



# Installation Instructions

## Electronic Rotational Control 45F Retrofit Kits 6023367 and 6029773

Electronic Rotational Control requires accurately located tapped holes for proper installation. For Cascade Paper Roll Clamps that have not been pre-drilled for ERC, the following steps are recommended for accurately locating the required holes. An overview of the holes being added is shown on page 2. (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 (6018260) as indicated by the layout on page 3.
- 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 two Switch Bracket holes (M8 x 1,25) according to layout on page 3.
- 6** Mount Switch Brackets to the Baseplate according to ERC retrofit install instructions (228724). See page 4.
- 7** Mount Faceplate jig (228702) to Switch bracket using M5 cap screws included in ERC retrofit kit. See page 4.
- 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 positioned on the right side (drivers view) and vertical (use a leveling device to ensure accuracy) in the attachment rotating plane.
- 10 Fixed Frame Clamps** – Using the two holes closest to the centerline of the faceplate jig, use transfer punch 6019664 (13/64") to locate new holes in the faceplate. See page 4.  
**Swing Frame Clamps** – Using the two holes closest to the centerline of the faceplate jig, use transfer punch 6019664 (13/64") to locate a new hole in the faceplate and locate the weld on anchor on the edge of the faceplate. Weld the anchor in place with a .25 in. fillet. See page 4.
- 11** Rotate the Paper Roll Clamp clockwise until the Short Arm Contact Pad is down and horizontal in the 'bilge' position (use a leveling device to ensure accuracy).
- 12 Fixed Frame Clamps** – Mark new hole locations the same as step 10.  
**Swing Frame Clamps** – Mark a new hole location and weld an anchor on the faceplate the same as step 10. See page 4.
- 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. See page 4.
- 14** Mark new hole locations the same as step 10. See page 4.
- 15** Drill and tap the six faceplate holes (M6 x 1,0) using a tap drill and tap. See page 4.
- 16** Install the relay mounting plate to the baseplate switch bracket. See page 5.
- 17** Proceed as directed by installation instructions 228724.

Part No. 6023066

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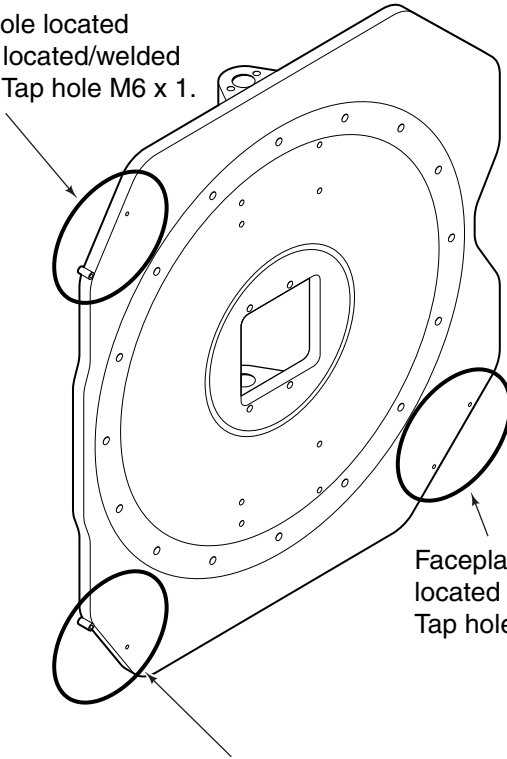
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### Swing Frame Faceplate

Faceplate hole located and anchor located/welded in **step 10**. Tap hole M6 x 1.

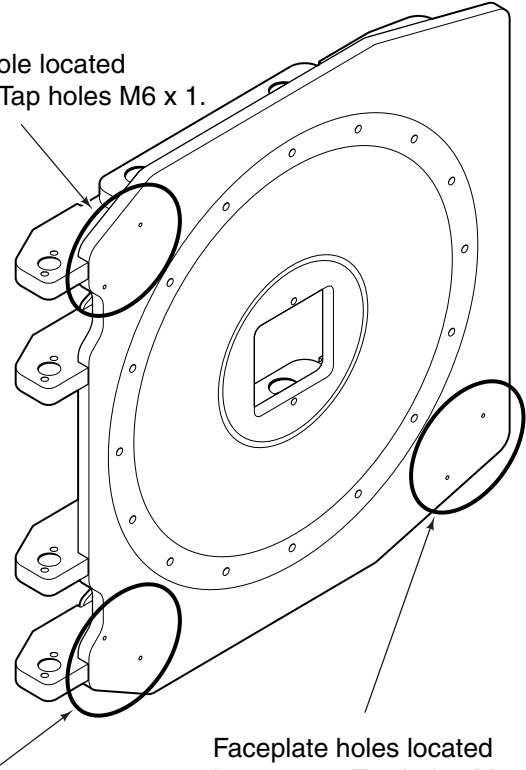


Faceplate holes located in **step 14**. Tap hole M6 x 1.

