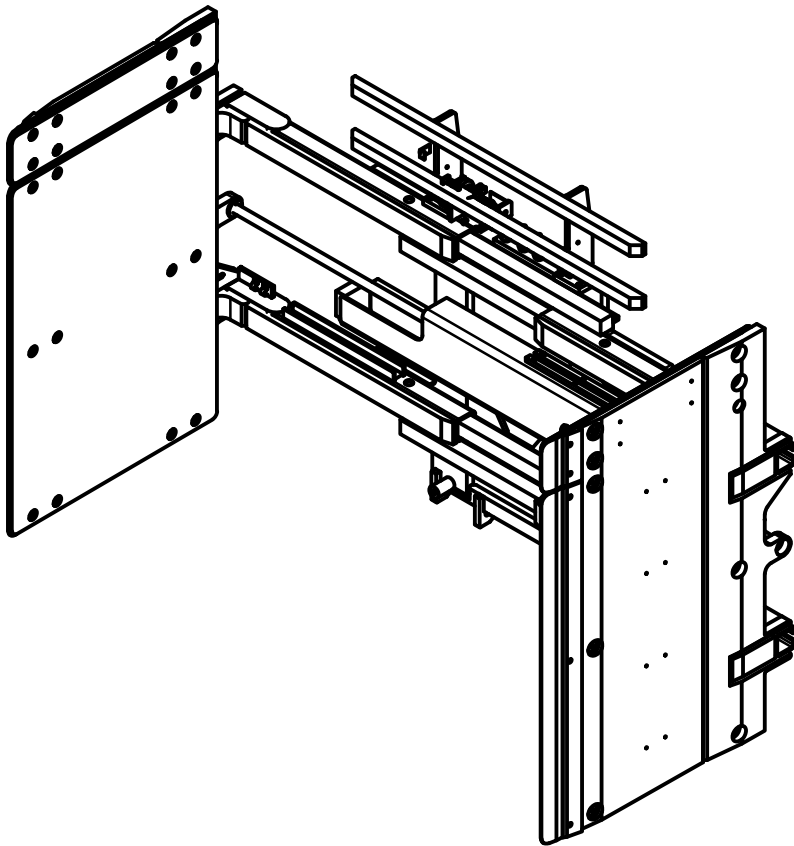




SERVICE MANUAL / PARTS LIST

APPLIANCE CLAMP SOFT TOUCH

MODEL #113319
PATENT NO. 9,630,821
PATENT NO. 10,597,272



Specifications:

Mounting: Class II
Side Shifting: External Side Shifting
Capacity: 1750 lbs at 18"
Pad Size: 55" High x 34" Long
Range: 21.5" - 83.3"
Frame: 48" Wide

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1	Lift Truck Requirements General Installation Procedures General Inspection & Maintenance
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6	Arm Group Assembly
7-9	Floating Pad Assembly
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13	Cylinder Assembly
14	Clamp Adjustments
15	Control Valve
16	Clamp Force Control Valve
17	Arm Slide & Shim Replacement
18	Trouble Shooting Guide

LIFT TRUCK REQUIREMENTS

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:

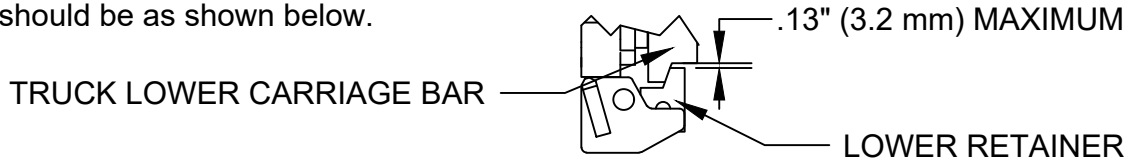
Side Shift = 3 GPM

Clamp Open/Close = 7 GPM

NOTE: Three Position Force Selector must be disabled.

GENERAL INSTALLATION PROCEDURES

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.

GENERAL INSPECTION AND MAINTENANCE

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.

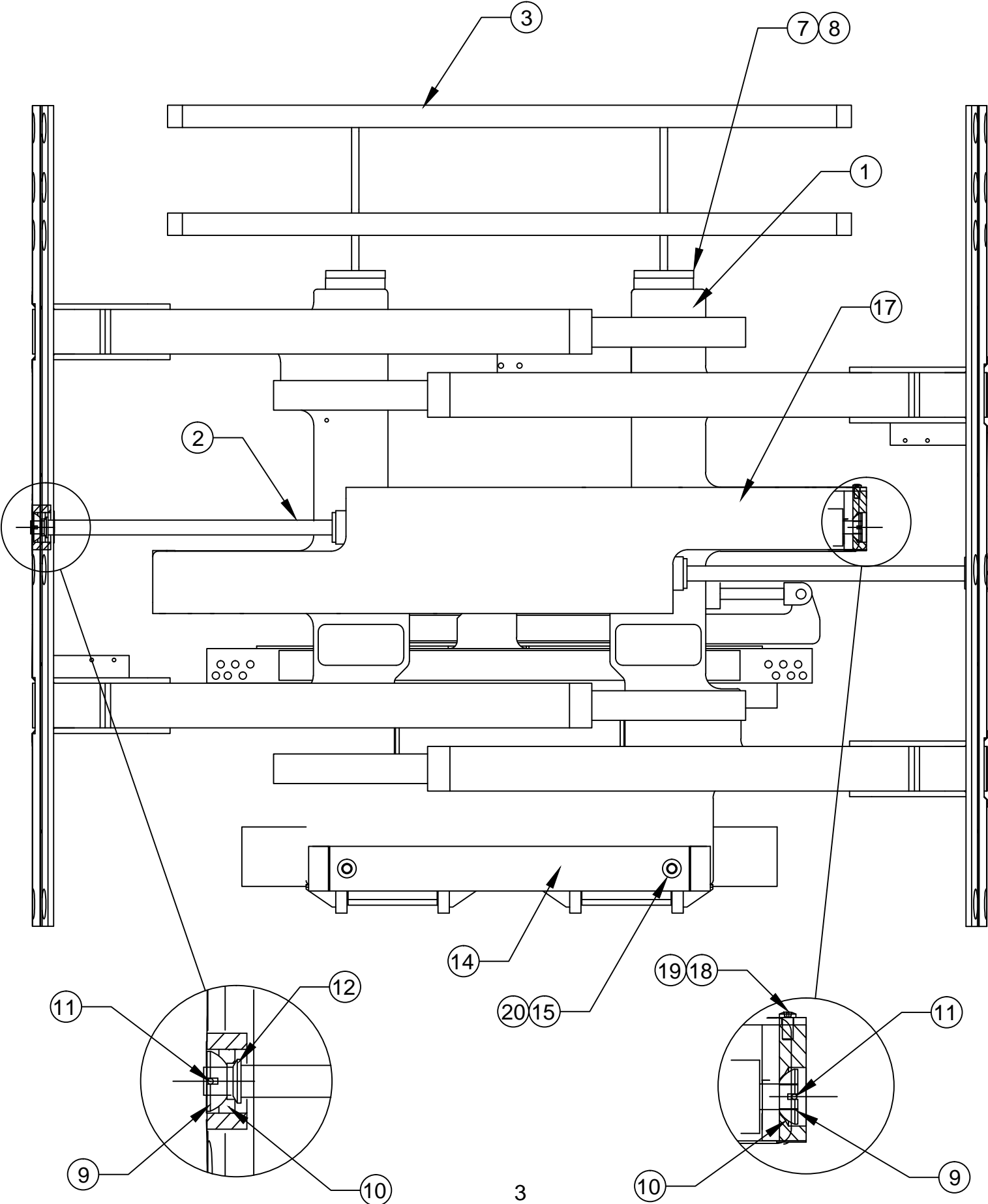
CLAMP ASSEMBLY-1

Drawing reference 113261

#	QTY	PART #	DESCRIPTION	20	2	4E.10	Lock Washer
1	1	113164	Frame Weldment	21	2	11G.08136	Bolt
2	2	111714.1	Cylinder Assembly	22	2	17D.08	Nut
3	1	111439.1	Load Backrest	23	1	100106	Cylinder Assembly
4	4	111622.1	Flat Slide	24	1	113028	Hook Weldment
5	8	111621.1	Angle Slide	25	6	11G.1040	Bolt
6	12	109212.4	Shim	26	6	16E.10	Lock Washer
7	8	1C.0820	Bolt	27	2	108421	Slide II
8	8	4E.08	Lock Washer	28	1	113029	Cylinder Anchor Weldment
9	4	111631	Spherical Bearing	29	1	113262	Lower Slide
10	4	100029.301	Rod Centering Seal	30	1	113150.1	Shim
11	4	100574.86	Cotter Pin	31	2	25GN.0612	Bolt
12	2	111380	Cylinder Rod Washer	32	1	100095.05	Fitting
13	2	107870	Lower Retainer	33	1	100222.1	Restrictor Fitting
14	1	111423	Lower Load Backrest	34	2	100075.14	Grease Fittings
15	2	11G.1028	Bolt	35	1	108272	Brass Set Screw
16	12	111619	Slide Button	36	1	7D.06	Jam Nut
17	1	111222	Cylinder Guard	37	2	11G.0808	Bolt
18	4	25GN.0612	Bolt	38	2	16E.08	Lock Washer
19	4	109528	Nord-Lock Washer				

