

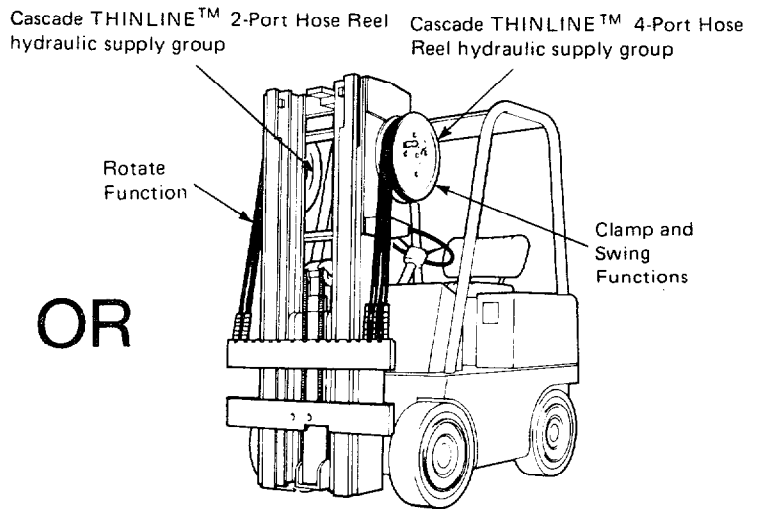
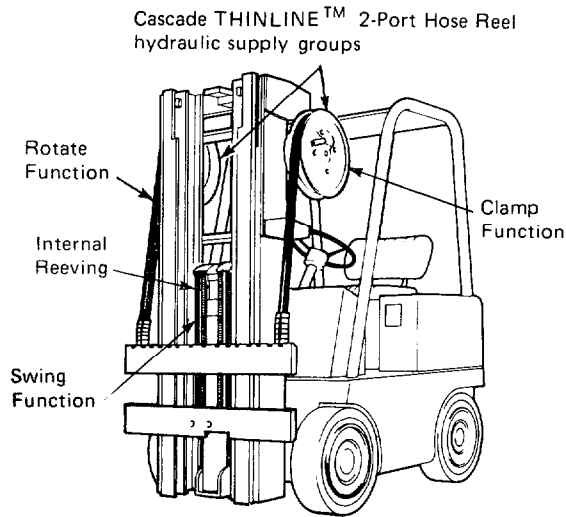


# Installation Instructions

## F-Series Paper Roll Clamp Solenoid Valve Groups 674924, 674925, 674926 and 674927

The F-Series Swing Frame Paper Roll Clamps require three hydraulic supply circuits over the mast. Installation of a Control Valve Group will be required to convert a 2 function auxiliary control valve to 3 function control. No. 8 size hosing is required for the rotate function to maximize speed and minimize restriction. No. 6 or No. 8 hosing may be used for the clamp and swing functions. Cascade THINLINE™ Hose Reels provide an economical and efficient means of

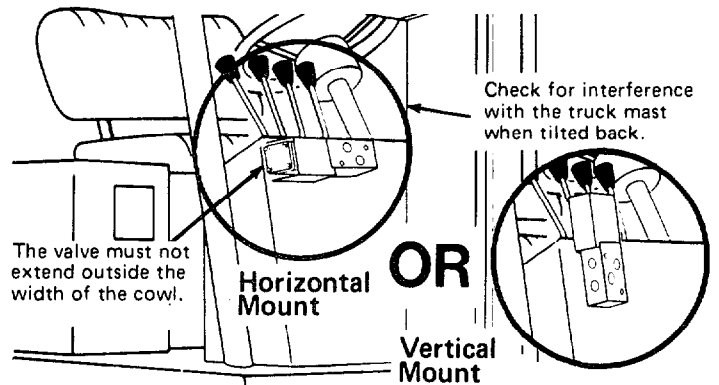
supplying hydraulics over the mast. Refer to Hose and Cable Reel Selection Guide Form 4099 to select the correct hose reels for the truck and mast. If the truck is equipped with mast single internal hose reeving, a R.H. 2-Port and L.H. 2-Port THINLINE™ Hose Reel will be required. Trucks not equipped with mast internal reeving will require a R.H. 2-Port and L.H. 4-Port THINLINE™ Hose Reel.



