



Technical Bulletin

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35C Carton Clamp Replacement Backrest Tubes 647073 Installation Instructions

MODELS: 35C Carton Clamps

Replacement Backrest Tubes 647073 are available from the Cascade Parts Depot in Springfield, Ohio (513/322-1199). Install the new Backrest Tubes as follows:

- ① Remove the defective backrest tube(s) from the arm. Grind the area smooth.
- ② Clean all surfaces to be welded. Remove paint, oil, grease and other contaminants.
- ③ Locate the new backrest tube(s) on the arm. Use the dimensions shown on the back of this sheet.

NOTE: If the short tube(s) are being replaced, saw the new tube(s) to match the dimension shown on the back of this sheet.

- ④ Protect all adjacent components from weld splatter.
- ⑤ Use AWS E-7018 electrodes to weld the tubes in place. Electrodes must be in good condition. Bake as required to remove all moisture per manufacturers procedures.
- ⑥ Weld around the backrest tube with a fillet sized per the detail drawing, holding a close arc.
- ⑦ Clean the weld area and repaint with Cascade paint P/N 668209.

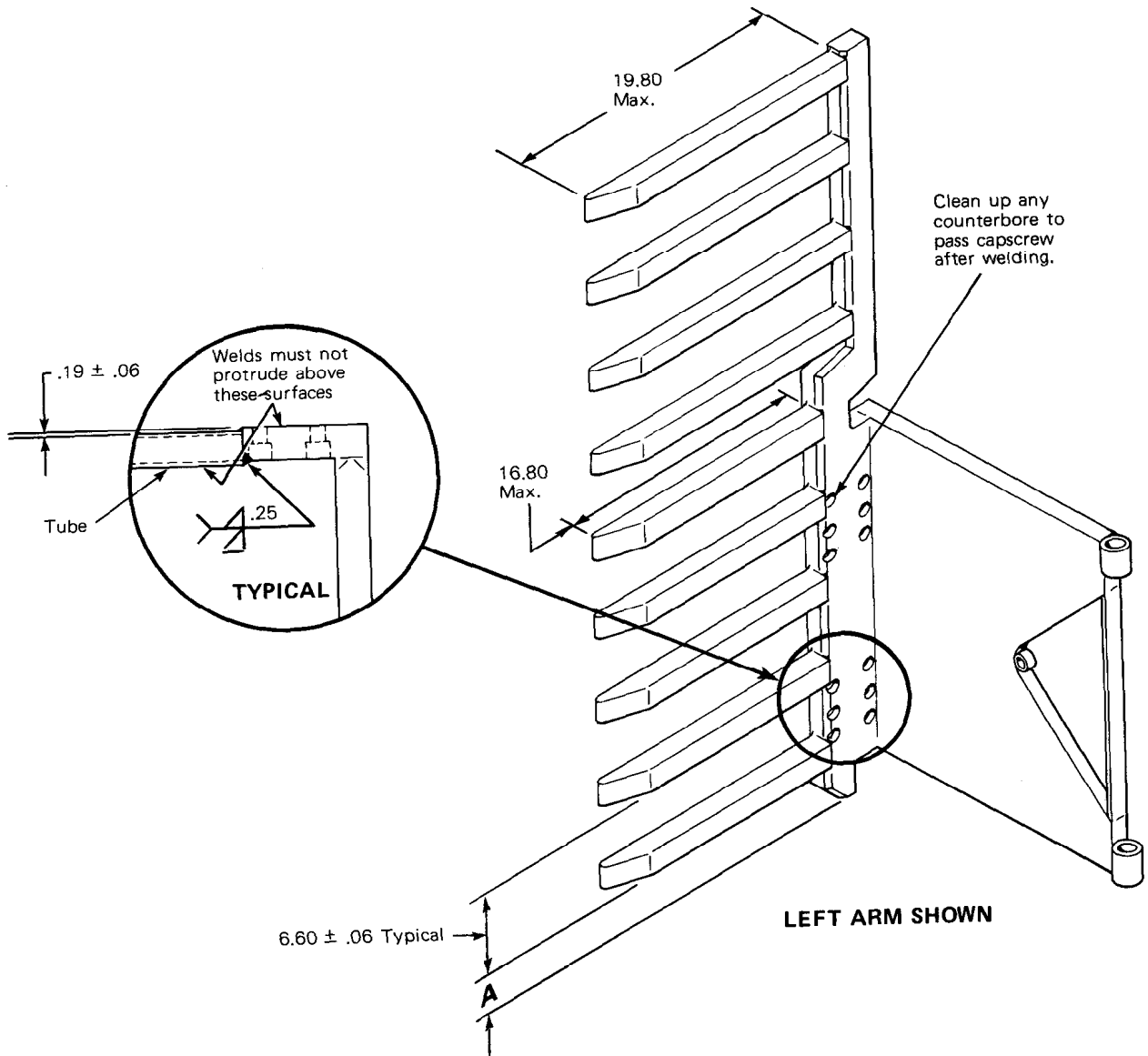
Part Number 674448

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Dial Directline
800 227-2233
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DIMENSION A	
RIGHT ARM	LEFT ARM
2.50 ± .06	4.70 ± .06