



Technical Bulletin

Clamp Valve Assembly 343684 Clamp Force (lbs.) and Sideshift Speed Adjustment

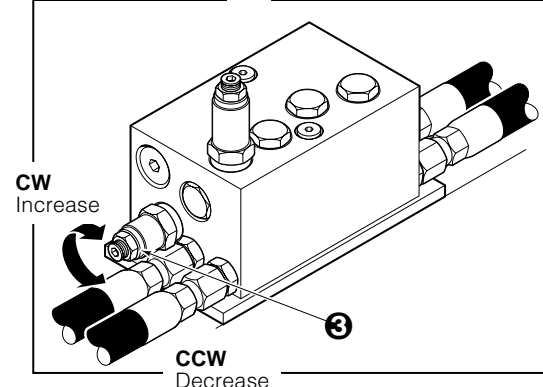
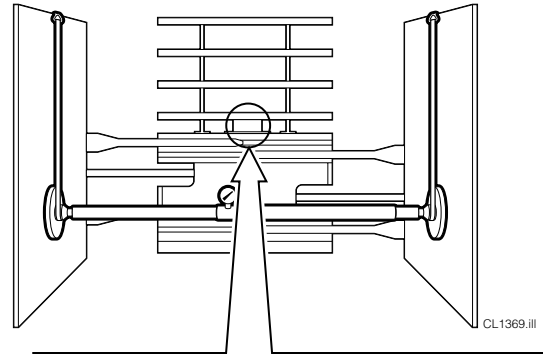
This sheet provides instructions for pressure adjustment of Valve Assembly 343684. The valve is equipped with a clamp force relief cartridge and a sideshift crossover relief cartridge.

Tools Required:

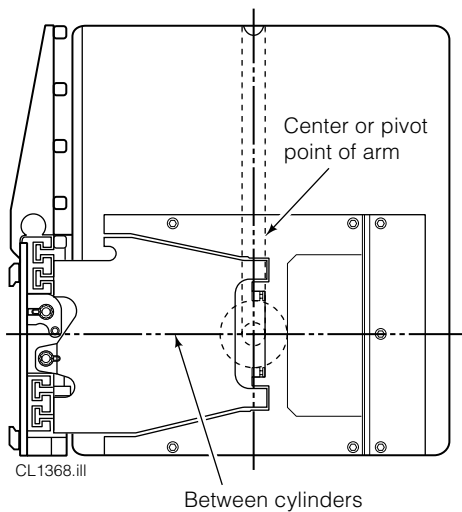
- 4 mm and 5 mm Allen Wrench
- 14 mm and 17 mm Open End Wrench
- 3500 psi Pressure Gauge and No. 6 Run Tee Fitting (Kit Part No. 671212)
- Clamp Force Indicator (Part No. 680072)

NOTE: Warm the truck to full operating temperature before adjusting the valve assembly.

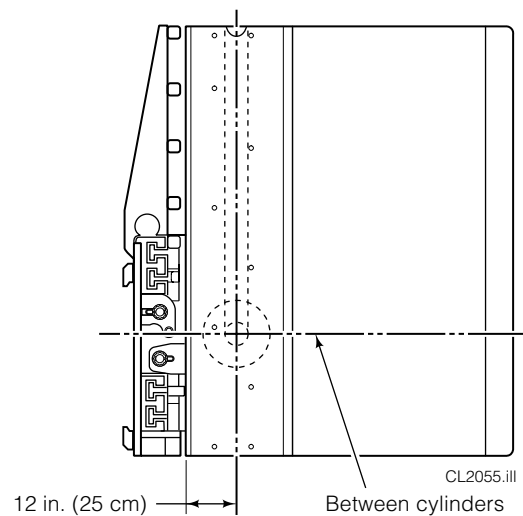
- 1 Install the Attachment as indicated in Installation Instructions 668987 (Clamps) or 670488 (Carton Clamps).
- 2 Install the clamp force indicator between the clamp's contact pads in the location as shown below.
- 3 **Clamp Force (lbs.) Adjustment:**
 - A Clamp the arms and hold the lever in the CLAMP position.
 - B Adjust the clamp relief cartridge until the required force is indicated on the clamp force indicator. Turn the adjustment screw clockwise (CW) to increase pressure, counterclockwise (CCW) to decrease pressure.
 - C Open the arms and reclamp on the clamp force indicator to confirm the setting. Tighten jam nut.



