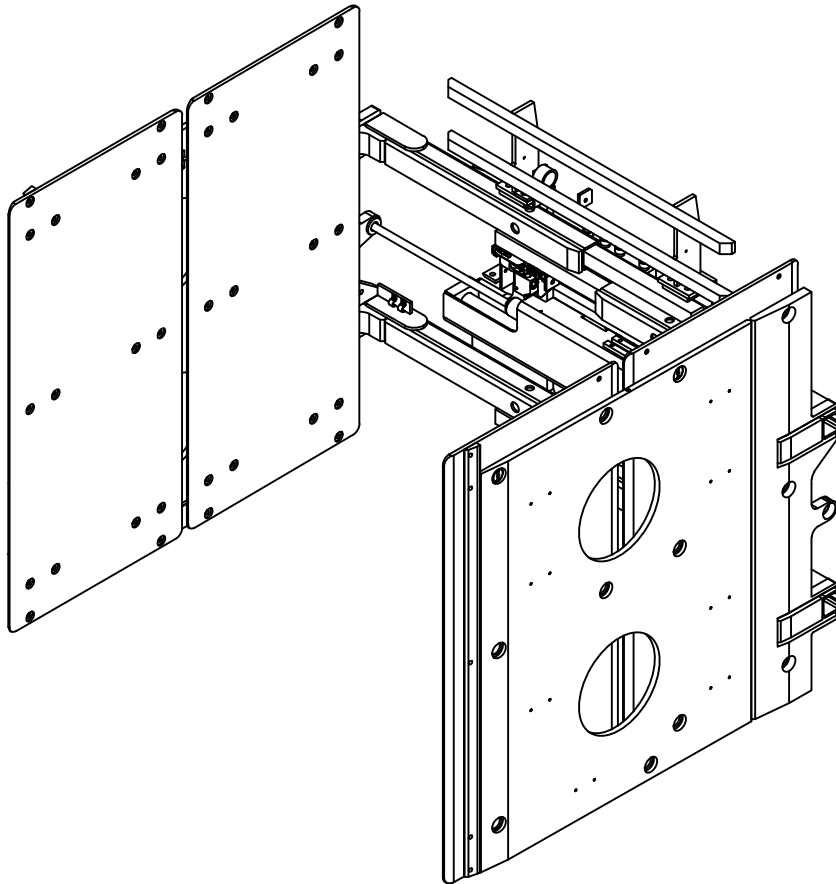




# SERVICE MANUAL / PARTS LIST

## APPLIANCE CLAMP SOFT TOUCH

MODEL #113305  
PATENT NO. 9,630,821  
PATENT NO. 10,597,272



## CONTENT:

### PAGE

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5	Arm Group Assembly
6-8	Floating Pad Assembly
9-11	Hydraulic Assembly
12	Cylinder Assembly
13	Clamp Adjustments
14	Control Valve
15	Clamp Force Control Valve
16	Arm Slide & Shim Replacement
17	Trouble Shooting Guide

### Specifications:

Mounting: Class II  
Side Shifting: External Side Shifting  
Capacity: 2200 lbs at 29"  
Pad Size: 57" High x 58" Long  
Range: 23.0" - 80.0"  
Frame: 46" Wide

R0 - 07/2017

425 Hazel St.  
Kelso WA 98626  
(800) 248-6079  
Fax (360) 578-9934

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# LIFT TRUCK REQUIREMENTS

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Capacity shown on the clamp's name plate is for the clamp only. The combined truck and clamp capacity is provided by the lift truck manufacturer.

**Recommended Truck Pressure:** 2300 to 2400 PSI (159 to 165 bar).

**Hydraulic fluid:** petroleum based hydraulic fluid only.

**Hydraulic supply group:** includes hoses and take-up - one for each function.

**Auxiliary valves:** 2 function (Side Shift & Clamp) = double auxiliary valve.

**Oil Volume Settings:**

Side Shift = 3 GPM

Clamp Open/Close = 7 GPM

**NOTE:** Three Position Force Selector must be disabled.

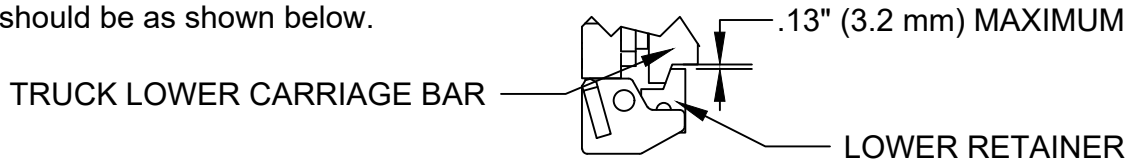
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## GENERAL INSTALLATION PROCEDURES

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1. Make sure that the attachment centering lug is correctly seated in truck carriage center notch.
2. Clearance between the lower retainers that hold the attachment to the truck lower carriage bar should be as shown below.



3. Connect hydraulic jumper hoses from the truck's supply group to the attachment's main manifold.
4. Standing clear of the clamp attachment, cycle the attachment in and out several times. Partially filled hydraulic lines may cause erratic movement.

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## GENERAL INSPECTION AND MAINTENANCE

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1. Check all hydraulic fittings, hoses, cylinders and valves for leakages - repair or replace as required.
2. Check bladder system pressure. If out of operating range adjust as required using the LORON hand pump (PN: 112909) and pure propylene glycol antifreeze mixed 1:1 with water. Check clamp force and adjust.

Time Schedule: Check bladder pressure every day and clamp forces every 3 weeks

Bladder System Pressure: 4 - 6 PSI

3. All bolts should be checked and tightened as required.
4. Check lower retainer clearance - see item 2 in the General Installation Procedures above.

