Fork Positioner

T 411 BZI

T 411 BZI  Fork positioner integrated with bolt-on forks and valveblock sideshift

T 411 BZI  Fork positioner integrated with welded on forks and valveblock sideshift

T 411 BZI  Fork positioner integrated with fork carrier for ISO 2330 forks and valveblock sideshift
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Our service department in Aschaffenburg will be happy to answer your technical questions and to provide additional support.

Technical Support:
0049 (0)6021 865 395
0049 (0)6021 865 284
0049 (0)6021 865 352

Orders for spare parts Domestic
0049 (0) 6021 865205
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Orders for spare parts Export
0049 (0) 6021 865344
0049 (0) 6021 865348

Outside of normal business hours the Kaup – Service Hotline is available to you 365 days a year:
0049 (0) 172 6295 297
Monday - Friday: 5 pm to 7 am
Saturday and Sunday: 8 am to 6 pm

Kaup GmbH & Co KG • Braunstr. 17 • D-63741 Aschaffenburg • email: kaup@kaup.de •
www.kaup.de
1. Introduction

1.1 Working with this manual

This operating manual contains important information on how to operate the attachment properly, safely and efficiently.

The operating manual shall be read, understood and applied by all personnel working on or with the equipment, for example:

- Installation and operating the equipment
- Inspection, maintenance and repair
- Transport and disposal

The manual must be kept available for ready reference at the equipment's place of use.

The illustrations in this operating manual may deviate from the actual version of the equipment.

1.2 Warning notes and symbols

The following symbols are used in this operating manual to highlight details of special importance:

- Identifies details relating to do's and don'ts for the purpose of avoiding injury and property damage.

- Specific details relating to the efficient use of the attachment and other advice.

- Lists are denoted by a shadowed box.

- Steps to be performed by the operator are denoted by a black dot.

(1) In illustrations, particular elements have numbered pointers. Numbers in brackets in the text refer to the corresponding elements.

1.3 Copyright

This documentation including all parts is copyrighted. Any use or change outside the narrow limits of copyright law without permission from KAUP GmbH & Co KG is forbidden and liable to prosecution. This applies, in particular, to reproduction, translation, microfilming as well as storage and processing in electronic systems.
1.4 Qualified and authorised personnel

Qualified and authorised personnel are equipped by way of their education and training to perform the tasks assigned to them in accordance with accepted practice and safety regulations. They are assigned tasks by the equipment owner.

1.5 Warranty claims based on defects

KAUP shall not be liable for any damage to the equipment resulting from:

- Improper use / operation.
- Modifications to components.
- Inappropriate installation, maintenance, inspection and servicing.
- Assignment of unqualified or non-authorised personnel.
- Claims raised by third parties.

1.6 Limits of applicable use

KAUP-attachments are intended for use under the following climatic conditions:

- Average ambient temperature for continuous operation: +25°C
- Allowable maximum ambient temperature, short term (up to 1h): +40°C
- Allowable minimum ambient temperature for attachments intended for indoor use: 0°C
- Allowable minimum ambient temperature for attachments intended for outdoor use: -20°C

Standard models of KAUP-attachments are NOT suitable for:

- Use in cold storage facilities.
- Use in explosive environments.
- Use in conjunction with hydraulic systems involving biological oils.
- Use in rough environmental conditions (e.g. seawater)
- The transport of acidic liquids.
2. Safety aspects

As the user, extend the safety instructions with generally applicable, legal and other measures that ensure a safe and environmentally friendly operation of the attachment.

Pay close attention to all safety- and danger-related signs on the attachment and in this operating manual. Failure to observe these can result in severe injury or even death.

Pay close attention to the operating manual provided by the manufacturer of the fork lift truck.

Keep a safe distance away from moving, reciprocating or rotating parts of the attachment to avoid danger of crushing, pinching or entanglement.

Notify the responsible department/person immediately of changes and faults in operation of the attachment that affect safety.

The attachment shall be shut down.

Use aids to vision (e.g. mirrors, camera, etc.) where goods being transported obstruct vision.

