



# Installation Instructions

## Electronic Rotational Control 77F Retrofit Kit 6019646

Electronic Rotational Control requires accurately located tapped holes for proper installation. For those Cascade Paper Roll Clamps that have not been pre-drilled for ERC the following steps are recommended for accurately locating the required holes. (This list does not determine for the Technician when he needs to dismount the attachment.)

- 1 Using one of the outer race capscrew holes, locate the Switch Bracket jig as indicated by the layout.
- 2 Mark Switch Bracket holes using transfer punch 6019664 (13/64").
- 3 Remove jig.
- 4 Reinstall and tighten the outer race capscrew to 80 ft.-lbs. (110 Nm).
- 5 Drill and tap Switch Bracket holes (M8 x 1,25) according to layout. Use tap drill and tap included in ECR Retrofit kit.
- 6 Mount Switch Bracket (222021) to Baseplate according to ERC retrofit install instructions (228724).
- 7 Mount Faceplate jig (228702) to Switch bracket using M5 cap screws included in ERC retrofit kit.
- 8 Tilt the truck mast so that the Short Arm Contact Pad is vertical in the tilting plane.
- 9 Rotate the Paper Roll Clamp until the Short Arm Contact Pad is vertical (use a leveling device to ensure accuracy) in the attachment rotating plane.
- 10 Using the two holes closest to the centerline of the faceplate jig, use transfer punch 6019664 (13/64") to locate two new holes in the faceplate.
- 11 Rotate the Paper Roll Clamp until the Short arm Contact Pad is down and horizontal in the 'bilge' position (use a leveling device to ensure accuracy).
- 12 Mark two new hole locations on the faceplate the same as step 10.
- 13 Rotate the Paper Roll Clamp until the Short Arm Contact Pad is on the other side from step 9. Ensure the Contact Pad is vertical (use a leveling device to ensure accuracy) in the attachment rotating plane.
- 14 Mark two new hole locations on the faceplate the same as step 10.
- 15 Drill and tap faceplate holes (M6 x 1,0) using tap drill and tap provided in the ERC Retrofit kit.
- 16 Locate the holes for the ERC Relay enclosure per Layout. Drill and tap (M6 x 1,0).
- 17 Proceed as directed by installation instructions 228724.

Part No. 6019665-R1

# cascade®

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**OR**

Write: Cascade Corporation, P.O. Box 20187, Portland, OR 97294

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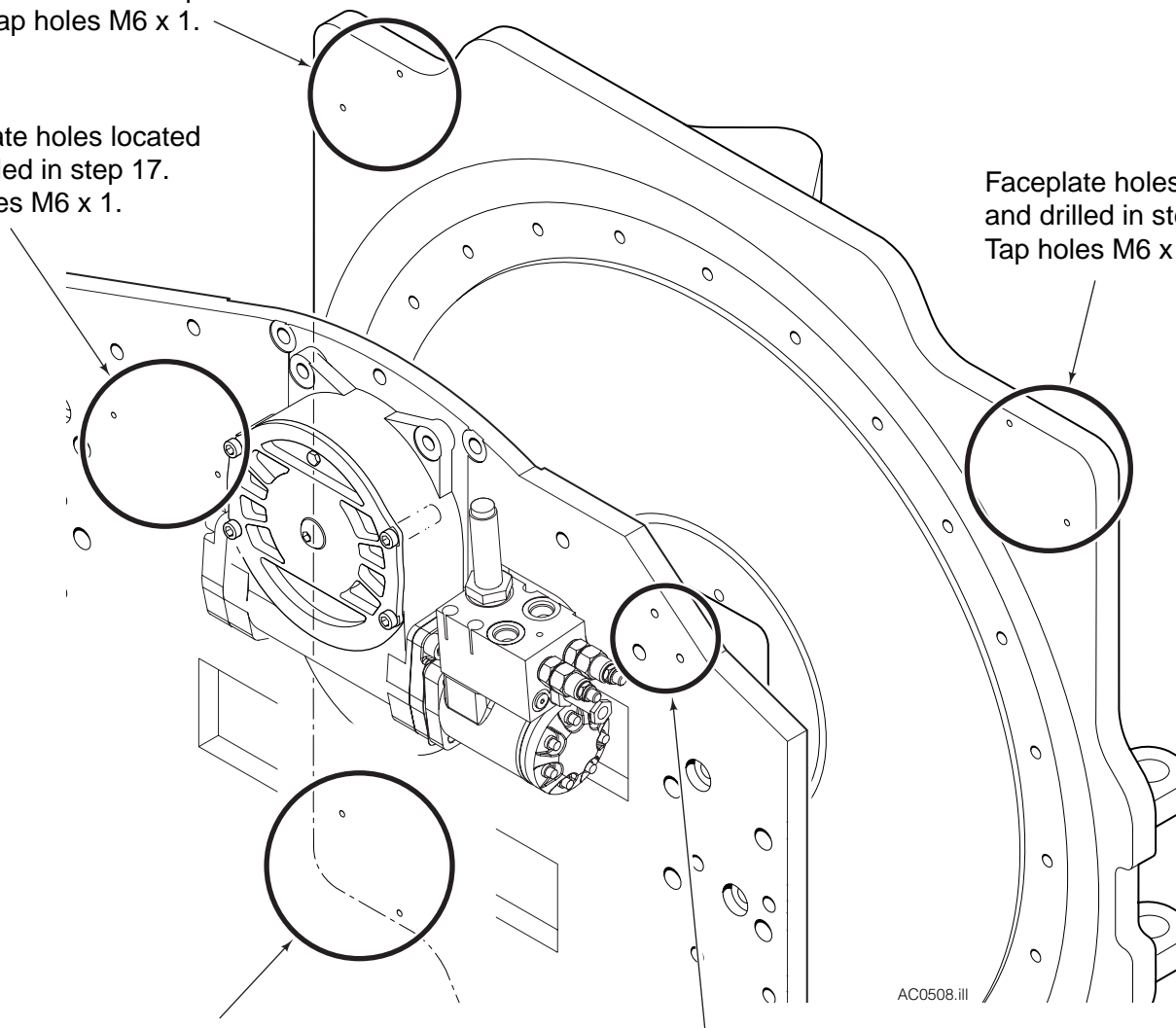
**OR**