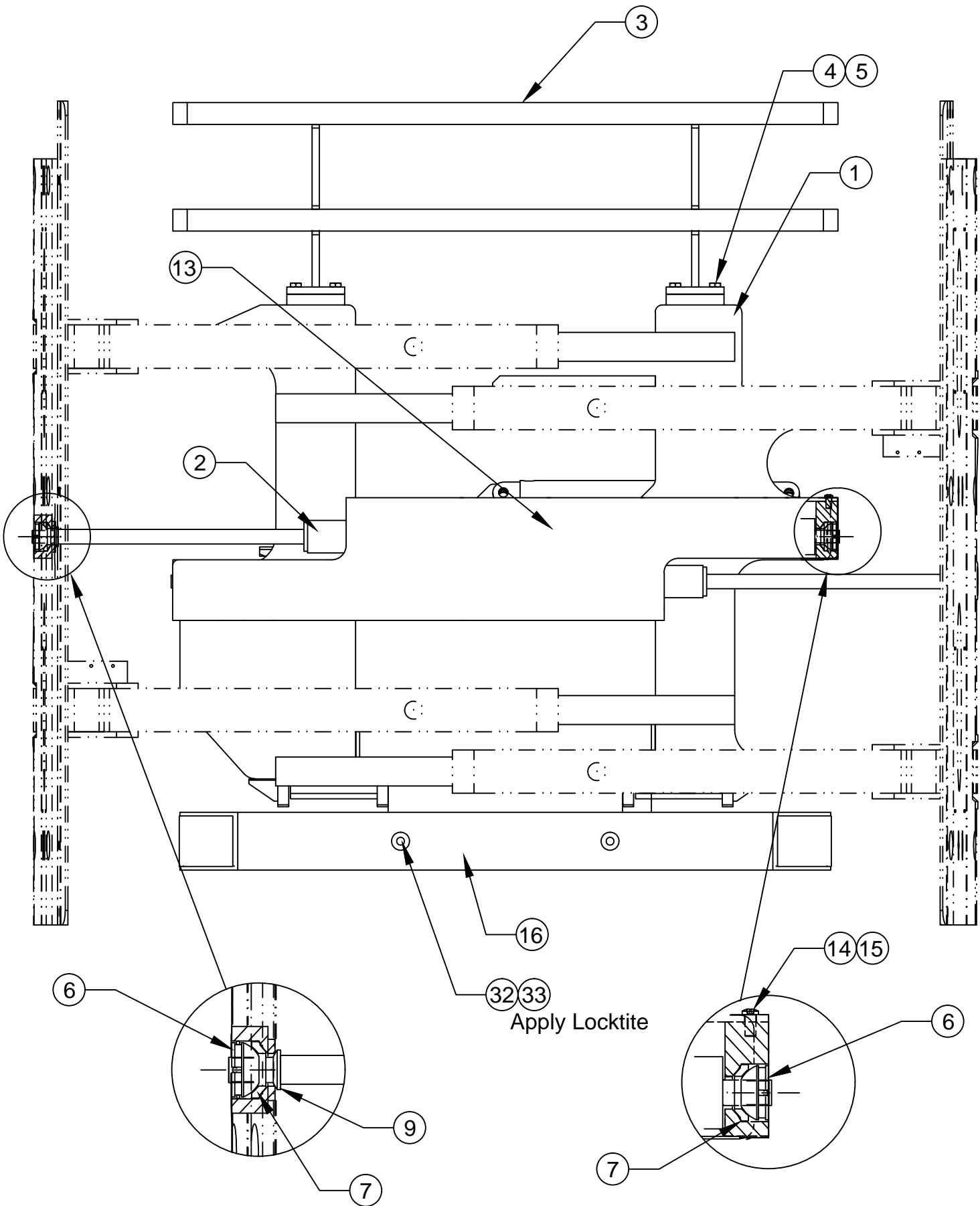
# CLAMP ASSEMBLY-1

Drawing reference 113400.1

#	QTY	PART #	DESCRIPTION
1	1	111610	Frame Weldment
2	2	111372.3	Cylinder Assembly
3	1	111652.1	Load Backrest
4	8	1C.0820	Bolt
5	8	4E.08	Lock Washer
6	4	110731	Spherical Bearing
7	4	110730	Spherical Seat
8	4	100574.86	Cotter Pin
9	2	111380	Cylinder Rod Washer
10	2	107870	Lower Retainer
11	2	11G.08136	Bolt
12	2	17D.08	Nut Nylock
13	1	111059	Cylinder Guard
14	4	25GN.0612	Bolt
15	4	109528	Nord-Lock Washer
16	1	111662	Lower Bumper
17	1	100106	Cylinder Assembly
18	1	111589	Hook Weldment
19	6	11G.1036	Bolt
20	6	16E.10	Lock Washer
21	2	108421	Slide II
22	1	111968	Cylinder Anchor Weldment
23	1	111357.2	Lower Slide
24	1	111594.1	Shim
25	1	9G.0816	Bolt
26	1	100095.05	Fitting
27	1	100222.1	Restrictor Fitting
28	2	100075.14	Grease Fittings
29	1	108272	Brass Set Screw
30	1	7D.06	Jam Nut
31	2	11G.0808	Bolt
32	4	16E.08	Lock Washer
33	2	11G.0820	Bolt

