



# Installation Instructions

## 55F Sideshifter Bearing Conversion Kits 6000617 & 6000618

This sheet provides installation instructions to replace the cylinder/anchor bracket assembly and upper bearings on Cascade 55F Sideshifters. The Sideshifter must be removed from the truck to accomplish this procedure.

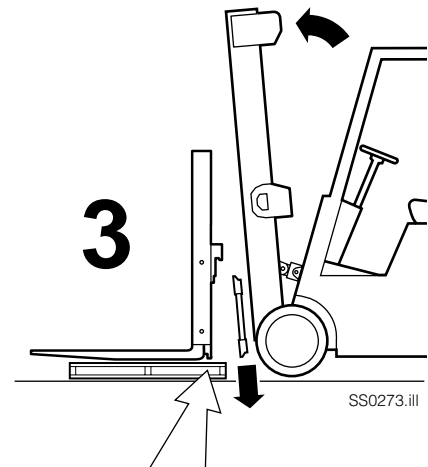
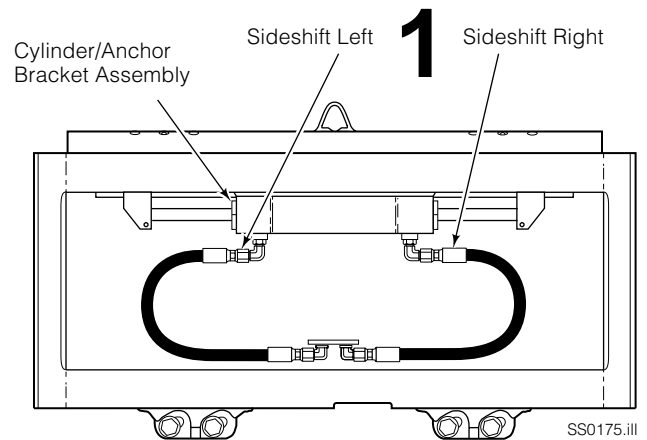
**A Bearing Conversion Kit is included whenever a new cylinder/anchor bracket is ordered.** Kits include upper bearings (Kit 6000617 for 2-bearing units, 6000618 for 4-bearing units), roll pins and metal stamps to change the Sideshifter Serial number code. New lower bearings or mounting hooks, if worn, should also be installed at this time.

**IMPORTANT:** This installation requires that the Sideshifter nameplate be modified by stamping a **revision code** at the end of the serial number. This will insure that correct replacement parts are ordered in the future.



**WARNING:** Before disconnecting hoses, relieve pressure in the attachment hydraulic system. Turn the truck off and move the truck control lever several times in both directions.

- 1 Disconnect the hoses from the cylinder. Tag hoses for reassembly.
- 2 Remove or disconnect the lower mounting hooks from the Sideshifter. For reassembly, adjust lower hook clearance as shown. Use a torque wrench and tighten the bolts to 120 ft.-lbs. (165 Nm). **CAUTION:** Lower hook clearance must be adjusted as shown for proper Sideshifter operation.
- 3 Set the Sideshifter down on a pallet and disengage the truck carriage from the Sideshifter upper hook as shown.



### 2

#### BOLT-ON

Truck Carriage

Sideshifter

→ F

Clearance:  
1/32 in. (0.8 mm) Min.  
1/16 in. (1.6 mm) Max.

Tighten bolts to  
120 ft.-lbs. (165 Nm).

#### QUICK-CHANGE

Reverse guides to reduce hook-to-carriage clearance.

5/8 in. (16 mm) offset on top provides max. clearance.

Tighten capscrews to  
120 ft.-lbs. (165 Nm)

