



Installation Instructions

Bearing Assembly Capscrew Kits for Rotating Attachments

Every 2000 hours or if any capscrews were found to rotate, are loose or found broken during the Bearing Assembly 500 hour periodic maintenance inspection, perform the following procedures for the bearing assembly capscrews.



WARNING: The baseplate bearing assembly capscrews above the upper mounting hooks and three faceplate capscrews must be checked every 500 hours. A complete capscrew inspection is required every 2000 hours. Failure to keep the capscrews tightened can result in serious injury.

Capscrew Replacement

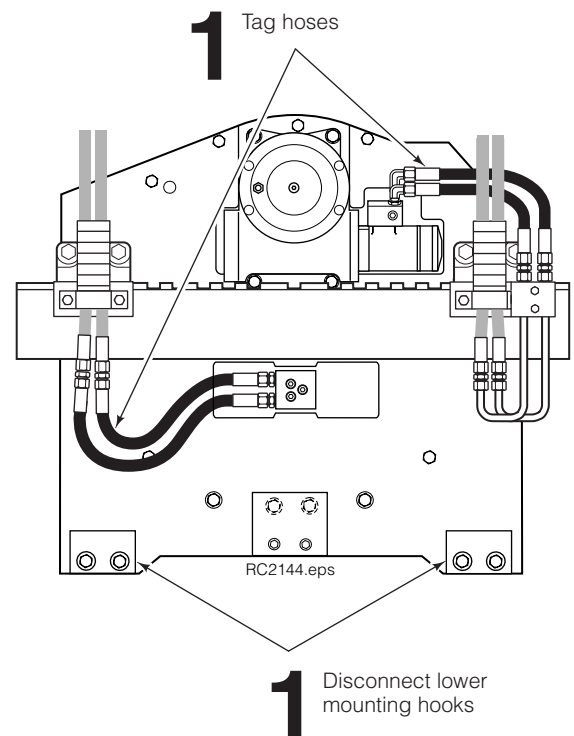


WARNING: Before removing hydraulic lines or components, relieve pressure in the hydraulic system. Turn truck off and open the truck auxiliary control valve(s) several times in both directions.

1 Clamps – Open the arms to frame width. Disconnect the lower mounting hooks. Disconnect and tag the supply hoses.

Paper Roll Clamps – Fully open the arms. Disconnect the lower mounting hooks. Disconnect and tag the supply hoses.

Rotators – Remove forks. Disconnect the lower mounting hooks. Disconnect and tag the supply hoses.



NOTE: This information should not be interpreted as the basis for warranty claims unless so designated.

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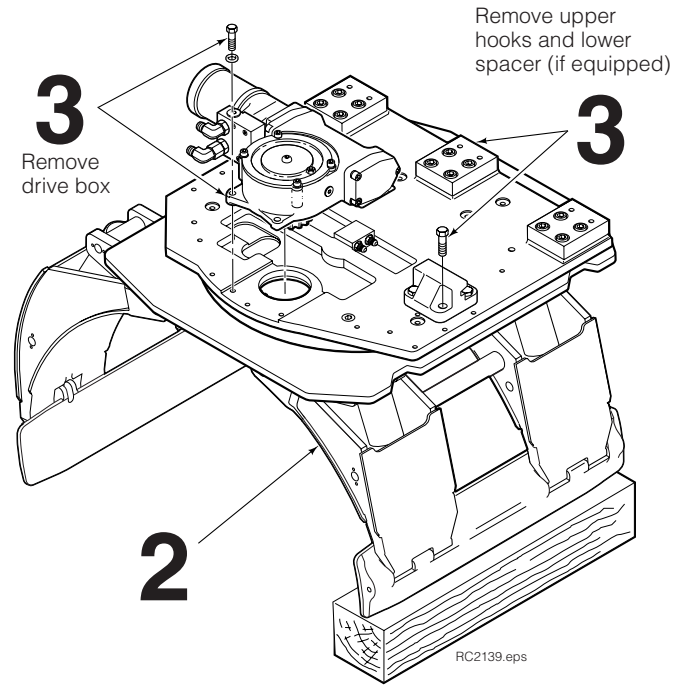
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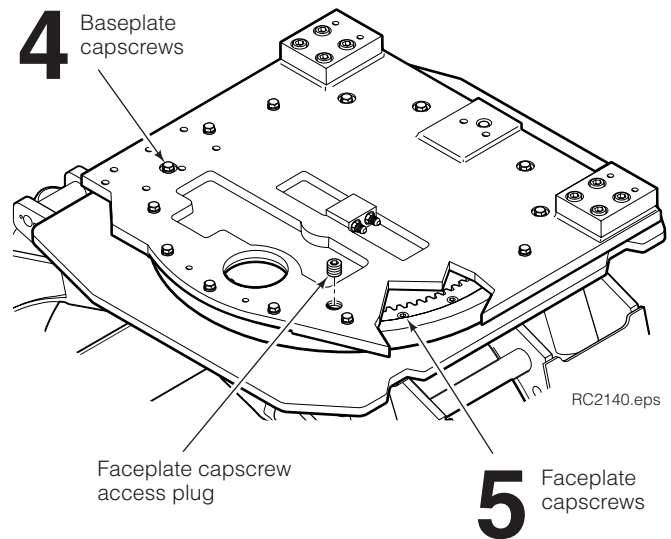