Faceplate hole located and anchor located/welded in **step 12**. Tap hole M6 x 1.

### Fixed Frame Faceplate

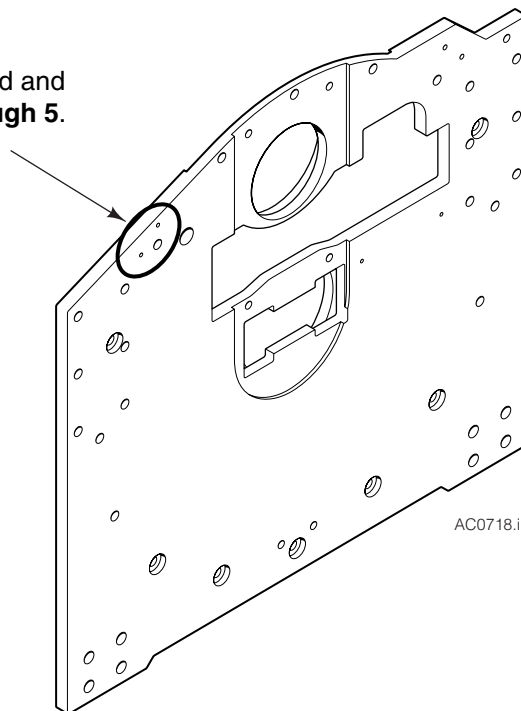
Faceplate hole located in **step 10**. Tap holes M6 x 1.



Faceplate holes located in **step 14**. Tap holes M6 x 1.

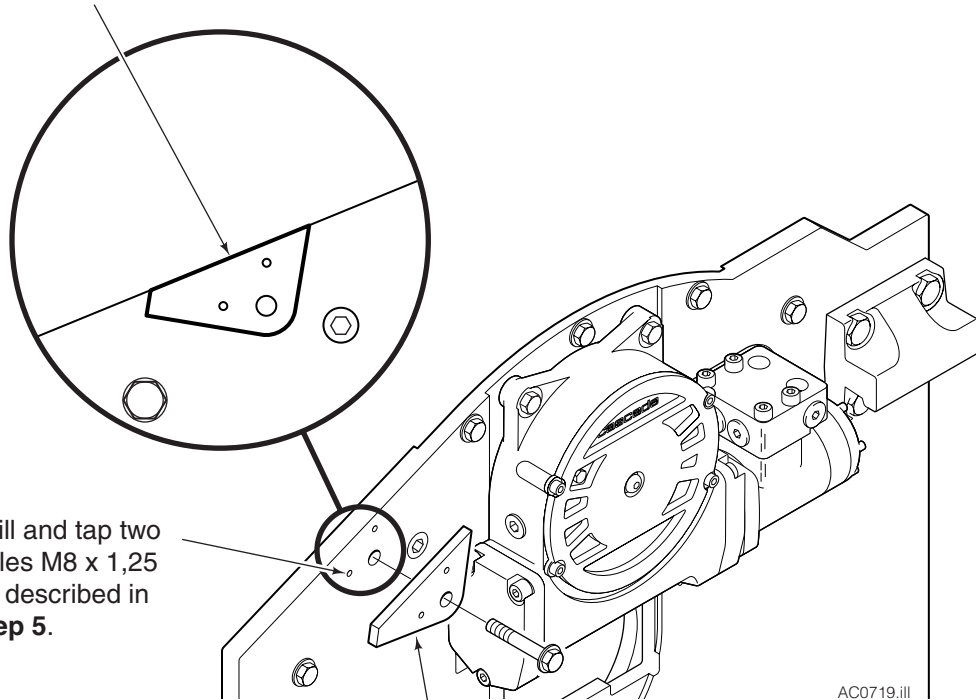
Faceplate holes located in **step 12**. Tap holes M6 x 1.

