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ROPE GUIDE RETROFIT

1. Turn power off to hoist.
2. Disconnect all electrical connected to hoist and trolley, lower hoist to floor.
3. Inspect cable for any damage.
4. Remove dead ending pin, carefully wrap cable with hook block assembly onto drum. If reeving is 4 part single you must remove the upper sheave and pin in order to wrap cable with hook block and sheave onto drum.



5. Remove drum guard (this will not be required at reassembly)
6. Remove outboard ball bearing cover or geared limit switch & bracket.

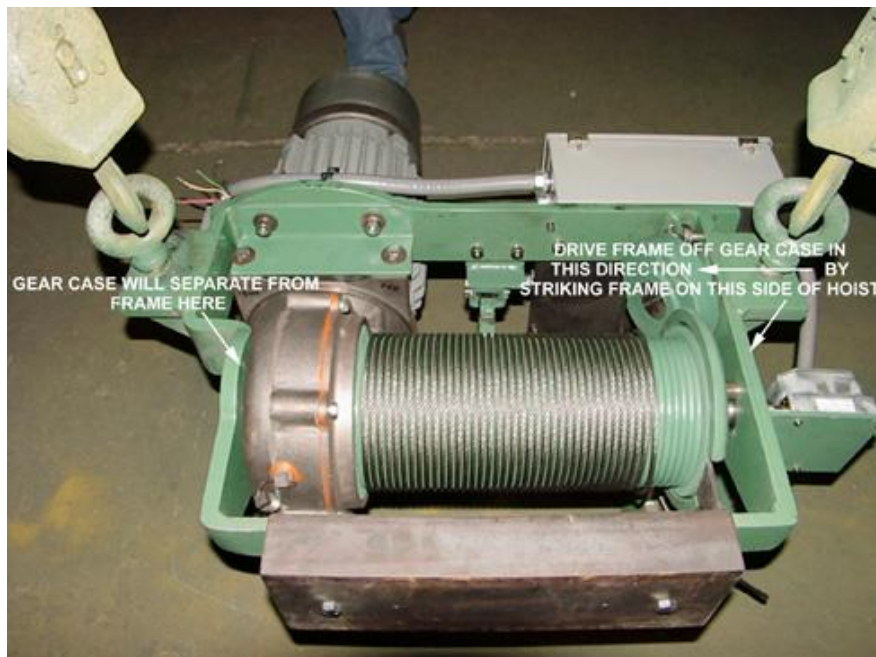


7. Remove screws on motor pickup. Typically there are: (1) screw for a "m" or "a" hoist; (4) screws for a "b" hoist; (1) screw for a "c" hoist; and (2) screws for a "d" hoist. To identify hoist see chart

HOIST	GEARCASE MARKING
M	P419
A	T478
B	T477
C	T479
D	P417

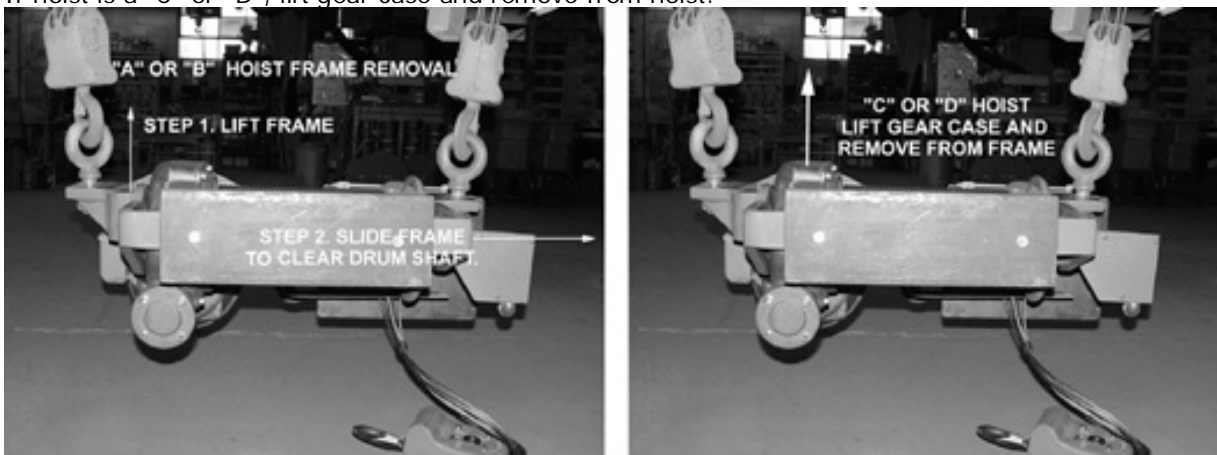


- Using a soft mallet, hit the frame on the outboard ball bearing side (drum side) driving the frame off the gearcase.



