

**MAINTENANCE AND
SERVICE MANUAL
PHA**

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SECTION 1

MODEL IDENTIFICATION

Each clamp is identified by a model number and a serial number located on the attachment nameplate which is attached to the top of the unit prior to shipment.

Before ordering replacement parts for any unit, be sure to use the correct parts list for your model number. Both model number and serial number must be given to ensure that the correct parts are ordered.

NOTE: The serial number is also metal stamped onto the plate under the identification plate.

 A Division of Allied Systems Company					
MODEL NO.:					
SERIAL NO.:					
MAXIMUM HYD. PRESS.:		PSI	WEIGHT:		LBS
CAPACITY:		LBS @	inch LC		
SEE TRUCK NAMEPLATE FOR COMBINED TRUCK & ATTACHMENT NET CAPACITY					
HOR. CG:	inches	VERT. CG:	inches	LOST LOAD /AET:	inches
CG AND AET SPECIFICATIONS ARE APPROXIMATE					
Manufactured By Allied Systems Company • 21433 Oregon Street, Sherwood, OR 97140 USA www.alliedsystems.com 2500005 RC					

Date Received:

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PH	A	
		Class II Mounting
		Perry Hook

SECTION 2

SAFETY SUMMARY

2.1 General Information

Safety is Everyone's Responsibility

Whether you are new on the job or a seasoned veteran, these safety tips may prevent injury to you, to others, or to the materials you are handling. Always be alert, watch out for others, and follow these suggestions:

Attachments Handle Material - Not People.

**SAFETY STARTS WITH COMMON SENSE.
GOOD JUDGEMENT, PROPERLY MAINTAINED
EQUIPMENT, CAREFUL OPERATION, AND
PROPERLY TRAINED OPERATORS.**

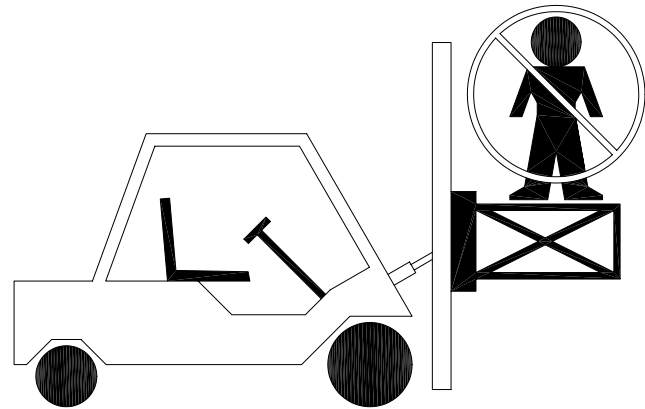


Figure 2-1

9. **Never** use the attachment or its load to support a man carrying device.

1. **Check** your equipment before you operate it.
2. **Check** to make sure the attachment on your truck is the same as on the truck capacity plate.
3. **Check** for hydraulic leaks and cracked hoses or fittings.
4. **Check** the hydraulic oil level in the lift truck hydraulic reservoir.
5. **Check** for physical damage to the attachment. If anything looks wrong, unusual or different, report it before using the attachment.
6. **When** removing / installing dismountable attachments always keep hands and feet free from dangerous positions or pinch points. Never leave a dismounted attachment in a dangerous position.
7. **Check** to make sure that the dismountable attachment is properly secured to the truck carriage before using the lift truck and attachment.
8. **Never** stand on top of material being raised, lowered, or transported. (Figure 2-1)

10. **Never** position an attachment or load over people. (Figure 2-2)

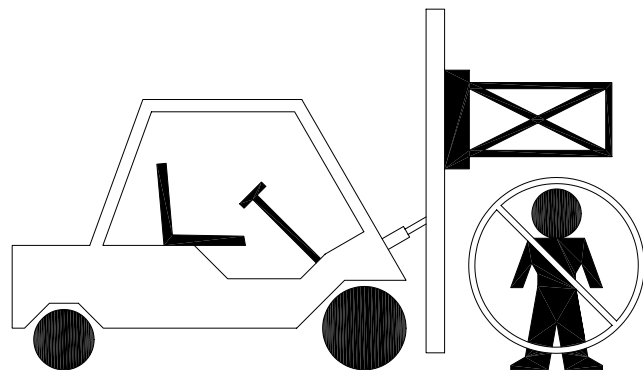


Figure 2-2

11. **Never** leave an attachment or load in an elevated position.

