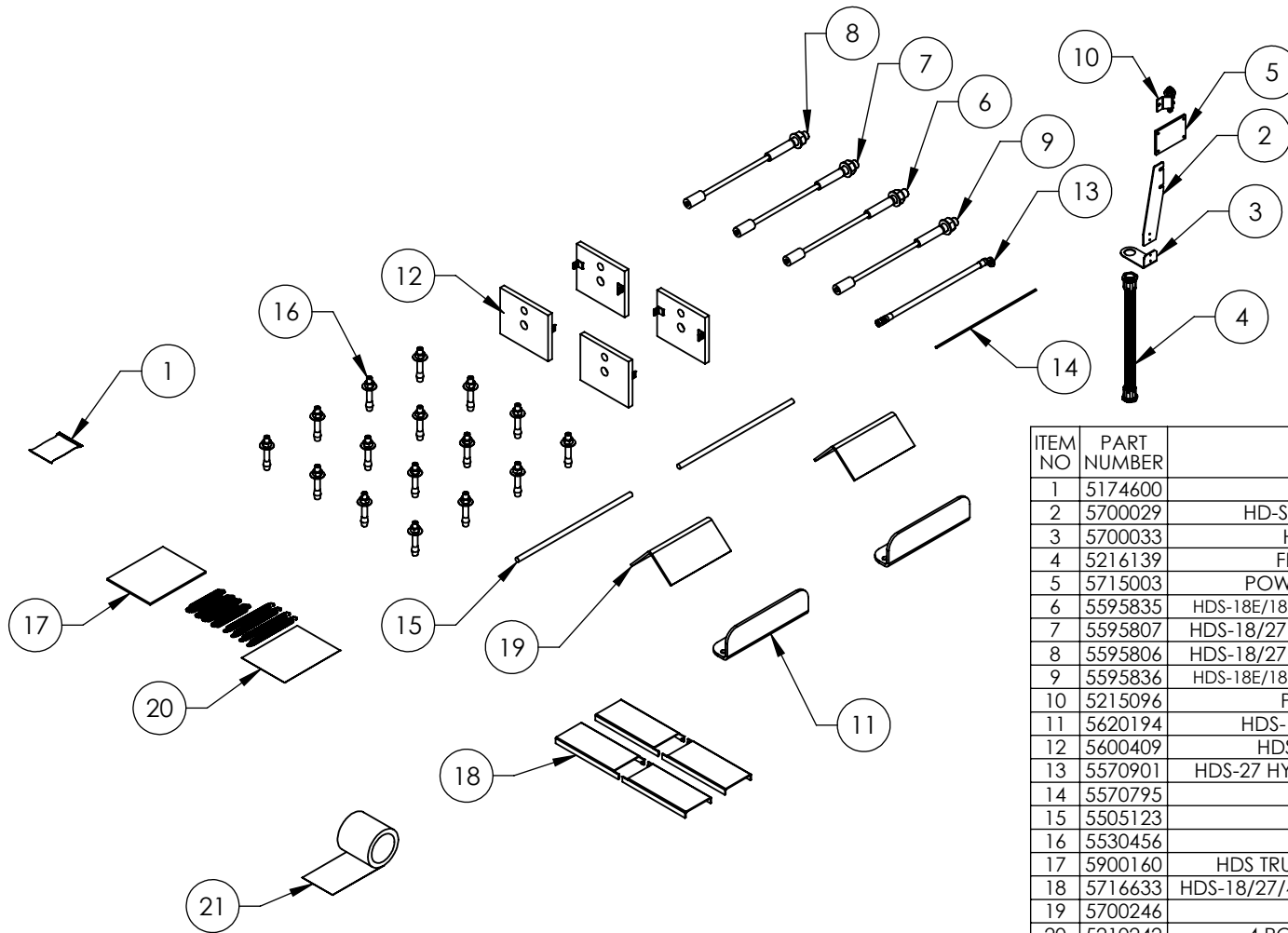
TITLE: HDS-18/27 CROSSTUBE ASSEMBLY, LARGE WINDOW

SIZE DWG. NO. REV
A 5216168 A

SCALE: 1:20

SHEET 1 OF 1

REVISION				
REV	DESCRIPTION	DATE	EDITED BY	ECO#
K	ADDED 5210242, REMOVED 5535104 AND 5545415, UPDATED BOM REVISIONS	07/21/2020	TM	01174
L	UPDATED BOM REVISION	08/25/2021	CA	01322
M	ADDED 5930195, REPLACED 5570050 WITH 5216139	05/04/2022	TM	01414 PRE A



ITEM NO	PART NUMBER	DESCRIPTION	QTY.	REV
1	5174600	HDS-18E/27/40 PARTS BAG	1	H
2	5700029	HD-SERIES FLEX TUBE BRACKET PLATE	1	F
3	5700033	HD-SERIES FLEX TUBE ANGLE	1	E
4	5216139	FLEX TUBE KIT, UP TO 2000mm	1	A
5	5715003	POWER UNIT VIBRATION DAMPENER	1	B
6	5595835	HDS-18E/18EA/27 CABLE ASSEMBLY Ø16 x 4127mm ST	1	E
7	5595807	HDS-18/27 CABLE ASSEMBLY Ø16 x 12215mm ST	1	J
8	5595806	HDS-18/27 CABLE ASSEMBLY Ø16 x 10483mm ST	1	H
9	5595836	HDS-18E/18EA/27 CABLE ASSEMBLY Ø16 x 5855mm ST	1	E
10	5215096	PUSH BUTTON AIR ASSEMBLY	1	G
11	5620194	HDS-18E/27/40 TIRE STOP WELDMENT	2	C
12	5600409	HDS-18/27 TOP PLATE WELDMENT	4	D
13	5570901	HDS-27 HYDRAULIC HOSE ASSY Ø10 x 5385mm	1	C
14	5570795	1/4" POLY-FLO TUBING	24000mm*	-
15	5505123	HDS-27 SERIES HINGE PIN	2	B
16	5530456	AB 3/4" x 4 - 3/4"	16	-
17	5900160	HDS TRUCK SERIES INSTALLATION MANUAL	1	-
18	5716633	HDS-18/27/40 SERIES CROSSTUBE COVER, PLASTIC	4	C
19	5700246	WHEEL CHOCK	2	B
20	5210242	4 POST HEAVY DUTY CE PARTS BAG	1	A
21	5930195	ANTI-SLIP TAPE, 6" x 24ft	1	--

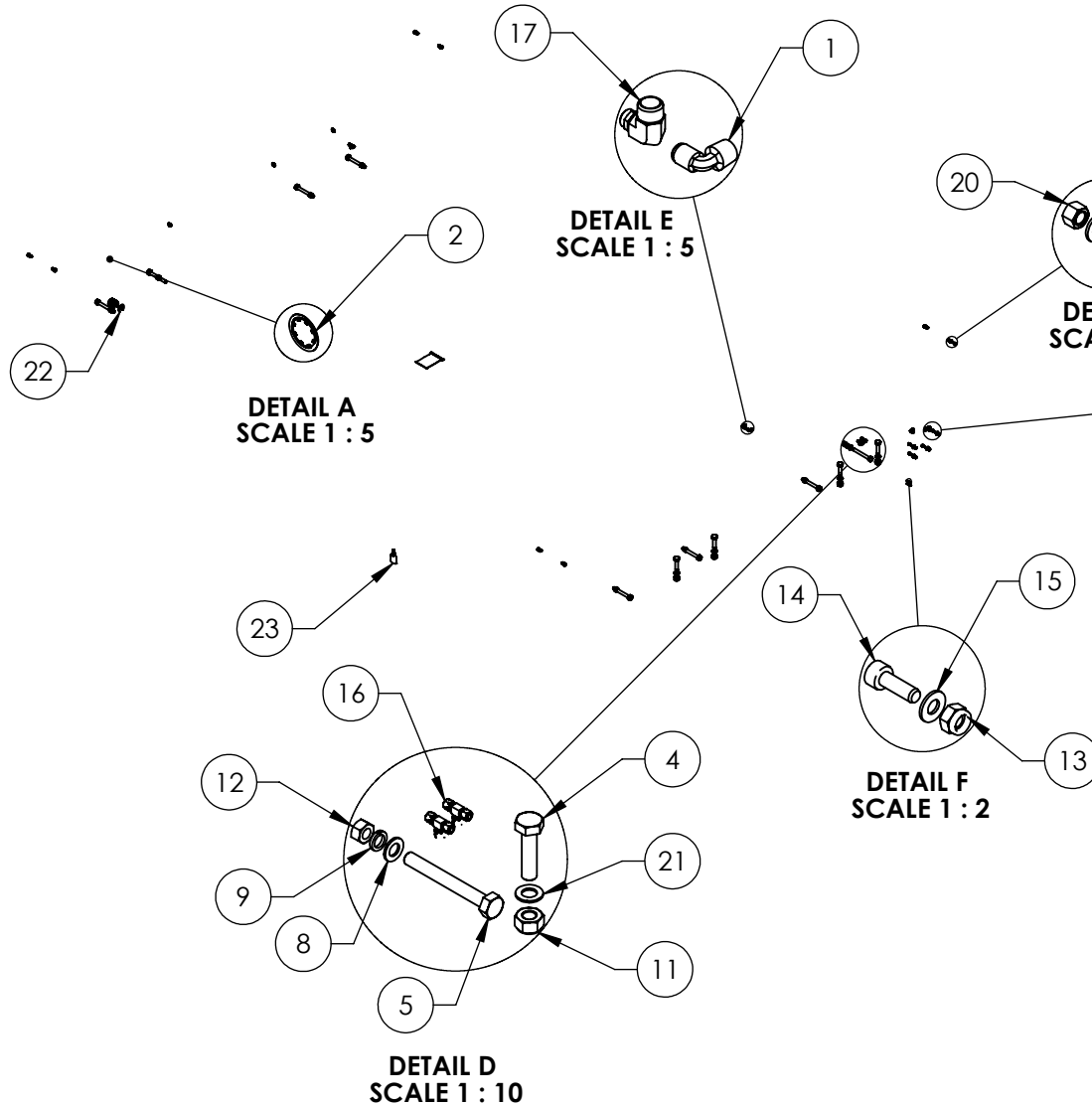
WHERE USED
HDS-18E
HDS-27

NOTE: UNLESS OTHERWISE SPECIFIED.

- REFER TO MODEL FOR ADDITIONAL INFORMATION
- SEE SHIPPING INSTRUCTIONS FOR FINAL PACKAGING
- HOSES AND CABLES IN REPRESENTATIONAL FORM
- (*) LENGTH FOR REFERENCE ONLY

NEXT ASSEMBLY
5260604
5260606

DO NOT SCALE DRAWING		NAME	DATE	 1645 LEMONWOOD DR. SANTA PAULA, CA 93060	
		DRAWN	TM	05/08/2013	
		CHECKED			
DIMENSIONS ARE IN MM		THIRD ANGLE PROJECTION		TITLE:	
				HDS-18E/27 PARTS BOX	
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				A	5250172
					REV
					M
				SCALE: 1:25	
				SHEET 1 OF 1	



REVISION				
REV	DESCRIPTION	DATE	EDITED BY	ECO#
F	UPDATED TITLE TO REFLECT WHERE USED, UPDATED NEXT ASSEMBLY	05/15/2018	TS	00945
G	ADDED (4) 5530200, (4) 5545342, (4) 5545350, (4) 5535106, 5550026 AND 5580012	12/13/2019	TM	01120
H	REMOVED 5550026	08/25/2021	CA	01322

ITEM NO	PART NUMBER	DESCRIPTION	QTY	REV
1	5550550	FTG ELB -06 JIC -06 NPT	1	--
2	5505032	ROTOR CLIP 18mm SS	4	--
3	5535001	NUT M8 x 1.25 NL	4	--
4	5530743	HHB M20 x 2.5 x 80	4	--
5	5530200	HHB M18 x 2.5 x 150mm	8	--
6	5530010	HHB M8 x 1.25 x 25	4	--
7	5550183	FTG ELB -06 JIC -06L ORB	1	--
8	5545342	WASHER M18 FLAT	8	--
9	5545350	WASHER M18 x 28 SL	8	--
10	5545340	WASHER M8 x24 FLAT	4	--
11	5535017	NUT M20 x 2.5 NL	4	--
12	5535106	HEX NUT M18 x 2.5	8	--
13	5535010	NUT M4 X 0.7 NL	2	--
14	5530008	SHCS M4 x 0.7 x 12 BOC	2	--
15	5545009	WASHER, Ø4.3 x Ø9mm x 0.8mm	2	--
16	5550395	FTG TEE -04 COMP x -04 COMP x -04 COMP	3	--
17	5550089	FTG ELB -04 COMP x -06 NPT	2	--
18	5545341	WASHER M10 x Ø20 FLAT	8	--
19	5530738	HHB M10 x 1.5 x 25	8	--
20	5535013	NUT M10 x 1.5 NL	8	--
21	5545343	WASHER, M20 FLAT	4	--
22	5545535	C WASHER SHIM FOR LIFTS	20	--
23	5580012	LIQUID PTFE THREAD SEALANT 50ml	1	--

WHERE USED
HDS-18E
HDS-27 SERIES
HDS-40 SERIES

NOTE: UNLESS OTHERWISE SPECIFIED.

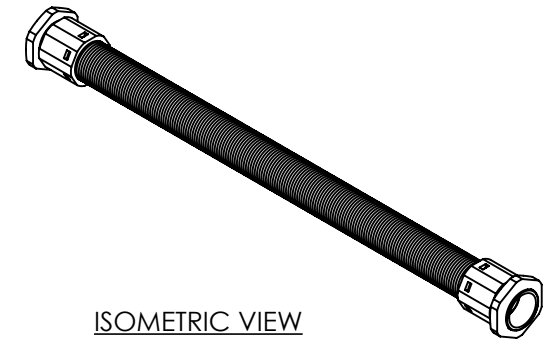
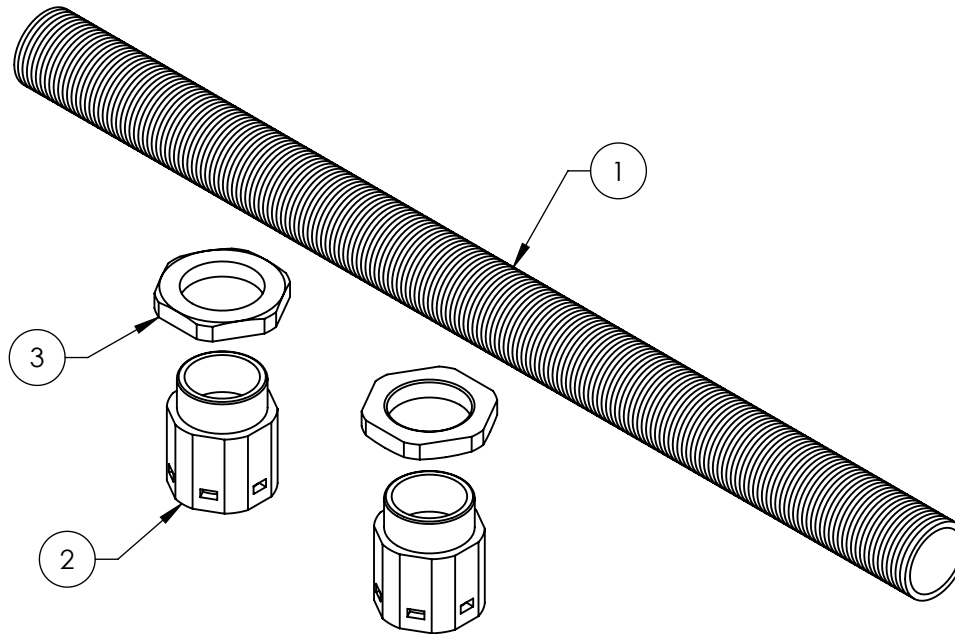
1. SEE SHIPPING INSTRUCTIONS FOR FINAL PACKAGING

NEXT ASSEMBLY
5250079
5250082
5250172
5250175
5250364

DO NOT SCALE DRAWING		NAME	DATE	 1645 LEMONWOOD DR. SANTA PAULA, CA 93060	
DRAWN		AC	05/06/2009		
CHECKED		OR	09/15/2021		
DIMENSIONS ARE IN MM		THIRD ANGLE PROJECTION		TITLE:	
				HDS-18E/27/40 PARTS BAG	
				SIZE DWG. NO.	REV
		A		5174600 H	
				SCALE: 1:50	SHEET 1 OF 1

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REPRODUCTION IN PART OR AS A WHOLE WITHOUT
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PROHIBITED.

