



Installation Instructions

D-Series Rotator and Revolving Clamp Bearing Kits 672481, 672482, 672483

This sheet provides instructions for D-Series Rotator and Revolving Clamp disassembly and installation of Bearing Service Kits 672481 (35D, 40D, 50D, 55D), 672482 (100D) and 672483 (125D).

1 ROTATORS

- Rotate the attachment to position the forks parallel to the ground.
- Remove the fork keepers at each end of the top carriage bar. For reassembly, tighten the capscrews to a torque of 50-60 ft.-lbs.
- Release the spring lock on the top of each fork. Remove the forks from the rotator.

REVOLVING CLAMPS

- Extend the arms. Lower the attachment to position the forks or arms $\frac{1}{2}$ in. above the floor. Remove the cotter pin, locking cap and nut retaining the cylinder rod to the lug.



WARNING: Make sure your overhead hoist has a rated lifting capacity of at least 1000 pounds.

- Attach a suitable overhead hoist and chain to the arm. Chain must be kept away from the arm bearing surface.
- Retract the cylinder rods until they come out of engagement with the arm lugs.
- Pull the arm assembly out of the frame.

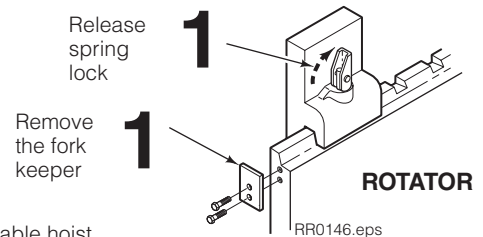
- 2** Remove the lower mounting hooks. For reassembly, tighten the capscrews to the torque values shown below.

35D/40D/50D/55D – 105-115 ft.-lbs.
100D/125D – 190-200 ft.-lbs.

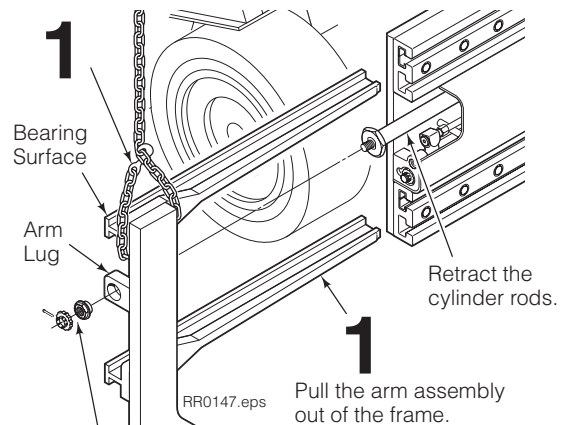


WARNING: Before removing any hoses, relieve pressure that might be present in the hydraulic system. With the truck off, open the truck auxiliary valve(s) several times in both directions.

- 3** Disconnect and plug the hydraulic hoses to the attachment. Tag the hoses for reassembly.

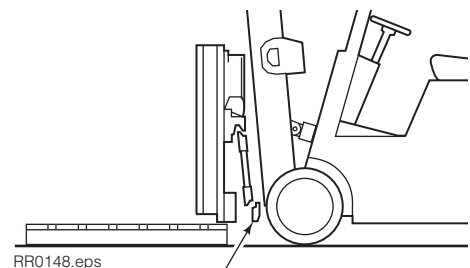


Attach a suitable hoist. Avoid arm bearing surface.



Remove cotter pin, locking cap, and nut.

Position fork or arms $\frac{1}{2}$ in. above the floor.



Remove lower mounting hooks.

cascade[®]
corporation

For Technical Support . . .

Call: 1-800-227-2233 Fax: 1-888-329-8207
Internet: 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
Write: Cascade Corporation, 2501 Sheridan Ave., Springfield, OH 45505



WARNING: Make sure your overhead hoist has a rated lifting capacity of at least 3500 pounds.

4 ROTATOR

- Attach a suitable overhead hoist to the upper fork bar.

REVOLVING CLAMP

- Install two eyebolts (½ in. – 13NC) in the frame and attach a suitable overhead hoist. Tilt the mast forward.

- Remove the attachment from the lift truck and place on a pallet.

6 125D ROTATORS

- Disconnect the crossover tubes from the check valve assembly.