**cascade**®  
corporation

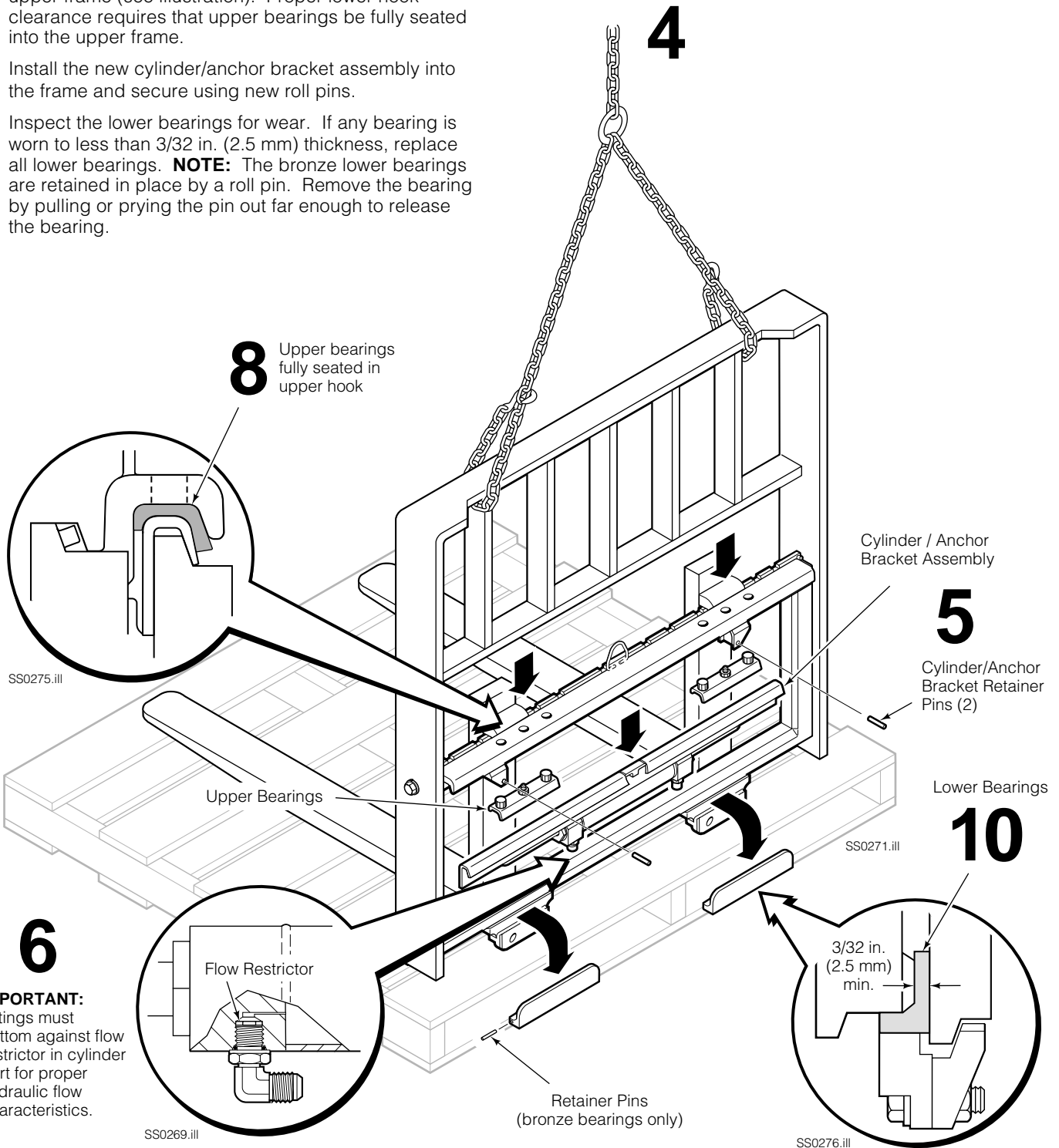
For Technical Support . . .

Call: 1-800-227-2233 Fax: 1-888-329-8207  
Internet: [www.cascorp.com](http://www.cascorp.com)  
Write: Cascade Corporation, PO Box 20187, Portland, OR 97294

To Order Parts . . .

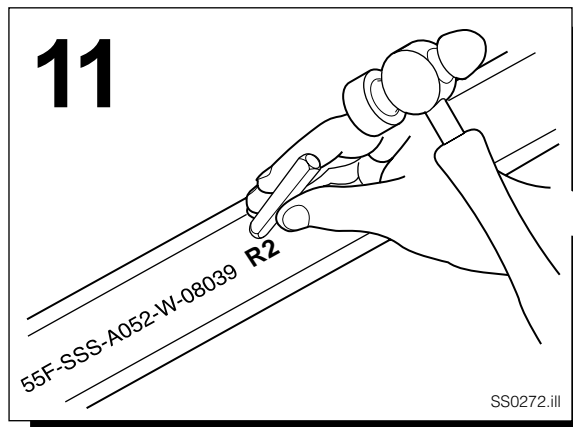
Call: 1-888-227-2233 Fax: 1-888-329-0234  
Internet: [www.cascorp.com](http://www.cascorp.com)  
Write: Cascade Corporation, 2501 Sheridan Ave., Springfield, OH 45505