12. **Never** reach through the mast of the truck. Keep all parts of the body within the driver's compartment.

13. **Never** leave a lift truck unattended without lowering the load to the floor, setting the brake, and turning the truck off.

14. **Always** operate an attachment from the operator's seat, never while standing next to the lift truck.

15. **Never** stand in front of or beside an attachment that is being operated. Never allow another person to approach an attachment that is being operated. (Figure 2-3)

16. **Do not** allow riders on the truck at any time.

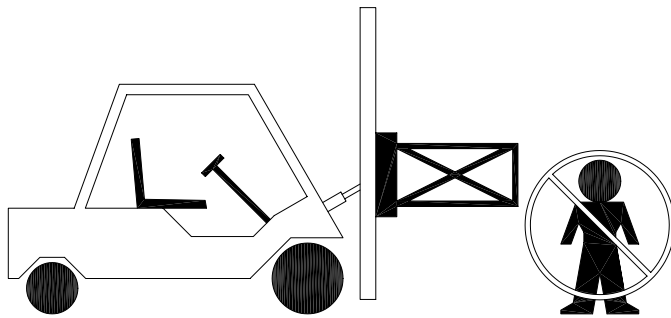


Figure 2-3

17. **Always** use reverse when carrying a load that impedes full vision.

18. **Watch** for pedestrians when transporting. Sudden stops can dislodge all or part of a load.

2.2 Load Handling

1. **All** operators must be trained and qualified.

2. **Never** overload the attachment. Refer to the attachment nameplate for the rated capacity of the attachment. Refer to the nameplate of the truck for the net working capacity of the truck and attachment. Observe the lower of the two capacities. The attachment capacity is the structural rating of the attachment and should not be exceeded. Net working capacity is the truck manufacturer's rating of the truck/attachment combination.

3. **Never** use a load to support or move another object. Doing so can easily exceed the holding capacity of the attachment, causing loss of the load.

4. **Never** lift, lower, side shift, pivot, rotate, or tilt loads while traveling. Repositioning loads while traveling affects the stability of the truck and may impede vision or clearances.

5. **Never** speed or race a lift truck. High speed adversely af-

fects the stability and steering of the lift truck.

6. **Do not** use an attachment to open or close boxcar doors. Doing so can severely damage the attachment and cause loss of warranty. Damage to clamp arms may result in product damage.

7. **Do not** carry loose items or unsupported loads on top of a clamped load.

8. **Never** allow anyone under a load or under the carriage.

9. **Never** use chains, cables, or other devices in conjunction with an attachment for load handling.

10. **Never** clamp loads other than what the attachment was designed to handle.

11. **Travel** slowly around corners. Sound horn on blind corners. Be careful of tail swing and overhead clearances. Watch in all directions. Avoid sudden stops.

12. **Do not** exceed the specified maximum operating pressure or flow for the attachment. To do so can severely damage the attachment and cause loss of warranty.

2.3 Load Positioning

1. **Always** operate an attachment from the driver's seat.

2. **Always** lower the attachment if you need to leave the lift truck. Remember a lift truck supporting a load requires your full attention.

3. **Never** use the attachment or its load to support or move other loads or equipment.

4. **Always** carry loads as close to the floor as possible, consistent with the surface being traversed. Scraping or bumping the floor surface with the load or the attachment can severely damage the attachment and cause product damage. The mast should be tilted back.