REVISION				
REV	DESCRIPTION	DATE	EDITED BY	ECO#
A	PRODUCTION RELEASE, DERIVED FROM 5570050, 5570052, 5570239	05/05/2022	TM	01414 PRE A



ISOMETRIC VIEW
FOR REFERENCE ONLY
DO NOT SCALE

WHERE USED
D4-12 SERIES
HD-14T
HD-7500 SERIES
HD-7W
HD-7P
HD-9 SERIES
HD-973 SERIES
HDS-14 SERIES
HDSO-14 SERIES
HDS-18/27/40 SERIES

NOTE: UNLESS OTHERWISE SPECIFIED.

- SEE SHIPPING INSTRUCTIONS FOR FINAL PACKAGING
- SHOWN IN REPRESENTATIONAL FORM ONLY
(*)LENGTH FOR REFERENCE ONLY

NEXT ASSEMBLY		
5250058	5250175	5250289
5250059	5250184	5250290
5250079	5250185	5250294
5250081	5250187	5250295
5250082	5250188	5250336
5250143	5250189	5250337
5250144	5250191	5250338
5250164	5250193	5250349
5250167	5250194	5250364
5250168	5250195	
5250169	5250278	
5250172	5250286	

ITEM NO	PART NUMBER	DESCRIPTION	QTY	REV
1	5570053	PE FLEX TUBE Ø34.5xØ29	2100mm*	-
2	5555555	WQG1-M36/AD34.5 CONNECTOR	2	-
3	5535050	PLASTIC NUT M36 x 2	2	-

DO NOT SCALE DRAWING

DIMENSIONS ARE IN MM



NAME	DATE
DRAWN TM	05/05/2022
CHECKED OR	05/10/2022

THIRD ANGLE PROJECTION



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BP BendPak.
1645 LEMONWOOD DR. SANTA PAULA, CA 93060

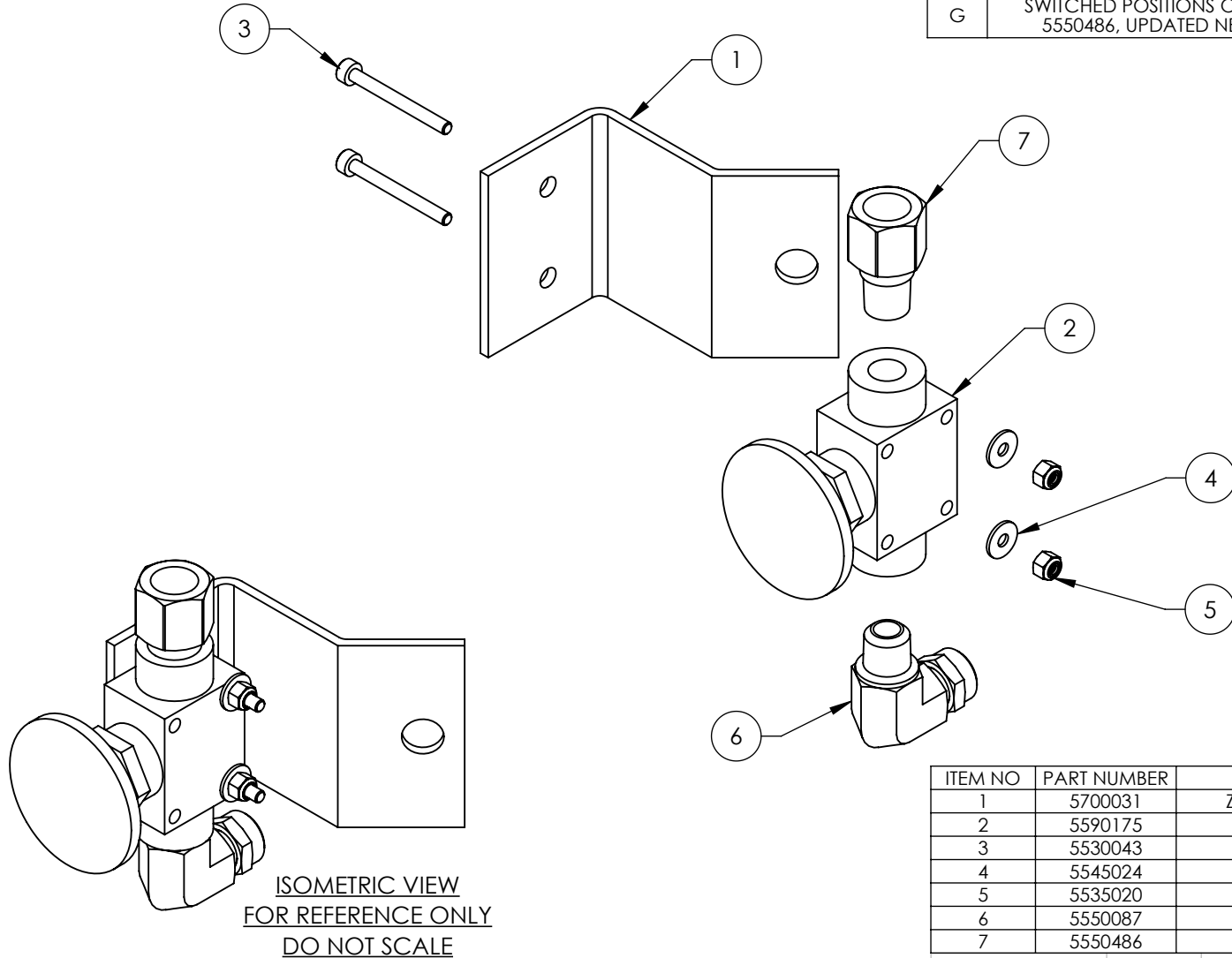
TITLE: FLEX TUBE KIT,
UP TO 2000mm

SIZE	DWG. NO.	REV
A	5216139	A

SCALE: 1:3

SHEET 1 OF 1

REVISION				
REV	DESCRIPTION	DATE	EDITED BY	ECO#
E	REPLACED 5550481 WITH 5550087	10/29/2013	TM	00593
F	REPLACED 5590240 WITH 5590175, UPDATED NEXT ASSEMBLIES	05/05/2015	MR	00683
G	SWITCHED POSITIONS OF 5550087 AND 5550486, UPDATED NEXT ASSEMBLY	06/16/2016	TS	00765

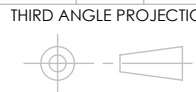


ITEM NO	PART NUMBER	DESCRIPTION	QTY	REV
1	5700031	ZERO ANGLE MOUNTING BRACKET	1	C
2	5590175	PUSH BUTTON AIR VALVE	1	-
3	5530043	SHCS M3 x 0.5 x 30	2	-
4	5545024	WASHER, M3 x 9mm FLAT	2	-
5	5535020	NUT M3 x 0.5, NL CL8	2	-
6	5550087	FTG ELB -04 COMP x -02 NPT	1	-
7	5550486	FTG NPL -02 NPT x -04 F NPT	1	-

DO NOT SCALE DRAWING

NAME DATE
DRAWN AC 03/14/2008
CHECKED CA 09/02/2015

DIMENSIONS ARE IN MM



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BendPak
1645 LEMONWOOD DR.
SANTA PAULA, CA 93060

TITLE: PUSH BUTTON AIR
ASSEMBLY

SIZE DWG. NO. REV
A 5215096 G

SCALE: 2:3

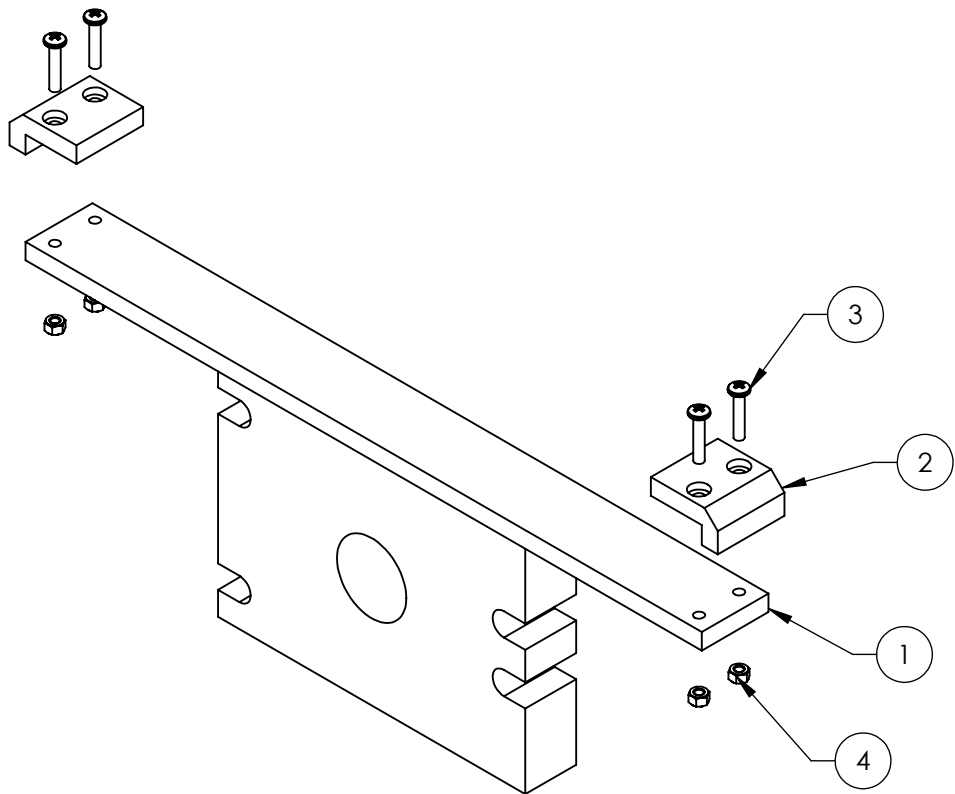
SHEET 1 OF 1

NOTE: UNLESS OTHERWISE SPECIFIED.

- SEE SHIPPING INSTRUCTIONS FOR FINAL PACKAGING
- ASSEMBLE ITEMS AS SHOWN

NEXT ASSEMBLY
D4-12 SERIES
HD SERIES
HDS SERIES
HDSO SERIES
PL-12000DP

REVISION				
REV	DESCRIPTION	DATE	EDITED BY	ECO#
F	UPDATED BOM REVISIONS	05/10/2017	TS	00829
G	UPDATED BOM REVISION AND NEXT ASSEMBLY	12/28/2017	TM	00909
H	UPDATED BOM REVISION	10/10/2018	CA	00945



ITEM NO	PART NUMBER	DESCRIPTION	QTY	REV
1	5620202	HDS-18/27 CYLINDER FLANGE ARM WELDMENT	1	E
2	5716153	HDS-18/27/40 SERIES ALIGNMENT BLOCK	2	E
3	5530095	BHPS M6 x 1 x 30mmL	4	-
4	5535357	NUT M6 x 1.0 NL	4	-

DO NOT SCALE DRAWING

NAME	DATE
DRAWN GJZ	10/21/2008
CHECKED CA	10/30/2018

BP BendPak.

1645 LEMONWOOD DR.
SANTA PAULA, CA 93060

DIMENSIONS ARE IN MM

THIRD ANGLE PROJECTION



TITLE:
**HDS-18/27 SERIES CYLINDER
FLANGE ARM ASSEMBLY**

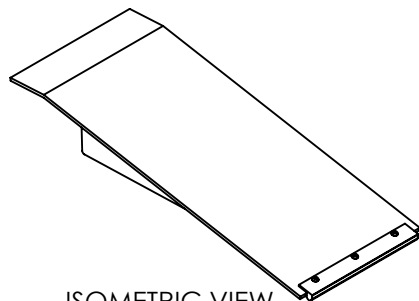
SIZE	DWG. NO.	REV
A	5215159	H

SCALE: 1:4

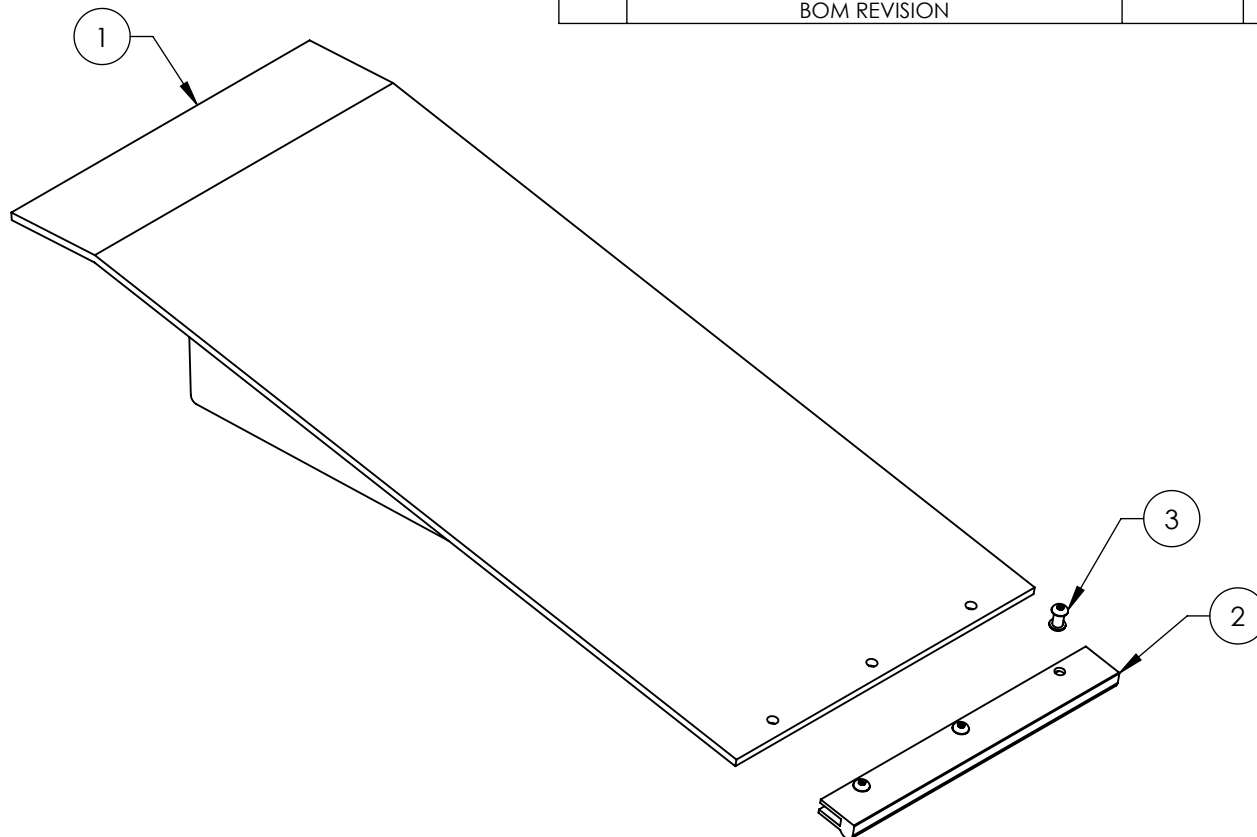
SHEET 1 OF 1

NEXT ASSEMBLY
5215157
5215164
5215657
5215689

NOTE: UNLESS OTHERWISE SPECIFIED.
1. SEE SHIPPING INSTRUCTIONS FOR FINAL PACKAGING
2. ASSEMBLE ITEMS AS SHOWN



ISOMETRIC VIEW
FOR REFERENCE ONLY
DO NOT SCALE



REVISION				
REV	DESCRIPTION	DATE	EDITED BY	ECO#
H	UPDATED BOM REVISIONS AND NEXT ASSEMBLY	06/14/2018	TS	00945
J	UPDATED BOM REVISION AND NEXT ASSEMBLIES	10/03/2019	TS	01120
K	REPLACED 5575663, WITH 5716088, REPLACED 5530012, AND 5530035 WITH 5530464, UPDATED BOM REVISION	08/09/2022	TM	01436

WHERE USED
HDS-18 SERIES
HDS-27 SERIES

NOTE: UNLESS OTHERWISE SPECIFIED.

