



# Operation and Safety Manual



# XR1255

Cummins Tier 4F

PN 24907-003 Rev D  
February 2021

Pre-delivery Inspection Report must be completed upon placing unit in service. Please use QR link or visit [www.xmfg.com/warranty/pre-delivery-inspection-report](http://www.xmfg.com/warranty/pre-delivery-inspection-report) to register online.



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**Warning**



Wear appropriate protective clothing. Personal protective equipment can include, but is not limited to hardhat, gloves, footwear, safety glasses or goggles, and hearing protection. Make sure clothing is snug and properly belted. **DO NOT** wear loose clothing, jewelry, watches, or anything that can catch on forklift controls, moving parts, etc. Failure to wear the proper protective clothing could result in death or serious injury.

**Before Starting Forklift**

**Warning**



Keep the Operation and Safety Manual on the forklift at all times. Contact Xtreme Manufacturing for replacement manuals.



Clearly define responsibilities and procedures for operating the forklift and all attachments. **DO NOT** proceed until you seek expert assistance from a qualified person if any doubt or question arises about the correct or safe methods for operating the forklift.



To avoid death or serious injury, carefully read and understand all instructions before operating the forklift. **DO NOT** operate, modify, repair, or maintain the forklift unless you read and understand the instructions and warnings in this and all other applicable manuals and technical publications. Follow all State and Federal health and safety laws and/or local regulations.



Consult Safety Data Sheets (SDS) for chemical hazards and first aid instructions. SDS should be available from the manufacturer or supplier of the fluid.

**Warning**



Perform a pre-operation inspection and functional tests at the beginning of each work shift. Perform the pre-operation inspection first. **DO NOT** perform the pre-operation inspection with the engine running or hot.

Contact with moving or heated parts could cause death or serious injury.



Perform the pre-operation inspection and functional tests in an open area and away from any other obstacles or equipment. Inspections and functional tests may require assistance. Keep the assistant visible and a safe distance from the forklift to prevent death or serious injury.

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Become familiar with all safety and hazard labels, regulations, and procedures. Make sure all proper safety and hazard labels are attached to the forklift and remain legible.



A brief description of controls, indicators, and instruments is provided as a convenience for the operator. These descriptions **DO NOT** provide complete operation instructions. Read and understand the entire manual to prevent death, serious injury, or equipment damage.



Keep fingers and feet away from moving parts or pinch points to prevent pinching or crushing. **DO NOT** allow anyone between the tires and the forklift frame while operating the forklift. Doing so can result in death or serious injury.



Always check the condition of the seat belt and mounting hardware before operating the forklift. If the seat belt or mounting hardware is defective, it may not properly restrain the operator, resulting in death or serious injury.

- **DO NOT** operate the forklift until the seat belt or mounting hardware is replaced, if worn or damaged.
- The seat belt **MUST** be worn while operating the forklift. Failure to wear the seat belt could result in death or serious injury.

**Caution**



Use caution when operating the forklift during storms or strong winds.







Fig 38. Regeneration Menu

**FAULT CONDITION POP-UPS**

A fault condition may trigger a pop-up dialog box describing the nature of the fault. A soft button may need to be pressed to acknowledge the fault.

**BACKUP CAMERA (OPTIONAL)**

The display automatically changes to backup camera when the transmission is in REVERSE. When the transmission is in NEUTRAL or FORWARD, the display can be switched from the GAUGE DISPLAY to the BACKUP CAMERA by using the select button. Press it again to return to the GAUGE DISPLAY.

**Steering Select Switch**

**Warning**

**DO NOT** change steering modes until the forklift slows or comes to a complete stop. Align all four (4) wheels perpendicular to the axle, before changing steering mode. Changing steering modes at higher travel speeds can make the forklift unstable, and cause a loss of control, which could result in death, serious injury, or property damage.

The Steering Select switch has three (3) steering positions: Crab, Two Wheel Steering (2W), and Four Wheel Steering (4W).