5. **Always** keep the load positioned as close as possible to the horizontal center of the lift truck.

6. **Always** back down ramps or inclines. Driving forward down a ramp or incline with a clamped load will lessen the stability of the truck. (Figure 2-4)

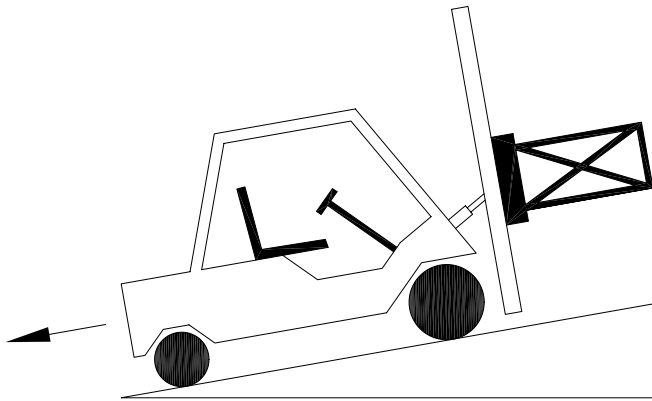


Figure 2-4

7. **Do not** cross dock boards or dock levelers with the attachment or carriage fully lowered. Ramming the front or rear of the attachment against a dock board can cause severe damage.

8. **Always** check loads to be handled. If they are broken, unbalanced, loose, or too heavy, advise a supervisor or properly correct the situation prior to handling.

9. **Limit** lift truck movement to a minimum when high stacking. Limit sideshift movement to a minimum when high stacking.

10. **Always** be observant when high stacking. Look for poorly stacked loads, overhead obstacles, broken cartons, or damaged products in the stack.

11. **Always** carry cylindrically shaped loads in the vertical position, not the horizontal.

12. **Always** clamp loads with the contact pads, if applicable, not the arm or arm base.

13. **Never** rotate a load that is off center to the centerline of rotation. Severe damage to the rotator could result.

14. **Always** check the attachment for proper fit and engagement of the truck carriage.

2.4 Operator's Controls

1. For clarity, the direction of arm movement is shown on the control handle. To move the arms in the direction shown, pull the handle towards the operator. To move the arms in the opposite direction, the push the handle away from the operator.

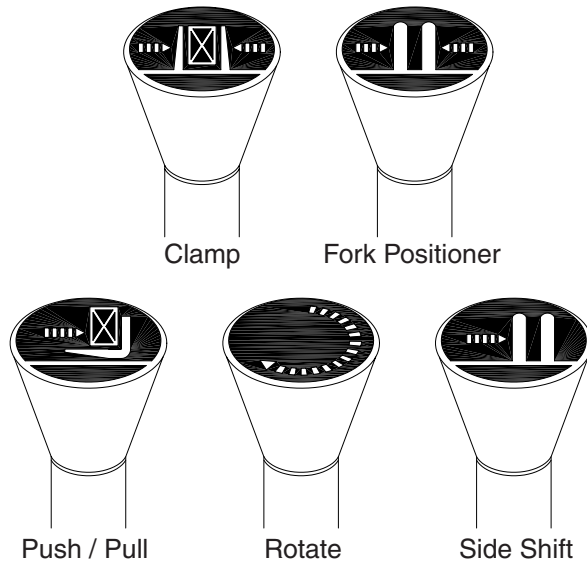


Figure 2-5

NOTE: OSHA OR STATE REGULATIONS MAY REQUIRE THE INSTALLATION OF BACKRESTS. WE SUGGEST THAT YOU CHECK YOUR APPLICATION AGAINST THOSE REQUIREMENTS.

SECTION 3

SERVICE PROCEDURE

3.1 Attachment Removal

1. Position the attachment forks to the width of the unit's body.



WARNING

BEFORE DISCONNECTING ANY HYDRAULIC CONNECTIONS BE SURE TO TURN OFF THE TRUCKS POWER AND ACTIVATE THE TRUCKS HYDRAULIC FUNCTIONS IN BOTH DIRECTIONS TO BLEED OFF THE HYDRAULIC PRESSURE.