- Remove the outboard ball bearing from the drum shaft.

10. If hoist is an "A" or "B" hoist, lift the frame to clear the gear case and slide frame away to clear drum shaft. If hoist is a "C" or "D", lift gear case and remove from frame.



11. Loosen setscrew on drum and remove with puller. Note: some drums may have two setscrews per hole.



12. If the hoist is equipped with a paddle limit switch bracket that is welded into place, it must be removed and the welds must be ground smooth.
13. Remove gearcase side cover (only required on type "A" or "B" hoists). Rotate gearcase/motor assembly onto its side and remove the (6) bolts. Replace with side cover and seals supplied with the retrofit components.

REASSEMBLE

1. Apply anti seize compound on drum shaft.
2. Insert keys in slots of drum shaft, align rope guide drum onto drum shaft.
3. Spot drill drum shaft at pre drilled hole in last groove of drum. Be careful not to damage threads. Use 27/64" dia. "long shank" drill for 1/2" setscrew. Use 21/64" "long shank" drill for 3/8" setscrew.
4. Coat threads of set screw with medium strength thread lock cement (blue loctite or equivalent)

5. Place *knurled* cup point socket set screw against shaft into spotted hole and tighten to recommended seating torque: 3/8" dia. Setscrew = 24 ft.-lbs., 288 in.-lbs.
1/2" dia. Setscrew = 52 ft.-lbs., 624 in. Lbs.
(do not try to move drum with setscrew tightened.)
6. Slide shaft collar onto shaft and press against drum.



7. If hoist is an "A" or "B" hoist slide frame onto drum shaft and lower the frame to the gear case. If hoist is a "C" or "D" hoist lower gear case into the frame.
8. Install the outboard ball bearing to the drum shaft.
9. Using a soft mallet hit the frame onto the gearcase.
10. Tighten set screws on drum shaft collar.
11. Install and tighten motor pickup screws.
12. Install outboard ball bearing cover or geared limit switch & bracket
13. Clamp rope guide bracket to the back member (opposite motor side), approximately centered horizontally with the drum. The vertical leg of the angle must be flush with the top of the frame member. The holes cut in the bracket will fit over the bolts holding the paddle limit switch to the frame. Weld intermittently to the frame.



14. Lay the flat steel blade on the horizontal leg of the angle, centered about the drum (as shown).

HOOKBLOCK SIDE



GEARCASE SIDE

15. Place the bronze cable guide at the approximate center of the drum and slide the steel blade into the horizontal slot in the back of the guide.



16. Adjust the in-and-out of the blade toward the drum so there is no clearance. This will capture the bronze finger between the blade and drum.
17. Mark and drill (2) 9/16" holes through the blade and angle for attachment. Do not bolt the blade to the bracket yet. The cable must first be reeved onto the drum.
18. If hoist was equipped with a welded on limit switch, take the existing switch, without bracket, along with the new lever (supplied) and attach it to the underside of the rope guide bracket in the pre-drilled holes. The lever should be positioned above the hook block at full up position.



(NOT ALL LIMIT SWITCH ASSEMBLIES WILL LOOK LIKE THIS)

19. If hoist is 4 part single reeving you must install upper sheave and pin.
20. Reeve cable onto hoist.
21. Attach cable clips per service manual.
22. Connect power to the hoist and run the hoist down so the drum is approximately half full with cable.
23. Place the bronze guide in the first open groove next to the cable and slide the blade into the horizontal slot and bolt the blade into place.



24. Connect remaining electrical connections to the hoist and trolley, raise hoist to original location.
25. Turn power on to the hoist.
26. Check hook block movement and insure that the hook block moves correctly.
27. Retorque cable clips after applying load.
28. Run the hoist full up to full down and check that the bronze cable guide runs smoothly in the grooves of the drum. If the guide does not reach the far end (hook block side) of the drum, loosen the bolts and slide the blade so the guide reaches the last groove of the drum (hook block side).