

PowerTilt 4.5 Service and Repair Manual

PT-4.5



Introduction

Product Introduction

This manual contains instructions for the repair, disassembly and reassembly of the PowerTilt Model PT-4.5 only. For complete product, installation, service and safety information, refer to the PowerTilt Instruction, Service and Repair Manual for the PT, PTA and PTB Series.

For additional information on maintaining, servicing or repairing the PT-4.5, please contact Parker Hannifin Corporation:

E-Mail: cylsaleshelac@support.parker.com

Web: www.parker.com/helac

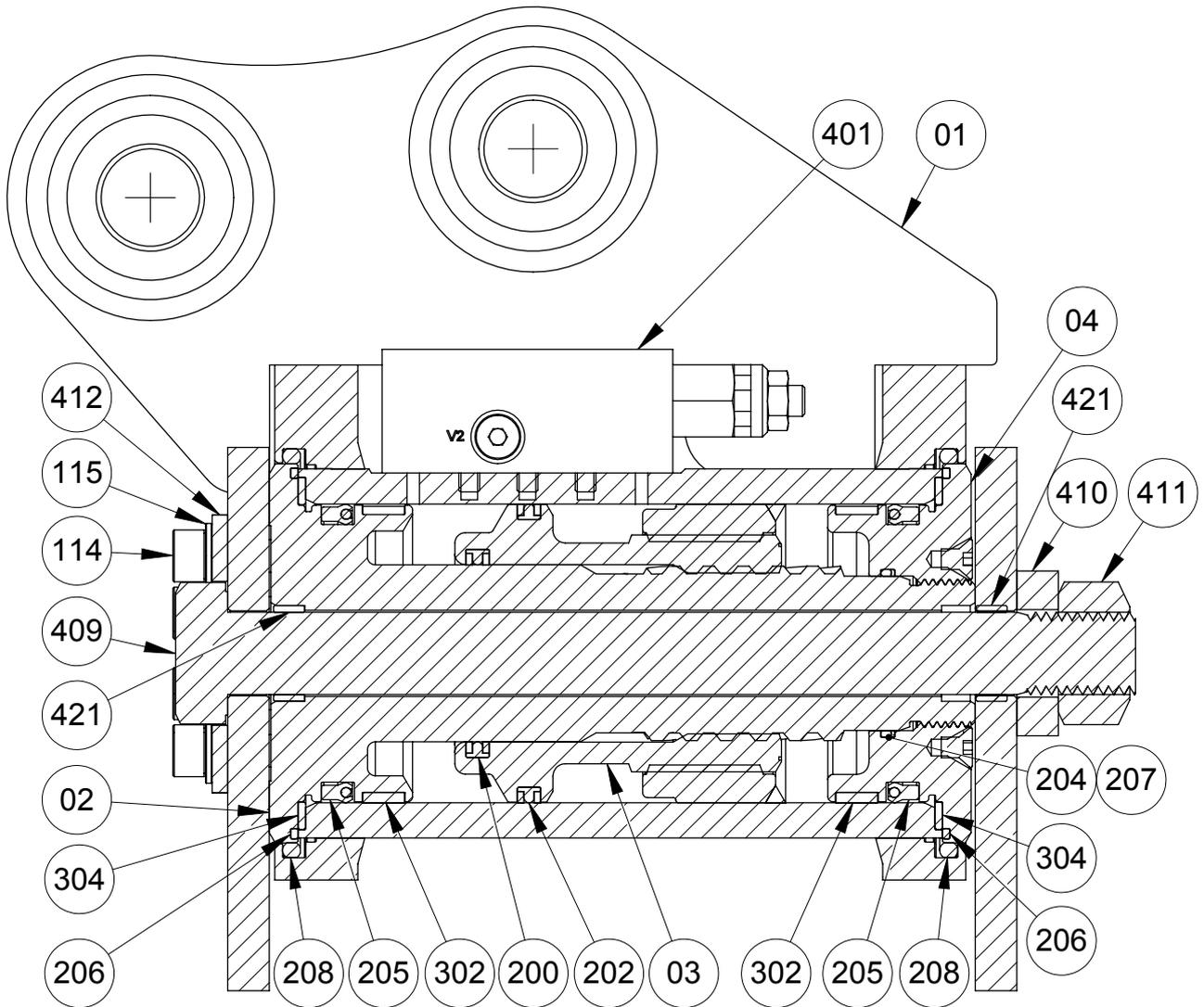
PT-4.5 Specifications

Max Machine Weight	Approximate PowerTilt Weight*	Total Tilt	Driving Torque	Holding Torque	Required Oil Flow	Circuit Pressure Range
kg	kg		Nm @ 210 bar	Nm @ 210 bar	l/min	
1800	35	180° **	930	2470	2-4	150-250 bar

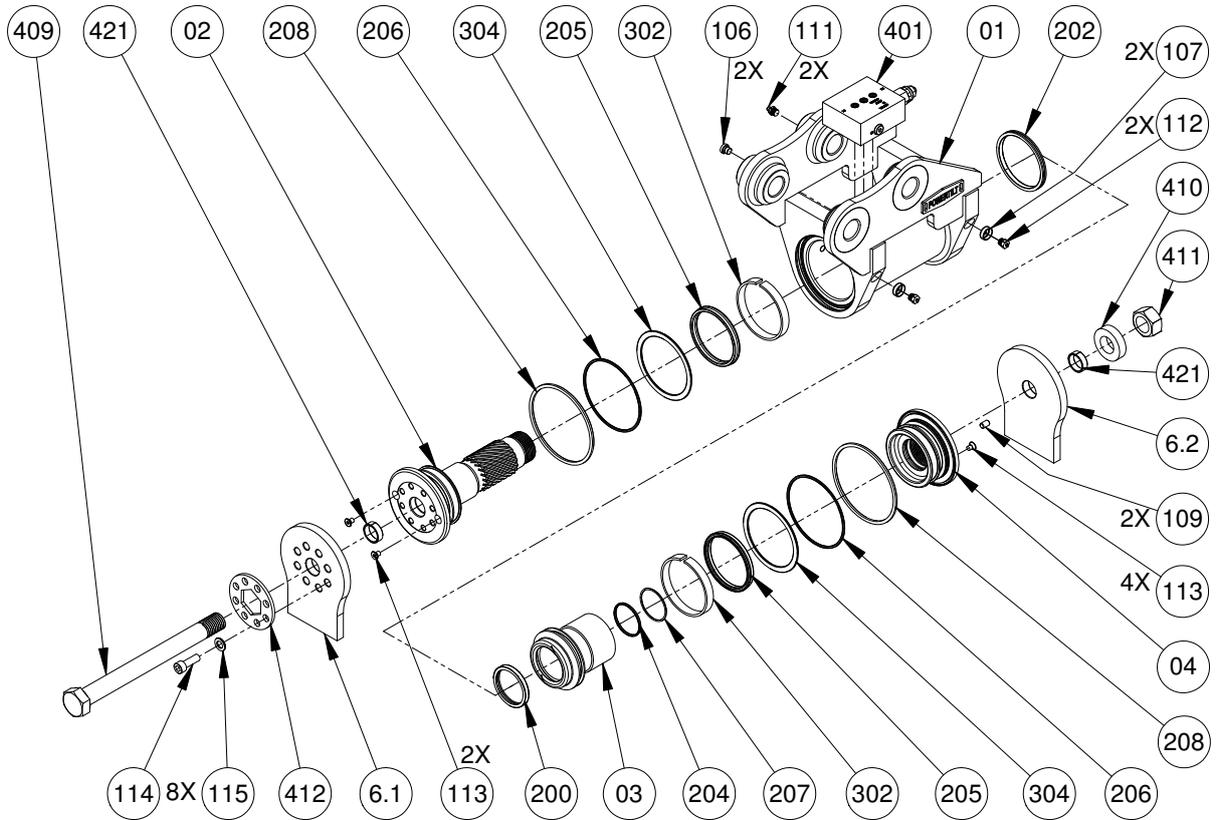
* Weights may vary depending on model size. Approximate weights for PTA and PTB Series do not include mounting brackets or couplers.

