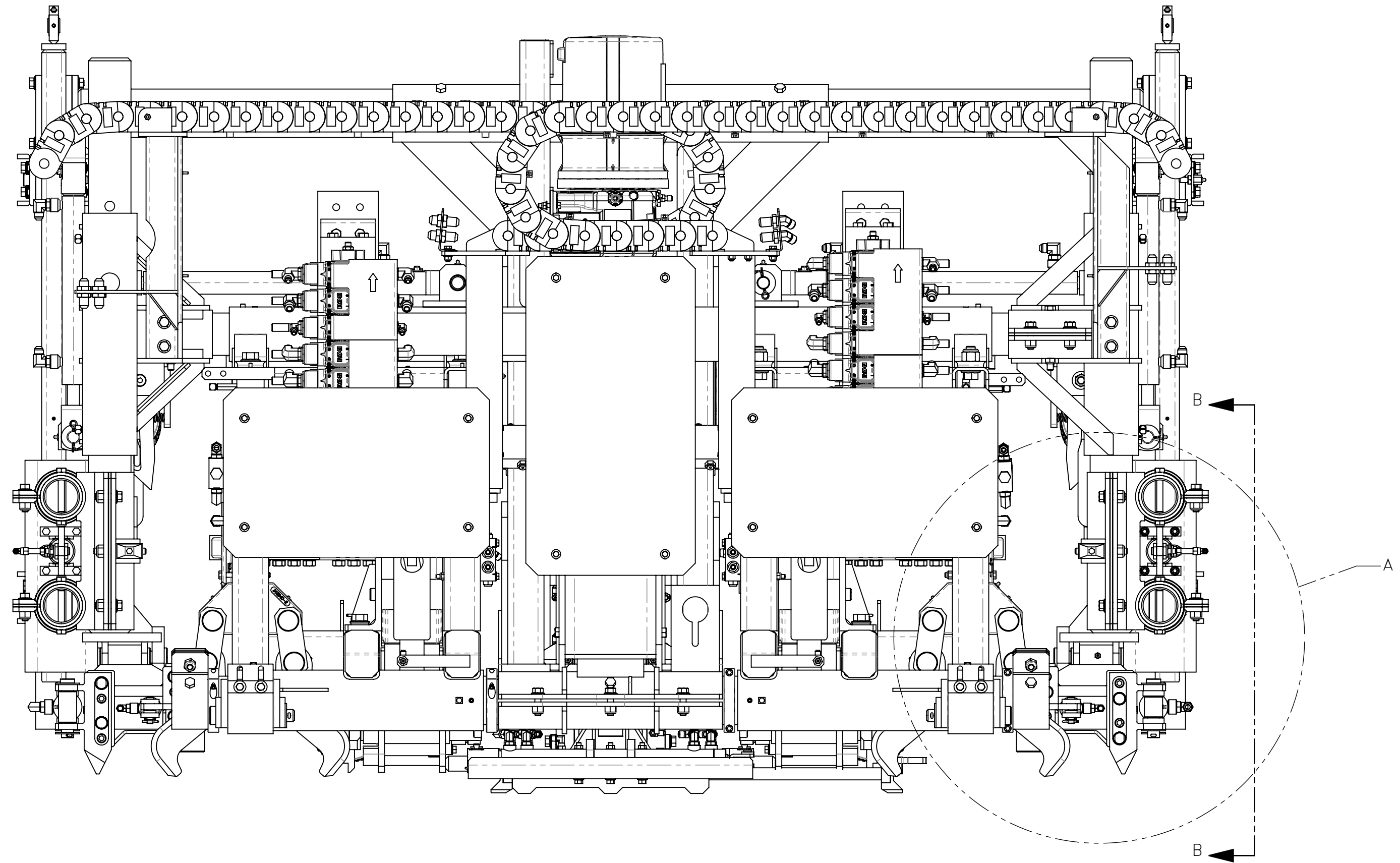


NO.	QTY	DESCRIPTION	PART NO.
1	REF	PIN, CLEVIS: 1 X 3.75	322842
2	REF	PIN, CLEVIS: 1 X 3.688	322843
3	REF	PIN, COTTER: .19 X 2	403904
4	REF	WASHER, FLT: 1	491551
5	REF	WASHER, FLT: 1	491597
6	REF	CLAMP, PLATE	720136
7	REF	GUIDE, FRONT/BACK	720143



