



Parts Manual

Model 77F Roll Clamp

Serial Number 77F-RCS-132

cascade[®]
corporation

For Technical Assistance call: 800-227-2233, Fax: 888-329-8207

To Order Parts call: 888-227-2233, Fax: 888-329-0234

OR

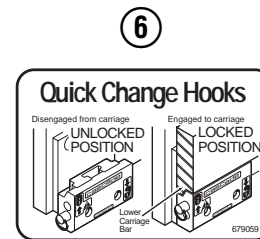
Write: Cascade Corporation, P.O. Box 20187, Portland, OR 97220

Internet: www.cascorp.com

Safety Decals



RC0636.ill



Roll Clamp Safety Decals			
REF	QTY	PART NO.	DESCRIPTION
1	6	665595	No Hand Hold Decal
2	3	660269	Short Arm Rotation Position Decal
3	4	656038	Caution Decal
4	4	679150	No Step Decal
5	4	665677	Trapped Pressure Decal
6	1	679059	Quick-Change Hook Decal

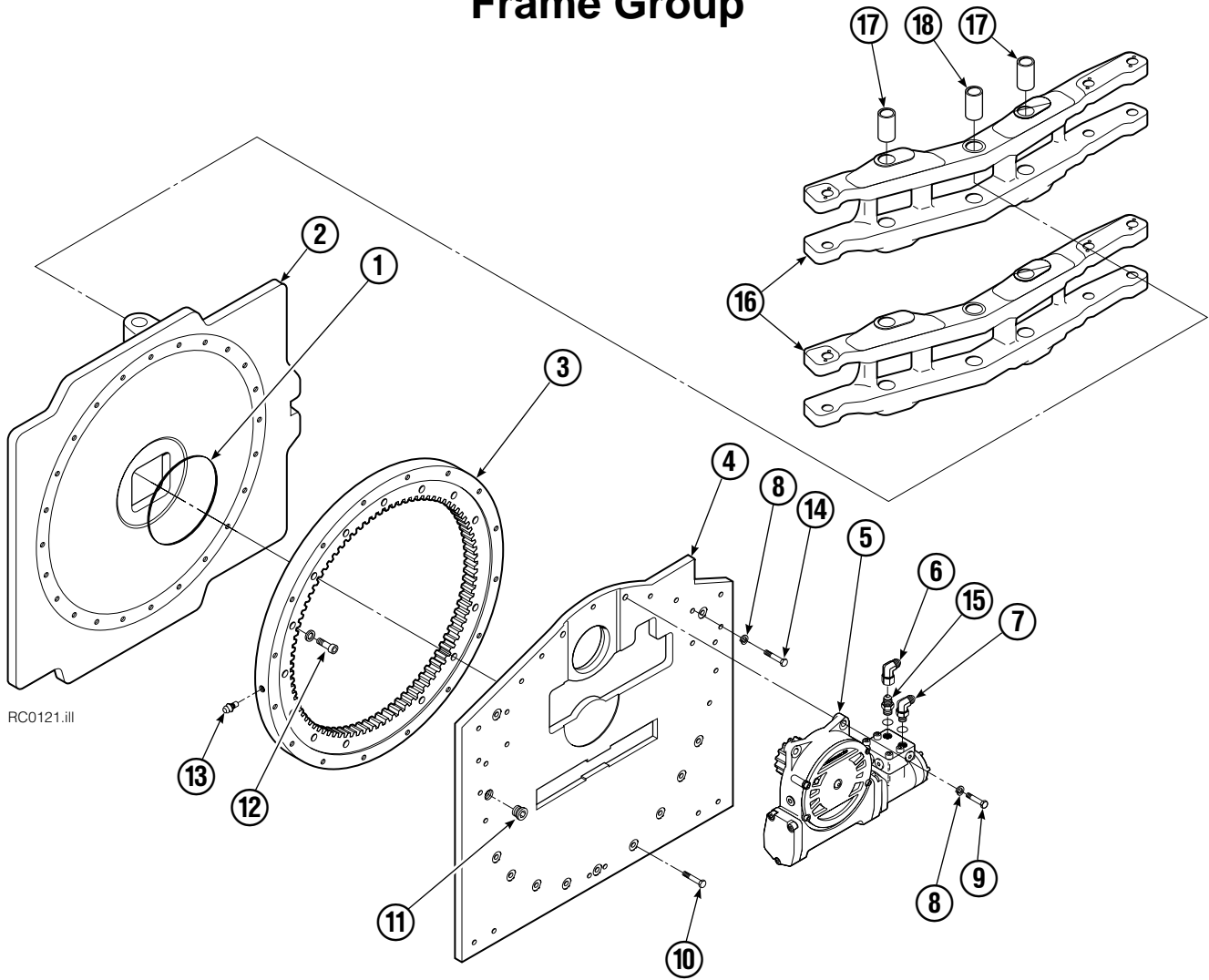
Publications



GA0006.ill

Roll Clamp Publications	
674512	Service Manual
674509	Operator's Guide – Fixed Frame
676268	Operator's Guide – Swing Frame