2. Disconnect the hydraulic connection for the attachment positioning at the side shift cylinder.
3. Slightly raise the truck carriage to allow the removal of the lower retainer hooks.
4. Position the attachment on the edge of a pallet. Lower the attachment so that the lower carriage bar misses the pallet when lowered. Tilt the mast forward to allow the carriage to disengage from the upper mounting hooks and back away. If lowering onto a floor, blocks of wood can be place under the body of the attachment to raise the rear.
5. To reinstall, follow the installation procedure in this manual.



WARNING

WHEN HYDRAULIC SERVICING HAS BEEN PERFORMED, BEFORE RETURNING ATTACHMENT TO SERVICE BE SURE TO ACTIVATE THE HYDRAULIC FUNCTIONS SEVERAL TIMES TO BLEED OUT TRAPPED AIR IN THE SYSTEM.

3.2 Cylinder Removal

1. Disconnect the hydraulic connections.
2. Remove the cylinder rod end hair pin and clevis pin.
3. Remove hair pin and clevis pin at the base end of the cylinder.

3.3 Cylinder Installation

1. Install the clevis pin and hair pin into the base end of the cylinder.
2. Attach the hydraulic connections to the cylinder.
3. Extend the cylinder until the rod end hole lines up with the mounting hole. Install the clevis pin and hair pin into the rod end of the cylinder.
4. Turn on the trucks power and activate the positioning cylinders several times to bleed out trapped air.



WARNING

WHEN HYDRAULIC SERVICE HAS BEEN PERFORMED, BEFORE RETURNING ATTACHMENT TO SERVICE BE SURE TO ACTIVATE THE HYDRAULIC FUNCTIONS SEVERAL TIMES TO BLEED OUT TRAPPED AIR IN THE SYSTEM.

3.4 Cylinder Disassembly

1. Remove the cylinder from the attachment. See removal instructions.
2. Clamp the cylinder lightly at the base end in a soft jawed vise. Use a block or other support under the rod end of the cylinder. (Figure 3-1)

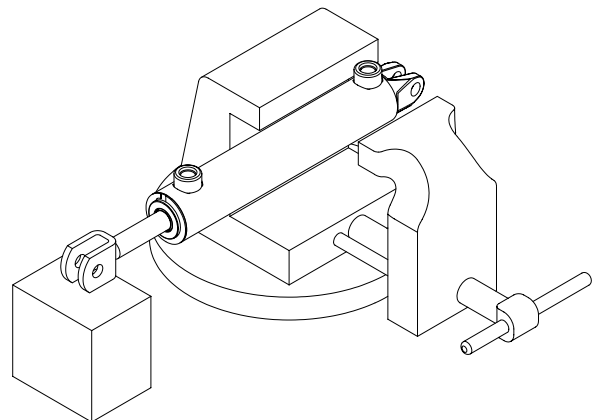


Figure 3-1, Cylinder Vise

3. Spread and remove the retaining ring from the gland cap.

4. Push gland inward 1 inch and pry out lock ring.

5. Remove the rod assembly from the cylinder tube.

6. Clamp the rod assembly in a soft jawed vise on the wrench flats, **not on the rod surface**. If the rod does not have wrench flats use two pieces of wood on both sides of the rod to prevent scaring. (Figure 3-2)

