



# Technical Bulletin

## 30C, 55C, 80C Triple Viewmast® II and 45C Quad Viewmast® II Freelifft Roller Mast Replacement Stub Shaft Installation Instructions


This Technical Bulletin provides installation instructions for the following Stub Shaft Service Kits:

MODEL	SERVICE KIT	STUB SHAFT
30C	675555	658344
	675556	660670
	675559	660574
55C	675556	660670
	675557	660576
	675558	660575
	675559	660574

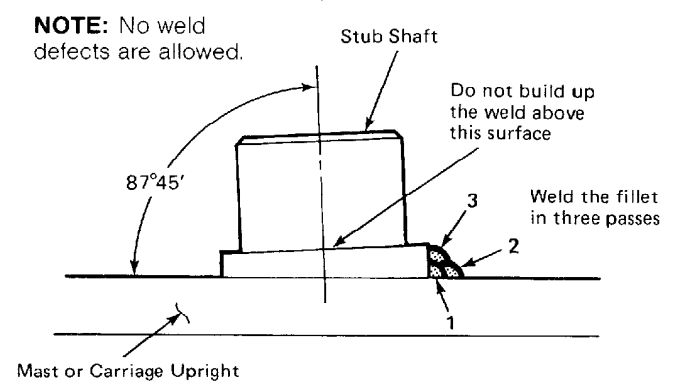
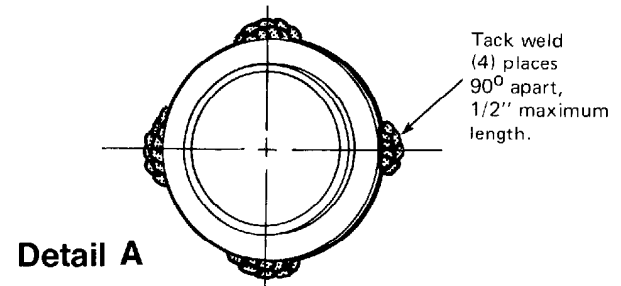
MODEL	SERVICE KIT	STUB SHAFT
80C	675551	662832
	675552	662831
	665553	662830
	675554	662829
45C	675556	660670
	675557	660576
	675558	660575
	675559	660574

Stub Shaft Service Kits may be purchased from Cascade Parts Depot (513/322-1199) and installed per this Technical Bulletin. Chain anchors are not available for field installation. Stub Shafts and Chain Anchors are available as a Cascade factory installation with price quoted at time of order, FOB Springfield, Ohio.

- Remove the mast from the truck and disassemble to gain access to the stub shaft requiring replacement. Refer to Triple Viewmast II Service Manual P/N 667443 or Quad Viewmast Service Manual P/N 669223.
- Remove the worn stub shaft by grinding off the attaching weld. Do not remove by Air-Arc or Oxy-Acetylene methods. Grind the stub shaft mounting surface smooth.
- Clean surfaces to be welded with a wire brush. Remove paint and other contaminants.
- Locate the new stub shaft using the dimensions shown in detail on the following pages for the stub shaft being replaced. **IMPORTANT:** The 87° 45' stub shaft angle must be oriented exactly as shown for correct mast operation.
- Use only E7018 (5/32" diameter) low hydrogen electrodes per AWS 5.1. Electrodes must be in good condition. Bake as required to remove all moisture per manufacturer's procedures.
- Use DC reverse polarity or an AC welding machine. Set the amperage at 175 amps. Tack weld the stub shaft in four (4) places, 90° apart as shown in detail A.
- Preheat the upright or carriage and stub shaft to 100° F. minimum, 200° F. maximum. Monitor with a Tempstick (crayon). DO NOT weld in a drafty or damp area.
- Weld completely around the stub shaft with a fillet, sized per the detail drawing, holding a close arc. Do not oscillate or use a wash bead pattern. Make the weld in three passes, as shown in Detail A, for welds greater than .25 fillet size. Let the weld slow cool.
- Remove slag and inspect weld after each pass. The following weld defects are not allowed: arc craters, undercut, overlap, stress cracks or porosity. Repair by grinding only. Refer to AWS D 1.1.
- Clean the weld area and repaint with Cascade paint P/N 668209. Reassemble the mast and make necessary adjustments as described in the Service Manual.



