



Technical Bulletin

Number 124
March 1983

Cylinder Service Kit 673514

Model: 45C Load Push/Pull with Sheet-Sav™ option Serial No. 670203 and 672356

Problem: Sideshift cylinder stroke is excessive causing possible weld failure on the cylinder anchor bracket.

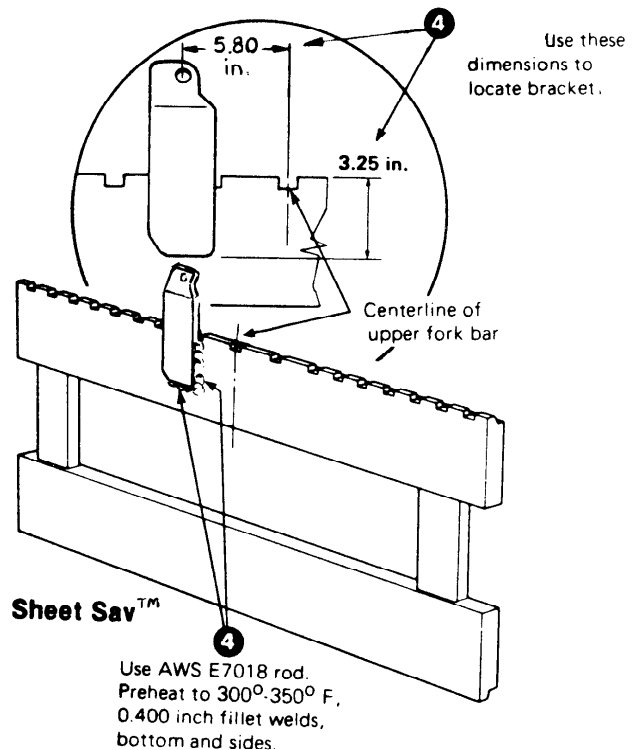
Solution: Install cylinder service kit 673514 to limit the cylinder stroke and improve the cylinder rod end anchor. The kit contains two cylinder spacers and an anchor bracket. The anchor bracket requires welding.



WARNING: Before removing hoses, actuate the auxiliary valve levers to relieve pressure trapped in the hydraulic circuit.

- 1 Remove the attachment from the truck. Refer to Service Manual Form 5181A.
- 2 Remove the sideshift cylinder from the attachment.
- 3 Remove the old anchor bracket from the truck carriage. Grind the truck carriage smooth.
- 4 Locate the new anchor bracket on the truck carriage using the dimensions shown. Preheat the bracket and carriage to 300°-350° F. Weld only the bottom and sides of the bracket with a .040 inch fillet weld using AWS E 7018 rod.

(continued)



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

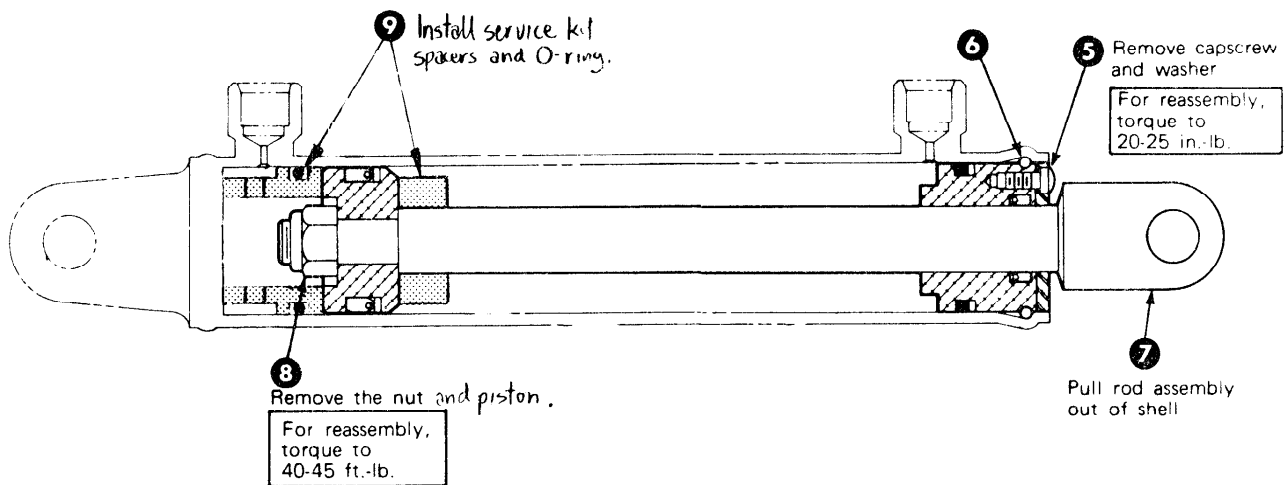
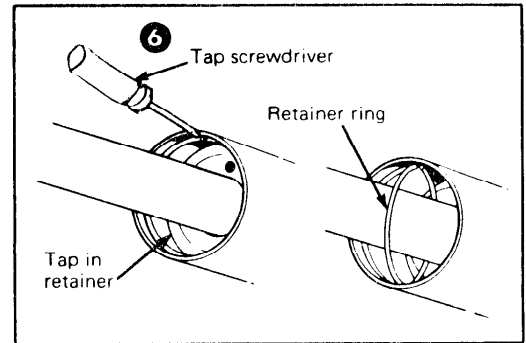
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- 5 Remove the capscrews fastening the washer to the cylinder retainer. Extend the rod 4 inches and remove the washer. For reassembly, tighten the capscrews to a torque of 20-25 in.-lbs.
- 6 Tap the retainer in 2 inches. Place a screwdriver on one side of the retainer ring near the split. Tap the screwdriver to compress the ring and turn it sideways. Remove the ring.
- 7 Remove the rod assembly from the cylinder shell.
- 8 Remove the nut and piston from the rod. For reassembly, tighten the nut to a torque of 40-45 ft.-lbs.
- 9 Install the service kit spacers and O-ring as illustrated.
- 10 Lubricate all seals with STP before reassembly. Reassemble the cylinder using the specified torque values.
- 11 Further reassembly is a reversal of previous procedures.



The Service Kit can be ordered by contacting:

Cascade Corporation Parts Depot
2501 Sheridan Ave.
Springfield, Ohio 45505
Telephone: (513) 322-1199
Telex: 205413