674510	Installation Instructions – Fixed Frame
674511	Installation Instructions – Swing Frame
677555	Driver Training Video – VHS
678363	Troubleshooting Video – VHS
680664	Servicing Cascade Cylinders – VHS
679929	Tool Catalog
673964	Literature Index Order Form

Frame Group



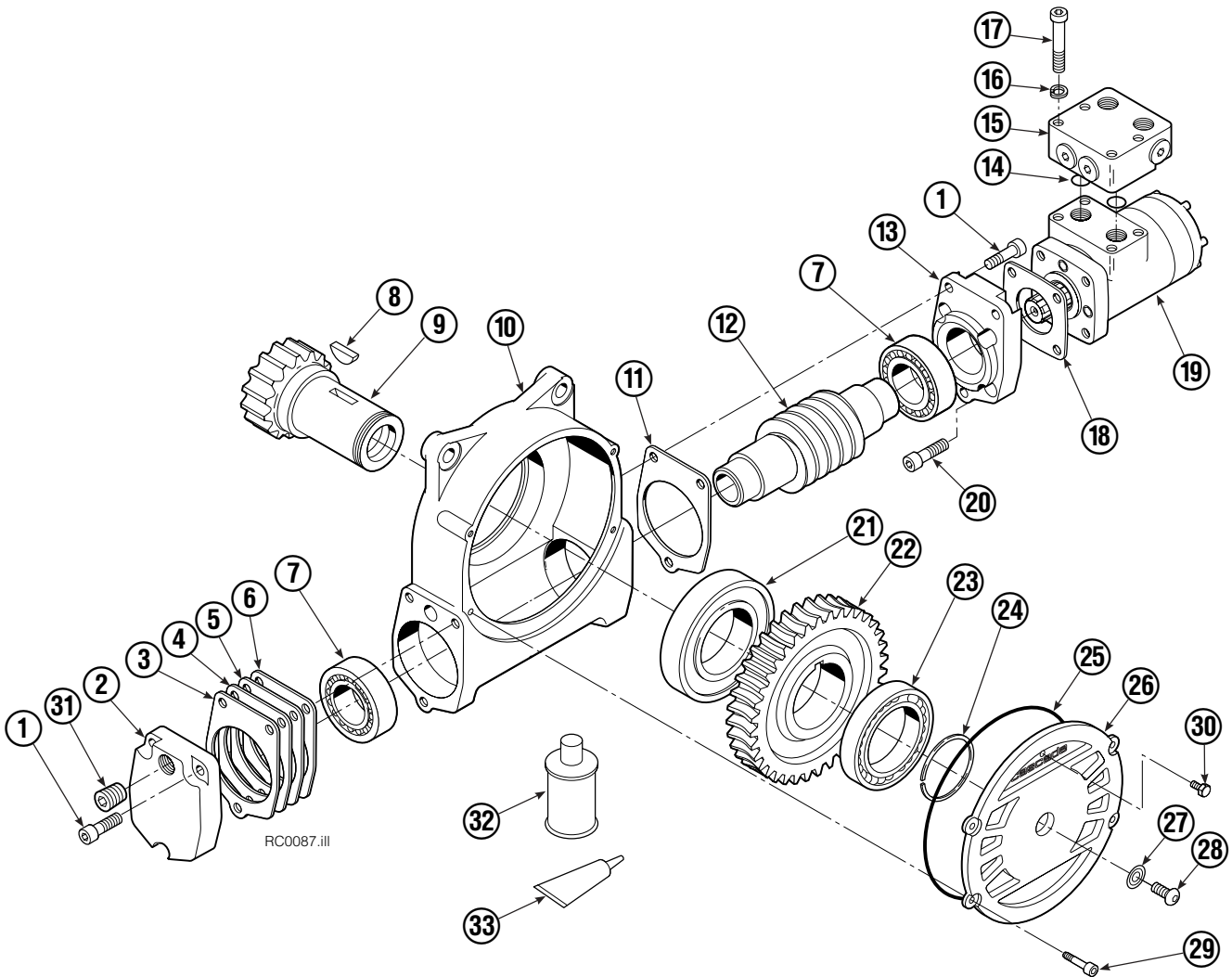
77F			
REF	QTY	PART NO.	DESCRIPTION
		678499	Frame Group
1	1	670931	Seal
2	1	674976	Faceplate
3	1	672830	Bearing Assembly
4	1	678381	Baseplate
5	1	795492	Drive Group ●
6	1	605761	Fitting, 8-8
7	1	601250	Fitting, 8-8
8	17	6290	Lockwasher, 1/2 ID
9	4	661742	Capscrew, 1/2 NC x 1.25 GR5
10	11	643538	Capscrew, 1/2 NC x 1.50 GR8
11	1	6605	Plug
12	24	4507	Capscrew
13	1	7401	Grease Fitting
14	13	643539	Capscrew, 1/2 NC x 1.75 GR8
15	1	601377	Fitting, 8-8
16	2	678519	Swing Frame ▼
17	8	675008	Bushing ▼
18	4	675006	Bushing ▼

