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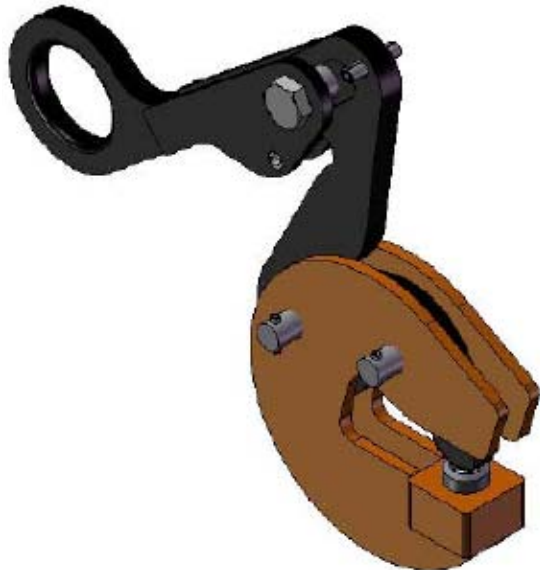
Before putting tool in service,
take to your immediate
supervisor.



RENFROE



Model AST



Model ASTL

Model AST/ASTL Clamp
Application, Operation and Maintenance Manual

OM 211-AST/L



Operators Manual

This Operator's Manual covers the Application, Operation and Maintenance of this RENFROE product. Operator's Manuals for other current RENFROE products are available upon request. Direct Requests to J.C. Renfro & Sons, Inc., Jacksonville, Florida 32201.

**J.C. RENFROE & SONS,
INCORPORATED**

of Jacksonville, Florida, has been an international leader in the manufacture and marketing of Lifting Clamps for over fifty years. **RENFROE** products are manufactured in Jacksonville, Florida. A worldwide network of stocking distributors provides a readily available source of supply and service.

**J.C. RENFROE & SONS,
INCORPORATED**

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THIS PUBLICATION SUPERSEDES ALL PREVIOUSLY PUBLISHED AND/OR DISTRIBUTED INFORMATION BY MANUFACTURER AND/OR ITS DISTRIBUTORS WITH RESPECT TO APPLICABLE RENFROE PRODUCTS AND SUBJECT MATTER DESCRIBED OR CONTAINED HEREIN.

WARNING:

Prior to selection, operation and/or maintenance of RENFROE products, read and understand the information provided in this manual.

The understanding and use of the Definitions are important in determining the limitations and proper application of RENFROE products.

Failure to review and utilize recommended applications, operation and maintenance instructions may result in serious injury to operator and others.

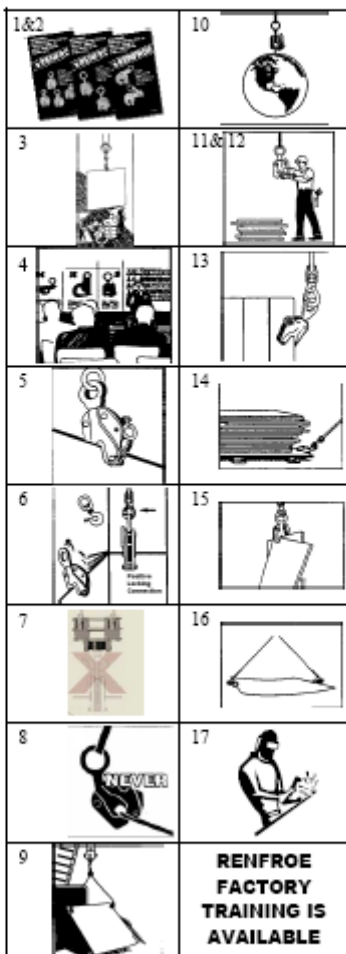
NOTICE OF EXCLUSION OF WARRANTY

RENFROE HAS HEREIN SET FORTH IN CONSPICUOUS LANGUAGE AN EXCLUSION OF ANY WARRANTY EITHER EXPRESSED OR IMPLIED, WHICH IS NOT SPECIFICALLY AND PARTICULARLY CONTAINED HEREIN. PLEASE REFER TO THAT STATEMENT FOR REPRESENTATIONS AND WARRANTIES OF PRODUCTS MANUFACTURED BY J.C. RENFROE & SONS, INC.