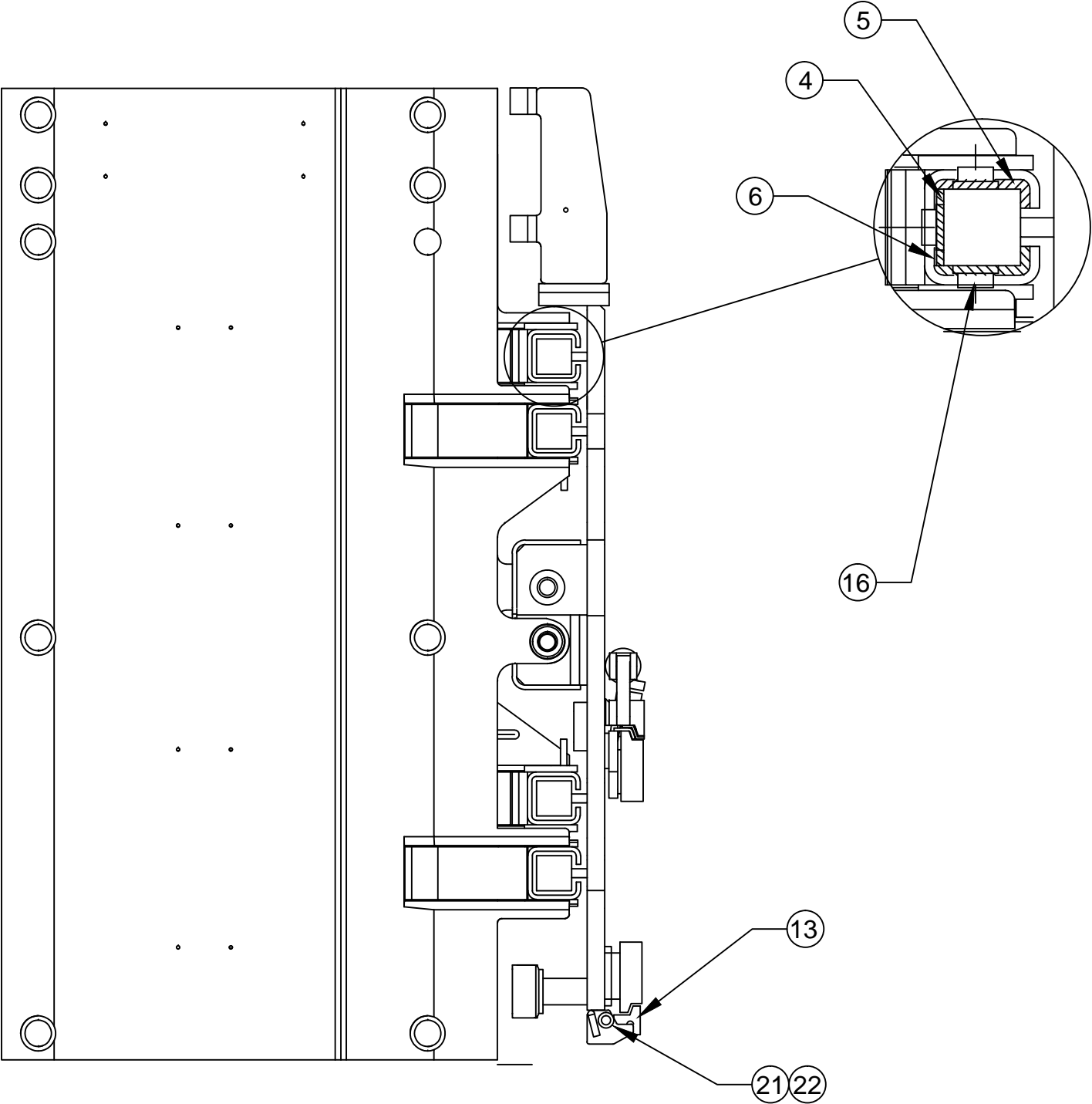
CLAMP ASSEMBLY-2

Drawing reference 113261



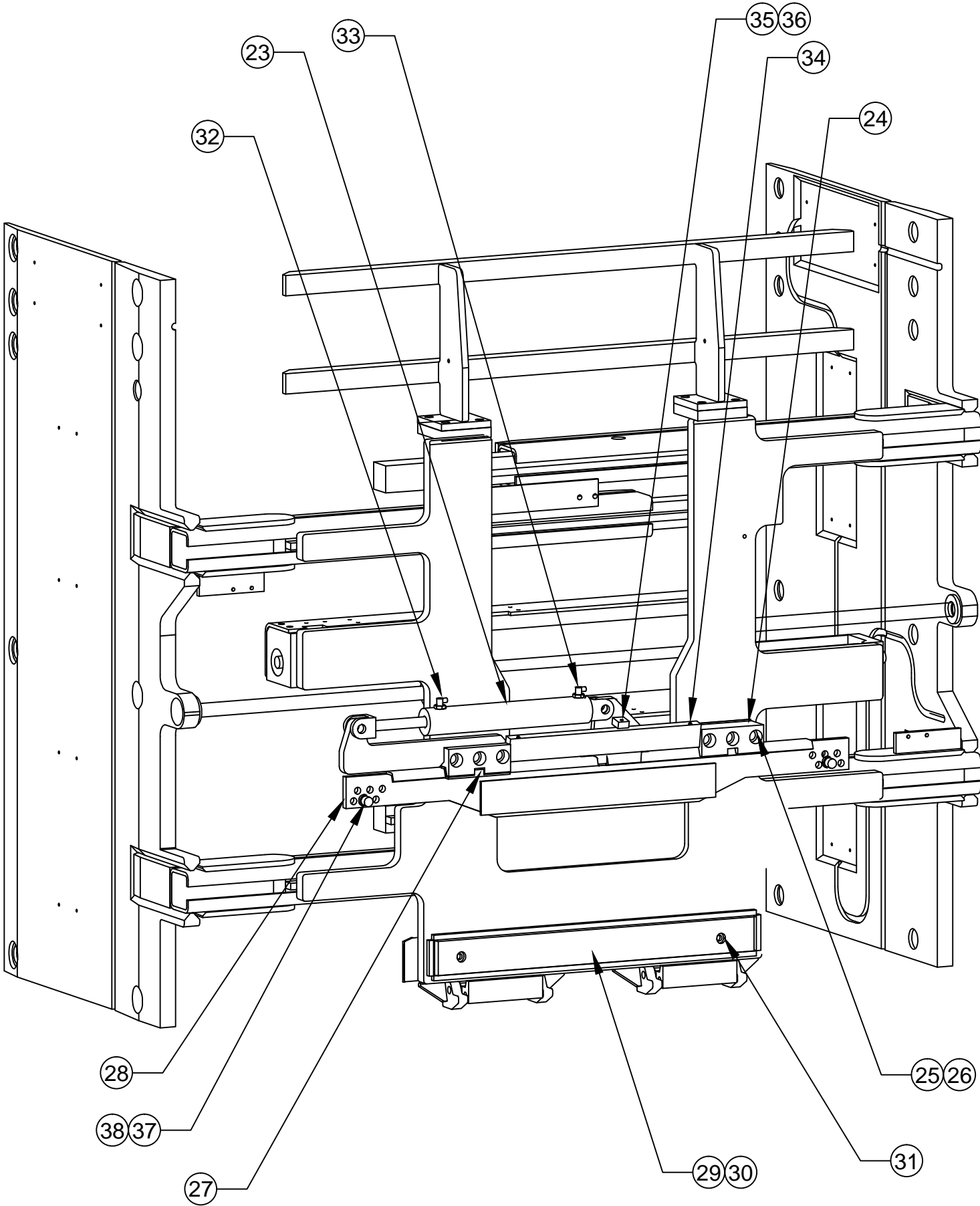
CLAMP ASSEMBLY-3

Drawing reference 113261



CLAMP ASSEMBLY-4

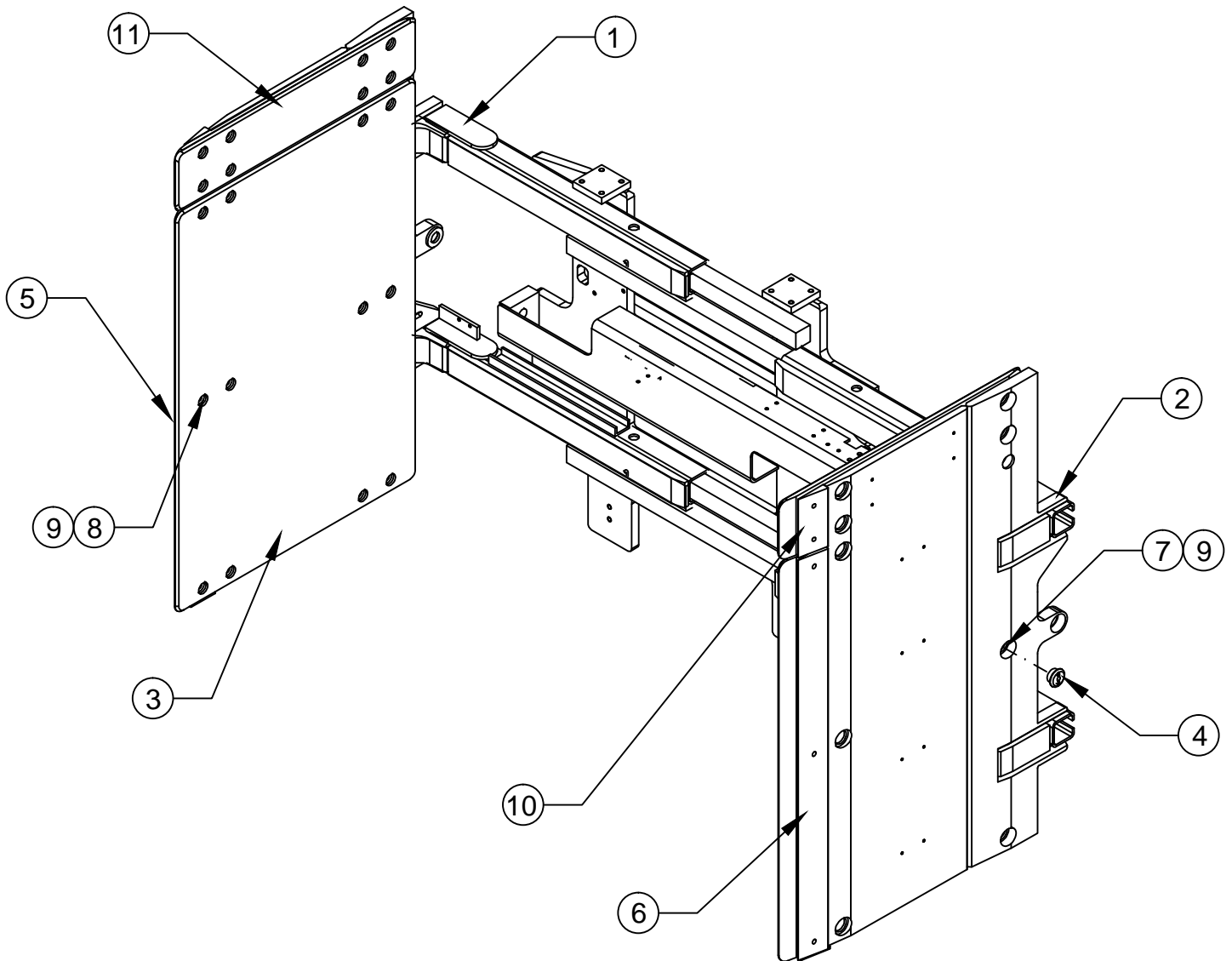
Drawing reference 113261



ARM GROUP ASSEMBLY

Drawing reference 111164.2

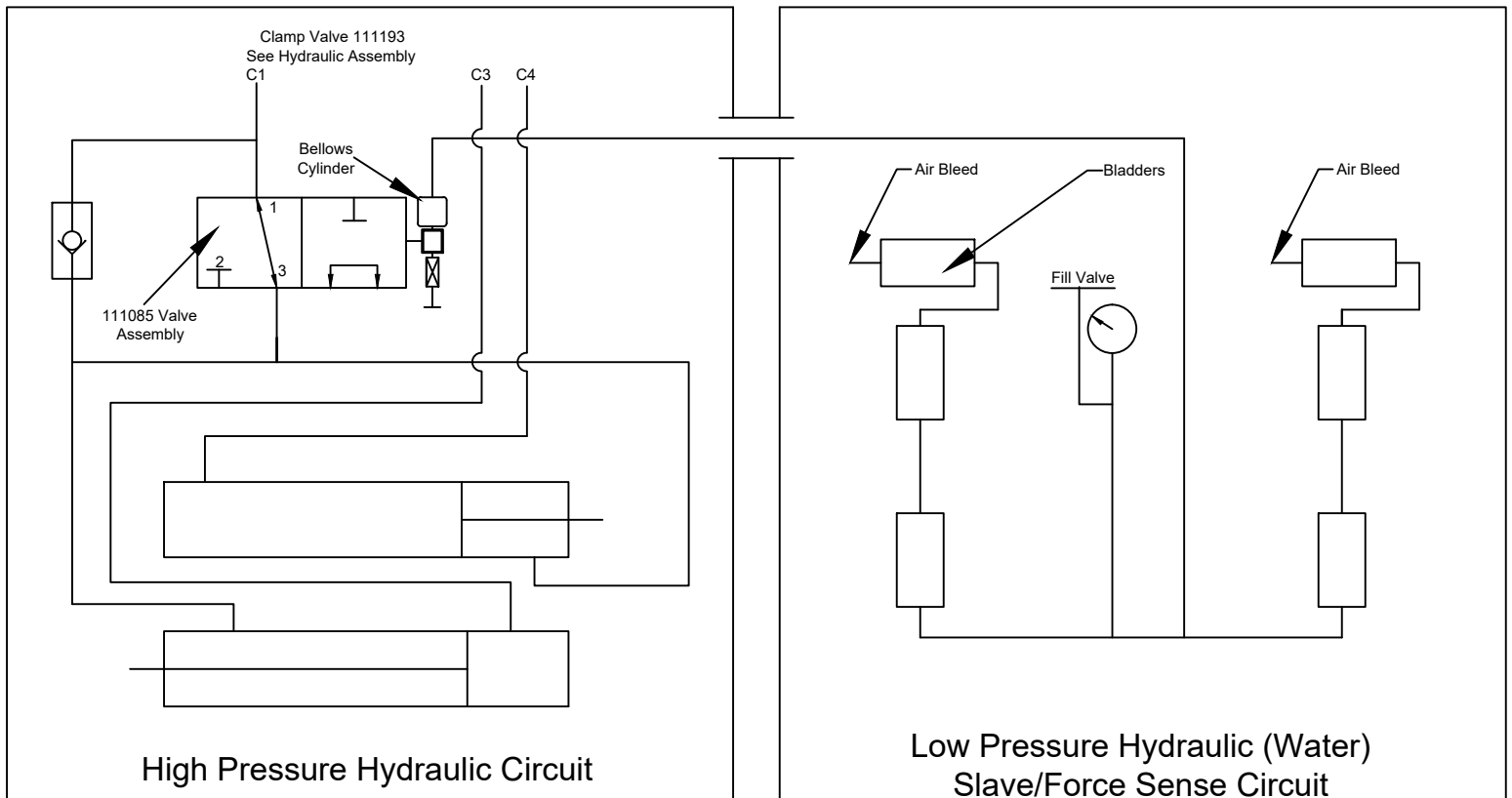
#	QTY	PART #	DESCRIPTION
1	1	111722	Right Hand Arm Weldment
2	1	111724	Left Hand Arm Weldment
3	2	111209	Contact Pad (Lower)
4	20	111031	Retaining Nut
5	1	111216	Right Hand Tip Plate
6	1	111218	Left Hand Tip Plate
7	20	1C.0820	Bolt
8	10	1C.0812	Bolt
9	30	108088	Spring Washer
10	2	112057	Tip Plate Upper
11	2	111210	Contact Pad (Upper)