Figure 39. Steering Select and 2-Wheel Rear Switches

**Outrigger Control**

The outrigger toggle switches are used to lower and raise the outriggers. The outrigger indicators illuminate when the outriggers are fully extended and on the ground (Figure 29).



Figure 40. Outrigger Toggle Switches



Figure 41. Outriggers Down

Once outriggers are fully extended, the transmission is disengaged, and the frame sway is locked. Frame sway lock can be overridden with the frame sway override switch.



Figure 42. Outriggers Up

**Before Starting Forklift**

**Warning**

Failure to use proper safety procedures when mounting and dismounting the forklift could result in death or serious injury.

- Keep steps clear of dirt, mud, snow, ice, debris, and other hazards.



Face the forklift for mounting or dismounting. Use hand holds and steps to maintain three (3) points of contact at all times, either both hands and one foot or both feet and one hand.

- DO NOT use the controls, steering wheel, or foot pedals as hand holds or steps. Avoid accidentally engaging or disengaging a control.



DO NOT jump from the forklift. Clothing can get caught on pedals, levers, or other protruding parts. Landing on uneven surfaces could result in death or serious personal injury.

1. Master battery disconnect on.
2. Use safe mounting/dismounting procedures to enter the operator cab.
3. Adjust the operator seat for position and comfort. (Refer to Seat Adjustment section in this manual)
4. Adjust mirrors (this may require assistance).
5. Adjust the side console control panel.
6. Fasten seat belt.
7. Make sure the travel select lever is set to NEUTRAL (N) and the Parking Brake is ON (engaged).

**NOTE:** The engine will only start when the travel select lever is in NEUTRAL (N) and the Parking Brake switch is ON (engaged).

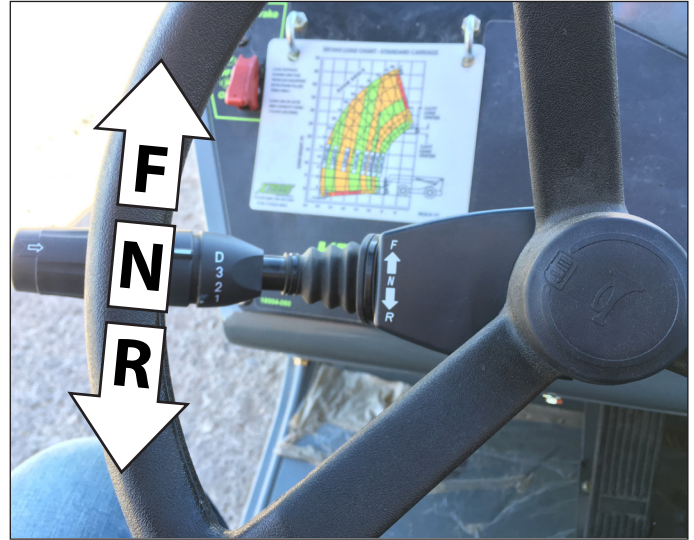


Figure 61. Travel Select Lever Must Be in NEUTRAL (N) to Start the Forklift

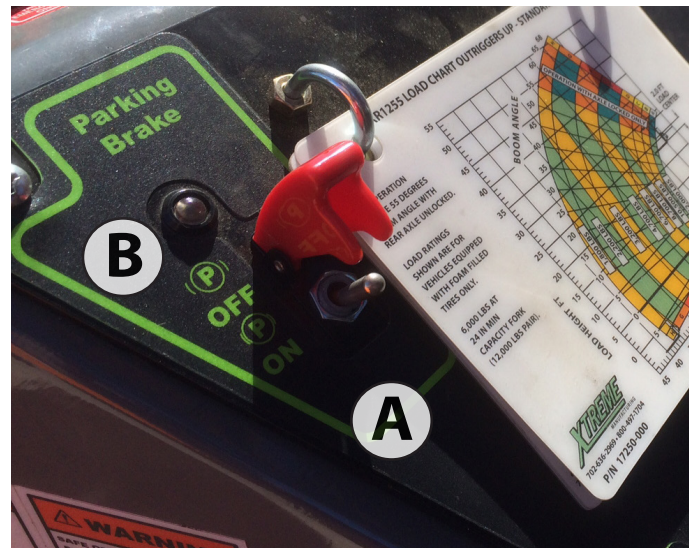


Figure 62. Parking Brake Switch (A) Must Be ON (Engaged) to Start the Forklift.