OPERATING AIDS

(DO'S AND DON'TS)

1. DO read and understand the operator's manual before using clamp.
2. DO consult Operators Manual or RENFROE when in doubt.
3. DON'T lift over workmen. DON'T lift over safety areas or personnel.
4. DO attend a factory training class for establishing proper use of Renfro Products.
5. DO Lock clamp closed when clamps are fitted with a lock. DON'T lift with lock in open or "lock open" position.
6. DON'T use a connection that may release the clamp.
7. DON'T attach clamp directly to crane hook. DO use a flexible connection between crane hook and clamp shackle. DON'T use heavy flexible connection.
8. DO use correct clamp for job. DON'T use large capacity clamps to lift light loads.
9. DO use an adequate number of clamps to balance load. DON'T lift loads that are not balanced.
10. DO use clamps within their rated capacity. DON'T overload clamps.
11. Do inspect clamp before each lift, follow inspection and maintenance instructions outlined in the manual and use RENFROE replacement parts to assure proper operation of the clamp.
12. DON'T use clamp that has been overloaded. DO refer to pre-lift inspection in Operator's Manual.
13. DON'T side load with a straight shackle clamp.
14. DON'T misuse. DON'T lift plate from bottom of plate stack.
15. DON'T rush. DON'T lift more than one plate at a time with a vertical clamp.
16. DON'T improvise. Always use correct clamp for the job. DON'T lift plate horizontally with a vertical lift only clamp.
17. DON'T alter clamp. DON'T grind, weld or modify the clamp in any manner.



J.C. RENFROE & SONS, INC.

P.O. BOX 4279 / 1926 SPEARING STREET / JACKSONVILLE, FL. 32201

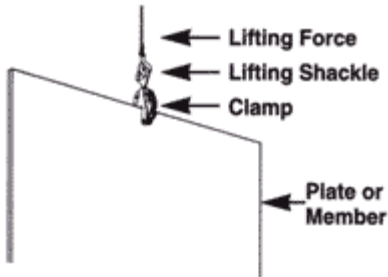
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OPERATING AIDS (DO'S AND DON'TS)

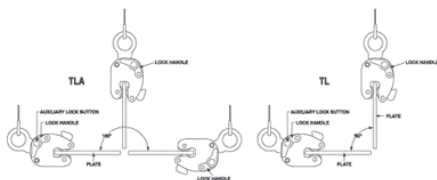
1. DO read and understand the Operators Manual before using the clamp
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3. DON'T Lift over workmen DON'T lift over Safety Areas or personnel.
4. Do attend a factory training class for establishing proper use of Renfro Products.
5. DO Lock clamp closed before lifting load. DON'T lift with lock in open or "Lock Open" position.
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7. DON'T attach clamp directly to crane hook. DO use a flexible connection between crane and clamp shackle. DON'T use heavy flexible connection.
8. DO use correct clamp for job. DON'T use large capacity clamps to lift light loads.
9. DO Use an adequate number of clamps to balance load. DON'T lift loads that are not balanced.
10. DO Use clamps within their rated capacity. DON'T overload clamps
11. DO Inspect clamp before each lift, follow inspection and maintenance instructions outlined in this manual and use RENFROE replacement parts to assure proper operation of the clamp
12. DON'T Use clamp that has been overloaded. DO refer to pre-lift inspection in Operators Manual
13. DON'T Side load with a straight shackle clamp. DON'T lift from side with vertical clamp
14. DON'T Misuse. DON'T lift plate from bottom of plate stack.
15. DON'T Rush. DON'T lift more than one plate at a time with a vertical clamp.
16. DON'T Improvise. Always use correct clamp for job. DON'T lift plate horizontally with a vertical lift only clamp.
17. DON'T Alter clamp. DON'T grind, weld or modify the clamp in any manner.

DEFINITIONS

VERTICAL LIFT: The lifting of a single plate or member in which the lifting force exerted by the rigging is directly above and in line with the lifting shackle as shown in the illustration below.

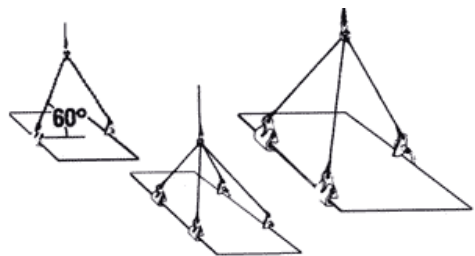


VERTICAL TURN/LIFT: A vertical turn/lift clamp is a vertical lifting clamp specifically intended to turn a single plate or member thru a ninety degree (90°) arc and back to vertical thru the same ninety degree (90°) arc or from horizontal to vertical to horizontal thru a one hundred and eighty degree (180°) arc. Refer to Application Section of specific Turn/Lift clamps for further detail. During the turning operation the edge of the plate opposite the edge to which the clamp is attached should always be in contact with a supporting surface such as a factory floor and the load on the clamp not exceed one half rated capacity of clamp—refer to illustrations shown below.



HORIZONTAL LIFT: Clamps (used in pairs or multiples) are attached to the side edges of a plate or bundle of plates positioned horizontally to the floor level. The rigging attached to clamps is generally multi-legged slings with the connecting point of the slings being approximately centered between the distance separating the clamps. Refer to illustrations shown below.