WARNING: Check the attachment weight (located on the nameplate) to make sure the overhead hoist and chains or straps are at least the rated capacity of the attachment.

- 2 Remove the attachment from the truck. Position the attachment face down on the floor, stack of pallets or work bench with the baseplate approximately parallel to the floor.
- 3 Remove the drive box, upper mounting hooks and lower spacer (if equipped).



- 4 Remove all baseplate bearing assembly capscrews and lockwashers (if equipped). Remove the baseplate with an overhead hoist.



- 5 Remove all faceplate bearing assembly capscrews. Remove the bearing assembly with an overhead hoist.
- 6 Thoroughly clean bearing assembly and faceplate threaded holes with a tap. See the thread sizes in **Table 1 and 2**. Threads must be clean and dry for the new Loctite to cure properly.

Table 1 – Baseplate Capscrews

Model	Torque ft.-lbs. (Nm)	Threads
Paper Roll Clamps		
25D–120D	75 (102)	.50 in. or M12
25F	120 (160)	M16
25H–33H	100 (135)	M12
38F	75 (100) ◆	M12
45F–66F	75 (100)	.50 in.
77F	75 (100) ◆	.50 in.
60G–66G	75 (100) ◆	M12
72G	75 (100)	.50 in.
90F, 90FX	75 (100) ◆	M12
90F, 100F Dual Drive	75 (100)	M12
100F, 100FX	75 (100)	M12
120F–150F	220 (300) ◆	.75 in.
140D–150D	75 (100) ◆	.75 in.
160F	220 (300) ◆	M20
195F	270 (365) ◆	M20
Revolving Clamps		
35D–70D	75 (100)	.50 in.
140D	75 (100) ◆	.75 in.
200D	370 (365) ◆	M20
Rotators		
30E	75 (100) ◆	M16
30G–40G	38 (52)	M10
40D–65D	75 (100)	.50 in.
45G–100G	77 (105)	M12
80D	75 (100) ◆	M12
100D	75 (100)	.50 in.
120D, 150D	220 (300) ◆	M12
200D	270 (365) ◆	M20
300D	270 (365) ◆	M20
400D	280 (365) ◆	M20

◆ Equipped with lockwashers.