**WARNING:** The following procedures must be performed by a welder certified per the applicable section of AWS D 1.1 and experienced in this type of repair.



Part No. 674435 R-1

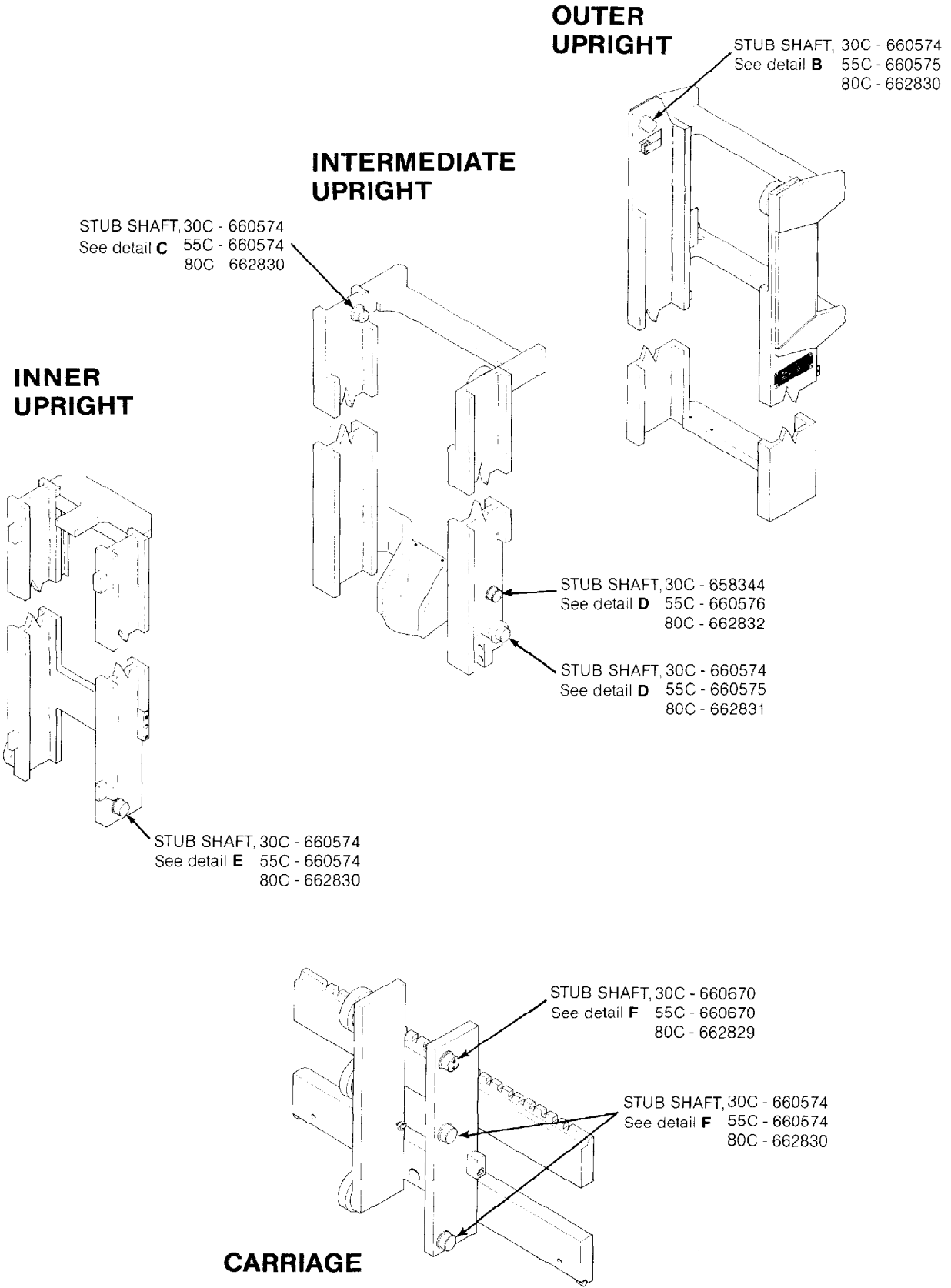


P.O. Box 20187 • Portland, Oregon 97220 • (503) 666-1511  
P.O. Box 360 • Springfield, Ohio 45505 • (513) 325-9271

