



Technical Bulletin

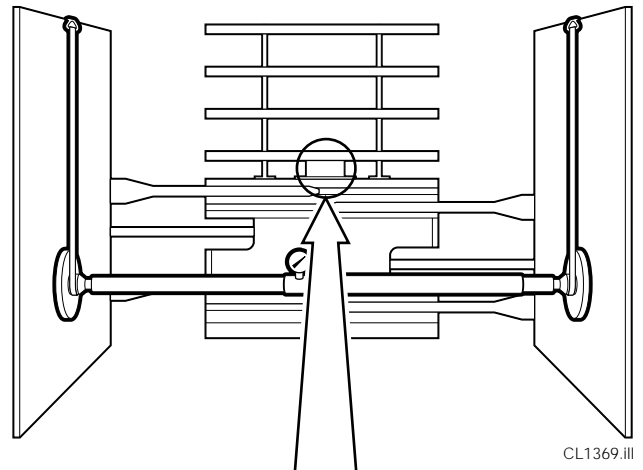
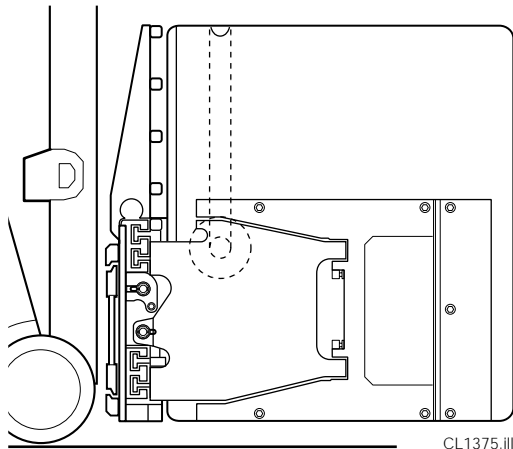
Sears Application Carton Clamp Valve Assembly 343684 Clamp Force (lbs.) and Sideshift Speed (psi) Adjustment

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

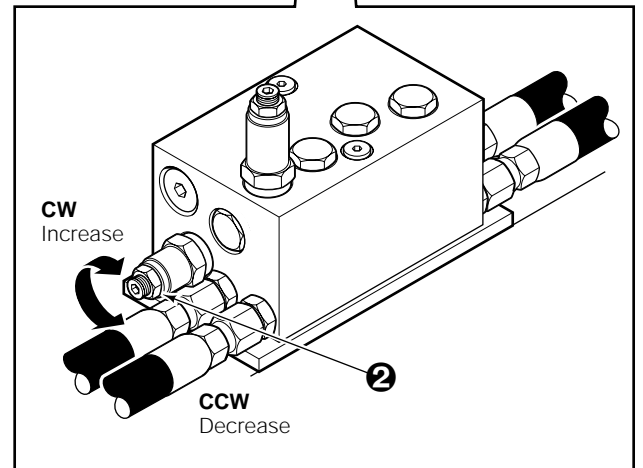
Tools Required:

- 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 clamp force indicator between the clamp's contact pads in the location shown.
- 2 **Clamp Force (lbs.) Adjustment:**
 - A Clamp the arms and hold the lever in the CLAMP position.
 - B Adjust the clamp relief cartridge until 1400 lbs. 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.



Part No. 685124 R-1



For Technical Support . . .

Call: 1-800-CASCADE (227-2233)

OR

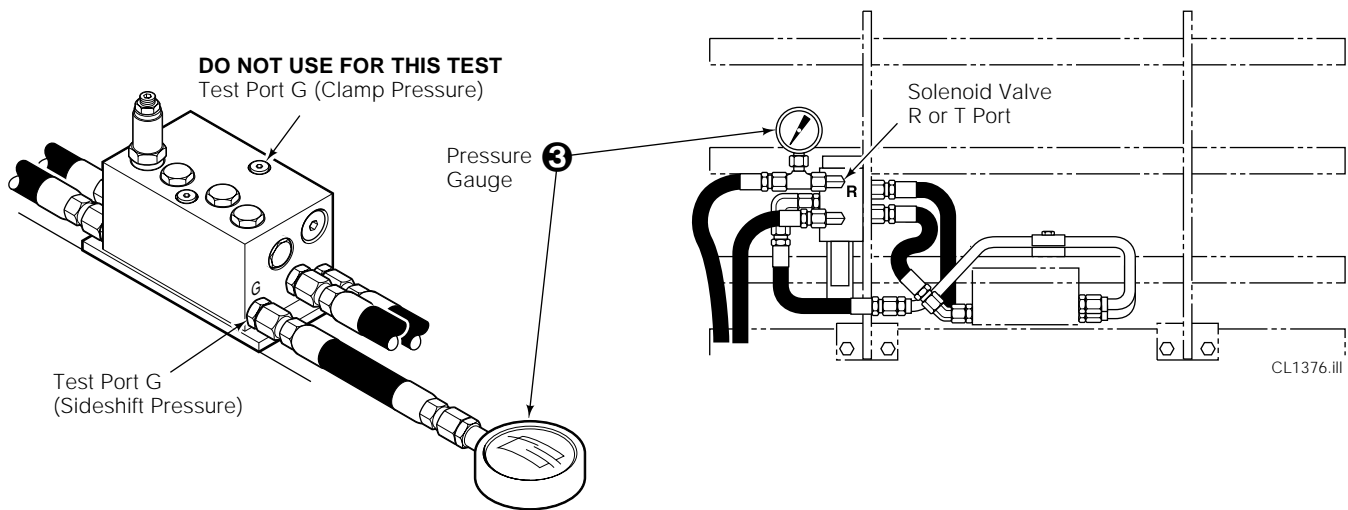
Write: Cascade Corporation, PO Box 20187, Portland, OR 97294-0187

To Order Parts . . .

Call: 1-888-CASCADE (227-2233)

OR

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



3 Pressure Gauge Installation

Clamps with gauge test port 'G':

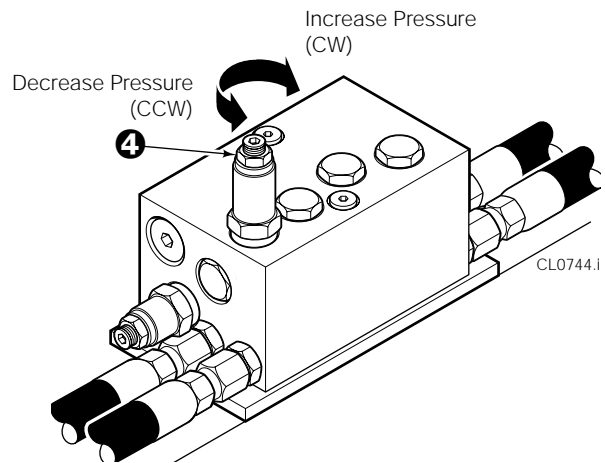
Remove the plug from the test port and install a 3500 psi (240 bar) pressure gauge.

Clamps without test port:

Disconnect the supply hose and install a No. 6 tee fitting to the solenoid valve 'R' or 'T' port. Install a 3500 psi (240 bar) pressure gauge to the tee fitting. Reconnect the supply hose.

4 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.