FLOATING PAD ASSEMBLY-1

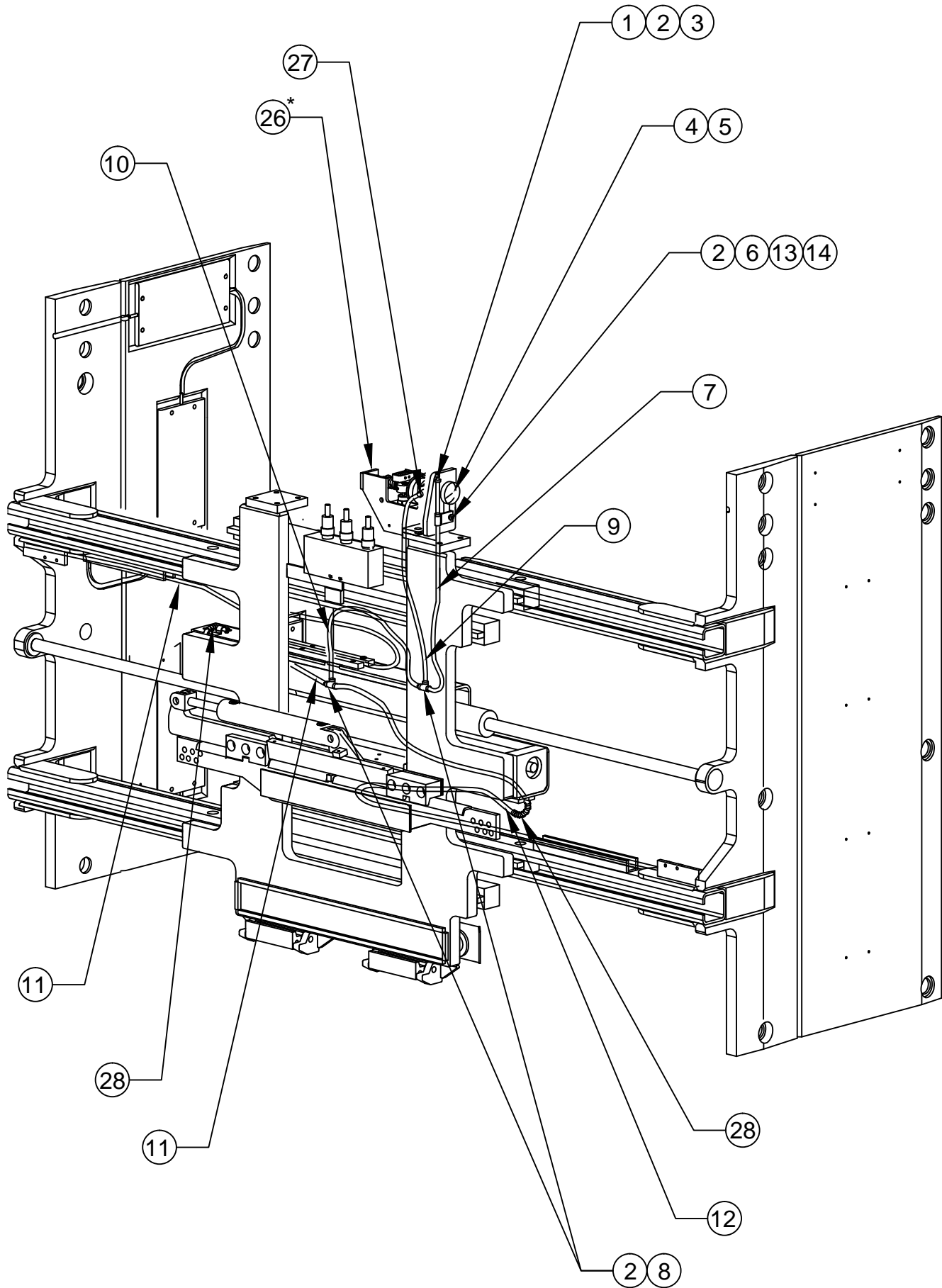
Drawing reference 113166.1

#	QTY	PART #	DESCRIPTION
1	3	111350	Air Tank Valve
2	9	111295	Hose Clamp
3	1	111290.0025	Hose
4	1	111296	Pressure Gauge
5	1	111543.01	90° Elbow Fitting
6	1	111292	Branch Tee
7	1	111290.0220	Hose
8	2	111293	Run Tee
9	1	111290.0180	Hose
10	1	111290.0082	Hose
11	1	111290.1170	Hose
12	1	111290.1115	Hose
13	1	111299	Hose Clip
14	1	25G.0520	Bolt
15	4	111030	Bladder
16	2	111290.0094	Hose
17	2	111290.0166	Hose
18	2	111290.0114	Hose
19	24	9G.0412	Bolt
20	12	111471	Clamp Bar
21	8	109256	Hose Clamp
22	8	25GN.0508	Bolt
23	2	113026.0360	Cover Hose
24	4	111128	Hose Guide
25	12	1C.0512	Bolt
26	1	111085	Direction Valve Assembly Ref
27	1	111289	Pipe Elbow
28	2	111510	Spring
29	24	111878	19 Gauge Stainless Wire Tie
30	2	112391	Modified Bladder
31	2	113416	Hose Extrusion w/Holes
32	8	3G.0808	Bolt