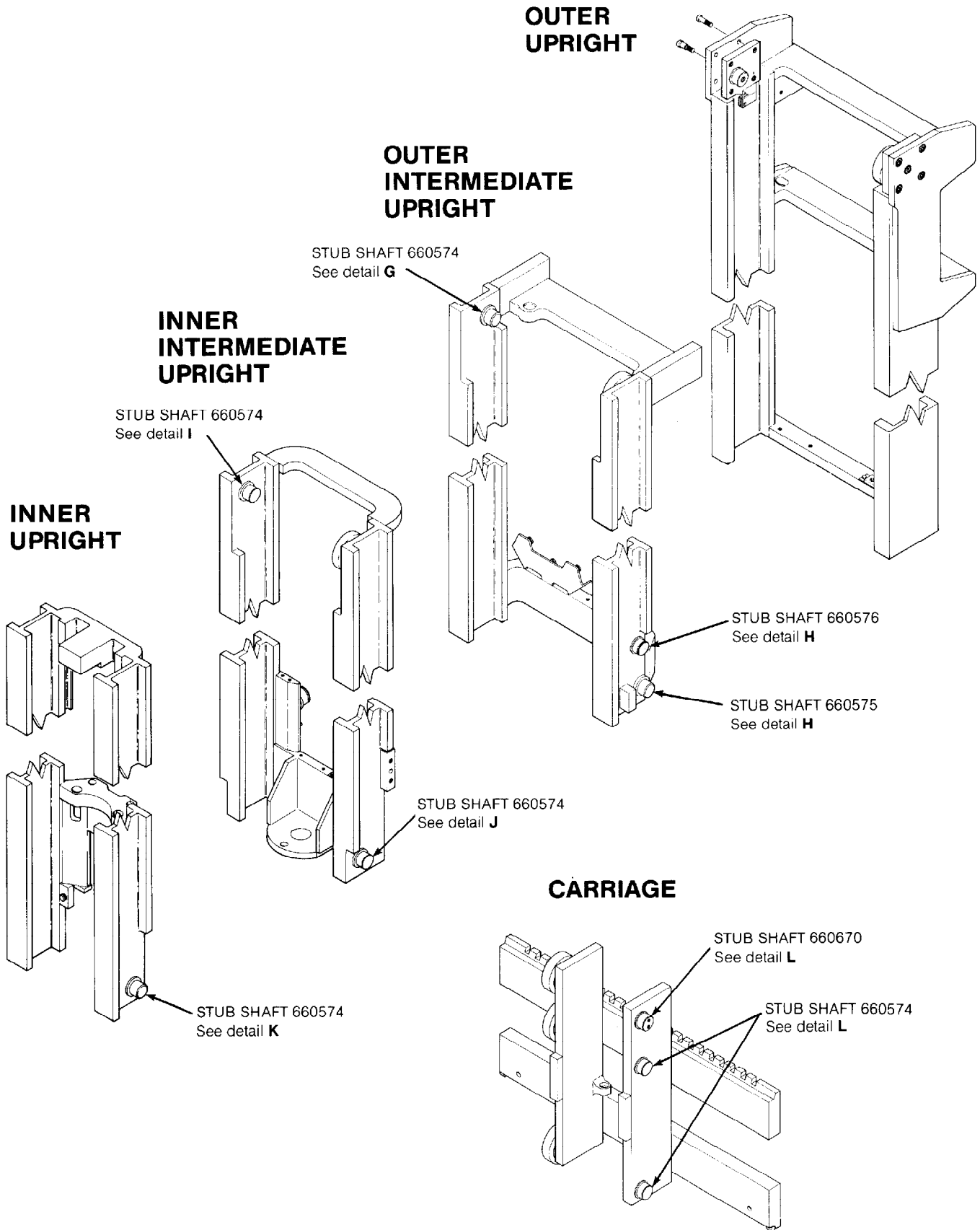
**Do you have questions you need answered right now?**

