



# Installation Instructions

## D-Series Clamp Revolving Connection Service Kits 209024 and 209026

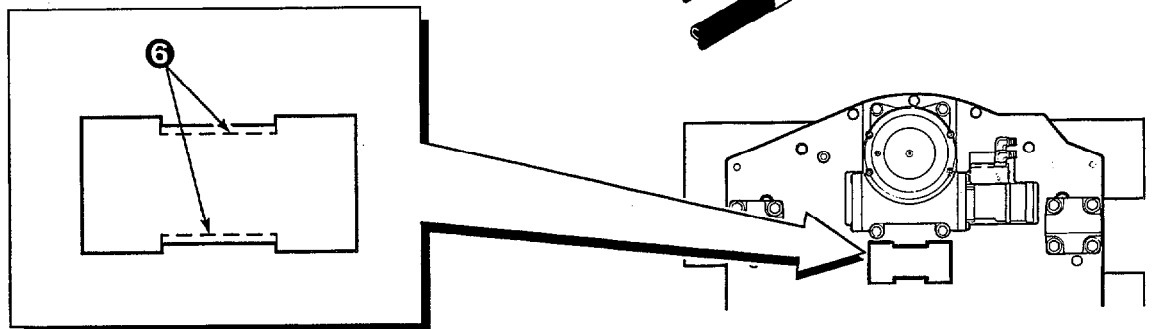
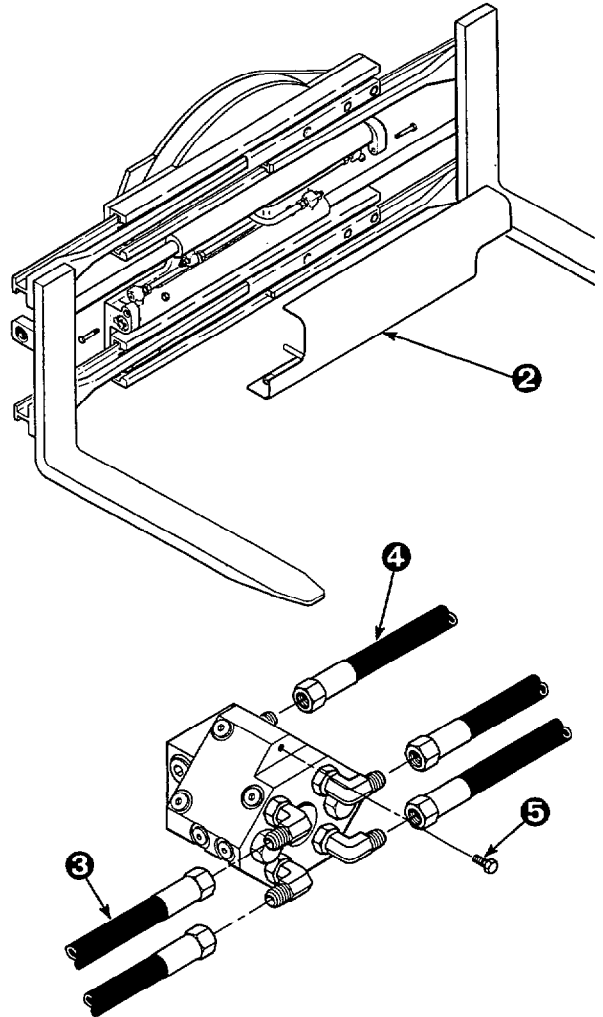
This sheet describes the installation of a shaft seal service kit or new revolving connection assembly and mounting hardware. The new mounting reduces side loading forces on the revolving connection that could cause leakage.

**IMPORTANT:** Service the revolving connection in a clean work area.



**WARNING:** Before removing any hydraulic lines, relieve pressure in the hydraulic system. Turn the truck off, then open the truck auxiliary control valves several times in both directions.

- 1 Remove the attachment from the lift truck as described in the D-Series Revolving Clamp Service Manual part no. 672362.
- 2 Remove the bumper from the attachment.
- 3 Disconnect the hoses from the front of the revolving connection. **Tag the hoses for reassembly.**
- 4 Disconnect the hoses or tubes from the rear of the revolving connection. **Tag the hoses or tubes for reassembly.**
- 5 Remove the capscrews fastening the revolving connection body to the faceplate. Remove the revolving connection from the backside of the attachment.
- 6 Grind off 1/8 in. (3 mm) of the projections in the baseplate revolving connection center hole.



