



Installation Instructions

30C/45C Load Push/Pull Faceplate and Lower Secondary Arm Clevis Service Kit 204398

This sheet shows how to install a new faceplate or lower secondary arm clevis (part no. 667319). Grinding and welding are required to replace the old clevis.



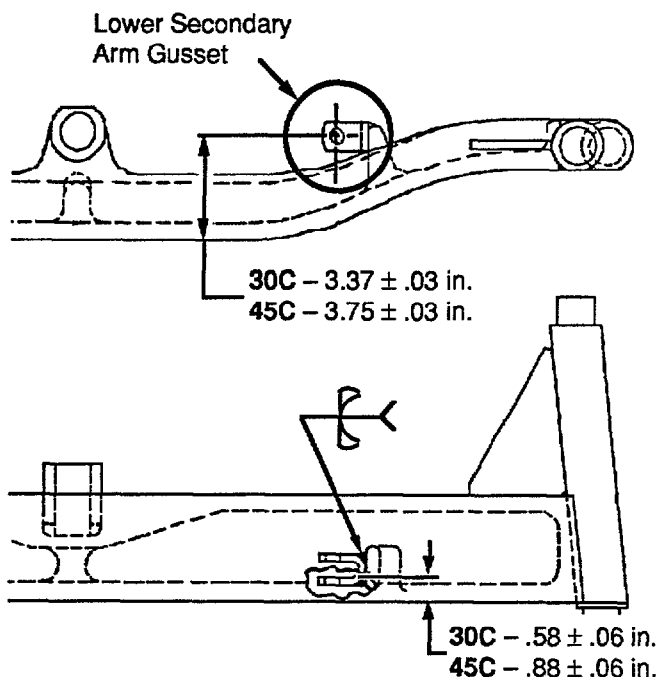
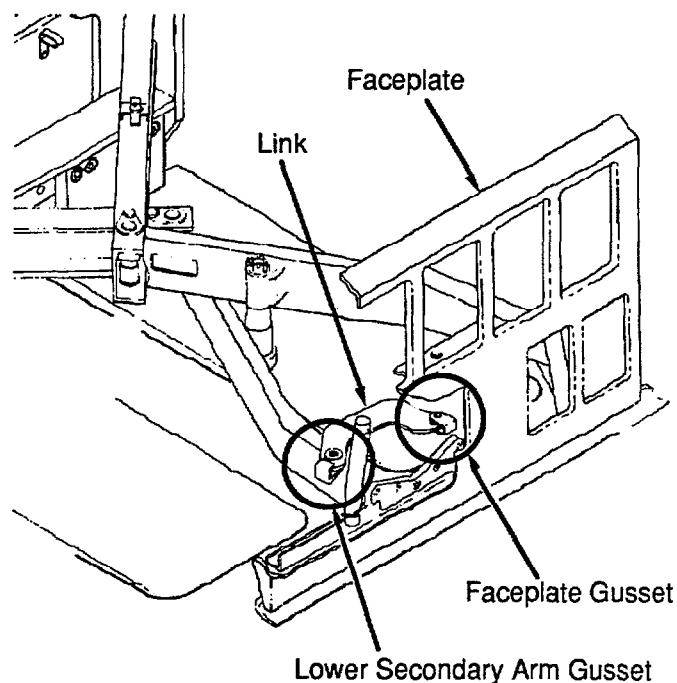
WARNING: Welding must be performed by a qualified welder familiar with this type of fabrication.

- 1 Remove the pins attaching the link to the faceplate and lower secondary arm clevis points.
- 2 Remove the old clevis using a grinder. Clean all surfaces to be welded. Remove paint, dirt and grease and other contaminants.
- 3 Locate the clevis on the lower secondary arm or faceplate using the dimensions shown (see the backside of this sheet for faceplate dimensions). Clamp in place with a 'C' clamp. Protect other surfaces and components from weld splatter with fiberglass cloth.
- 4 Use one of the weld methods below:

WELD METHOD A – Attach the ground wire to the arm or faceplate. Weld using FCAW (Flux Core Arc Weld) AWS E70T-5 1/16 in. (1.5 mm) diameter wire with 100% CO₂ shielding gas. Apply the fillet holding a close arc. Do not oscillate or use a wash bead pattern. Let the welds slow cool.

WELD METHOD B – Attach the ground wire to the arm or faceplate. Weld using E-7018 low hydrogen 5/32 in. (4 mm) electrodes. Use reverse polarity or a AC welding machine set at 145-225 amps. **Do not use electrodes exposed to moisture without first re-drying them at 200° F (75° C) for 2 hours.** Apply the fillet holding a close arc. Do not oscillate or use a wash bead pattern. Let the welds slow cool.

- 5 Remove slag and inspect the weld. The following defects are not allowed: undercut, overlap, stress cracks and porosity. Clean the weld area and repaint.
- 6 Install the link to the faceplate and lower secondary arm clevis points. Test the push/pull through several cycles to check for proper operation.



Part No. 204399

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