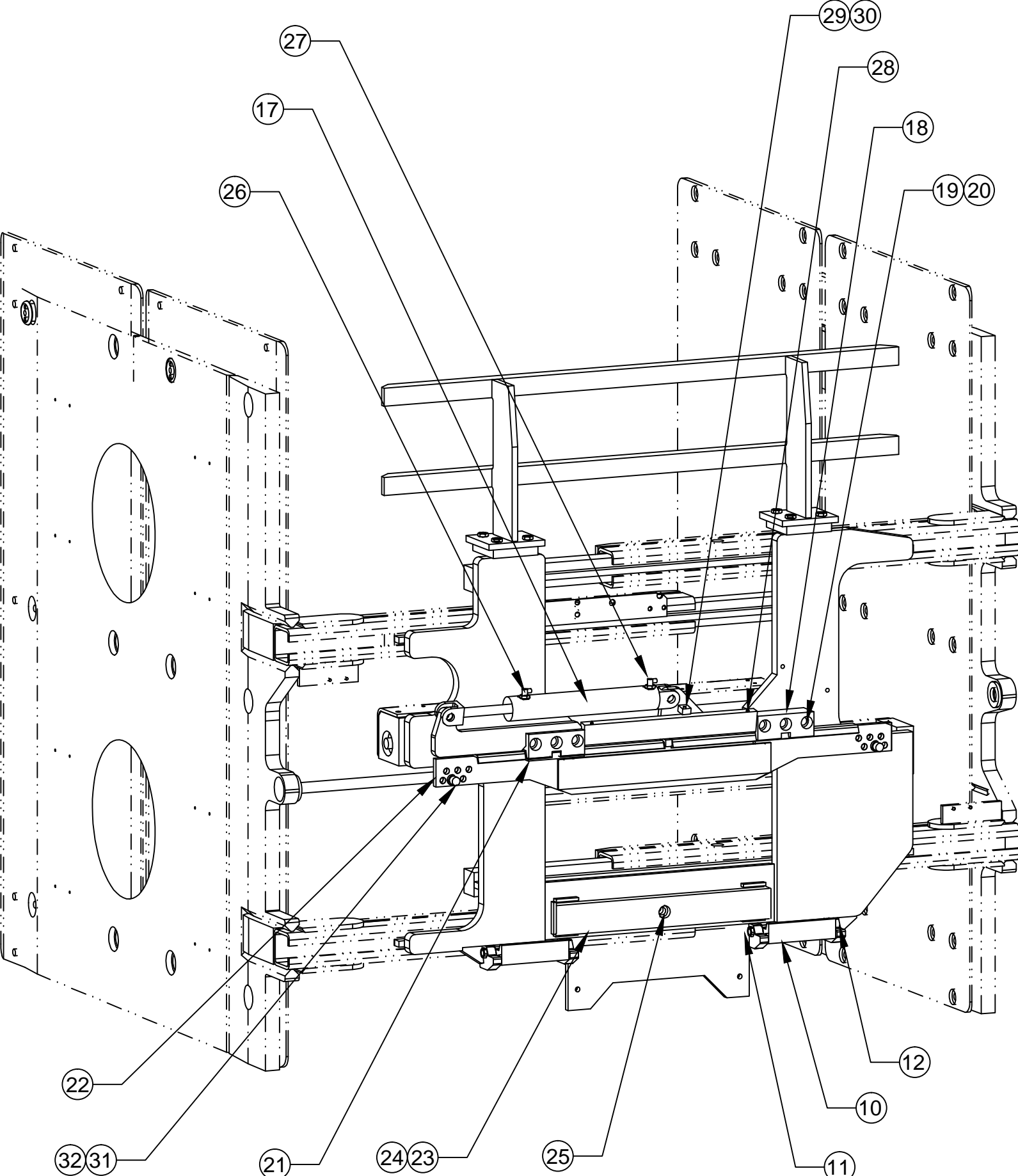
# CLAMP ASSEMBLY-2

Drawing reference 113400.1



# CLAMP ASSEMBLY-3

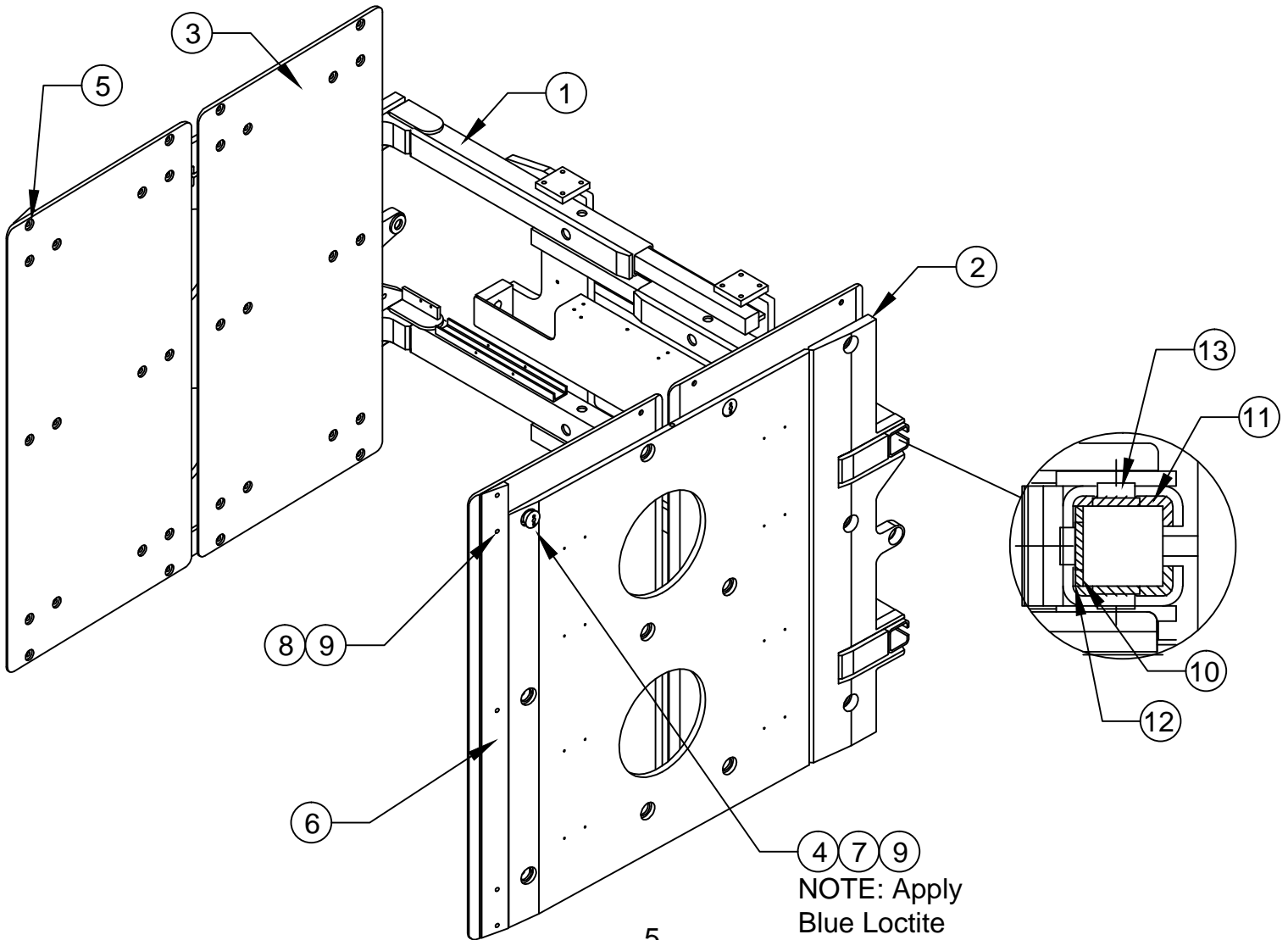
Drawing reference 113400.1



# ARM GROUP ASSEMBLY

Drawing reference 111582.1

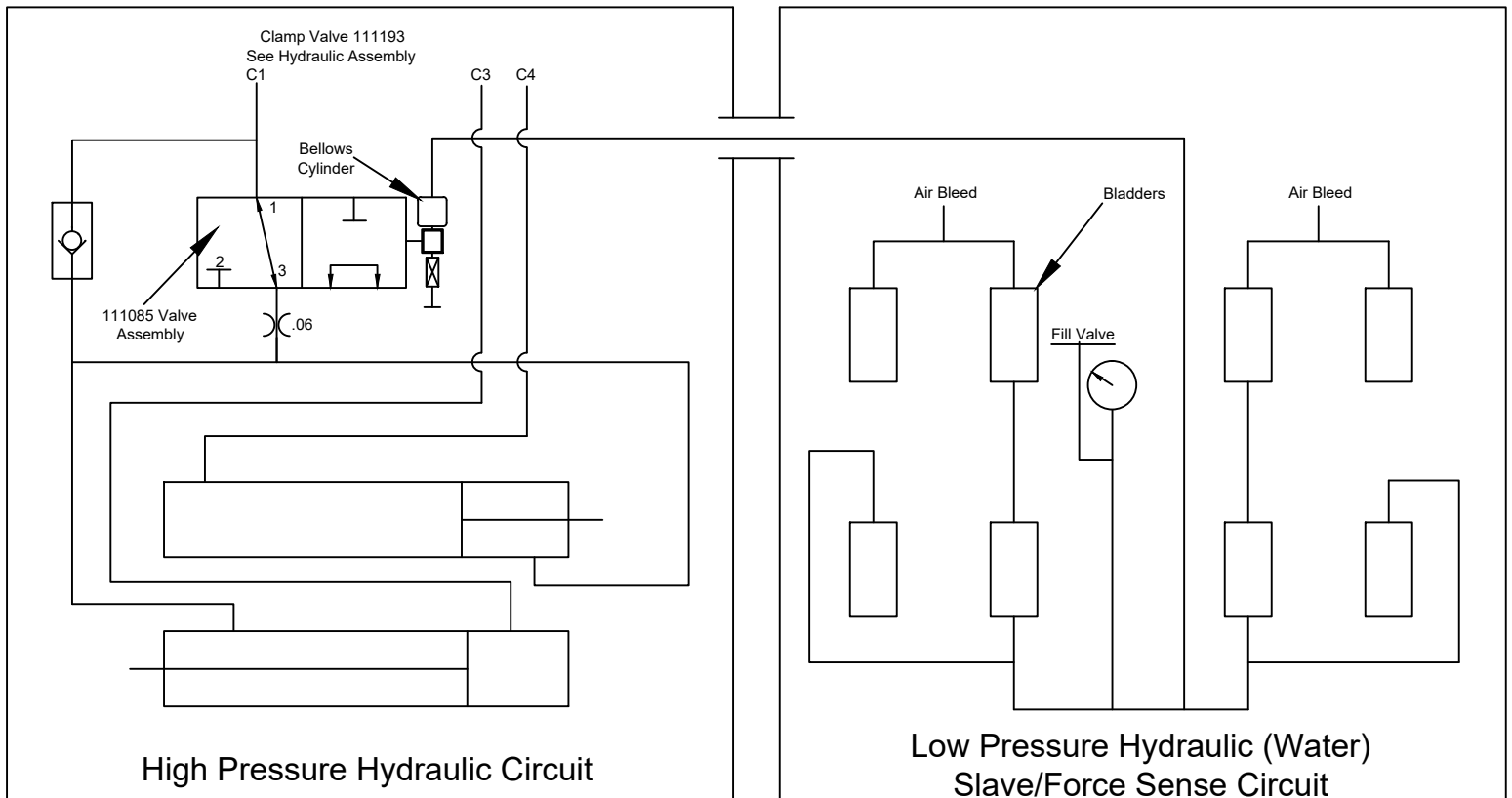
#	QTY	PART #	DESCRIPTION
1	1	111617	Right Hand Arm Weldment
2	1	111618	Left Hand Arm Weldment
3	4	111608	Contact Pad
4	24	111031	Retaining Nut
5	1	111609	Right Hand Tip Plate
6	1	111609	Left Hand Tip Plate
7	24	1C.0820	Bolt
8	10	1C.0812	Bolt
9	34	108088	Spring Washer
10	4	111622.1	Flat Slide
11	8	111621.1	Angle Slide
12	12	109212.4	Shim
13	12	111619	Slide Button



