

****NOTE (FOR KIT #793114)**
 SHEET 1: OVERVIEW OF WORK
 SHEET 2: REMOVAL
 SHEET 3: INSTALLATION VIEWS
 SHEET 4: INSTALLATION VIEWS
 SHEET 5: HYDRAULIC SCHEMATIC

THESE INSTRUCTIONS ARE FOR KIT 793114

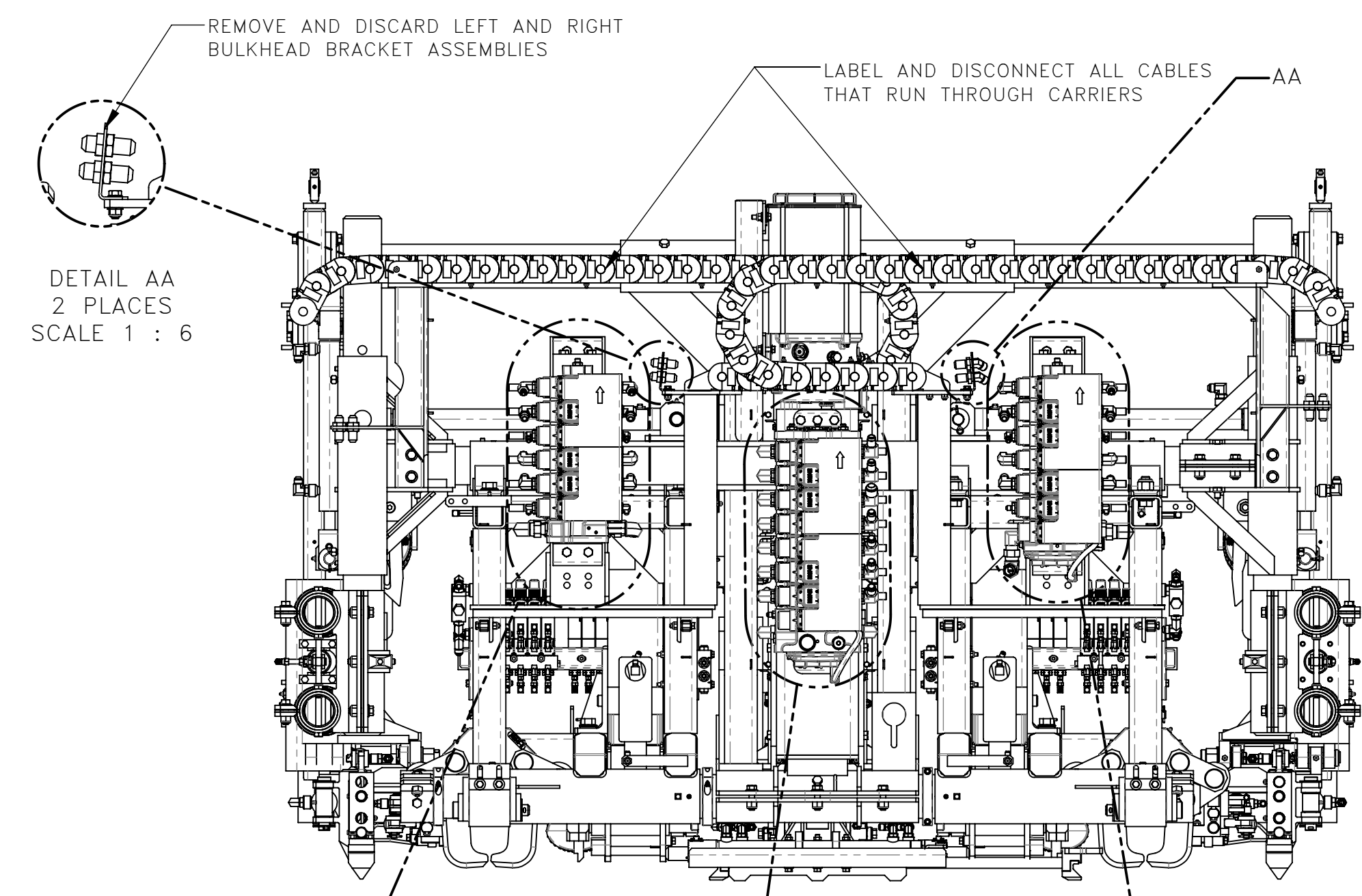
REMOVAL: (SHEET 2)

1. POWER OFF MACHINE AND TAG OUT BEFORE PERFORMING CONVERSION
2. DRAIN ALL HYDRAULIC FLUID FROM WORKHEAD TOOLING.
3. DISCONNECT AND DISCARD ALL HYDRAULIC HOSES ONLY
4. DISCONNECT ALL CABLES & DISCARD CARRIERS (SEE SHEET 2: FRONT VIEW)
5. REMOVE GUIDE ROLLERS (4 PLACES) AND KEEP FASTENERS (SEE SHEET 2: REAR VIEW)
6. REMOVE AND DISCARD LEFT AND RIGHT BULKHEAD BRACKETS ASSEMBLIES (SEE SHEET 2: DETAIL AA)
7. REMOVE LEFT, RIGHT, AND CENTER WORKHEAD VALVE GUARDS WITH MOUNTING BRACKETS (SEE SHEET 2: FRONT ISO VIEW)
8. DISCONNECT CABLES CONNECTED TO LEFT, RIGHT, AND CENTER VALVES. REMOVE LEFT, RIGHT, AND CENTER WORKHEAD VALVES (SEE SHEET 2: DETAIL AB (RIGHT), DETAIL AC (CENTER) & DETAIL AD (LEFT))
9. REMOVE AND DISCARD LEFT AND RIGHT BULKHEAD PLATES ASSEMBLIES (SEE SHEET 2: DETAIL AE)
10. REMOVE LOWER PLATE CLAMPS FROM FRONT/BACK GUIDES (SEE SHEET 2: DETAIL AF)
11. REMOVE FRONT/BACK GUIDE HORIZONTAL CYLINDER AND KEEP EXISTING FASTENERS (SEE SHEET 2: DETAIL AF)
12. DISCONNECT WIRING FROM FRONT/BACK GUIDE HORIZONTAL CYLINDER IF NECESSARY (SEE SHEET 2: DETAIL AF)
13. REMOVE AND KEEP EXISTING FASTENERS AND SPACERS FROM TUBE CLAMPS (SEE SHEET 2: DETAIL AF)
14. SLIDE TUBES OFF THE FRONT/BACK GUIDES UNTIL ABLE TO REMOVE GUIDES KEEP TUBES RETAINED IN ONE SIDE OF CLAMPS (SEE SHEET 2: DETAIL AE)
15. CUT CARRIER WELDMENT AND CLEAN UP APPROX. 4 X 7.25 AREAS PER SIDE (SEE SHEET 3: TOP VIEW)

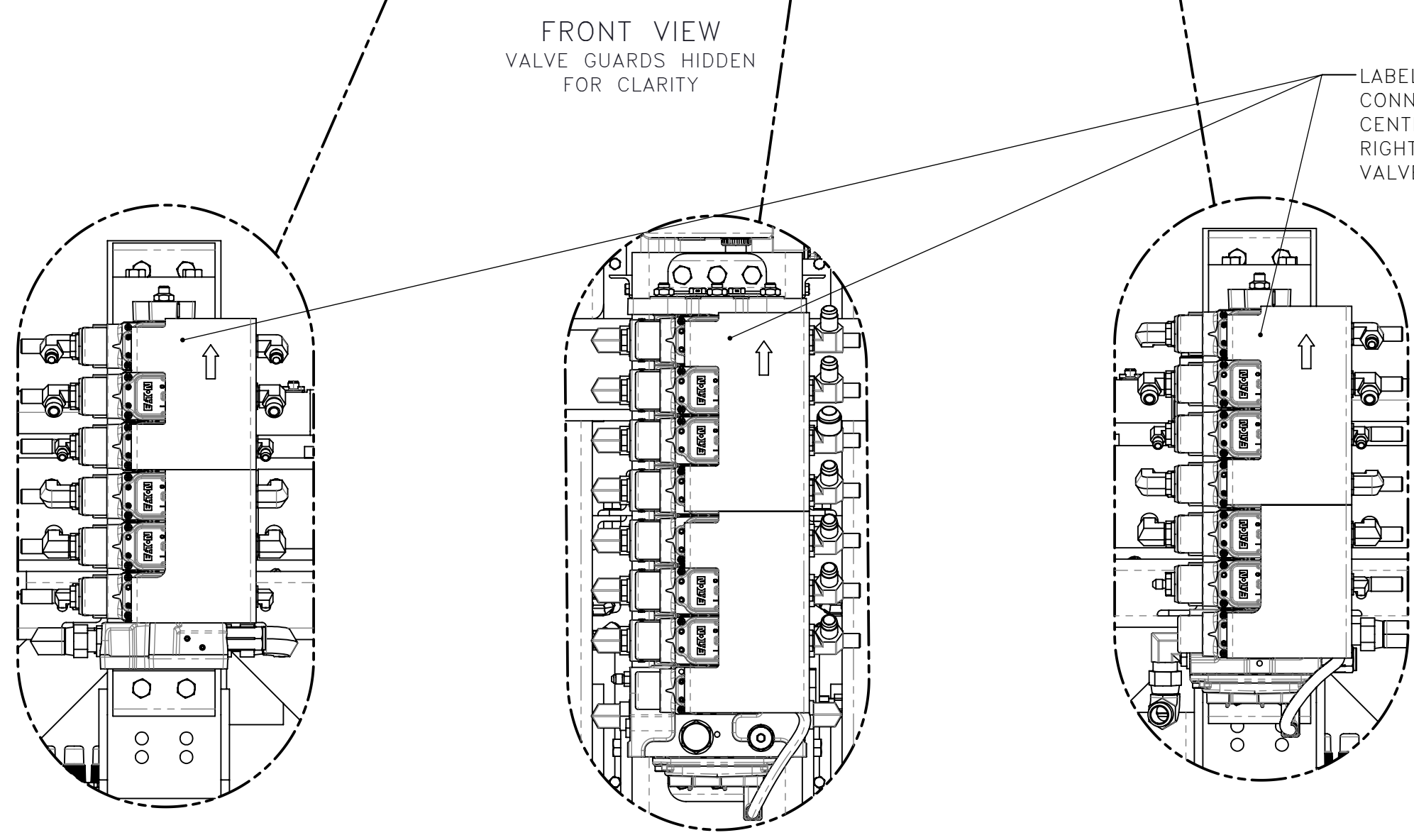
INSTALLATION: (SHEET 4 TO 5)

1. WELD FLAT (319735) TO ANGLE (397887) (SEE SHT 3: CARRIER WELDMENTS)
2. WELD FLAT (319734) TO ANGLE (397890) (SEE SHT 3: CARRIER WELDMENTS)
3. WELD ANGLE (397887) TO RIGHT SIDE (SEE SHT 3: DETAIL BA & TOP VIEW)
4. WELD ANGLE (397890) TO LEFT SIDE (SEE SHT 3: DETAIL BA & TOP VIEW)
5. REPAINT SURFACES AFTER WELDING
6. REPLACE EXISTING GUIDE ROLLERS WITH NEW GUIDE ROLLER (719850) 4 PLACES. USE EXISTING HARDWARE (SEE SHT 3: DETAIL BB)
7. MOUNT NEW LEFT CARRIER BRACKET (781566) AND RIGHT CARRIER BRACKET (781567) WITH SPECIFIED FASTENERS. INSTALL SPECIFIED FITTINGS (SEE SHT 3: DETAIL BD; SECT. BF)
8. INSTALL CHECK VALVE (719034) PER SIDE (SEE SHT 3: DETAIL BE)
9. BEFORE LEFT AND RIGHT WORKHEAD VALVES CAN BE INSTALLED, DRILL ADDITIONAL MOUNTING HOLES IN LEFT AND RIGHT WELDMENT VALVE MOUNTS AS SHOWN ON SHT 3: DETAIL BC
10. MOUNT LUBE BRACKET (397805) WITH ADAPTER (459891) AND GREASE ZERK (401987) (SEE SHT 4: DETAL BM)
11. MOUNT NEW LEFT WORKHEAD VALVE (718836) TO VALVE MOUNT AND CONNECT CABLES PER WIRING, WORKHEAD (720119) (SEE SHT 4: SECT. BJ-BJ)
12. MOUNT NEW RIGHT WORKHEAD VALVE (718837) TO VALVE MOUNT AND CONNECT CABLES PER WIRING, WORKHEAD (720119) (SEE SHT 4: SECT. BK-BK)
13. MOUNT NEW CENTER WORKHEAD VALVE (718842) AND CONNECT CABLES PER WIRING, WORKHEAD (720119) (SEE SHEET 5: SECTION BL-BL)
14. INSTALL NEW LEFT AND RIGHT CABLE/HOSE CARRIERS WITH EXISTING CABLES (SEE SHT 3: FRONT ISO VIEW)
15. INSTALL NEW LEFT BULKHEADS (719306) AND NEW RIGHT BULKHEADS (719307) ASSEMBLIES (SEE SHT 3: DETAIL BP)
16. INSTALL (QTY: 1 PER EACH MECHANISM) NEW 90° ELBOW (459906), ADAPTER (459891) AND GREASE ZERK (401987) ON LEFT AND RIGHT MECHANISMS (SEE SHT 3: DETAIL BN)
17. RE-INSTALL LEFT, RIGHT, AND CENTER VALVE GUARDS. USE NEW PLATE (319492) ON CENTER GUARD (SEE SHEET 4: FRONT ISO VIEW)
18. INSTALL NEW FRONT/BACK GUIDES ON TO TUBES (SHT 4: SECT. BG)
19. THEN SLIDE TUBES THROUGH CLAMPS AND REFASTEN WITH EXISITING FASTENERS (SHT 4: SECT. BG)
20. ATTACH FRONT/BACK GUIDE CYLINDER WITH EXISITING FASTENERS (SHT 4: SECT. BG)
21. RECONNECT LABELED WIRING CONNECTION ON FRONT/BACK GUIDE HORIZONTAL CYLINDER (SHT 4: SECT. BG)
22. INSTALL NEW PLATE CLAMPS WITH CLEVIS PINS. (SHT 4: SECT. BH)
23. MARK WITH LUBE BLUE ARROWS ALL WORKHEAD GREASE FITTINGS AS NECESSARY
24. INSTALL NEW CMA HYDRAULIC HOSES SEE SHT 5
25. INSTALL ALL OTHER HYDRAULIC HOSES PER 718797 PLUMBING, WORKHEAD HYDRAULIC
26. RECONNECT ALL LABELED ELECTRICAL CABLES PER 720119 WIRING, WORKHEAD AND 720118 SCHEMATIC, ELECTRIC
27. REFILL HYDRAULIC FLUID LEVELS & PRIME LINES AS NECESSARY

