



Technical Bulletin

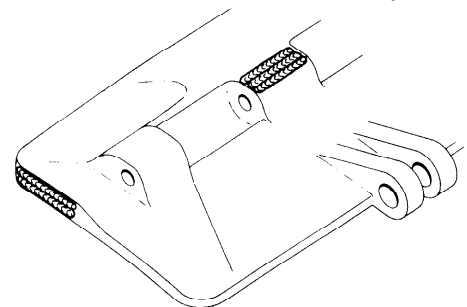
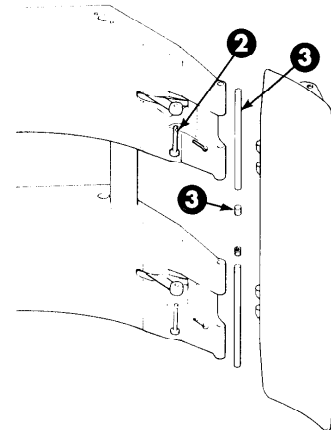
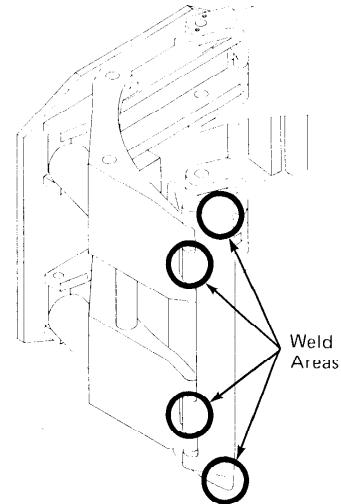
Paper Roll Clamp Contact Pad Hard Surface Facing

This sheet describes the procedures and processes to apply hard surface facing to the contact pad wear surfaces. Kit part no. 200639 includes 5 lbs. of ARS-316 (stainless) welding rod which achieves a hardness of 60C Rockwell. Kit part no. 200636 includes 5 lbs. of AR-81 (copper) welding rod which achieves a hardness of 65C Rockwell.



WARNING: Welding must be performed by a qualified welder familiar with this type of fabrication. Always weld in a well ventilated area. Protect yourself and others from arc rays, fumes and gases.

- 1 Rotate the clamp to the vertical roll handling position. Lower the clamp to position the contact pad lightly on the ground. Do not place the full weight of the attachment on the contact pad.
- 2 Remove the clevis pins fastening the links to the contact pads.
- 3 Remove the pipe plugs and pivot pins from the arm. Remove the contact pad.
- 4 Clean all surfaces to be welded. Remove paint, rust, grease, scale and other contaminants.
- 5 Preheat to the weld areas to 600° F with a rose bud torch. Do not weld in a drafty area.
- 6 Attach the ground wire to the contact pad. Use a DC straight amperage setting of 125 to 175+. Hold the rod at a 35-40° angle. Weld the first pass using a 1/4 to 1/2 in. arc length. Let the welds slow cool. The welds should be flat and smooth. If the weld passes are turning out uneven, additional preheat may be required.
- 7 You may weld a second pass over the prior welds if desired.
- 8 Preheat the first pass welds to 600° F. Apply a small amount of Harris Stay-Silv Flux or Peterson Flux No. 1 Blue to the first pass welds.
- 9 Clean and repaint the weld areas. Reassemble the arm.



NOTE: This information should not be interpreted as the basis for warranty claims unless so designated.
Part No. 200481

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