



Technical Bulletin

Number 134

December 1983

D-Series Carton Clamp Wear Tile Service Kit

Procedures for the installation of D-Series Carton Clamp - Wear Tile Service Kit 674141. The kit includes 2 front wear tiles (674133) and 2 rear wear tiles (674134) for installation on both stabilizers.

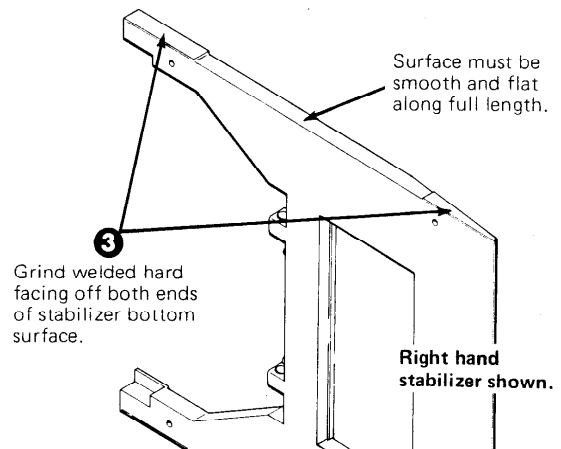
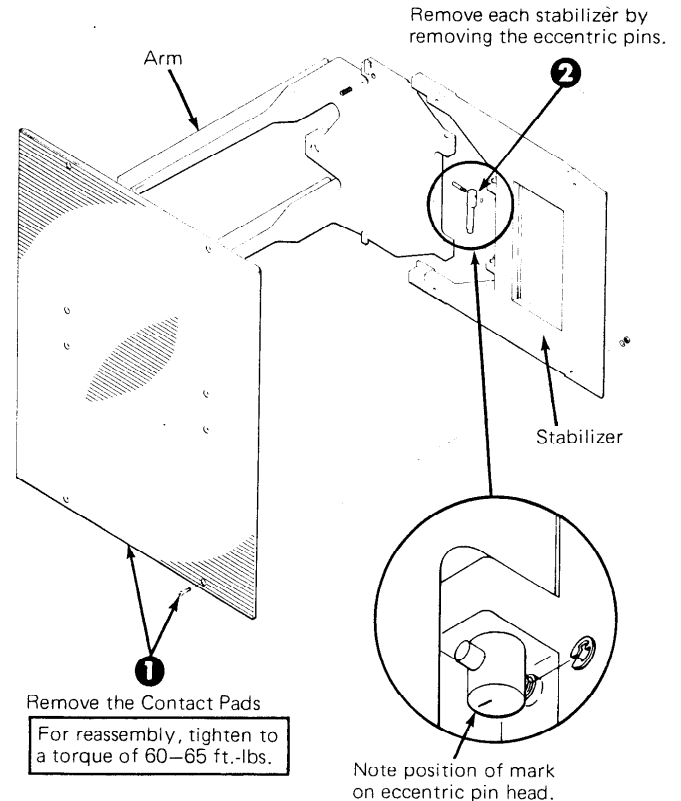
Models: 20D, 35D and 60D Carton Clamps

1 Remove the contact pads from the stabilizers. For reassembly, tighten the capscrews to a torque of 60-65 ft.-lbs.

2 Remove each stabilizer by removing the two eccentric pins that secure them to the arms. Note the position of the mark on each eccentric pin head for reassembly.

3 Grind the welded hardfacing off both ends of the stabilizer bottom surface. The bottom surface should be smooth and flat along the full length.

IMPORTANT: If the stabilizer bottom surface is excessively worn, build up with weld and grind flat to within 1/16" along the full length.



(Continued)

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- 4 Weld the wear tiles to the bottom surface of the stabilizer using AWS-E-7018, 3/16" diameter rod.

NOTE: Welding temperature does not affect wear tile surface adhesion. The tile hard surfacing cannot be welded on.

- 5 Grind the welds along the inside edge of the stabilizer flush with the inside surface. The contact pads must bolt up flat against the stabilizer without interference with the welds.
- 6 Reassembly is a reversal of disassembly.