REV	EN	DESCRIPTION	DATE	DRN
1	5726	NEW RELEASE	6-21	ML
DIMENSION TOLERANCES UNLESS OTHERWISE SPECIFIED				
LINEAR		.XX=±.03	.XXX=±.010	
ANGULAR		X' = ±1'	X.X' = ±.5'	
SURFACE FINISH 125/√			SMOOTH ALL SHARP EDGES CLEAN ALL WELDS	
THIS PRINT AND ALL INFORMATION WITHIN BELONGS TO RACINE RAILROAD PRODUCTS				
RACINE RAILROAD PRODUCTS RACINE, WISCONSIN USA				
DESCRIPTION INSTRUCTIONS, WORKHEAD RETROFIT KIT				
MATERIAL REFERENCE				
USED ON			SCALE	DATE
			1:12	06-29-21
DRN	CHK	APP	JOB NO	SHEET
ML				1 OF 5
DWG SIZE	CATALOG	DWG NO		
D	N		800355	



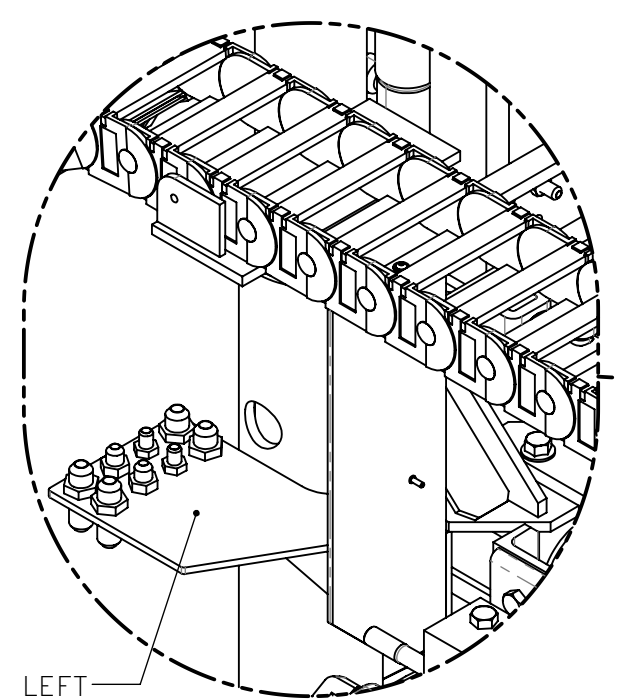
DETAIL AA
2 PLACES
SCALE 1 : 6



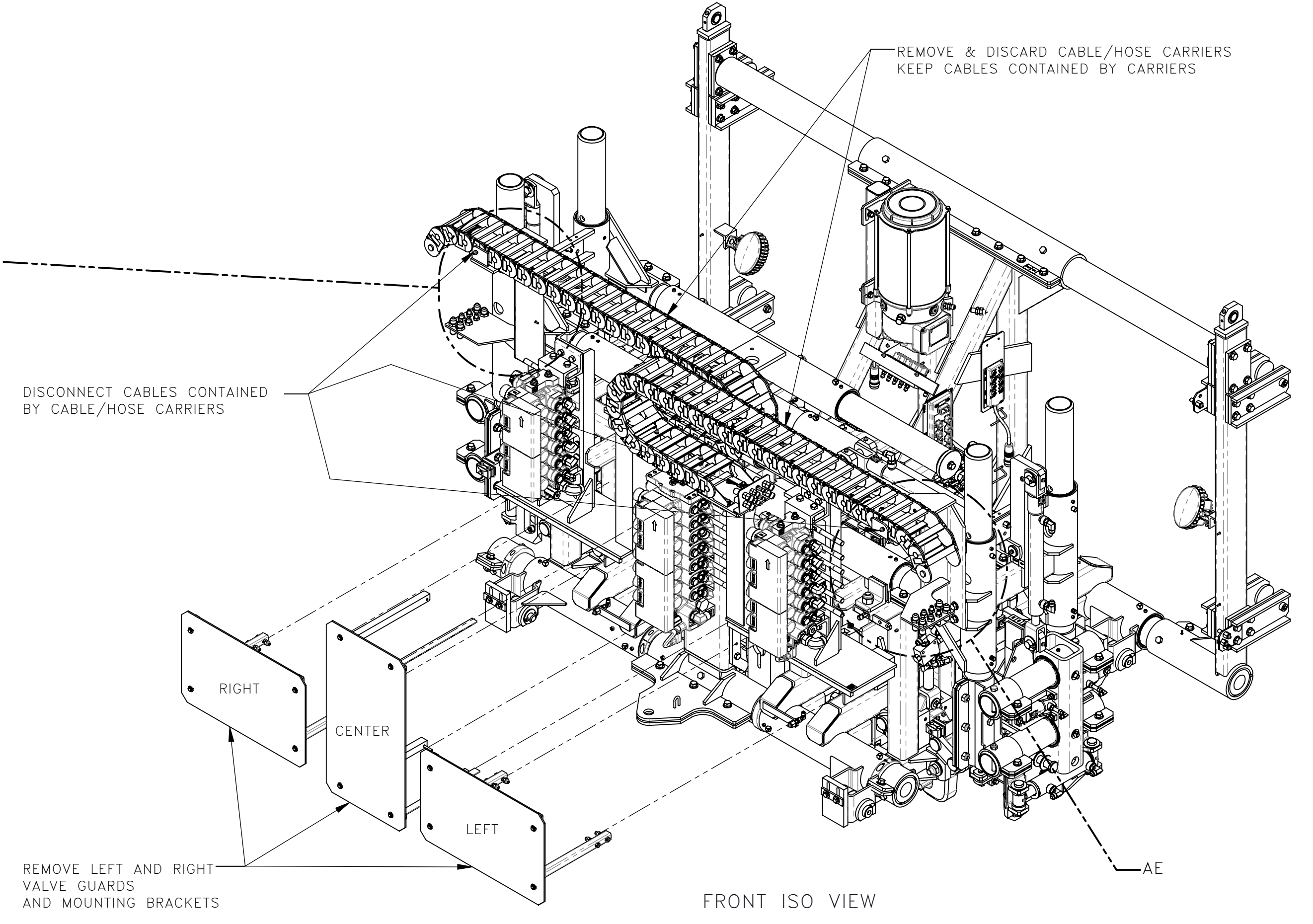
DETAIL AB
RIGHT
SCALE 1 : 6

DETAIL AC
CENTER
SCALE 1 : 6

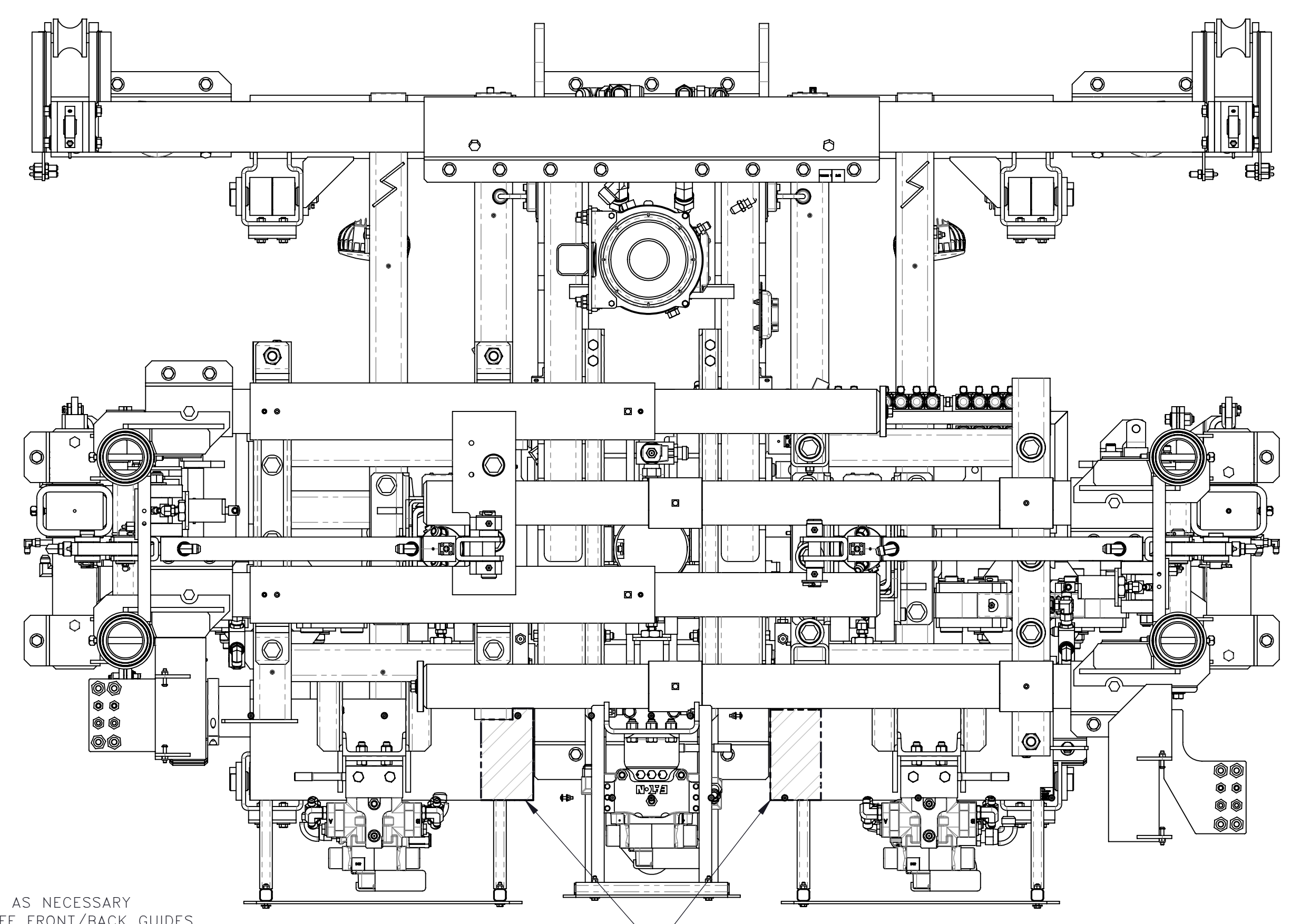
DETAIL AD
LEFT
SCALE 1 : 6



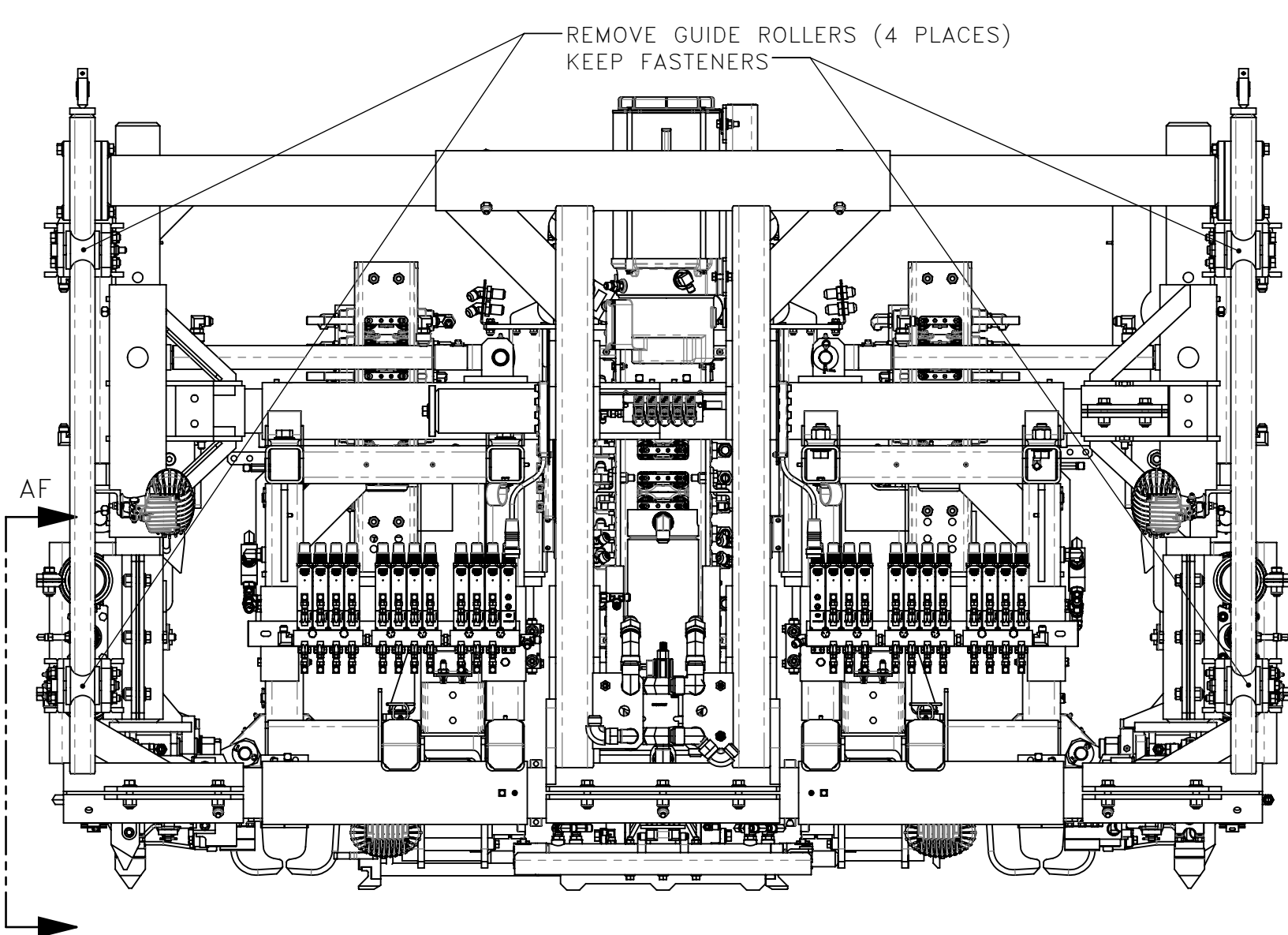
DETAIL AE
2 PLACES
SCALE 1 : 6



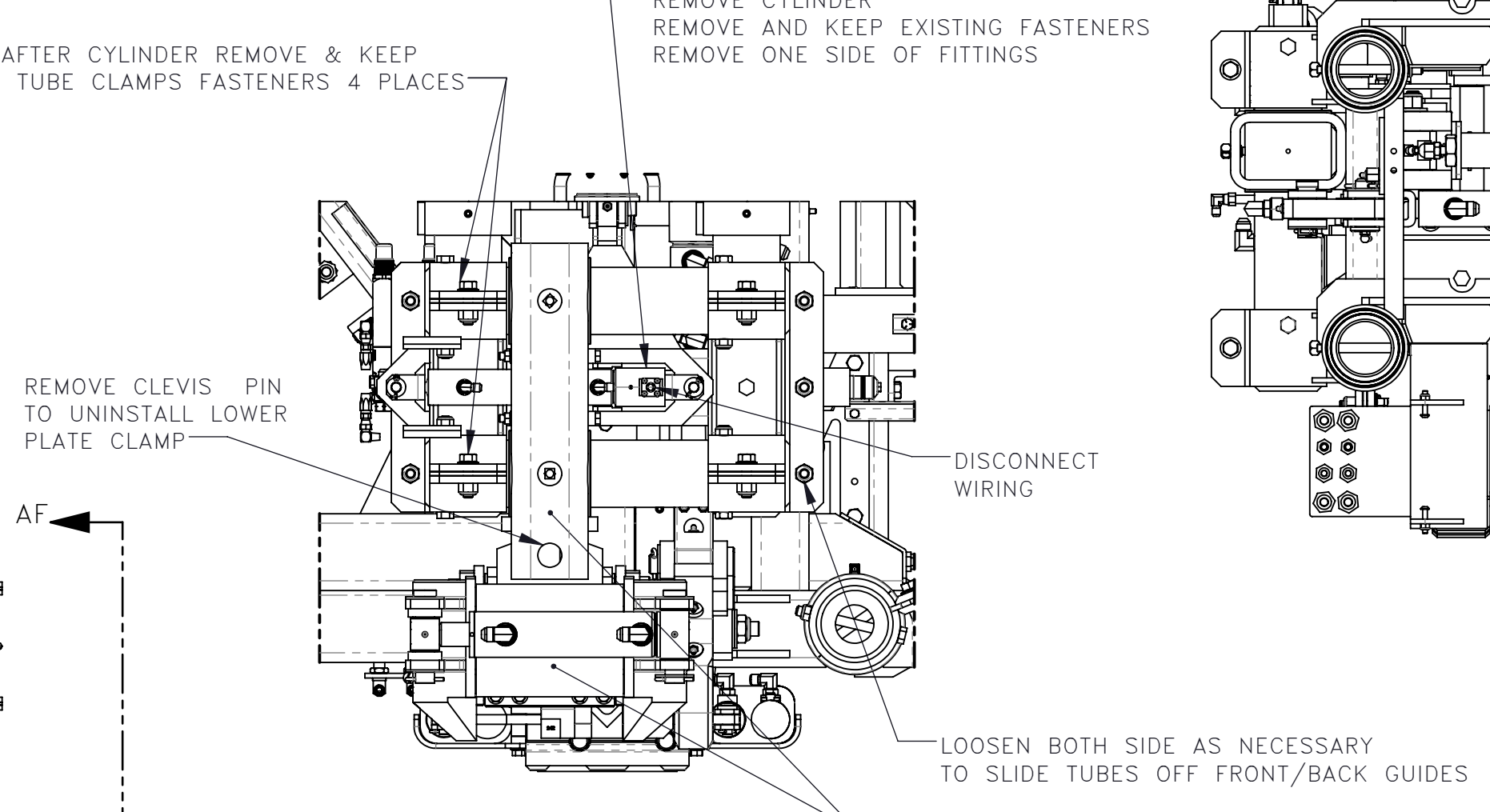
FRONT ISO VIEW



TOP VIEW

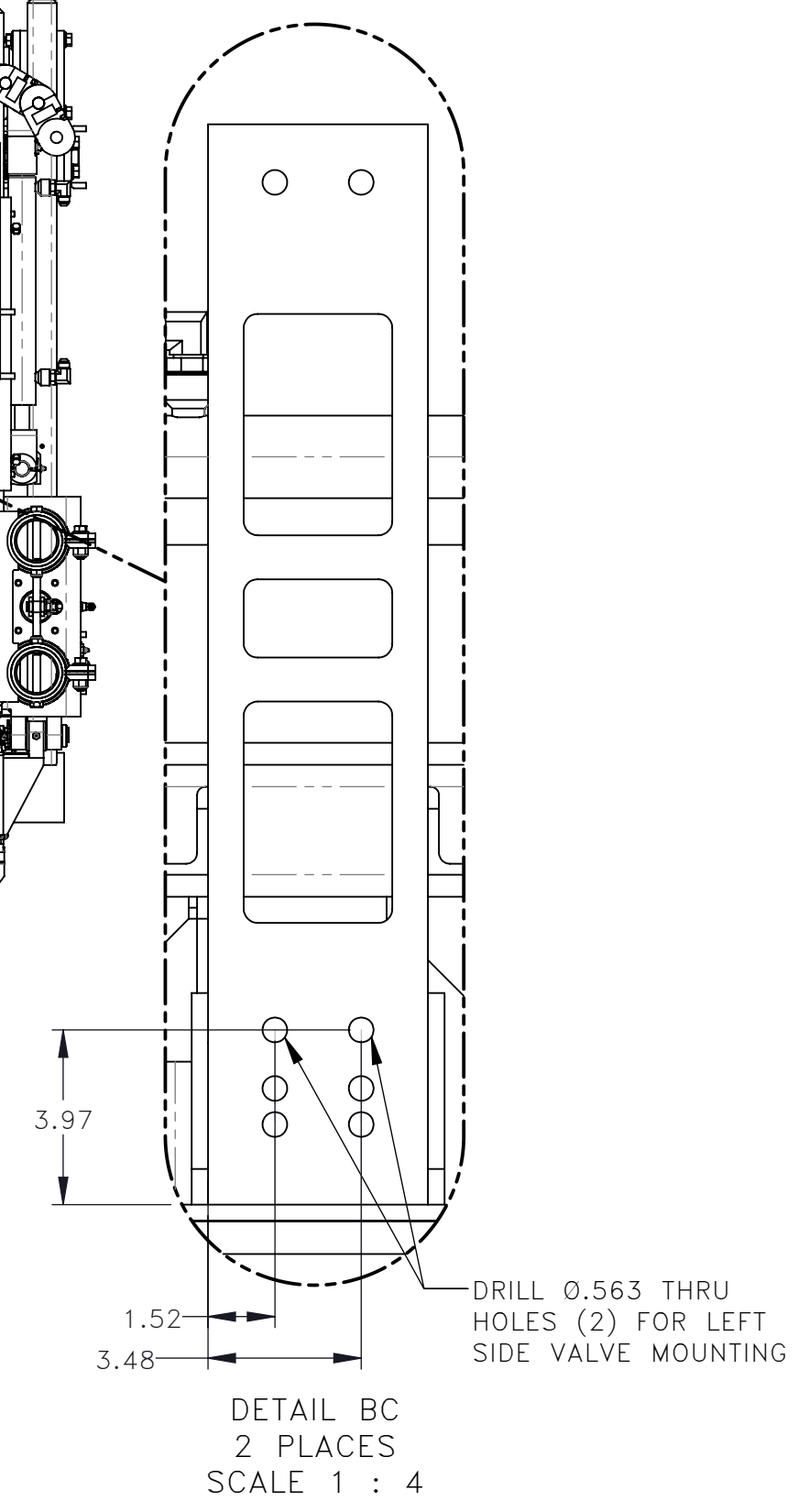
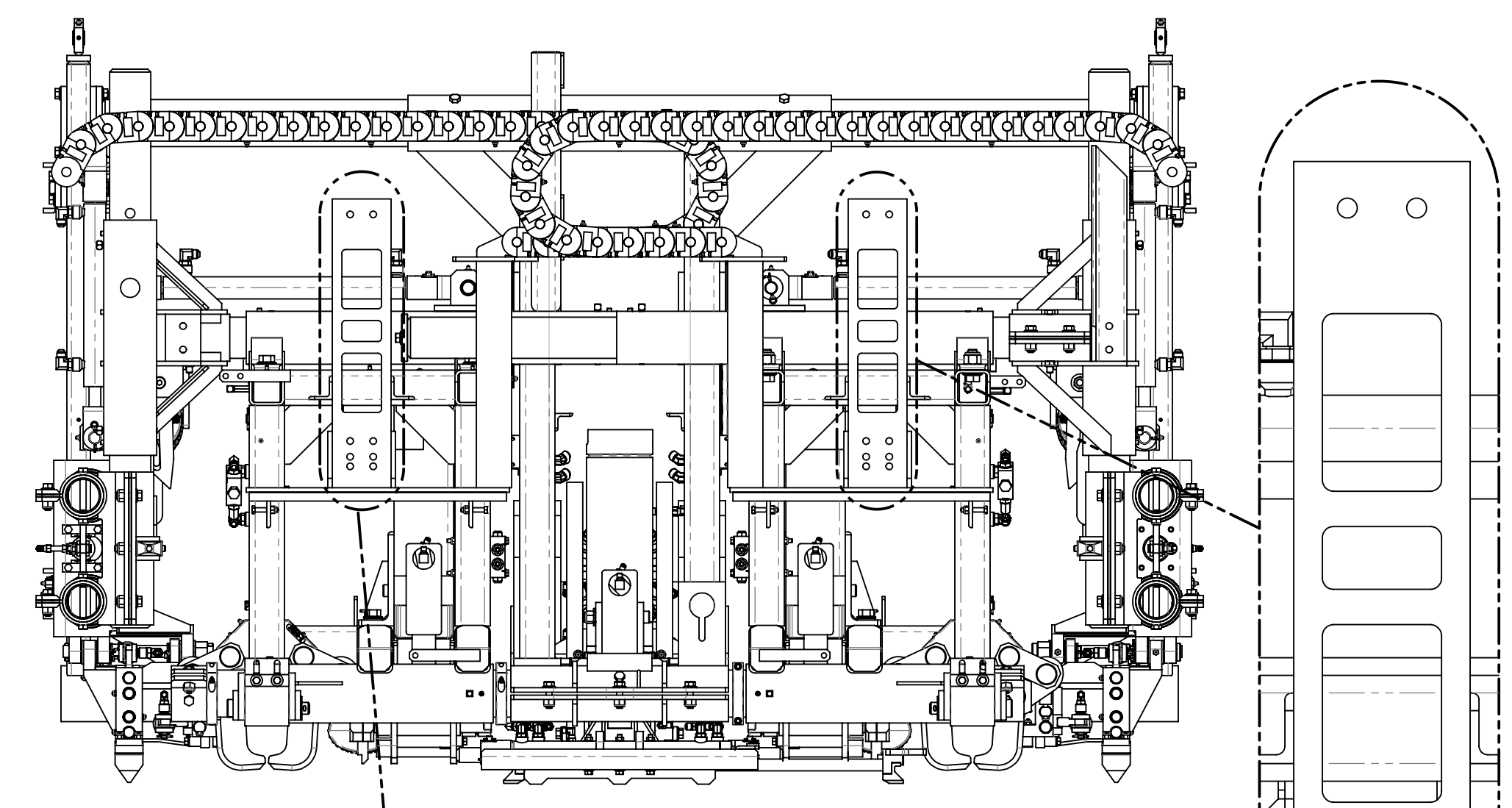
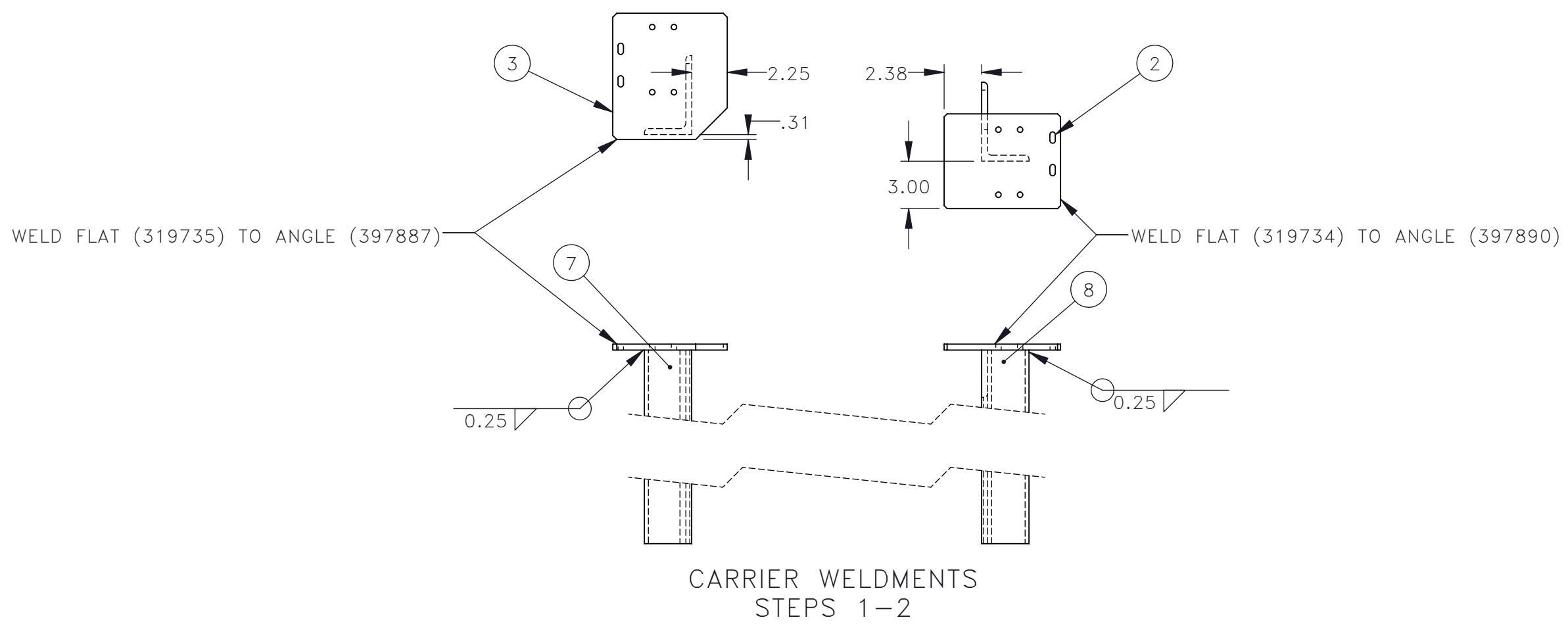