1. REFER TO MODEL FOR ADDITIONAL INFORMATION
2. SEE COLORS & GRAPHICS FOR LABEL PLACEMENT
3. SEE SHIPPING INSTRUCTIONS FOR FINAL PACKAGING
4. ASSEMBLE ITEMS AS SHOWN

NEXT ASSEMBLY
5245086
5245087
5245088
5245089
5245090

ITEM NO	PART NUMBER	DESCRIPTION	QTY	REV
1	5600196	HDS-18/27 EXTENDED DRIVE UP RAMP WELDMENT	1	K
2	5716088	HDS-18/27 APPROACH RAMP EDGE GUARD	1	A
3	5530464	BBSS M10 x 1.5 x 24mm	3	--

DO NOT SCALE DRAWING

DIMENSIONS ARE IN MM



NAME	DATE
DRAWN AC	05/06/2009
CHECKED OR	08/16/2022

THIRD ANGLE PROJECTION



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BP BendPak
1645 LEMONWOOD DR.
SANTA PAULA, CA 93060

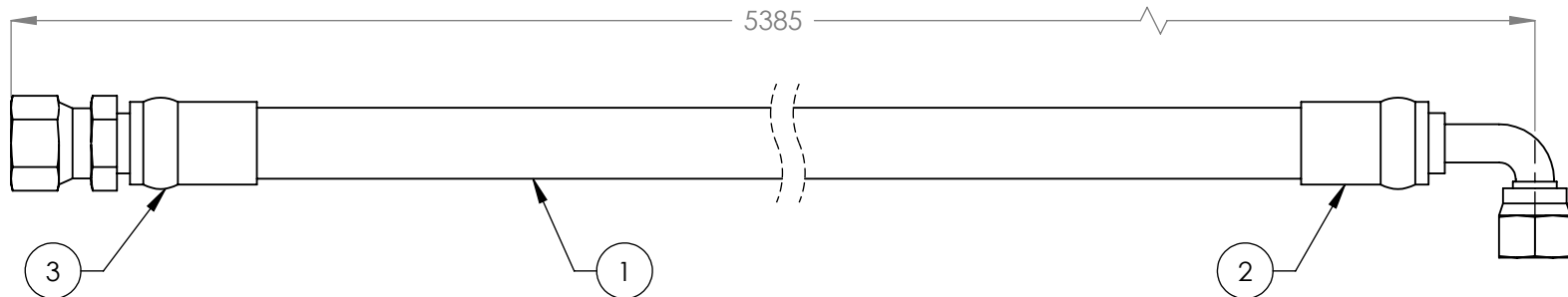
TITLE: HDS-18/27 EXTENDED
DRIVE UP RAMP ASSEMBLY

SIZE DWG. NO. REV
A 5215161 K

SCALE: 1:10

SHEET 1 OF 1

REVISION				
REV	DESCRIPTION	DATE	EDITED BY	ECO#
A	PRODUCTION RELEASE	08/27/2008	AC	00235
B	UNOBSOLETE DUE TO USE IN HDS-27/27A, CHANGED LENGTH WAS 3385 NOW 5385, UPDATED TITLE AND NEXT ASSEMBLY TO REFLECT WHERE USED	06/11/2010	TM	00371
B-001	UPDATED NEXT ASSEMBLIES	05/21/2013	TM	00593
C	UPDATED TITLE TO REFLECT WHERE USED	09/18/2015	TM	00724



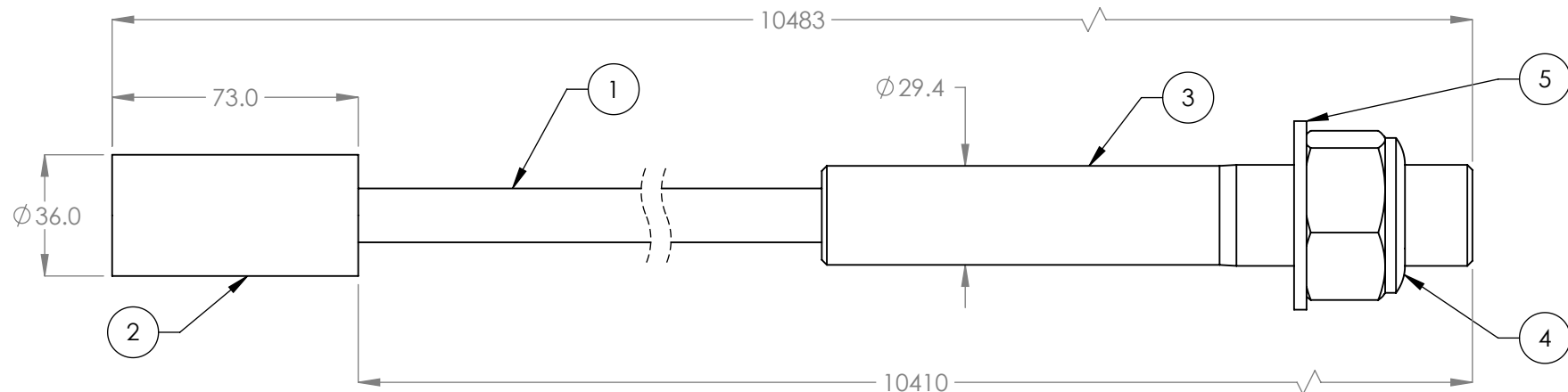
ITEM NO	PART NUMBER	DESCRIPTION	QTY.	REV
1	5570116	Ø10 ID HYDRAULIC HOSE	5325*mm	-
2	5550337	FTG ELB -06 CRIMP x -06 JIC	1	-
3	5550336	FTG NPL -06 CRIMP x -06 JIC	1	-

DO NOT SCALE DRAWING		NAME	DATE	 1645 LEMONWOOD DR. SANTA PAULA, CA 93060			
DIMENSIONS ARE IN MM TOLERANCES: 0. = ±1.5 0.0 = ±1.0 0.00 = ±0.25 0.000 = ±0.13 SURFACE FINISH 1.6 ISO Ra µm FOR MACHINED SURFACES UNLESS OTHERWISE SPECIFIED		DRAWN	AC			08/27/2008	
		CHECKED	CA			02/02/2016	
		THIRD ANGLE PROJECTION			TITLE: HDS-27 HYDRAULIC HOSE ASSY Ø10 x 5385mm		
							
		PROPRIETARY AND CONFIDENTIAL THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF BENDPAK INC. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF BENDPAK INC. IS PROHIBITED.					
NEXT ASSEMBLY 5250172 5250173					SIZE	DWG. NO.	REV
					A	5570901	C
					SCALE: 1:2		SHEET 1 OF 1

NOTE: UNLESS OTHERWISE SPECIFIED.

1. FOR ITEM 1 SPECIFICATIONS REFER TO PART SPECIFICATION FORM
2. (*)ITEM 1 QTY FOR REFERENCE ONLY

REVISION				
REV	DESCRIPTION	DATE	EDITED BY	ECO#
F	UPDATED TITLE TO REFLECT WHERE USED, UPDATED NEXT ASSEMBLY	09/18/2015	TM	00724
G	UPDATED BOM REVISION	12/28/2017	TM	00909
H	ADDED 5535104 AND 5545415, UPDATED TITLE AND NEXT ASSEMBLY	07/21/2020	TM	01174



WHERE USED
HDS-18 SERIES
HDS-27

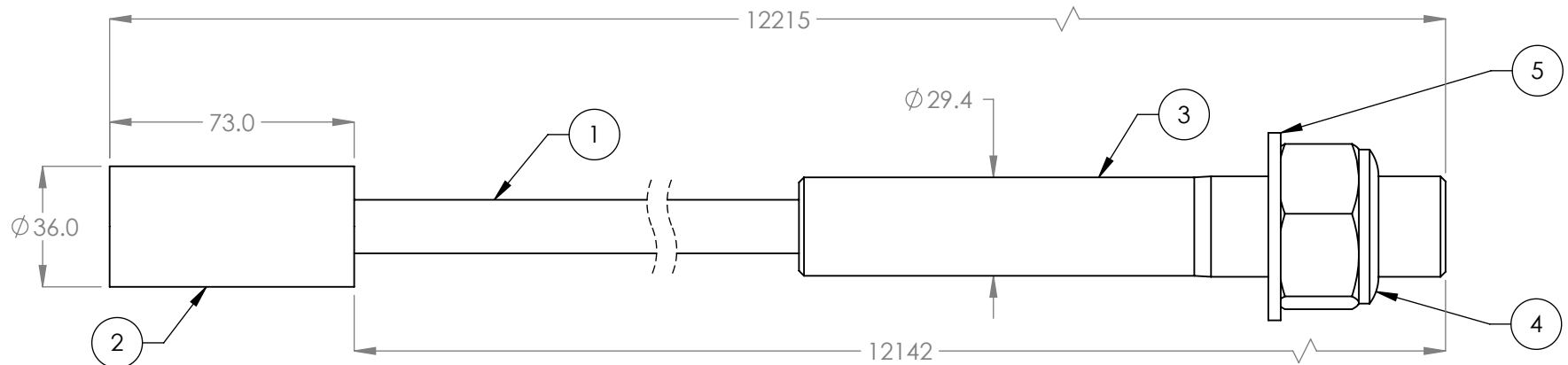
NOTE: UNLESS OTHERWISE SPECIFIED.

- FOR ITEM 1 SPECIFICATIONS REFER TO PART SPECIFICATION FORM
- LENGTH SHOWN IS AFTER SWAGING
- ITEM 1 QTY FOR REFERENCE ONLY
- THREAD 5535104 WITH 5545415 ONTO CABLES FOR SHIPMENT

ITEM NO	PART NUMBER	DESCRIPTION	QTY.	REV
1	5595190	CABLE, LIFTING 16mm	10330mm*	-
2	5746061	Ø16 CABLE BUTTON	1	C
3	5746060	Ø16 THREADED CABLE CONNECTOR	1	A
4	5535104	NUT M30 x 3.5 NL	1	-
5	5545415	WASHER M30 x 56 FLAT	1	-

DO NOT SCALE DRAWING		NAME	DATE	 BendPak. 1645 LEMONWOOD DR. SANTA PAULA, CA 93060	
		DRAWN	AC		05/16/2008
		CHECKED			
DIMENSIONS ARE IN MM TOLERANCES: 0. = ±1.5 0.0 = ±0.5		THIRD ANGLE PROJECTION			TITLE: HDS-18/27 CABLE ASSEMBLY Ø16 x 10483mm ST
SURFACE FINISH 1.6 ISO Ra µm FOR MACHINED SURFACES UNLESS OTHERWISE SPECIFIED					
		PROPRIETARY AND CONFIDENTIAL THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF BENDPAK INC. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF BENDPAK INC. IS PROHIBITED.			
Y			SIZE	DWG. NO.	REV
			A	5595806	H
			SCALE: 1:2		SHEET 1 OF 1

REVISION				
REV	DESCRIPTION	DATE	EDITED BY	ECO#
G	UPDATED TITLE TO REFLECT WHERE USED, UPDATED NEXT ASSEMBLY	09/18/2015	TM	00724
H	WAS 12100 NOW 12142, WAS 12023 NOW 12118, UPDATED BOM REVISION	12/28/2017	TM	00909
J	ADDED 5535104 AND 5545415, UPDATED TITLE AND NEXT ASSEMBLY	07/21/2020	TM	01174



WHERE USED
HDS-18 SERIES
HDS-27

NOTE: UNLESS OTHERWISE SPECIFIED.

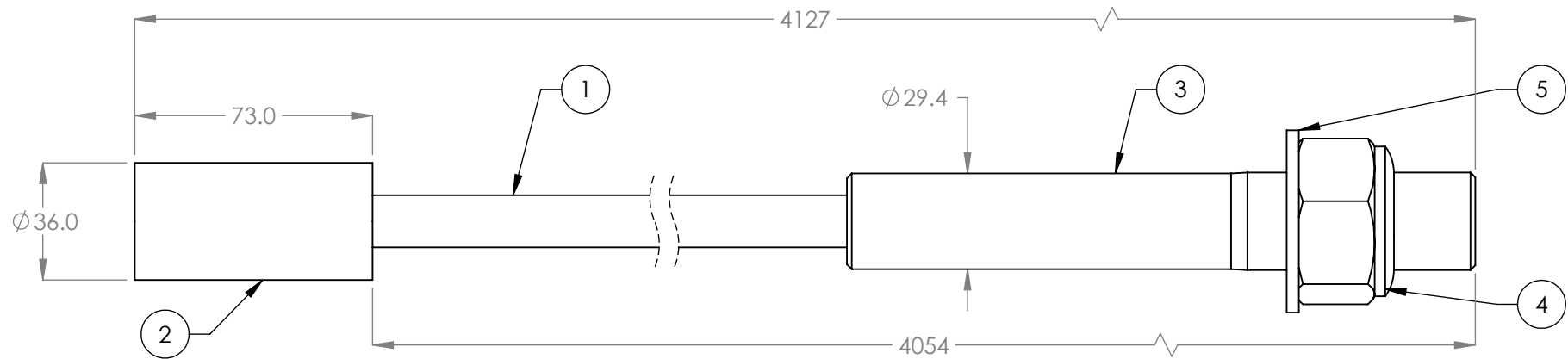
- FOR ITEM 1 SPECIFICATIONS REFER TO PART SPECIFICATION FORM
- LENGTH SHOWN IS AFTER SWAGING
- ITEM 1 QTY FOR REFERENCE ONLY
- THREAD 5535104 WITH 5545415 ONTO CABLES FOR SHIPMENT

NEXT ASSEMBLY
5250172
5250286

ITEM NO	PART NUMBER	DESCRIPTION	QTY.	REV
1	5595190	CABLE, LIFTING 16mm	12118mm*	-
2	5746061	Ø16 CABLE BUTTON	1	C
3	5746060	Ø16 THREADED CABLE CONNECTOR	1	A
4	5535104	NUT M30 x 3.5 NL	1	-
5	5545415	WASHER M30 x 56 FLAT	1	-

DO NOT SCALE DRAWING		NAME	DATE	 BendPak. 1645 LEMONWOOD DR. SANTA PAULA, CA 93060	
		DRAWN	AC		05/16/2008
		CHECKED			
DIMENSIONS ARE IN MM TOLERANCES: 0. = ±1.5 0.0 = ±0.5		THIRD ANGLE PROJECTION			TITLE: HDS-18/27 CABLE ASSEMBLY Ø16 x 12215mm ST
SURFACE FINISH 1.6 ISO Ra µm FOR MACHINED SURFACES UNLESS OTHERWISE SPECIFIED					
		PROPRIETARY AND CONFIDENTIAL THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF BENDPAK INC. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF BENDPAK INC. IS PROHIBITED.			
Y			SIZE DWG. NO.		REV
			A 5595807		J
	SCALE: 1:2				SHEET 1 OF 1

REVISION				
REV	DESCRIPTION	DATE	EDITED BY	ECO#
C	UPDATED TITLE TO REFLECT WHERE USED AND NEXT ASSEMBLIES	08/04/2015	TM	00683
C-001	UPDATED NEXT ASSEMBLIES	09/18/2015	TM	00724
D	UPDATED TITLE TO REFLECT WHERE USED, UPDATED BOM REVISION	12/20/2017	TM	00909
E	ADDED 5535104 AND 5545415	07/21/2020	TM	01174



WHERE USED
HDS-18 SERIES
HDS-27
HDS-27X

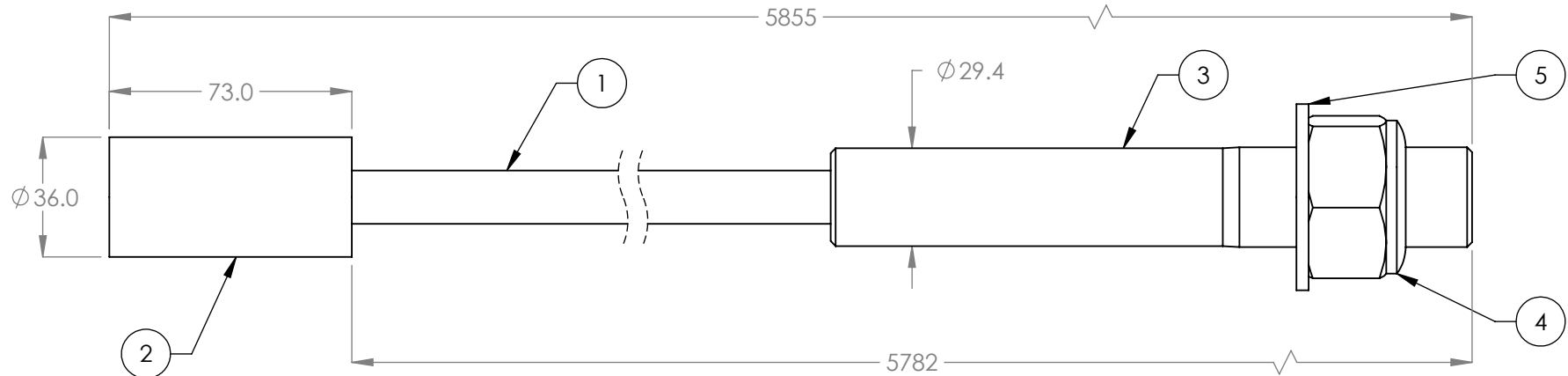
NOTE: UNLESS OTHERWISE SPECIFIED.