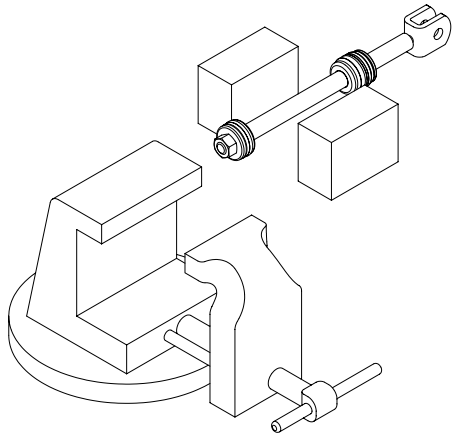


Figure 3-2, Cylinder Shaft

7. Remove the piston retaining nut and remove the piston. (Figure 3-3)

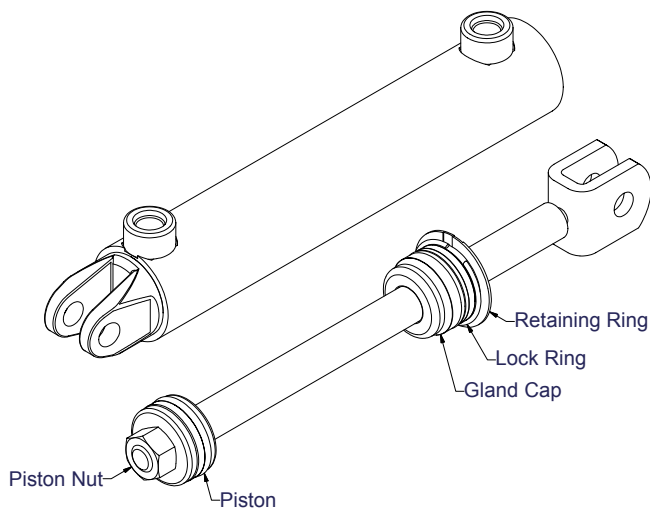


Figure 3-3, Rod Assembly

8. Carefully pry up on the piston seals using a blunt tip screw driver being careful not to scratch the seal grooves. Cut the seals to remove from the piston. (Figure 3-4)

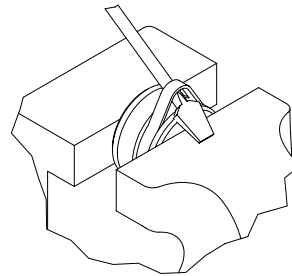


Figure 3-4, Piston Seal

9. Use the same procedure as above to remove the seals from the gland cap.

3.5 Cylinder Inspection

Inspect the cylinder tube bore for:

1. Deep scratches or nicks.
2. Signs of galling or excessive wear.
3. Out-of-roundness or deformities of the barrel.

Inspect the Piston for:

1. Scratches or nicks on seal grooves.
2. Wear on O.D.

Inspect the Cylinder Rod for:

1. Scratches or nicks on the rod surface.
2. Straightness of the rod.
3. Damaged threads.

Inspect the Gland Cap for:

1. Scratches or nicks in seal grooves.
2. Damaged threads or spanner wrench holes.
3. Excessive wear in bore.

Replace any component found to be bad.

3.6 Cylinder Assembly

1. Spray the Piston, Gland Cap, and Seals with WD40 or other similar product to ease slipping of the seals in place.

2. Note the direction of the seal on the piston. Improper installation will result in poor performance. The cupped side or O-Ring side of the seal should be facing the gland cap. (Figure 3-5)

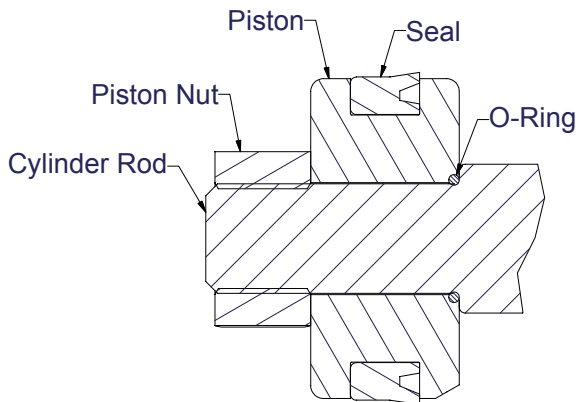


Figure 3-5, Piston Seal

3. Install the seals and wipers in the gland cap. Note the direction of the seals. The cupped side or O-Ring side of the seal should be facing the piston. (Figure 3-6)