REAR VIEW

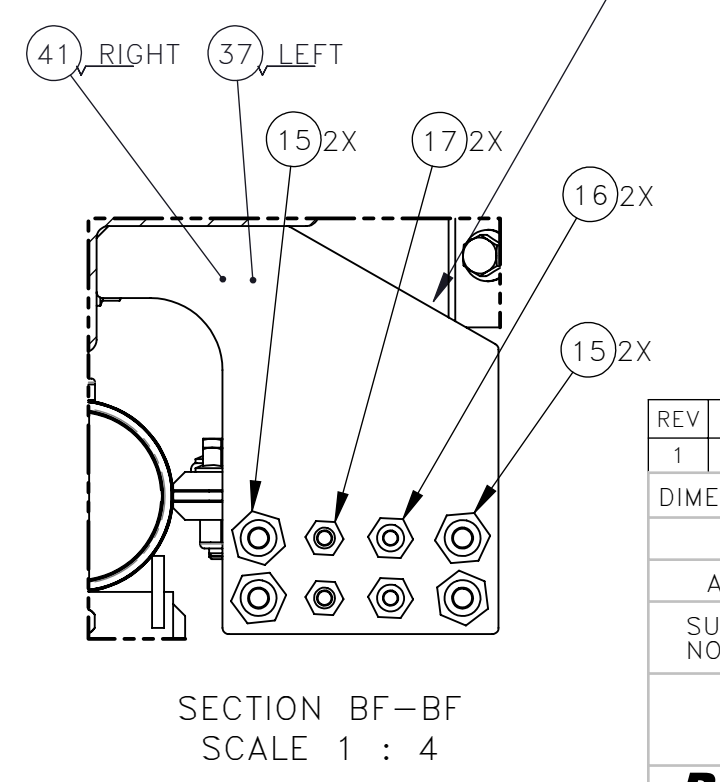
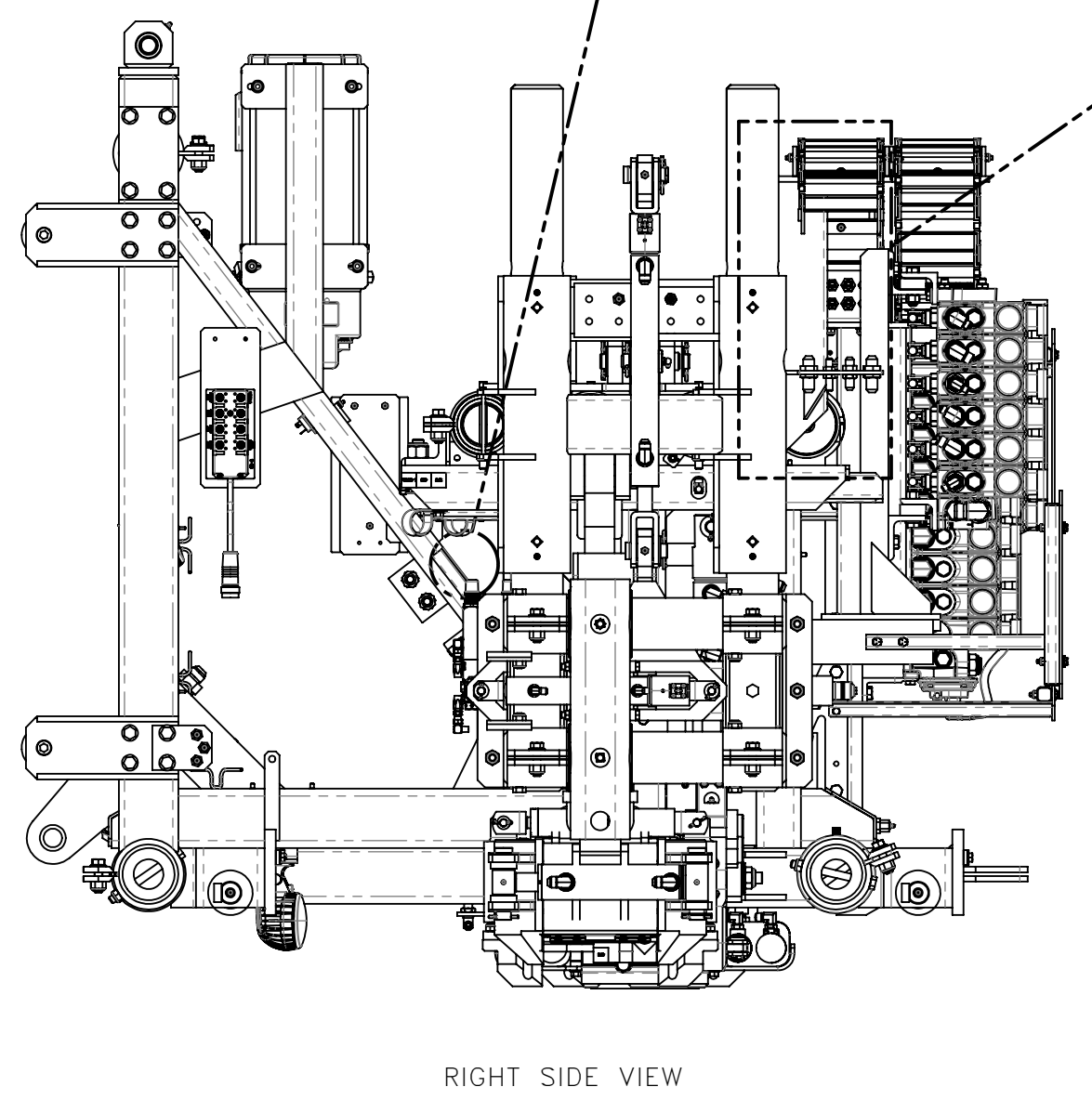
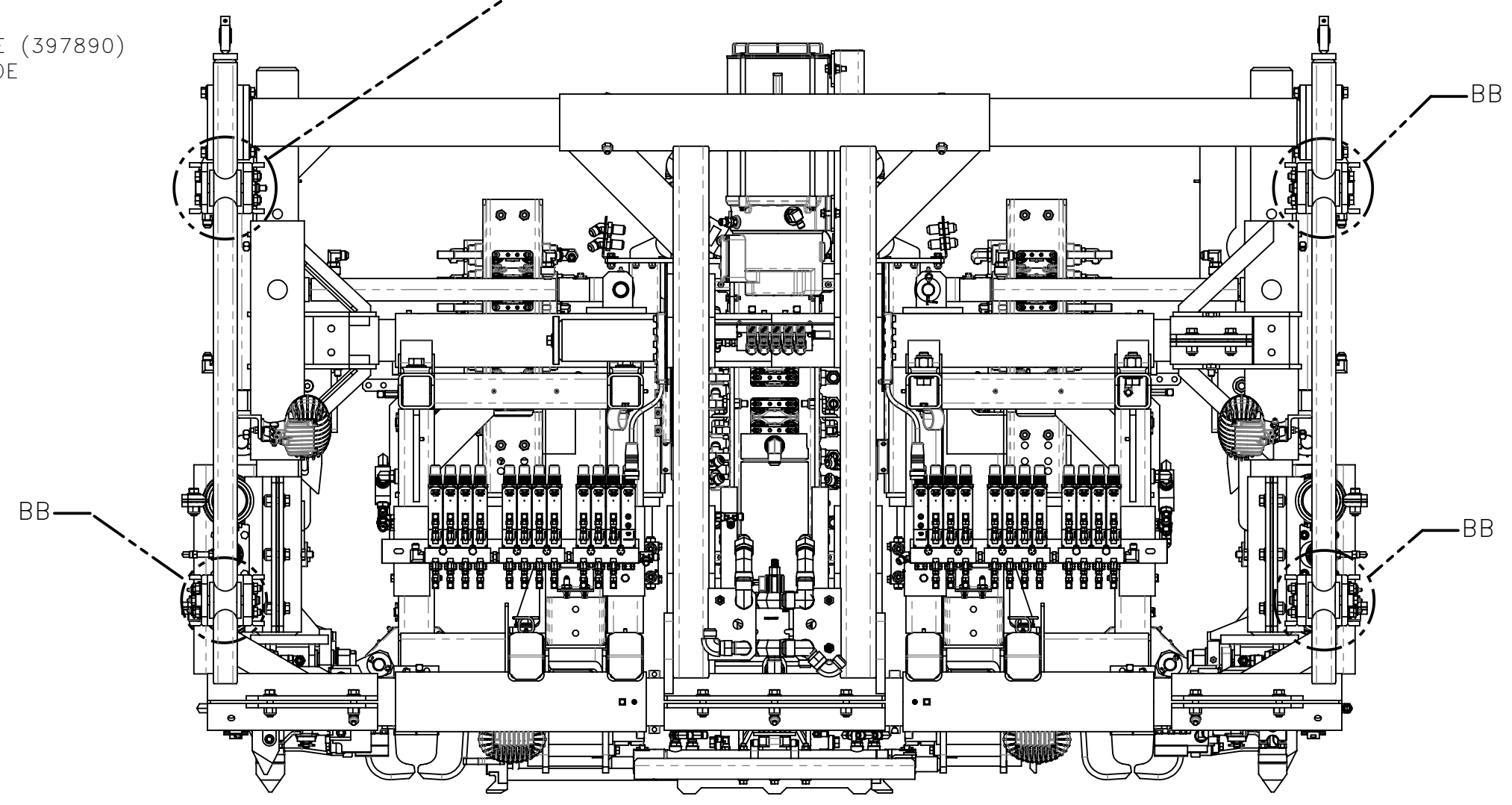
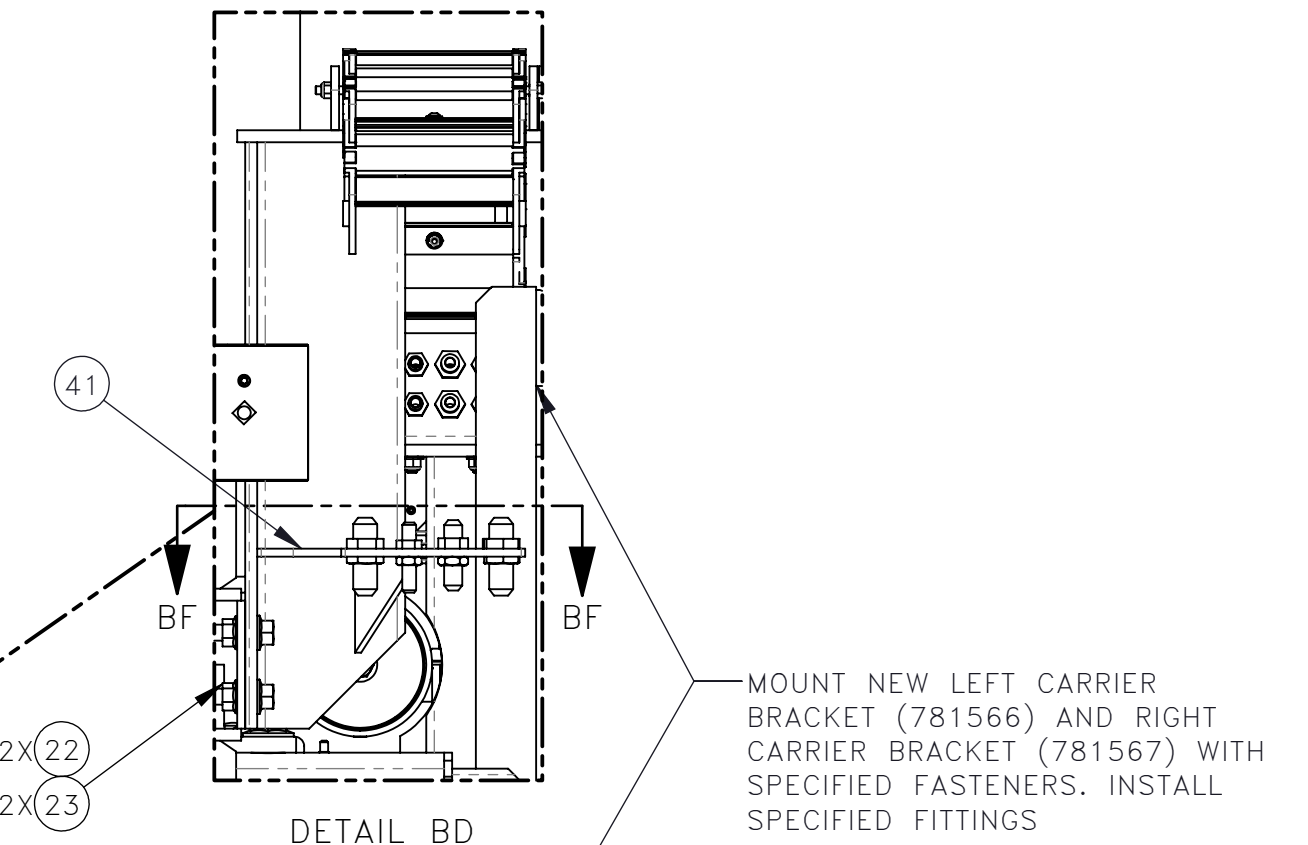