# FLOATING PAD ASSEMBLY-1

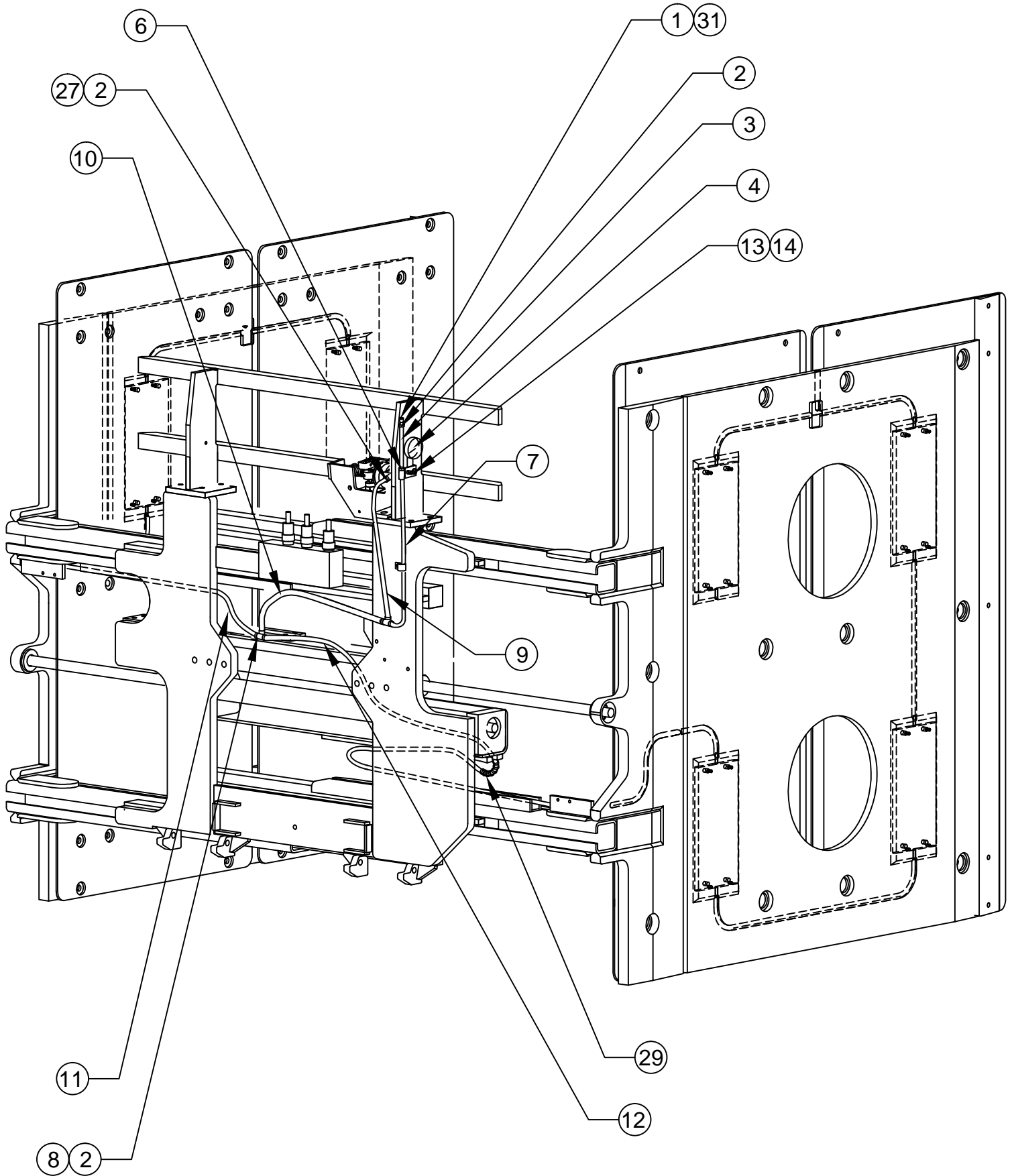
Drawing reference 113402.1

#	QTY	PART #	DESCRIPTION	19	8	111030	Bladder
1	3	111350	Air Tank Valve	20	32	9G.0412	Bolt
2	18	111295	Hose Clamp	21	16	111471	Clamp Bar
3	1	111290.0025	Hose	22	8	109256	Hose Clamp
4	1	111296	Pressure Gauge	23	8	25GN.0508	Bolt
5	1	111543.01	90° Elbow Fitting	24	2	113026.0360	Cover Hose
6	1	111292	Branch Tee	25	4	111128	Hose Guide
7	1	111290.0178	Hose	26	12	1C.0512	Bolt
8	4	111293	Run Tee	27	1	111289	Pipe Elbow
9	1	111290.0155	Hose	28	2	111654	Plug
10	1	111290.0110	Hose	29	2	111510	Spring
11	1	111290.0895	Hose	30	VARIABLES	111878	19 Gauge Stainless Wire Tie
12	1	111290.0925	Hose	31	3	111653	Valve Cap
13	1	111299	Hose Clip	32	1	111085	Direction Valve Assembly
14	1	25G.0520	Bolt	33	1	113018	Cable Tab
15	2	111290.0027	Hose	34	2	113416	Hose Channel
16	4	111290.0164	Hose	35	8	3G.0808	Bolt
17	2	111290.0134	Hose				
18	2	111290.0360	Hose				



# FLOATING PAD ASSEMBLY-2

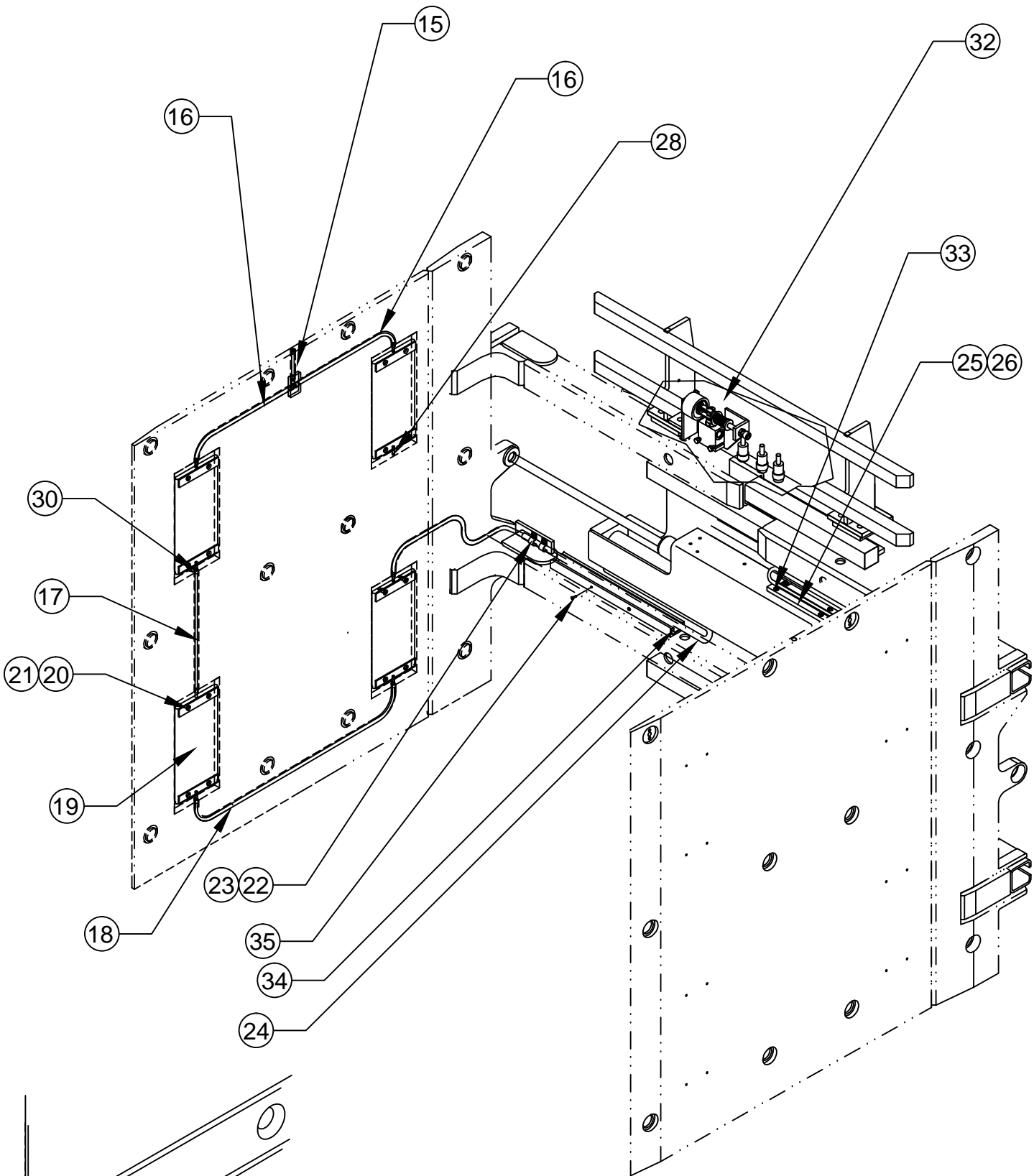
Drawing reference 113402.1





# FLOATING PAD ASSEMBLY-3

Drawing reference 113402.1

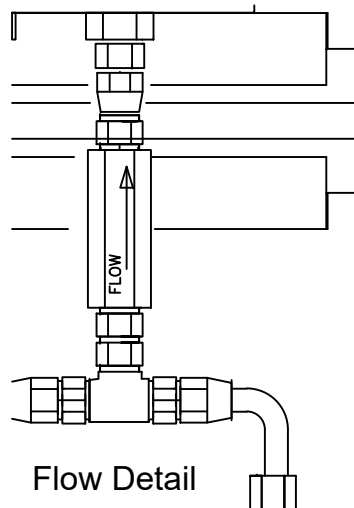
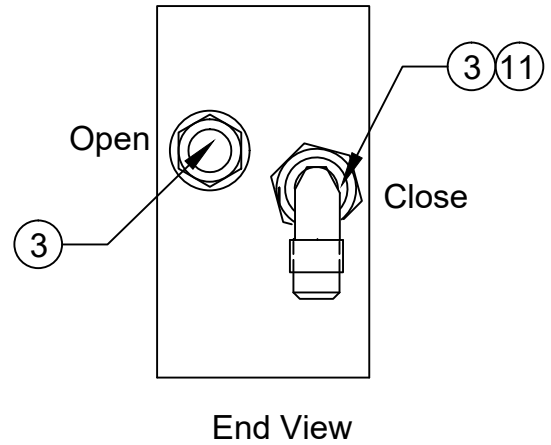


Note: Use two 19 gauge stainless steel wire ties (111878) at each bladder connection twist to tighten and clip to reduce ends.