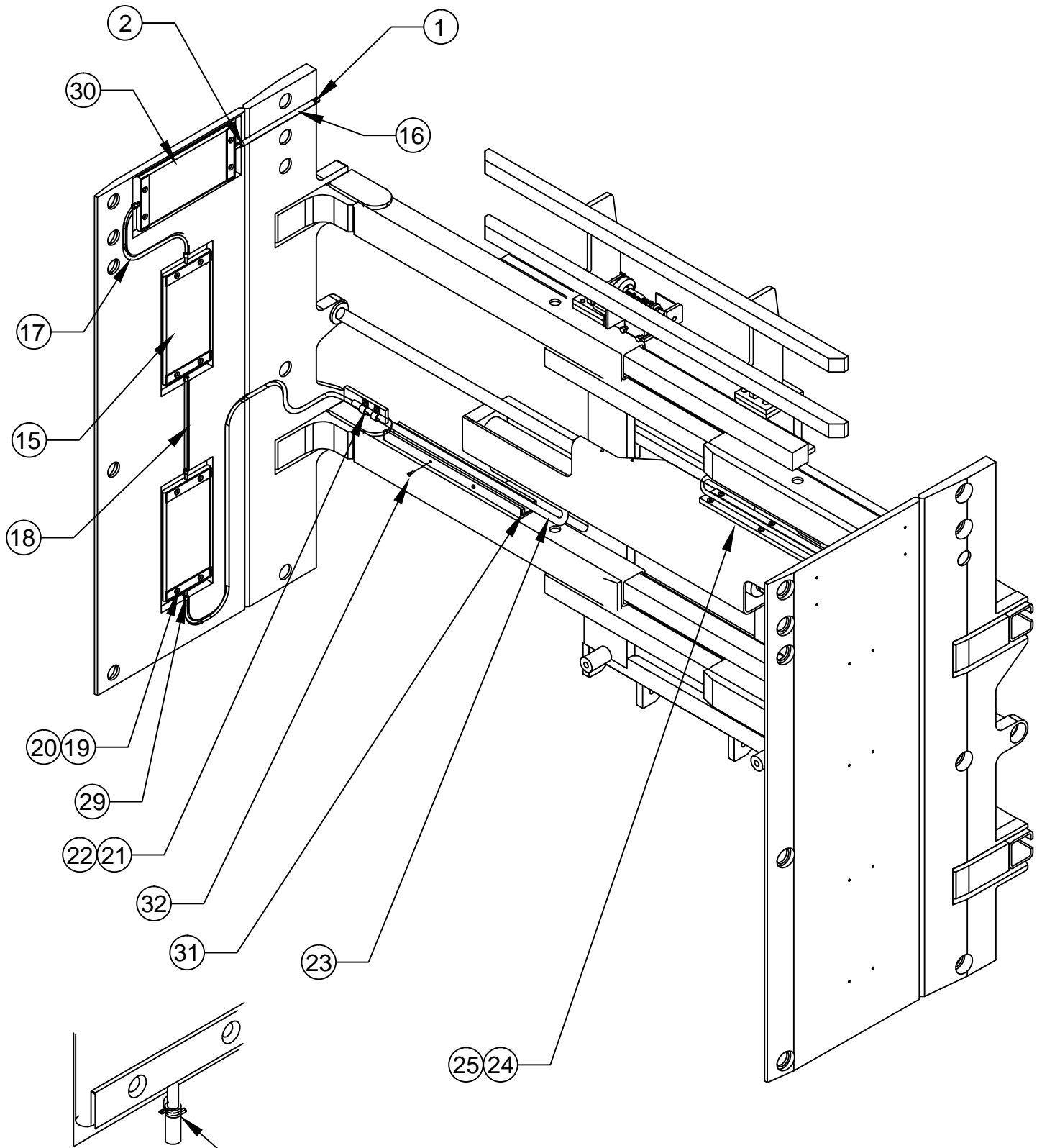
FLOATING PAD ASSEMBLY-2

Drawing reference 113166.1



FLOATING PAD ASSEMBLY-3

Drawing reference 113166.1

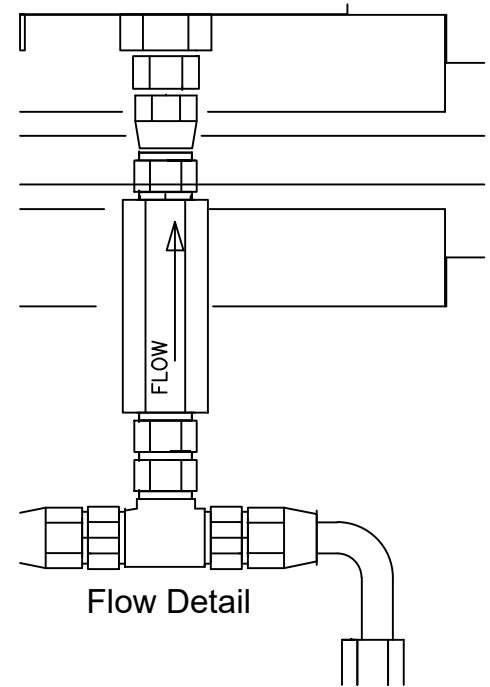
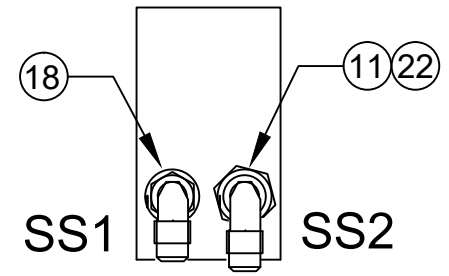
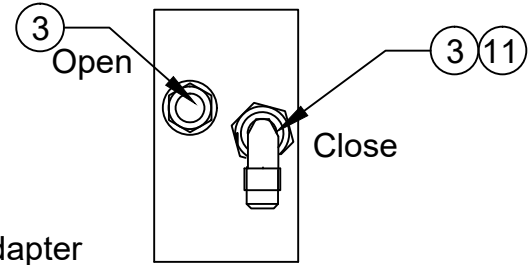


Note: Use two 19 gauge stainless steel wire ties (111878) at each bladder connection. Twist to tighten and clip to reduce ends.

HYDRAULIC ASSEMBLY-1

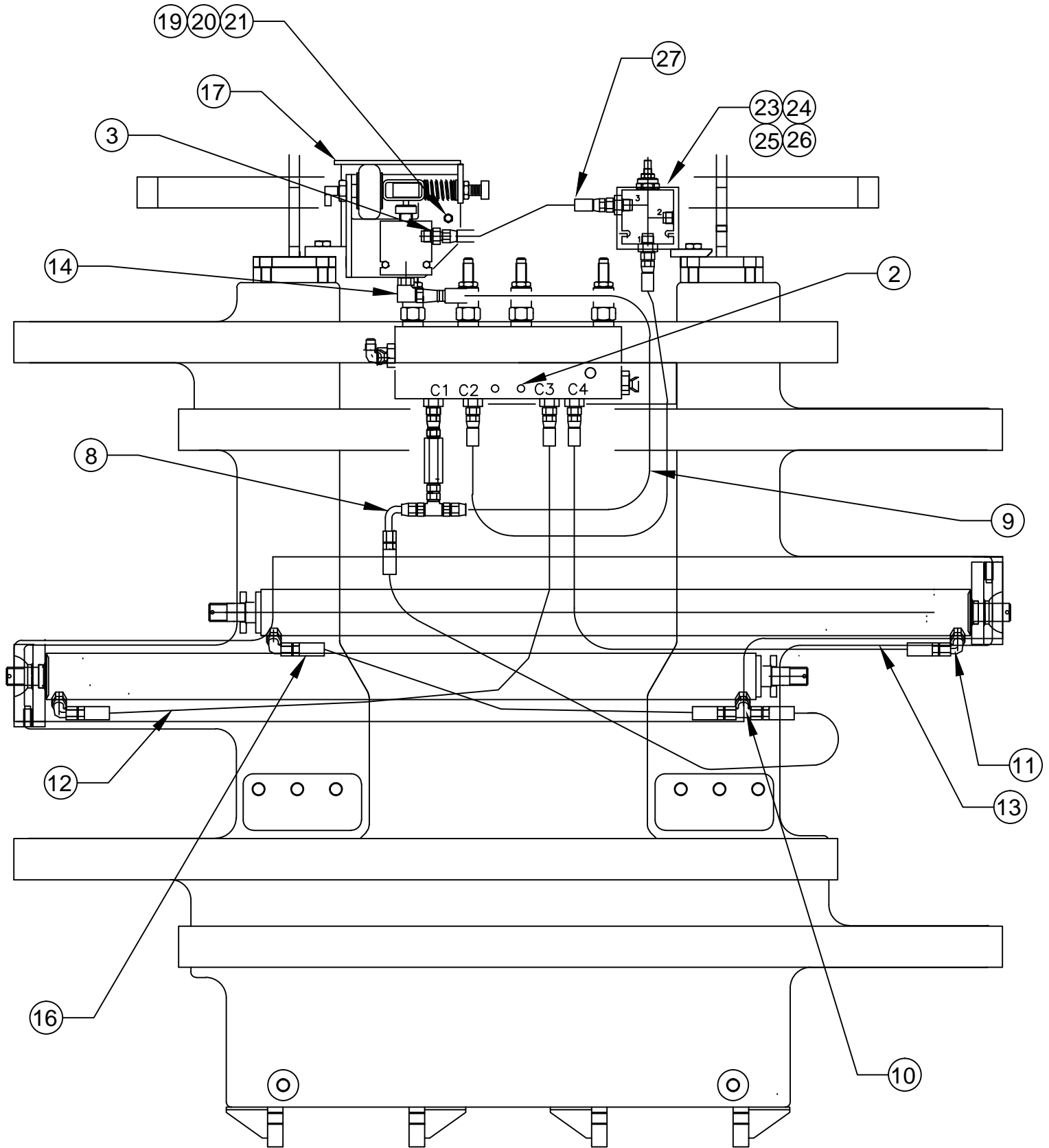
Drawing reference 113489

#	QTY	PART #	DESCRIPTION
1	1	1111193	Clamp Valve
2	2	25G.0524	Bolt
3	8	100676.05	Thread Adapter
4	2	111518.06	04 Pipe to 06 JIC Straight 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 Assembly
9	1	100674.0290	Hose Assembly
10	1	100678.05	O-Ring Tee Branch Fitting
11	2	100440.05	90° Swivel Fitting
12	1	100674.0340	Hose Assembly
13	1	100674.0275	Hose Assembly
14	4	100095.05	90° O-Ring Fitting
15	1	100674.0270	Hose Assembly
16	1	100674.0200	Hose Assembly
17	1	111514	Valve Guard
18	1	100222	90° O-Ring Restrictor Fitting
19	1	25G.0616	Bolt
20	1	4F.05	Flat Washer
21	1	17D.06	Nylock Nut
22	1	109626.1	O-Ring Straight Restrictor Fitting
23	1	113395	Valve Mount Weldment
24	1	113403	Flow Regulator Assembly
25	2	1C.0424	Bolt
26	2	4E.04	Lock Washer
27	1	100233.0090	Hose Assembly