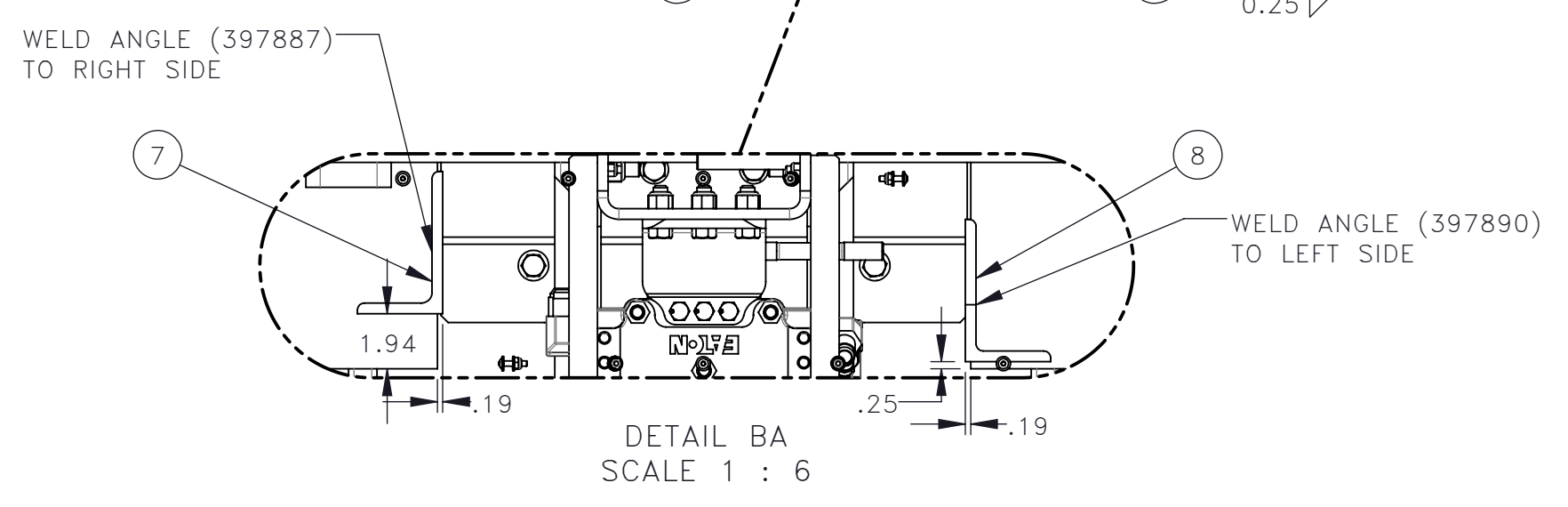
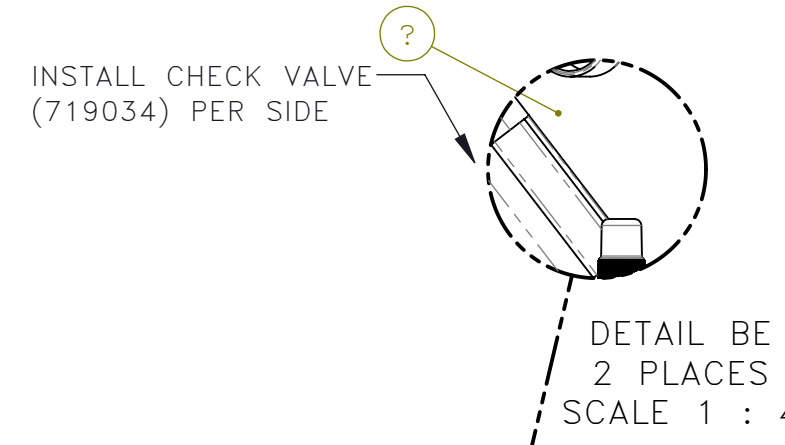
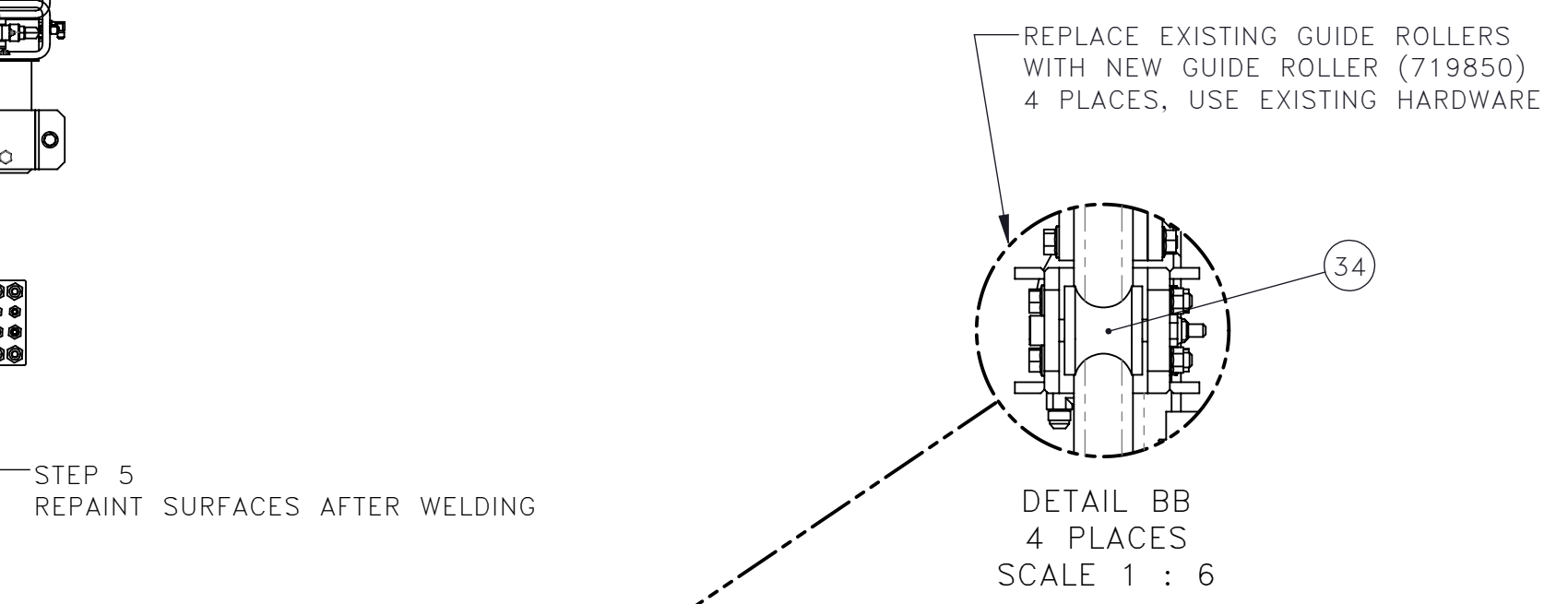
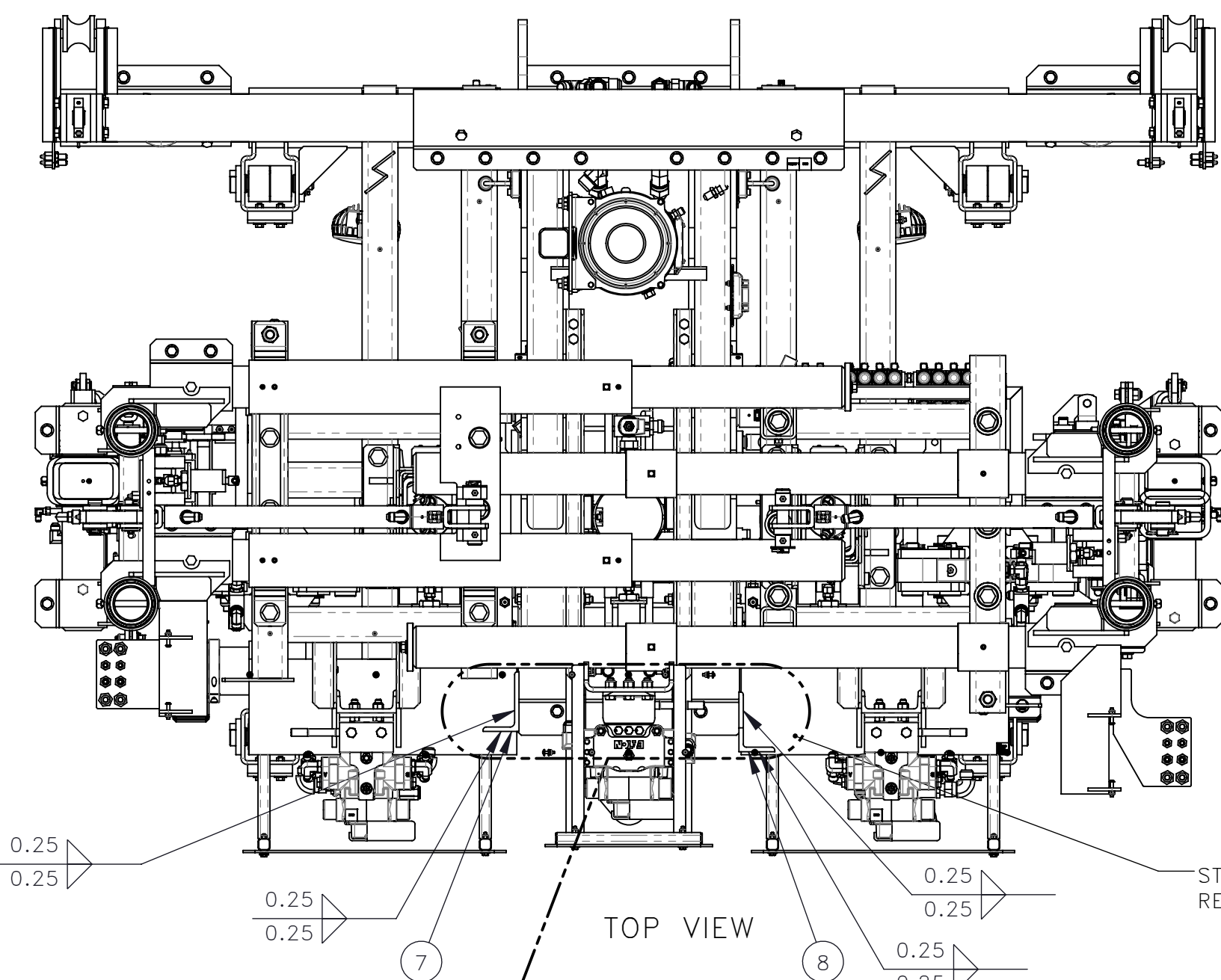


