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60F Paper Roll Clamp Frame and Cylinder Spacer Kit 681775

This sheet provides instructions for the installation of Spacer Kit 681775. The spacers are a product improvement designed to extend the service life of the frame, cylinder bushings and pivot pins. Included in the service kit are spacers to service either a Fixed or Swing Frame Clamp.

FIXED FRAME CLAMPS

Six of the spacers included in the kit are required for use on Swing Frame Clamps only. Discard the four 1.55 in. ID X 4.60 in. long spacers and two of the 1.31 in. ID X 4.70 in. long spacers.

- ① Remove the clamp cylinders from the attachment as described in Section 1.1.
- ② Install two additional bushings to each cylinder base as described in Section 1.2.
- ③ Install a spacer to each arm pivot pin as described in Section 1.3.

SWING FRAME CLAMPS

Four of the spacers included in the kit are required for use on Fixed Frame Clamps only. Discard the four 1.55 in. ID X 5.85 in. long spacers.

- ① Remove the clamp cylinders from the attachment as described in Section 1.1.
- ② Install two additional bushings to each cylinder base as described in Section 1.2.
- ③ Install a spacer to each arm pivot pin as described in Section 1.3.
- ④ Install spacers to the swing frame pins as described in Section 1.4.

NOTE: This information should not be interpreted as the basis for warranty claims unless so designated.
Part No. 681771

cascade[®]

For Technical Assistance . . .

Call: 1-800-CASCADE or 503-669-6300

OR

Write: Cascade Corporation, P.O. Box 20187, Portland, OR 97220

To Order Parts . . .

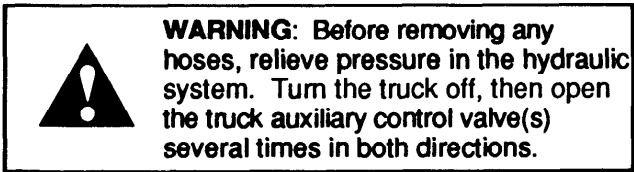
Call: 513-322-1199

OR

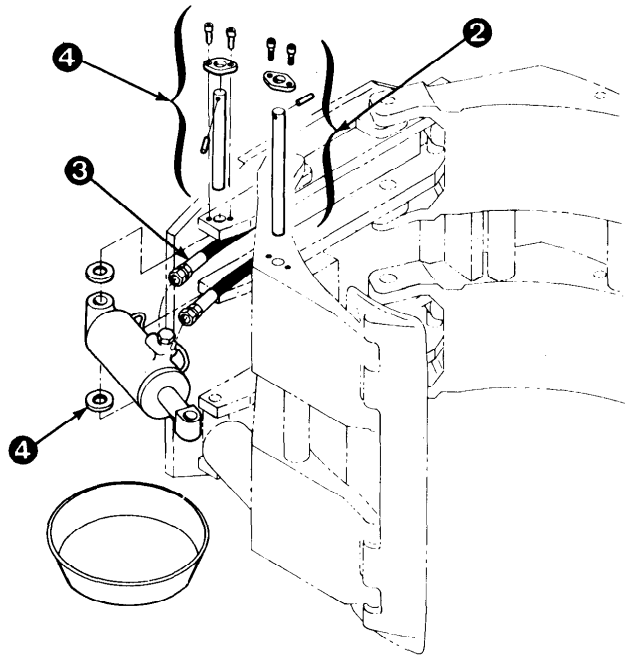
Write: Cascade Corporation, P.O. Box 360, Springfield, OH 45505

1.1 Clamp Cylinder Removal

- ❶ Rotate the clamp to the vertical roll handling position. Close the arms.
- ❷ Remove the cylinder rod anchor pins. For reassembly, tighten the pin keeper capscrews to a torque of 30-35 ft.-lbs. (40-48 Nm).



- ❸ Retract the cylinder rods. Place a drip pan under the cylinders. Disconnect the hoses from the cylinder ports. Plug the hose ends and tag for reassembly.
- ❹ Remove the cylinder base anchor pins. Note the locations of the shims. For reassembly, tighten the pin keeper capscrews to a torque of 30-35 ft.-lbs. (40-48 Nm).