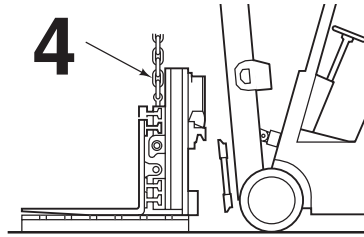
REVOLVING CLAMP

- Disconnect the two hydraulic tubes from the back of the revolving connection.
- Remove the revolving connection bracket. For reassembly, tighten capscrews to a torque of 6-10 ft.-lbs.

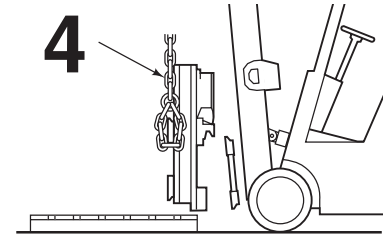
- Remove the four capscrews fastening the drive group to the baseplate. For reassembly, tighten the capscrews to a torque of 65-75 ft.-lbs.

- Remove the upper mounting hooks. For reassembly, tighten the capscrews to the torque values shown.

Install eyebolts and attach suitable chain hoist

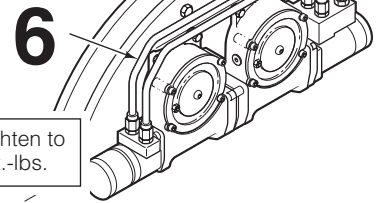


Attach suitable chain hoist



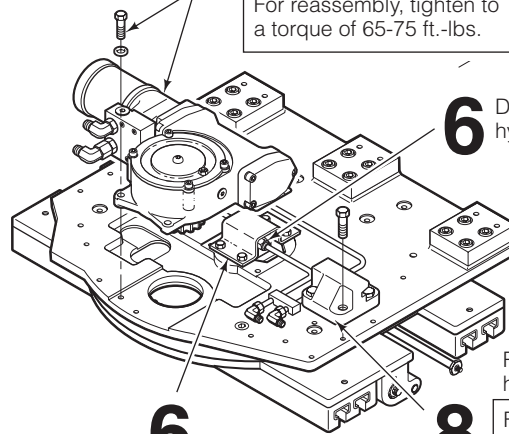
RR0149.eps

Remove crossover tubes.

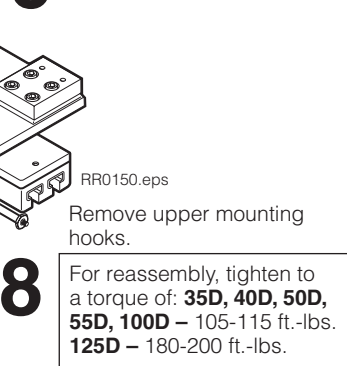


Remove the drive group.

For reassembly, tighten to a torque of 65-75 ft.-lbs.



Disconnect the hydraulic tubes.



RR0150.eps

Remove upper mounting hooks.

For reassembly, tighten to a torque of: **35D, 40D, 50D, 55D, 100D** – 105-115 ft.-lbs.
125D – 180-200 ft.-lbs.

Remove revolving connection bracket.

For reassembly, tighten to a torque of 6-10 ft.-lbs.

Attach an overhead hoist.

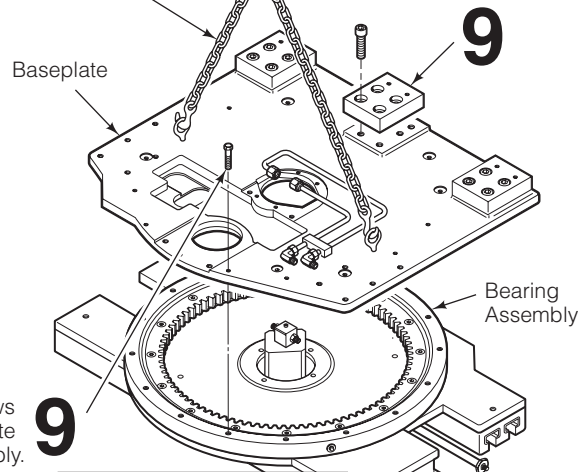
10

For reassembly, tighten to a torque of: **35D, 40D, 50D, 55D, 100D** – 65-75 ft.-lbs.
125D – 105-115 ft.-lbs.

Remove the lower center mounting spacer

- Remove the capscrews fastening the baseplate to the bearing assembly. For reassembly, tighten the capscrews to the torque values shown. Remove the lower mounting spacers if necessary to gain access to all of the capscrews. For reassembly, tighten capscrews to the torque values shown.