WARNING: The capacity of all horizontal clamps is based on a sling angle of sixty degrees (60°). See illustration below. Sling angles less than sixty degrees (60°) increase the load exerted on the clamps, Never exceed the rated capacity of a single clamp.



STEEL PLATES: Unless otherwise specified, lifting clamps are manufactured to handle hot-rolled steel plates whose Brinell Hardness does not exceed 300. **WARNING:** Do not lift plates with coatings or mill scale that prevent the gripping surfaces of the clamp from making positive contact with the base metal.

For applications not covered by the above information, secure written recommendations from RENFROE.

FINISHED AND POLISHED PLATES: Steel plates in this category have other than hot-rolled surfaces such as stainless steel, etc., are generally handled using non-marring clamps incorporating smooth gripping surfaces.

WARNING: For applications using clamps with serrated gripping sur-

faces on finished or polished plates, secure written recommendations from RENFROE.

STRUCTURAL MEMBERS — FABRICATED SECTIONS: Unless otherwise specified, clamps described as capable of handling structural members and fabricated sections are limited to hot-rolled steel whose Brinell Hardness does not exceed 300. **WARNING: For applications not covered by the above information, secure written recommendations from RENFROE.**

RATED CAPACITY: The rated capacity of a RENFROE product is based on the product being in “new or as new” condition and represents the maximum load the product is to be subjected to when utilized in the manner described in this manual. Wear, misuse, abuse and other factors relating to usage may reduce the rated capacity. Shock loading and the factors listed must be taken into consideration when selecting a RENFROE product for a given application.

PLATE THICKNESS: The minimum and maximum plate thickness a clamp specified for handling plates is capable of lifting. **WARNING: Never use a clamp for lifting a plate where the plate thickness is less than or greater than the minimum and maximum stenciled on the clamp.**

JAW OPENING: The minimum and maximum thickness of a member of clamp specified as having a JAW OPENING is capable of handling. **WARNING: Never use a clamp on a member whose thickness is less than or greater than the range of jaw**

opening stenciled on the clamp.

OPERATING TEMPERATURES: Unless specified under the Application Section of the individual model, the approved operating temperature of RENFROE clamps is from zero degrees Fahrenheit (-18 Celsius) to a maximum of 200 degrees Fahrenheit (+93 degrees Celsius). The minimum and maximum temperatures apply to both ambient and the material being handled by the clamp. **WARNING: Secure written authorization from RENFROE before using clamps in temperatures other than shown.**

“HOT LIFTS”: The Model R and S clamps are available in modifications that are capable of making lifts where the temperatures of the member being lifted exceeds 200 degrees Fahrenheit (+93 degrees Celsius). Depending on conditions a lift may exceed 1000 degrees Fahrenheit (538 degrees Celsius). The exact application and temperatures of the plates to be handled are critical in selecting the proper model. **WARNING: Secure written instructions from RENFROE for all hot lift applications.**

LOCKING CLAMPS: Locking clamps are divided into the categories listed below. With the exception of the “Locking Wedge” and “Locking Screw” type the purpose of the locks are to facilitate the attaching and removing of the clamp from the member being handled.

“LOCK CLOSED” - an overcenter spring loaded mechanism in which the spring exerts a force on the gripping cam when the lock handle is moved to the “Lock Closed” position. When the

handle is moved to unlocked position the force exerted by the spring is relaxed and the gripping cam may be retracted by pushing the lifting shackle into body of clamp. Refer to the Operation Section of specific models of "Lock Closed" clamps for additional details. Typical "Lock Closed" clamps are Models DG, FR and M.

"LOCK OPEN ONLY" - normally used on "Hot Lift" clamps and consists of a manually operated "Lock Stop Pin" that is inserted when gripping cam of clamp is retracted and removed when clamp is positioned on the plate. Tag line may be used to permit operator to remove pin from a greater distance from clamp. Refer to the Operation Section of specific model of "Lock Open Only" clamps for additional details. Typical "Lock Open Only" clamp is the Model RO.

"LOCK OPEN-,LOCK CLOSED" - an over-center spring loaded mechanism in which the spring exerts a force on the gripping cam when the lock handle is moved to the "Lock Closed" position. When the handle is moved to the "Lock Open" the gripping cam is maintained in the retracted position for ease in installing the clamp on a plate or member. The Model FRD contains individual "Lock Open" and "Lock Closed" mechanisms that must be operated separately. Refer to the Operation Section of specific models of the "Lock Open-Lock Closed" clamps for additional details. Typical "Lock Open-Lock Closed" clamps are Models FRD, R, S, SD, SEA, SX, TL, TLA and the J-Series.

