

**46547 CONVERSION KIT  
INSTALLATION INSTRUCTIONS  
ARO 7700-D SERIES TO 7700-E SERIES HOISTS  
(REFERENCE OPERATOR'S MANUAL SECTION M50,  
MANUAL 11 AND SECTION M50, MANUAL 12)**

**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.

Remove Screw (Y200-59) and Washer (33274) from Spindle. Remove End Plate (33283), Spacer (33272), Cylinder Assembly (34032), Blades (34038), Springs (34051) and Rotor (37507) from Spindle. Leave Key (33277) and End Plate (33284) with Bearing and Spacer attached to Spindle.

**REASSEMBLY**

Assemble new Rotor (43068) to Spindle aligning keyway with Key (33277). NOTE: identification mark (1/4" drill point) on end of rotor can be positioned to face either End Plate without impairing the motor function. Assemble Cylinder (34032) over Rotor and assemble new Blades (43067) to Rotor.

Remove Bearing (33235) from End Plate (33283) and assemble to new End Plate (46074). Assemble End Plate with Spacer (33272) to Spindle aligning hole in End Plate with Roll Pin of Cylinder. Secure with Washer (33274) and Screw (Y200-59). **TIGHTEN SCREW TO 90-110 INCH POUNDS TORQUE.**

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

Assemble Motor Assembly into housing. Assemble Brake Wheel (33376) to motor spindle and secure with Washer (Y117-616) and Nut (Y12-106). Assemble the two (2) "O" Rings (Y325-12) supplied with kit into counterbores of End Plate (46074).

Assemble Screen (33672) and Filler Pads (34028), supplied with kit, to new Head (46071). Assemble "O" Ring (Y325-9), supplied with kit, into .343 inch dia. counterbore on machined face of new Head.

Position Gear (34022) to Head. Insure Gasket (41623) is in serviceable condition and assemble Gasket and new Head to hoist housing while aligning Gear (34022) to Control Rod (34021). Secure Head to housing with Washers (Y14-10) and Screws (Y154-54). Secure Gear (34022) to Control Rod with Roll Pin (Y178-56).

Assemble Screen (46072), "O" Ring (Y325-17) Swivel Body (33314), O-Rings (Y325-115), Swivel (46839) and Retaining Ring (Y145-28), supplied with kit, to new Head. Remove air inlet adapter and Screen (31648) from old head. Clean Screen and assemble to new Swivel Assembly and secure with new inlet Adapter (46211) supplied with kit.

Remove all other components from old Head, including Oilite Casting (33190). These parts, except Lock Screw (41586) and Lift Valve (37703) will be used with new Head.

Assemble Valves (41595) with "O" Rings attached, Set Screws (41598) and Oilite Casting (33190) to new Head.

Assemble Valve Body (37704) to new Head aligning identification groove on o.d. of the Valve Body with centerline of hole in head for Gear (34030). Insure Control Arm (37719) is positioned parallel with Valve Body and insert Gear (34030) into head aligning gear teeth with Valve Body. Assemble Shaft (34025) to Gear and Head. Assemble "O" Ring (Y325-19) to Lock Screw (34024), both supplied with kit, and assemble Lock Screw to head securing shaft and gear. Assemble "O" Rings (Y330-12), supplied with kit, to Lift and Descent valves. NOTE: Lift Valve (46079) is supplied with kit and replaces old Valve (37703) — while standing facing the Head end of hoist the Lift Valve is the valve on the left side of Head. Replace the "O" Ring on the descent Valve (37703) with "O" Ring (Y330-12) supplied with kit.

Assemble Lift Valve (46079), Descent Valve (37703) and Springs (38966) to Head and secure with Valve Caps (34026) and "O" rings (Y325-116). Refer to "Timing of Head" section of Operator's Manual.

Assemble oil cavity drain Screw (31389) with Washer (30747) to Head. Fill oil cavity with spindle oil and assemble oil Screw (31389) with Washer (30747) to Head.

Assemble Balls (Y16-10) to Bracket. Position Brake Shoes on Brake Wheel and secure with Brake Spring (33281). Assemble Housing Cap and secure with two (2) Screws (Y19-112).

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

Air outlet in head (sealed with Pipe Plug Y227-2) is used when pressure pendent control assembly is used with hoist.

**46547 CONVERSION KIT INCLUDES:**

1	46071	HEAD ASSEMBLY
1	33672	SCREEN
1	34024	LOCK SCREW
3	34028	PAD, FILLER
8	43067	BLADES
1	43068	ROTOR
1	46072	SCREEN
1	46074	END PLATE
1	46079	LIFT VALVE
1	46211	ADAPTER, AIR INLET
1	Y325-9	"O" RING
2	Y325-12	"O" RING
1	Y325-17	"O" RING
1	Y325-19	"O" RING
1	Y325-154	"O" RING
2	Y330-12	"O" RING
1	33314	SWIVEL BODY
1	46839	SWIVEL
1	Y145-28	RETAINING RING
2	Y325-115	"O" RING



SECTION M50, MANUAL 12 ENCLOSED