SECTION AF-AF
2 PLACES
SCALE 1 : 8

REV	EN	DESCRIPTION	DATE	DRN
1		5726 NEW RELEASE	6-21	ML
DIMENSION TOLERANCES UNLESS OTHERWISE SPECIFIED				
LINEAR		.XX=±.03	.XXX=±.010	
ANGULAR		X'=±1°	X.X'=±.5°	
SURFACE FINISH 125/√			SMOOTH ALL SHARP EDGES NOT TO EXCEED CLEAN ALL WELDS	
THIS PRINT AND ALL INFORMATION WITHIN BELONGS TO RACINE RAILROAD PRODUCTS				
RACINE RAILROAD PRODUCTS RACINE, WISCONSIN USA				
DESCRIPTION INSTRUCTIONS, WORKHEAD RETROFIT KIT				
MATERIAL		REFERENCE		
USED ON		SCALE	DATE	
		1:12	06-29-21	
DRN	CHK	APP	JOB NO	SHEET
ML				2 OF 5
DWG SIZE	CATALOG	DWG NO		
D	N			800355



NO.	QTY	DESCRIPTION	PART NO.
1	REF	PLATE	319492
2	REF	FLAT	319734
3	REF	FLAT	319735
4	REF	PIN, CLEVIS: 1 X 3.75	322842
5	REF	PIN, CLEVIS: 1 X 3.688	322843
6	REF	BRACKET, LUBE	397805
7	REF	ANGLE	397887
8	REF	ANGLE	397890
9	REF	FITTING, LUBE: .12 NPT(M)	401987
10	REF	PIN, COTTER: .19 X 2	403904
11	REF	NUT, HEX ES: .31-18	450578
12	REF	NUT, HEX ES: 10-24	456470
13	REF	ADAPTER, .12 NPT(F) X #4 JIC(M) BULK	459891
14	REF	ELBOW, 90°: #4 JIC(M) X #4 JIC(F)	459906
15	REF	UNION, #8 JIC(M) BULK	459928
16	REF	UNION, #6 JIC(M) BULK	459929
17	REF	UNION, #4 JIC(M) BULK	460155
18	REF	CARRIER, CABLE/HOSE	474050
19	REF	SCR, HEX FLG: .31-18 X 1	491043
20	REF	NUT, HEX ES: .25-20	491232
21	REF	WASHER, FLT: .31	491259
22	REF	SCR, HEX FLG: .5-13 X 1.5	491484
23	REF	NUT, HEX FLG: .5-13	491487
24	REF	WASHER, FLT: 1	491551
25	REF	WASHER, FLT: 1	491597
26	28	WASHER, FLT: #10	491646
27	REF	SCR, SOC BUT: 10-24 X .88	491944
28	REF	PLUMBING, WORKHEAD HYDRAULIC	718797
29	REF	VALVE, LEFT WORKHEAD	718836
30	REF	VALVE, RIGHT WORKHEAD	718837
31	REF	VALVE, CENTER WORKHEAD	718842
32	REF	BULKHEADS, LEFT	719306
33	REF	BULKHEADS, RIGHT	719307
34	REF	ROLLER, GUIDE	719850
35	REF	SCHEMATIC, ELECTRIC	720118
36	REF	WIRING, WORKHEAD	720119
37	REF	CLAMP, PLATE	720136
38	REF	GUIDE, FRONT/BACK	720143
39	REF	BRACKET, LEFT CARRIER	781566
41	REF	BRACKET, RIGHT CARRIER	781567
43	REF	SCR, SOC BUT: .25-20 X 1.25	25021681



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ANGULAR	X' = ±1'	X.X' = ±.5'