- 4 Stabilize the Sideshifter on the pallet by attaching a 1000 lb. (450 kg) capacity overhead hoist as shown.
- 5 Remove the retainer pins and old cylinder/anchor bracket assembly from the frame.
- 6 Remove the fittings and flow restrictors from the old cylinder and install in the new cylinder ports.  
**IMPORTANT:** Assure that fittings and flow restrictor washers are installed as shown.
- 7 Remove the upper bearings from the Sideshifter frame by driving them out with a punch. Clean all bearing areas on the frame of built-up dirt and grease.
- 8 Install the new bearings. **IMPORTANT:** Use a wood block or plastic hammer to fully seat new bearings into upper frame (see illustration). Proper lower hook clearance requires that upper bearings be fully seated into the upper frame.
- 9 Install the new cylinder/anchor bracket assembly into the frame and secure using new roll pins.
- 10 Inspect the lower bearings for wear. If any bearing is worn to less than 3/32 in. (2.5 mm) thickness, replace all lower bearings. **NOTE:** The bronze lower bearings are retained in place by a roll pin. Remove the bearing by pulling or prying the pin out far enough to release the bearing.

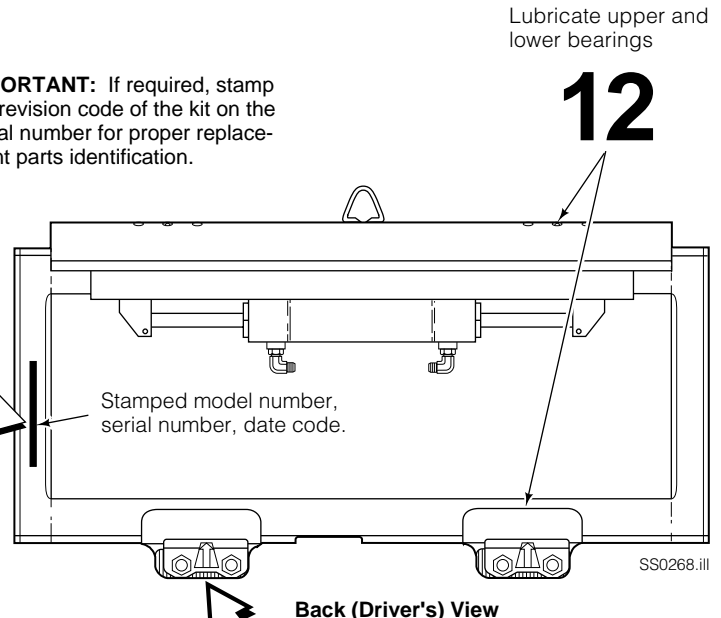


- 11** If the Sideshifter does not have a revision code, or if the code is R1, use the steel stamps provided in the kit to add the **R2 revision code** at the end of the Sideshifter's serial number (see illustration). If the revision code is R2 or higher, no stamping is required.

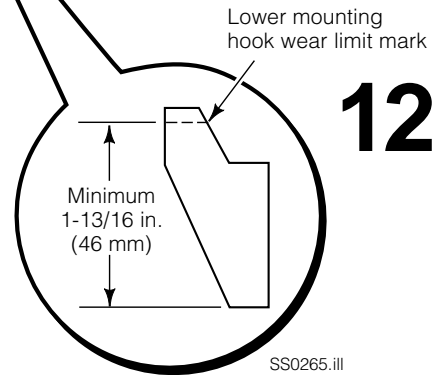
**NOTE:** The revision code can be identified by the letter 'R' followed by a number.



**IMPORTANT:** If required, stamp the revision code of the kit on the serial number for proper replacement parts identification.



