



Installation Instruction

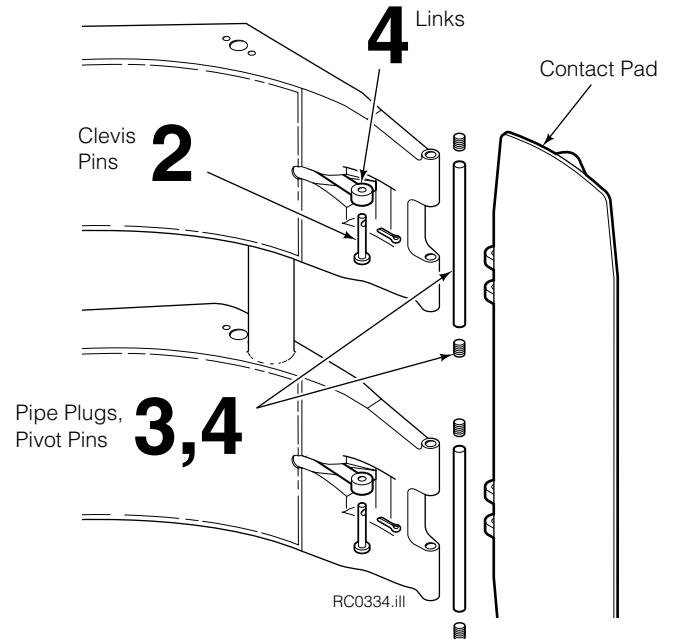
77F and 90F Paper Roll Clamp Arm Tip Service Kit 6035623

This sheet describes arm tip replacement procedures for 77F and 90F Paper Roll Clamps. Each kit includes replacement tips, links and pins for one arm.



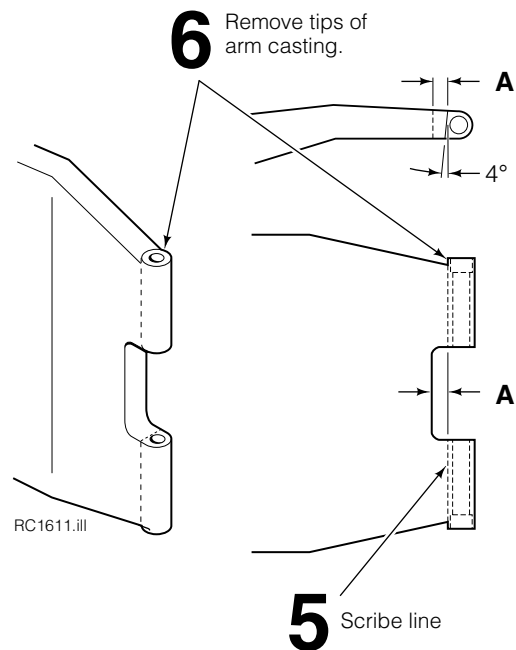
WARNING: Cascade Corporation recommends that a qualified welder experienced in this type of repair be used for best quality.

- 1 Rotate the Roll Clamp to the vertical roll-handling position. Lower the unit until the contact pads just touch the ground. Do not place the full weight of the Roll Clamp on the contact pads.
- 2 Remove the clevis pins fastening the links to the contact pads.
- 3 Remove the pipe plugs from the contact pad pivot points.
- 4 Remove the pivot pins and links.
- 5 Scribe a cut line using dimension **A**, forward from the pocket on both sides of the arm tip castings.



Model	Dimension A in. (mm)
77F & 90F	.50 ± .03 (13 ± .7)

- 6 Remove the defective tip area entirely by grinding, sawing, torch, or arc gouging. Finish the face of the arm tip casting with a 4° angle. Remove paint or contaminants from around repair area. If arc gouging is used, make sure all carbon particles are completely removed.



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

Part No. 6035649

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- 7** Position the new tips on the arm using the dimensions **B** and **C** as shown. Place a rod of dimension **D** diameter through all tips for alignment. All repairs should be done in the flat position.

Dimensions			
Model	B in. (cm)	C in. (cm)	D in. (mm)
77F	10.60 ± .06	32.20 ± .12	.59
90F	(26.9 ± .15)	(81.8 ± .30)	(15)

- 8** Preheat the arm tip casting base metal to 70° F (21° C) minimum, and tack weld the new tips to the arm tip castings. Use one of the recommended weld methods listed below.
- 9** Install the contact pad, new links and pins to the arm. Check tip alignment. Check contact pad and link clearances. Realign the tips as required. Remove the contact pad, links and pins.
- 10** Finish welding the new tips to the arm tip castings using the following weld procedures:
- Protect threaded end of tips from weld spatter.
 - Preheat arm tip casting base metal to 150° F (66° C). Monitor and maintain arm tip casting heat at locations shown using suitable temperature measurement devices.
 - Weld sequence – Start weld on side indicated. Terminate each weld at center of tip.
 - **WELD METHOD A – FCAW (Flux-Cored Arc Weld).** Attach ground wire to arm. Weld using AWS E70T-1 1/16 in. (1.6 mm) or 5/64 in. (2 mm) diameter wire with 100% CO₂ shielding gas at 35–50 CFH. Set welding amps per manufacturer's recommendations. Apply weld holding a close arc. Do not oscillate or use a wash bead pattern.
 - **WELD METHOD B – SMAW (Stick Welding).** Attach ground wire to arm. Weld using E-7018 low hydrogen 1/8 in. (3.2 mm) or 5/32 in. (4 mm) diameter electrodes. Set welding amps per manufacturer's recommendations. **Do not use electrodes exposed to moisture without first re-drying them at 200° F (75° C) for 2 hours.** Apply weld holding a close arc. Do not oscillate or use a wash bead pattern.
 - Air cool the arm tip castings.

- 11** Remove slag after each weld and inspect for defects. **NOTE:** Arc craters, undercut, overlap and porosity are not permitted. Repair any weld defect as required.
- 12** Grind all welds to smooth transitions between parts.
- 13** Install the contact pad, new links and pins to the arm. Check for free movement.