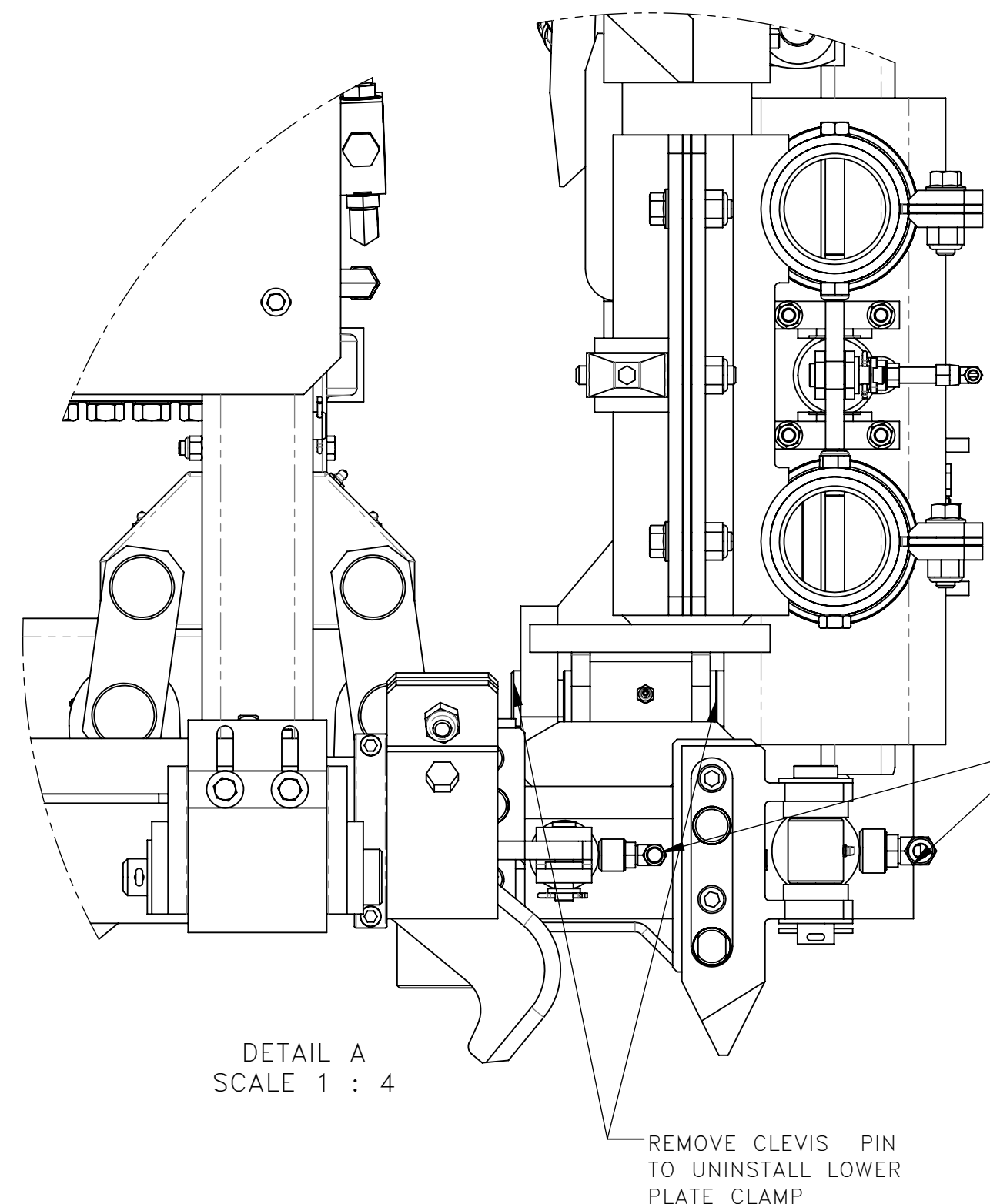
THESE INSTRUCTIONS ARE FOR KIT 793118.

