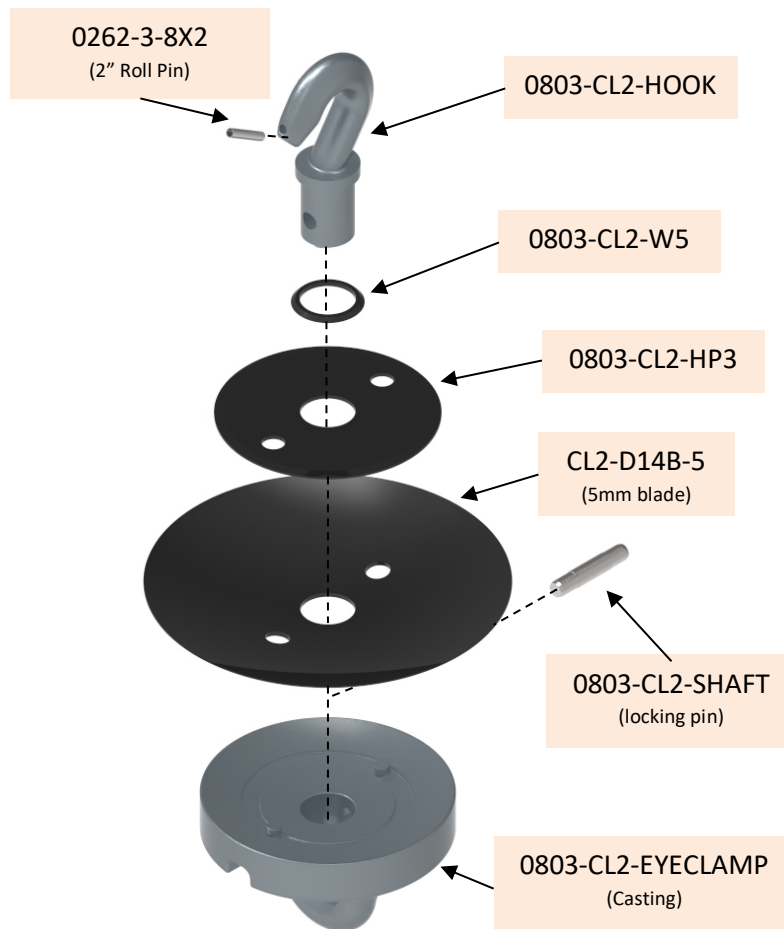
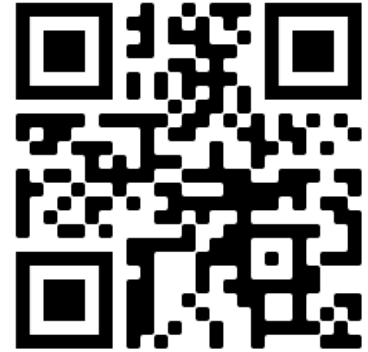


## CL2 Retrofit – Disc Change Procedure

This work instruction describes a procedure for the safe upgrade of CL2 discs. A demonstration of this process is available at <https://int.kellytillage.com/cl2-upgrade-program/> or using the QR code.



This work instruction should be read carefully in its entirety before commencing any work, as it contains safeguards and procedures to prevent possible injury.

*The CL2 discs weigh 53lb (24kg). Exercise care when lifting and maneuvering.*

**Caution:** *The discs have sharp edges. Protective gloves are recommended when handling the discs and the assemblies.*

### Equipment

- 10 Ton press with guarding
- Lump Hammer
- Personal Protective Equipment:
  - Safety glasses
  - tear & puncture resistant gloves
  - hearing protection
- safety boots (steel cap)
- Lock Pin Punch  $\varnothing 5/8''$  ( $\varnothing 16\text{mm}$ )
- Roll Pin Punch,  $\varnothing 3/8''$  ( $\varnothing 9\text{ mm}$ )
- Wire brush
- 2'' (50mm) paint scraper
- Crate for discarded blade & washer
- 5'' Angle Grinder or Oxy Cutting Gear

### Installation Procedure

#### Removing Disc Assemblies from Chain

1. To remove the CL2 disc assemblies from your machine, cut the roll pins off and drive a 3/8" pin punch through the hole to remove any remnants of the roll pin.



Caution: roll pin fragments are sharp and may cause lacerations.

Release the chain tension and separate the chain into individual assemblies.



The assemblies are heavy so use proper lifting techniques and hand protection when uncoupling and transferring to the press.

#### Removing Cutting Disc

2. Load the CL2 assembly into the press.



Ensure the hook is facing away from the operator as a safeguard against hook failure during loading.

3. *Slowly* lower the press to apply a force onto the hook.



Do not exceed 19,800 lb (9 MT) of force.

4. The force will compress the disc's convex surface to release the locking pin (0803-CL2-SHAFT). If too much pressure is applied, the locking shoulder of the pin will catch on the opposite edge of hole (the pin should 'float' in the hole space).
5. Push or tap the locking pin out with the 5/8" drift and lump hammer.
6. Inspect the ejected locking pin. Roll on a flat surface to check for straightness. If bent, worn or damaged, replace with new pin.



7. Raise the press and lift the hook (0803-CL2-HOOK) from the eye clamp (0803-CL2-EYECLAMP). If your assembly has the hook plate of the older CL2 design, this component will likely come away with the hook. Separate the hook plate from the hook and discard.
8. The blade should be free and can be removed and scrapped.
9. Clean the surfaces of dirt & plant material. Pay particular attention to the areas around the locating lugs.

#### Re-assembly

10. The re-assembly begins by positioning a new disc (0803-CL2-DB14B-5) onto the eye clamp, aligning the holes in the blade with the lugs on the casting.




11. Place the CL2-HP3 plate on the centre of the disc, aligning the holes with the cutting disc so the casting lugs are visible and aligned with the holes.
12. Slide a new washer (0803-CL2-W5) onto the round shank of the hook and insert through the hook plate (0803-CL2-HP3) and disc into the centre of the casting.

 **Ensure the hook is facing away from the operator.**



13. Align the hook so the locating hole in the shank is aligned with the pin hole in the eye clamp casting.

 **Correct alignment of press plunger, hook and body is critical to avoid injury.**

14. Apply load not exceeding 13200 lb (6000kg) to the hook, depressing the 0803-CL2-HP3 clamping plate until the locking pin holes align in the casting and the hook shank.
15. Insert the locking pin and tap into place. Ensure it is centralised in the housing. Release the press load.
16. At this point carefully check that the disc is not distorted. How flat is the rim of the disc?

**Quality Assurance:** The key compliance criteria for the resulting retrofitted CL2 assemblies are:

- ✓ Clamping loads are between 4400 - 13200 lb (2000 – 6000 kg)
- ✓ Disc distortion at the cutting edge is less than 3/32" (2mm).



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If your assembly fails either of these criteria, please put aside for a credit and replacement.