

**Non-Current  
Use TB 315**

# Technical Bulletin

## 25H, 30H & 33H Roll Clamp Arm Tip and Wear Plate Service Repair Kits

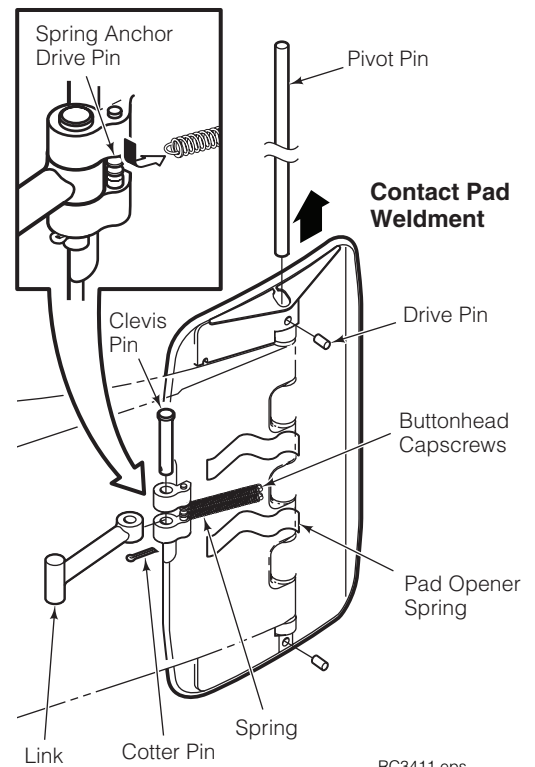
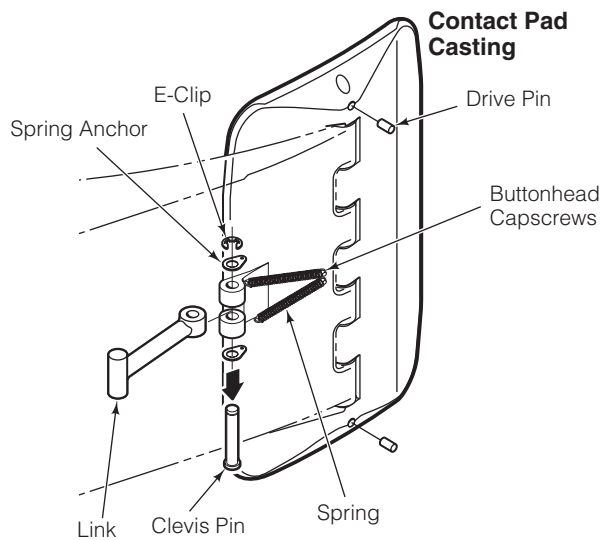
This sheet describes arm tip removal and wear plate installation procedures for 25H, 30H & 33H Roll Clamp Service Repair Kits 6097843 and 6810073. Kit 6097843 includes replacement tips and wear plates for one solid arm. Kit 6810076 includes wear plates for one solid arm.



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

- 1 Rotate the clamp to the vertical roll handling position. Lower the clamp until the contact pads are approximately 1 in. (25 mm) from the ground.
- 2 **Contact Pad Casting** – Remove the E-clips from the clevis pins. While removing the clevis pins, unhook the spring anchors. Springs will remain fixed to the arms.  
**Contact Pad Weldment** – Remove cotter pins from the clevis pins that fasten the links to the contact pad. Remove the clevis pins from the links. Unhook the springs from the anchor drive pins. Springs will remain fixed to the arms.

- 3 Remove the drive pins from the contact pad pivot points and remove pivot pins.
- 4 Remove the contact pad and pad opener springs. Pad links can be removed from the arm by rotating 90 degrees and pulling out.



RC3411.eps

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

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Write: Cascade Corporation, PO Box 20187, Portland, OR 97294-0187