SURFACE FINISH 125/ ✓ SMOOTH ALL SHARP EDGES NOT TO EXCEED CLEAN ALL WELDS

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RACINE RAILROAD PRODUCTS
RACINE, WISCONSIN USA

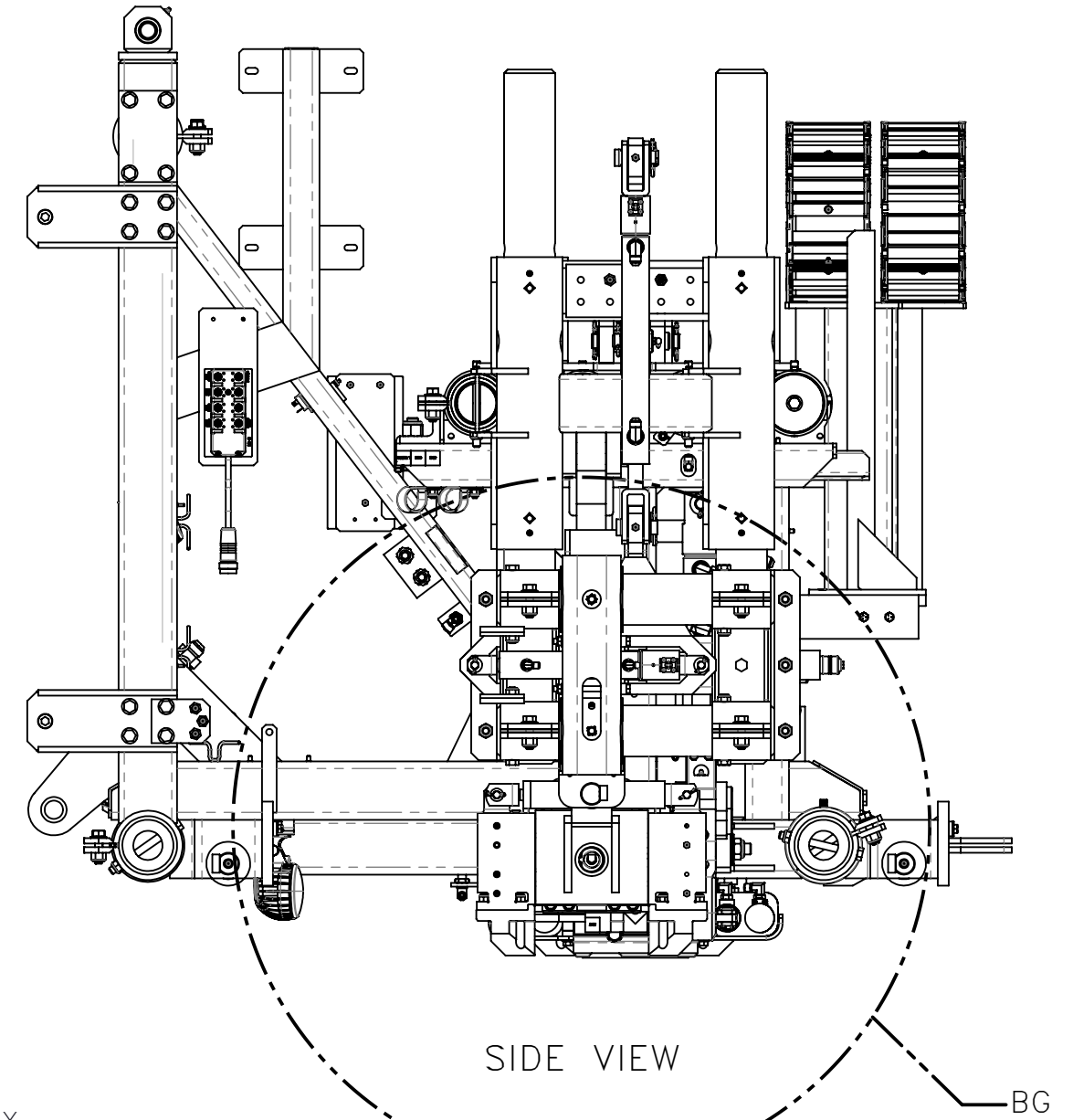
DESCRIPTION
INSTRUCTIONS, WORKHEAD RETROFIT KIT

MATERIAL REFERENCE

USED ON	SCALE	DATE
	1:12	06-29-21

DRN	CHK	APP	JOB NO	SHEET
ML				3 OF 5

DWG SIZE	CATALOG	DWG NO
D	N	800355

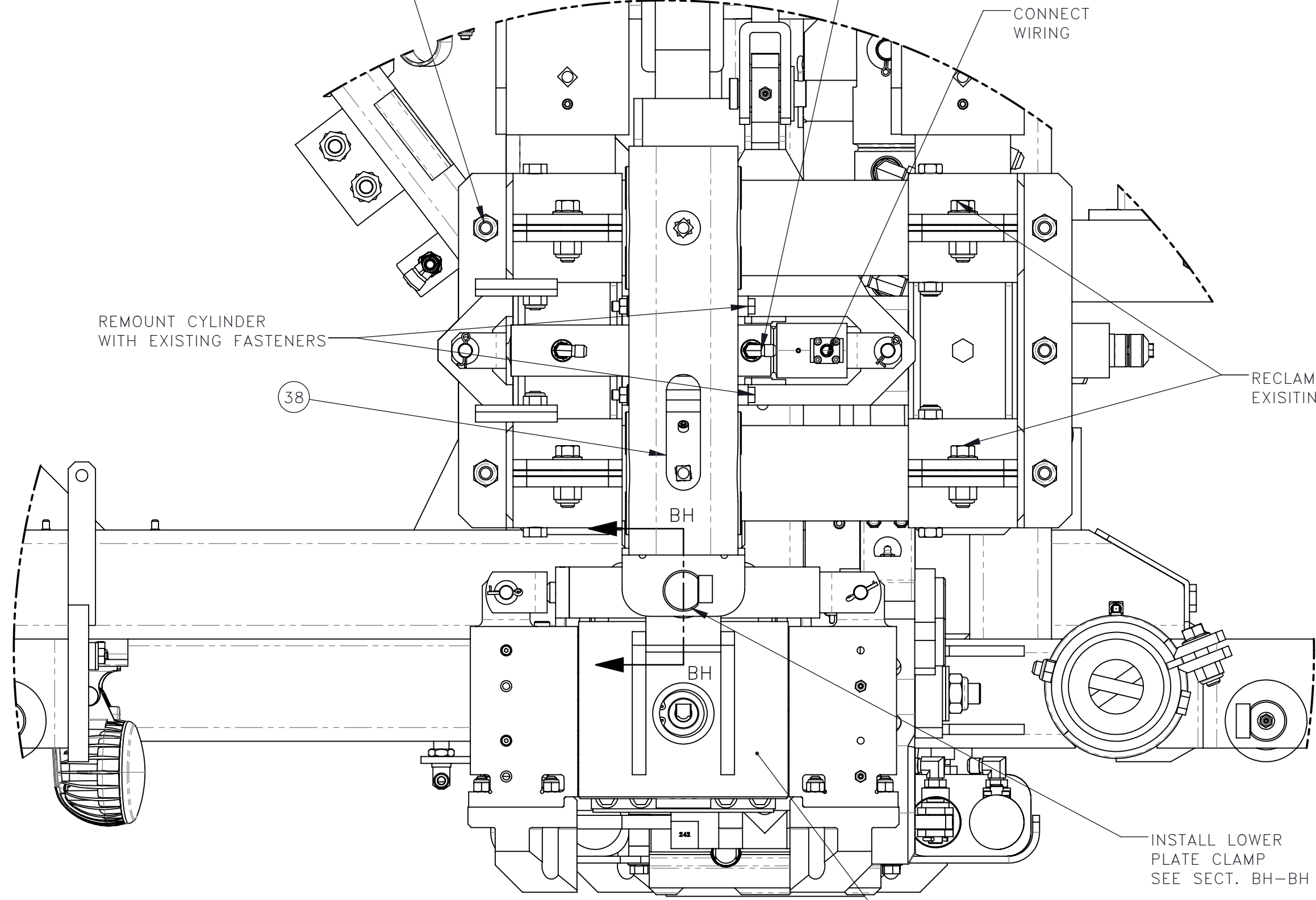


SIDE VIEW

TIGHTEN BOTH SIDE AS NECESSARY TO ADJUST SLIDE TUBES FROM BINDING

REINSTALL EXISTING FITTINGS

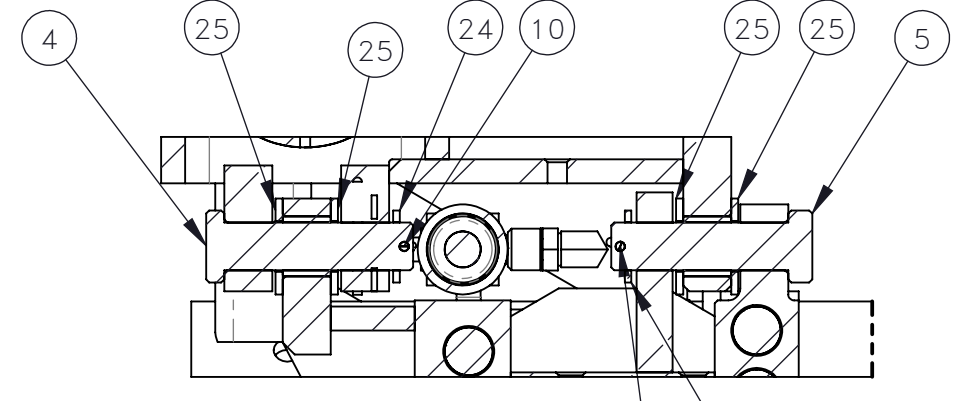
CONNECT WIRING



RE-MOUNT CYLINDER WITH EXISTING FASTENERS

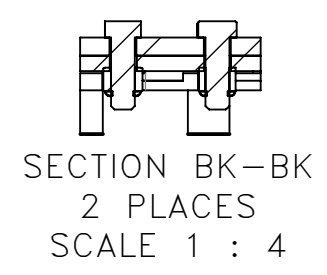
RECLAMP TUBINGS WITH EXISTING FASTENERS

INSTALL LOWER PLATE CLAMP SEE SECT. BH-BH

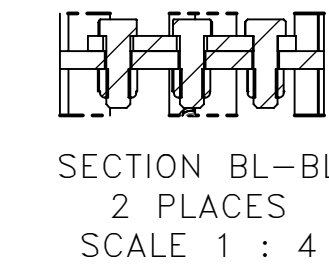


DETAIL BG SCALE 1 : 4

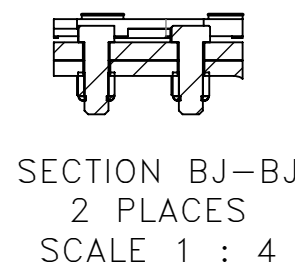
SECTION BH-BH SCALE 1 : 4



SECTION BK-BK 2 PLACES SCALE 1 : 4



SECTION BL-BL 2 PLACES SCALE 1 : 4

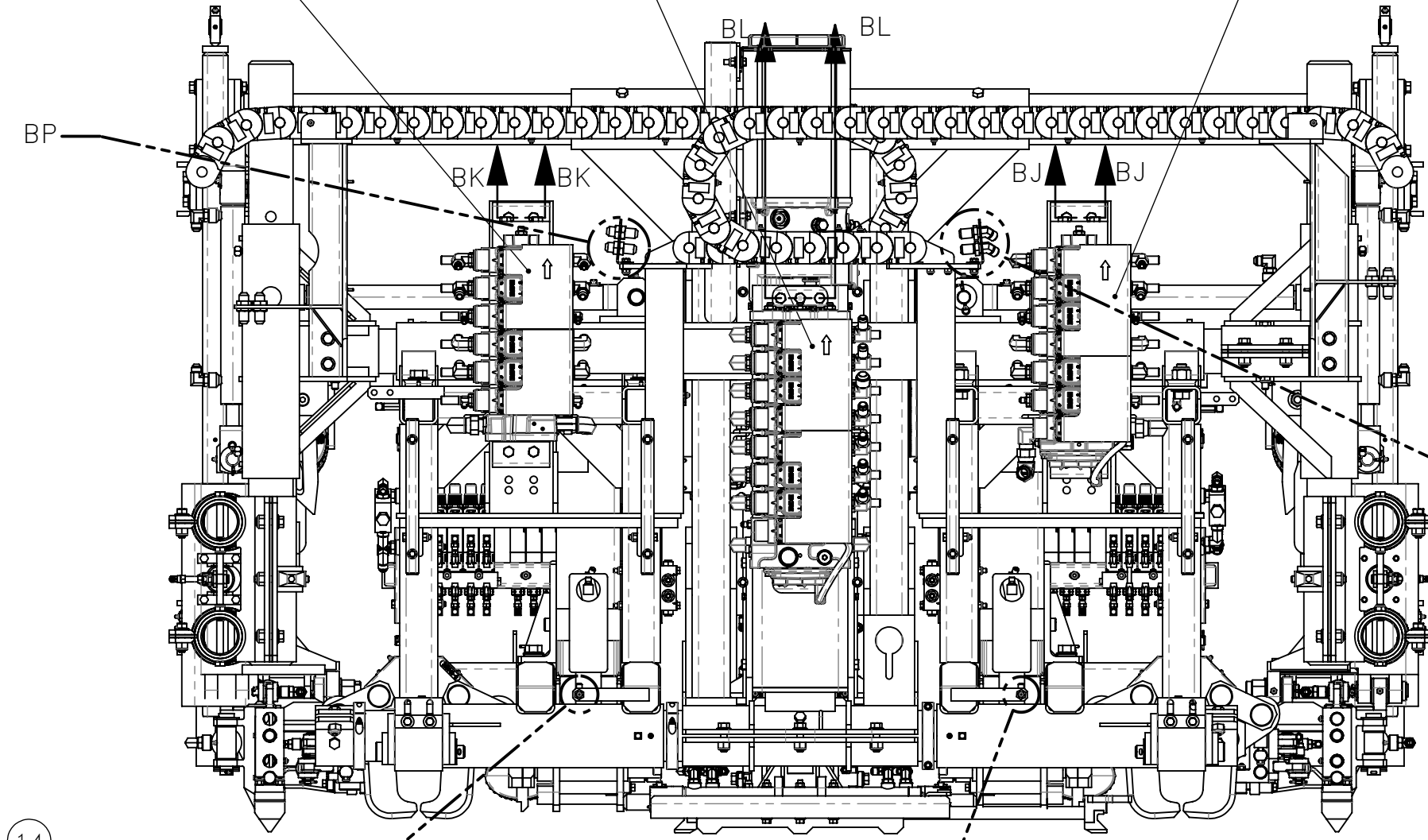


SECTION BJ-BJ 2 PLACES SCALE 1 : 4

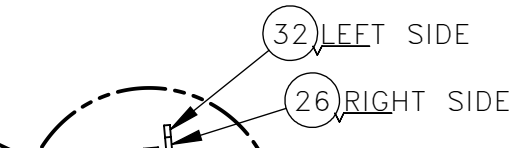
MOUNT NEW RIGHT WORKHEAD VALVE (718837) TO VALVE MOUNT AND CONNECT CABLES PER WIRING, WORKHEAD (720119)

MOUNT NEW CENTER WORKHEAD VALVE (718842) AND CONNECT CABLES PER WIRING, WORKHEAD (720119) (SEE SHEET 5: SECTION BL-BL)

MOUNT NEW LEFT WORKHEAD VALVE (718836) TO VALVE MOUNT AND CONNECT CABLES PER WIRING, WORKHEAD (720119)