This Section describes procedures for installation of Solenoid Valve Groups. The groups convert a 2 function auxiliary control valve to 3 function operation. Refer to Form 673835 for THINLINE™ 2-Port L.H. Hose Reel installation and Form 675395 for THINLINE™ 4-Port L.H. Hose Reel installation (for masts without internal reeving). Solenoid Valve Groups for different truck voltages are listed.

Truck Voltage	Solenoid Valve Group Part No.
12V	674924
24V	674925
36V	674926
48V	674927

- Determine an approximate mounting location for the solenoid valve on the truck cowl. The valve can be mounted horizontally or vertically. The valve must not extend outside the width of the cowl or interfere with the truck mast when tilted back.



Part No. 683219 Rev. 0

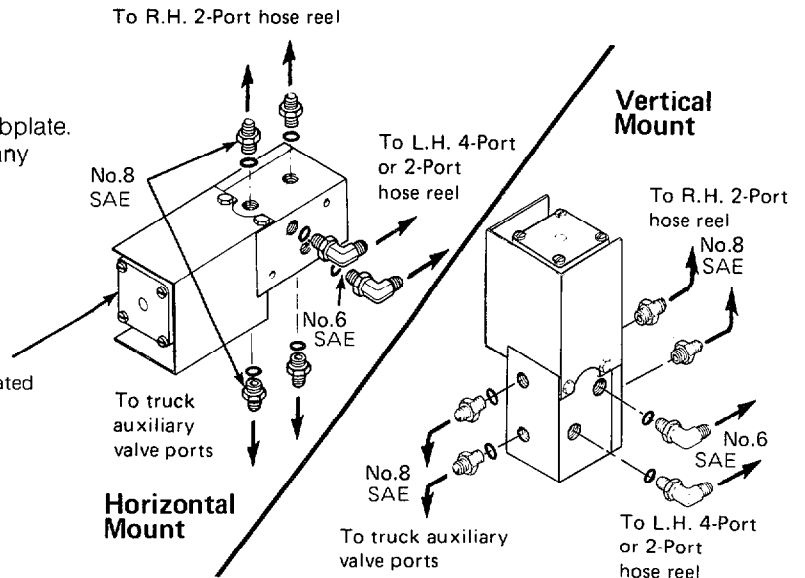
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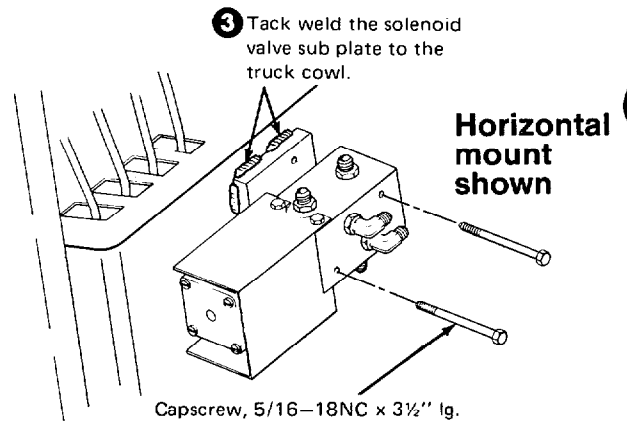
## Control Valve Group Installation (Continued)

- 2 Assemble the solenoid valve, fittings, cover and subplate. Position the assembly on the truck cowl noting any clearance problems.