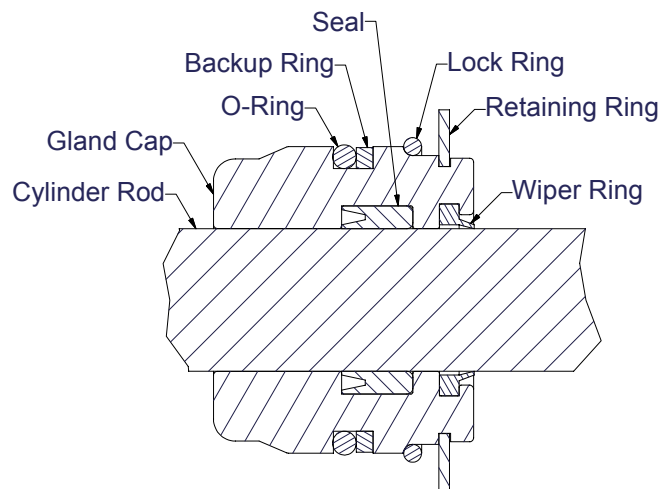


Figure 3-6, Gland Cap Seal

4. Install the gland cap on the cylinder rod being extremely careful not to cut the rod seal on the threads of the rod or rod shoulder. If available use a sleeve to cover the rod threads or plastic electrical tape.

5. Install the piston on the rod and tighten the locknut to 90 ft-lbs (0.56 UNF), 22 ft-lbs (0.75 UNF).

6. Spray the inside of the cylinder tube with lubricant to ease inserting the rod and piston. Insert the rod and piston into the cylinder tube. Tap the rod in with a rubber mallet if resistance is encountered.

7. Press on the lock ring and spread retaining ring to install onto the gland cap.

SECTION 4 MAINTENANCE

4.1 Maintenance Schedule

Daily:

1. Visually inspect all hoses, fittings and cylinder for signs of hydraulic leaks.

2. Visually inspect for external damage or cracks.

100 Hour Maintenance:

1. Complete the above daily checks.

2. Check all hoses and fittings for wear or damage. Inspect for hydraulic leaks.

3. Check for loose or missing bolts.

4. On the forks and top hooks, check grease fittings to ensure that they are clean and properly working.

5. Check wearstrips on the top hooks. Wearstrips should be replaced before top hooks contact carriage.

200 Hour Maintenance:

1. Re-Torque top hook bolts per chart.

4.2 Torque Specifications

Unless otherwise specified

SAE Grade 5 Capscrews

Nominal Size	Thread Series	Inches	Torque (Ft-Lbs)	
			Dry K=0.20	Lubed K=0.15
1/4	20 UNC	0.2500	8	6
	28 UNF		10	7
5/16	18 UNC	0.3125	17	13
	24 UNF		19	14
3/8	16 UNC	0.3750	31	23
	24 UNF		35	26
7/16	14 UNC	0.4375	49	37
	20 UNF		55	41
1/2	13 UNC	0.5000	75	57
	20 UNF		85	64
9/16	12 UNC	0.5625	110	82
	18 UNF		120	91
5/8	11 UNC	0.6250	150	115
	18 UNF		170	130
3/4	10 UNC	0.7500	265	200
	16 UNF		295	225
7/8	9 UNC	0.8750	430	320
	14 UNF		475	355
1	8 UNC	1.0000	645	485
	14 UNF		720	640
1-1/8	7 UNC	1.1250	795	595
	12 UNF		890	670
1-1/4	7 UNC	1.2500	1120	840
	12 UNF		1240	930