REMOVAL: (SHEET 1)

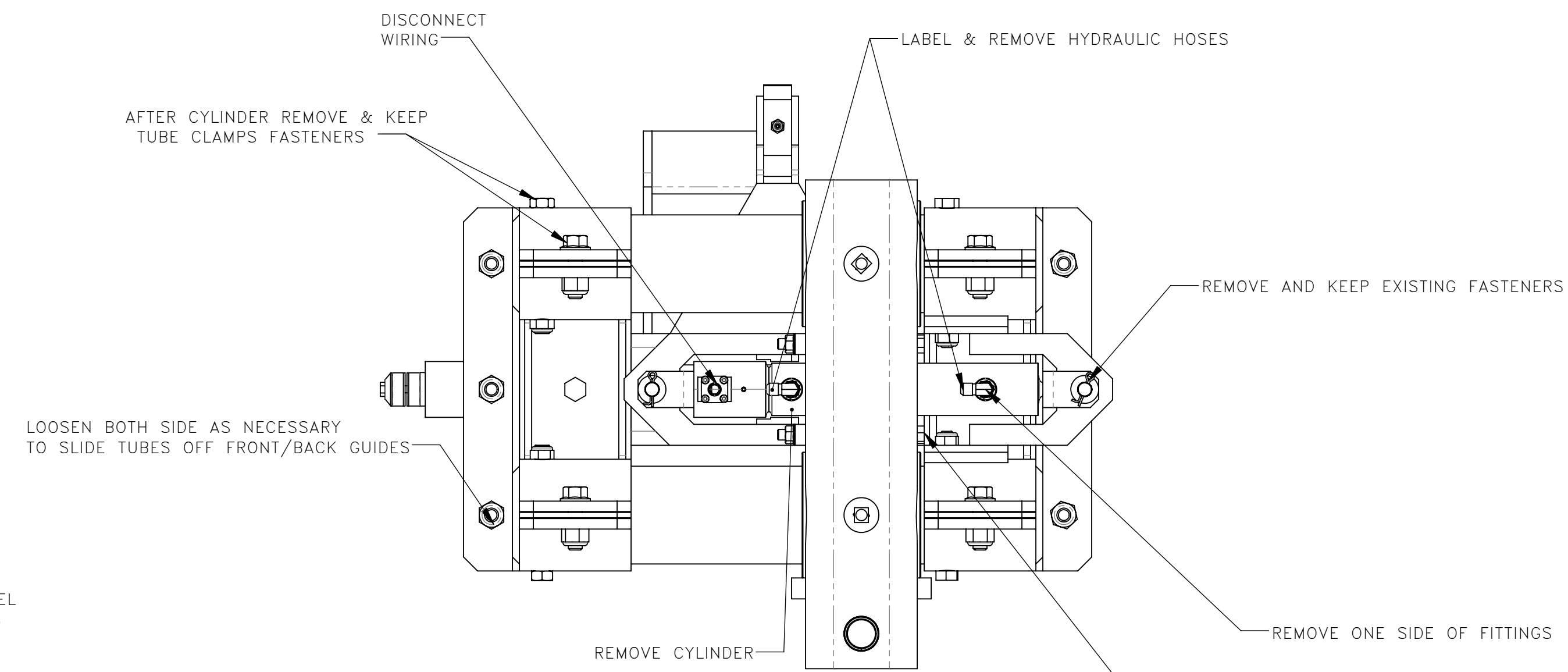
1. POWER OFF MACHINE AND TAG OUT BEFORE PERFORMING CONVERSION
2. DRAIN ALL HYDRAULIC FLUID FROM WORKHEAD TOOLING.
3. DISCONNECT AND LABEL PORT HOSES FROM PLATE CLAMP CYLINDERS
4. REMOVE LOWER PLATE CLAMPS FROM FRONT/BACK GUIDES
5. REMOVE PORT FITTINGS ON ONE SIDE OF FRONT/BACK GUIDE HORIZONTAL CYLINDER AND KEEP EXISTING FITTINGS
6. REMOVE FRONT/BACK GUIDE HORIZONTAL CYLINDER AND KEEP EXISTING FASTENERS
7. DISCONNECT WIRING FROM FRONT/BACK GUIDE HORIZONTAL CYLINDER IF NECESSARY
8. REMOVE AND KEEP EXISTING FASTENERS AND SPACERS FROM TUBE CLAMPS
9. SLIDE TUBES OFF THE FRONT/BACK GUIDES UNTIL ABLE TO REMOVE GUIDES KEEP TUBES RETAINED IN ONE SIDE OF CLAMPS