- FOR ITEM 1 SPECIFICATIONS REFER TO PART SPECIFICATION FORM
- LENGTH SHOWN IS AFTER SWAGING
- ITEM 1 QTY FOR REFERENCE ONLY
- THREAD 5535104 WITH 5545415 ONTO CABLES FOR SHIPMENT

ITEM NO	PART NUMBER	DESCRIPTION	QTY.	REV
1	5595190	CABLE, LIFTING 16mm	3977mm*	-
2	5746061	Ø16 CABLE BUTTON	1	C
3	5746060	Ø16mm THREADED CABLE CONNECTOR	1	A
4	5535104	NUT M30 x 3.5 NL	1	-
5	5545415	WASHER M30 x 56 FLAT	1	-

DO NOT SCALE DRAWING		NAME	DATE	 BendPak. 1645 LEMONWOOD DR. SANTA PAULA, CA 93060		
		DRAWN	MT		04/19/2011	
		CHECKED	OR		08/28/2020	
DIMENSIONS ARE IN MM TOLERANCES: 0. = ±1.5 0.0 = ±0.5 SURFACE FINISH 1.6 ISO Ra µm FOR MACHINED SURFACES UNLESS OTHERWISE SPECIFIED		THIRD ANGLE PROJECTION			TITLE: HDS-18E/18EA/27 CABLE ASSEMBLY Ø16 x 4127mm ST	
						
		PROPRIETARY AND CONFIDENTIAL THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF BENDPAK INC. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF BENDPAK INC. IS PROHIBITED.			SIZE DWG. NO.	REV
					A 5595835	E
					SCALE: 1:2	SHEET 1 OF 1

REVISION				
REV.	DESCRIPTION	DATE	EDITED BY	ECO#
C	UPDATED TITLE TO REFLECT WHERE USED AND NEXT ASSEMBLIES	08/04/2015	TM	00683
C-001	UPDATED NEXT ASSEMBLIES	09/18/2015	TM	00724
D	UPDATED TITLE TO REFLECT WHERE USED, UPDATED BOM REVISION	12/20/2017	TM	00909
E	ADDED 5535104 AND 5545415, UPDATED NEXT ASSEMBLY	07/21/2020	TM	01174



WHERE USED
HDS-18 SERIES
HDS-27
HDS-27X

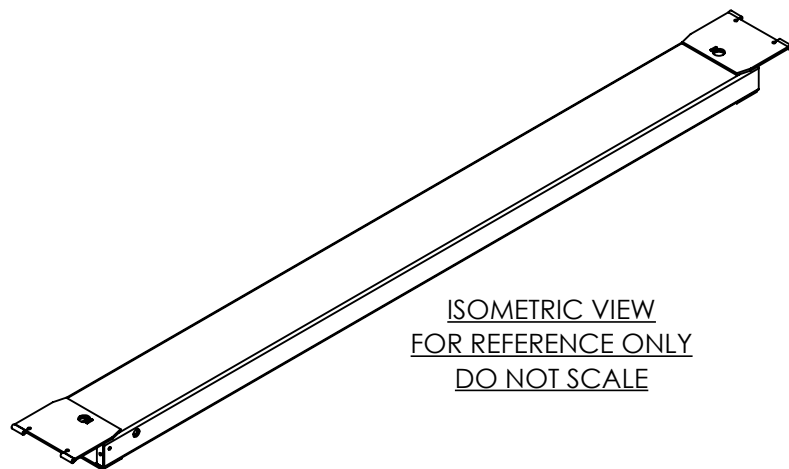
NOTE: UNLESS OTHERWISE SPECIFIED.

- FOR ITEM 1 SPECIFICATIONS REFER TO PART SPECIFICATION FORM
- LENGTH SHOWN IS AFTER SWAGING
- ITEM 1 QTY FOR REFERENCE ONLY
- THREAD 5535104 WITH 5545415 ONTO CABLES FOR SHIPMENT

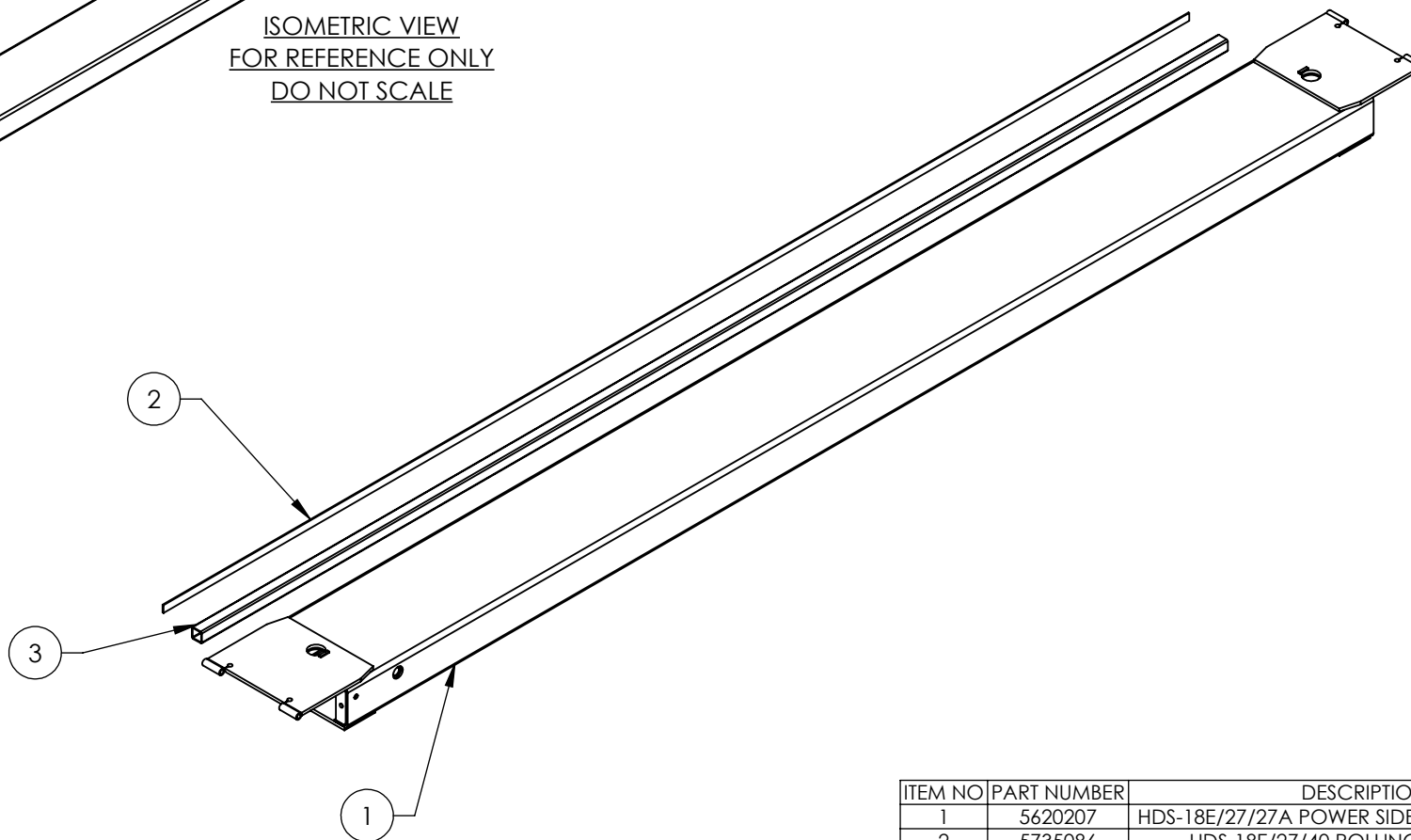
NEXT ASSEMBLY
5250172
5250175
5250286

ITEM NO	PART NUMBER	DESCRIPTION	QTY.	REV
1	5595190	CABLE, LIFTING 16mm	5702mm*	-
2	5746061	Ø16 CABLE BUTTON	1	C
3	5746060	Ø16mm THREADED CABLE CONNECTOR	1	A
4	5535104	NUT M30 x 3.5 NL	1	-
5	5545415	WASHER M30 x 56 FLAT	1	-

DO NOT SCALE DRAWING		NAME	DATE	 BendPak.	
DIMENSIONS ARE IN MM TOLERANCES: 0. = ±1.5 0.0 = ±0.5		DRAWN	MT	04/19/2011	1645 LEMONWOOD DR. SANTA PAULA, CA 93060
		CHECKED	OR	08/28/2020	
		THIRD ANGLE PROJECTION			
SURFACE FINISH 1.6 ISO Ra µm FOR MACHINED SURFACES UNLESS OTHERWISE SPECIFIED					TITLE: HDS-18E/18EA/27 CABLE ASSEMBLY Ø16 x 5855mm ST
THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF BENDPAK INC. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF BENDPAK INC. IS PROHIBITED.		SIZE DWG. NO.			REV
		A 5595836			E
SCALE: 1:2					SHEET 1 OF 1



ISOMETRIC VIEW
FOR REFERENCE ONLY
DO NOT SCALE



WHERE USED

HDS-18E
HDS-27

NOTE: UNLESS OTHERWISE SPECIFIED.

1. REFER TO MODEL FOR ADDITIONAL INFORMATION
2. BREAK AND DEBURR ALL SHARP EDGES 0.3mm
3. REMOVE ALL WELD SPLATTER
4. DIMENSIONS SHOWN ARE AFTER PAINTING
5. PAINT BENDPAK GRAY (RAL-7024) 20% GLOSS

NEXT ASSEMBLY
5215164

REVISION				
REV	DESCRIPTION	DATE	EDITED BY	ECO#
H	ADDED RAL NUMBER TO NOTES, UPDATED TITLE TO REFLECT WHERE USED, UPDATED BOM REVISION	12/20/2016	TS	00798
J J-001	UPDATED BOM REVISIONS ADDED GLOSS NOTE TO PAINT, REMOVED GRIT NOTE	08/28/2018 02/05/2020	CA CA	00945 01120
K	UPDATED BOM REVISION	01/10/2022	TM	01378

ITEM NO	PART NUMBER	DESCRIPTION	QTY	REV
1	5620207	HDS-18E/27/27A POWER SIDE RAMP WELDMENT	1	J
2	5735086	HDS-18E/27/40 ROLLING JACK PLATE	1	D
3	5765020	HDS-18EA/27/40 ROLLING JACK TUBE	1	D

DO NOT SCALE DRAWING

DIMENSIONS ARE IN MM
TOLERANCES:
0. = ±1.5
0.0 = ±0.5

SURFACE FINISH 1.6 ISO Ra µm
FOR MACHINED SURFACES
UNLESS OTHERWISE SPECIFIED

NAME	DATE
DRAWN GJZ	10/23/2008
CHECKED OR	01/11/2022



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1645 LEMONWOOD DR.
SANTA PAULA, CA 93060

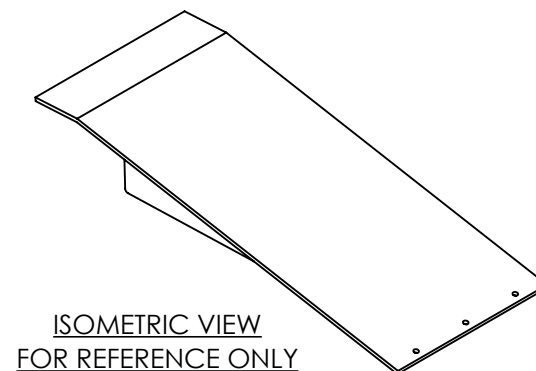
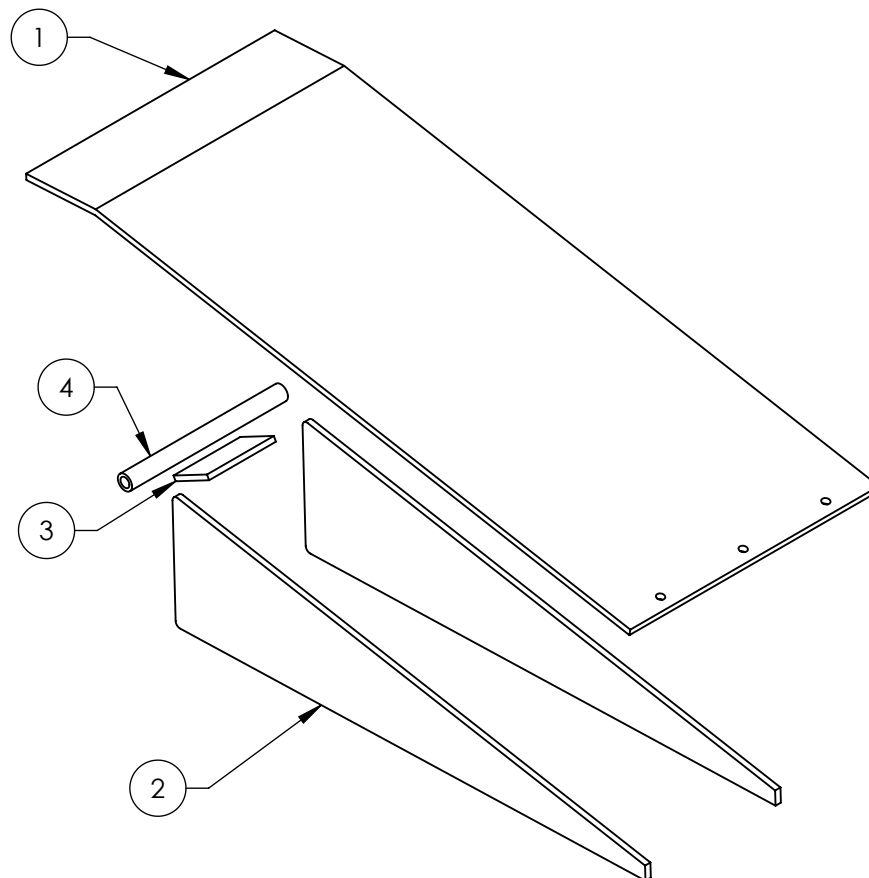
TITLE:
HDS-18E/27 POWER SIDE
RAMP WELDMENT

SIZE DWG. NO. REV

A 5600142 K

SCALE: 1:30

SHEET 1 OF 2



ISOMETRIC VIEW
FOR REFERENCE ONLY
DO NOT SCALE

REVISION				
REV	DESCRIPTION	DATE	EDITED BY	ECO#
H	WAS 217 NOW 283, WAS 100 NOW 90, UPDATED BOM REVISIONS	06/14/2018	TS	00945
J	UPDATED BOM REVISION, ADDED GLOSS NOTE TO PAINT	10/03/2019	TS	01120
K	REMOVED 5755032, REMOVED ALUMINUM OXIDE GRIT, WAS 1220 NOW 1218.6, WAS 270 NOW 271, UPDATED BOM REVISION	08/08/2022	TM	01436

WHERE USED
HDS-18 SERIES
HDS-27 SERIES

NOTE: UNLESS OTHERWISE SPECIFIED.