● See Drive Group page for parts breakdown.

▼ Included in Swing Frame Group 678516.

Reference: Common Parts 675069.

Drive Group



REF	QTY	PART NO.	DESCRIPTION	REF	QTY	PART NO.	DESCRIPTION
		795492	Drive Group with 2.8 c.i. Motor	19	1	206392	Drive Motor – 2.8 c.i. ■
1	6	769570	Capscrew, M12 x 25	20	4	4468	Capscrew, 3/8 NC x .75 GR8
2	1	676855	Cover	21	1	670580	Bearing
3	●	674513	Shim – .005" (blue)	22	1	675609	Worm Gear
4	●	670574	Shim – .010" (brown)	23	1	670581	Bearing
5	●	671757	Shim – .015" (pink)	24	1	7214	Snap Ring
6	●	671758	Shim – .020" (yellow)	25	1	643423	O-Ring
7	2	670579	Bearing	26	1	775552	Cover
8	1	670582	Key	27	1	783609	Seal
9	1	670556	Pinion	28	1	783608	Capscrew, M10 x 16
10	1	775551	Housing	29	4	200882	Capscrew, M8 x 20
11	1	686465	Gasket	30	1	644010	Relief Fitting
12	1	675608	Worm	31	1	604510	Fitting, 6
13	1	775553	Adapter	32	1	656300	Gear Box Lube – 48 oz.
14	2	2705	O-Ring	33	1	668184	Sealant
15	1	670549	Check Valve ▲			670578	Shim Service Kit (items 3-6,25,33)
16	4	6444	Lockwasher			675637	Bearing Service Kit (items 21 & 33)
17	4	607059	Capscrew, 5/16 NC x 1.75 GR8			675638	Bearing Service Kit (items 3-7,25)
18	1	670575	Gasket			206394	Motor Kit-2.8 c.i. (items 11,14,18,19)

● Quantity as required.

■ See Drive Motor page for parts breakdown.

▲ See Check Valve page for parts breakdown.

Drive Motor



REF	QTY	PART NO.	DESCRIPTION
		206392	Drive Motor
1	1	675478	Shaft
2	1	675477	Drive
3	1	675479	Spacer Plate
4	1	675480	■ Gerotor Set (101-1768-007)
4	1	685075	■ Gerotor Set (101-1768-009)
5	1	675482	End Cap
6	1	206405	● Service Kit
7	1	685089	■ Flange (101-1768-007)
7	1	685090	■ Flange (101-1768-009)

Cascade provides service replacement parts for the listed parts only. Due to cost, if others parts need replacement, the complete drive motor should be replaced.

■ See Nameplate under valve for correct part number of Gerotor Set and Flange.