Dial Directline  
800 227-2233  
(toll free)

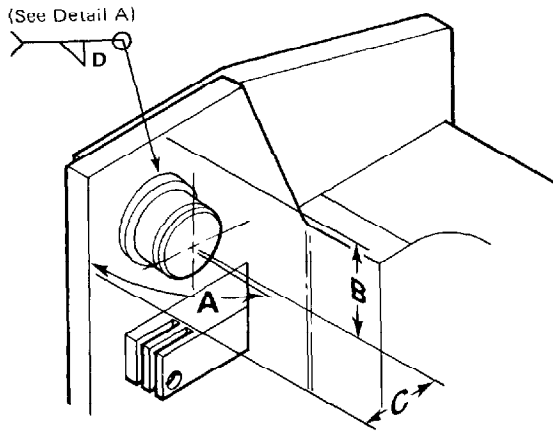
# MODEL 30C, 55C, 80C MASTS



# MODEL 45C MASTS

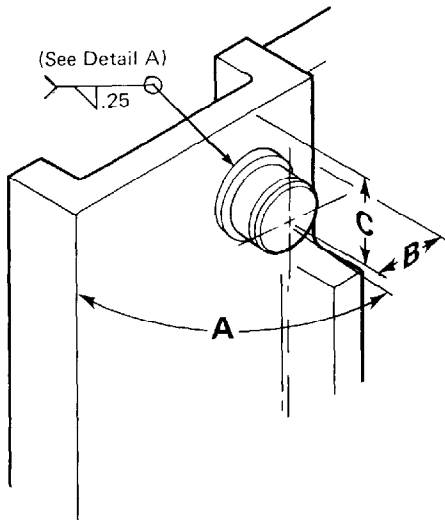


**CAUTION:** All welding must be performed as specified in the cover page welding instructions steps 1-10.



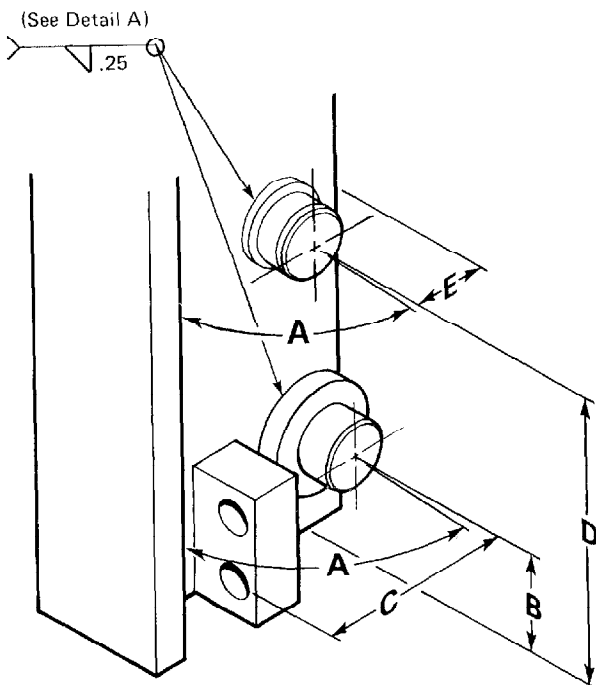
**Detail B**  
30C, 55C, 80C Outer Upright

Mast Model	Dimension			
	A	B	C	D
30C	87°45'	1.88±.03	1.70±.03	.25
55C	87°45'	2.03±.03	1.84±.03	.25
80C	87°45'	2.50±.03	2.25±.03	.38