Table 2 – Faceplate Capscrews

Model	Torque ft.-lbs. (Nm)	Threads
Paper Roll Clamps		
25D–120D	75 (102)	.50 in. or M12
25F	120 (160)	M16
25H–33H	100 (135)	M12
38F	75 (100) ◆	M12
45F–66F	75 (100)	.50 in.
77F	75 (100) ◆	.50 in.
60G–66G	75 (100) ◆	M12
72G	75 (100)	.50 in.
90F, 90FX	75 (100) ◆	M12
90F, 100F Dual Drive	75 (100)	M12
100F, 100FX	75 (100)	M12
120F–150F	220 (300) ◆	.75 in.
140D–150D	75 (100) ◆	.75 in.
160F	220 (300) ◆	M20
195F	270 (365) ◆	M20
Revolving Clamps		
35D–70D	75 (100)	.50 in.
140D	75 (100) ◆	.75 in.
200D	370 (365) ◆	M20
Rotators		
30E	75 (100) ◆	M16
30G–40G	47 (63)	M10
40D–65D	75 (100)	.50 in.
45G–100G	81 (110)	M12
80D	75 (100) ◆	M12
100D	75 (100)	.50 in.
120D, 150D	220 (300) ◆	M12
200D	270 (365) ◆	M20
300D	270 (365) ◆	M20
400D	280 (365) ◆	M20

◆ Equipped with lockwashers.

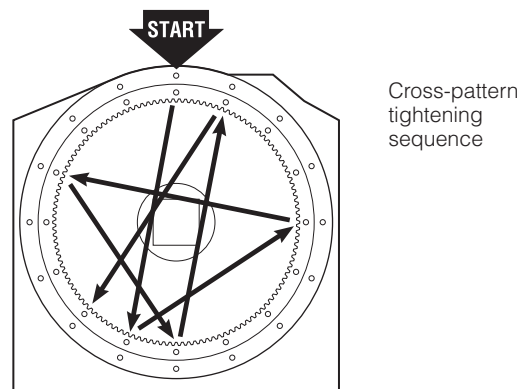
7 Place the bearing assembly on the faceplate. Install **all new** faceplate capscrews. See Service Kits listed on page 4. Apply Loctite 242 (blue) to the threads.

H-Series Roll Clamps – Apply loctite 262 (purple) to threads.

8 Tighten all faceplate capscrews to 50% of the final torque value shown in Table 1. Use the cross-pattern tightening sequence. **Double torque the capscrews.** Tighten all capscrews to the full torque value. Loosen 1/2 turn, then immediately tighten to the full torque value using the cross-pattern tightening sequence.

9 Place the baseplate on the bearing assembly. Install **all new** baseplate capscrews. Short baseplate capscrews go in the counterbore holes. See Service Kits listed on page 4. Apply Loctite 242 (blue) to the threads.

H-Series Roll Clamps – Apply loctite 262 (purple) to threads **above** upper hooks



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WARNING: Install the short baseplate capscrews in the baseplate counterbore holes only. Use lockwashers if supplied in kit.

- 10** Tighten all baseplate capscrews to 50% of the final torque value shown in **Table 2**. Use the cross-pattern tightening sequence. **Double torque the capscrews.** Tighten all capscrews to the full torque value. Loosen 1/2 turn, then immediately tighten to the full torque value using the cross-pattern tightening sequence.

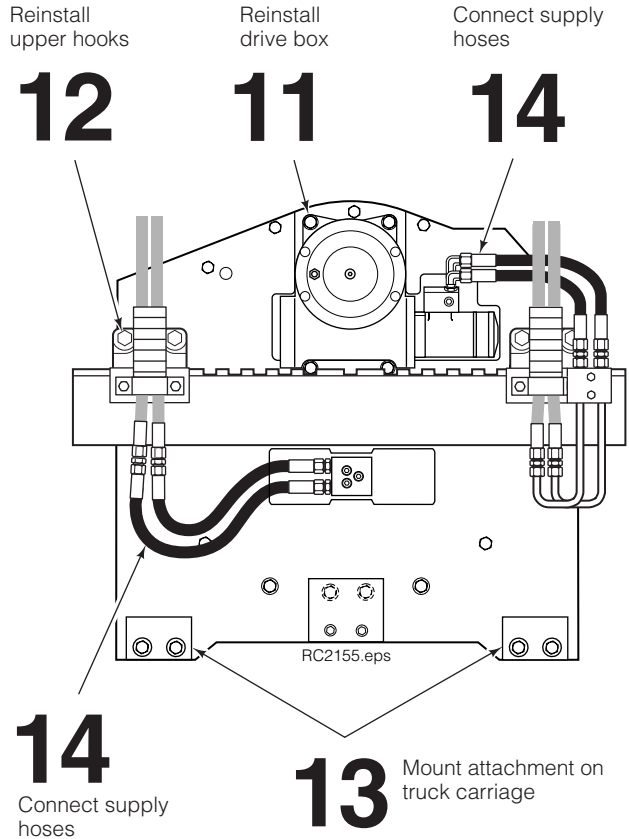
H-Series Roll Clamps – Tighten capscrews **above upper hooks** to 100 ft.-lbs. (135 Nm). Capscrews **at hooks and below** should be tightened to 77 ft.-lbs. (105 Nm).

