



PRODUCT SUPPORT

BULLETIN NO. 234

DATE: December 8, 1995

MACHINE: AUTO-LIFTS

PRODUCTION DATES: ALL

SUBJECT: RAIL CLAMP BRACKET KIT
NORDCO P/N: 9879 0005

Responding to concerns regarding rail clamp brackets wearing out, we have developed a new rail clamp bracket that has been reinforced and has replaceable clamp plates that can be re-ordered when worn out.

These kits are designed to be installed in your shop, but can be installed in the field with only a minimum of difficulty. Welding is required for cutting off original bracket and welding on new mounting brackets. The kit includes all parts for both sides of the machine and the instructions necessary to install on your existing Auto-Lifts.

Please contact your Nordco Representative or Nordco Parts Sales for prices, availability and lead-times required.

**Installation Instructions for
RAIL CLAMP BRACKET
Kit No. 9879 0005**

1. Place hydraulic lift (or other suitable lifting device) under existing rail clamp housing (Item A in Figure 4, attached).

NOTE: All items removed during this installation, with the exception of the clamp housing being torched off, will be reused in later steps.

2. With the lift supporting the weight of the Rail Clamp Assembly, remove pin and hairpin cotter (Item #'s 8 and 9 on Figure 4). This will cause the weight of the assembly to rest on the lockpin and pin (Item #'s 14 and 27 on Figure 4).

WARNING!



The following step will cause the rail clamp assembly to rest on the hydraulic lift, with no other means of support. To avoid personal injury caused by the assembly falling off lift, make certain that lift can support the weight of the assembly and IS SUPPORTING the weight of the assembly.

3. Remove 1/2" hoses from the clamp cylinder. Plug hoses with hose plugs included in kit.
4. Remove the lockpin and pin (Item #'s 13, 14, 15, 27 and 28 on Figure 4). Allow assembly to rest on lift. Lower assembly and remove from immediate area.
5. Remove rail clamp cylinder hardware (Item #'s 4, 5 and 6 in Figure 4). Place these items with the clamp assembly removed under Step 3.

CAUTION!



Do not use Air Arc for the following steps. Use of Air Arc will cause frame cross tubes to warp, causing damage to the machine frame.

6. Torch around frame cross tube leaving 1/2" to 3/4" of existing rail clamp housing weldment attached to frame. Remove old rail clamp housing.
7. Trim off remaining material using care NOT to use excessive heat. This may cause frame cross tube to warp. Grind surface smooth, allow surface to cool.

- 8. Slide new rail clamp bracket onto frame cross tubes. Repeat Steps 1 through 8 for other side.**
- 9. The new clamp bracket centerline is 3.735" from the outside of the main frame (see Drawing 9679 0170 - Top View for dimensions).**
- 10. Apply a 1/4" fillet weld around all edges where the rail clamp bracket comes in contact with the frame cross tubes. Welding may cause slight warpage of the bracket. Make certain that the 6.25" +/- .030" dimension holds for 12 inches from the bottom of the bracket. Rail Clamp Assembly will not fit if dimensions are not held.**
- 11. Take rail clamp assembly items removed in Steps 4 and 5 and add the new rail clamp plate as shown in the drawing attached.**
- 12. Remount the cylinder to the new bracket. Tighten hardware.**
- 13. Slide assembly under new housing. Lift assembly so that you can re-insert the lockpin and pin removed in Step 3. This will hold the assembly in place so that you can attach the plate to the new bracket.**
- 14. Attach plate to bracket using the hardware provided in this kit. Test clamp assembly to make sure clamp mechanism moves freely up and down in the slots on the plate. Too much clearance between shoulder bushing and bracket will require adding shims as needed. If clearance is ok, torque nuts to 60 lbs. Ft.**
- 15. Repeat Steps 9 through 14 for other side. Make certain centerline distance is maintained.**