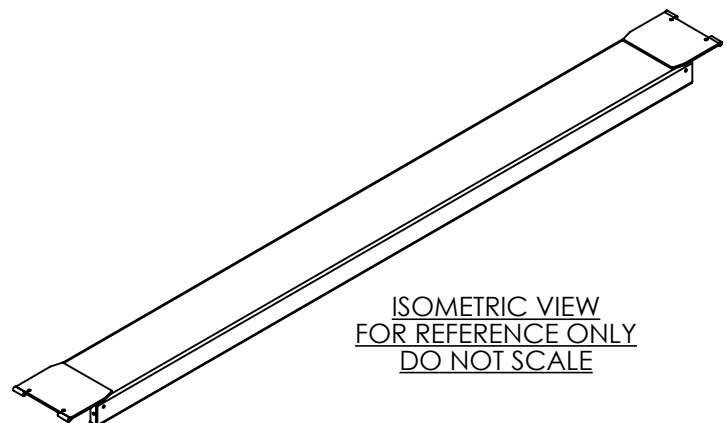
1. REFER TO MODEL FOR ADDITIONAL INFORMATION
2. BREAK AND DEBURR ALL SHARP EDGES 0.3mm
3. REMOVE ALL WELD SPLATTER
4. DIMENSIONS SHOWN ARE AFTER PAINTING
5. PAINT YELLOW (RAL-1018) 20% GLOSS

NEXT ASSEMBLY
5215161

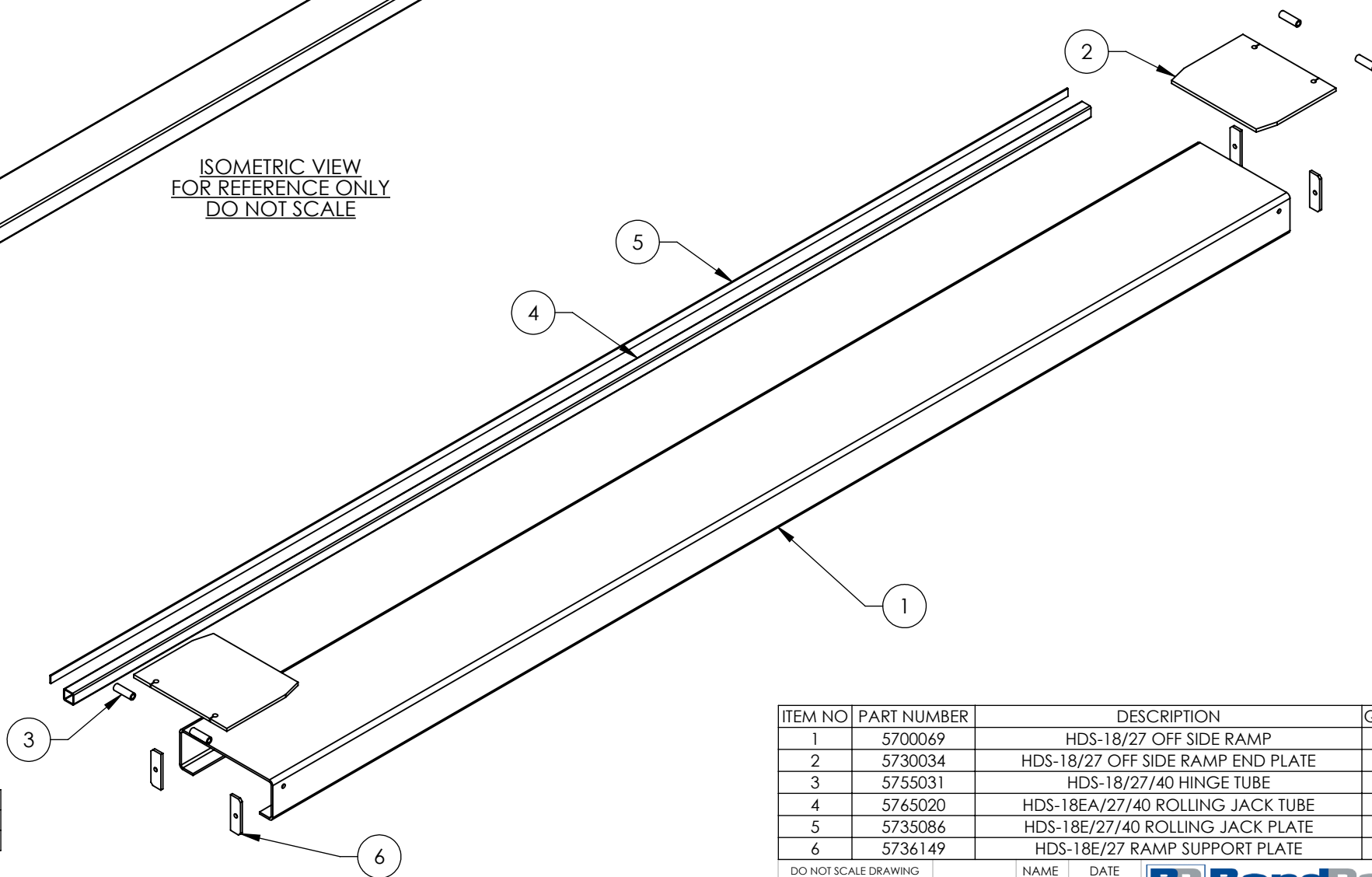
ITEM NO	PART NUMBER	DESCRIPTION	QTY	REV
1	5701054	HDS-18/27 EXTENDED DRIVE UP RAMP	1	E
2	5731011	HDS-18/27/40 EXTENDED DRIVE UP WEDGE	2	F
3	5735465	HDS-18/27/40 SERIES LONG HINGE STOP	1	E
4	5755033	LONG HINGE TUBE, DRIVE UP RAMP	1	B

DO NOT SCALE DRAWING		NAME	DATE	 1645 LEMONWOOD DR. SANTA PAULA, CA 93060
DRAWN		AC	05/06/2009	
CHECKED		OR	08/16/2022	
DIMENSIONS ARE IN MM TOLERANCES: 0. = ±1.5 0.0 = ±0.5 SURFACE FINISH 1.6 ISO Ra µm FOR MACHINED SURFACES UNLESS OTHERWISE SPECIFIED		THIRD ANGLE PROJECTION		TITLE: HDS-18/27 EXTENDED DRIVE UP RAMP WELDMENT
 PROPRIETARY AND CONFIDENTIAL THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF BENDPAK INC. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF BENDPAK INC. IS PROHIBITED.		SIZE	DWG. NO.	REV
		A	5600196	K
SCALE: 1:12			SHEET 1 OF 2	

REVISION				
REV	DESCRIPTION	DATE	EDITED BY	ECO#
A	PRODUCTION RELEASE, DERIVED FROM 5620208	12/12/2019	TM	01120
B	UPDATED BOM REVISION	01/10/2022	TM	01378



ISOMETRIC VIEW
FOR REFERENCE ONLY
DO NOT SCALE



WHERE USED
HDS-18E
HDS-27

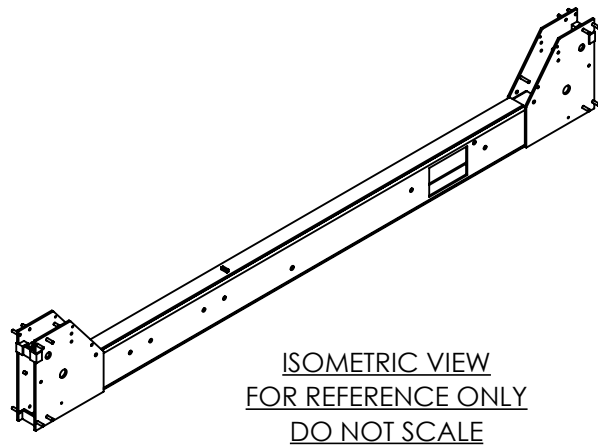
ITEM NO	PART NUMBER	DESCRIPTION	QTY	REV
1	5700069	HDS-18/27 OFF SIDE RAMP	1	D
2	5730034	HDS-18/27 OFF SIDE RAMP END PLATE	2	B
3	5755031	HDS-18/27/40 HINGE TUBE	4	D
4	5765020	HDS-18EA/27/40 ROLLING JACK TUBE	1	D
5	5735086	HDS-18E/27/40 ROLLING JACK PLATE	1	D
6	5736149	HDS-18E/27 RAMP SUPPORT PLATE	4	B

NOTE: UNLESS OTHERWISE SPECIFIED.

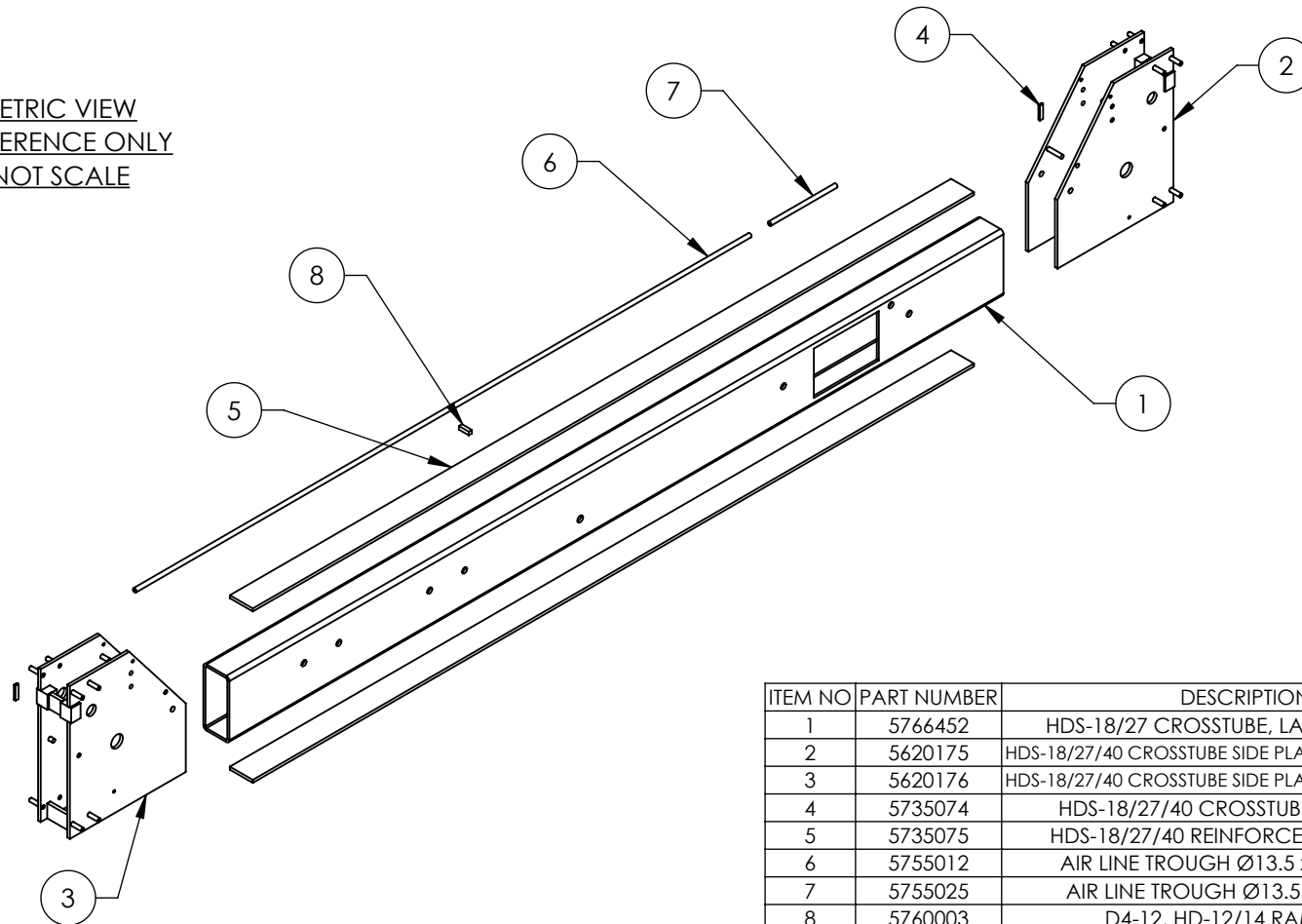
1. REFER TO MODEL FOR ADDITIONAL INFORMATION
2. BREAK AND DEBURR ALL SHARP EDGES 0.3mm
3. REMOVE ALL WELD SPLATTER
4. DIMENSIONS SHOWN ARE AFTER PAINTING
5. PAINT GRAY (RAL-7024) 20% GLOSS

NEXT ASSEMBLY
5245088
5245090

DO NOT SCALE DRAWING		NAME	DATE	 1645 LEMONWOOD DR. SANTA PAULA, CA 93060
DRAWN		TM	12/12/2019	
CHECKED		OR	01/11/2022	
THIRD ANGLE PROJECTION				TITLE: HDS-18E/27 OFF SIDE RAMP WELDMENT
DIMENSIONS ARE IN MM TOLERANCES: 0. = ±1.5 0.0 = ±0.5		SURFACE FINISH 1.6 ISO Ra µm FOR MACHINED SURFACES UNLESS OTHERWISE SPECIFIED		SIZE DWG. NO. REV
				A 5601441 B
		PROPRIETARY AND CONFIDENTIAL THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF BENDPAK INC. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF BENDPAK INC. IS PROHIBITED.		SCALE: 1:25 SHEET 1 OF 2



REVISION				
REV	DESCRIPTION	DATE	EDITED BY	ECO#
A	PRODUCTION RELEASE, DERIVED FROM 5601443	05/02/2022	TM	01414



WHERE USED
HDS-18 SERIES
HDS-27 SERIES

NOTE: UNLESS OTHERWISE SPECIFIED.

- REFER TO MODEL FOR ADDITIONAL INFORMATION
- BREAK AND DEBURR ALL SHARP EDGES 0.3mm
- REMOVE ALL WELD SPLATTER
- DIMENSIONS SHOWN ARE AFTER PAINTING
- PAINT GRAY (RAL-7024) 20% GLOSS

ITEM NO	PART NUMBER	DESCRIPTION	QTY	REV
1	5766452	HDS-18/27 CROSSTUBE, LARGE WINDOW	1	A
2	5620175	HDS-18/27/40 CROSSTUBE SIDE PLATE SUBWELDMENT #1	1	M
3	5620176	HDS-18/27/40 CROSSTUBE SIDE PLATE SUBWELDMENT #2	1	M
4	5735074	HDS-18/27/40 CROSSTUBE SHAFT STOP	2	D
5	5735075	HDS-18/27/40 REINFORCER, CROSSTUBE	2	C
6	5755012	AIR LINE TROUGH Ø13.5 x Ø9.5 x 2362	1	C
7	5755025	AIR LINE TROUGH Ø13.5 x Ø9.5 x 254	1	C
8	5760003	D4-12, HD-12/14 RAMP STOP	1	C

DO NOT SCALE DRAWING

DIMENSIONS ARE IN MM
TOLERANCES:

0. = ±1.5
0.0 = ±0.5

SURFACE FINISH 1.6 ISO Ra µm
FOR MACHINED SURFACES
UNLESS OTHERWISE SPECIFIED

NAME	DATE
DRAWN	TM 05/02/2022
CHECKED	OR 06/06/2022

THIRD ANGLE PROJECTION



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1645 LEMONWOOD DR.
SANTA PAULA, CA 93060