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



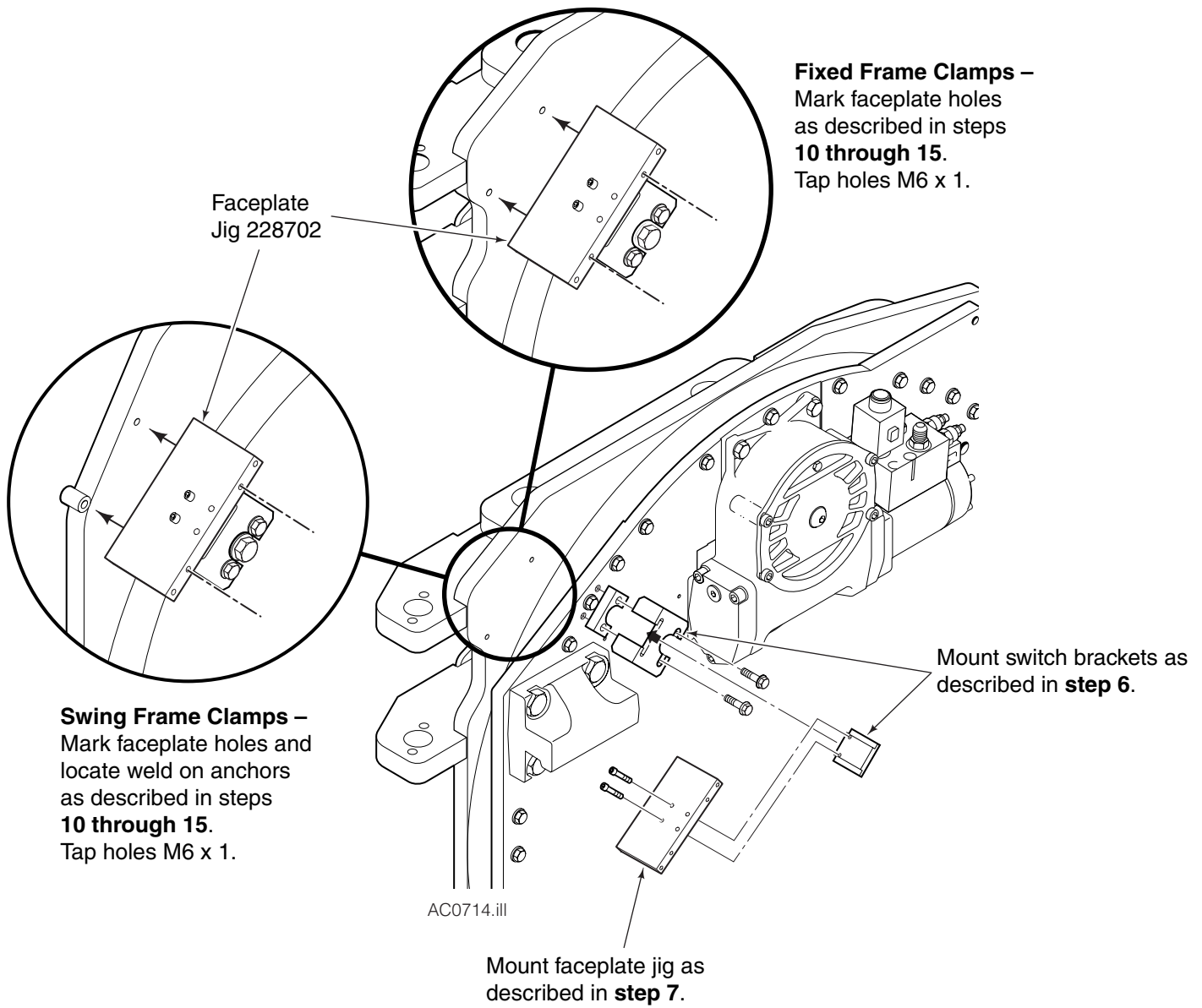
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Align template edge parallel to edge of baseplate. Mark hole locations as described in **step 2**.