** Actual rotation may vary slightly.

PT-4.5 Assembly Drawing



PT-4.5 Exploded View



Parts List - PT-4.5

Parts

Part Number	Item #	Description	Qty
68560	01	Housing - PTA 180 degree (no side plates or bosses)	1
Obsolete	01	Housing - PTA 110 degree (no side plates or bosses)	1
27707	02	Shaft 180 Degree (8 bolt)	1
Obsolete	02	Shaft 110 Degree (10 Bolt)	1
26802	03	Piston Sleeve 180 Degree	1
Obsolete	03	Piston Sleeve 110 Degree	1
26801	04	End Cap	1
69800-H	6.1 / 6.2	Foot Kit (Standard)	1
977022	106	Port Plug (BSPP G 1/8)	2
74897	107	**Grease Relief Valve Cover	2
27713	109	**Service and Lock Pin kit	1
936002	111	**Grease Fitting (Balcrank, 5000 Lincoln, 1/8-27 NPT)	2
938001	112	**Grease Relief Valve (50500, 1/8-27 NPT, Alemite 400-650 PSI)	2
958008-H	113	Set Screw (HSFHCS; 1/4"-20 x .375, Grade 8)	6
9551012	114	Torque Foot Screw (SHCS; M10-1.5-030 Grd 12.9)	8
9664001	115	Washer (M10 hardened flat washer)	10
S71503	401	Cross Port Relief Valve Assy w/ PO Checks (includes valve manifold with cartridges and items below)	1
		O-ring (2-012, 90 durometer Buna N)	2
		Screws (socket head 1/4"-20 - 1.50" Grd 8)	3
70811	409, 410, 411	Tie Rod Bolt Assembly	1
70681	412	Lock Plate	1
931070	421	Bushing	2

**Items included in seal kit

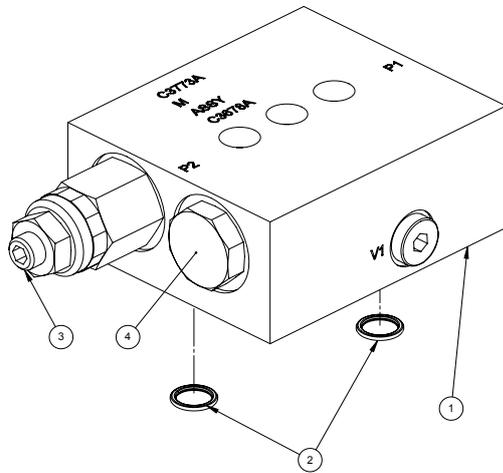
Seal and Bearing Kits

Part Number	Item #	Description	Qty
S26803-1		Seal Kit (parts listed below included)	
	107	Grease Relief Valve Cover	2
	109	Service and lock pin kit	1
	111	Grease Fitting	2
	112	Grease Relief Valve	2
	200	Seal	1
	202	Seal	1
	204	O-Ring	1
	205	Seal	2
	206	O-Ring	2
	207	Back-up Ring	1
208	O-Ring	2	
S26807-1		Bearing Kit (parts listed below included)	
	302	Bearing	2
	304	Thrust Washer	2

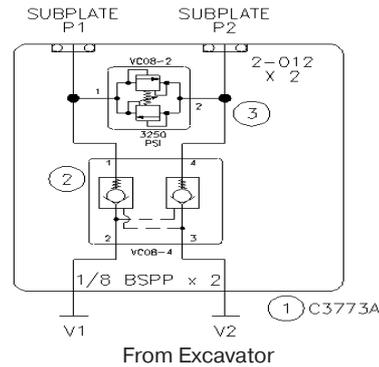
TT-4.5 Serial Numbers that used 110 Degree Shaft and Piston Sleeve

Between Beginning #	And Ending #	Beginning Year Made	End Year Made
198856	329045	2001	2006
T210751	T210758	2002	2002
All other serial numbers use the 180 degree shaft and piston sleeve			

Cross Port Relief Valve



Item	Description	Quantity
1	Manifold Body	1
2	O-Ring	2
3	Dual Relief	1
4	Dual PO Check	1



DISASSEMBLY

Disassembly



WARNING

To avoid personal injury and machinery damage:

Read the Service and Repair Manual for proper installation, maintenance and repair procedures.