"LOCKING WEDGE" - is a fluted steel wedge that is driven in place with a

hammer. The body of the wedge is positioned in a slot in the clamp body with the fluted edges contacting the member to which the clamp is being attached. Refer to Operation Section of specific models of the "Locking Wedge" clamps for additional details. Typical "Locking Wedge" clamps are Model A1, B1, B2 and PB.

"LOCKING SCREW" - "Lock Screw" clamps depend on manually adjusting a screw to hold the gripping surface in place for lifting and removing the clamp from member being lifted. Refer to Operation Section of a specific model of "Locking Screw" clamps for additional details. Typical "Locking Screw" clamps are Models AC, ACP, NM, PC, SCP and SCPA.

NON-LOCKING: "Non-Locking" clamps have no mechanisms to aid in attaching or removing clamp from member being lifted. It is necessary to have position of clamp maintained on the member being lifted until a properly applied force is exerted to the lifting shackle. Refer to Operation Section of specific models of the "Non-Locking" clamps for additional details. Typical "Non-Locking" clamps are Model AST, ASTL, BD, HR, HDR and WHSR.

WARNING: A pointing out and notice of danger. The purpose of a "WARNING" is to apprise the operator and all other affected persons of the existence of danger of which he should be but may not be aware and to enable the operator to protect himself and others where applicable against such danger. An attempt is made herein to warn against reasonable and reasonably foreseeable danger in the proper use and possible reasonable misuse of RENFROE products described in this manual.

DESIGNATED PERSON — A person selected by the employer or the employer's representative as being competent to perform those specific duties.

QUALIFIED PERSON — A person who, by possession of a recognized degree in an applicable field or certificate of professional standing, or who, by extensive knowledge, training, and experience, has successfully demonstrated the ability to solve problems relating to the subject matter at hand.

MODEL AST

Vertical Lifting

Non-Locking

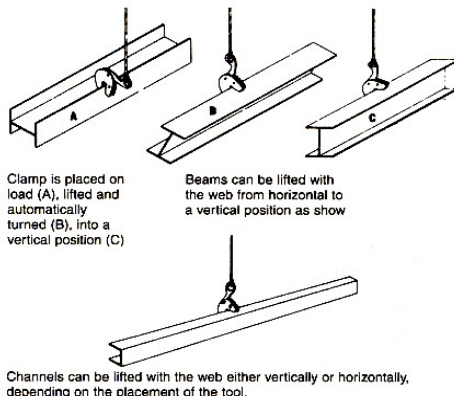
Application AST



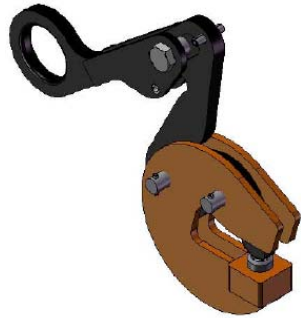
The Model “AST” was developed primarily for lifting, turning, stacking light beams and structural shapes where a constant tension is applied to the lifting shackle throughout the entire operation. Refer to Definition Pages for explanation of “Non-Locking” Clamp. The shackle permits a beam to be lifted with the web of the beam in a near horizontal position by placing the clamp on a flange with the shackle positioned over the web and between the flanges. With the beam lying in a horizontal position, and the clamp placed with the shackle overhanging the flange, the beam can be lifted, turned ninety degrees and raised with the web in a near vertical position. Refer to illustrations shown below.

For identification of component parts, refer to exploded view of clamp located at the end of the Maintenance Section.

WARNING: Refer to the sections on operation and maintenance for the approved procedures in the Operation and Maintenance of this product.

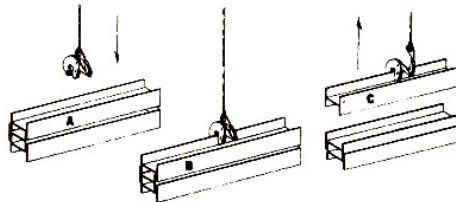


MODEL ASTL Vertical Lifting Non-Locking



Application ASTL

The Model “ASTL” includes all of the features and limitations of the Model “AST” and in addition incorporates a linkage allowing the clamp to be lowered in the open position until the gripping surfaces pass over the beam flange. Further lowering of the crane hook will disengage linkage permitting the gripping surfaces to engage the flange when the crane hook is raised. The beam can then be lifted with the flange near vertical. The procedure can be reversed for stacking beams. Refer to illustrations shown below.



(A) clamp, in open position is lowered to load...