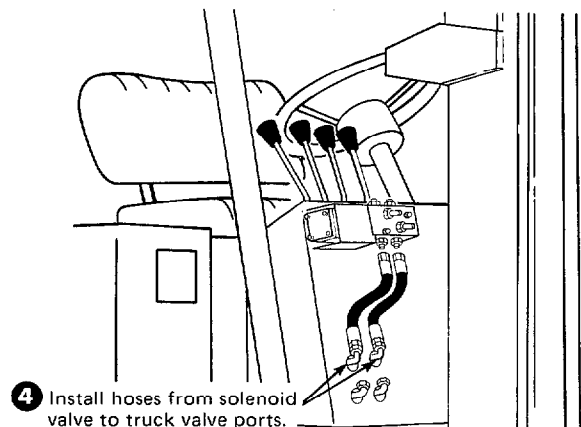
**NOTE:** The solenoid coil must be rotated 90° to clear the cover when assembled.



- 3 Mark a mounting location on the truck cowl. Grind the mounting area for welding the subplate to the truck cowl. Tack weld the subplate to the cowl. Mount the valve to the subplate with the bolts supplied.



- 4 Measure and assemble two hoses (user supplied) to run from the control valve **P** and **T** ports to the **truck valve** ports. Install the hoses.




**IMPORTANT:** Proceed to step 6 if the lift truck is equipped with mast internal hose reeving.

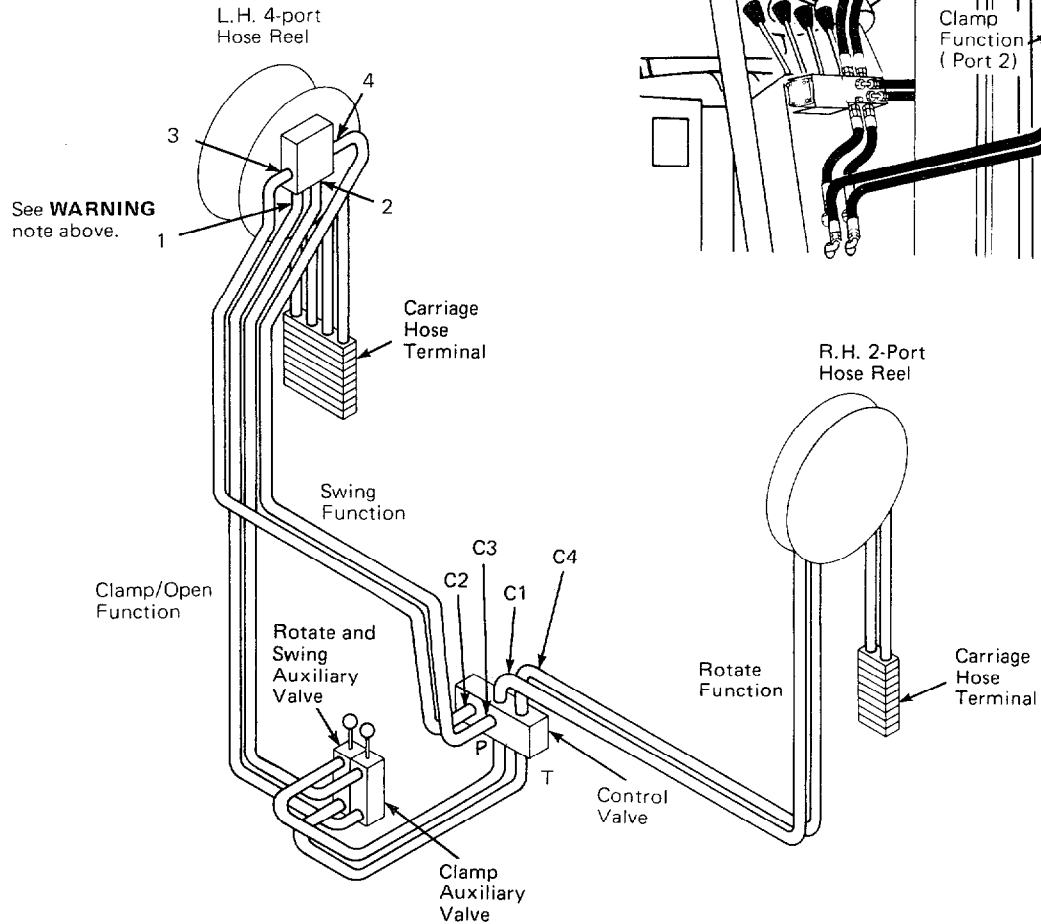
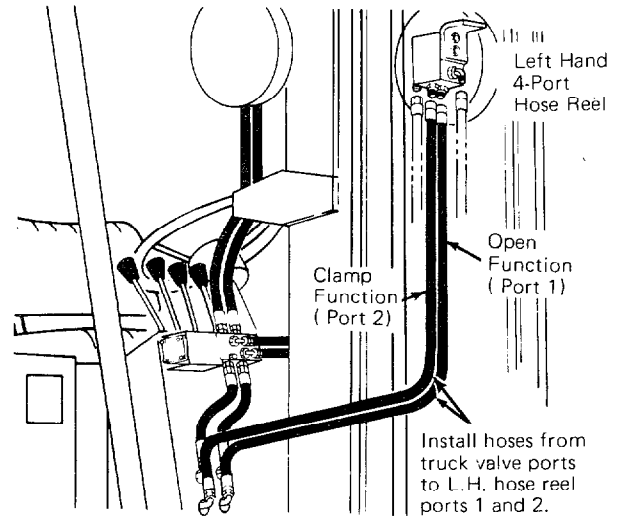
