

# Technical Bulletin

## Adjusting E-Series Carton Clamp Relief Pressures


This Bulletin describes how to adjust the clamp and sideshift relief cartridges for E-Series Carton Clamps. If the cartridges are out of adjustment allowing excessive clamp pressure, machine structural damage may result.

### Clamp Relief Adjustment

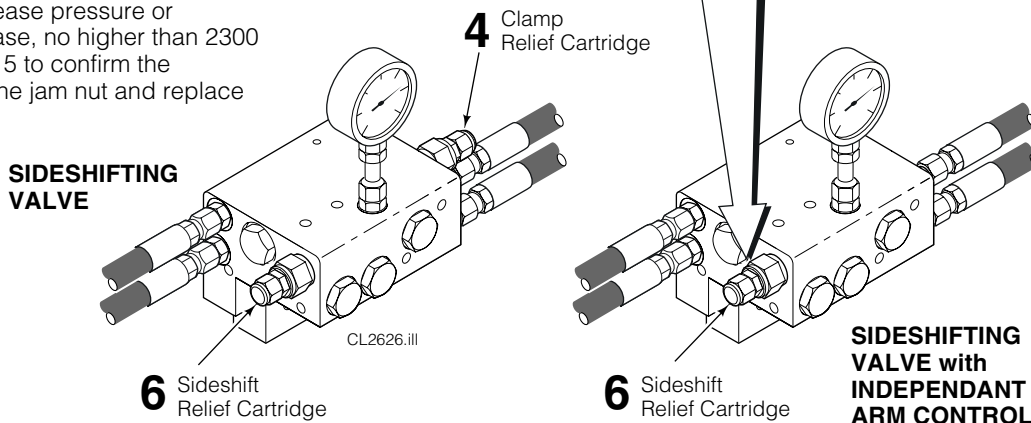
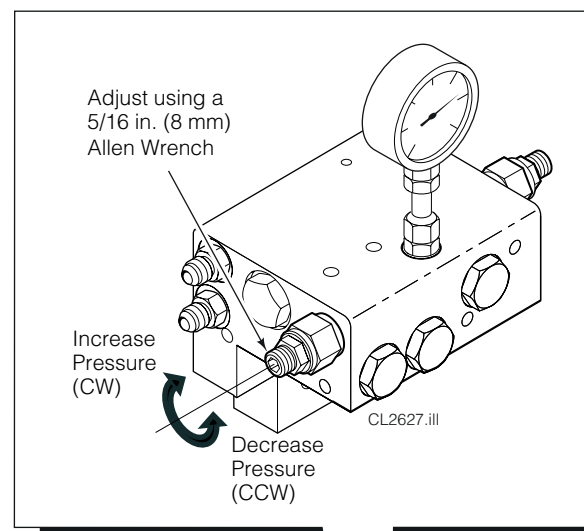
- 1 Confirm that the truck hydraulic pressure and flow are a maximum of 2300 psi (160 bar) and 10 GPM (38 L/min) at the carriage hose terminal.
- 2 Install a 3000 psi (200 bar) pressure gauge in the valve No. 4 O-ring test port.
- 3 Cycle the arms to full open. Slowly close the arms while clamping a typical load (or clamp force indicator). Hold the lever in the CLAMP position to develop full pressure.
- 4 Adjust the **CLAMP** relief cartridge to the required clamp pressure for loads being handled. Adjust the cartridge clockwise to increase pressure or counterclockwise to decrease, no higher than 2300 psi (160 bar). Tighten the jam nut and replace cap.

### Sideshift Relief Adjustment

- 5 While clamping the same load, sideshift fully to the left or right. Pull the handle several times at the end of the sideshift stroke and note the gauge pressure reading.
- 6 Adjust the **SIDESHIFT** relief cartridge to set the gauge pressure when fully sideshifted to less than the clamp pressure set in step 4 above. Adjust the cartridge clockwise to increase pressure or counterclockwise to decrease, no higher than 2300 psi (160 bar). Repeat step 5 to confirm the pressure setting. Tighten the jam nut and replace cap.



**WARNING:** Before installing a pressure gauge, relieve pressure in the hydraulic system. Turn the truck off and open the truck auxiliary control valves several times in both directions.



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

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