HYDRAULIC ASSEMBLY-2

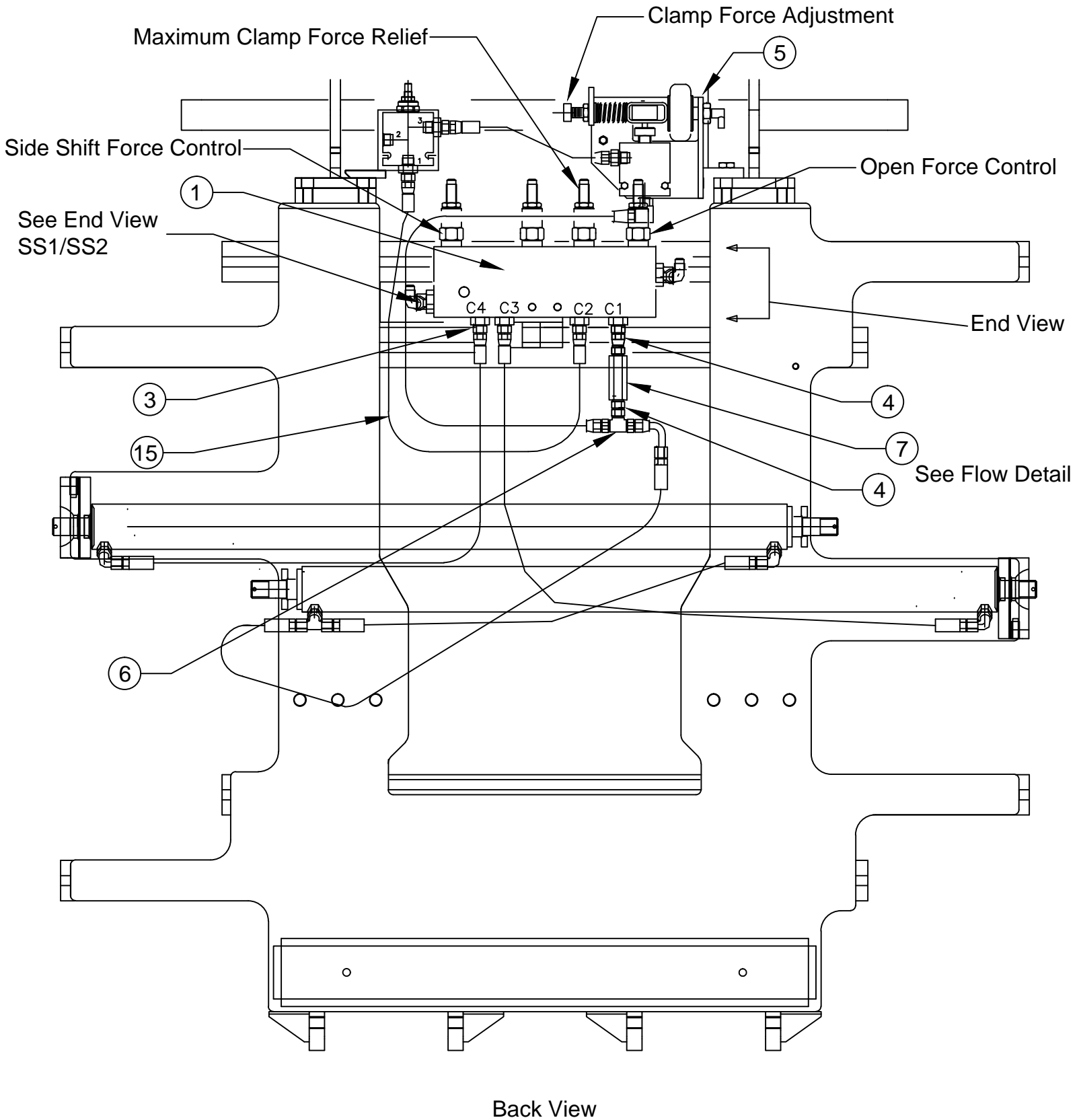
Drawing reference 113489



Front View

HYDRAULIC ASSEMBLY-3

Drawing reference 113489

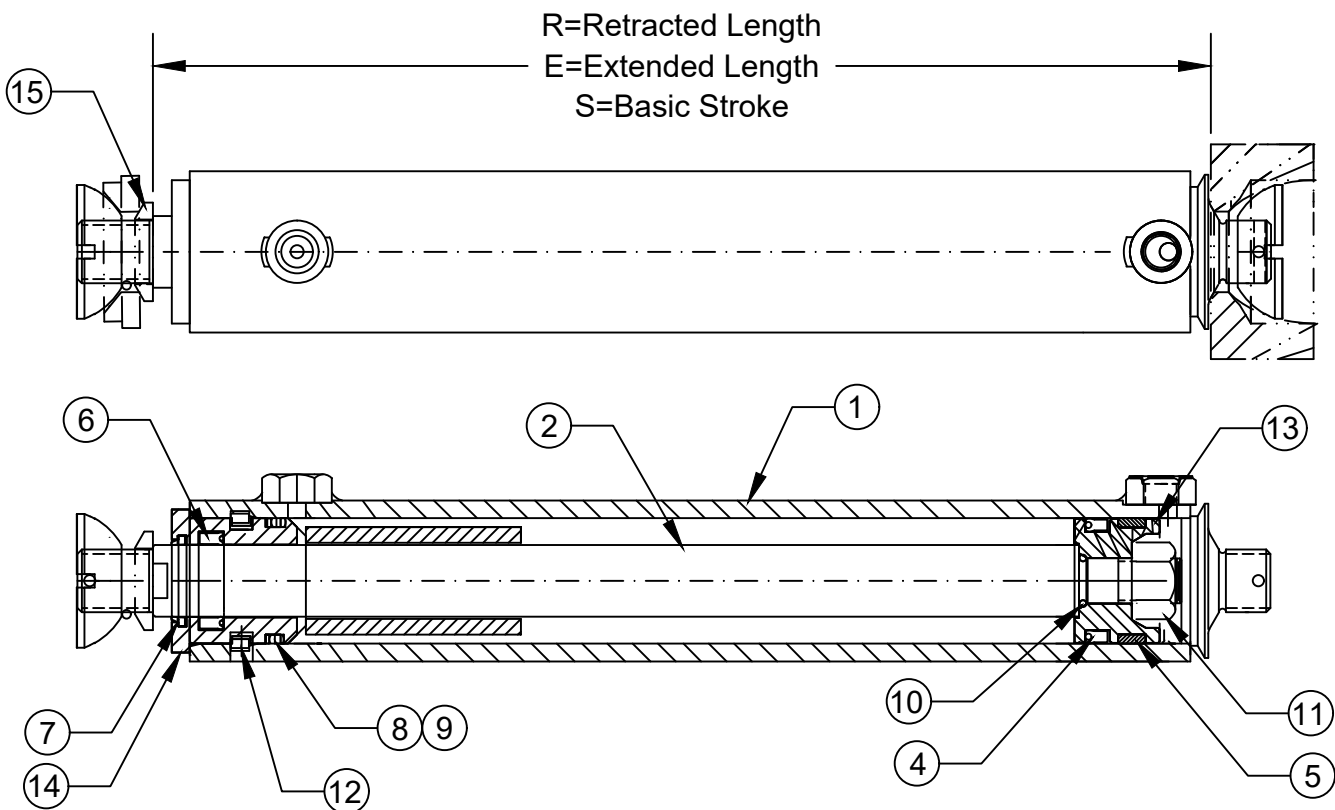


CYLINDER ASSEMBLY

Drawing reference 111714.1

Part #	R	E	S	NET STROKE
111714.1	35.08	66.16	31.08	31.08

#	QTY	PART #	DESCRIPTION	8	1	100029.2	O-Ring
1	1	111715.1	Tube Weldment	9	1	100028.2	Back-Up Ring
2	1	111717.1	Rod	10	1	100029.201	O-Ring
3	1	111482	Seal Kit (Items 4-12)	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