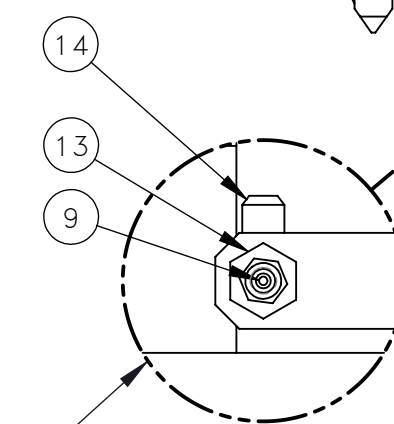


FRONT VIEW



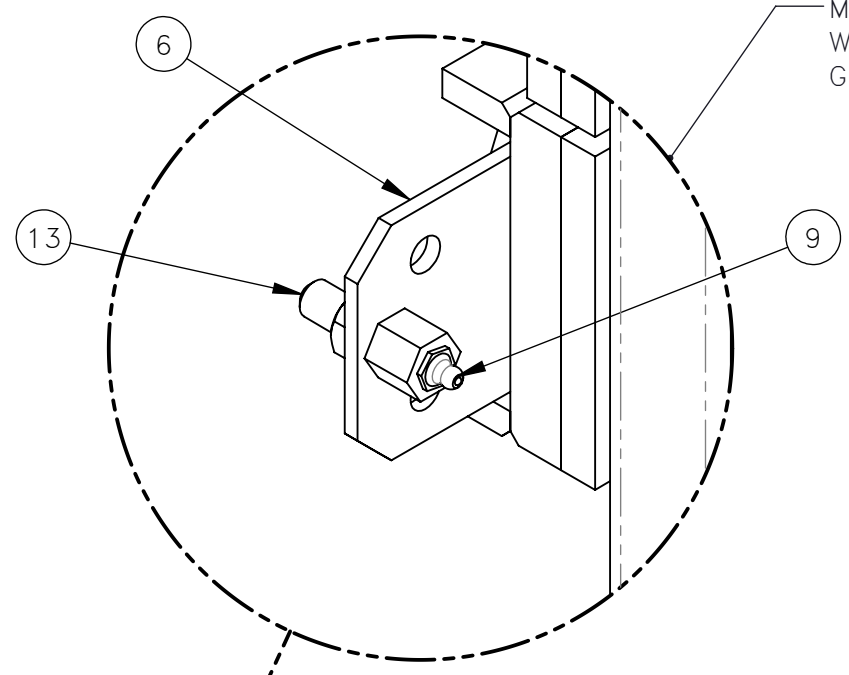
DETAIL BP 2 PLACES SCALE 1 : 4

INSTALL NEW LEFT BULKHEAD (719306) AND NEW RIGHT BULKHEAD (719307) ASSEMBLIES



DETAIL BN 2 PLACES SCALE 1 : 2

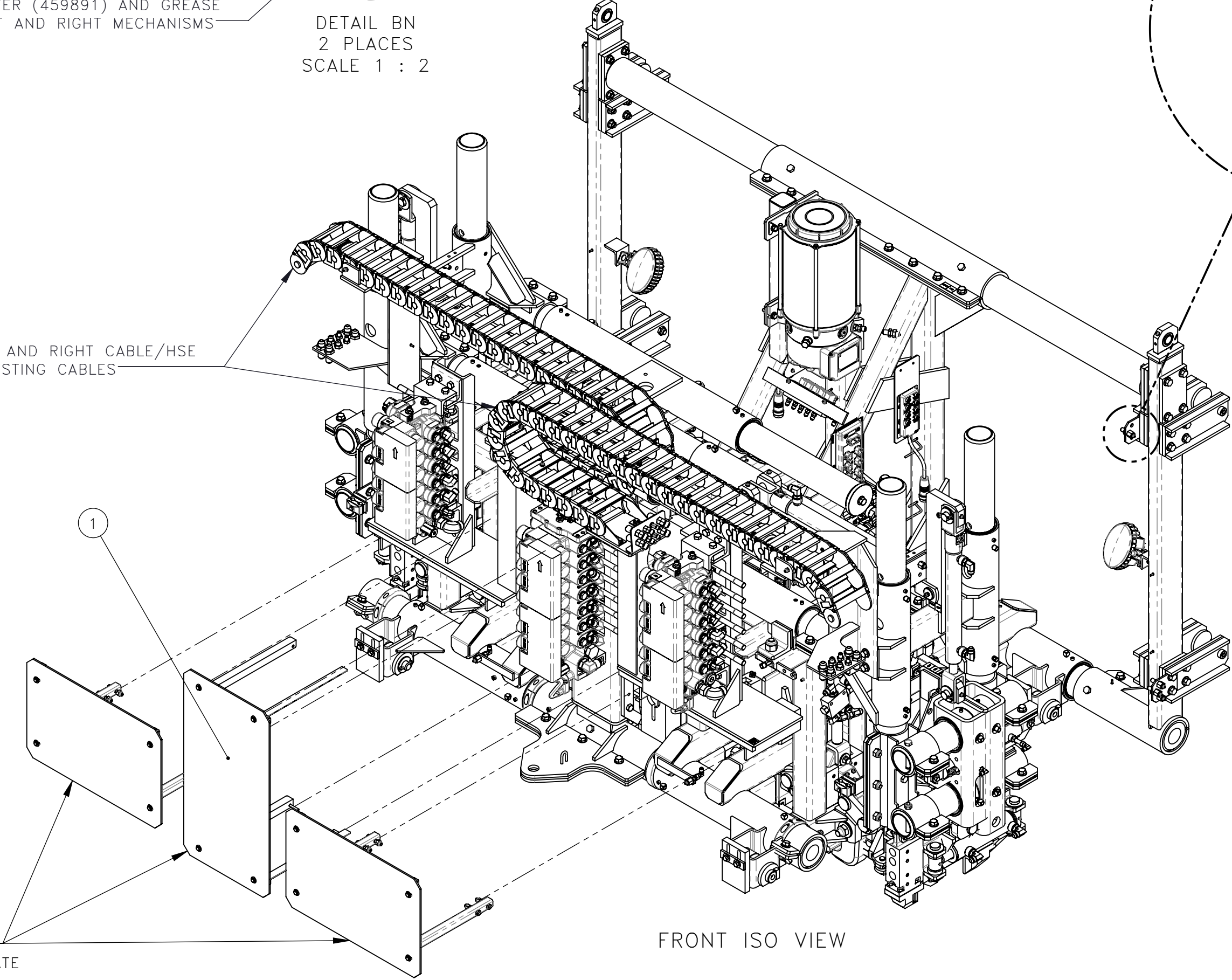
INSTALL (QTY: 1 PER EACH MECHANISM) NEW 90° ELBOW (459906), ADAPTER (459891) AND GREASE ZERK (401987) ON LEFT AND RIGHT MECHANISMS



DETAIL BM SCALE 1 : 2

MOUNT LUBE BRACKET (397805) WITH ADAPTER (459891) AND GREASE ZERK (401987)

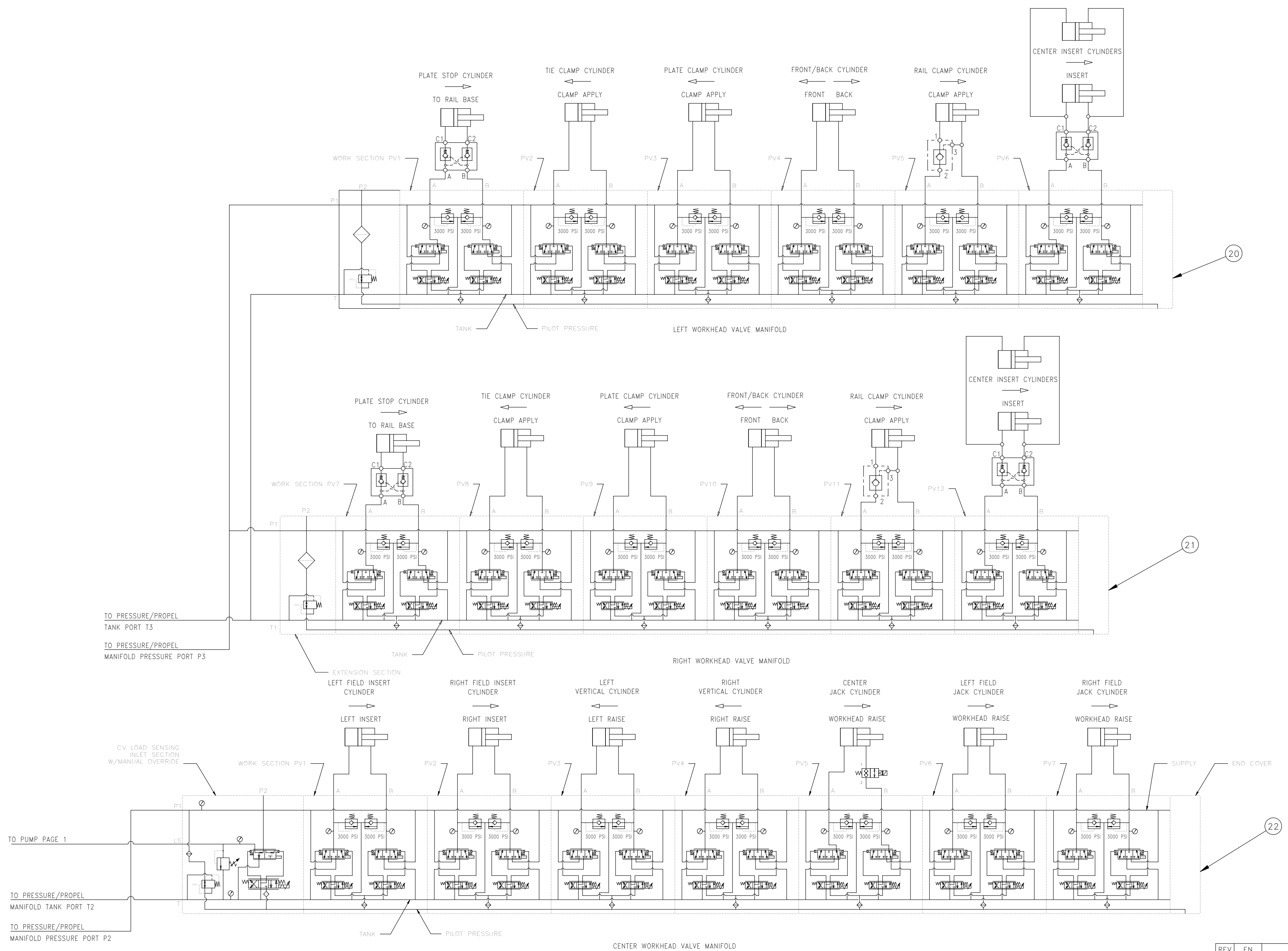
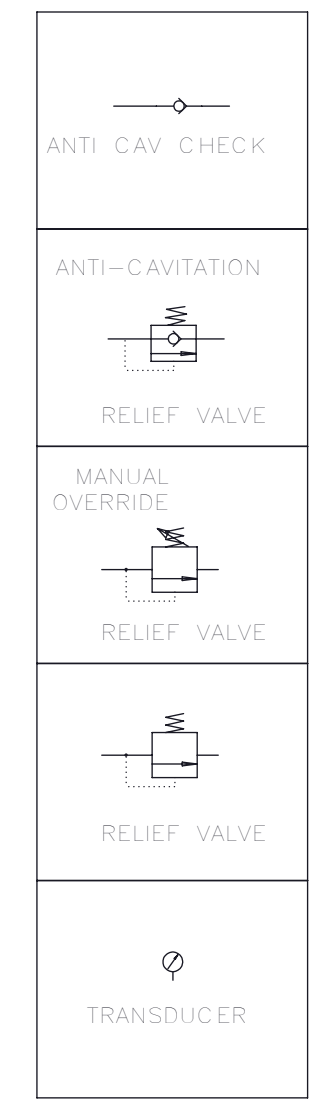
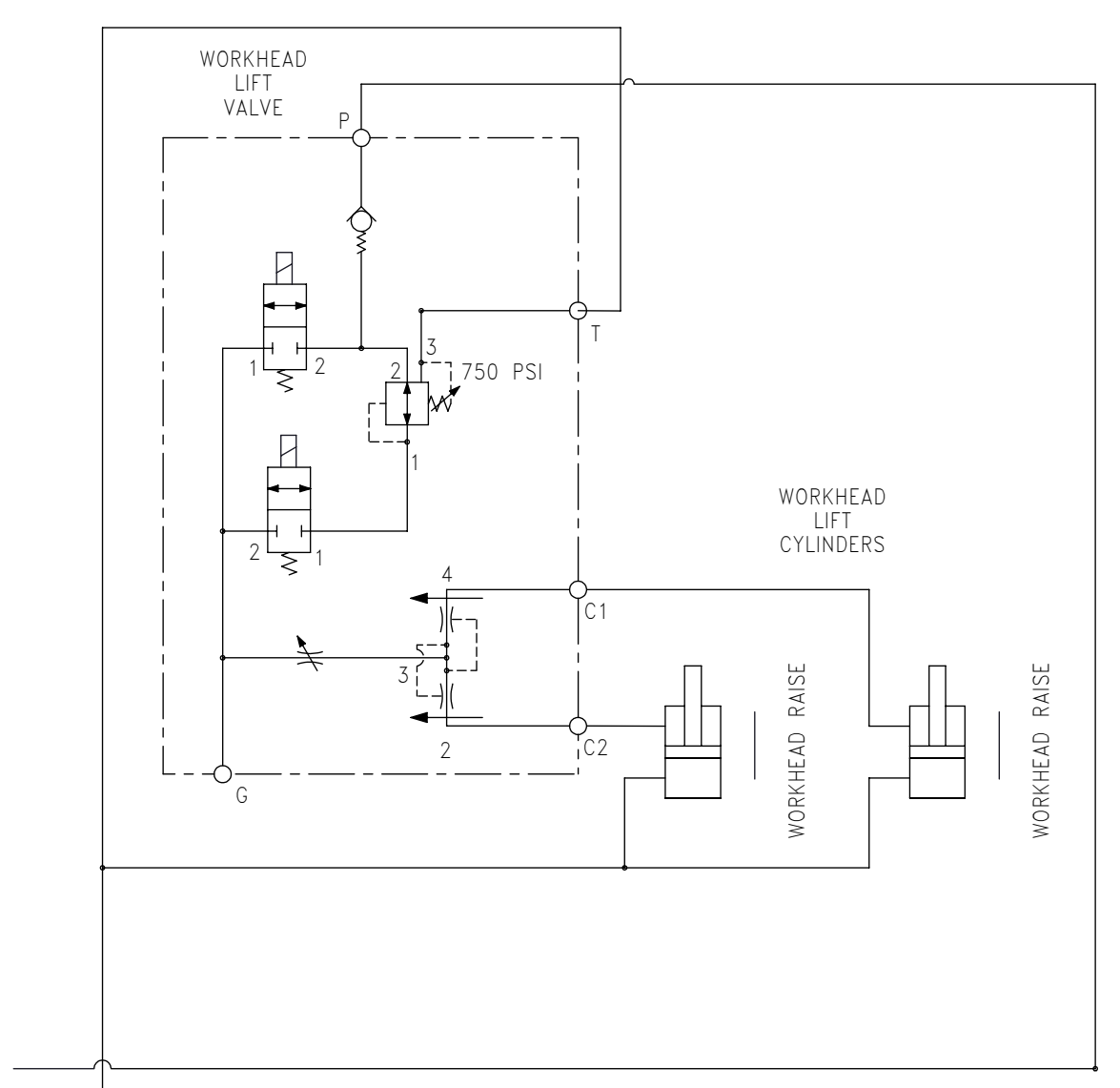
INSTALL NEW LEFT AND RIGHT CABLE/HSE CARRIERS WITH EXISTING CABLES



FRONT ISO VIEW

RE-INSTALL LEFT AND RIGHT VALVE GUARDS. INSTALL CENTER VALVE GUARD WITH NEW PLATE (319492) AND EXISTING BRACKETS AND FASTENERS.

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LINEAR		.XX=±.03	.XXX=±.010	
ANGULAR		X' = ±1'	X.X' = ±.5'	
SURFACE FINISH		125/√	SMOOTH ALL SHARP EDGES CLEAN ALL WELDS	
THIS PRINT AND ALL INFORMATION WITHIN BELONGS TO RACINE RAILROAD PRODUCTS				
RACINE RAILROAD PRODUCTS RACINE, WISCONSIN USA				
DESCRIPTION INSTRUCTIONS, WORKHEAD RETROFIT KIT				
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ML				4 OF 5
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RACINE RAILROAD PRODUCTS RACINE, WISCONSIN USA				
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			1:12	06-29-21
DRN	CHK	APP	JOB NO	SHEET
ML				5 OF 5
DWG SIZE		CATALOG	DWG NO	
D		N	800355	