# HYDRAULIC ASSEMBLY-1

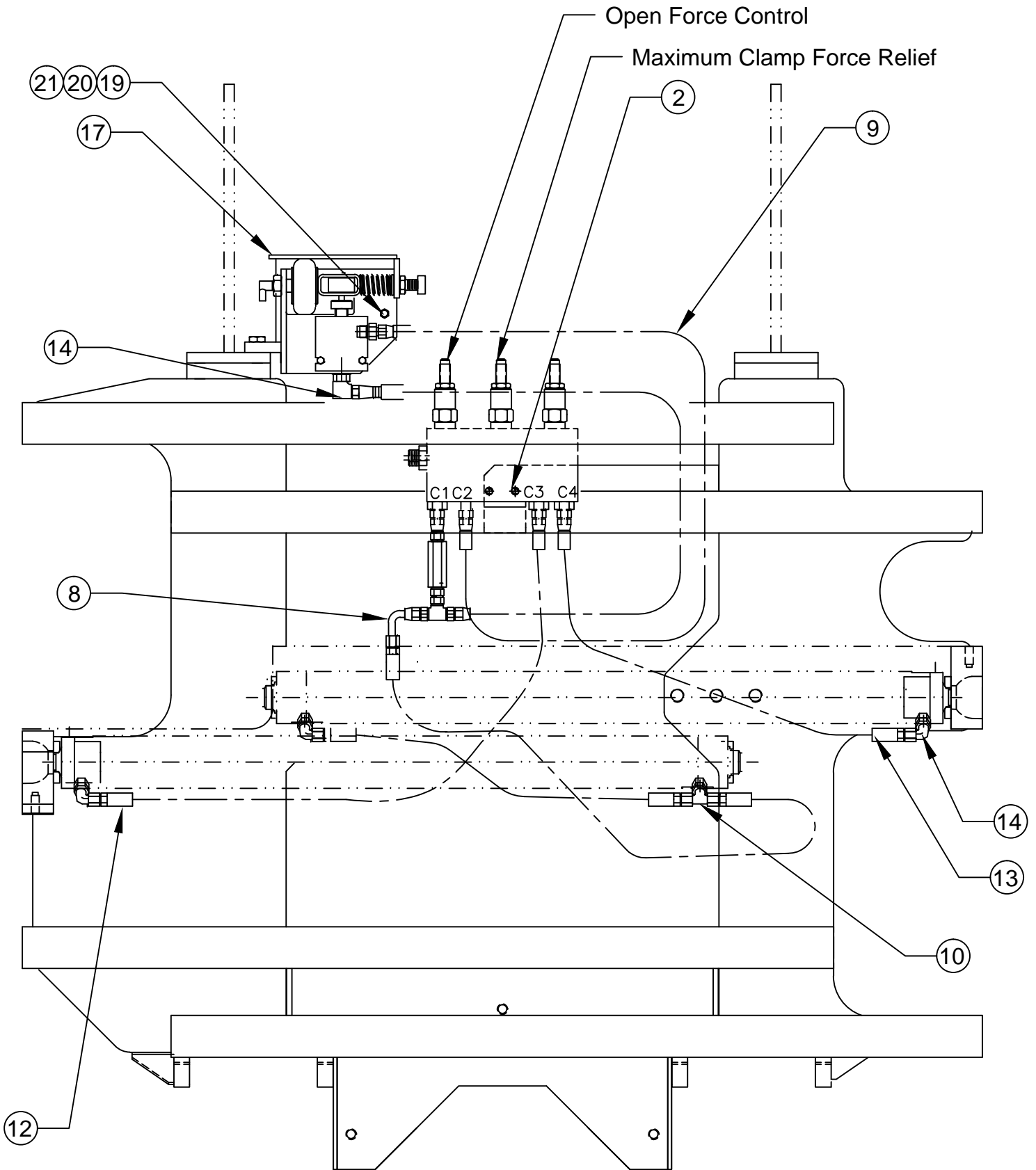
Drawing reference 113401

#	QTY	PART #	DESCRIPTION
1	1	111591	Clamp Valve
2	2	25G.0524	Bolt
3	4	100676.05	Straight Thread Adapter
4	2	111518.06	Fitting Adapter
5	1	111085	Directional Valve Assembly
6	1	100227.05	Union Tee Fitting
7	1	111123	In-Line Check Valve
8	1	103411.0345	Hose
9	1	100674.0395	Hose
10	1	100678.05	O-Ring Tee Branch Fitting
11	1	100440.05	90° Swivel Fitting
12	1	100674.0320	Hose Assembly
13	1	100674.0250	Hose Assembly
14	4	100095.05	90° Elbow Fitting
15	1	100674.0332	Hose Assembly
16	1	100674.0205	Hose Assembly
17	1	111514	Valve Guard
18	1	109626.1	O-Ring Straight Restrictor Fitting
19	1	25G.0616	Bolt
20	1	4F.05	Washer
21	1	17D.06	Nylock Nut