TITLE: HDS-18/27 CROSSTUBE
WELDMENT, LARGE WINDOW

SIZE	DWG. NO.	REV
A	5601831	A

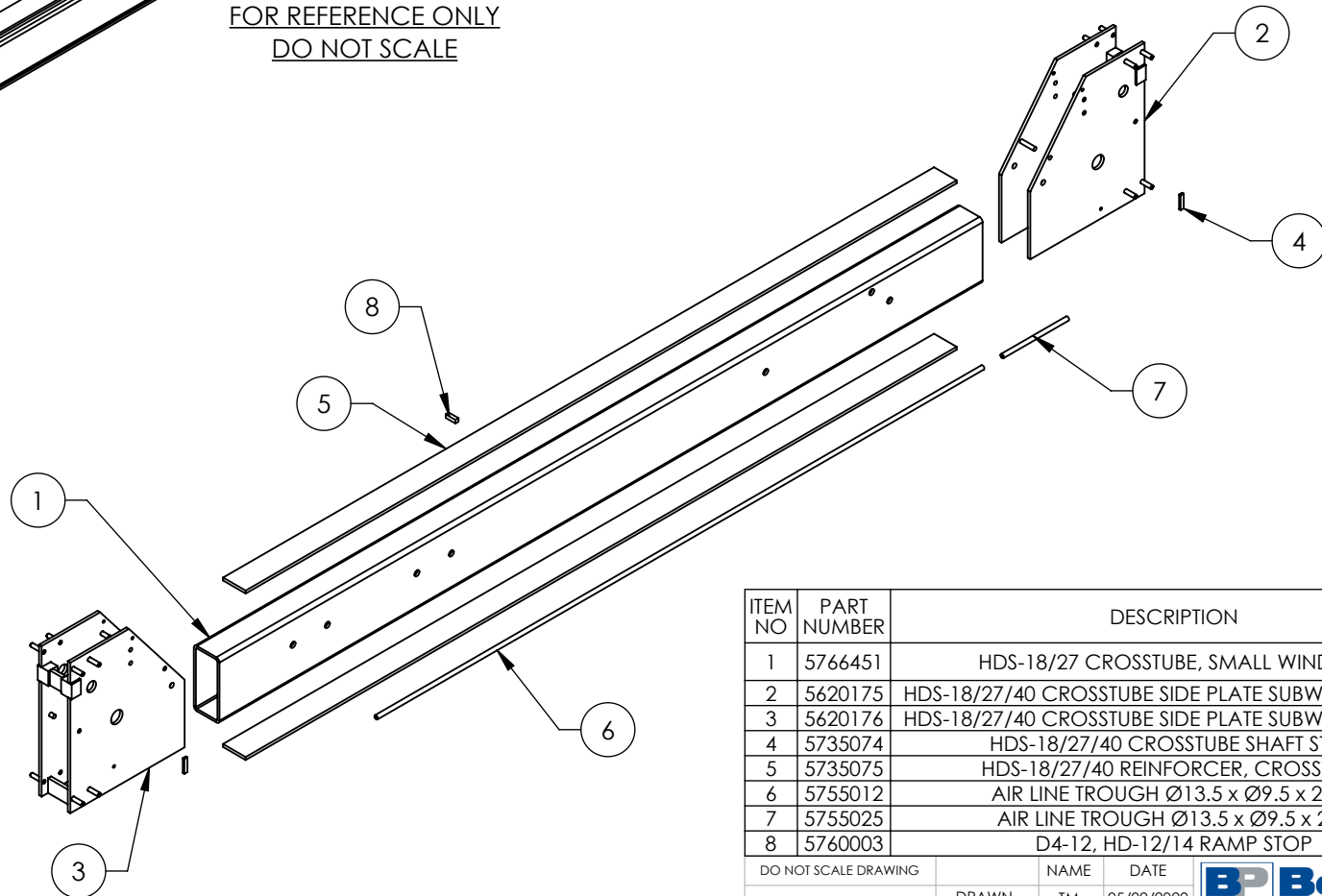
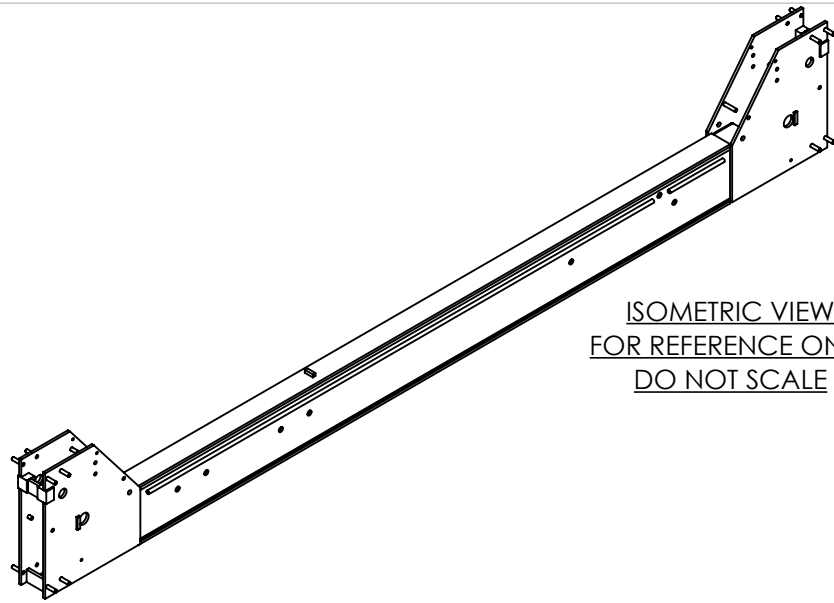
SCALE: 1:20

SHEET 1 OF 3

NEXT ASSEMBLY
5216168

REVISION				
REV	DESCRIPTION	DATE	EDITED BY	ECO#
A	PRODUCTION RELEASE, DERIVED FROM 5601444	05/02/2022	TM	01414

ISOMETRIC VIEW
FOR REFERENCE ONLY
DO NOT SCALE



WHERE USED
HDS-18 SERIES
HDS-27 SERIES

NOTE: UNLESS OTHERWISE SPECIFIED.

1. REFER TO MODEL FOR ADDITIONAL INFORMATION
2. BREAK AND DEBURR ALL SHARP EDGES 0.3mm
3. REMOVE ALL WELD SPLATTER
4. DIMENSIONS SHOWN ARE AFTER PAINTING
5. PAINT GRAY (RAL-7024) 20% GLOSS

NEXT ASSEMBLY
5216167

ITEM NO	PART NUMBER	DESCRIPTION	QTY	REV
1	5766451	HDS-18/27 CROSSTUBE, SMALL WINDOW	1	A
2	5620175	HDS-18/27/40 CROSSTUBE SIDE PLATE SUBWELDMENT #1	1	M
3	5620176	HDS-18/27/40 CROSSTUBE SIDE PLATE SUBWELDMENT #2	1	M
4	5735074	HDS-18/27/40 CROSSTUBE SHAFT STOP	2	D
5	5735075	HDS-18/27/40 REINFORCER, CROSSTUBE	2	C
6	5755012	AIR LINE TROUGH Ø13.5 x Ø9.5 x 2362	1	C
7	5755025	AIR LINE TROUGH Ø13.5 x Ø9.5 x 254	1	C
8	5760003	D4-12, HD-12/14 RAMP STOP	1	C

DO NOT SCALE DRAWING

DIMENSIONS ARE IN MM
TOLERANCES:
0. = ±1.5
0.0 = ±0.5

SURFACE FINISH 1.6 ISO Ra µm
FOR MACHINED SURFACES
UNLESS OTHERWISE SPECIFIED

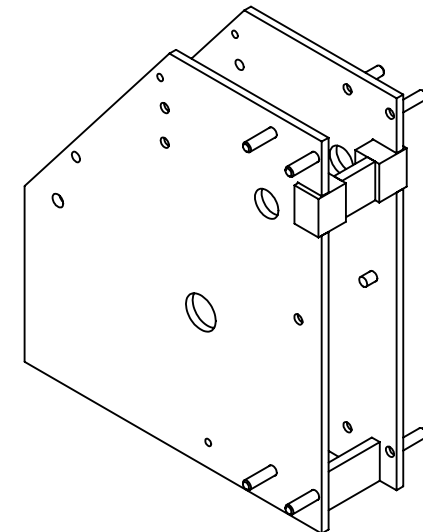
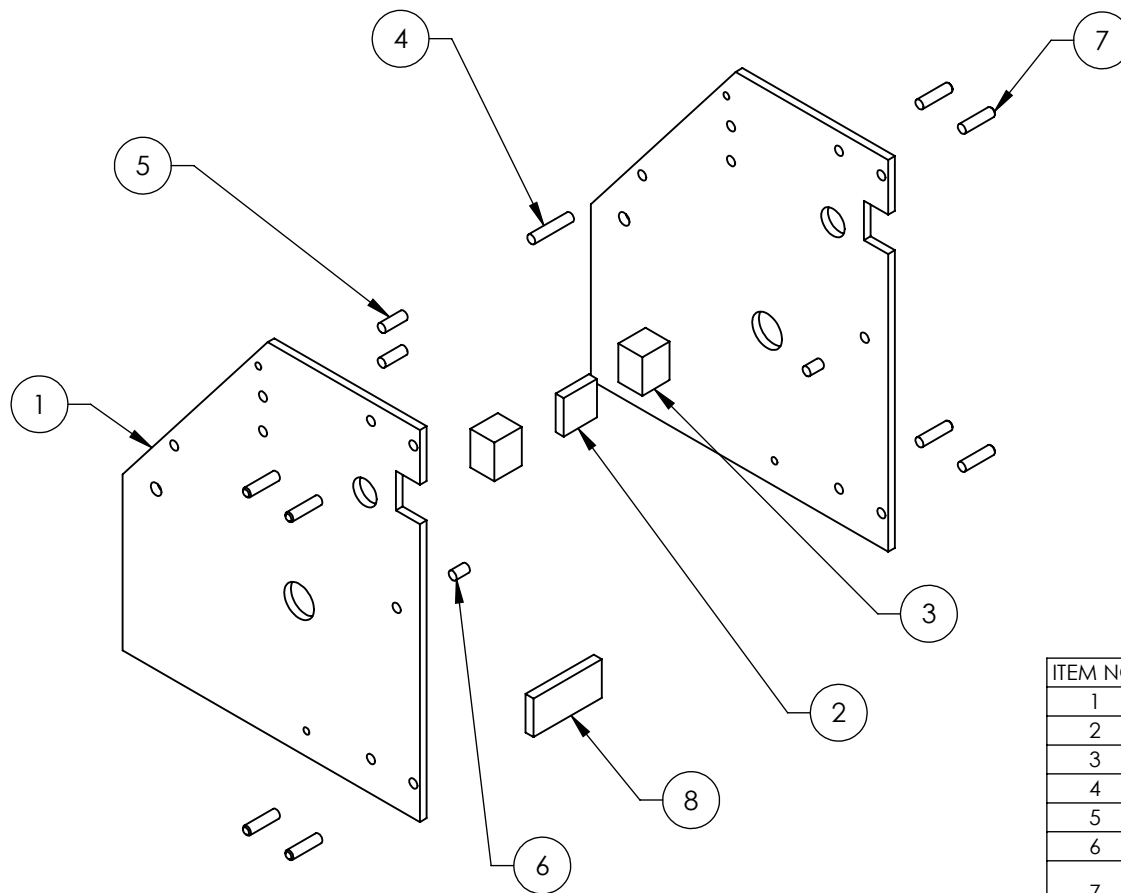
NAME	DATE
DRAWN TM	05/02/2022
CHECKED OR	06/06/2022
THIRD ANGLE PROJECTION	

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BendPak.
1645 LEMONWOOD DR.
SANTA PAULA, CA 93060

TITLE: HDS-18/27 CROSSTUBE WELDMENT, SMALL WINDOW	
SIZE DWG. NO. A 5601832	REV A
SCALE: 1:20	SHEET 1 OF 3

REVISION				
REV	DESCRIPTION	DATE	EDITED BY	ECO#
K	UPDATED BOM REVISION	12/18/2017	TM	00909
L	UPDATED TITLE TO REFLECT WHERE USED, UPDATED BOM REVISIONS AND NEXT ASSEMBLY	05/14/2018	TS	00945
M	UPDATED BOM REVISION AND NEXT ASSEMBLIES	10/16/2019	TS	01120



**ISOMETRIC VIEW
FOR REFERENCE ONLY
DO NOT SCALE**

ITEM NO	PART NUMBER	DESCRIPTION	QTY	REV
1	5731008	HDS-27/40 SERIES CROSSTUBE SIDE PLATE #1	2	J
2	5735076	HDS-27/40 SERIES SAFETY STOP BLOCK SUPPORT	1	C
3	5735077	HDS-27/40 SERIES EAR BLOCK SUPPORT	2	C
4	5746077	HDS-18/27/40 SERIES CLEVIS PIN, AIR CYLINDER	1	C
5	5746078	HDS-18/27/40 SERIES SPRING CLEVIS PIN	2	D
6	5746079	HDS-18/27/40 SERIES SAFETY STOP PIN	2	C
7	5746082	HDS-18/27/40 PIN 45mm LG, PLASTIC SLIDE BLOCK	8	D
8	5735078	HDS-27/40 SERIES EAR TIE BAR	1	D

WHERE USED

HDS-18 SERIES

HDS-27 SERIES

HDS-40 SERIES

NOTE: UNLESS OTHERWISE SPECIFIED.

1. REFER TO MODEL FOR ADDITIONAL INFORMATION
2. BREAK AND DEBURR ALL SHARP EDGES 0.3mm
3. REMOVE ALL WELD SPLATTER

NEXT ASSEMBLY
5601831
5601832
5601833
5601834

DO NOT SCALE DRAWING

DIMENSIONS ARE IN MM
TOLERANCES:
0. = ±1.5
0.0 = ±0.5

SURFACE FINISH 1.6 ISO Ra µm
FOR MACHINED SURFACES
UNLESS OTHERWISE SPECIFIED

NAME	DATE
DRAWN GJZ	09/18/2008
CHECKED OR	4/22/2020

THIRD ANGLE PROJECTION



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1645 LEMONWOOD DR.
SANTA PAULA, CA 93060

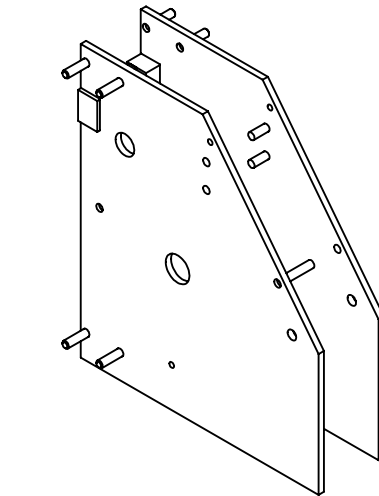
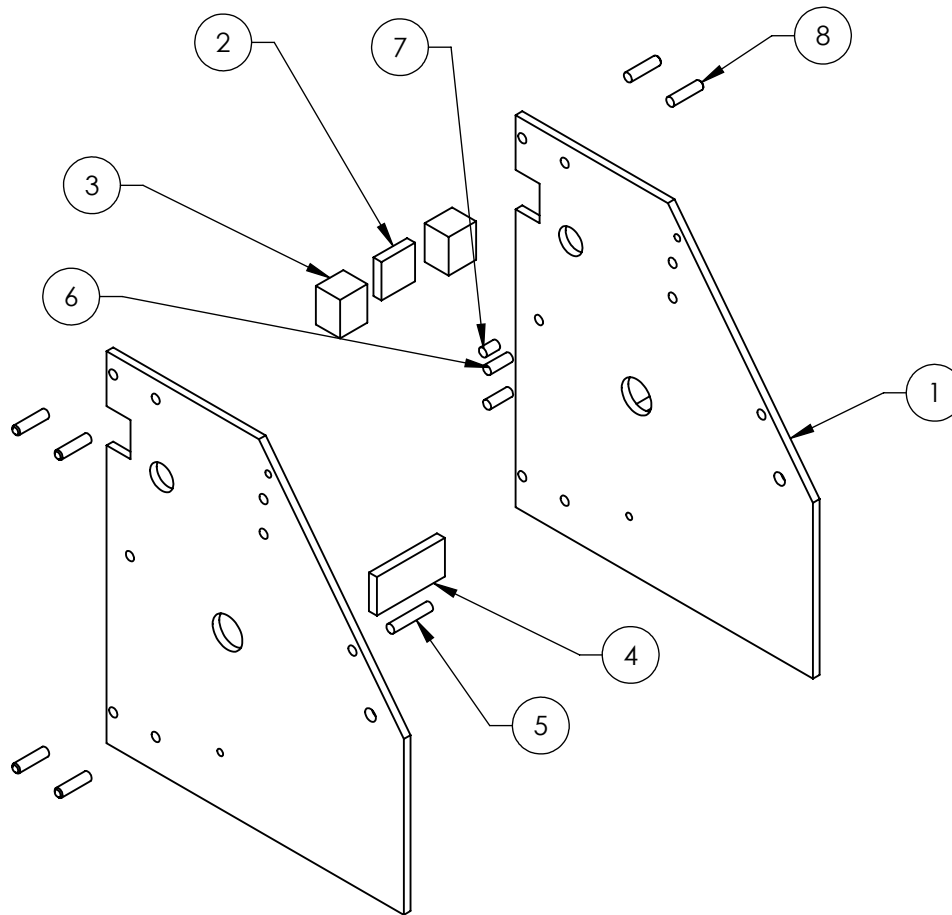
TITLE: HDS-18/27/40
CROSSTUBE SIDE PLATE
SUBWELDMENT #1

SIZE	DWG. NO.	REV
A	5620175	M

SCALE: 1:8

SHEET 1 OF 3

REVISION				
REV	DESCRIPTION	DATE	EDITED BY	ECO#
K	UPDATED BOM REVISION	12/18/2017	TM	00909
L	UPDATED TITLE TO REFLECT WHERE USED, UPDATED BOM REVISIONS AND NEXT ASSEMBLY	05/14/2018	TS	00945
M	UPDATED BOM REVISION AND NEXT ASSEMBLIES	10/16/2019	TS	01120



**ISOMETRIC VIEW
FOR REFERENCE ONLY
DO NOT SCALE**

WHERE USED
HDS-18 SERIES
HDS-27 SERIES
HDS-40 SERIES

NOTE: UNLESS OTHERWISE SPECIFIED.