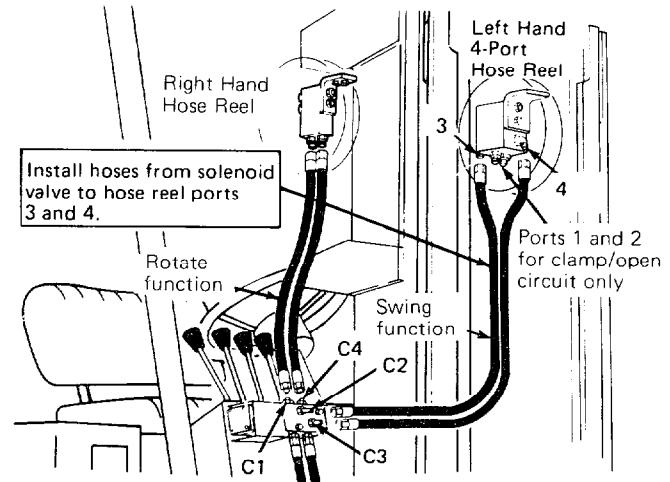
**5 Installation with R.H. 2-Port and L.H. 4-Port Hose Reels.**

Measure and assemble two hoses (user supplied) to run from the control valve **C1** and **C4** ports to the **R.H. hose reel**. Measure and assemble two hoses (user supplied) to run from the control valve **C2** and **C3** ports to the **L.H. 4-Port hose reel 3 and 4** ports. Install the hoses.

Measure and assemble two hoses (user supplied) to run from the **truck valve** ports to the **L.H. 4-Port hose reel 1 and 2** ports. Install the hoses.



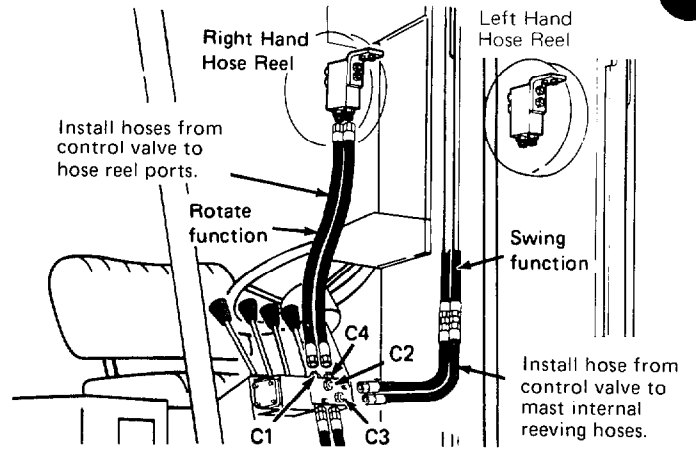
**WARNING:** The hose operating the **open function** must connect to 4-Port Hose Reel **Port 1**.