CAUTION

Spraying fluids:

Contents under pressure. Wear approved eye protection. Use caution when removing port plugs and fittings.



CAUTION

To avoid injury or damage to product:

Secure product to work bench.

NOTICE

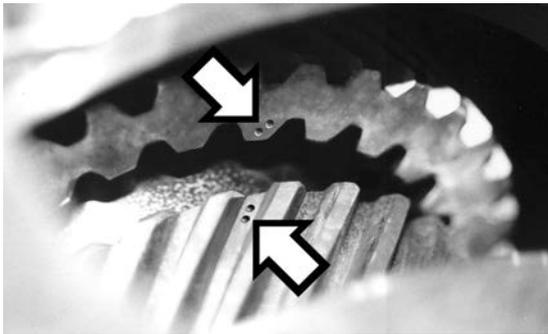
To avoid contamination to machined parts:

Make sure work area is clean.

NOTICE All numbers that appear in parenthesis () in the following sections are referring to items on Page 3.

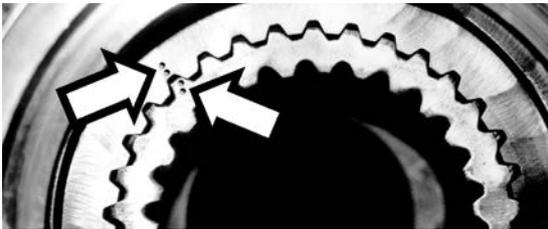
1. First remove the tie rod, washer and nut assembly (409, 410, 411, 412), cap screws (114) and washers (115) to remove the lower coupler, bucket, attachments and/or other assemblies.
2. Next remove the port plugs (106) and drain the oil. Inspect the oil for signs of contamination, i.e. water, metal shavings.
3. During the end cap removal process, begin with removing the set screws (113) that cover the end cap lock pins (109). Using a 4 mm drill bit, drill a hole in the center of each lock pin to a depth of approximately 9.5 mm. Remove the lock pins using a screw extracting tool. Insert two appropriately sized screws and service pins in the grease ports. Unthread the end cap (4) by turning it counterclockwise using a pry bar. Remove the end cap and set aside for inspection.
4. Rotate the shaft (2) and piston sleeve (3) so both components are flush with the ring gear inside the housing (1). Do not remove the

Disassembly



shaft; it must remain in the housing so that gear timing marks can be located in Step 5.

5. Locate the timing marks on the piston sleeve (3) gearing and shaft (2). Every PowerTilt has two sets of small punched timing marks that indicate timing between the gear sets. One set indicates the timing between the shaft (2) and the piston sleeve (3) as seen in the photo above (the shaft timing marks may be located in the root or “V” of the gearing). The second set indicates timing between the piston sleeve and the housing (1) as seen in the photo below.



6. Prior to removing the shaft (2), use a felt marker to highlight the punched timing marks between the shaft and piston sleeve (3) as seen in the photo below to simplify timing when the PowerTilt is reassembled. Rotate the shaft (2) counterclockwise until it disengages from the piston sleeve (3) and can be removed. Gently



tap the end of the shaft with a plastic mallet and mandrel if needed.

7. As in Step 6 above, before removing the piston sleeve (3), mark the housing (1) ring gear in relation to the piston sleeve outside diameter gear with a marker as seen in the photo below. Be sure to gently push the piston sleeve (3) out of the housing (1) until the gear teeth just come out of engagement with the housing gear teeth. Then remove the



piston sleeve (3). Use a plastic mallet and mandrel if necessary. Avoid scratching or denting the inside of the housing bore.

8. Remove all seals, bearings and thrust washers from the end cap (4), shaft (2), piston sleeve (3) and housing (1). Note their order and orientation to aid assembly.