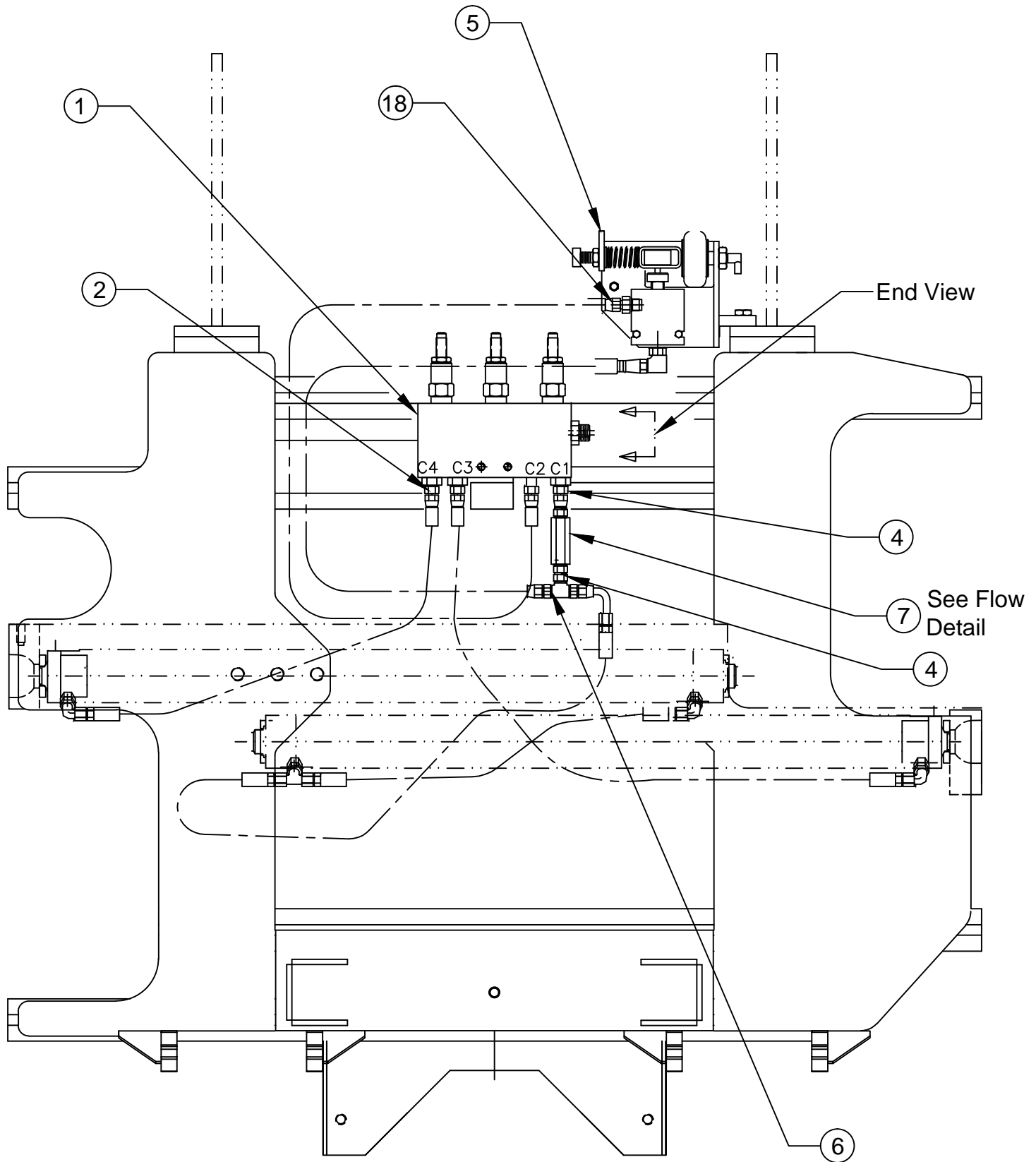
# HYDRAULIC ASSEMBLY-2

Drawing reference 113401



# HYDRAULIC ASSEMBLY-3

Drawing reference 113401

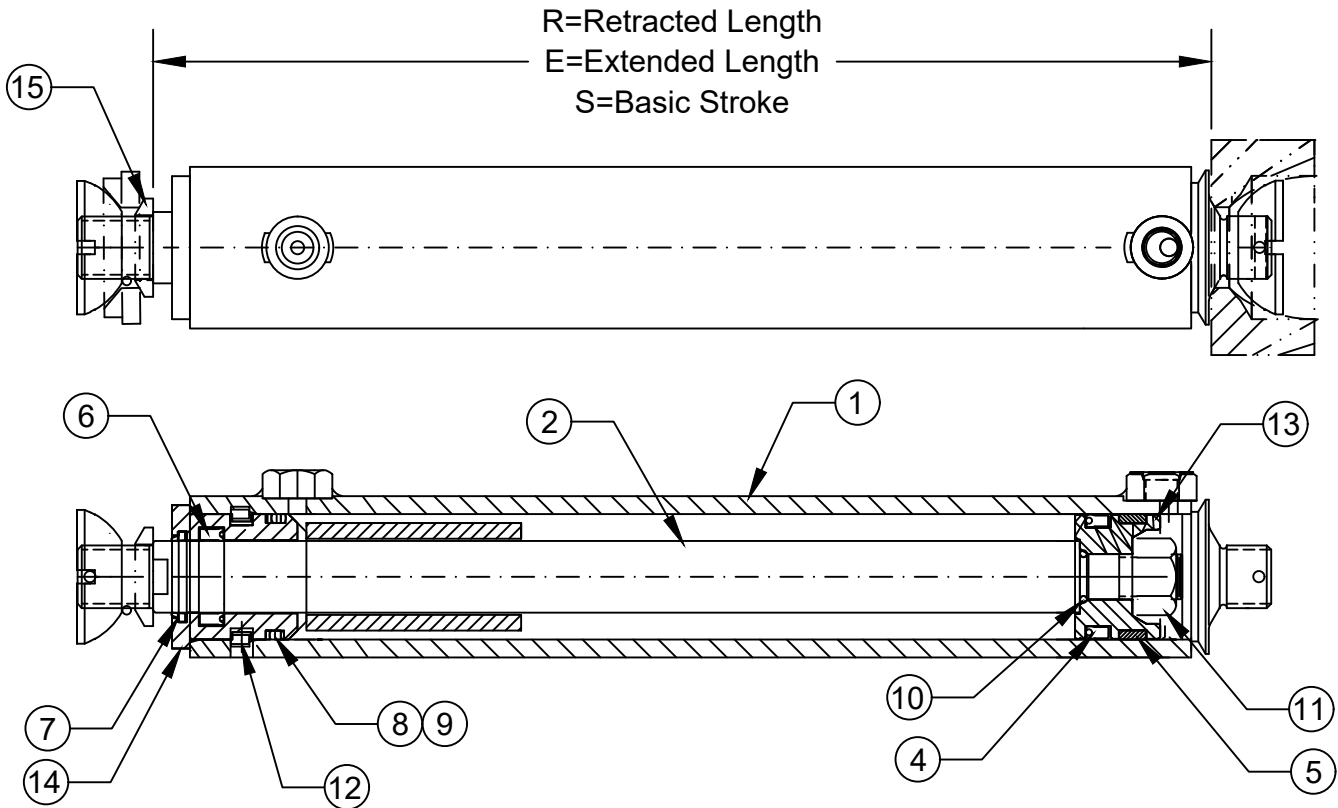


# CYLINDER ASSEMBLY

Drawing reference 111372.3

Part #	R	E	S	NET STROKE
111372.3	34.00	64.00	30.00	30.00

#	QTY	PART #	DESCRIPTION	8	1	100029.2	O-Ring
1	1	111375.3	Tube Weldment	9	1	100028.2	Back-Up Ring
2	1	111379.3	Rod	10	1	100029.201	O-Ring
3	1	111482	Seal Kit (Items 4-10)	11	1	27D.10	Nut Self Locking
4	1	100032.6	Poly-Pak "B"	12	1	100027.7	Lock Wire
5	1	102099.1	Wear Ring	13	1	111374	Piston
6	1	112905	Rod Seal	14	1	111373	Gland
7	1	102098.5	Rod Wiper	15	1	111380	Washer Cylinder



## Cylinder Service

- Prior to assembly lubricate seals, cylinder bore and rod with STP.
- Inspect all parts for scratches, nicks and gouges - replace all damaged components.
- Inspect cylinder bore and rod for scoring - replaced if scored.
- Avoid damage to seal grooves - use a dull screwdriver for seal removal.
- Torque piston nut to 110 FT/LBS. (15.3kg-m).

# CLAMP ADJUSTMENTS

## CLAMP FORCE CHECK/ADJUSTMENT

1. Check water pressure. If out of operating range fill with LORON hand pump # 112909. NOTE: Use pure Propylene Glycol Antifreeze mixed 1 to 1 with water.
2. Check the clamp force.

## CLAMP CONTROL VALVE ADJUSTMENT

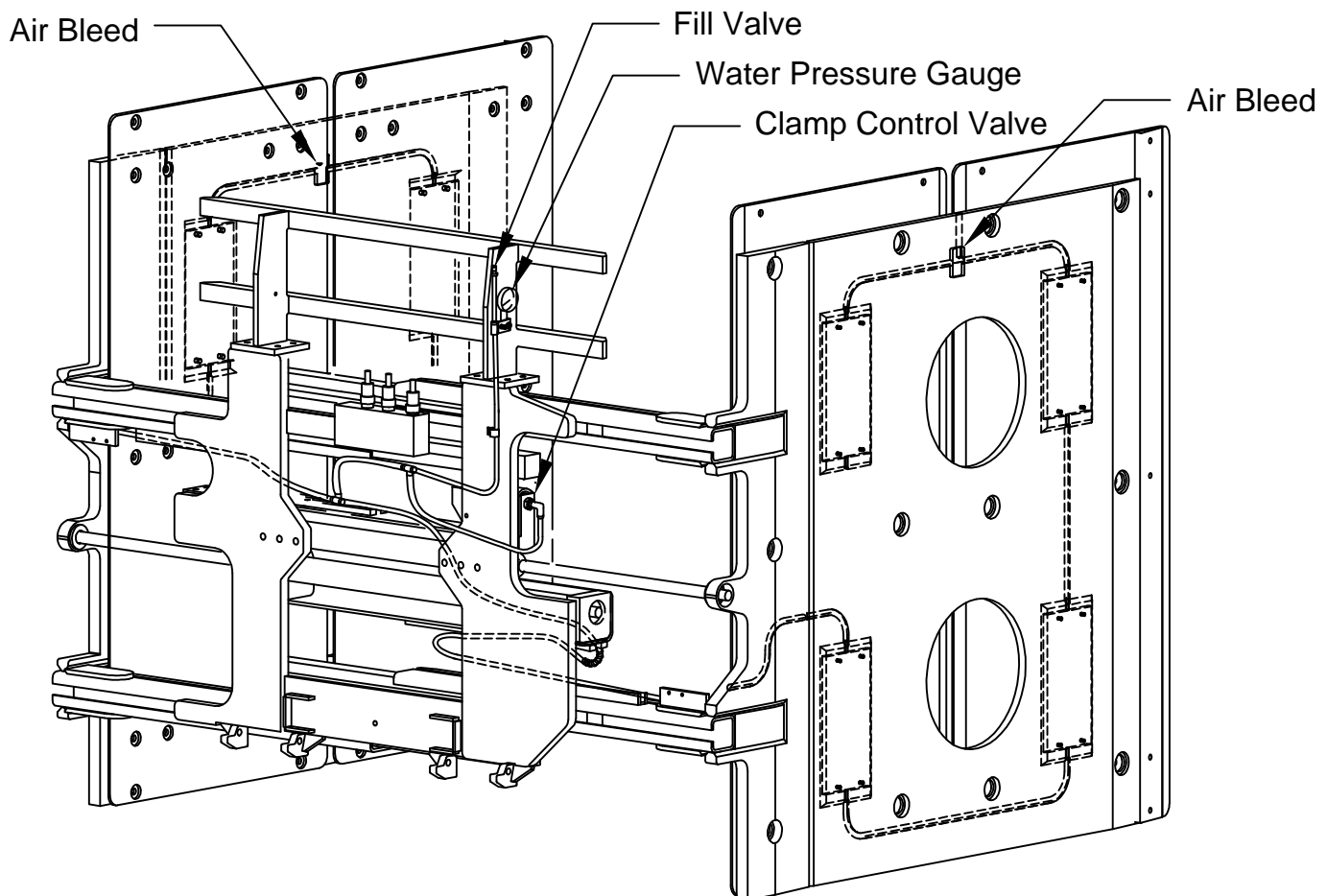
NOTE: When looking at the clamp control valve from the front of the clamp, the clevis pin should be directly in front of the shut off valve stem, or slightly to the left, when the clamp will not close. To check the pin position, turn the force control screw in until the clamp just starts to move, at which point the clevis pin should be directly in front of the valve stem.

