



Installation Instructions

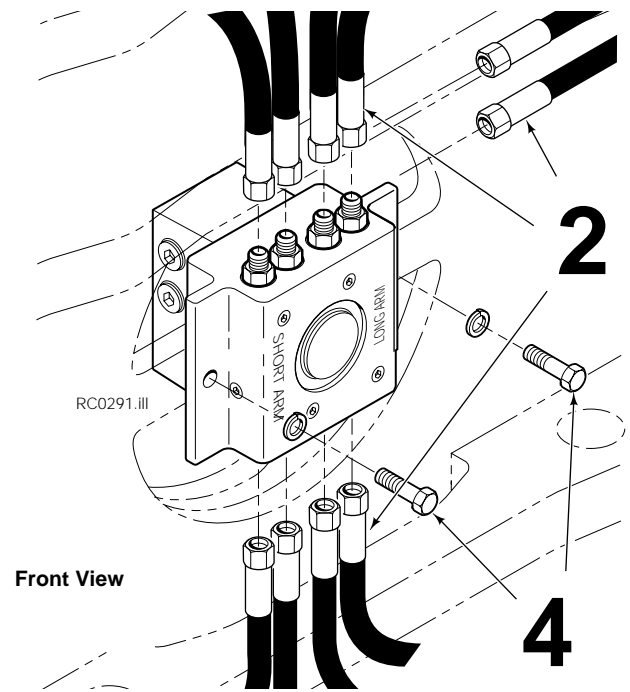
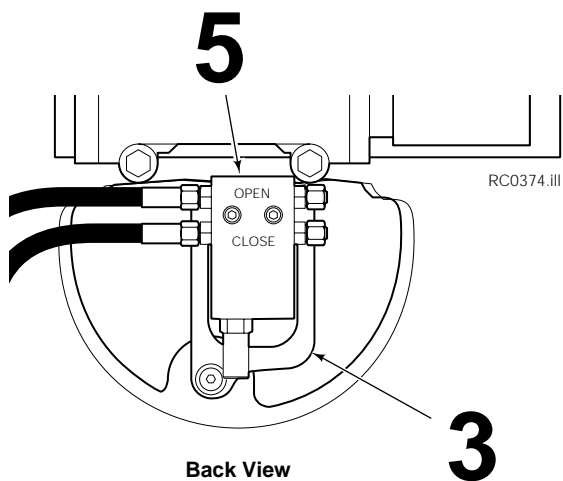
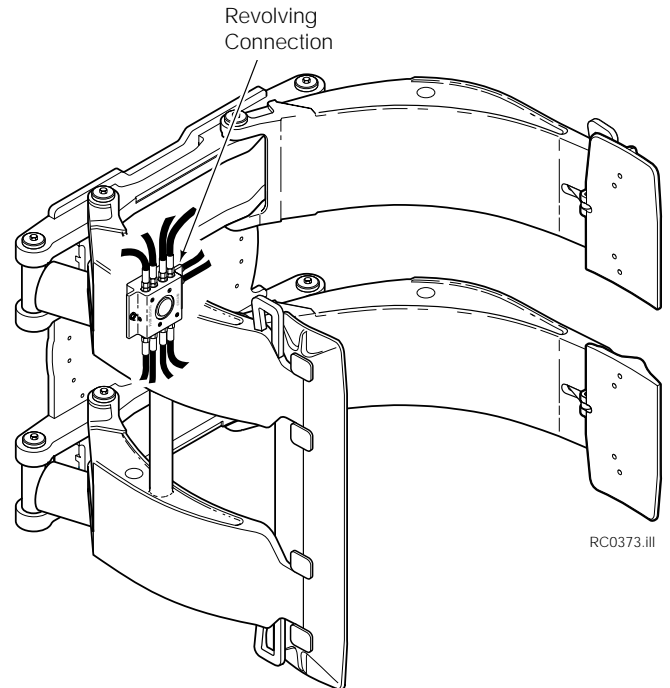
G-Series Paper Roll Clamp Revolving Connection Service Kit 212912

Revolving Connection Removal



WARNING: Before removing any hydraulic lines or components, relieve pressure in the hydraulic system. Turn the truck off, then move the truck auxiliary control valves several times in both directions.