Write: Cascade Corporation, 2501 Sheridan Ave., Springfield, OH 45505

Faceplate holes located  
and drilled in step 12.  
Tap holes M6 x 1.

Baseplate holes located  
and drilled in step 17.  
Tap holes M6 x 1.

Faceplate holes located  
and drilled in step 10.  
Tap holes M6 x 1.

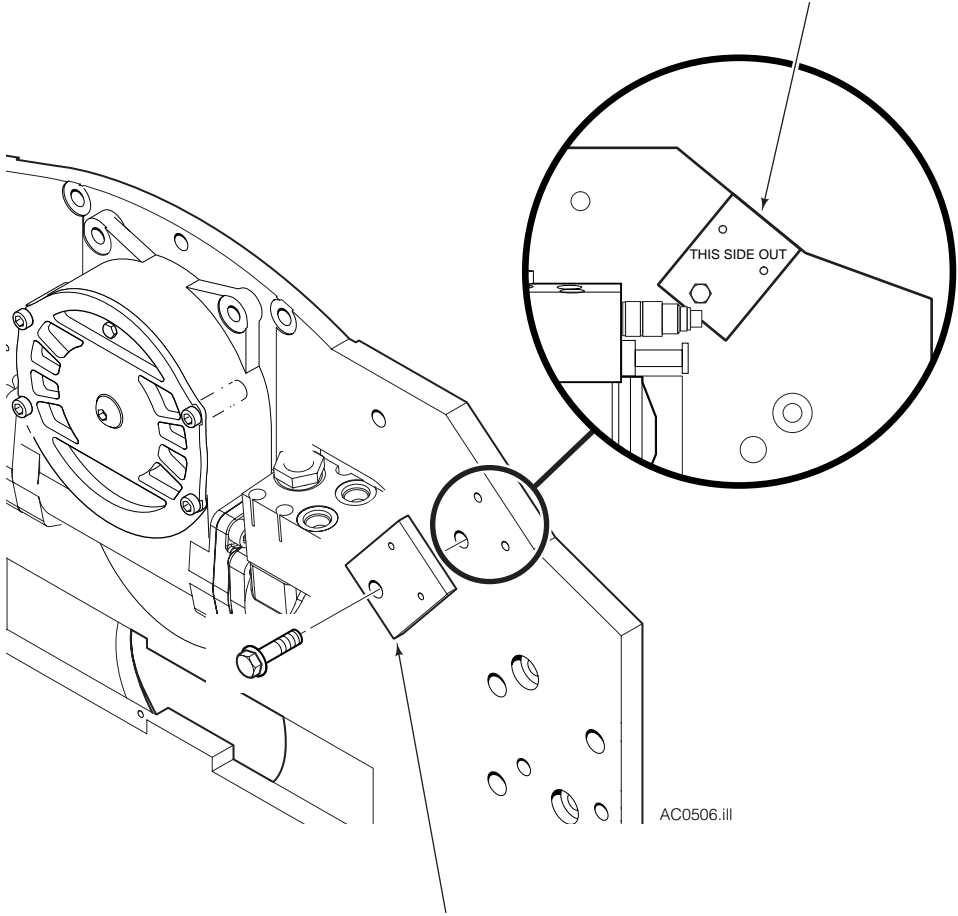


Faceplate holes located  
and drilled in step 15.  
Tap holes M6 x 1.

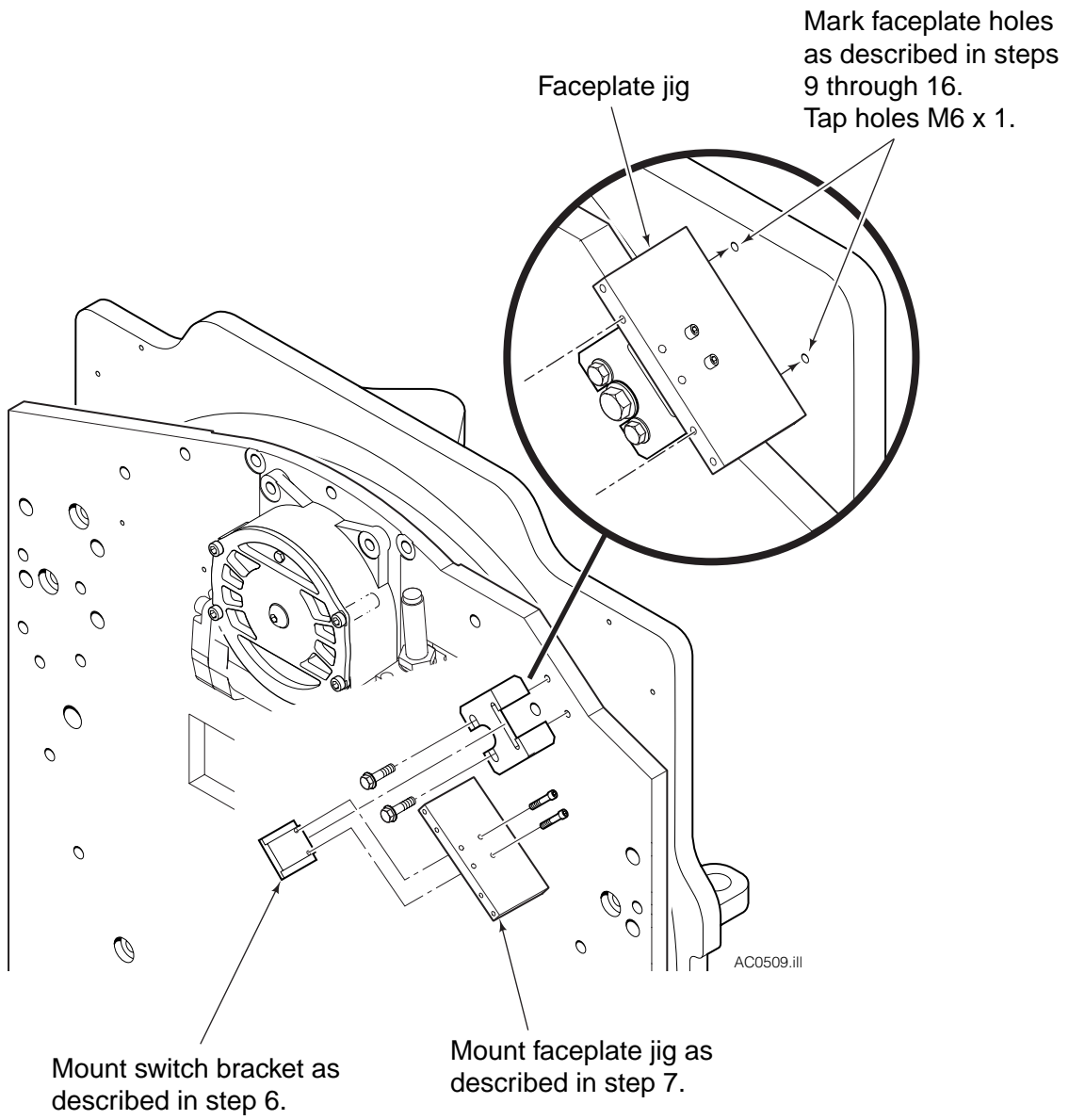
Baseplate holes located  
and drilled in steps 1 through 5.  
Tap holes M8 x 1,25.