NOTICE

It is not necessary to remove the valve block and cartridge unless leakage is suspected.

Assembly

NOTICE Replace all seals, bearings and thrust washers (304) as required.

1. Before installation, coat the seals and machined surfaces with a high quality hydraulic oil.
2. Coat the end cap (4) threads and both sides of the thrust washers (304) with lithium grease.
3. Install all the seals, bearings and thrust washers on the end cap (4), piston sleeve (3) shaft (2) and housing (1). Refer to the Assembly Drawing on Page 2 and PT-4.5 Exploded View on Page 3 for correct locations and orientations.
4. Carefully insert the piston sleeve (3) into the housing (1) until it contacts the housing ring gear. Rotate the piston sleeve until the timing marks applied to the piston and housing during the disassembly process align. Using a plastic mallet or mandrel, tap the piston into the housing until the gear teeth contact.

5. Insert the shaft (2) into the piston sleeve (3), aligning the timing marks of the shaft with the piston sleeve. Once the timing marks are verified, rotate the shaft inward until the pressure seal (205) contacts the housing (1). Then tap gently to compress the seal and rotate the shaft into the housing.

NOTICE As the shaft is installed, be careful not to disengage the piston sleeve and housing gearing.

6. Thread the end cap (4) onto the shaft (2). Using a pry bar, tighten the end cap until the lock pin (109) holes align. Then insert the lock pins (109) into the holes with the dimple side up. Using a punch, tap the lock pins to the bottom of the hole. Insert the set screws (113) over the lock pins and tighten to 2.8 Nm. Install the port plugs (106).

Fastener Torque Specifications

Torque Values for Port Plugs and Fittings

Plug Size	Torque Value - Steel Plug / Fitting in Steel Port Nm	Torque Value - Steel Plug / Fitting in Aluminum Manifold Nm
BSPG G1/8	18 +/- 1	10 +/- 1

Torque Values for Metric Fasteners

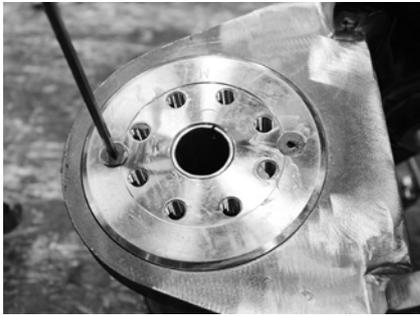
Fasteners	Socket Head Bolt (grd 12.9) Nm	Hex Head Bolt (grd 10.9) Nm	Jam Nut (grd 12.9) Nm
M10 x 1,50	60 +/- 3	44 +/- 3	27 +/- .2
M12 x 1,75	103 +/- 5	75 +/- 4	41 +/- .3
M16 x 2,00	258 +/- 7	187 +/- 5	54 +/- .5
M20 x 2,50	502 +/- 20	365 +/- 14	61 +/- 1
M24 x 3,00	868 +/- 27	630 +/- 20	68 +/- 2
M30 x 3,50	1 723 +/- 41	1 253 +/- 34	

Greasing and Testing

Greasing

After the actuator is assembled but before it is put into service, the thrust washer area must be packed with Lithium grease.

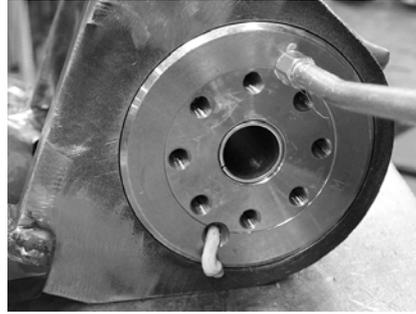
1. There are two grease ports located on both the shaft flange and the end cap. They are plugged with cap screws (113) or set screws. Remove the grease port screws from the shaft flange and end cap. (See exploded view on page 4)



NOTICE

If a hydraulic test bench is not available, the actuator can be rotated by hand, open the pressure ports and use a pry bar with cap screws inserted into the shaft flange to turn the shaft in the desired direction.