INSTALLATION: (SHEET 2)

1. INSTALL NEW FRONT/BACK GUIDES ON TO TUBES
2. THEN SLIDE TUBES THROUGH CLAMPS AND REFASTEN WITH EXISTING FASTENERS
3. ATTACH FRONT/BACK GUIDE CYLINDER WITH EXISTING FASTENERS
4. INSTALL PLATE CLAMPS WITH CLEVIS PINS.
5. RECONNECT ALL LABELED HYDRAULIC HOSES TO CYLINDER PORTS
6. RECONNECT LABELED WIRING CONNECTION ON FRONT/BACK GUIDE HORIZONTAL CYLINDER
7. REFILL HYDRAULIC FLUID TO WORK HEAD
8. LUBE BLUE ARROW MARKED GREASE FITTINGS



DETAIL A
SCALE 1 : 4



SECTION B-B
FOR CLARITY GUIDE FRAME AND GUIDE SHOWN ONLY

REV	EN	DESCRIPTION	DATE	DRN
1	5817	NEW RELEASE	8-21	PR

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

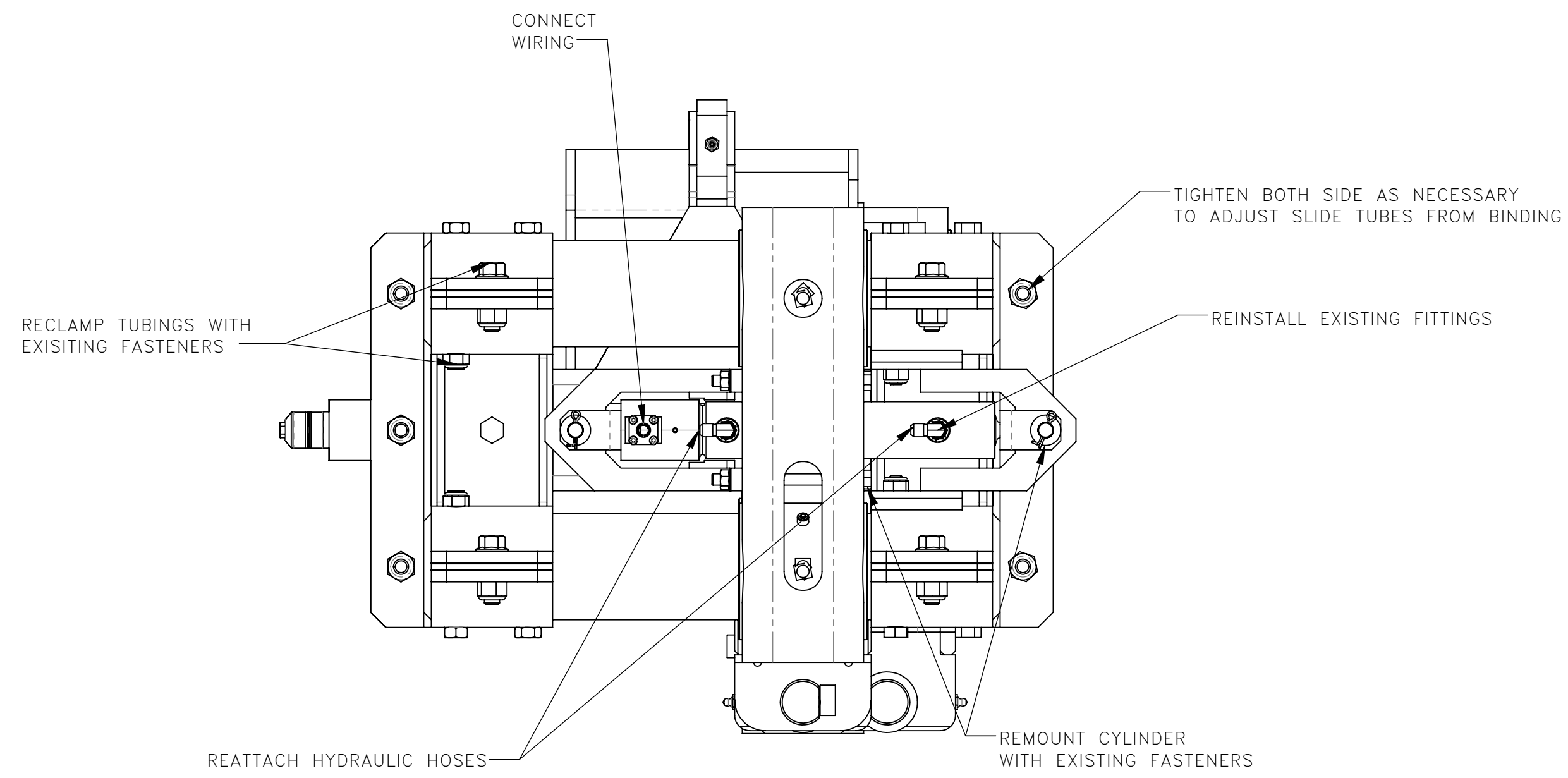
DESCRIPTION
INSTRUCTIONS, WORKHEAD TOOLING KIT

MATERIAL
SEE BOM

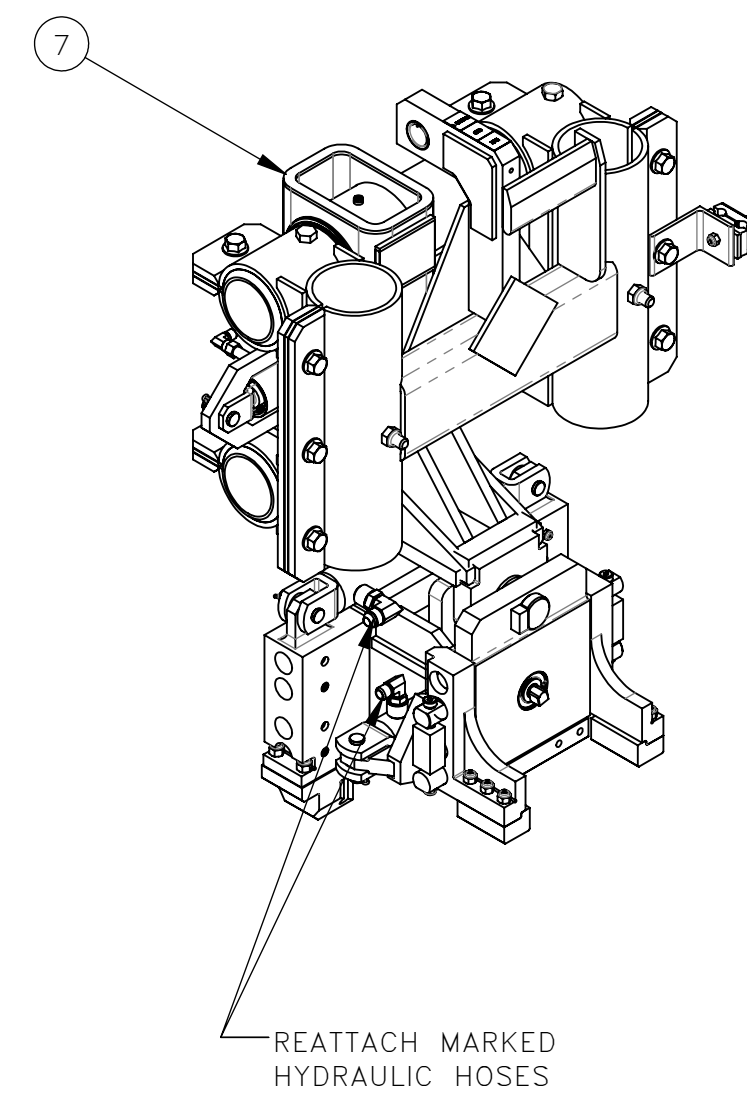
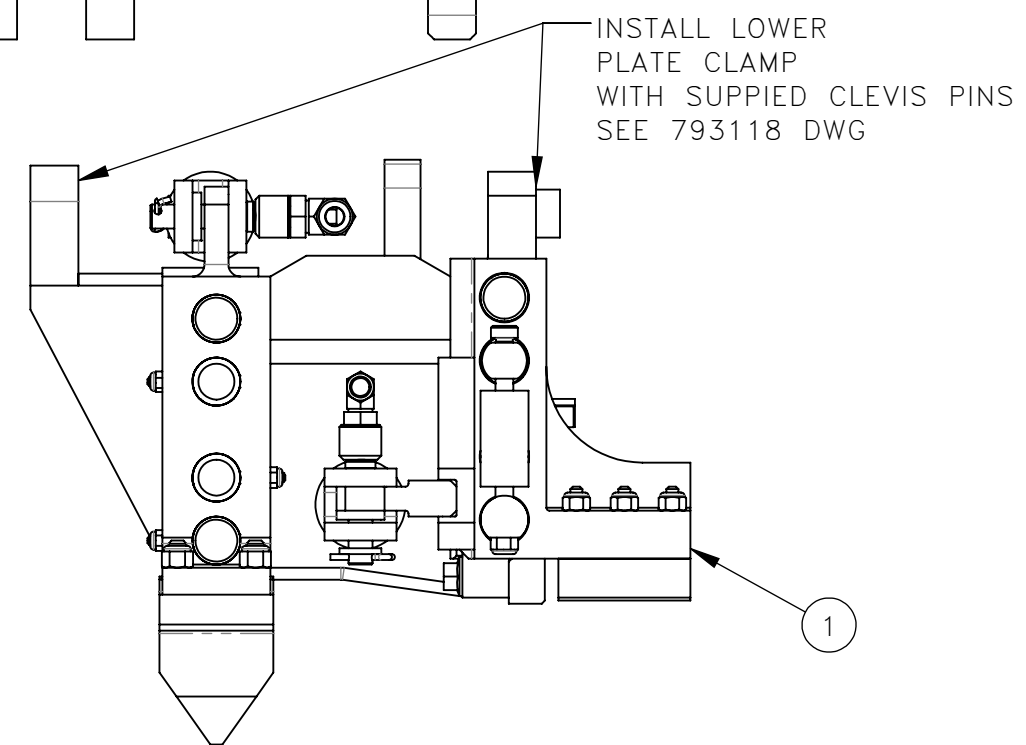
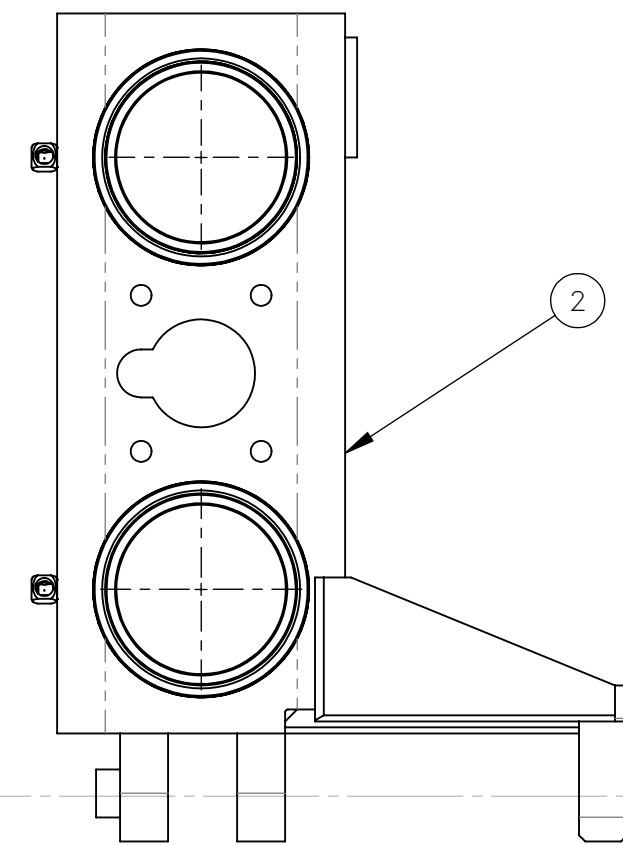
USED ON	793118	SCALE	DATE
		2:1	08-18-21