The Parking Brake switch (A) has two (2) positions: ON and OFF.

To move the forks outward, press the top button (1) on the front control handle, or move the auxiliary handle (3) to the left. To move the forks inward, press the lower button (2) on the front control handle, or move the auxiliary handle (3) to the right (figure 68).

**Warning**



Hydraulic attachments have a maximum hydraulic pressure rating. Failure to make sure the attachment is equipped with a pressure reducing valve, or is rated to be equal or greater than 3,500 psi, which is the maximum pressure of the forklift auxiliary hydraulic system at the quick-disconnect couplers, could result in death or serious injury.

When the auxiliary attachment control lever is moved right or left it activates hydraulic pressure through the quick attach couplers (A) and (B) to move the carriage.

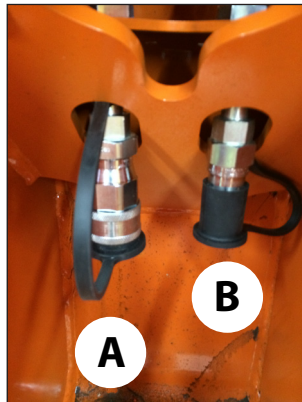


Figure 69. Quick Attach Couplers For Hydraulic Systems. (A) Female Coupler. (B) Male Coupler.

**Quick Attach System**

This forklift includes a quick attach system that allows for easy attachment changes. Perform attachment connection and removal procedures on level ground.

**Attachment Connection**

**Warning**



Improper connection of an auxiliary attachment can result in death or serious injury. Attachments not locked into place could become unstable and fall on the operator or other personnel near the forklift, which could result in death or serious injury.

- Make sure attachment locking devices are always in place.
  - **DO NOT** operate the forklift until you have positive indication that the carriage attachment is fully engaged.
1. Position the forklift directly behind the attachment. **NOTE:** Allow enough distance to extend the boom approximately 18 to 20 inches.
  2. Tilt the quick attach adapter forward.
  3. Extend the boom and/or drive the forklift forward until the pivot pins (A) are below and between the two (2) attachment hooks (B).

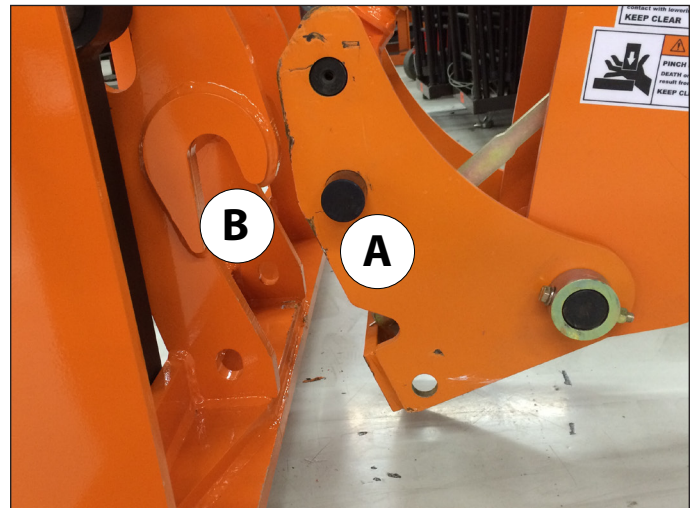


Figure 70. Drive Forklift Forward to Align Pivot Pins (A) with Attachment Hooks (B)