## OPEN FORCE CHECK/ADJUSTMENT

Open the arms against a force fixture and adjust for desired maximum force.

## SIDE SHIFT FORCE ADJUSTMENT

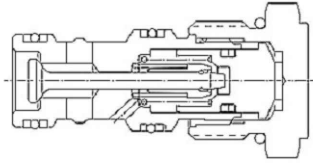
1. Clamp on the heaviest load that will be handled.
2. Adjust the side shift force down until the arms stop.
3. Turn the adjusting screw one turn in.



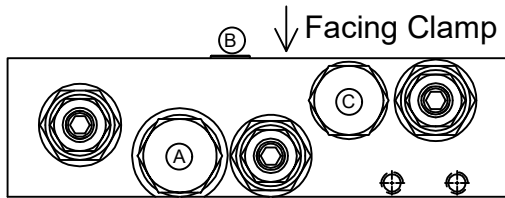
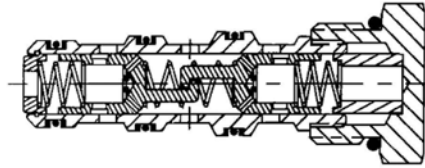
# CONTROL VALVE

Drawing reference 111591

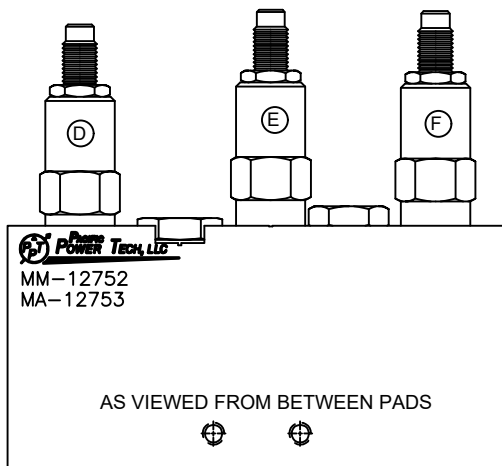
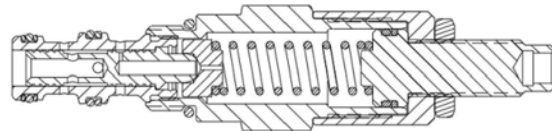
(A) **111244** Check Valve  
Torque 30-35 ft-lb  
Seal Kit 112059



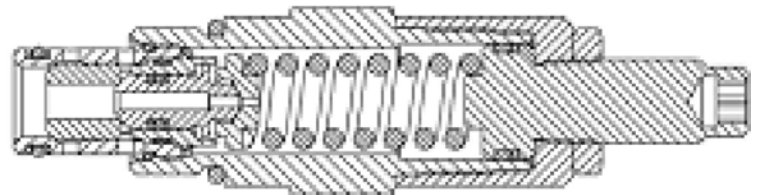
(C) **112887** Flow Divider  
Torque 10-12 ft-lb  
Seal Kit 104711



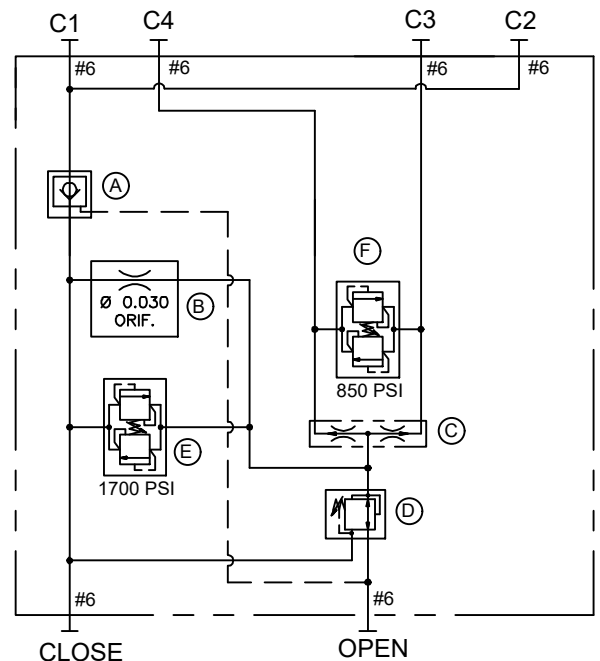
(D) **111627** Pressure Reduce/Relief Valve  
Torque 15-20 ft-lb  
Seal Kit 112065



(E) **112406.1** & (F) **112406.2** Bi-Direction Relief Valve  
Torque 20-25 ft-lb  
Seal Kit 112064



## HYDRAULIC SCHEMATIC



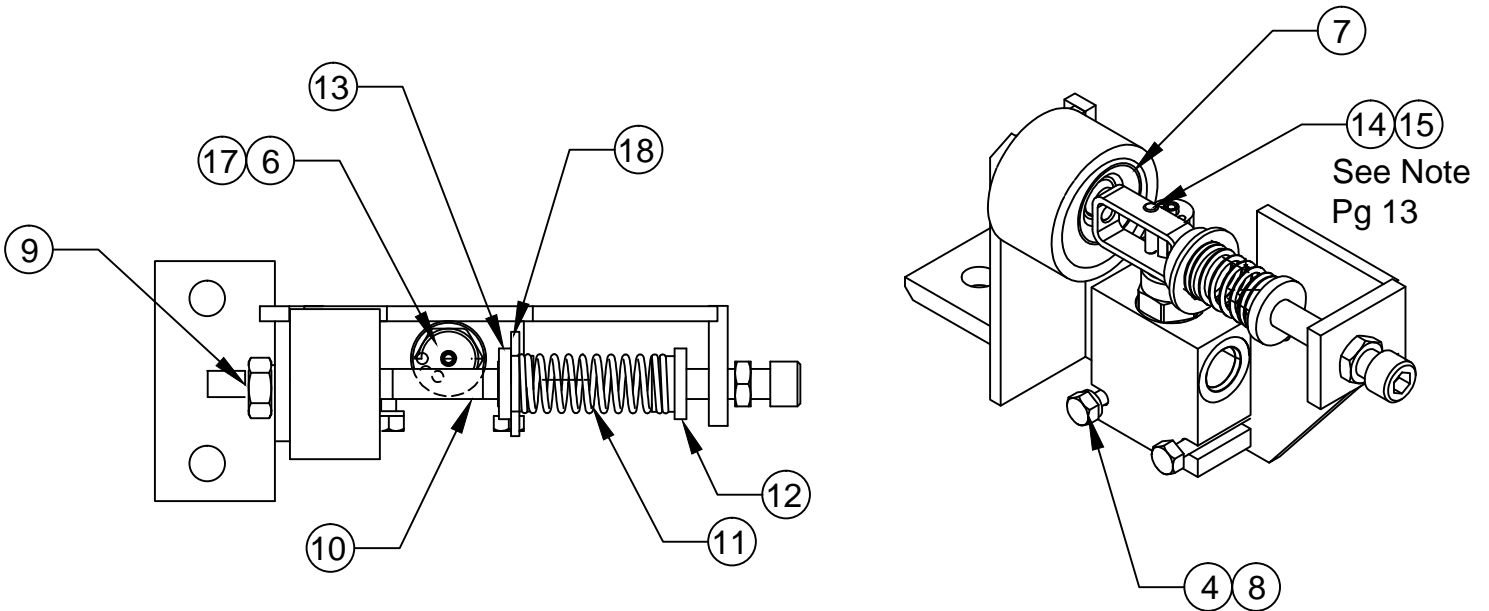
**NOTE:** Lubricate threads & seals prior to assembly.