Part No. 209025

# cascade®

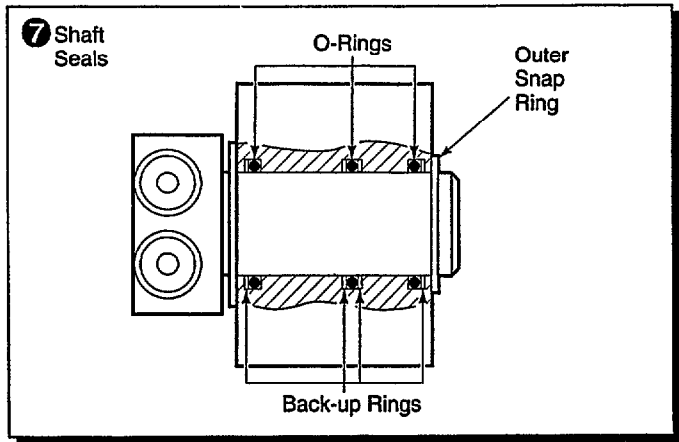
For Technical Assistance and to Order Parts . . .

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

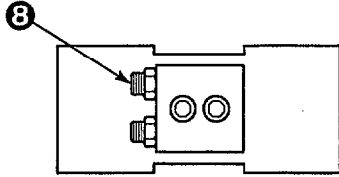
FAX: 503-669-6338

Write: Cascade Corporation, PO Box 20187, Portland, OR 97220

**7** Kit 209026 includes new shaft seals. Install the seals in the body. Lubricate the shaft and body bore with hydraulic oil prior to assembly. Rotate the body while installing the shaft to prevent damage to the seals. Install the outer snap ring.

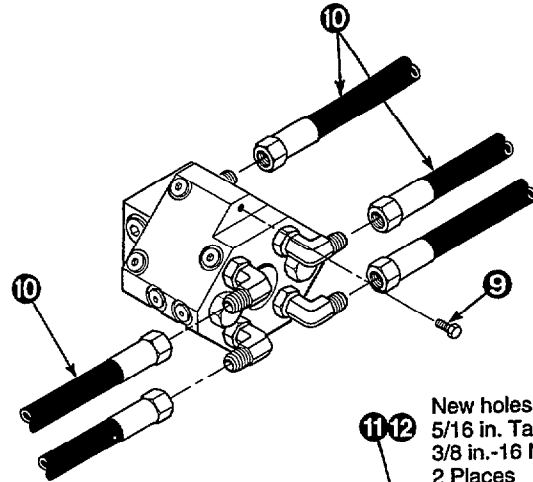


**8** Install the revolving connection through the baseplate and position the end block in the baseplate with the CLAMP/ OPEN fittings facing left as viewed from the back of the attachment.



**9** Fasten the revolving connection to the faceplate. Tighten the capscrews to a torque of 35-40 ft.-lbs. (47-54 Nm).

**10** Install the hoses and/or tubes to the revolving connection. See the Service Manual for hose and tube hook-up if necessary.



**11** Place the new bracket over the revolving connection end block and centerpunch to locate 3 new tapped holes in the baseplate.

**12** Drill and tap three holes in the baseplate as shown.

**11 12** New holes  
5/16 in. Tap Drill  
3/8 in.-16 NC  
2 Places

**13** Install the bracket, grommets, washers and shoulder bolts to the baseplate. Tighten the capscrews to a torque of 6-8 ft.-lbs. (8-10 Nm).

**14** Install the bumper to the attachment. Tighten the self-locking nuts to leave .050-.080 in. (1.3-2.0 mm) end play for each capscrew.

**15** Reinstall the attachment to the truck as described in the service manual.

**16** Rotate and operate the clamp functions through several cycles to test for proper operation.

Rotate Clockwise – Pull lever BACK  
Arms Close – Pull Lever BACK

Inspect for hydraulic leaks prior to returning the clamp to service.

