



Technical Bulletin

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Cascade D-Series Non-Sideshifting Clamps, Sideshifting Clamps and Carton Clamps utilize a regenerative hydraulic circuit in the arm opening mode. The arms open at a faster speed than when closing while using less energy. This feature is especially valuable for electric trucks with low volume hydraulic systems. However, on trucks with high volume hydraulic systems, it may be desirable to plug the regenerative circuit to (1) reduce arm opening speed and (2) alleviate check valve heat build-up. The circuit can be plugged as follows:

- 1 Open the clamp arms to the width of the frame.



WARNING: Before removing any hoses, relieve pressure that might be present in the hydraulic system. With the truck off, open the truck auxiliary control valve(s) several times in both directions.

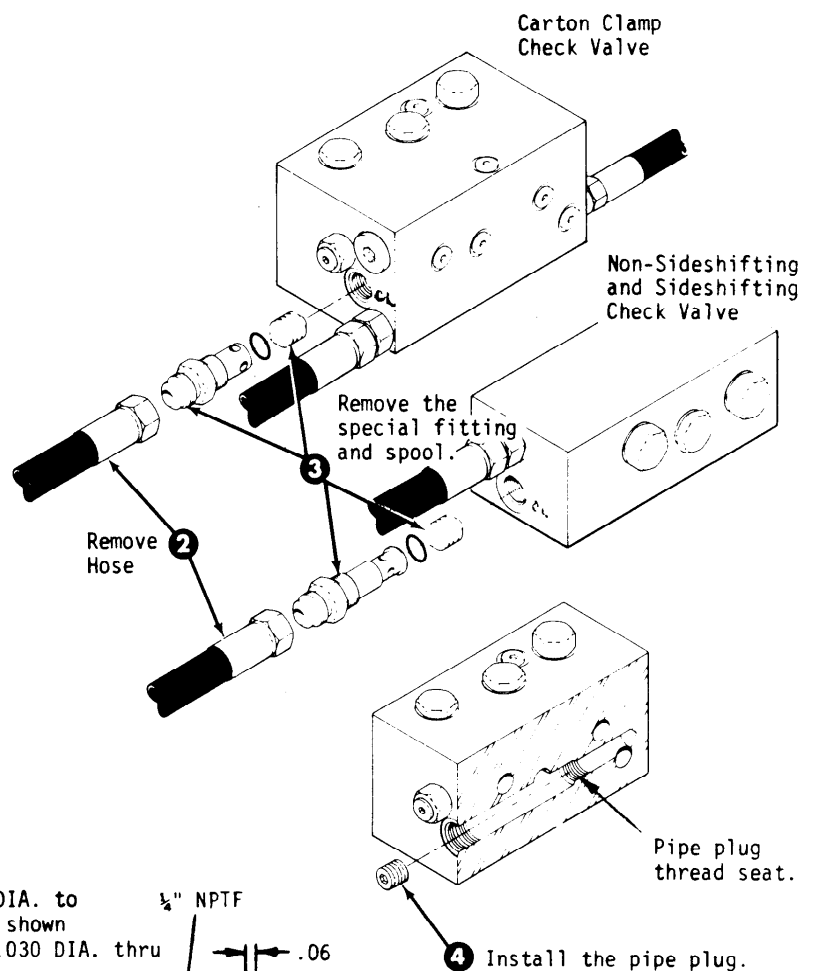
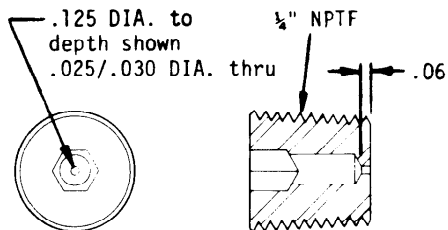
- 2 Remove the hydraulic hose from the check valve (CL) port.
- 3 Remove the special fitting and spool from the check valve (CL) port.
- 4 Install pipe plug 673271 or a $\frac{1}{2}$ " NPTF pipe plug with a .025/.030" orifice (see drawing below) into the port. The thread seat for the plug is approximately 4" inside the port. Tighten the plug to 25 - 30 ft.-lbs.

NOTE: A predrilled pipe plug (673271) is available from the Cascade Parts Depot or a pipe plug can be modified as shown in the drawing below.

- 5 Reinstall the special fitting and hydraulic hose. Do not reinstall the spool.

