

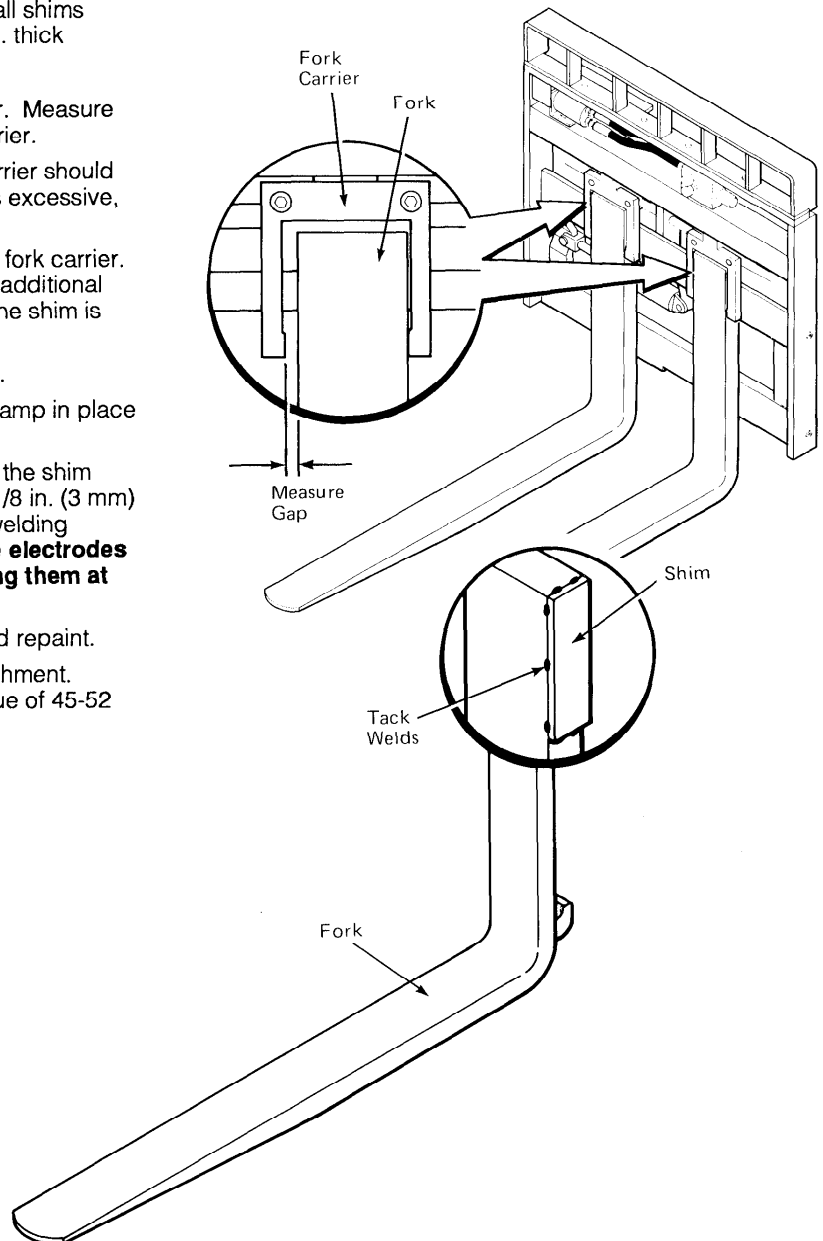


# Technical Bulletin

## E-Series Fork Positioner Fork Carrier Shim Kit 200643

This sheet describes procedures to inspect the clearance between the fork and fork carrier and how to install shims when required. The shim kit includes four 1/16 in. thick shims.

- 1 Slide each fork to one side of the fork carrier. Measure the clearance between the fork and fork carrier.
- 2 The clearance between the fork and fork carrier should be 1/16 in. (1.5 mm) maximum. If the gap is excessive, shims must be installed.
- 3 Slide one of the shims between the fork and fork carrier. If the gap still exceeds 1/16 in. (1.5 mm) an additional shim(s) will be required. When more than one shim is required, install on both sides of the fork.
- 4 Remove the fork carriers. Remove the forks.
- 5 Locate the shim(s) on the fork as shown. Clamp in place with a "C" clamp.
- 6 Attach a ground wire to the fork. Tack weld the shim using ER-312 low hydrogen stainless steel 1/8 in. (3 mm) electrodes. Use reverse polarity or an AC welding machine set at 125-145 amps. **Do not use electrodes exposed to moisture without first re-drying them at 180°-220° for 2 hours.**
- 7 Remove weld slag. Clean the weld area and repaint.
- 8 Install the forks and fork carriers to the attachment. Tighten the fork carrier capscrews to a torque of 45-52 ft.-lbs. (60-70 Nm).



**NOTE:** This information should not be interpreted as the basis for warranty claims unless so designated.  
Part No. 200644

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