

# Technical Bulletin

## 45F and 60F Paper Roll Clamp Arm Outer Wrapper Plate Repair Kits 684983, 684984, 684985, 684986

This sheet provides instructions to repair a cracked outer wrapper plate on 45F and 60F Paper Roll Clamp arms. The Service Kits and applications are listed below.

**Service Kit**

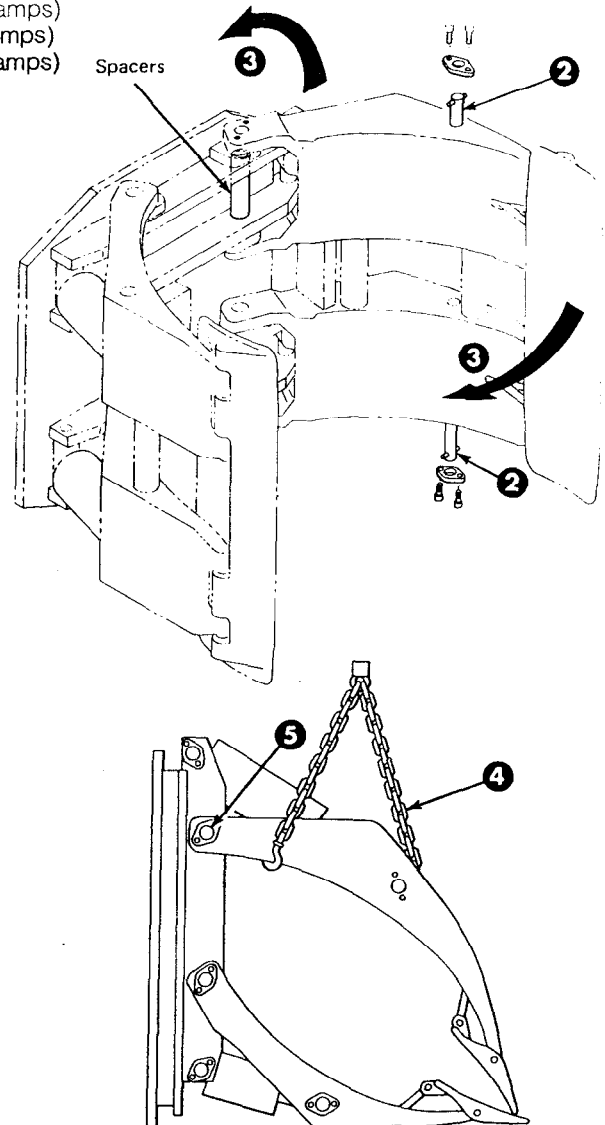
| Part No. | Model | Arm Serviced                                  |
|----------|-------|---|
| 684983   | 45F   | 45 in. & 51 in. Long Arm (Fixed Frame Clamps) |
| 684984   | 45F   | 45 in. & 51 in. Long Arm (Swing Frame Clamps) |
| 684985   | 60F   | 51 in. & 60 in. Long Arm (Fixed Frame Clamps) |
| 684986   | 60F   | 51 in. & 60 in. Long Arm (Swing Frame Clamps) |

The arm can be serviced while on the attachment or after it has been removed as described in steps 1 through 5. If you are servicing the arm on the attachment, proceed to step 6 to begin repairs.

- 1 Fully open the arm to be removed. Rotate the clamp to the vertical roll handling position.
- 2 Remove the cylinder rod anchor pins. For reassembly, tighten the anchor capscrews to a torque of 30-35 ft.-lbs. (40-48 Nm).
- 3 Swing the arm being removed inward to contact the other arm. Rotate the attachment 90° to position the arm being removed in the upper position.

**WARNING:** Make sure your overhead hoist has a rated lifting capacity of 1000 lbs. (450 kg).

- 4 Attach an overhead hoist to the arm and take up slack in the chain.
- 5 Remove the arm/faceplate anchor pins and spacers (if equipped). Note the location of the shims. Lift away the arm assembly. For reassembly, tighten the anchor capscrews to a torque of 30-35 ft.-lbs. (40-48 Nm).



**NOTE:** This information should not be interpreted as the basis for warranty claims unless so designated. Part No. 682932

- 6 Magnaflux or use a dye penetrant and developer to determine the extent of the wrapper plate crack.
- 7 Remove one side of the crack by using one of the following methods:
  - a. **Air Arc**
    - Use a welder set on D.C. reverse polarity, 300-350 amps.
    - Use an air arc electrode .25 in. diameter D.C.
    - Air arc to 1/2 thickness of parent material.
    - Completely remove any carbon deposits or slag with a grinder.
  - b. **Grinding**
    - Grind the crack to 1/2 thickness of parent material.

- 8 Weld the crack using FCAW E-70T-1, 1/16 in. diameter welding wire. Set the amperage to 325-350A, with the voltage at 28-30V. Use cover gas 100% CO<sub>2</sub> @ 45 CF/H. Set the stick out to 1/2 - 1 in. Protect the weld zone from external drafts to insure proper gas coverage. Start the weld at the edge of the plate. Grind weld fillet flush.

**CAUTION:** Weld defects – arc craters, stress cracks, porosity, pin holes, overlap, coldlap and other flaws are not permitted.

- 9 Repeat steps 7 and 8 for the opposite side of the cracked plate. Air arc or grind out the crack opposite side, until you have reached the depth of the previously deposited weld (100% penetration is required).
- 10 Place the template supplied in the kit on the wrapper plate centered between the side plates. Draw the outline of the template on the wrapper plate. Cut away the wrapper plate to the drawn line.
- 11 Position the repair plate on the wrapper plate as shown. Weld a .25 in. fillet around the plate using FCAW E70T-1 low hydrogen rod as described in step 8. Blend all edges smooth.
- 12 For reassembly, reverse the above procedures.