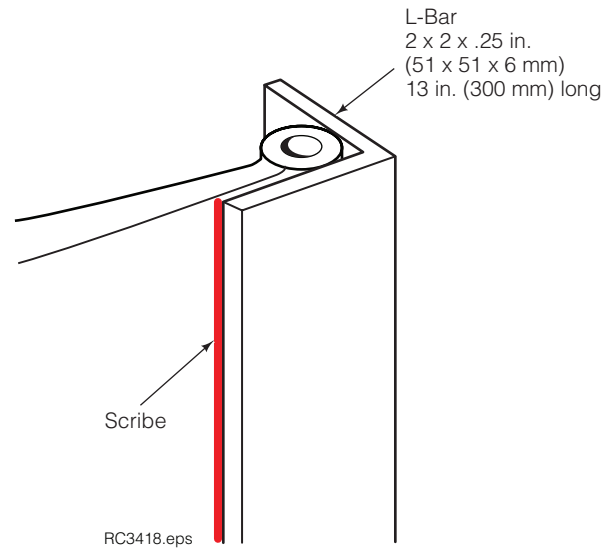
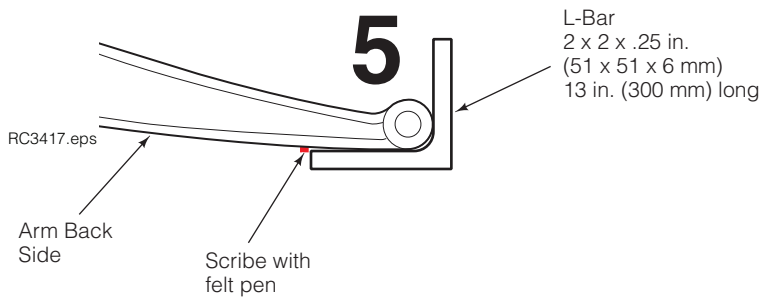
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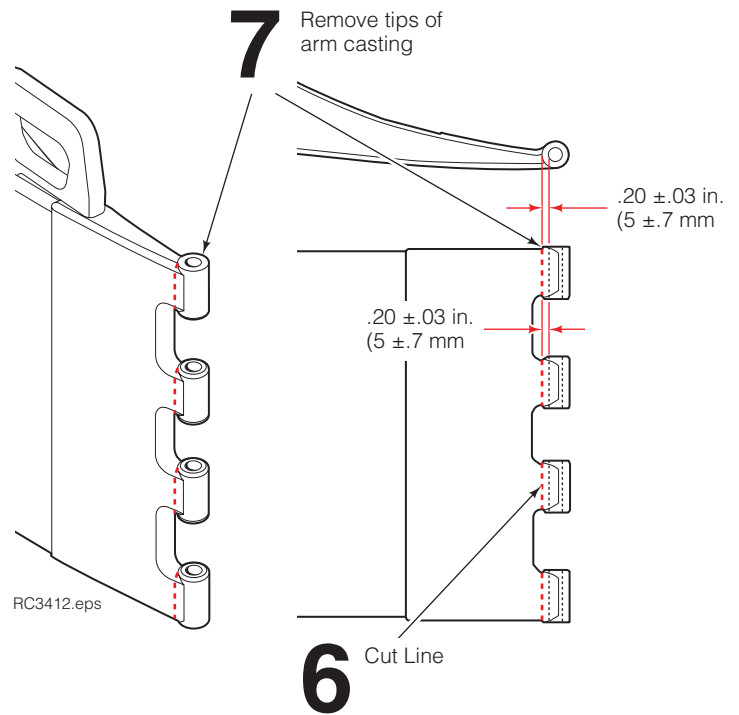
Write: Cascade Corporation, 2501 Sheridan Ave., Springfield, OH 45505

- 5** Place a 2 x 2 x .25 in. (51 x 51 x 6 mm) 13 in. (300 mm) long L-bar against the tip and back side of arm. Use a felt pen to scribe a line against the L-bar. Remove L-bar.

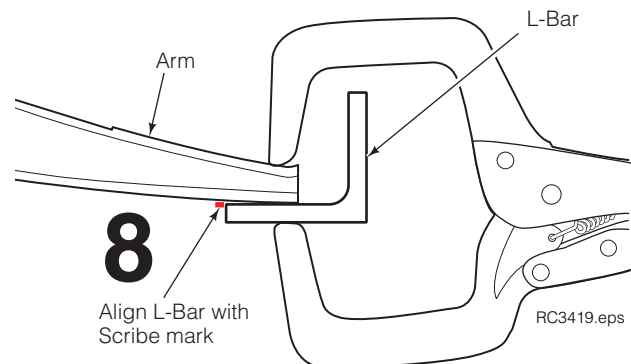


- 6** Scribe a cut line  $.20 \pm .03$  in. ( $5 \pm .7$  mm) back from the inner surface of the existing tip holes on both sides of the arm tips.

- 7** Remove defective tip area entirely by grinding, sawing, torch or arc gouging. Remove any paint contamination from around the repair area. If arc gouging is used, make sure all carbon particles are completely removed.