(B) crane hook is lowered to disengage

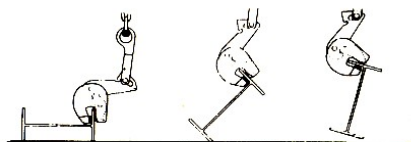
(C) beam is lifted in horizontal position...

This sequence can be reversed for horizontal nesting of beams in a stack



Holds load in a more level position for nesting beams

Automatic lock open feature releases clamp without manual assistance



Turning beam 90 degrees

Operation - AST and ASTL

Step 1.

Before using and RENFROE clamp, refer to the Application Section to confirm the operation to be undertaken is an appropriate application for this product.

Step 2.

Select appropriate capacity and jaw opening. The model designation, capacity and jaw opening are stenciled on each clamp.

WARNING: Never exceed rated capacity or use on material that is not within the range of jaw opening stenciled on the clamp.

Always use clamps with the maximum jaw opening and rated capacity near equal to the thickness and weight of the selection being lifted.

Step 3.

Inspect clamp before each lift.

WARNING: Do not use if in need of repair.

If in doubt refer to the Maintenance Section for detailed maintenance instructions and exploded view of the clamp for part identification.

- A. Check the clamp to be certain the Identification and warning tags are present and legible.
- B. Do not use the clamp if the tags are missing or illegible
- C. Inspect gripping surfaces for wear and defects. Gripping surfaces must be sharp and free of foreign matter.
- D. Swivel jaw should turn freely in body of clamp. Inspect swivel jaw mounting hole in body for elongation indicating overload or wear.
- E. Inspect condition of body for wear, damage and distortion, particularly in the area of the jaw opening.
- F. Inspect pin holes for elongation and wear.
- G. Inspect lifting shackle and all pins for wear and damage.
- H. Remove any clamp from service in need of repair.

Step 4. The clamp is a component of the rigging used in the lifting or transporting of beams or structural shapes. It is important to use safe and adequate rigging.

The clamp is manually held in place until the gripping mechanism of the clamp is activated by a force applied to the lifting shackle.

WARNING: Improper or excessively heavy rigging may interfere with the operation of the clamp and its ability to maintain proper position on the beam or structural shape. Never attach crane hook directly to the clamp - always use sling between crane hook and clamp.

Step 5.

Determine number of clamps required to handle member to be lifted. Never use more than two clamps.

WARNING: Long and flexible members require more than a single clamp. Single clamps must be positioned at the center of gravity of length of member. Never use a single clamp on a member that will be subjected to oscillation.

Step 6.

Position clamp on beam or structural member to be lifted. Do not permit tip of clamp body to contact member or inside of jaw opening to rest on edge of beam or structural member.

Refer to Illustration A and Photograph B.

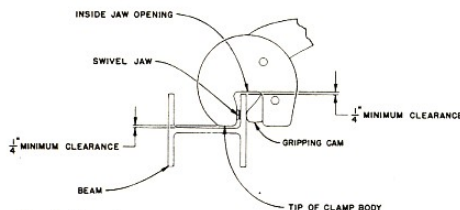


Illustration A



Photograph B

Step 7.

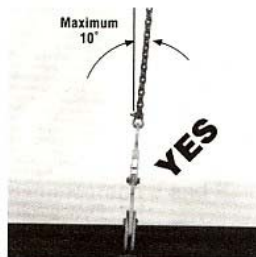
Position clamp so direction of force applied by crane is in line with the lifting shackle. Make certain the swivel jaw and gripping cam are fully in contact with member to be lifted and not partially on or off the member.

WARNING: Never exceed 10 degrees side loading.

Refer to Photograph C, D and E.



Photograph C Sling directly above and in line with shackle.



Photograph D Maximum allowable side loading.

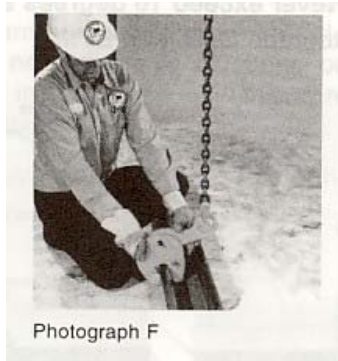


Photograph E Exercise side loading

Step 8.

Hold clamp in position keeping hands clear of mechanisms. Apply force to lifting shackle until sling tension is able to hold clamp in place. Make certain gripping surfaces are in full contact and exerting a force on the member being lifted. Refer to Photograph "F".

WARNING: A constant force must be maintained on the lifting shackle throughout the entire operation.



Step 9.

Commence lift.

WARNING: The operator should position himself away from and fully clear of the member to be lifted. Do not commence lift until all personnel are clear of the area of the lift. Never stand under or near a member being lifted.

Refer to Photograph G.