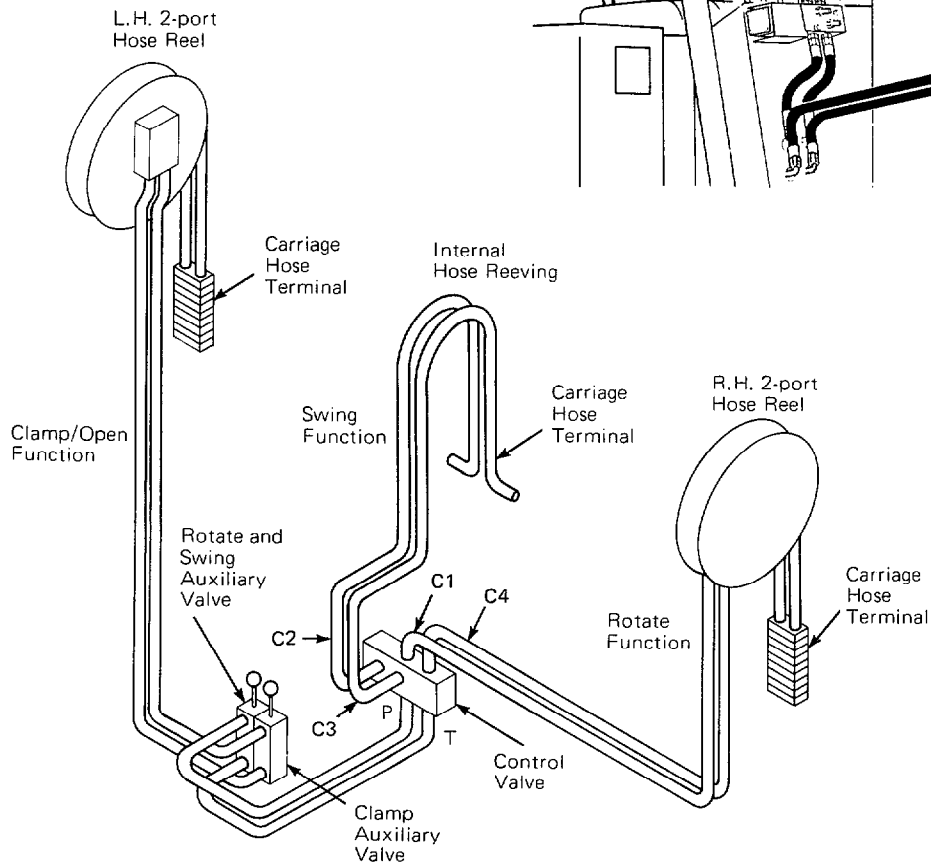
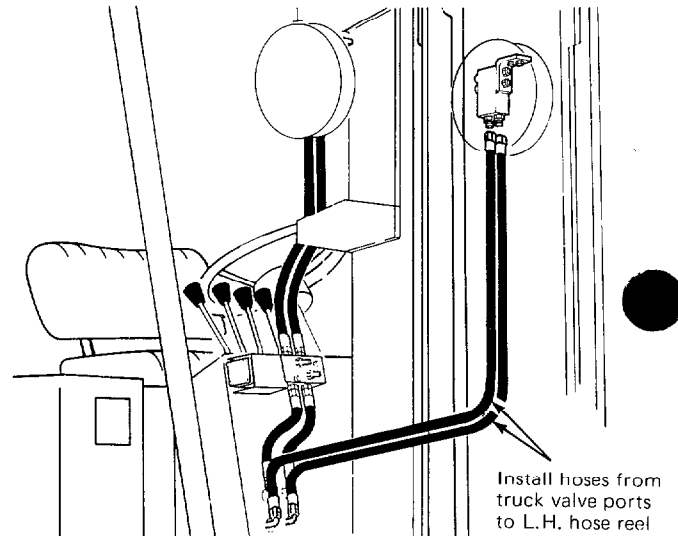
# Control Valve Group Installation (Continued)