Only allow work on the attachment to be carried out by qualified and authorised persons. Adhere to the legal minimum age in the country of operation!

The attachment should only be used for the purpose intended.

Never work on or with attachments while under the influence of drugs, alcohol or medicines which affect reaction time.
3. Design

Modell 1

Modell 2

1

2

3

4

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9
An integrated fork positioner consists of a clamp body (3) in which sliders (4) are installed.

Cylinders (5) move the slides (1), onto which

fork tines screwed (2),
fork tines welded (8) or
fork carriage welded (9)

Cheek plates (6) with mast rollers (7) are welded onto the rear side of the clamp body (3).

3.1 Efficient equipment settings on electric vehicles

Please use our reference values for setting the lift trucks and attachments. These are found at www.kaup.de in the Services -> Product Support section.

3.2 Proper use of the equipment

Fork positioners are designed for carrying loads on pallets or in skeleton containers.

Proper use of the machine and/or equipment includes the following:

- Observance of the operating manual at all times.
- Observance of the technical data on the identification plate on the attachment.
- Adherence to the specified inspection and maintenance instructions.

3.3 Improper use

- Exceeding the allowable load capacity and load centre.
- Dragging or pushing loads with the attachment.
- Transporting persons with the load or load handling devices.
- Mounting auxiliary equipment on the attachment such that the original mode of usage is changed, (e.g. fork extensions) must be authorised by the manufacturer.
4. Installation and checking out

4.1 Installation

Installation and commissioning should be performed by qualified and authorised personnel only.

Pay attention to a sufficient load-carrying capacity of the lifting means.

The following are examples of preferred lifting means:

<table>
<thead>
<tr>
<th>Capacity</th>
<th>Part-no.</th>
</tr>
</thead>
<tbody>
<tr>
<td>250 kg/M16</td>
<td>9710160008</td>
</tr>
<tr>
<td>1200 kg/M16</td>
<td>0360010201</td>
</tr>
<tr>
<td>2000 kg/M16</td>
<td>0360010301</td>
</tr>
</tbody>
</table>

Integrated fork positioner are part of the conveyor truck and must be installed in the mast in accordance with the instructions issued by the truck manufacturer. This applies in particular to the choice of mast rollers, stops, chain attachments and hydraulic connections.
Mount the mast rollers (1) on the sidemover's roller pins (2).

Install additional stops to prevent the rollers from coming out of the mast.

Using suitable lifting means (3) lift the fork positioner integrated and ease it into position in the mast.

Connect the mast chain to the eyes (4) on the carriage and secure the chain.

Install the stops necessary to prevent the carriage from moving too far and disengaging from the mast of the forklift.
Connect the hydraulics (5) to the truck’s hydraulic system.

Remove the safety retaining stops (6) and slide the fork arms onto the fork carrier from the side.

Make sure that all safety retaining stops (6) have been correctly reinstalled.

Mast designs vary, so the procedure for installation might not necessarily be as described here. Always comply with the specifications and instructions issued by the manufacturer of the mast.

Before initial operation, check the functions and the identification of the attachment with the movement directions of the operating elements (operating lever, joystick, etc.).

Mount the residual carrying capacity notice and identification of the operating elements (if not already present) of the combination of lift truck/attached equipment on the lift truck.

4.2 Checking out

KAUP-attachments are delivered pre-lubricated. If the attachment has been in storage for a longer period, we recommend that it be lubricated again before being placed in service. See 6. Maintenance and onwards.

Failure of the safety devices (e.g. the pressure relief valve and the non-return valve) and incorrect connection of the controls to the actuators can cause malfunctioning of the attachment and damage to it.

After mounting and before initial operation, check the functions and the identification of the attached equipment with the movement directions of the operating elements (operating lever, joystick, etc.).

4.2.1 Bleeding the hydraulic system

Start the lift truck.

Move the fork positioner repeatedly in both directions to maximum extent.

Inspect the hydraulic connections for leakage.