**Back (Driver's) View**



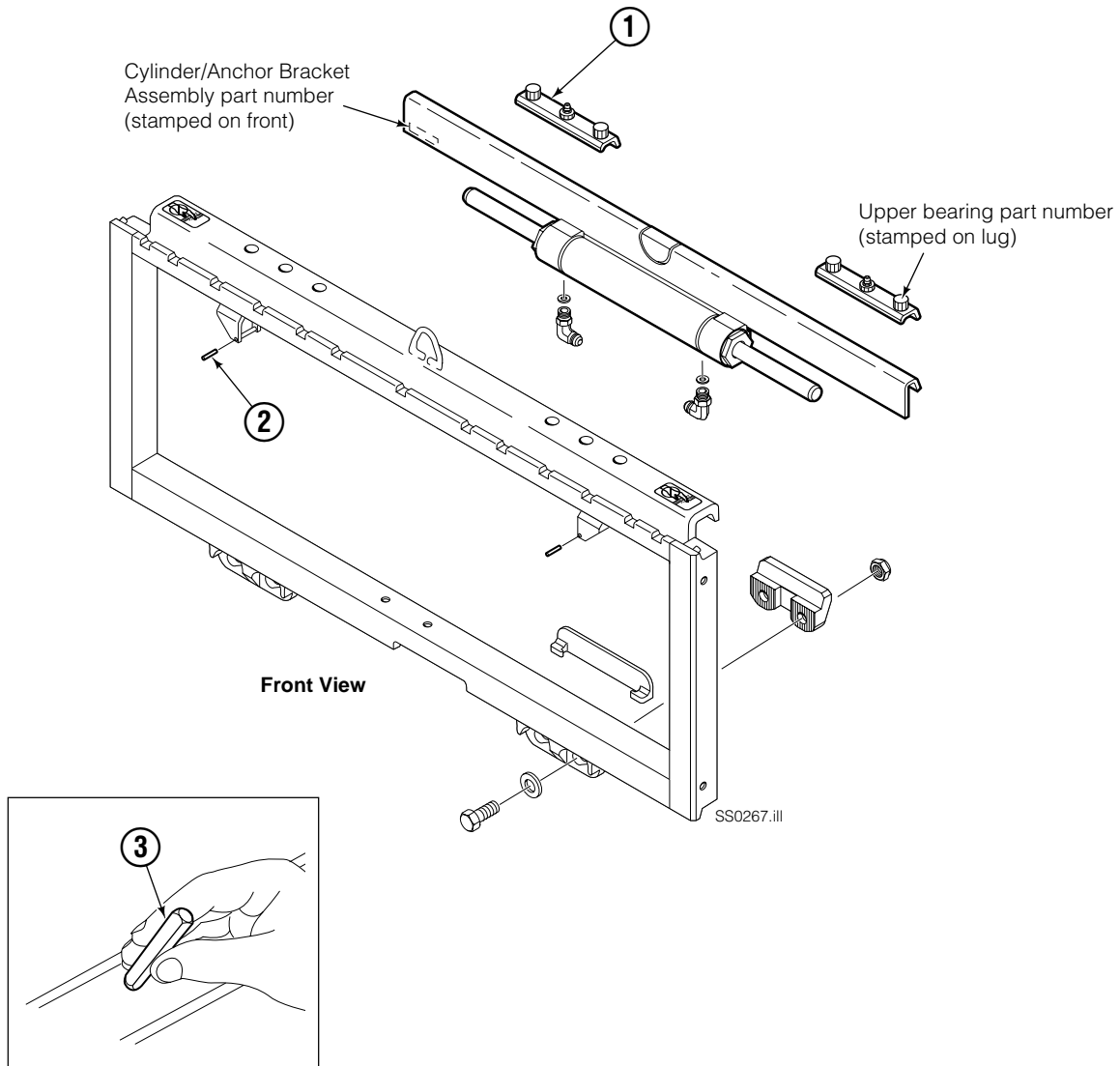
- 12** Prior to reinstalling the Sideshifter on the truck, accomplish the following:

- Clean and inspect truck carriage bars for damage and smoothness. Assure that bars are parallel and ends are flush. Repair any protruding welds that may affect Sideshifter lower bearings. Repair any damage to Sideshifter centering notch.
- Lubricate both upper and lower Sideshifter bearings with general-purpose lithium-based chassis grease.
- Inspect lower mounting hooks for wear (see illustration). Replace if necessary. Refer to Step 2 for hook adjustment procedure.



**WARNING:** After completing any service procedure, always test the Sideshifter through five complete cycles. First test empty, then test with a load to make sure the Attachment operates correctly before returning it to the job.

# Bearing Conversion Parts



55F			
REF	QTY	PART NO.	DESCRIPTION
		6000617	Bearing Conversion Kit (2 bearings)
		6000618	Bearing Conversion Kit (4 bearings)
1	▼	228782	Upper Bearing, Composite
2	2	7890	Roll Pin
3	1	6000613	Metal Stamp (R)
3	1	6000614	Metal Stamp (2)

▼ Quantity as required.  
Reference: S-10039