- REFER TO MODEL FOR ADDITIONAL INFORMATION
- BREAK AND DEBURR ALL SHARP EDGES 0.3mm
- REMOVE ALL WELD SPLATTER

NEXT ASSEMBLY
5601831
5601832
5601833
5601834

ITEM NO	PART NUMBER	DESCRIPTION	QTY	REV
1	5731009	HDS-27/40 SERIES CROSSTUBE SIDE PLATE #2	2	K
2	5735076	HDS-27/40 SERIES SAFETY STOP BLOCK SUPPORT	1	C
3	5735077	HDS-27/40 SERIES EAR BLOCK SUPPORT	2	C
4	5735078	HDS-27/40 SERIES EAR TIE BAR	1	D
5	5746077	HDS-18/27/40 SERIES CLEVIS PIN, AIR CYLINDER	1	C
6	5746078	HDS-18/27/40 SERIES SPRING CLEVIS PIN	2	D
7	5746079	HDS-18/27/40 SERIES SAFETY STOP PIN	2	C
8	5746082	HDS-18/27/40 PIN 45mm LG, PLASTIC SLIDE BLOCK	8	D

DO NOT SCALE DRAWING

DIMENSIONS ARE IN MM
TOLERANCES:
0. = ±1.5
0.0 = ±0.5

SURFACE FINISH 1.6 ISO Ra µm
FOR MACHINED SURFACES
UNLESS OTHERWISE SPECIFIED

NAME	DATE
DRAWN GJZ	09/18/2008
CHECKED OR	4/22/2020

THIRD ANGLE PROJECTION



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1645 LEMONWOOD DR.
SANTA PAULA, CA 93060

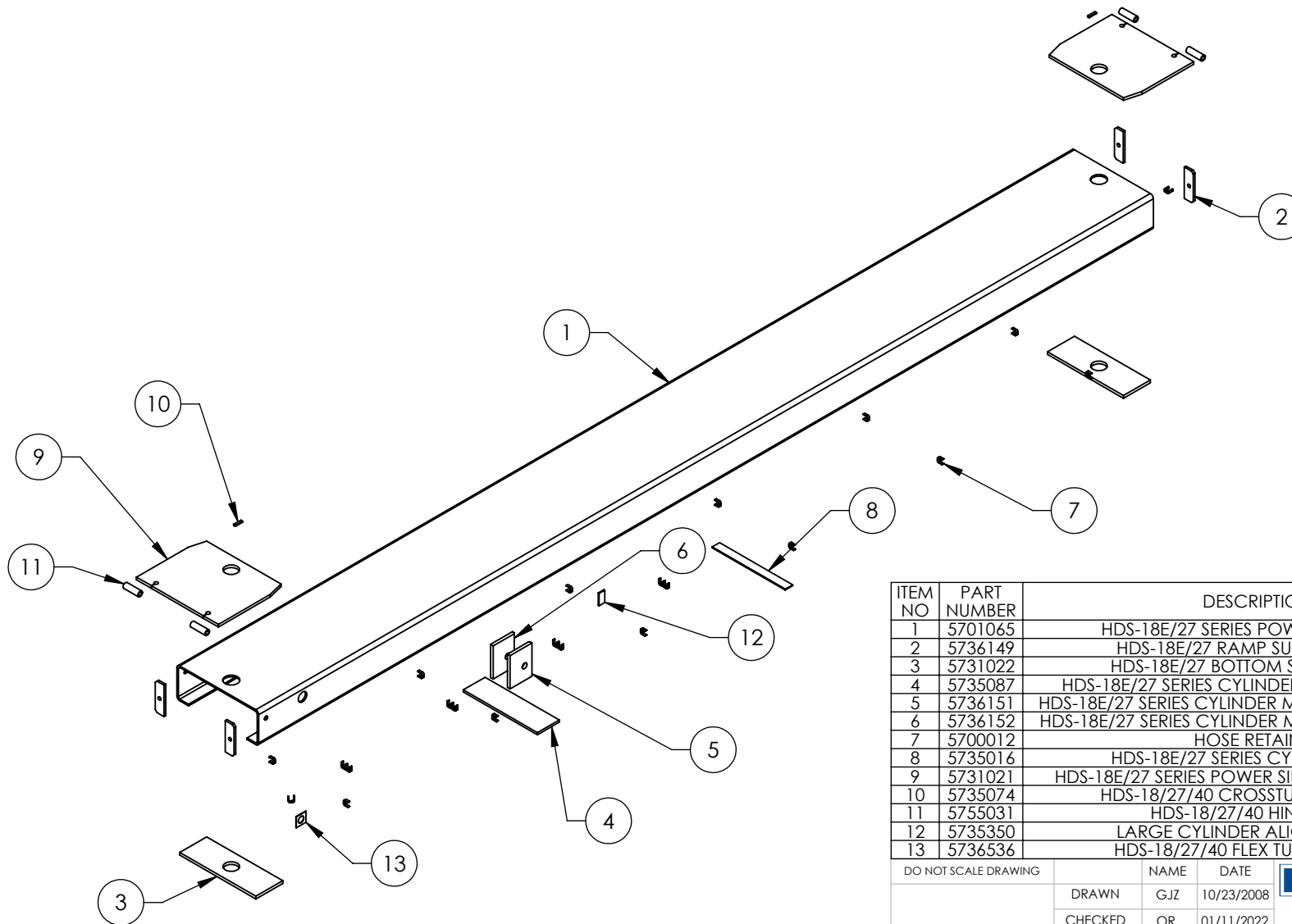
TITLE: HDS-18/27/40
CROSSTUBE SIDE PLATE
SUBWELDMENT #2

SIZE	DWG. NO.	REV
A	5620176	M

SCALE: 1:8

SHEET 1 OF 3

REVISION				
REV	DESCRIPTION	DATE	EDITED BY	ECO#
G	UPDATED TITLE TO REFLECT WHERE USED, UPDATED BOM REVISIONS	12/20/2016	TS	00798
H	UPDATED BOM REVISION AND NEXT ASSEMBLIES	08/21/2018	CA	00945
J	UPDATED BOM REVISION	01/10/2022	TM	01378



ITEM NO	PART NUMBER	DESCRIPTION	QTY	REV
1	5701065	HDS-18E/27 SERIES POWER SIDE RAMP	1	E
2	5736149	HDS-18E/27 RAMP SUPPORT PLATE	4	B
3	5731022	HDS-18E/27 BOTTOM SHEAVE PLATE	2	B
4	5735087	HDS-18E/27 SERIES CYLINDER MOUNTING PLATE	1	C
5	5736151	HDS-18E/27 SERIES CYLINDER MOUNTING BLOCK R.H.	1	B
6	5736152	HDS-18E/27 SERIES CYLINDER MOUNTING BLOCK L.H.	1	B
7	5700012	HOSE RETAINER	22	B
8	5735016	HDS-18E/27 SERIES CYLINDER STRAP	1	B
9	5731021	HDS-18E/27 SERIES POWER SIDE RAMP END PLATE	2	B
10	5735074	HDS-18/27/40 CROSSTUBE SHAFT STOP	2	D
11	5755031	HDS-18/27/40 HINGE TUBE	4	D
12	5735350	LARGE CYLINDER ALIGNMENT KEY	1	A
13	5736536	HDS-18/27/40 FLEX TUBE NUT PLATE	1	B

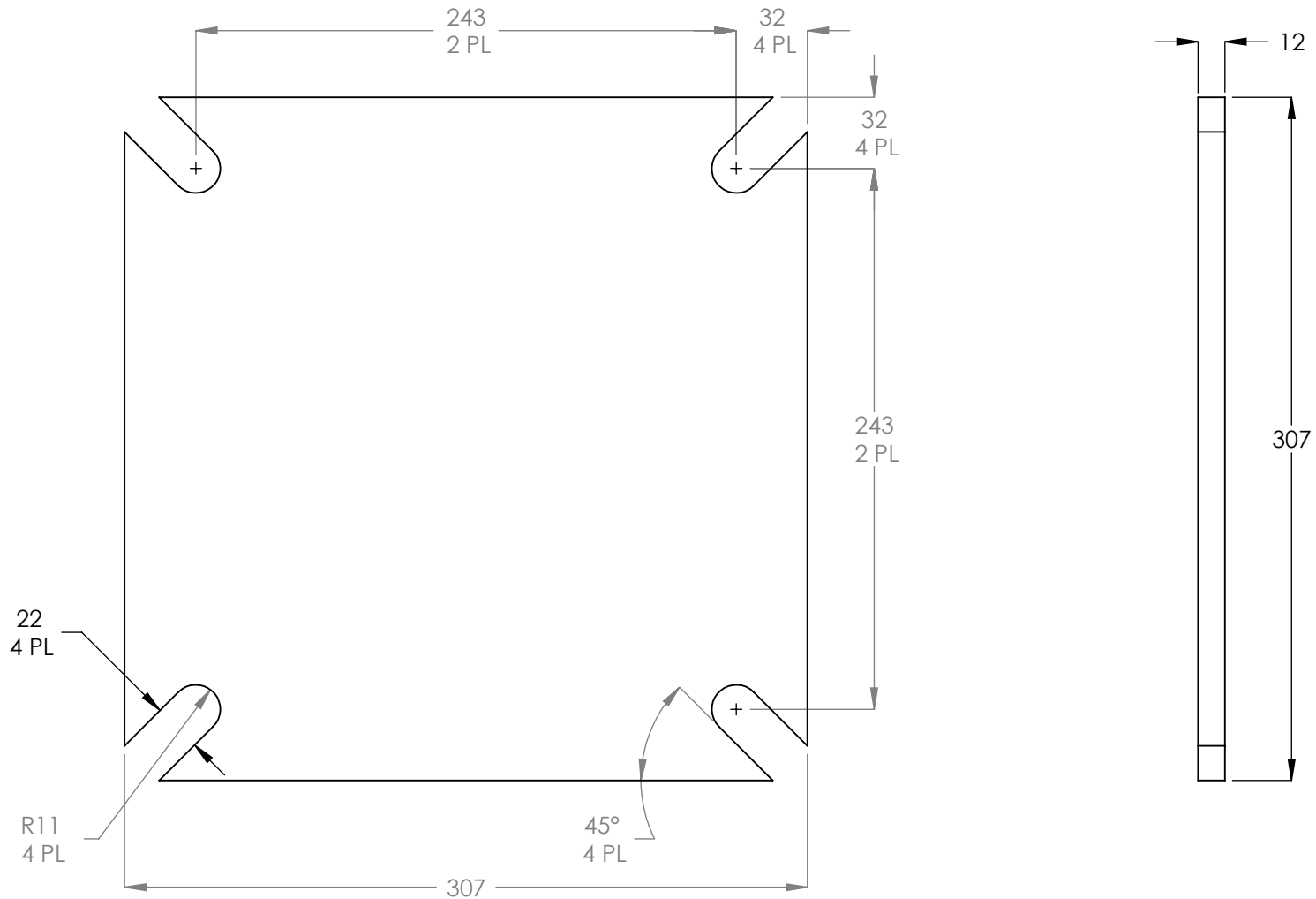
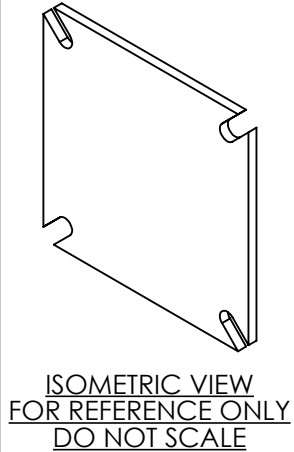
DO NOT SCALE DRAWING		NAME	DATE	 1645 LEMONWOOD DR. SANTA PAULA, CA 93060
DRAWN		GJZ	10/23/2008	
CHECKED		OR	01/11/2022	
THIRD ANGLE PROJECTION				TITLE:
DIMENSIONS ARE IN MM TOLERANCES: 0. = ±1.5 0.0 = ±0.5		SURFACE FINISH 1.6 ISO Ra μm FOR MACHINED SURFACES UNLESS OTHERWISE SPECIFIED		HDS-18E/27/27A POWER SIDE RAMP WELDMENT
PROPRIETARY AND CONFIDENTIAL THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF BENDPAK INC. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF BENDPAK INC. IS PROHIBITED.		SIZE	DWG. NO.	REV
		A	5620207	J
		SCALE: 1:30		SHEET 1 OF 4

NOTE: UNLESS OTHERWISE SPECIFIED.

1. REFER TO MODEL FOR ADDITIONAL INFORMATION
2. BREAK AND DEBURR ALL SHARP EDGES 0.3mm
3. REMOVE ALL WELD SPLATTER

NEXT ASSEMBLY
5600857
5600142

REVISION				
REV	DESCRIPTION	DATE	EDITED BY	ECO#
A	PRODUCTION RELEASE, DERIVED FROM 5730026	02/22/2017	TM	00798
B	UPDATED TITLE TO REFLECT WHERE USED, UPDATED NEXT ASSEMBLIES	05/04/2018	TS	00945



NOTE: UNLESS OTHERWISE SPECIFIED.

- BREAK AND DEBURR ALL SHARP EDGES 0.3mm
- MATERIAL:** HR ASTM A36 OR Q235 GB/T 700
- FLAME CUT PERMISSABLE

NEXT ASSEMBLY
5600978
5600980
5601141
5601143

DO NOT SCALE DRAWING		NAME		DATE		 BendPak.		
DIMENSIONS ARE IN MM TOLERANCES: MACHINE TO 0 = ±1.5 0.0 = ±0.5 0.00 = ±0.13 ANGULAR: MACHINE TO 0 = ±1/2° SURFACE FINISH 1.6 Ra µm FOR MACHINED SURFACES UNLESS OTHERWISE SPECIFIED		DRAWN	TM	02/22/2017		1645 LEMONWOOD DR. SANTA PAULA, CA 93060		
		CHECKED	CA	10/30/2018				
Y	THIRD ANGLE PROJECTION				TITLE:			
	HDS-18/27/40 SERIES BASE PLATE							
	SIZE DWG. NO.				REV			
	PROPRIETARY AND CONFIDENTIAL THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF BENDPAK INC. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF BENDPAK INC. IS PROHIBITED.		A		5730077		B	
			SCALE: 1:3					SHEET 1 OF 1

PART SPECIFICATION FORM (STANDARD)

BENDPAK Number:	5900160
MRP Description:	HDS TRUCK SERIES INSTALLATION MANUAL
Date:	04/18/2022
ECO :	---

1. Engineering Specification

Application:

INSTALLATION MANUAL

Detailed Description:

Print Settings

Unless otherwise specified, use these settings for printing BendPak manuals:

Size:	A4 (210 to 297 mm), 8.5 by 11 inches (216 to 279 mm), or between
Color:	Black and White
Binding:	Saddle Stitched
Paper:	100 to 120 gsm (27 to 32 pound), uncoated

WARNING

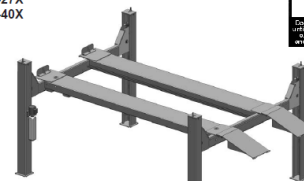
EUROPEAN USERS
400V 50Hz SUPPLY DETAILS ARE INCLUDED WITH ELECTRICAL CONTROL BOX. DISREGARD SUPPLY WIRING DETAILS IN THIS MANUAL.

IMPORTANT SAFETY INSTRUCTIONS, SAVE THESE INSTRUCTIONS!
READ THIS MANUAL THOROUGHLY BEFORE INSTALLING, OPERATING, SERVICING OR MAINTAINING THIS LIFT. FAILURE TO FOLLOW THE INSTRUCTIONS AND SAFETY PRECAUTIONS IN THIS MANUAL CAN RESULT IN SERIOUS INJURY OR DEATH. MAKE SURE ALL OTHER OPERATORS ALSO READ THIS MANUAL. KEEP THE MANUAL NEAR THE PRODUCT FOR FUTURE REFERENCE. BY PROCEEDING WITH INSTALLATION AND OPERATION, YOU AGREE THAT YOU FULLY UNDERSTAND THE CONTENTS OF THIS MANUAL AND ASSUME FULL RESPONSIBILITY FOR PRODUCT USE.
Manual Part Number 5900160 Manual Revision HS - April 2022

INSTALLATION AND OPERATION MANUAL SUPER-DUTY FOUR-POST LIFTS

Models:
HDS-18E
HDS-27 / HDS-27X
HDS-40 / HDS-40X

READ FIRST



ORIGINAL INSTRUCTIONS IN ENGLISH LANGUAGE

RECEIVING

The shipment should be thoroughly inspected as soon as it is received. The signed Bill of Lading is acknowledgement by the shipping carrier as receipt of this product as listed in your invoice as being in a good condition of shipment. If any of these goods listed on this Bill of Lading are missing or damaged, do not accept goods until the shipping carrier makes a notation on the freight bill of the missing or damaged goods. Do this for your own protection.