- 11** Reinstall the drive box. Tighten the capscrews to a torque of 80 ft.-lbs. (108 Nm).
- 12** Reinstall the upper hooks. Tighten the capscrews to a torque value shown in **Table 3**.
- 13** Mount the attachment on the truck carriage. Tighten the lower hooks to a torque shown in **Table 3**.
- 14** Connect the supply hoses to the attachment fittings.
- 15** Test the attachment functions before returning the truck to operational service.

Table 3 – Hook Capscrews

Model	Upper Hook(s) ft.-lbs. (Nm)	Lower Hooks ft.-lbs. (Nm)
Paper Roll Clamps		
60G–66G CL II/III	122 (165)	122 (165)
72G CL III	122 (165)	122 (165)
72G CL IV	235 (320)	235 (320)
25H–33H	122 (165)	122 (165)
33H	235 (320)	235 (320)
Rotators		
30G–40G	165 (225) ◆	122 (165)
45G–55G CL II	122 (165) ◆	122 (165)
45G–65G CL III	122 (165) ◆	122 (165) ◆
80G–100G CL III	122 (165)	122 (165)
80G–100G CL IV	235 (320)	235 (320)
Other Models		
CL II/III	110 (150)	110 (150)
CL IV up to 8900 lbs. capacity	195 (265)	195 (265)
CL IV above 9000 lbs. capacity	265 (360)	265 (360)

◆ Loctite 242



Capscrew Service Kits

	Baseplate Capscrew Service Kit	Faceplate Capscrew Service Kit
Paper Roll Clamps		
25D	6055154	6055155
25F	6052716	6052717
25H	6095219	6095219
30H	6095219	6095219
33H	6095293	6095293
35D	6052721	6052722
38F	6052719	6052720
40D	6052721	6052722
45F	6052721	6052722
50D	6052721	6052722
55D	6052721	6052722
60D	6055156	6052788
60F	6052727	6052726
60G	6052780	6052781
65D	6052721	6052722
66D	6055157	6052788
66F	6055143	6055145
66G	6052774	6052775
70D	6055158	6055159
72G	6052778	6052779
77F	6052728	6052779
80D	6052774	6052801
90F	6052731	6052730
90FX	6052777	6052776
90F Dual Drive	6052731	6052730
100D	6052789	6052788
100F	6052731	6052730
100FX	6052777	6052776
100F Dual Drive	6052731	6052730
120D	6052731	6052799
120F	6052761	6052763
130F	6052761	6052763
150D	6052761	6052763
150F	6052764	6052765
160F	6052773	6052770
195F	6052773	6052770
Revolving Clamps		
35D	6052721	6052722
40D	6052721	6052722
50D	6052721	6052722
70D	6052789	6052788
140D	6052761	6052763
200D	6052773	6052770
Rotators		
30E	6052716	6052717
30G	6095842	6095846
40D	6052721	6052722
40G	6095842	6095846
45G – CL II	6059344	6059344
45G – CI III	6083302	6083302
55D	6052721	6052722
55G	6058580	6052781
65D	6052721	6052722
65G	6058580	6052781
80D	6052774	6052775
80G	6076302	6052781
100D	6052728	6052779
100G	6058580	6052781
120D	6052731	6052730
150D	6052761	6052763
200D	6052773	6052770
220D	6052773	6052770
300D	6055146	6055147
400D	6055149	6055147

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