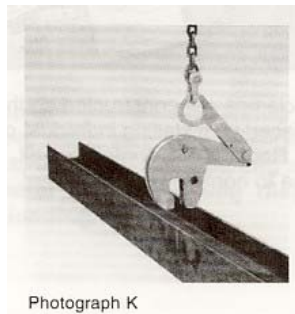
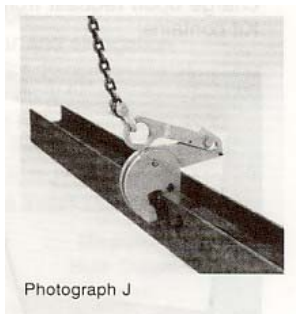
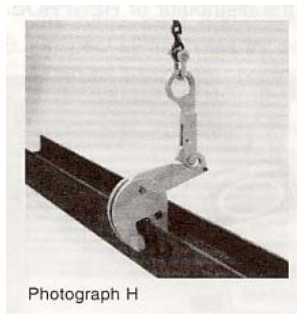


Step 10.

“AST”/“ASTL”: To remove clamp - after member is resting in a stable position, relax lifting force and manually move gripping cam to “Open” position by actuating the lifting shackle.

“ASTL”: The model “ASTL” may be removed by lowering member being lifted until it rests in a fully supported and stable position, refer to Photograph H, then allowing additional slack in the sling until lifting shackle locks in “Open” position. Clamp may now be lifted from member. Refer to Photograph J and K.

WARNING: Never attempt lift when shackle is in “lock Open” position.



Step 11.

Inspect clamp. Remove from service any clamp in need of repair.

WARNING: In the event the stenciling is worn and not legible or the tag containing the model, capacity and other pertinent information is missing—do not use clamp until it has been properly labeled.

Inspection Kits are available at not charge upon request from the distributor or RENFROE. Kit contains:



Maintenance Program for Renfroe Clamps Manufactured from Steel

The severity of service to which the clamp is subjected in the work place determines the frequency and type of inspection procedure required for the clamp. The frequency and type of inspection is determined by the clamp owner. Renfroe acknowledges the ASME B30.20 safety standard which sets forth minimum inspection requirements for "Below-the-Hook" lifting devices and the Renfroe Recommended Inspection Schedule meets and/or exceeds the ASME inspection recommendations.

Before using a clamp operators should be trained by a qualified person to visually inspect a lifting clamp that will include but not be limited to the following:

Every lift Inspection:

A visual inspection by the operator before and after each lift made by the clamp.

- Check the clamp to be certain the Identification and warning tags are present and legible.
- Do not use the clamp if the tags are missing or illegible
- Inspect gripping surfaces for wear and defects. Gripping surfaces must be sharp and free of foreign matter.
- Swivel jaw should turn freely in body of clamp. Inspect swivel jaw mounting hole in body for elongation indicating overload or wear.
- Inspect condition of body for wear, damage and distortion, particularly in the area of the jaw opening.
- Inspect pin holes for elongation and wear.
- Inspect lifting shackle and all pins for wear and damage.
- Remove any clamp from service in need of repair.

Remove any clamp from service in need of repair.

WARNING: Do not use the clamp if in need of repair.

If, during the every lift inspection, the operator believes the clamp exhibits excessively worn parts or is damaged, the clamp should be inspected by a qualified person who will make a determination as to its fitness to make a lift. At this time the condition of the clamp should be noted and recorded. After inspection by the qualified person it may be decided that a periodic inspection procedure is necessary.

Frequent Inspection:

A visual inspection (see every lift inspection) by an operator or other designated person timed according to the clamps service class.

- **Normal Service:** monthly
- **Heavy Service:** weekly to monthly
- **Severe Service:** daily to weekly.

If, during the frequent lift inspection, the operator believes the clamp exhibits excessively worn parts or is damaged the clamp should be inspected by a qualified person who will make a determination as to its fitness to make a lift. At this time the condition of the clamp should be noted and recorded. After inspection by the qualified person it may be decided that a periodic inspection procedure is necessary.

Periodic Inspection:

A recorded inspection by a qualified person as described in the Periodic Inspection Procedure below timed according to the clamps service class.

- **Normal Service:** annual
- **Heavy Service:** semi-annual
- **Severe Service:** quarterly.

If during any inspection a condition is found which leads to a periodic inspection then the next periodic inspection is due from the time the clamp is returned to service. See the table below.

Normal Service-One Year
Heavy Service-6 Months
Severe Service-3 Months

Warning: If any hazardous condition is found that may cause injury to the operator or other personnel then the clamp should be subjected to a Periodic Inspection by a Qualified Person.

Repair (replacement of worn parts)

During regular maintenance when replacing parts that are worn a record should be made of the parts replaced. After the replacement of worn parts clamps need not be load tested.