BE SAFE

Your new lift was designed and built with safety in mind. However, your overall safety can be increased with proper training and thoughtful operation on the part of the operator. DO NOT operate or repair this equipment without reading this manual and the important safety instructions shown inside. Keep this operation manual near the lift at all times. Make sure that ALL USERS read and understand this manual.

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1645 Lemonwood Dr.
Santa Paula, CA 93060, USA
Toll Free (800) 933-9970
Tel: (805) 253-2363
www.bendpak.com

2. Vendor Information (Or for Reference)

Approved Vendor	Vendor Part #	Contact #	Preferred Vendor
1)			
OR BENDPAK ENGINEERING APPROVED EQUIVALENT			

4 Post Lifts Product Decal Positioning



**CLEAR ADHESIVE PET
DOES NOT
PRINT YELLOW.**

Total of 6

PN 5905311

BPK Post Branding Decal-Large.pdf:

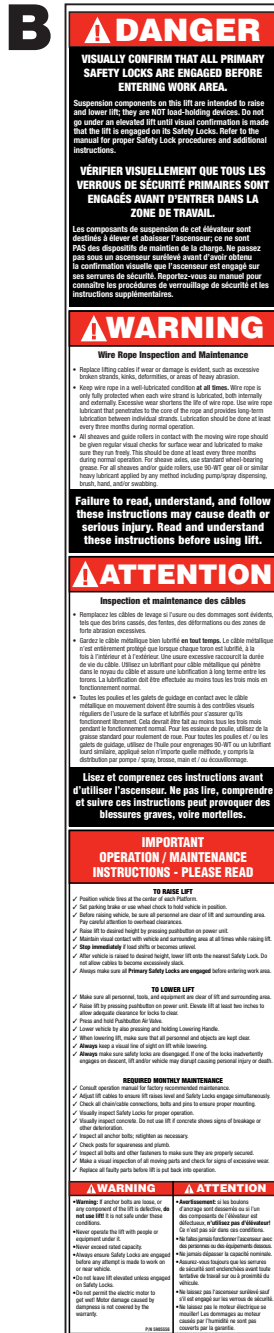
Size: 4.25"W x 38"H

Material: 4 Mil Clear Adhesive PET

Finish: Matte Overlamine (No gloss)

Print Process: Silk Screen, 85 line-screen
(Yellow color in file represents what should be clear PET material and SHOULD NOT print as Yellow ink. White area in file represents Opaque White ink.)

Lamination: Clear laminate non-glare medium matte over-lamine (No gloss) for abrasion, chemical and ultra violet protection.



PN 5905556

4-Post Safety-Operation Decal FRE-ENG.pdf:

Size: 4"W x 24"H

Material: 4 Mil. Permanent White Adhesive Vinyl

Ink: U.V. protected CMYK 2/C Process

Finish: Matte Overlamine (No gloss)

Print Process: Offset Lithography - 200 line-screen or 300 p.p.i. for digital

Lamination: Clear laminate non-glare medium matte over-lamine (No gloss) for abrasion, chemical and ultra violet protection.



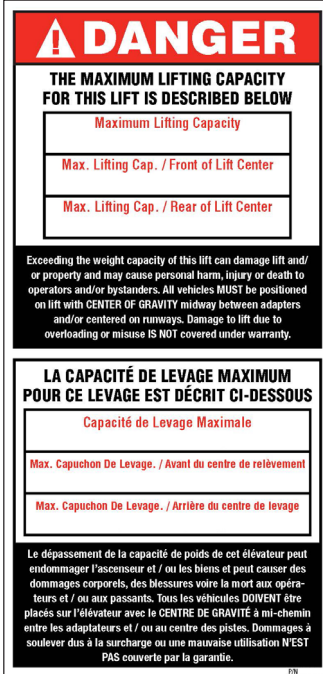
PN 5905103

ALI_4_Post_labels.pdf:
(Order Labels from ALI)

IMPORTANT: Please use materials as instructed

4 Post Lifts Product Decal Positioning

***D**



P/N 5905401 - Max Cap. Danger 7k
 P/N 5905695 - Max. Cap. Danger 7500
 P/N 5905402 - Max Cap. Danger 9k
 P/N 5905557 - Max. Cap. Danger 14K
 P/N 5905406 - Max Cap. Danger 18k
 P/N 5905407 - Max. Cap. Danger 27K
 P/N 5905408 - Max. Cap. Danger 35K
 P/N 5905068 - Max. Cap. Danger 37K
 P/N 5905409 - Max. Cap. Danger 40K

***Max. Cap. Danger ENG-FRE.pdf:**

Size: 4"W x 8.5"H

Material: 4 Mil. Permanent White Adhesive Vinyl

Ink: U.V. protected CMYK 2/C Process

Finish: Matte Overlamine (No gloss)

Print Process: Offset Lithography - 200 line-screen or 300 p.p.i. for digital

Lamination: Clear laminate non-glare medium matte over-lamine (No gloss) for abrasion, chemical and ultra violet protection.

***DEPENDS ON LIFT
 MODEL AND CAPACITY**

***E**



***NRTL_Lifting_Cap_ENG-FRE_.pdf:**

Size: 4.5"W x 3.25"H

Material: 4 Mil. Permanent White Adhesive Vinyl

Ink: U.V. protected CMYK 2/C Process

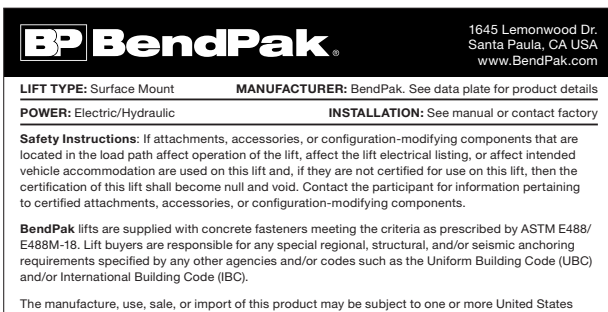
Finish: Matte Overlamine (No gloss)

Print Process: Offset Lithography - 200 line-screen or 300 p.p.i. for digital

Lamination: Clear laminate non-glare medium matte over-lamine (No gloss) for abrasion, chemical and ultra violet protection.

P/N 5905645 - NRTL_Lifting_Cap_Label_7K
 P/N 5905700 - NRTL_Lifting_Cap_Label_7500
 P/N 5905650 - NRTL_Lifting_Cap_Label_9k
 P/N 5905665 - NRTL_Lifting_Cap_Label_14k
 P/N 5905675 - NRTL_Lifting_Cap_Label_18k
 P/N 5905680 - NRTL_Lifting_Cap_Label_27k
 P/N 5905685 - NRTL_Lifting_Cap_Label_35K
 P/N 5905067 - NRTL_Lifting_Cap_Label_37K
 P/N 5905690 - NRTL_Lifting_Cap_Label_40K

F



Product_Data_Label_5905940-New.pdf: PN 5905940

Size: 4.5"W x 2.3"H

Material: 4 Mil. Permanent White Adhesive Vinyl

Ink: U.V. protected CMYK 2/C Process

Finish: Matte Overlamine (No gloss)

Print Process: Offset Lithography - 200 line-screen or 300 p.p.i. for digital

Lamination: Clear laminate non-glare medium matte over-lamine (No gloss) for abrasion, chemical and ultra violet protection.

G



ALI_Notice_Label.jpg

PN 5905377

Size: 3"W x 1.75"H

(Order Label from ALI)

IMPORTANT: Please use materials as instructed

4 Post Lifts Product Decal Positioning

H



Slipper_When_Wet_Label-5905138.pdf: PN 5905138

Size: 4.5"W x 2.5"H

Material: 4 Mil. Permanent White Adhesive Vinyl

Ink: U.V. protected CMYK 2/C Process

Finish: Matte Overlamine (No gloss)

Print Process: Offset Lithography - 200 line-screen or

300 p.p.i. for digital

Lamination: Clear laminate non-glare medium matte over-laminate (No gloss) for abrasion, chemical and ultra violet protection.

I



ALI Gold Label - MET C-US PN 5905654

****FOR ALI APPROVED LIFTS ONLY**

J

BP BendPak		Santa Paula, CA USA www.bendpak.com	
MODEL NUMBER			
DESCRIPTION			
LIFT CAPACITY		DATE CODE	
ROLLING JACK MAX CAP.		MAX PSI / BAR	
VOLTAGE		SERIAL NUMBER	
☐ 110-240V, 50-60 Hz, 1 Ph ☐ 208-240V, 50-60 Hz, 1 Ph ☐ 380-415V, 50-60 Hz, 3 Ph ☐ 208-440V, 50-60 Hz, 3 Ph			
		UPC	
DANGER! Disconnect Power Before Servicing WARRANTY VOID IF DATA PLATE IS REMOVED PN 5905953			

PN 5905953

2017_Serial_Tag-D.jpg:

Size: 3"W x 3"H

Material: 2 Mil. Matte Silver Polyester (Flex-PSE)

Print using thermal transfer printer with resin ribbon

Ink: 1 Color-Black

CE APPROVED LIFTS ONLY

K

BP BendPak		Santa Paula, CA USA www.bendpak.com	
MODEL NUMBER			
DESCRIPTION			
LIFT CAPACITY		DATE CODE	
ROLLING JACK MAX CAP.		MAX PSI / BAR	
VOLTAGE		SERIAL NUMBER	
☐ 110-240V, 50-60 Hz, 1 Ph ☐ 208-240V, 50-60 Hz, 1 Ph ☐ 380-415V, 50-60 Hz, 3 Ph ☐ 208-440V, 50-60 Hz, 3 Ph			
		UPC	
DANGER! Disconnect Power Before Servicing WARRANTY VOID IF DATA PLATE IS REMOVED PN 5905952			

PN 5905952

2017_Serial_Tag-C.jpg:

Size: 3"W x 3"H

Material: 2 Mil. Matte Silver Polyester (Flex-PSE)

Print using thermal transfer printer with resin ribbon

Ink: 1 Color-Black

NON-CE APPROVED LIFTS ONLY

IMPORTANT: Please use materials as instructed

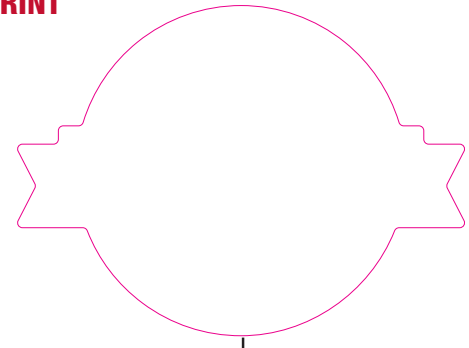
4 Post Lifts Product Decal Positioning

L



GRAY DOES NOT PRINT

PN 5906044



DIE-CUT LINE
DOES NOT PRINT

American_Owned_50_Years_Logo.pdf:

Trim: 4"W x 3"H

Material: 4 Mil. Permanent White Adhesive Vinyl

Ink: U.V. protected CMYK 4/C Process

Finish: Matte Overlamine (No Gloss)

Print Process: Offset Lithography - 200 line-screen or 300 p.p.i. for digital

Lamination: Clear Laminate non-glare medium matte over laminate for abrasion, chemical, and ultra violet protection

M

CALIFORNIA PROPOSITION 65



WARNING! This product can expose you to chemicals including styrene and vinyl chloride which are on the list of over 900 chemicals identified by the State of California to cause cancer, birth defects or reproductive harm. ALWAYS use this product in accordance with the manufacturer's instructions.

For more information, go to
www.p65warnings.ca.gov.

PN 5905775

Prop_65_Label.pdf:

Size: 1.5"W x 1.5"H

Material: 4 Mil. Permanent White Adhesive Vinyl

Ink: U.V. protected CMYK 2/C Process

Finish: Matte Overlamine (No gloss)

Print Process: Offset Lithography - 200 line-screen or 300 p.p.i. for digital

Lamination: Clear laminate non-glare medium matte over-lamine (No gloss) for abrasion, chemical and ultra violet protection.

PN 5905775

IMPORTANT: Please use materials as instructed

4 Post Lifts Product Decal Positioning

**SEE NEXT PAGE
FOR LABEL
PLACEMENT HEIGHT**

****FOR ALL APPROVED
LIFTS ONLY**

M, E, C

**Back of Post
(Top to Bottom)**

**G, D, I,
J or K, F**

**Front of Post
(Top to Bottom)**

B
Side of Post

L

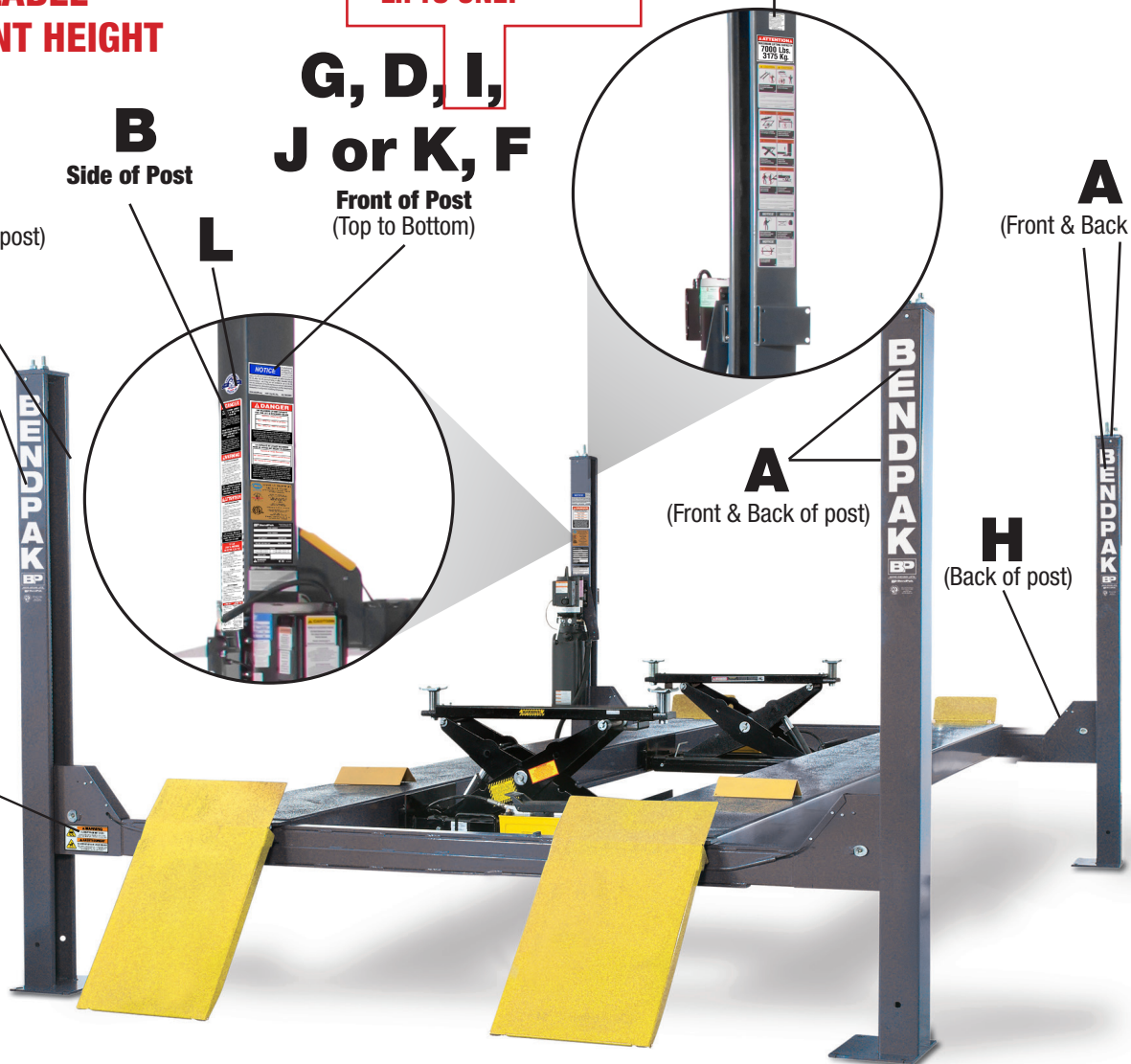
A
(Front & Back of post)

A
(Front & Back of post)

A
(Front & Back of post)

H
(Back of post)

H
(Also on other side of lift)



4 Post Lifts Product Decal Positioning

Views of Powerside Post

BACK OF POST

SIDE OF POST

FRONT OF POST