- 1 Remove the Clamp from the lift truck.
- 2 Disconnect the hoses from the front and rear of the revolving connection. Tag hoses for reassembly.
- 3 Remove the yoke supporting the end block on the rear of the revolving connection. For reassembly, tighten the capscrew to 30 ft.-lbs. (40 Nm).
- 4 Remove the two capscrews and the revolving connection from the front of the Clamp. For reassembly, tighten the capscrews to 30 ft.-lbs. (40 Nm).
- 5 For reassembly, reverse the above procedures except as follows:
 - Position the revolving connection on the faceplate so that the stampings 'SHORT ARM' and 'LONG ARM' are facing the appropriate arms.
 - Rotate the end block/shaft assembly so that the stamping 'OPEN' is on top.



Part No. 212913 R-2

cascade®

For Technical Support . . .

Call: 1-800-CASCADE (227-2233)

OR

Write: Cascade Corporation, P.O. Box 20187, Portland, OR 97294-0187

To Order Parts . . .

Call: 1-888-CASCADE (227-2233)

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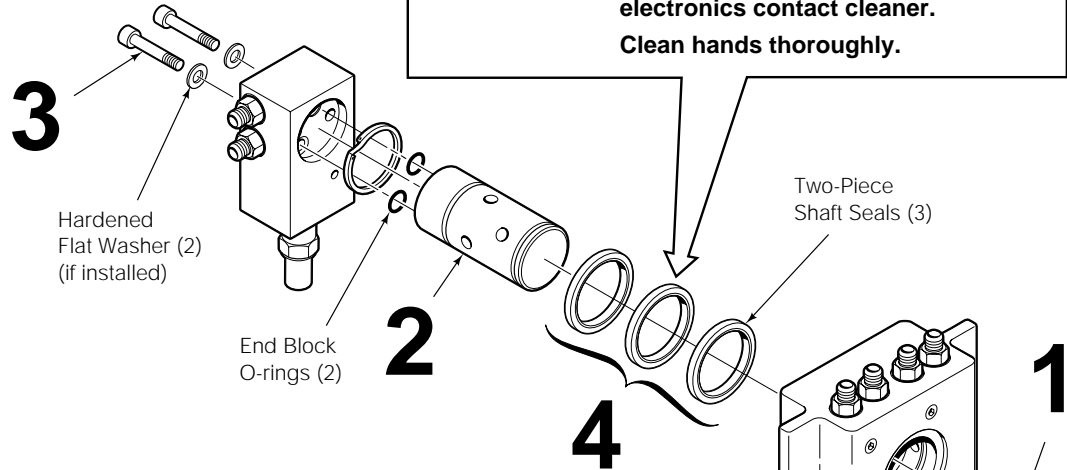
Write: Cascade Corporation, 2501 Sheridan Ave., Springfield, OH 45505

Revolving Connection Service

1 Remove the spiral retaining ring from the front of the shaft.

CAUTION: Remove all burrs and paint from the exposed shaft surface prior to removal from the body. **Burrs or paint chips pulled through the bore may permanently damage the body.**

2 Remove the shaft from the body.



3 Remove the end block from the shaft. For reassembly, apply Loctite 242 (blue) to the capscrews and tighten to 15 ft.-lbs. (20 Nm).

4 Remove the two-piece seals from the revolving connection body using a hook-type seal removal tool (Cascade part no. 674424) or a small, flat blunt screwdriver.

NOTE: Do not scratch or damage grooved surfaces.

5 Clean the parts with a noncorrosive solvent and inspect the following areas:

- Check the sealing surface of the shaft for minor surface imperfections. Remove with 320-grit emery paper. Sand the shaft radially, not along the length. If severely worn, replace the shaft.
- Check the seal grooves in the body for sharp nicks or projections. Remove minor imperfections with 320-grit emery paper. If severely worn, replace the body.
- Break the edges on the outer end of the shaft and the snap ring grooves with 320-grit emery paper.

6 For reassembly, reverse the previous procedures with the following exceptions:

- Install new O-rings between shaft and end block.
- Install square-section rubber rings into revolving connection body grooves.
- Install Teflon rings over rubber rings.

NOTE: Use internal seal installation tool (Cascade part number 599513) when installing new seals. If installing seals by hand, form seals into 'kidney' shape to avoid sharp bends that can permanently damage seals.

- Lubricate shaft and body with STP or petroleum jelly prior to reassembly.
- Start shaft loader (Cascade part number 221849) into body and carefully install shaft, displacing loader. Rotate body to ease installation.