4.2.2 Adjustment after putting into service

The hydraulic system is under pressure. During work on hydraulic components oil spurtng out can cause injuries. Unload the system in accordance with the operating instructions of the lift truck manufacturer. In the case of injuries caused by high pressure oil, inform the works physician and seek out a specialist immediately.
Synchronising the arms

The synchronization of arms is adjusted ex-factory. This can alter for different friction conditions (wear), temperatures and volumes conveyed. Perform a readjustment. The recommended working temperature of the hydraulic fluid is approx. 35 °C.

The synchronization is adjustable by means of two throttles on the bottom of the cylinders.

5. Operation

5.1 General

At least once per working shift, the machine and equipment must be inspected for visible damage and defects. Repeat faults to your superior and have them rectified without delay.

Be aware of persons present in the area where you are working or driving and ensure that they are not endangered.

Do not transport any load exceeding that specified on the residual load plate for the particular combination of lift truck and attachment.

Note the load-bearing capacity of the attachment as stated on the rating plate. This figure always represents the load carried by two or more fork arms.

The nominal capacity of the forks must exceed the load.

5.2 Load handling

Set the forks as wide apart as possible for the load to be carried.

Position the mast vertically and take up the load parallel to the floor.

Always transport pallets, boxes and containers using both forks.
Drive the attachment up to the load to maximum extent.

Raise the load about 300 mm and tilt the mast backwards.

Centre the load to the middle of the lift truck during take-up and transport.

### 5.3 Driving

Ensure that pallets, boxes, containers and packaging are in good condition.

Do not drive with the mast tilted forward.

Take care when driving that neither the attachment nor the load comes into contact with the ground.

Ensure that multiple items stacked on top of one another are securely fastened.

### 6. Maintenance and servicing

#### 6.1 General

Regular maintenance is essential to ensure reliable operation and long service life of the KAUP attachment.

Ensure that maintenance and servicing are performed by qualified and authorised personnel only.

Lubrication and cleaning work on the attachment may also be performed by the lift truck operator.

Perform maintenance and servicing work only when the attachment is parked securely on a stable, level foundation. For installing and removing, it is recommended to use a pallet to take the attachment. The attachment can thus be securely placed and transported.

Pay attention to a sufficient load-carrying capacity of the lifting means.

Replace missing or defective warning signs on the attachment.

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**⚠️** Do not use third party spare parts. Through poor quality or incorrect matching they can result in a risk of accident. The EC Declaration of Conformity by the manufacturer becomes invalid and you assume full responsibility in the case of accident.

Use only original spare parts from the manufacturer.
The hydraulic system is under pressure. During work on hydraulic components oil spurting out can cause injuries.Unload the system in accordance with the operating instructions of the lift truck manufacturer. In the case of injuries caused by high pressure oil, inform the works physician and seek out a specialist immediately.

Screw connections can loosen due to vibration of the attachment. During routine maintenance check that screw connections are correctly torqued and replace screws which are visibly damaged.

Note the following tightening torques which are valid for screws with connecting surfaces according to ISO 4762, ISO 4014, ISO 4032 etc.:

<table>
<thead>
<tr>
<th>Screw/bolt rating</th>
<th>8.8</th>
<th>10.9</th>
<th>12.9</th>
</tr>
</thead>
<tbody>
<tr>
<td>M6 thread</td>
<td>9,3Nm</td>
<td>14Nm</td>
<td>16Nm</td>
</tr>
<tr>
<td>M8 thread</td>
<td>23Nm</td>
<td>33Nm</td>
<td>39Nm</td>
</tr>
<tr>
<td>M10 thread</td>
<td>45Nm</td>
<td>66Nm</td>
<td>77Nm</td>
</tr>
<tr>
<td>M12 thread</td>
<td>77Nm</td>
<td>115Nm</td>
<td>135Nm</td>
</tr>
<tr>
<td>M16 thread</td>
<td>190Nm</td>
<td>280Nm</td>
<td>330Nm</td>
</tr>
<tr>
<td>M20 thread</td>
<td>385Nm</td>
<td>550Nm</td>
<td>640Nm</td>
</tr>
</tbody>
</table>

During any disassembly operations, be sure that parts to be disassembled can easily be removed. For removing parts, use the clearance between bolts and the parts to be removed.