4. Raise the boom until pivot pins (A) have seated fully in attachment hooks (B).

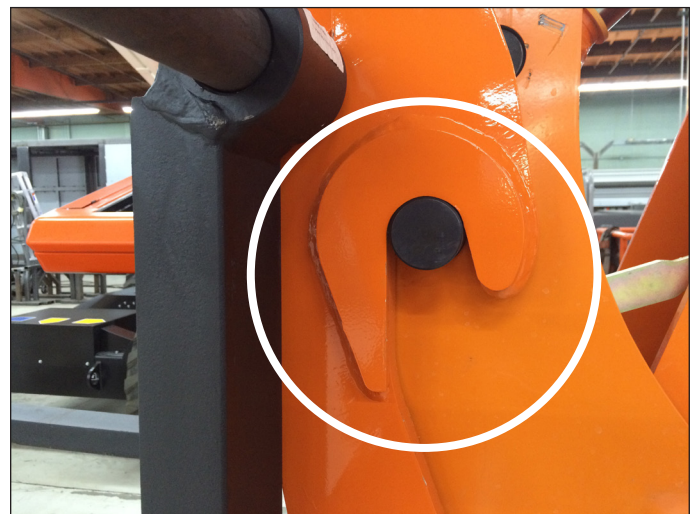


Figure 71. Raise Boom Until Pivot Pins (A) Are Fully Seated in Attachment Hooks (B)

## Preventive Maintenance

## Establishing a Maintenance Program

The hour meter displays elapsed engine operating hours and has a total readout of 9,999.9 hours. Use the hour meter and the schedules contained in this section to establish a comprehensive preventive maintenance program.

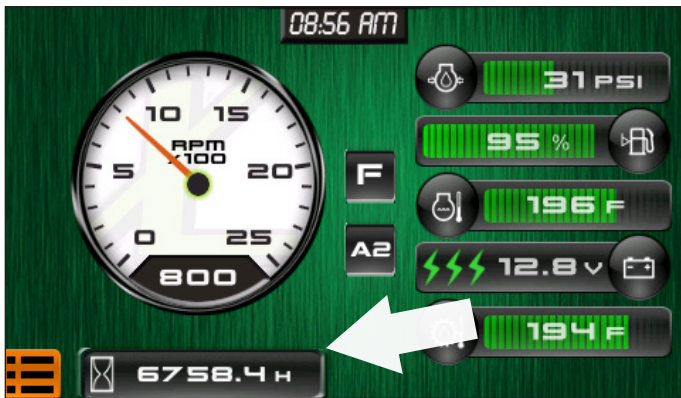


Figure 91. Hour Meter

## Maintenance Schedule

## Every Day or 8 Hours of Operation

See **Pre-Operation Inspection Checklist**

## After First 50 Hours of Operation

- Change engine oil and filters
- Check air filter (replace if necessary)
- Replace fuel filter and prefilter
- Check engine hoses and connections for leaks, damage, and tightness
- Check radiator hoses for leaks, damage, and tightness
- Check electrical cables, leads, and connections for damage and tightness
- Check for oil and coolant leaks

- Check condition and tension of drive belts (use tension meter to check belt tension)
- Lubricate front and rear drive shaft grease fittings
- Lubricate outrigger pivot point grease fittings
- Lubricate front and rear axle grease fittings
- Change differential oil
- Change wheel-end oil
- Check wheel lug nuts torqued to 515-570 Nm (380-420 ft lbs)
- Lubricate boom pivot point grease fittings
- Lubricate front and rear axle cylinder pivot point grease fittings
- Lubricate boom roller grease fittings and chains
- Replace hydraulic return line filter
- Replace transmission filter and top off fluid, as required

## After Every 50 Hours of Operation

- Lubricate boom pivot point grease fittings
- Lubricate front and rear axle cylinder pivot point grease fittings
- Lubricate outrigger pivot point grease fittings

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