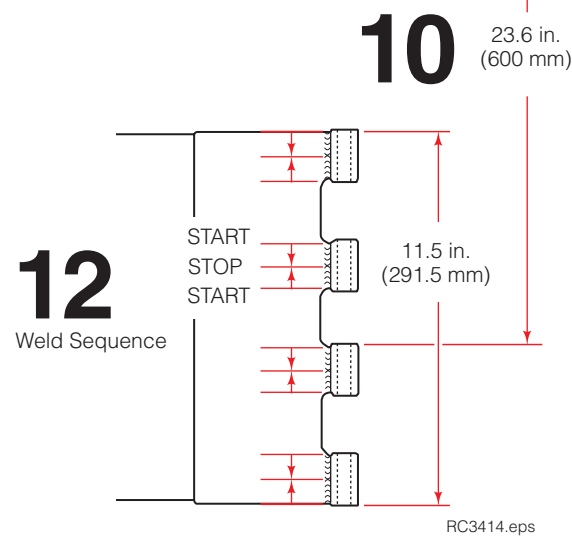
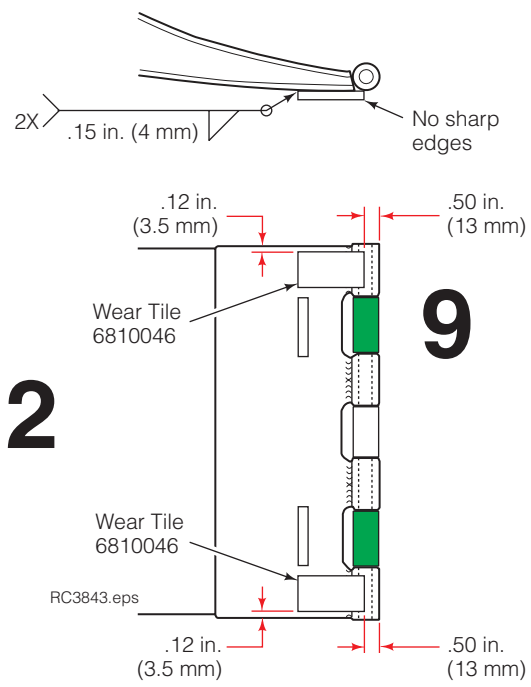
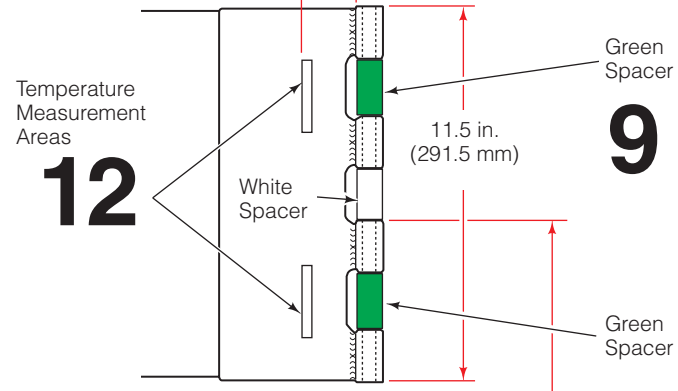
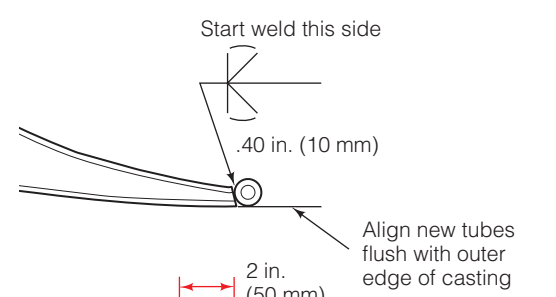
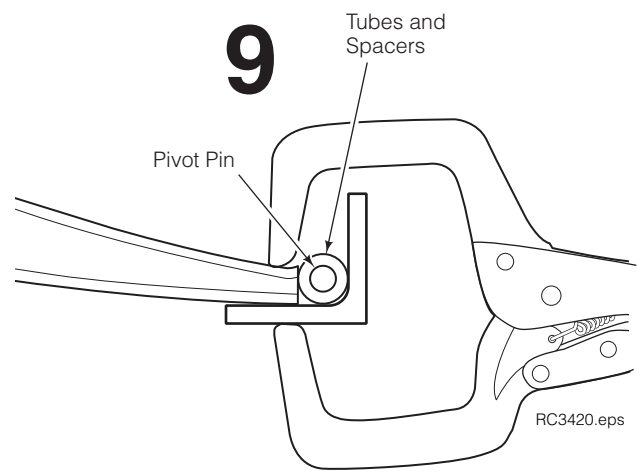


- 8** Clamp the L-bar in line with the scribe mark.



- 9 Position wear tiles on short arms using the dimensions shown. Position the new tubes on the arm tips using the dimensions shown. Place existing pivot pin through all tubes and spacers for alignment. All repairs should be done in the flat position.
- 10 Preheat arm tip base metal to 70°F (21°C) minimum. Tack weld new tubes and wear tiles to the tips. Use the recommended weld procedures listed below. Remove L-bar.
- 11 Install the contact pad and pivot pin on the arm. Check the tube alignment, realign as required. Remove the contact pad and pin.
- 12 Finish-weld the tubes to the arm tips and wear tiles using the following weld procedures:
  - Protect inside of tubes from weld spatter.
  - Preheat arm tip base metal to 150°F (66°C). Monitor and maintain arm tip heat at locations shown using suitable temperature-indicating devices.
  - **Weld Sequence** – Start weld on side indicated. Terminate each weld at center of tube.
  - **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% CO<sub>2</sub> shielding gas at 35-50 CFH. Set welding amp per manufacturers 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-7015 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 electrode 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.
  - Cool arm tip base metal at normal air cool.
- 13 Remove slag after each weld and inspect for defects.
 

**NOTE:** Arc craters, undercut, overlap and porosity are not permitted. Repair any defect as required.
- 14 Grind all welds to smooth transitions between parts.
- 15 Install contact pads by reversing Steps 1 through 4.



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