



# Technical Bulletin

## Split Arm Paper Roll Clamp Revolving Connection Flow Divider & Pressure Settings

This sheet describes the F-Series Paper Roll Clamp Split Arm Revolving Connection flow divider cartridge replacement and pressure setting procedures.

The revolving connection on the Split Arm Paper Roll Clamp has been designed to:

- Provide equal arm movement in both directions.
- Allow a roll to be clamped with one arm, eliminating the need to actuate the other arm to full stroke to build up clamp pressure.
- Allow the arms to align with each other at the full open or full close positions or when clamped on the same diameter roll.

### Flow Divider Removal and Installation



**WARNING:** Before removing any fittings or hoses, relieve pressure in the hydraulic system. Turn the truck off, then open the auxiliary control valve(s) several times in both directions.

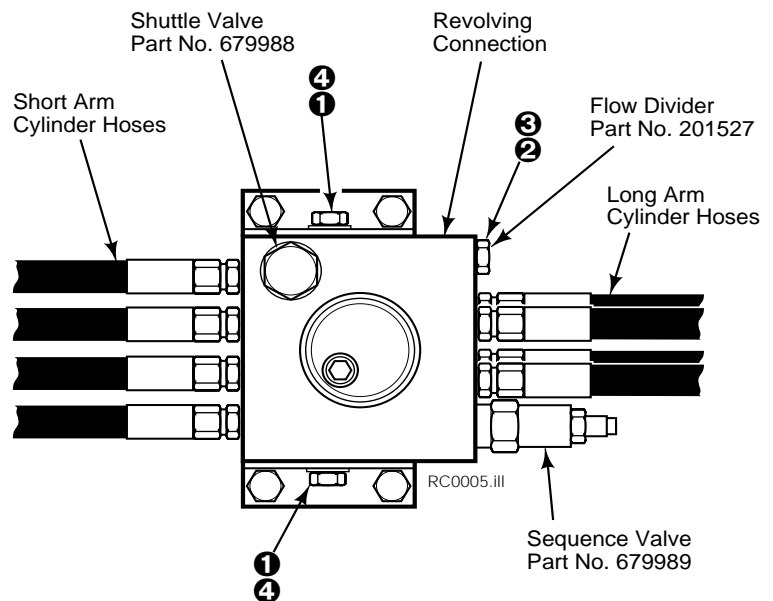
- 1 Remove the two capscrews holding the revolving connection to the angle brackets. Pull out the revolving connection enough to remove the flow divider cartridge.
- 2 Remove the flow divider cartridge.
- 3 Install the new flow divider cartridge.
- 4 Install capscrews.

### Pressure Setting Procedure

- To adjust the Sequence Valve, install a pressure gauge in the long arm cylinder test port.
- Close arms without a load and set the lift truck auxiliary valve relief pressure to the truck system pressure or 2300 psi maximum.
- Clamp on a roll or clamp force indicator with **only** the arm that has the pressure gauge.

**NOTE:** The lift truck pressure **must be set between 1600 psi and 2300 psi**. A **minimum of 1600 psi** is required to allow the arms to align properly.

- Set the Sequence Valve pressure at 100 psi less than the gauge reading. The setting is adjusted by loosening the locknut and turning the Sequence Valve threaded stem **in to increase** the pressure or **out to decrease** the pressure.
- Retighten the locknut.



Part No. 206494

**NOTE:** This information should not be interpreted as the basis for warranty claims unless so designated.

# cascade®

For Technical Assistance and to Order Parts . . .

Call: 1-800-CASCADE (227-2233) or 503-669-6300

FAX: 503-669-6367

Write: Cascade Corporation, PO Box 20187, Portland, OR 97220