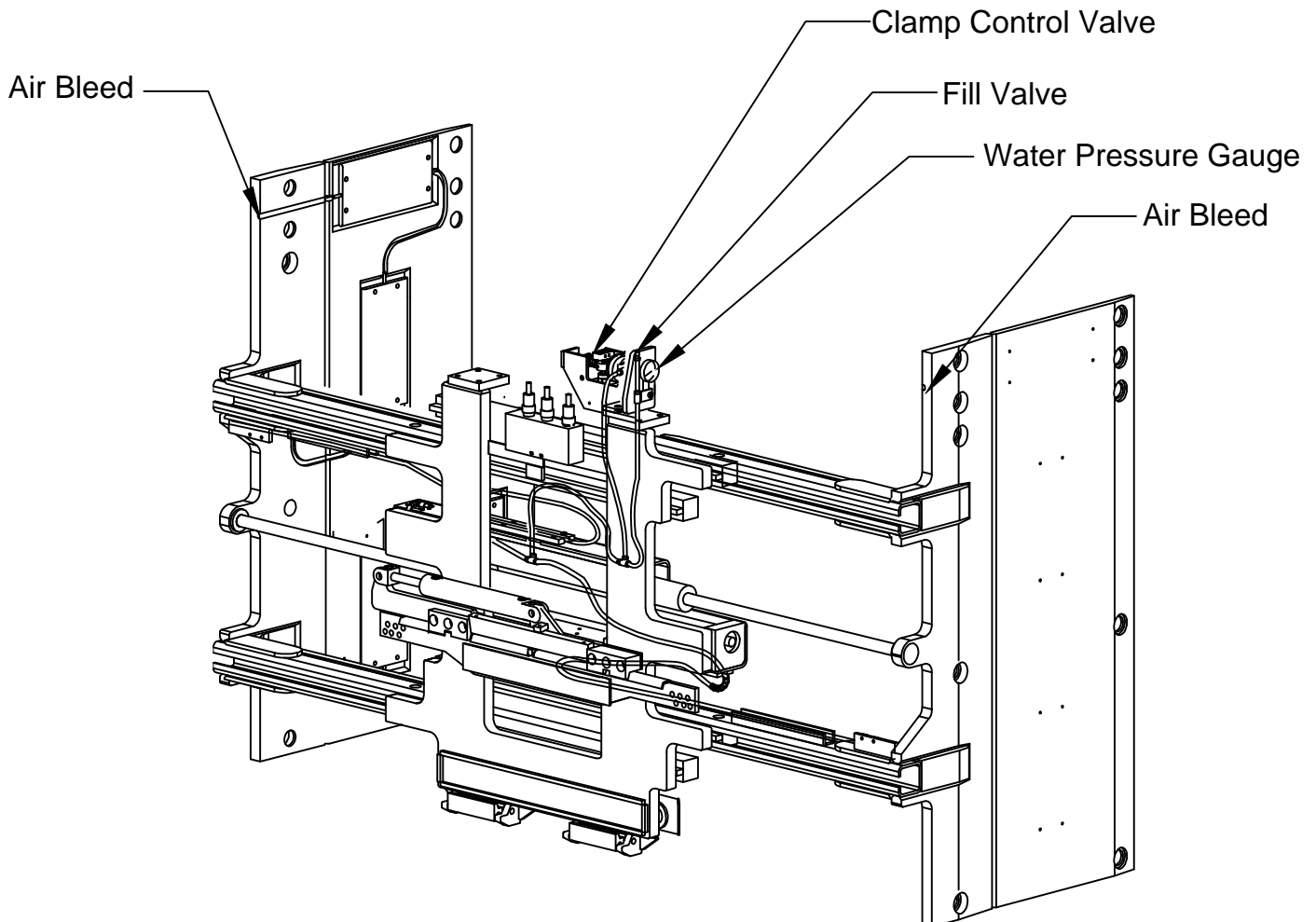
NOTE: When looking at the clamp control valve from the front of the clamp, the clevis pin should be directly in front of the shut off valve stem, or slightly to the left, when the clamp will not close. To check the pin position, turn the force control screw in until the clamp just starts to move, at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

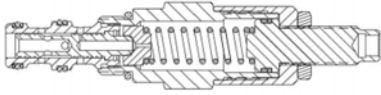
1. Clamp on the heaviest load that will be handled.
2. Adjust the side shift force down until the arms stop.
3. Turn the adjusting screw one turn in.



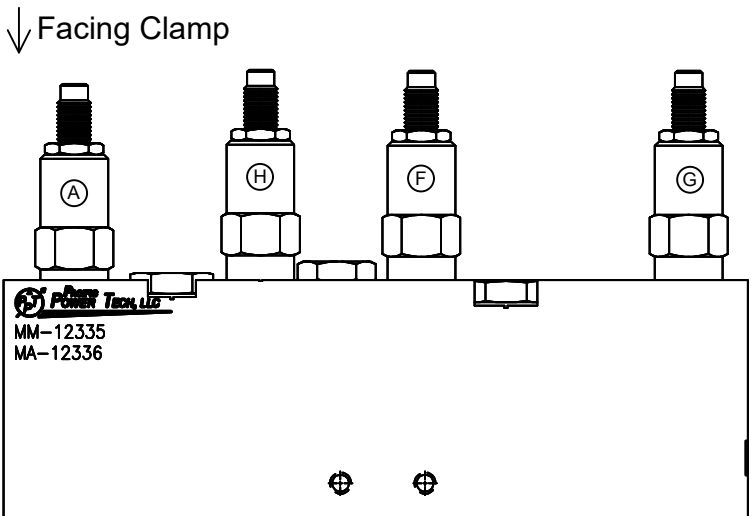
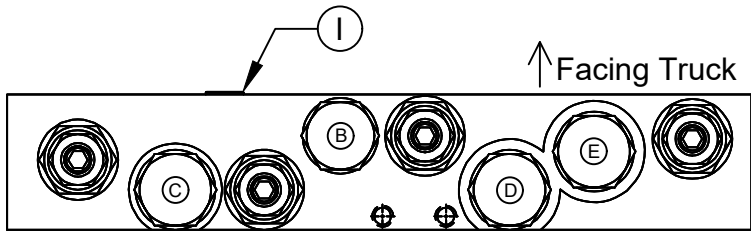
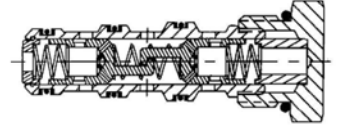
CONTROL VALVE

Drawing reference 111193

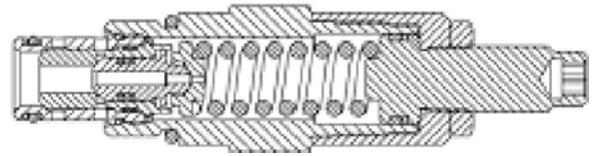
(A) **111627** Pressure Reduce/Relief Valve
Torque 15-20 FT/LBS
Seal Kit 112065



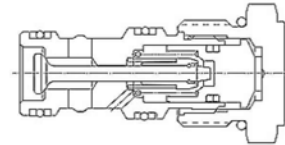
(B) **112887** Flow Divider
Torque 10-12 FT/LBS
Seal Kit 104711



(H)(G) **112406.1** & (F) **112406.2** Relief Valve
Torque 20-25 FT/LBS
Seal Kit 112064