## 6 Installation with R.H. and L.H. 2-Port Hose Reels and Internal Hose Reeving.

Measure and assemble two hoses (user supplied) to run from the control valve **C1** and **C4** ports to the **R.H. hose reel**. Measure and assemble two hoses (user supplied) to run from the control valve **C2** and **C3** ports to the **internal hose reeving hoses**. Install the hoses.

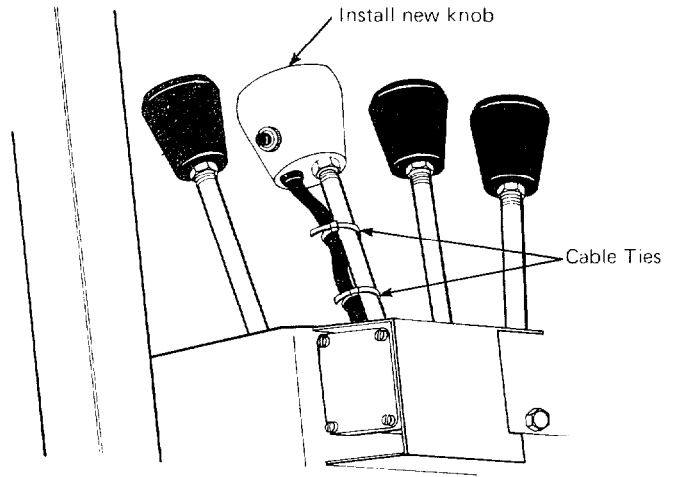


Measure and assemble two hoses (user supplied) to run from the **truck valve** ports to the **L.H. 2-Port hose reel**. Install the hoses.

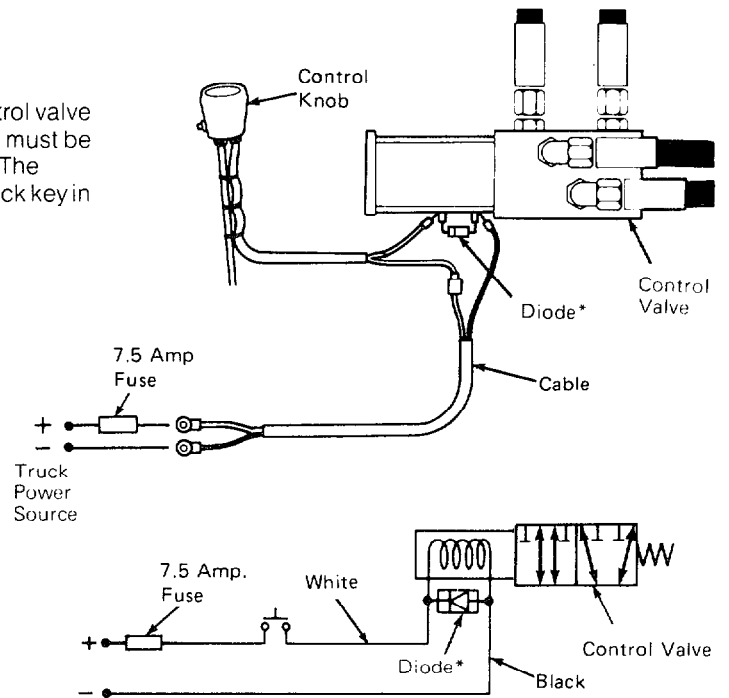


- 7 Remove the existing knob from the handle that operates the hydraulic hoses connected to the control valve **P** and **T** ports. Install the new knob using one of the adapters provided.