Our service videos available at www.kaup.de in the Online Services section may be used for assistance as necessary.

Failure of the safety devices (e.g. the pressure relief valve and the non-return valve) and incorrect connection of the controls to the actuators can cause malfunctioning of the attachment and damage to it. After mounting and before initial operation, check the functions and the identification of the attached equipment with the movement directions of the operating elements (operating lever, joystick, etc.).
6.2 Significant modification

Significant modifications are, for example, those which affect the stability, performance, speed and strength of components.

Modifications to the attachment may only be made with prior approval by the manufacturer.

6.3 Schedule for routine maintenance and lubricants

<table>
<thead>
<tr>
<th>Lubricants approved and recommended by KAUP</th>
</tr>
</thead>
<tbody>
<tr>
<td>Greases</td>
</tr>
<tr>
<td>Lithium soap grease</td>
</tr>
<tr>
<td>NLGI Class 2</td>
</tr>
<tr>
<td>Complex soap grease</td>
</tr>
<tr>
<td>NLGI Class 2</td>
</tr>
<tr>
<td>Teflon spray</td>
</tr>
</tbody>
</table>

The specified maintenance schedules can change as a result of the operating conditions such as extreme cold, heat and dust or poor ground conditions and this must be taken into account by the owner.

With other loads, such as fork arms with a length of over 2,400 mm or raised load centres, amended/shorter maintenance intervals should be agreed by the user with the manufacturer.
6.3.1 Fork Positioner

Modell 1

1,5-2mm
depending on width
Daily

Check all lines, hoses and connections for leakage and damage.

Ensure that all fork safety retaining stops (11, 12) are present and undamaged.

After 50h / every 500h thereafter

Check:

- Screws (3) on the forks.
- on the fork safety retaining stops (11, 12).
- (13) on the safety metal sheets (14).
- (15) on the safety metal sheets (16).

Replace loose or damaged screws. Torque the screws as specified in Chapter 6.1 General.

Weekly

Grease:

- Sliding pieces (2) by way of the greasing nipples (1).

Every 200h

Check wear on:

- Sliding pieces (2).
- safety metal sheets (13, 15).

As necessary

**Modell 1**

Replace worn sliders (2) by removing nut (6) from each cylinder (7). Pull both slides to the side to remove. Remove the screw (4). Replace the sliders (2). When installing the new sliders, make sure that the axial stops (5) are correctly seated. Remount the screw (4). Push the slides into clamp body (8) and reinstall nuts (6) of cylinders (7).

**Modell 2**

Replace worn sliders (2), by removing the safety metal sheet (14) and nut (6) from each cylinder (7). Pull the slides (17) on the side to remove. Replace the sliders (2). Push the slides into clamp body (8), reinstall the safety metal sheet (14) with screws (15) and nut (6) of cylinder (7).

Renew the faulty cylinder (7) by removing the hydraulic lines from the cylinder (7) with the hydraulic system depressurised. Remove the nuts (6, 10) and replace the cylinders (7). Reinstall the nuts (10, 6) and the hydraulic lines.

After installing or removing a cylinder (7), always check the clearance between the cylinder mount and nut of the cylinder (6, 10). Cylinders are installed with axial clearance of 1.5 to 2 mm.
6.3.2 Forks

Annually

Inspect the heel of the fork (9) for wear and cracks.

Remove forks from service when wear exceeds 10% of the thickness of the fork.

As necessary

Bent forks are not safe to operate and their continued use should be prevented.

Straightening of forks may only be performed by the manufacturer of the fork or by one of his authorised workshops.

You can increase the service life of forks by using forks especially protected against wear.

6.3.3 Identification plate and caution board
Number | Description | KAUP order number
--- | --- | ---
1 | Identification plate without CE-Mark | only by Quality department
2 | Before putting into operation carefully read and take note of the operating and security instructions. | 0100016401
3 | Never reach into the unit as long as parts could still be moving due to the danger of squashing or shearing. | 0100016601
4 | Use suspension point! | 0100015001
5 | KAUP – order number | without, engraved in the material

7. Troubleshooting

Troubleshooting should only be performed by qualified and authorised personnel.