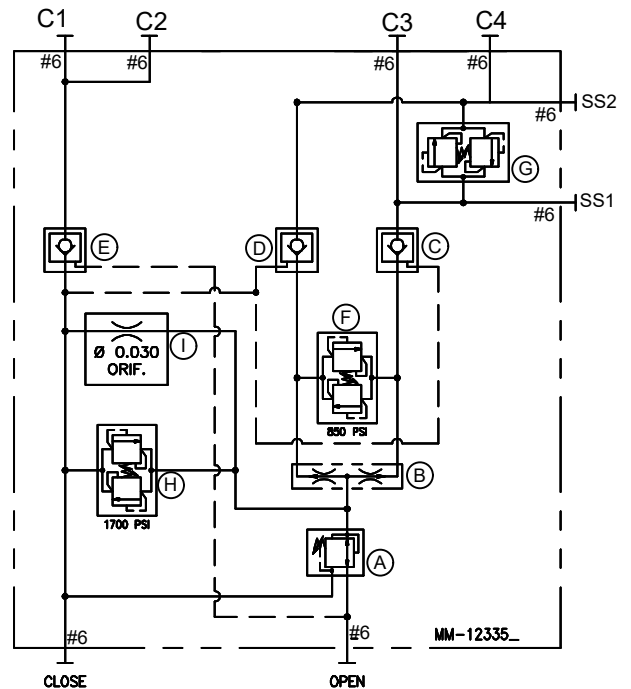
(C)(D)(E) **111244** Check Valve
Torque 30-35 FT/LBS
Seal Kit 112059



NOTE: Lubricate threads & seals prior to assembly.

QTY	PART #	DESCRIPTION
1	111627	Pressure Reducer Valve
1	103813	Flow Divider
2	112406.1	Relief Cartridge
1	112406.2	Relief Cartridge
1	00.030 ORIFICE	1/16" NPT Orifice Plug
3	111244	Check Valve

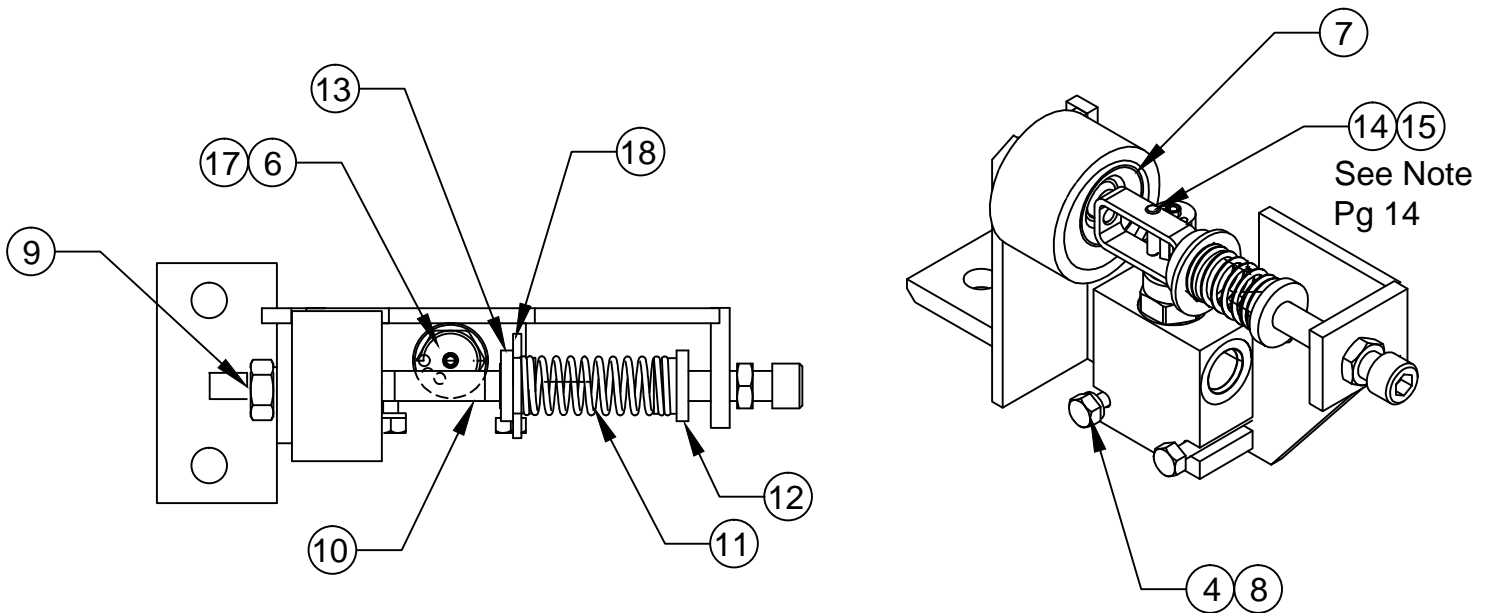
HYDRAULIC SCHEMATIC



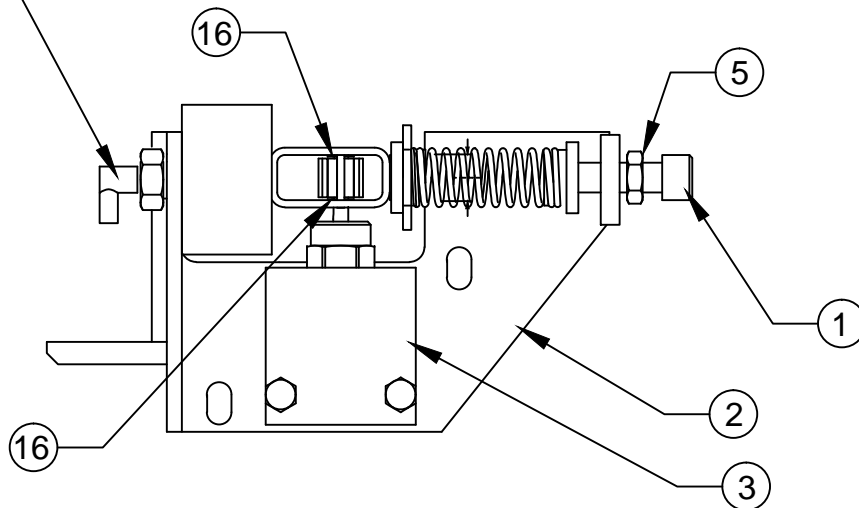
CLAMP FORCE CONTROL VALVE

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

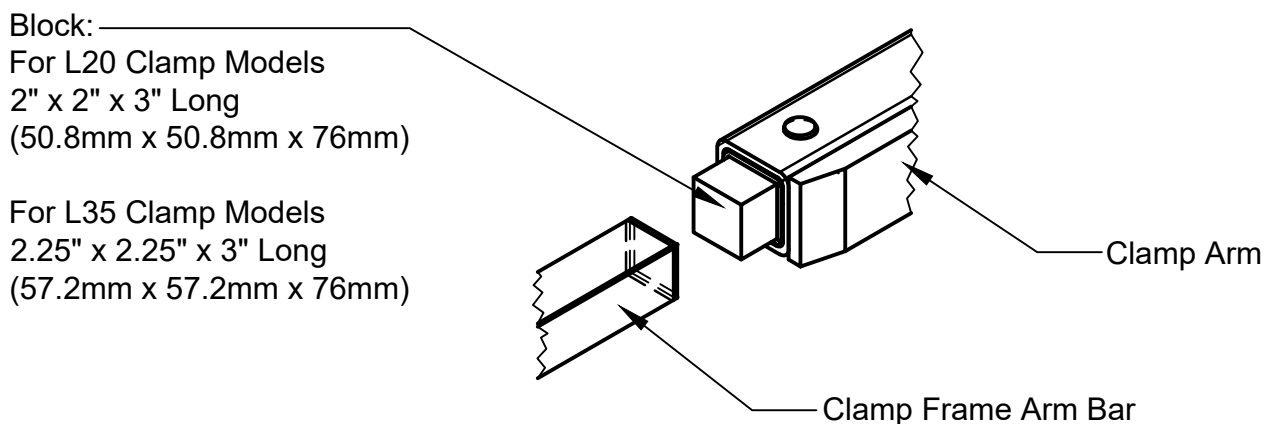


Reference 111289 see floating pads assembly



ARM SLIDE & SHIM REPLACEMENT

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.

TROUBLE SHOOTING GUIDE

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.