

**CONVERSION KITS**  
**46542, 46543, 46544, 46545, 46546**

INSTALLATION INSTRUCTIONS  
ARO 7700-D SERIES TO 7700-E SERIES HOISTS  
(REFERENCE OPERATOR'S MANUAL SECTION M50, MANUAL 11. NEW  
-E SERIES MANUAL, SECTION M50, MANUAL 12 ENCLOSED)

**46542 CONVERSION KIT**

**KIT INCLUDES:**  
1 46073-1 HEAD ASS'Y.  
1 46076 MOTOR ASS'Y.  
1 Y325-9 "O" RING  
2 Y325-12 "O" RING  
1 Y325-154 "O" RING

**DISASSEMBLY**

**HEAD SECTION REMOVAL** — Shut off air supply to hoist and remove air inlet hose from hoist head inlet adapter. Drain oil from reservoir of Head.

Drive out Roll Pin (Y178-56) which secures Gear (34022) to Control Rod. Remove Six (6) Screws (Y154-54) and Washers (Y14-10) and remove Head with Gear (34022) and Gasket (41623) from hoist housing. Lay aside for later use.

**MOTOR SECTION REMOVAL** — Remove two (2) Screws (Y19-112), Housing Cap (41585), Brake Spring (33281), Brake Shoes (33387) and Balls (Y16-10). Place a pin thru hole in Brake Wheel (33376) to keep from turning and remove Nut (Y12-106) and Washer (Y117-116). Remove Brake Wheel. Remove Motor Assembly from housing.

**REASSEMBLY**

Remove "O" Ring (41579) from housing and replace with new "O" Ring (Y325-154) supplied with kit.

Refer to pages 8, 10, 11, 12 and 13 of Operator's Manual, supplied with kit, for reassembly of hoist. Remove tape from Head that holds Muffler Fillers in place before assembling to housing. Follow Lube and Inspection requirements.

**IMPORTANT:** Test operation of hoist INCLUDING BRAKE FUNCTION before placing hoist in use.

**46543 CONVERSION KIT (LINK CHAIN HOIST)**

**KIT INCLUDES:**  
1 44677 HOUSING AND BUSHING ASS'Y.  
1 46067-1 CAPACITY LABEL  
1 46067-2 CAPACITY LABEL  
1 46067-3 CAPACITY LABEL  
1 Y13-4-C WASHER  
1 Y157-51 CAP SCREW

Refer to Operator's Manual originally supplied with hoist (Section M50, Manual 11) to disassemble components from old housing and for reassembly to new Housing Assembly (44677). Refer to Operator's Manual supplied with kit (Section M50, Manual 12) for correct method of anchoring load chain to new housing. Follow Lube and Inspection requirements as outlined in Operator's Manual(s). Apply correct Capacity Label to hoist housing to show the same maximum rated load capacity of housing being replaced.

**IMPORTANT:** Test operation of hoist INCLUDING BRAKE FUNCTION before placing hoist in use.

**46544 CONVERSION KIT (ROLLER CHAIN HOIST)**

**KIT INCLUDES:**  
1 44677 HOUSING AND BUSHING ASS'Y.  
1 44686 ANCHOR BLOCK  
1 46067-1 CAPACITY LABEL  
1 46067-2 CAPACITY LABEL  
1 46067-3 CAPACITY LABEL  
1 Y157-51 CAP SCREW

Follow instructions as outlined for 46543 Conversion Kit.

**46545 CONVERSION KIT**

**KIT INCLUDES:**  
1 45667 HOUSING (BRAKE) CAP  
1 45672-1 CAPACITY LABEL  
1 45672-2 CAPACITY LABEL  
1 45672-3 CAPACITY LABEL  
2 Y19-113-C MACHINE SCREW

Remove two (2) Screws (Y19-112) and old Housing Cap (41585). Apply correct Capacity Label to Brake Cap (45667) to show the same maximum rated capacity on Cap being replaced and assemble new Cap (45667) to Housing securing with two (2) Machine Screws (Y19-113-C) supplied with kit.

**46546 CONVERSION KIT (1/2 and 1-Ton)**

**KIT INCLUDES:**  
1 45912 GEARING ASS'Y.  
4 Y99-41 CAP SCREW

Refer to pages 7, 11 and 12 of Operator's Manual originally supplied with hoist (Section M50, Manual 11) for removal of old Gearing Assembly. Refer to pages 6 and 11 of Operator's Manual supplied with kit (Section M50, M 12) for assembling new Gearing Assembly (45912) to housing. New Cap Screws (Y99-41) supplied with kit, are required to secure new gearing to housing.

**IMPORTANT:** Test operation of hoist INCLUDING BRAKE FUNCTION before placing hoist in use.