<table>
<thead>
<tr>
<th>Fault</th>
<th>Possible cause</th>
<th>Correction</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Fork Positioner</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Opening and closing</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>❑ No synchronism</td>
<td>WE throttles on the cylinder unequally adjusted</td>
<td>Adjust the WE throttles on the cylinder</td>
</tr>
<tr>
<td>❑ Movement too slow</td>
<td>Insufficient fluid flow from truck's hydraulics</td>
<td>Increase flow rate of truck's hydraulics</td>
</tr>
<tr>
<td><strong>Clearance</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>❑ Carriage has too much clearance</td>
<td>Slider is worn</td>
<td>Replace sliders</td>
</tr>
<tr>
<td>❑ Carriage tilts at outer limit</td>
<td>Slider is worn</td>
<td>Replace sliders</td>
</tr>
<tr>
<td>❑ Carriage rubbing against guide section</td>
<td>Slider is worn</td>
<td>Replace sliders</td>
</tr>
</tbody>
</table>
### Faults

<table>
<thead>
<tr>
<th>Fault</th>
<th>Possible cause</th>
<th>Correction</th>
</tr>
</thead>
<tbody>
<tr>
<td>Oil leakage</td>
<td></td>
<td></td>
</tr>
<tr>
<td>At cylinder</td>
<td>WE throttle leaky</td>
<td>Replace the WE throttle</td>
</tr>
<tr>
<td></td>
<td>Sealing kit defective</td>
<td>Replace sealing kit</td>
</tr>
<tr>
<td></td>
<td>Screw fitting is leaking</td>
<td>Tighten / seal screw fitting</td>
</tr>
<tr>
<td></td>
<td>Piston rod scored</td>
<td>Replace piston rod and sealing kit</td>
</tr>
<tr>
<td>Solenoid valve</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Not functioning</td>
<td>Solenoid coil defective</td>
<td>Replace solenoid coil</td>
</tr>
<tr>
<td></td>
<td>No power to the magnet</td>
<td>Inspect power cable and connections</td>
</tr>
</tbody>
</table>

**Legend:** FFZ = lift truck, WE-Drossel = elbow-type screwed throttle

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### 8. Disposal

Prevent environmental damage by disposing of the following items properly in accordance with relevant national regulations:

- Hydraulic fluids, greases, lubricants and soiled working materials (Cleaning rags, etc.)
- Packaging material (Pallets, straps, cartons and plastic sheeting)
- After decommissioning, the attachment should be disposed of in accordance with local legislation and regulations.

### 9. Transport

During transport of the attachment, care should be given to using appropriate means of support (e.g. pallets). These must not be damaged. The attachment must be secured against slipping or tipping over on the support.

### 10. Decommissioning and storage

If the attachment is to be stored for an extended period, the clutches must be sealed against contamination and damage. Store the attachment in a clean, dry environment.

### 11. Spare parts list

(not part of the Operating Manual)
12. EC declaration of incorporation of partly completed machinery (Summary)

KAUP GmbH & Co. KG
Braunstraße 17
63741 Aschaffenburg

We declare, that the partly completed machinery

<table>
<thead>
<tr>
<th>Model:</th>
<th>Fork Positioner integrated</th>
</tr>
</thead>
<tbody>
<tr>
<td>Type:</td>
<td>T 411BZI</td>
</tr>
</tbody>
</table>

meets the requirements of the 2006/42/EC machine directive as delivered and is intended for installation in a machine.

The following fundamental health and safety requirements of Appendix 1 of the above-mentioned directive have been applied and adhered to:

- Articles 1.1.2, 1.1.3, 1.1.5, 1.3.2 and 1.3.4

The special technical documentation according to Appendix VII B has been produced.

The manufacturer commits itself to electronically transfer spezial documents for partly completed machinery to Community & National authorities upon request.

The person authorised to compile the technical documents:

**Head of Quality department**

Initial startup is not permitted until it has been determined that the machine into which the incomplete machine will be installed meets the requirements of EU machine directive 2006/42/EG.

Aschaffenburg,

**Head of Quality department**