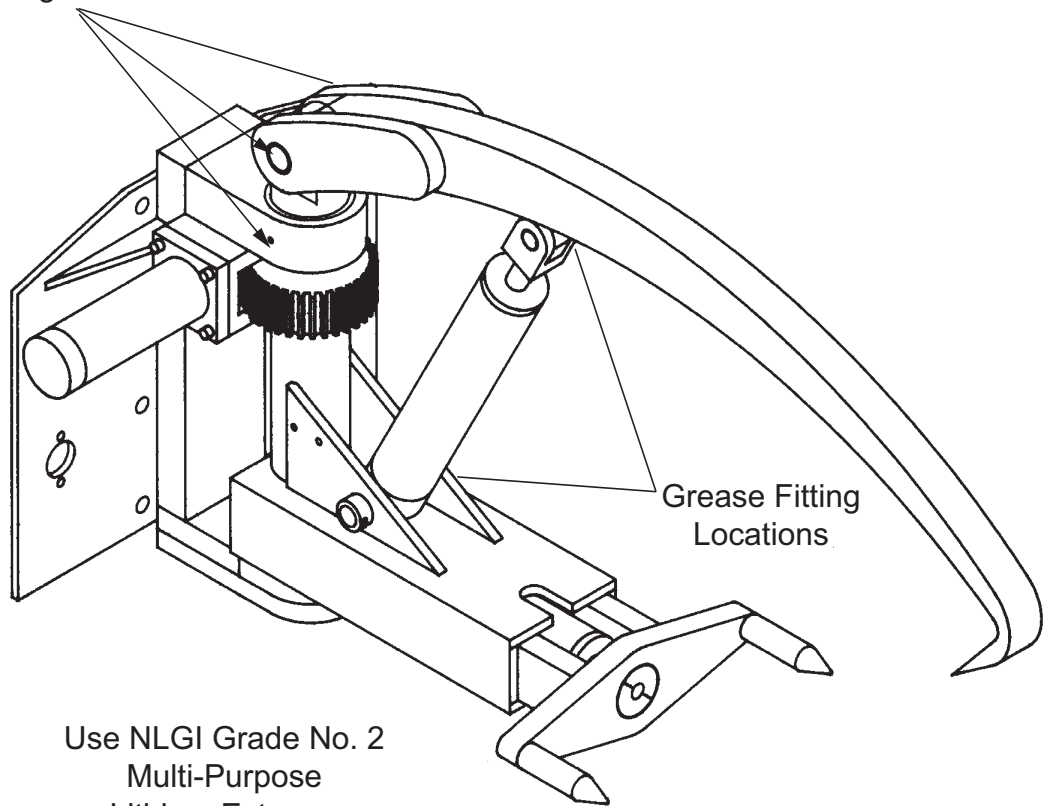
SAE Grade 8 Capscrews

Notes:

Nominal Size	Thread Series	Inches	Torque (Ft-Lbs)	
			Dry K=0.20	Lubed K=0.15
1/4	20 UNC	0.2500	12	9
	28 UNF		14	10
5/16	18 UNC	0.3125	25	18
	24 UNF		27	20
3/8	16 UNC	0.3750	44	33
	24 UNF		49	37
7/16	14 UNC	0.4375	70	52
	20 UNF		78	58
1/2	13 UNC	0.5000	105	77
	20 UNF		120	90
9/16	12 UNC	0.5625	155	112
	18 UNF		170	130
5/8	11 UNC	0.6250	210	155
	18 UNF		240	180
3/4	10 UNC	0.7500	375	280
	16 UNF		420	315
7/8	9 UNC	0.8750	605	455
	14 UNF		670	500
1	8 UNC	1.0000	910	680
	14 UNF		1020	765
1-1/8	7 UNC	1.1250	1290	965
	12 UNF		1440	1080
1-1/4	7 UNC	1.2500	1820	1360
	12 UNF		2010	1500

4.3 Lubrication

Grease Fitting Locations



Grease Fitting Locations

Use NLGI Grade No. 2
Multi-Purpose
Lithium Extreme
Pressure Grease

Figure 4.1, Grease Fitting Locations