DRN	CHK	APP	JOB NO	SHEET
PR			RD150003	1 OF 2

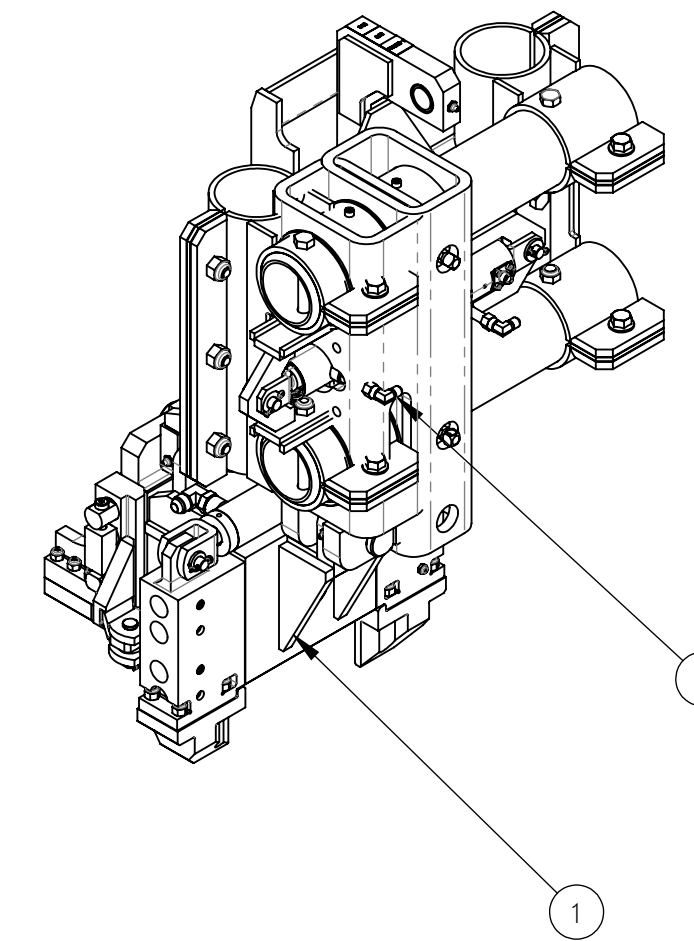
DWG SIZE	CATALOG	DWG NO
D	A	800357



FOR CLARITY GUIDE FRAME AND GUIDE SHOWN ONLY



FOR CLARITY GUIDE FRAME AND GUIDE SHOWN ONLY



REV	EN	DESCRIPTION	DATE	DRN
1		5817 NEW RELEASE	8-21	PR
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 TOOLING KIT				
MATERIAL SEE BOM				
USED ON	793118	SCALE	DATE	
		2:1	08-18-21	
DRN	CHK	APP	JOB NO	SHEET
PR			RD150003	2 OF 2
DWG SIZE	CATALOG	DWG NO		
D	A		800357	