Repair (replacement of damaged parts)

During a repair in which parts are replaced due to damage a record should be made of the repair. At this time the clamp should be marked with the following information as per the ASME B30.20 requirements:

- **Name and address of the repairer**
- **Repairer's unit identification**
- **Clamp weight (if altered)**
- **Rated load (if altered)**
- **ASME BTH-1 Design Category (if altered)**
- **ASME BTH-1 Service Class (if altered)**

RENFROE clamps are constructed so the wearing parts may be replaced by installing individual parts or by using RENFROE Repair Kits containing all parts generally replaced due to normal wear.

Model AST/L Periodic Inspection Procedures

Step 1.

Verify the identity of the clamp by checking the I. D. plate on the clamp body. If the I. D. plate is missing or not legible an RFID chip (Radio Frequency Identification Device) is embedded in the clamp body or a clamp component. If the I. D. plate is missing and the RFID chip is unavailable call the Renfroe factory for instructions on returning the clamp for recertification.

Step 2.

Completely disassemble clamp.

Step 3.

Remove all dirt, grease and other matter that may inhibit proper inspection of the clamp body or clamp components.

Step 4 BODY

- A. Inspect welds for fractures. RENFROE recommends a dye penetrant or similar method of detecting indications on the clamp. If an indication is found it may be necessary to use a magnetic particle, ultrasonic or similar methods for determining damage to the clamp or components.
- B. Inspect all pin holes for wear and elongation.
- C. Inspect inside jaw opening for displaced metal and distortion.
- D. Inspect swivel jaw mounting hole for elongation and wear. Swivel jaw must turn freely. Remove clamp body from service when Swivel Jaw Mounting Hole Dimensions equal or exceed those listed below.

Rated Capacity Tons	Mounting Hole Dia. Inches	Mounting Hole Depth Inches
1/2	.905	.455
1 1/2	1.030	.640
3	.540	.900

WARNING: Replace clamps containing fractures; elongated holes, worn and elongated swivel jaw mounting holes, distorted jaw opening and clamp bodies with metal in jaw opening displaced by excessive side-loading.

Step 5. LIFTING SHACKLE AST-1

- A. Inspect shackle eye for elongation and wear at point where eye engages sling attachment.
- B. Inspect shackle pin hole for elongation and wear.
- C. Inspect shackle body for bending.
- D. Inspect shackle at area where it contracts the gripping cam.
Refer to Illustration L.

WARNING: If the area is worn, distorted or the metal is displaced, replace shackle.

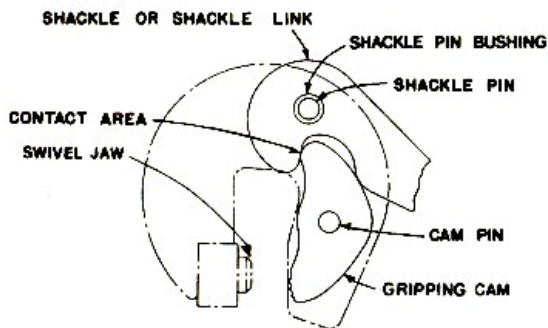


Illustration L

Elongated shackle eye indicates overloading. Elongated shackle pin hole indicates wear and possible overloading. Bent shackle indicates excessive side-loading.

WARNING: Replace shackles that are bent, show excessive wear at the eye and at the contacting gripping cam and have elongated eye and shackle pin holes/

Step 5. LIFTING SHACKLE ASTL-1

- A. Inspect shackle eye for elongation and wear at point where eye engages sling attachment. Refer to Illustration L, Step 4.
- B. Inspect shackle pin holes for wear and elongation.
- C. Spiral pin must be in place and free of damage.
- D. Inspect shackle body for bending.

Elongated shackle eyes indicate overloading. Elongated shackle pin holes indicate wear and possible overloading. Bent shackle indicates excessive side-loading.

WARNING: Replace shackles that are bent, show excessive wear at the eye, have elongated eye and shackle pin holes.

Step 6. SHACKLE PIN AST-2 and ASTL-2
CAM PIN AST-3 and ASTL-3

- A. Inspect all pins for the following:
1. Distortion.
 2. Surface blemishes.
 3. Wear.
 4. Fractures.

WARNING: Replace pins that are distorted, have surface scars, are worn and contain fractures.

- B. Inspect shackle pin bushing for wear.

Step 7. SWIVEL JAW AST-4 and ASTL-4

- A. Inspect swivel jaw for wear and damage.
- B. Swivel jaw must turn freely in clamp. When installing swivel jaw in clamp, insert lubricant in body recess before installing swivel jaw. Recommended lubricant is powdered graphite or Molybdenum Disulfide grease. Install retaining screw and nut, then reverse nut one turn to allow swivel jaw to turn freely in clamp body.

