



Technical Bulletin

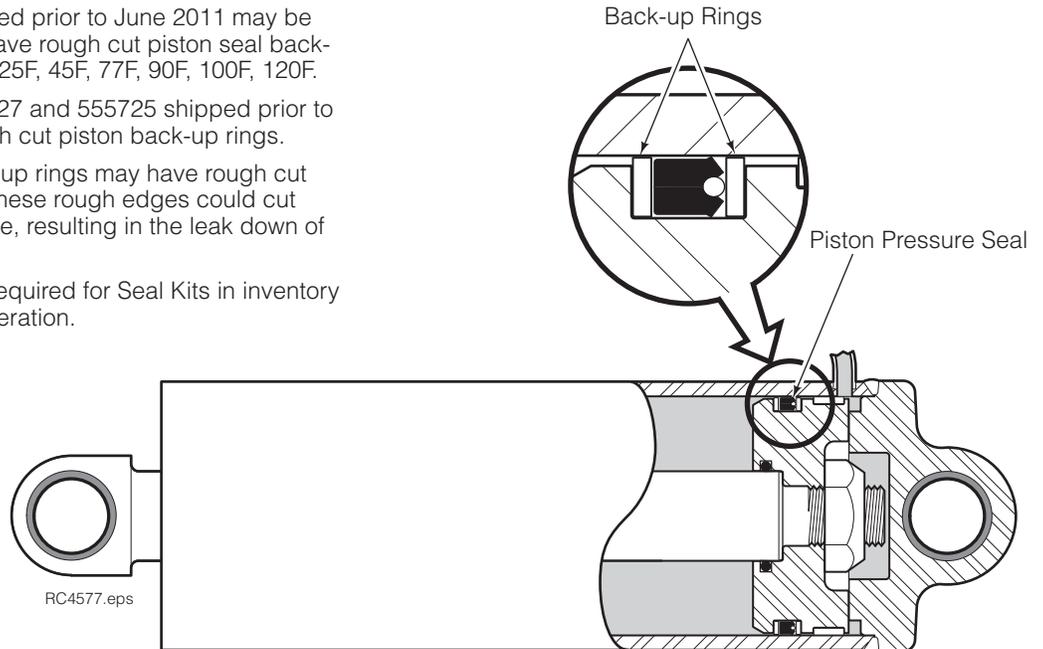
F-Series Paper Roll Clamp Cylinder Back-up Rings and Seal Service Kits 555227 & 555725

Paper Roll Clamps manufactured prior to June 2011 may be equipped with cylinders that have rough cut piston seal back-up rings. Models affected are 25F, 45F, 77F, 90F, 100F, 120F.

Cylinder seal service kits 555227 and 555725 shipped prior to June 2011 may also have rough cut piston back-up rings.

The piston pressure seal back-up rings may have rough cut edges on the diagonal split. These rough edges could cut the piston pressure seal surface, resulting in the leak down of clamping pressure.

Continue for two action items required for Seal Kits in inventory and existing Roll Clamps in operation.



Action Item 1

Inspect Existing Inventory of Cylinder Seal Kits 555227 and 555725

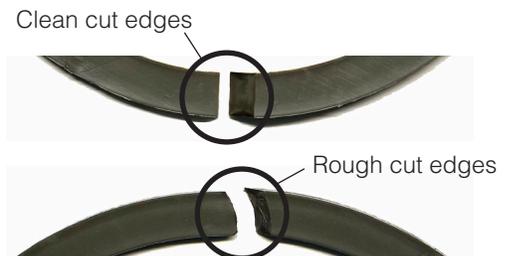
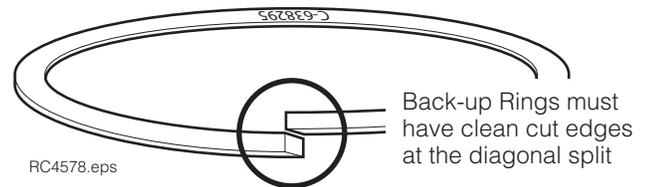
We are relying on our dealers to inspect their existing inventory of Seal Kits 555227 and 555725 with the Batch Codes listed below and to communicate with end users who may also have seal kits in inventory.

Seal Kit 555227 with Batch Code prior to 262047-0001

Seal Kit 555725 with Batch Code prior to 263179-0002

Inspect the large back-up rings in the seal kit. The part number C-638293 or C-638295 is molded into the side of the ring. The back-up rings must have clean cut edges on the diagonal split. Rough edges on the split surfaces may cut the piston pressure seal surface, resulting in the leak down of clamping pressure.

If you identify rough cut back-up rings in a kit or have any question as to the condition of the ring, contact Cascade to arrange returning the seal kit to the Cascade Parts Depot for an exchange kit. See contacts on front of this document.



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



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

Action Item 2

25F, 45F, 77F, 90F, 100F, 120F Roll Clamps in Operation

Clamp force should be checked prior to each operational shift and at 100 hour Preventive Maintenance intervals. Use Method A or B to check clamp force retention. Clamps equipped with force control technology require special considerations—consult Cascade. Refer to Service Manual 674512 to calibrate or check system performance.

Method A – Cylinder Pressure Test Using Gauges

1 Check for external leaks at the cylinders and revolving connection. **Position both arms at mid stroke to relieve cylinder pressure.**

2 Long Arm Cylinders – Install a pressure gauge to each long arm cylinder's test port. Close the long arm fully and hold the handle in the CLAMP position a few seconds to develop full truck system pressure. Watch the gauge pressure readings.

Short Arm Cylinders – Install a pressure gauge to each short arm cylinder's gauge port. Rotate the Clamp to the 45 degree position. Close the short arm fully and hold the handle in the CLAMP position a few seconds to develop full truck system pressure. Watch the gauge pressure readings.