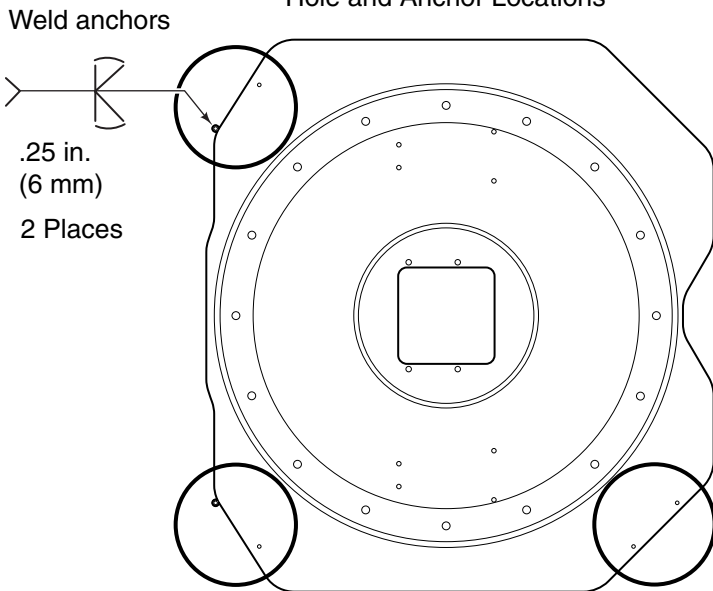


Drill and tap two holes M8 x 1,25 as described in **step 5**.

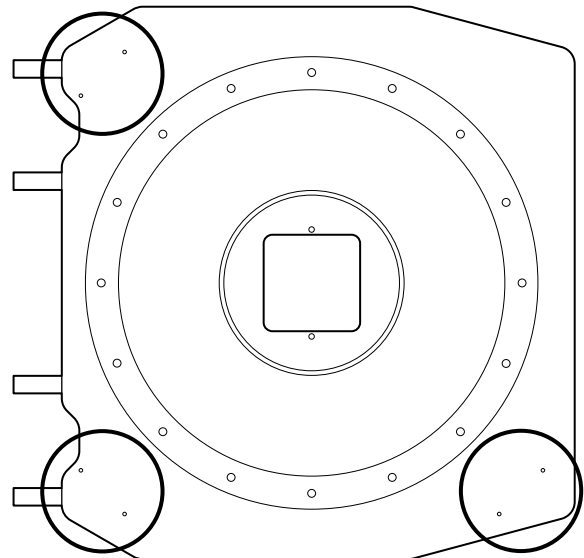
Install template using existing capscrew as described in **steps 1 and 2**.



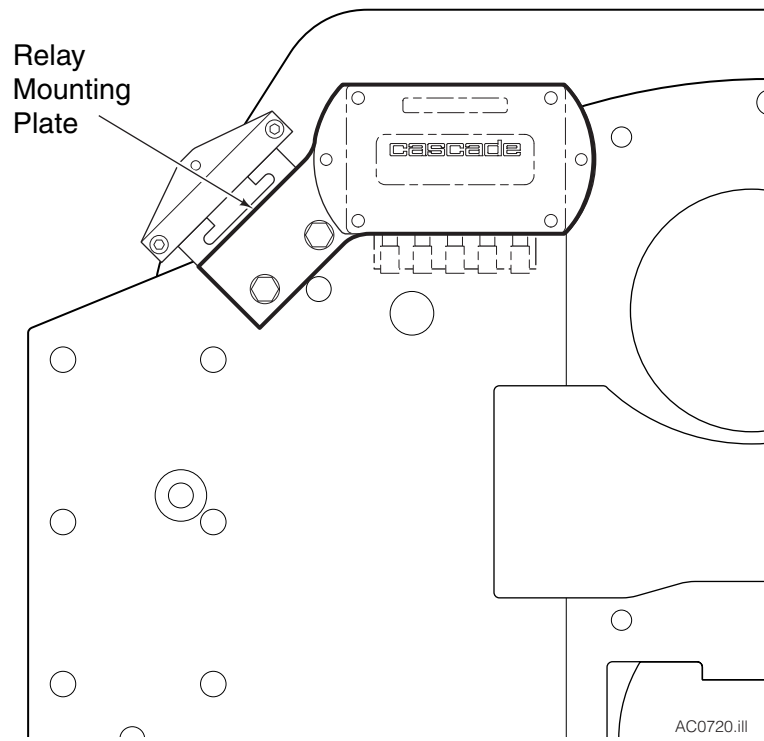
**Swing Frame Clamps**  
Hole and Anchor Locations



**Fixed Frame Clamps**  
Hole and Locations



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