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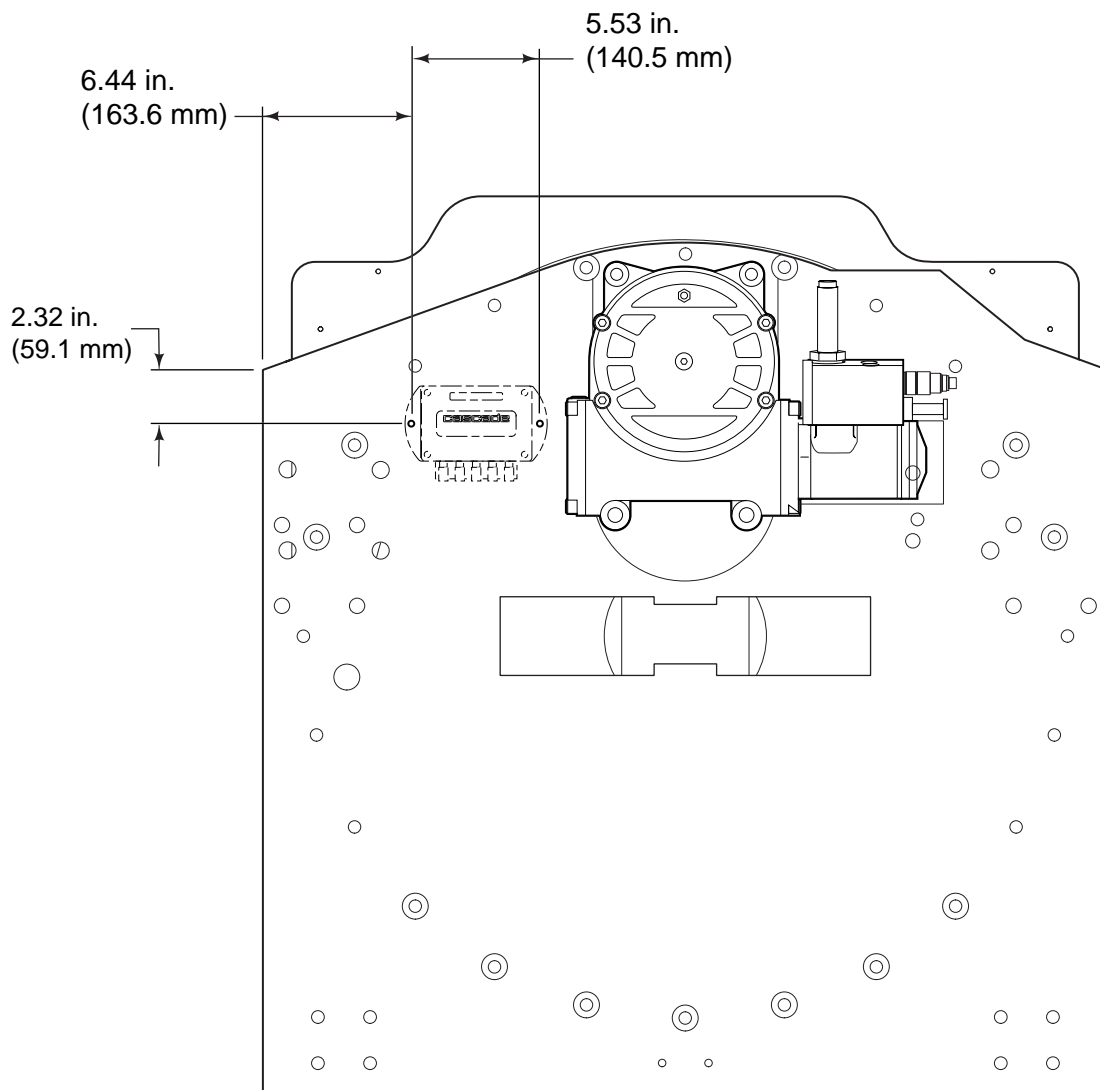
Align template edge parallel to edge of baseplate. Mark hole locations as described in step 2.



Install template using existing capscrew as described in steps 1 through 4.



Locate mounting holes  
for relay box as described  
in step 17. Drill and  
tap M6 x1 holes.



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

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