**CAUTION:** Secure the cable so it will not be pinched at the truck cowl when the handle is actuated.



- 8 Connect electric cables from the knob and control valve terminals to the truck electrical system. The fuse must be connected to an unswitched positive terminal. The control valve must be able to energize with the truck key in the off position.



\*The banded end of the diode must connect to the white wires.

Do you have questions you need answered right now? Call your nearest Cascade Service Department.

**Cascade Corporation**  
2201 N.E. 201st Ave.  
Troutdale, OR 97060-9718  
TEL: 503-669-6300  
800-~~CAS-CADE~~ (227-2233)  
Telex: 590480  
Cable: Cascade Ptl  
FAX: 503-669-6280

**Cascade (UK) Ltd.**  
15, Orgreave Crescent  
Dore House Industrial Estate  
Handsworth  
Sheffield S13 9NQ  
England  
Tel: 0742-697524/5/6/7  
Telex: 547254 cascsh g

**Cascade France S.A.R.L.**  
11, rue Jean Charcot  
Zone Industrielle Sud  
B.P. 22  
91421 Morangis Cedex  
France  
Tel: 1-69091139  
Telex: cascade 690016f

**Cascade N.V.**  
**Benelux Sales and Service**  
P.O. Box 170  
1110 AD Deimen  
Weesperstraat 110  
1112 AP Diemen  
The Netherlands  
Tel: 020-906411  
Telex: 14495 casc nl

**Cascade N.V.**  
**European Headquarters**  
P.O. Box 50086  
1305 AB Almere-Haven  
Achterwerf 240  
1357 CB Almere-Haven  
The Netherlands  
Tel: 03240-92911  
Telex: 40838 case nl  
FAX: 011-31-3240-92286

**Cascade Materials Handling**  
**(Aust.) Pty. Ltd.**  
**(Incorporated in N.S.W.)**  
121 Long Street  
Smithfield, N.S.W. 2164  
Australia  
Tel: 02-604-6222  
Te/Ac: 790-24302  
Cable: Cascaus  
FAX: 011-61-2-609-2742

**Cascade Hydraulics Ltd.**  
7615 Kimbel Street  
Mississauga, Ontario  
Cascade L5S-1A8  
Tel: 416-677-9695  
Direct Parts Line:  
416-677-9686  
416-677-9684  
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Shinsenri Higashimachi  
Toyonaka, Osaka 565  
Japan  
Tel: 06-835-2900  
Te/Ac: 781-5287115 Cascade J  
Cable: Cascadecfe, Osaka  
FAX: 011-816-835-2905

**Cascade Scandinavia**  
**Hydraulik A.B.**  
Muskotgatan 17-(E.8-9)  
252 55 Helsingborg  
Sweden  
Tel: 042-151135  
Telex: 72565 caschbg s

**Cascade Materials Handling**  
**(Aust.) Pty. Ltd.**  
44E Winton Road  
Clayton, Victoria 3168  
Australia  
Tel: 03-543-4344  
Cable: Casmel

**Cascade Hispania S.A.**  
Avenida De La Fabregada, 7  
Hospitalet De Llobregat  
Barcelona  
Spain  
Tel: 93-3355158  
Telex: 54018 casc e

**Cascade (Africa) Pty. Ltd.**  
P.O. Box 625, Isando 1600  
60A Steel Road,  
Sparton, Kempton Park  
South Africa  
Tel: 011-974-5611/2/3/4/5  
Telex: 4-29718 S.A.

**Cascade GmbH**  
Klosterhofweg 52  
4050 Monchengladbach 3  
B.R. Deutschland  
Tel: 02166-602091  
Telex: 852812 casc d