

Technical Bulletin

F-Series Paper Roll Clamp Split Arm Revolving Connection

This sheet describes the F-Series Paper Roll Clamp Split Arm Revolving Connection function and pressure setting procedures.

Split Arm Revolving Connection Description

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 re-index with each other at the full open or full close positions or when clamped on the same diameter roll.

When rolls are clamped with one arm, the clamp pressure is controlled by the Sequence Valve in the revolving connection. See figure 1. The valve is factory set at 1900 psi. The valve pressure setting is adjustable from 400 psi to 2400 psi. The **usable** pressure range of the valve in the circuit is 1500 psi to 2200 psi.

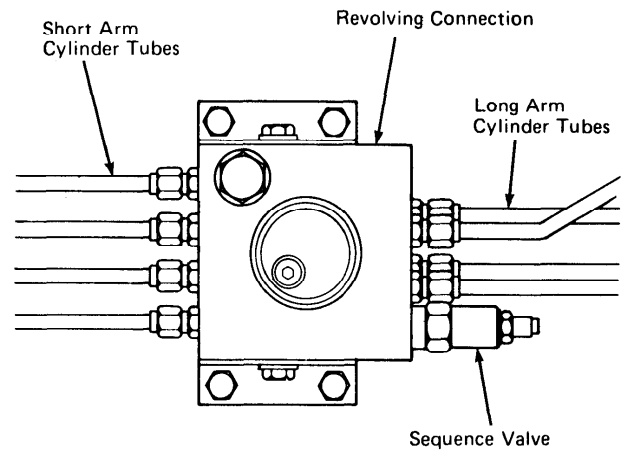


Figure 1.

NOTE: The lift truck system pressure **must be a minimum of 100 psi above** the Sequence Valve pressure setting. The lift truck pressure **must be set between 1600 psi and 2300 psi**. A minimum of 1600 psi is required to allow the arm to re-index properly.

When clamping with both arms or clamping with one arm and stroking the other arm to the end of the cylinder stroke, the clamping pressure equals the lift truck pressure setting.

Pressure Setting Procedure

To adjust the Sequence Valve, install a pressure gauge in one of the split arm clamp cylinder test ports. Clamp on a roll with the arm that has the pressure gauge, stopping the other arm slightly inside the roll diameter. The gauge pressure reading is the Sequence Valve setting. The setting is adjusted by loosening the locknut and turning the threaded stem **in to increase** the pressure or **out to decrease** the pressure. See figure 1. Retighten the locknut.

NOTE: This information should not be interpreted as the basis for warranty claims unless so designated.
Part No. 680066

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