- If one of the gauge pressures drops more than 150 psi (10 bar) initially, and additional drop exceeds 25 psi (2 bar) per minute, the cylinder check valve cartridge or piston seals may be faulty. Continue troubleshooting.
- If both gauge pressures do not drop more than 150 psi (10 bar) initially, and additional drop does not exceed 25 psi (2 bar) per minute, the problem is not hydraulic. Review the Operator Guide for proper roll handling techniques.

3 Position both arms at mid stroke to relieve cylinder pressure. Remove, swap and reinstall the cylinder check valve cartridges.

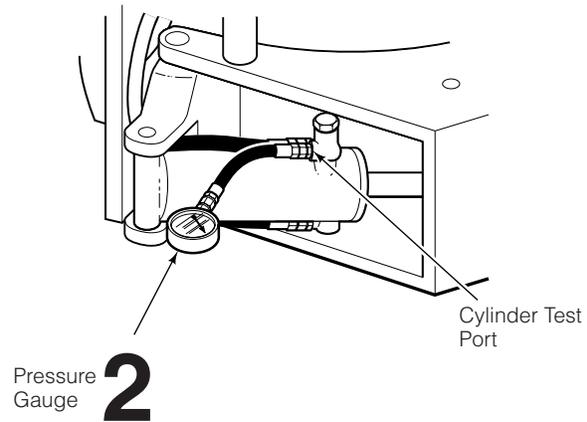
4 Long Arm Cylinders – Close the long arm fully and hold the handle in the CLAMP position a few seconds to develop full truck system pressure. Watch the gauge pressure readings.

Short Arm Cylinders – Rotate the Roll Clamp to the 45 degree position. Close the short arm fully and hold the handle in the CLAMP position a few seconds to develop full truck system pressure. Watch the gauge pressure readings.

- If the gauge pressure on the cylinder continues to drop more than 150 psi (10 bar) initially, and additional drop exceeds 25 psi (2 bar) per minute, the cylinder piston seals are faulty. Refer to Service Manual 674512 for cylinder service.
- If the gauge pressure on the cylinder does not drop more than 150 psi (10 bar) initially, and additional drop does not exceed 25 psi (2 bar) per minute, the check valve (now in the other cylinder) is faulty and requires replacement.



WARNING: Before removing hydraulic lines, position both arms at mid stroke to relieve cylinder pressure. Turn the truck off and open the truck auxiliary control valves several times in both directions.



Method B – Measure Clamp Force Retention using a Clamp Force Indicator

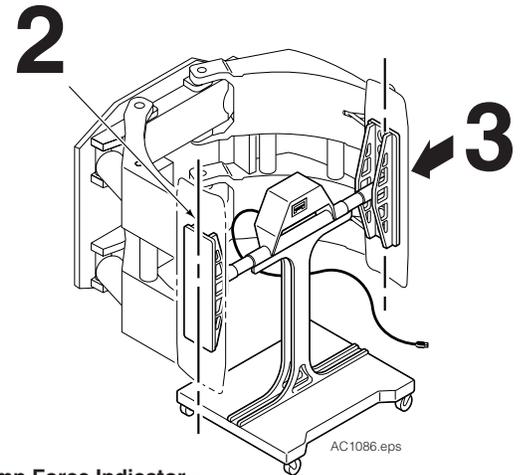
- 1 Check for external leaks at the cylinders and revolving connection.

NOTE: Connect the Digital Clamp Force Indicator to a power source. Measurements will be taken automatically.

- 2 **Make sure both arms are not at the end of stroke when clamped on the Indicator.** Position the Clamp Force Indicator solidly against the short arm contact pad. Center pad surfaces vertically and horizontally.
- 3 Slowly clamp the long arm pad against the indicator pad. Clamp fully at 2/3rd throttle, holding the CLAMP lever several seconds. Release and record the initial display value. **Determine if this value is correct and does not exceed clamp force recommended for rolls being handled.**

NOTE: Clamp Force required to prevent crushing is commonly marked on roll.

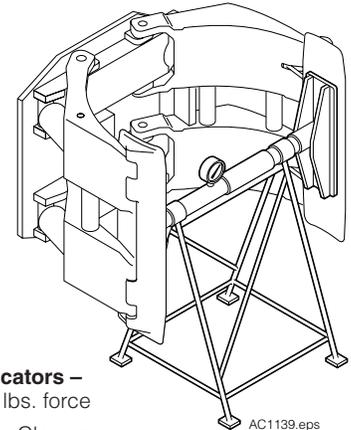
- If the indicator pressures drops more than 150 psi (10 bar) initially and an additional drop exceeds 25 psi (2 bar) per minute, the cylinder check valve cartridges or piston seals may be faulty. Continue troubleshooting using Service Manual 674512.
- If the cylinder seals are isolated as needing service, rebuild the cylinder using a seal kit that has had the back-up rings inspected. See Action item 1 for inspection,



Digital Clamp Force Indicator –
Measures up to 30,000 lbs. force

300G-DFI-812C – Split Arm Clamps
8 x 12 in. Radiused Pads

300G-DFI-824C – Solid Arm Clamps
8 x 24 in. Radiused Pads



Analog Clamp Force Indicators –
Measures 5,000 to 25,000 lbs. force

300G-CFI-812C – Split Arm Clamps
8 x 12 in. Radiused Pads

300G-CFI-824C – Solid Arm Clamps
8 x 24 in. Radiused Pads

Do you have questions you need answered right now?

Call your nearest Cascade Service Department.

Visit us online at www.cascorp.com

AMERICAS

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