WARNING: Replace worn, dull or damaged swivel jaws.

Step 8. GRIPPING CAM AST-5 and ASTL-5

- A. Inspect cam for chipped or worn teeth. Teeth must be sharp and free of foreign matter.
- B. Inspect cam for fractures and wear.

WARNING: Replace cams with fractures and chipped or worn teeth.

Step 9. SHACKLE LINK ASTL-6

- A. Inspect shackle link pin holes for elongation and wear.
- B. Inspect shackle link body for bending.
- C. Spiral pin must be in place and free of damage.

D. Inspect shackle link at area where it contacts the gripping cam. Refer to Illustration L, Step 4.

WARNING: If this area is worn, distorted or the metal displaced, replace shackle link.

WARNING: Replace shackle links that are bent, show excessive wear or distortion at slotted hole, shackle pin hole and at area contacting gripping cam. Reference exploded view.

Step 10. SHACKLE LINK PIN ASSEMBLY ASTL-7

A. Inspect shackle link pin, sleeve and nut for distortion, wear and damage.

B. Nut must be tight.

WARNING: Replace distorted, worn or damaged components.

Step 11. SHACKLE PIN BUSHING ASTL-8

A. Inspect shackle pin bushing for wear and damage. Refer to Illustration L, Step 4.

WARNING: It is absolutely necessary that the shackle pin bushing be used. Do not omit from the assembly—Replace if worn or damaged.

Step 12. ASSEMBLY

After reassembly, check operation of clamp. All parts should move freely without binding. Refer to exploded view for proper location of component parts.

WARNING: All retaining pins and fasteners must be in place.

GENERAL

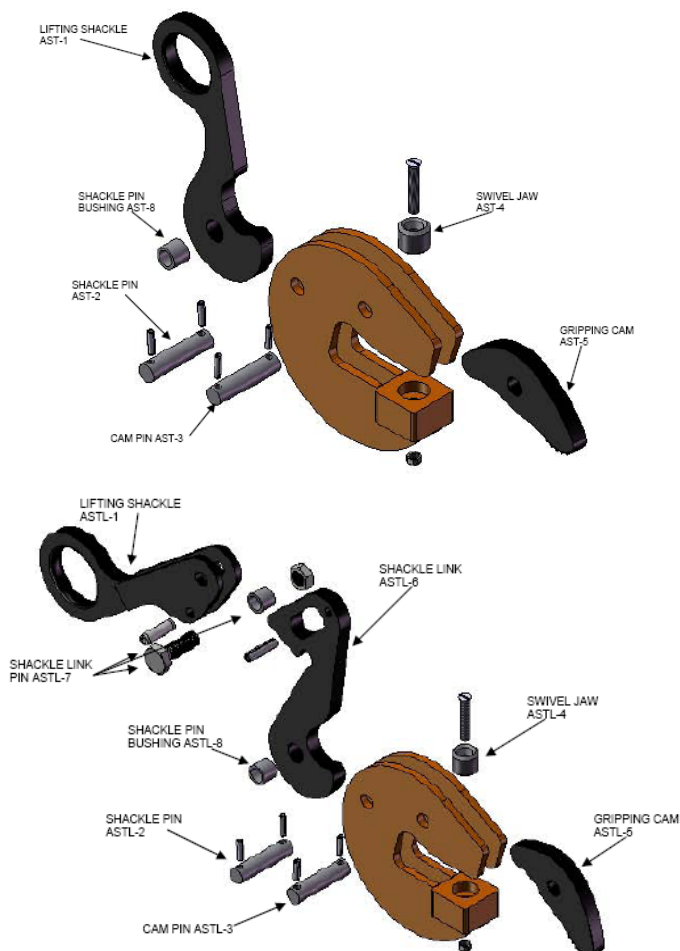
RENFROE products may be returned to the factor for inspection and refurbishment in accordance with an established fee schedule.

Use only RENFROE replacement parts to insure maximum efficiency and safety factor originally built into product. Refer to RENFROE catalog for instructions on ordering replacement parts.

WARNING: Do not weld, grind, or modify the clamp body or component parts in any manner. In the event the stenciling is worn and not legible or the tag containing the model, capacity or other pertinent information is missing - Do not use clamp until it has been properly labeled.

Exploded View

*These parts are included in Renfroe Repair Kit.



EXCLUSION OF WARRANTY

**THERE EXISTS NO WARRANTIES NEITHER
EXPRESSED NOR IMPLIED WHICH EXTEND
BEYOND THE DESCRIPTIONS OR STATE-
MENTS CONTAINED IN THE FACE OR ANY
PART HEREOF.**



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