ARTICULATING CONTACT PAD



RAZORBACK CONTACT PAD



Part No. 685532 R-3



For Technical Support . . .

Call: 1-800-227-2233

OR

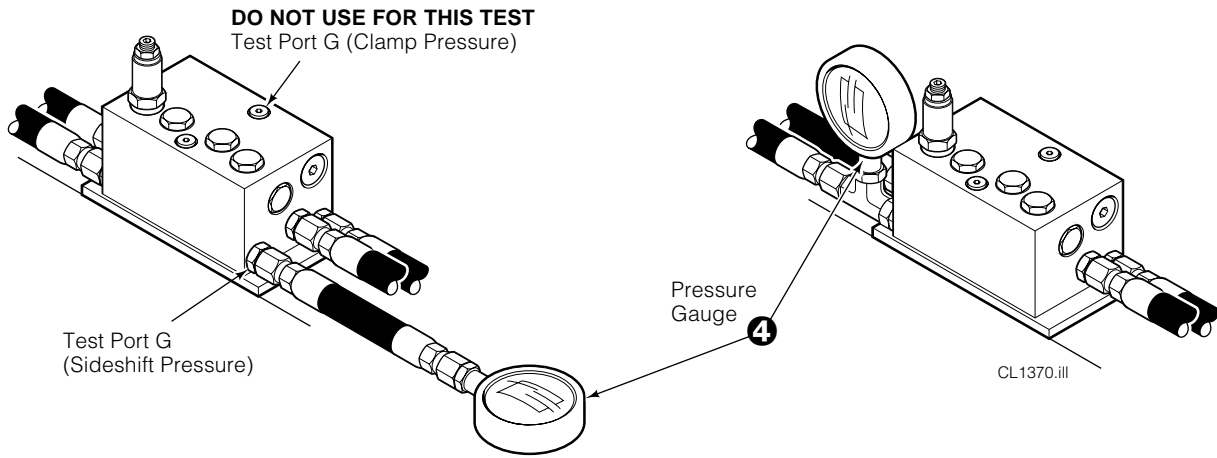
Write: Cascade Corporation, P.O. Box 20187, Portland, OR 97294

To Order Parts . . .

Call: 1-888-227-2233

OR

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



4 Pressure Gauge Installation

Clamps with gauge test port 'G':

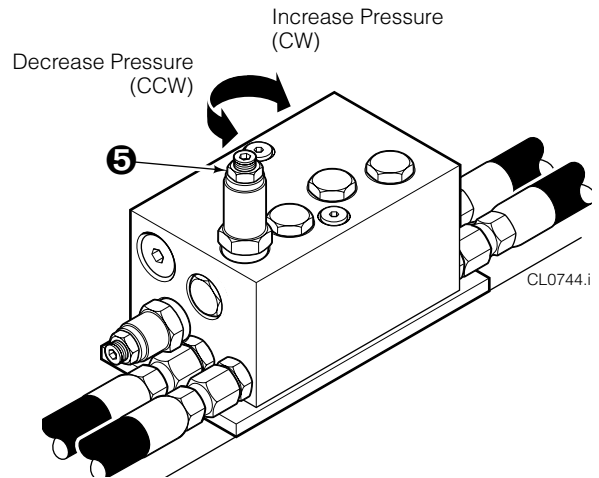
Remove the plug from the test port and install a 3500 psi (240 bar) pressure gauge.

Clamps without test port:

Disconnect the supply hose and install a No. 6 tee fitting to the SIDESHIFT LEFT (SSL) port in the valve. Install a 3500 psi (240 bar) pressure gauge to the tee fitting. Reconnect the supply hose.

5 Sideshift Relief Adjustment

- A With a maximum load clamped, sideshift full left and full right. Check for an arm speed of 8–10 in./sec. at a recommended 7.5 GPM (28 L/min.) hydraulic flow rate.
- B Adjust the SIDESHIFT relief cartridge counterclockwise (CCW) 1/4-turn. Repeat Steps A & B until sideshift speed slows (relief opening).
- C Readjust cartridge clockwise (CW) 1/4-turn. Tighten jam nut and replace cap.



WARNING: After completing any service procedure, always test the Clamp through 5 complete cycles. First test empty, then test with a load to make sure the Clamp operates correctly before returning it to the job.

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