1.2 Cylinder Bushing Installation

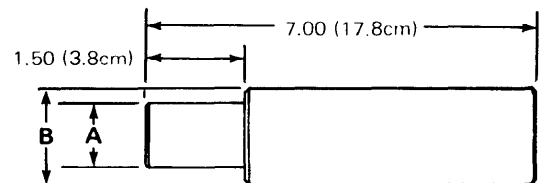
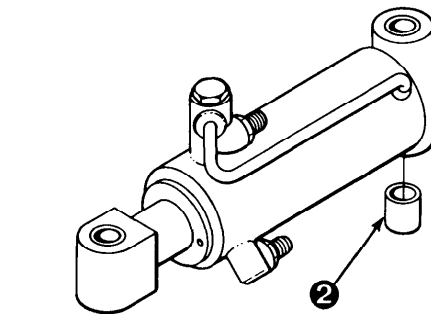
- ❶ Remove the cylinder from the clamp as described in Section 1.1.
- ❷ Install a new bushing to each side of the cylinder base end using a bushing driver. Drive each outer bushing to the center, then install the new bushings. Both outer bushings must be flush with the outer surface.

- The bushing driver (part no. 678588) can be ordered from the Cascade Parts Depot (see cover page for phone and address) or can be fabricated using the dimensions shown.

CAUTION: The bushings may be damaged if installed without a bushing driver.

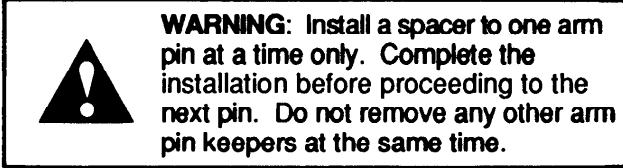
Dimension A	Dimension B
1.23 in. (31.2mm) dia.	1.48 in. (37.6mm) dia.

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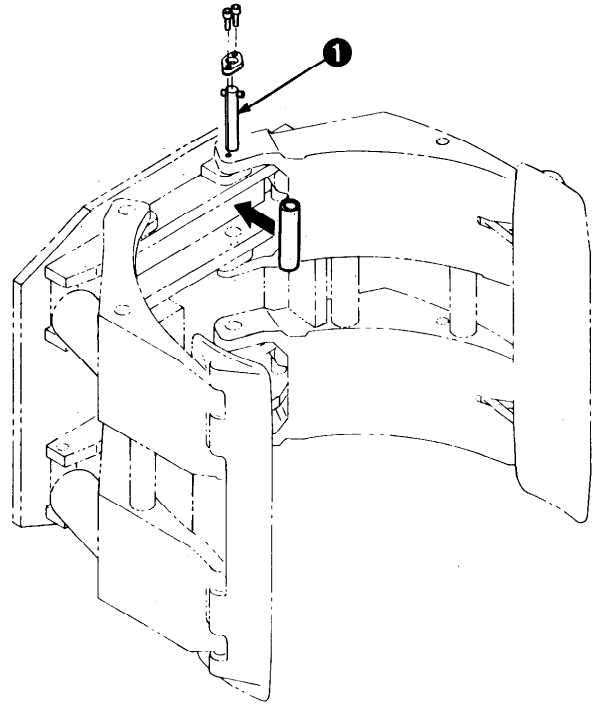


Bushing Driver

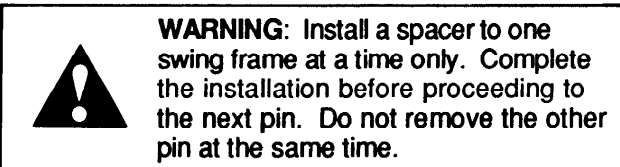
1.3 Arm Spacer Installation



- 1 Remove a pin keeper and pull the arm pivot pin out **only far enough** to install the spacer between the frame members. Reinstall the pin. Tighten the pin keeper capscrews to a torque of 30-35 ft.-lbs. (40-48 Nm).
- 2 Repeat step 1 for the other three arm pins.



1.4 Swing Frame Spacer Installation



- 1 Lower the attachment to the floor.
- 2 Remove a pin keeper and pull the swing frame pivot pin out **only far enough** to install the spacer between the casting members. Reinstall the pin. Tighten the pin keeper capscrews to a torque of 30-35 ft.-lbs. (40-48 Nm).
- 2 Repeat step 1 for the other swing frame pin.