Pipe plug 673271 can be ordered by contacting:

Parts Depot
Cascade Corporation
2501 Sheridan Ave.
Springfield, Ohio 45505
Telephone: (513)322-1199
Telex: 205413



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P.O. Box 20187 • Portland, Oregon 97220 • (503) 666-1511
P.O. Box 360 • Springfield, Ohio 45505 • (513) 325-9271

Do you have questions
you need answered
right now?

Dial Direct no.
600-277-2233
(toll free)



Installation Instructions

D-Series Clamp Regeneration Eliminating Plug 673271

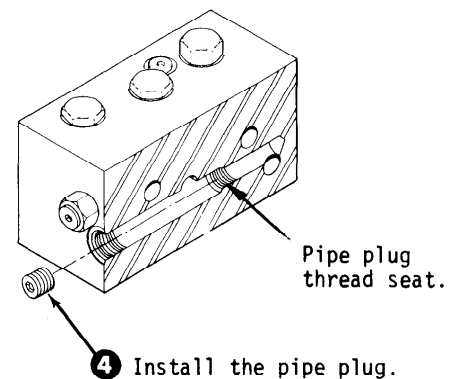
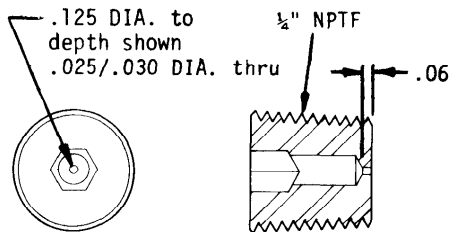
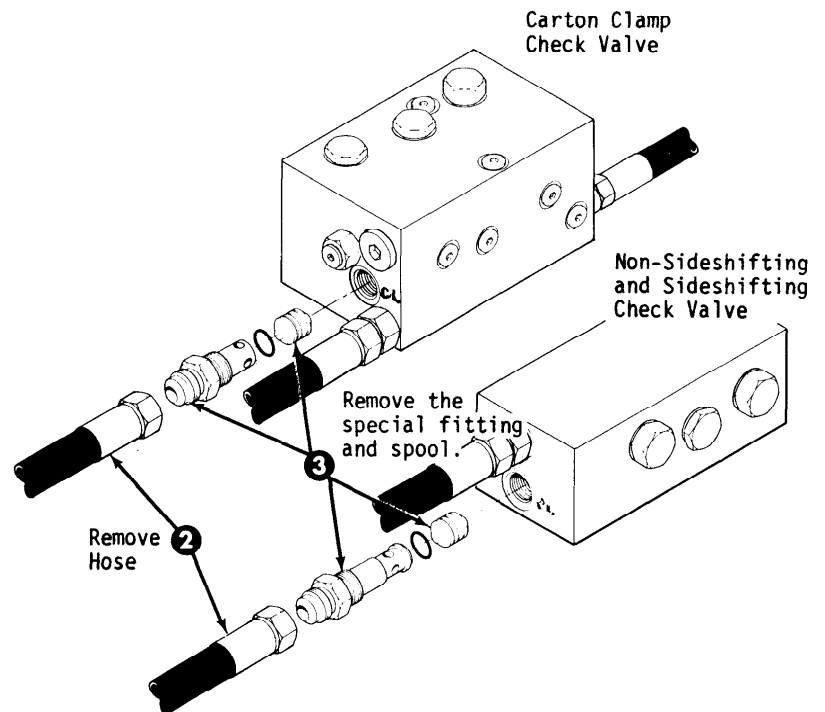
This sheet provides installation instructions for the Regeneration Eliminating Plug 673271 or a similarly modified pipe plug. The plug reduces the arm opening speed.

- 1 Open the clamp arms to the width of the frame.



WARNING: Before removing any hoses, relieve pressure that might be present in the hydraulic system. With the truck off, open the truck auxiliary control valve(s) several times in both directions.

- 2 Remove the hydraulic hose from the check valve (CL) port.
- 3 Remove the special fitting and spool from the check valve (CL) port.
- 4 Install pipe plug 673271 or a $\frac{1}{2}$ " NPTF pipe plug with a .025/.030" orifice (see drawing below) into the port. The thread seat for the plug is approximately 4" inside the port. Tighten the plug to 25 - 30 ft.-lbs.
- 5 Reinstall the special fitting and hydraulic hose. Do not reinstall the spool.



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