- Attach two eyebolts to the baseplate. Attach an overhead hoist and lift away the baseplate.



Remove capscrews fastening baseplate to bearing assembly.

9

For reassembly, tighten to a torque of: **35D, 40D, 50D, 55D, 100D** – 65-75 ft.-lbs.
125D – 200-220 ft.-lbs.

RR0151.eps

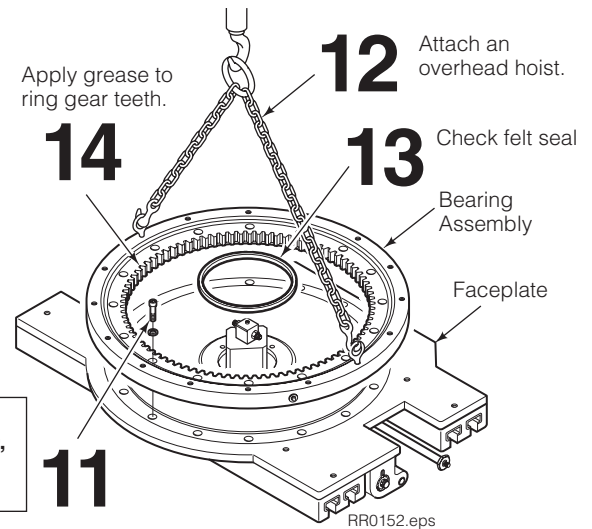
- 11** Remove the capscrews fastening the bearing assembly to the faceplate. New capscrews are supplied with each bearing service kit and must be installed. For reassembly, tighten the new capscrews to the torque values shown.
- 12** Attach two eyebolts to the bearing assembly. Attach an overhead hoist and lift away the bearing assembly.

13 REVOLVING CLAMPS

- Check condition of the faceplate center hole felt seal. Replace if necessary.

Remove capscrews fastening bearing assembly to faceplate.

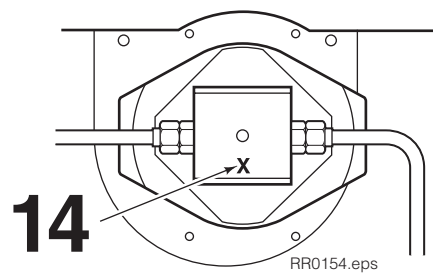
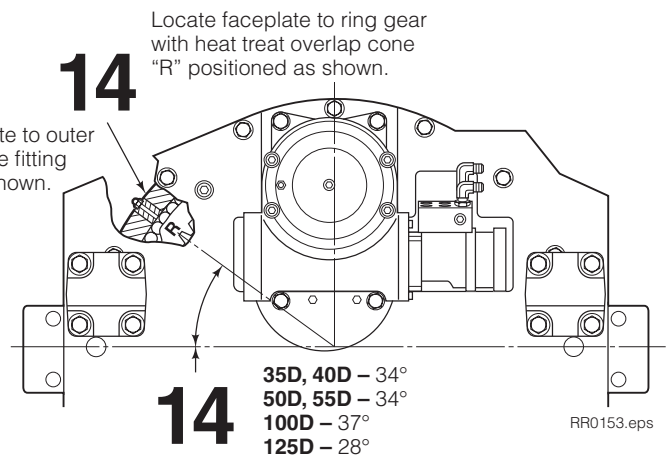
For reassembly, tighten to a torque of: **35D, 40D, 50D, 55D, 100D** – 65-75 ft.-lbs.
125D – 120-135 ft.-lbs.



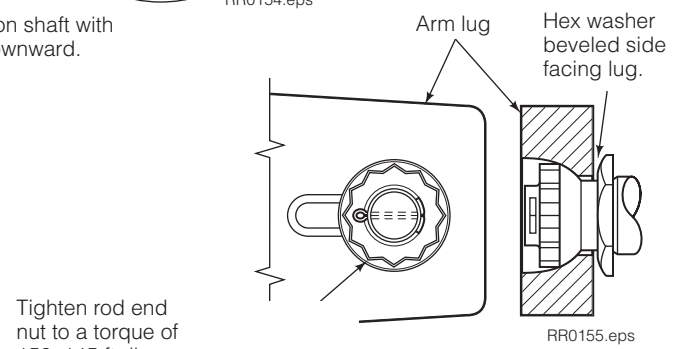
- 14** For reassembly, reverse the above procedures except as follows:
- Position the bearing assembly ring gear heat treat overlap zone "R" and outer race grease fitting as shown before bolting to the faceplate.
 - Apply NLGI No. 0 grease to the teeth of the bearing assembly ring gear before installing the baseplate.