2. Insert the tip of a grease gun into one port and apply grease to the shaft flange. Continue applying until grease flows from the opposite port. Cycle the actuator five times and apply grease again. Repeat this process on the end cap. Insert the cap screws into the grease ports and tighten to 25 in-lbs. (2.8 Nm).



Testing

If the equipment is available, the PowerTilt should be tested on a hydraulic test bench. The breakaway pressure — the pressure at which the shaft begins to rotate — should be approximately 28 bar. Cycle the actuator at least 25 times at 210 bar pressure.

Testing for internal leakage

Connect hydraulic lines to the housing ports. Bleed all air from the PowerTilt. Rotate the shaft to the end of rotation at 210 bar and maintain pressure. Remove the hydraulic line from the non-pressurized side. Continuous oil flow from the open housing port indicates internal leakage across the piston or cross port relief valve. Replace the line and rotate the shaft to the end of rotation in the opposite direction. Repeat the test procedure outlined above for the other port. If there is an internal leak, disassemble, inspect and repair.

Install Quick Coupler

1. Install coupler on PowerTilt. Insert 8 ea. M10 screws (114) with washers (115) through lock plate (412) and torque to 68 Nm (50 ft-lbs).



2. Insert screw (409), 1" tie-rod bolt through center of PowerTilt from the torque foot end, install spacer (410) and lock-nut (411) and torque to 920 Nm (680 ft-lbs).



Maintenance

Daily

1. Grease the thrust washers at the two grease fittings with a high quality Lithium-based grease. Apply grease until clean grease flows from the grease reliefs. Severe operating conditions such as abrasive dust or prolonged submersion in water may require more frequent grease applications.
2. Make sure the grease reliefs are functioning properly. Open or replace non-functioning grease reliefs immediately.

NOTICE

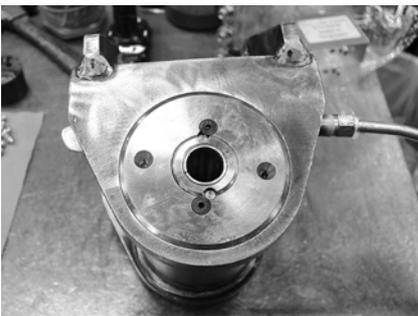
Never replace the grease relief valves with grease fittings or plugs.

NOTICE

Do not operate the PowerTilt if the grease reliefs are not functioning.

Monthly

Check shaft end play. When the end play exceeds 0.38 mm, the end cap must be tightened.



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7. Confidential Information. Buyer acknowledges and agrees that any technical, commercial, or other confidential information of Seller, including, without limitation, pricing, technical drawings or prints and/or part lists, which has been or will be disclosed, delivered or made available, whether directly or indirectly, to Buyer ("Confidential Information"), has been and will be received in confidence and will remain the property of Seller. Buyer further agrees that it will not use Seller's Confidential Information for any purpose other than for the benefit of Seller.

8. Loss to Buyer's Property. Any tools, patterns, materials, equipment or information furnished by Buyer or which are or become Buyer's property ("Buyer's Property"), will be considered obsolete and may be destroyed by Seller after two (2) consecutive years have elapsed without Buyer ordering the Products manufactured using Buyer's Property. Furthermore, Seller shall not be responsible for any loss or damage to Buyer's Property while it is in Seller's possession or control.

9. Special Tooling. "Special Tooling" includes but is not limited to tools, jigs, fixtures and associated manufacturing equipment acquired or necessary to manufacture Goods. Seller may impose a tooling charge for any Special Tooling. Such Special Tooling shall be and remain Seller's property notwithstanding payment of any charges by Buyer. In no event will Buyer acquire any interest in the Special Tooling, even if such Special Tooling has been specially converted or adapted for manufacture of Goods for Buyer and notwithstanding any charges paid by Buyer. Unless otherwise agreed, Seller has the right to alter, discard or otherwise dispose of any Special Tooling or other property owned by Seller in its sole discretion at any time.