**Detail C**  
30C, 55C, 80C Intermediate Upright

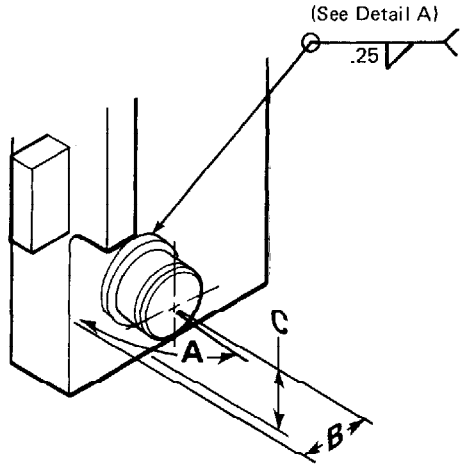
Mast Model	Dimension		
	A	B	C
30C	87°45'	1.70±.03	1.88±.06
55C	87°45'	1.80±.03	2.00±.06
80C	87°45'	2.25±.03	2.50±.06



**Detail D**  
30C, 55C, 80C Intermediate Upright

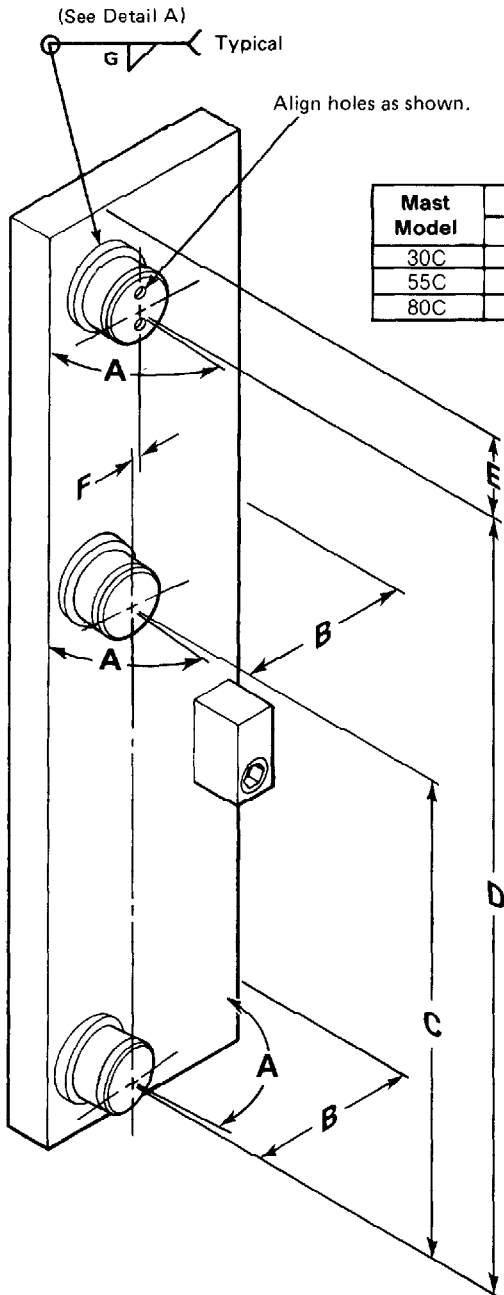
Mast Model	Dimension				
	A	B	C	D	E
30C	87°45'	1.88±.06	2.98±.03	6.25±.06	1.00±.03
55C	87°45'	2.00±.03	3.16±.03	6.50±.06	1.20±.03
80C	87°45'	2.50±.06	4.93±.03	8.25±.03	1.40±.03

**CAUTION:** All welding must be performed as specified in the cover page welding instructions steps 1-10.



**Detail E**  
30C, 55C, 80C Inner Upright

Mast Model	Dimension		
	A	B	C
30C	87°45'	1.70±.03	1.88±.06
55C	87°45'	1.80±.03	2.00±.06
80C	87°45'	2.25±.03	2.50±.06



**Detail F**  
30C, 55C, 80C Carriage

Mast Model	Dimension						
	A	B	C	D	E	F	G
30C	87°45'	3.69±.03	12.50±.06	20.00±.06	1.25±.06	.022±.005	.20
55C	87°45'	4.20±.03	12.50±.06	20.00±.06	1.25±.06	.022±.005	.20
80C	87°45'	5.00±.06	16.50±.06	25.00±.06	1.50±.06	.014±.005	.25

**CAUTION:** All welding must be performed as specified in the cover page welding instructions steps 1-10.