• REVOLVING CLAMPS

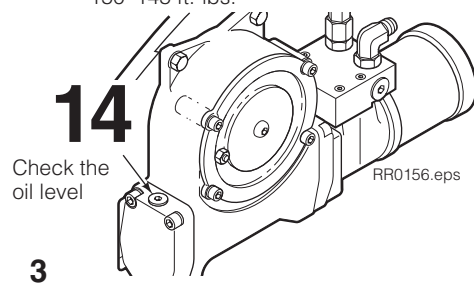
- The "x" stamped into the back surface of the revolving connection shaft must be placed in the downward position before reconnecting the hydraulic tube fittings.
 - Lubricate the cylinder rod threads, nut threads and spherical portion of nut with STP. Install the hex washer on the rod end with the beveled side facing the lug. Engage the rod end into the lug.
 - Tighten the rod end nut to a torque of 150-175 ft.-lbs. Prevent the rod from turning by using a wrench on the hex washer.
- NOTE:** The rod end nut is being tightened against the hex washer. The nut will not be tight against the arm lug. The looseness allows for cylinder alignment during clamping.
- Install the locking cap and cotter pin.
 - Lubricate the bearing portion of the arm bars with a thin film of chassis grease.



Position shaft with "x" downward.



Tighten rod end nut to a torque of 150-145 ft.-lbs.



Check the oil level

Do you have questions you need answered right now? Call your nearest Cascade Service Department. Visit us online at www.cascorp.com

AMERICAS

**Cascade Corporation
U.S. Headquarters**
2201 NE 201st
Fairview, OR 97024-9718
Tel: 800-CASCADE (227-2233)
Fax: 888-329-8207

Cascade Canada Inc.
5570 Timberlea Blvd.
Mississauga, Ontario
Canada L4W-4M6
Tel: 905-629-7777
Fax: 905-629-7785

Cascade do Brasil
Rua João Guerra, 134
Macuco, Santos - SP
Brasil 11015-130
Tel: 55-13-2105-8800
Fax: 55-13-2105-8899

EUROPE-AFRICA

**Cascade Italia S.R.L.
European Headquarters**
Via Dell'Artigianato 1
37030 Vago di Lavagno (VR)
Italy
Tel: 39-045-8989111
Fax: 39-045-8989160

Cascade (Africa) Pty. Ltd.
PO Box 625, Isando 1600
60A Steel Road
Sparton, Kempton Park
South Africa
Tel: 27-11-975-9240
Fax: 27-11-394-1147

ASIA-PACIFIC

Cascade Japan Ltd.
2-23, 2-Chome,
Kukuchi Nishimachi
Amagasaki, Hyogo
Japan, 661-0978
Tel: 81-6-6420-9771
Fax: 81-6-6420-9777

Cascade Korea
121B 9L Namdong Ind.
Complex, 691-8 Gojan-Dong
Namdong-Ku
Inchon, Korea
Tel: +82-32-821-2051
Fax: +82-32-821-2055

Cascade-Xiamen
No. 668 Yangguang Rd.
Xinyang Industrial Zone
Haicang, Xiamen City
Fujian Province
P.R. China 361026
Tel: 86-592-651-2500
Fax: 86-592-651-2571

**Cascade India Material
Handling Private Limited**
No 34, Global Trade Centre
1/1 Rambaugh Colony
Lal Bahadur Shastri Road,
Navi Peth, Pune 411 030
(Maharashtra) India
Phone: +91 020 2432 5490
Fax: +91 020 2433 0881

Cascade Australia Pty. Ltd.
1445 Ipswich Road
Rocklea, QLD 4107
Australia
Tel: 1-800-227-223
Fax: +61 7 3373-7333

Cascade New Zealand
15 Ra Ora Drive
East Tamaki, Auckland
New Zealand
Tel: +64-9-273-9136
Fax: +64-9-273-9137

**Sunstream Industries
Pte. Ltd.**
18 Tuas South Street 5
Singapore 637796
Tel: +65-6795-7555
Fax: +65-6863-1368