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11. User Responsibility. Buyer, through its own analysis and testing, is solely responsible for making the final selection of the Products and assuring that all performance, endurance, maintenance, safety and warning requirements of the application of the Products are met. Buyer must analyze all aspects of the application and follow applicable industry standards, specifications, and any technical information provided with the Quote or the Products, such as Seller's instructions, guides and specifications. If Seller provides options of or for Products based upon data or specifications provided by Buyer, Buyer is responsible for determining that such data and specifications are suitable and sufficient for all applications and reasonably foreseeable uses of the Products. In the event Buyer is not the end-user of the Products, Buyer will ensure such end-user complies with this paragraph.

12. Use of Products; Indemnity by Buyer. Buyer shall comply with all instructions, guides and specifications provided by Seller with the Quote or the Products. Unauthorized Uses. If Buyer uses or resells the Products in

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13. Cancellations and Changes. Buyer may not cancel or modify, including but not limited to movement of delivery dates for the Products, any order for any reason except with Seller's written consent and upon terms that will indemnify, defend and hold Seller harmless against all direct, incidental and consequential loss or damage and any additional expense. Seller, at any time, may change features, specifications, designs and availability of Products.

14. Limitation on Assignment. Buyer may not assign its rights or obligations without the prior written consent of Seller.

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21. Entire Agreement. These Terms, along with the terms set forth in the main body of any Quote, forms the entire agreement between the Buyer and Seller and constitutes the final, complete and exclusive expression of the terms of sale and purchase. In the event of a conflict between any term set forth in the main body of a Quote and these Terms, the terms set forth in the main body of the Quote shall prevail. All prior or contemporaneous written or oral agreements or negotiations with respect to the subject matter shall have no effect. These Terms may not be modified unless in writing and signed by an authorized representative of Seller.

22. Compliance with Laws. Buyer agrees to comply with all applicable laws, regulations, and industry and professional standards, including those of the United States of America, and the country or countries in which Buyer may operate, including without limitation the U.S. Foreign Corrupt Practices Act ("FCPA"), the U.S. Anti-Kickback Act ("Anti-Kickback Act"), U.S. and E.U. export control and sanctions laws ("Export Laws"), the U.S. Food Drug and Cosmetic Act ("FDCA"), and the rules and regulations promulgated by the U.S. Food and Drug Administration ("FDA"), each as currently amended. Buyer agrees to indemnify, defend, and hold harmless Seller from the consequences of any violation of such laws, regulations and standards by Buyer, its employees or agents. Buyer acknowledges that it is familiar with all applicable provisions of the FCPA, the Anti-Kickback Act, Export Laws, the FDCA and the FDA and certifies that Buyer will adhere to the requirements thereof and not take any action that would make Seller violate such requirements. Buyer represents and agrees that Buyer will not make any payment or give anything of value, directly or indirectly, to any governmental official, foreign political party or official thereof, candidate for foreign political office, or commercial entity or person, for any improper purpose, including the purpose of influencing such person to purchase Products or otherwise benefit the business of Seller. Buyer further represents and agrees that it will not receive, use, service, transfer or ship any Products from Seller in a manner or for a purpose that violates Export Laws or would cause Seller to be in violation of Export Laws. Buyer agrees to promptly and reliably provide Seller all requested information or documents, including end-user statements and other written assurances, concerning Buyer's ongoing compliance with Export Laws. 8/20

Notes

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Tel: +43 (0)7224 66201

AZ – Azerbaijan, Baku

Tel: +994 50 2233 458

BE/NL/LU – Benelux,

Hendrik Ido Ambacht
Tel: +31 (0)541 585 000

BY – Belarus, Minsk

Tel: +48 (0)22 573 24 00

CH – Switzerland, Etoy

Tel: +41 (0)21 821 87 00

CZ – Czech Republic,

Prague
Tel: +420 284 083 111

DE – Germany, Kaarst

Tel: +49 (0)2131 4016 0

DK – Denmark, Ballerup

Tel: +45 43 56 04 00

ES – Spain, Madrid

Tel: +34 902 330 001

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