ID	QTY	PART #	DESCRIPTION
A	1	111244	Check Valve
B	1	00.030 ORIFICE	Orifice
C	1	112887	Flow Divider
D	1	111627	Pressure Reducer Valve
E	1	112406.1	Bi-Direction Relief Valve
F	1	112406.2	Bi-Direction Relief Valve

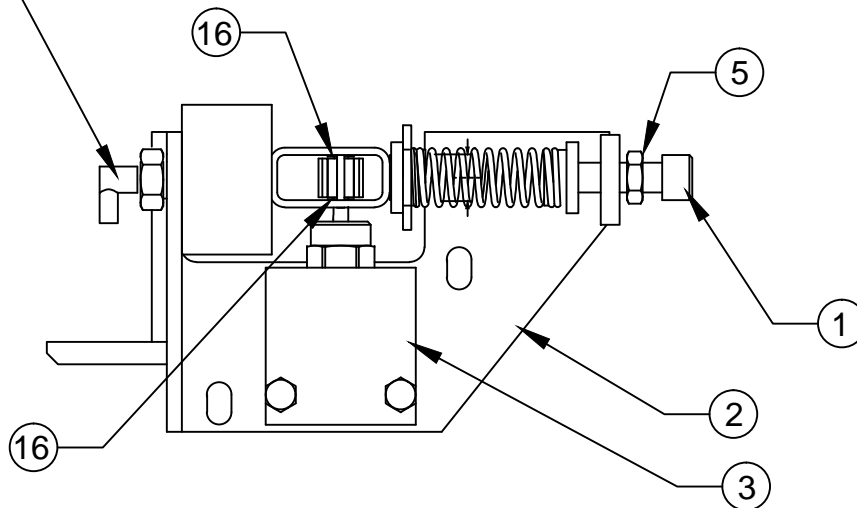
# CLAMP FORCE CONTROL VALVE

Drawing reference 111085

#	QTY	PART #	DESCRIPTION
1	1	11G.0844	Bolt
2	1	111573	Mounting Plate Weldment
3	1	111094	Directional Valve
4	2	4E.04	Lock Washer
5	1	7D.08	Jam Nut
6	1	110906	Wheel
7	1	111091	Air Spring
8	2	1C.0424	Bolt
9	1	7D.10	Hex Nut
10	1	111328	Wheel Housing
11	1	111097	Spring
12	1	111098	Spring Tension Cap
13	1	111572	Spring Cap
14	1	111655	Clevis Pin
15	1	100574.28	Cotter Pin
16	1	113234	Nylon Washer
17	1	15G.0408	Set Screw
18	1	113233	Washer
19	1	113235	Nylon Washer



Reference 111289 see floating pads assembly





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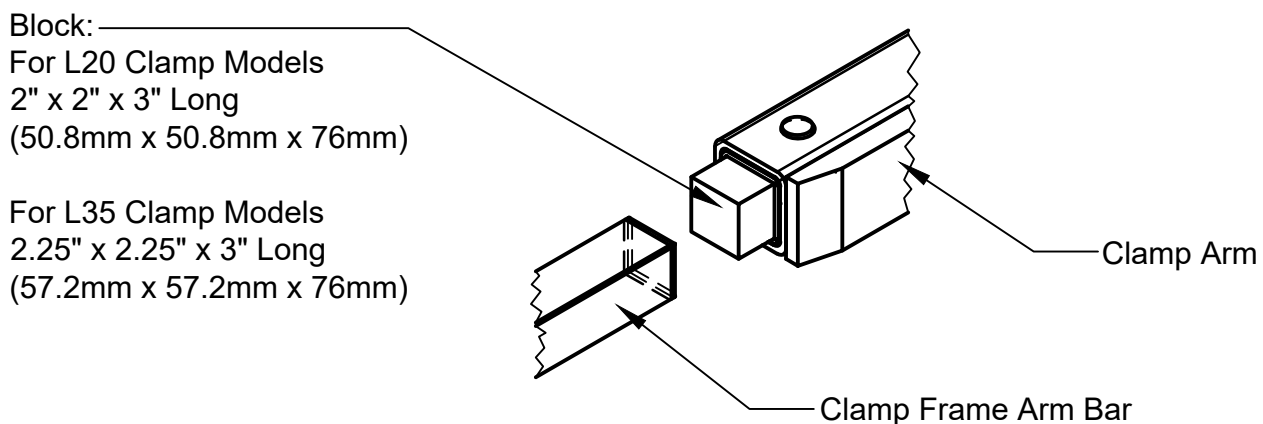
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# ARM SLIDE & SHIM REPLACEMENT

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1. To replace the slides, the arms need to be in the fully open position. Release system pressure prior to removing the arms by turning the truck off and working the side shift and clamp function controls several times.
2. Support the arm with an overhead crane or lift truck. Be sure to secure the chain or sling in a manner that prevents the arm from falling out of the chain or sling when hanging free of the clamp.
3. Remove the cotter pin, slotted nut and spherical bearing from the end of the clamp cylinder rod. Keeping hands and feet clear, and carefully slide the clamp arm off of the clamp frame.
4. Inspect slides and slide buttons for wear. Slides may be rotated end-to-end and reused if excessively worn on the outer end only. Extra shims may be used to tighten operating clearance on slightly worn slides. Replace any slides worn to less than 0.15" (3.8mm) thick or any slide that is deeply scored or broken.



5. To aid in replacing the slides a block may be fashioned of wood or another convenient material to the dimensions shown above. The block is inserted to the end of the arm to hold the slides, shims, and buttons in position while the arm is inserted over the arm bars on the clamp frame. The block is expelled out the opposite end of the arm as the arm is pushed onto the frame. Prior to installing the arm the block may be used to determine the number of shims to place under the slides. Adjust the clearance between the slides and the block to provide approximately .06" (1.5mm) running clearance between the slides and arm when installed.
6. Keeping hands and feet clear, carefully slide the clamp arm onto the clamp frame. Be sure the arm moves freely without excessive binding. If the arm is too loose or too tight add or remove shims as required.
7. Install the spherical bearing, slotted nut and cotter pin onto the end of the clamp cylinder rod. Be sure to leave .03"-.06" (.7mm to 1.5mm) clearance to allow the cylinder to "float" on its mountings.

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# TROUBLE SHOOTING GUIDE

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## LOADS SLIPPING OR DROPPING

### POSSIBLE CAUSES

1. Clamp force set too low.
2. Internal leakage in cylinder.
3. Load too heavy for the clamp capacity.
4. Load may not be stacked correctly or may need to be unitized.
5. Bent arms or contact pads.
6. Damaged / leaking hydraulic hose

### SOLUTION

1. Adjust clamp force.
2. Replace cylinder seals. If tube, pistons or rod is scored replace with new parts.
3. Consult factory.
4. Restack or unitize load (shrink wrap).
5. Consult factory.
6. Replace damaged hose.

## CRUSHING LOADS

### POSSIBLE CAUSES

1. Clamp force set too high.
2. Bent arms or contact pads.
3. Leak in the bladder system.

### SOLUTION

1. Adjust clamp force.
2. Consult factory.
3. Check for leaks and repair.

## ARM CHATTERING OR ERRATIC MOVEMENT

### POSSIBLE CAUSES

1. Bent clamp arms.
2. Nylon slides sticking.  
Note: Sticking slides can cause inconsistent force measurements.
3. Nylon slides worn, broken or missing.

### SOLUTION

1. Consult factory.
2. Clean slides if necessary, the slides are self lubricating.
3. Replace damaged slides, shims, and retaining buttons.