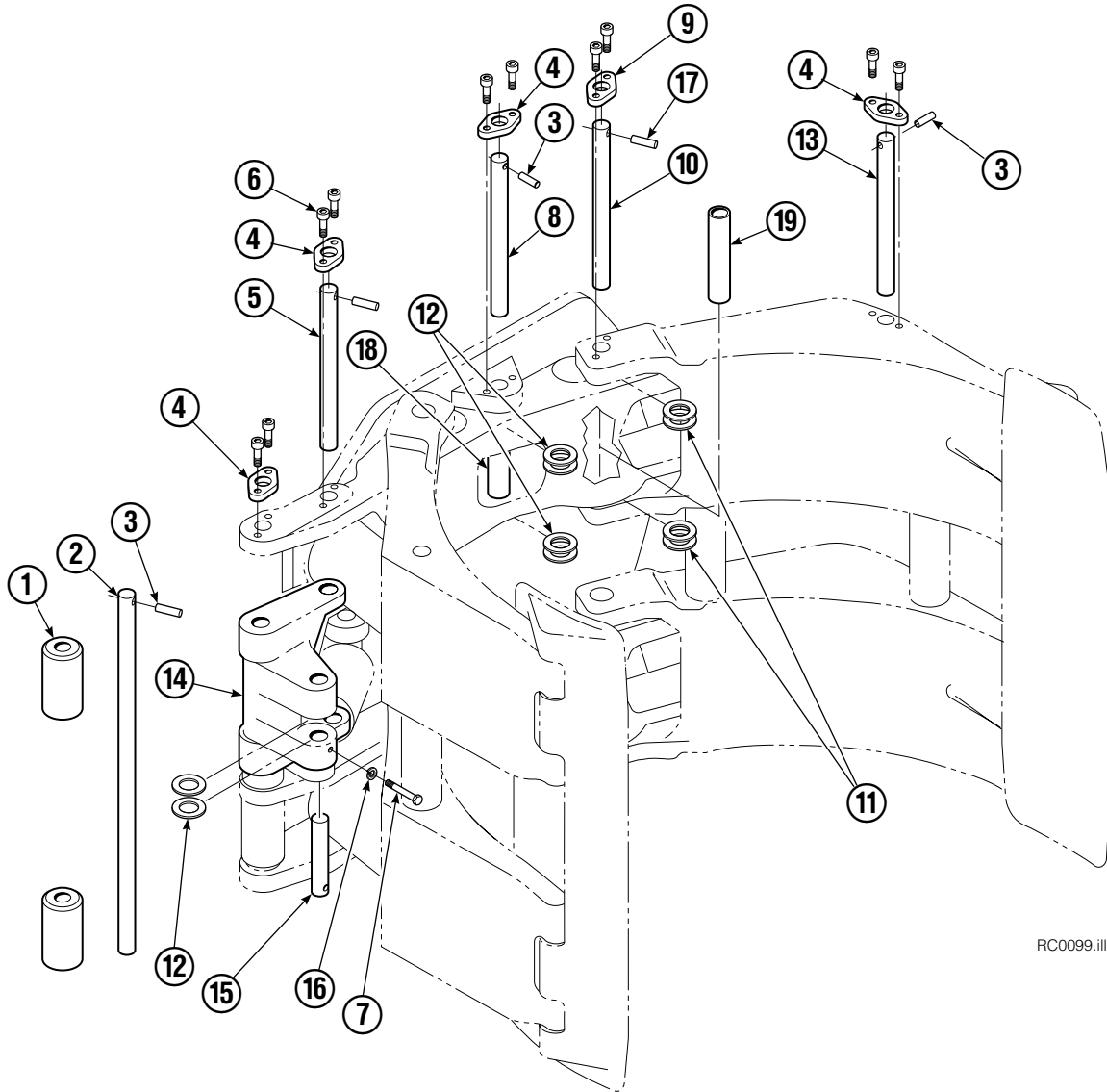
● Compatible with water glycol based hydraulic fluids.

Check Valve



REF	QTY	PART NO.	DESCRIPTION
		670549	Check Valve Assembly
1	2	609453	Fitting, 10
2	2	670552	Spring
3	2	670551	Guide
4	2	7020	Ball
5	2	602580	Fitting, 8
6	2	673989	Spring
7	1	670550	Body
8	1	670553	Spool

Common Components Group

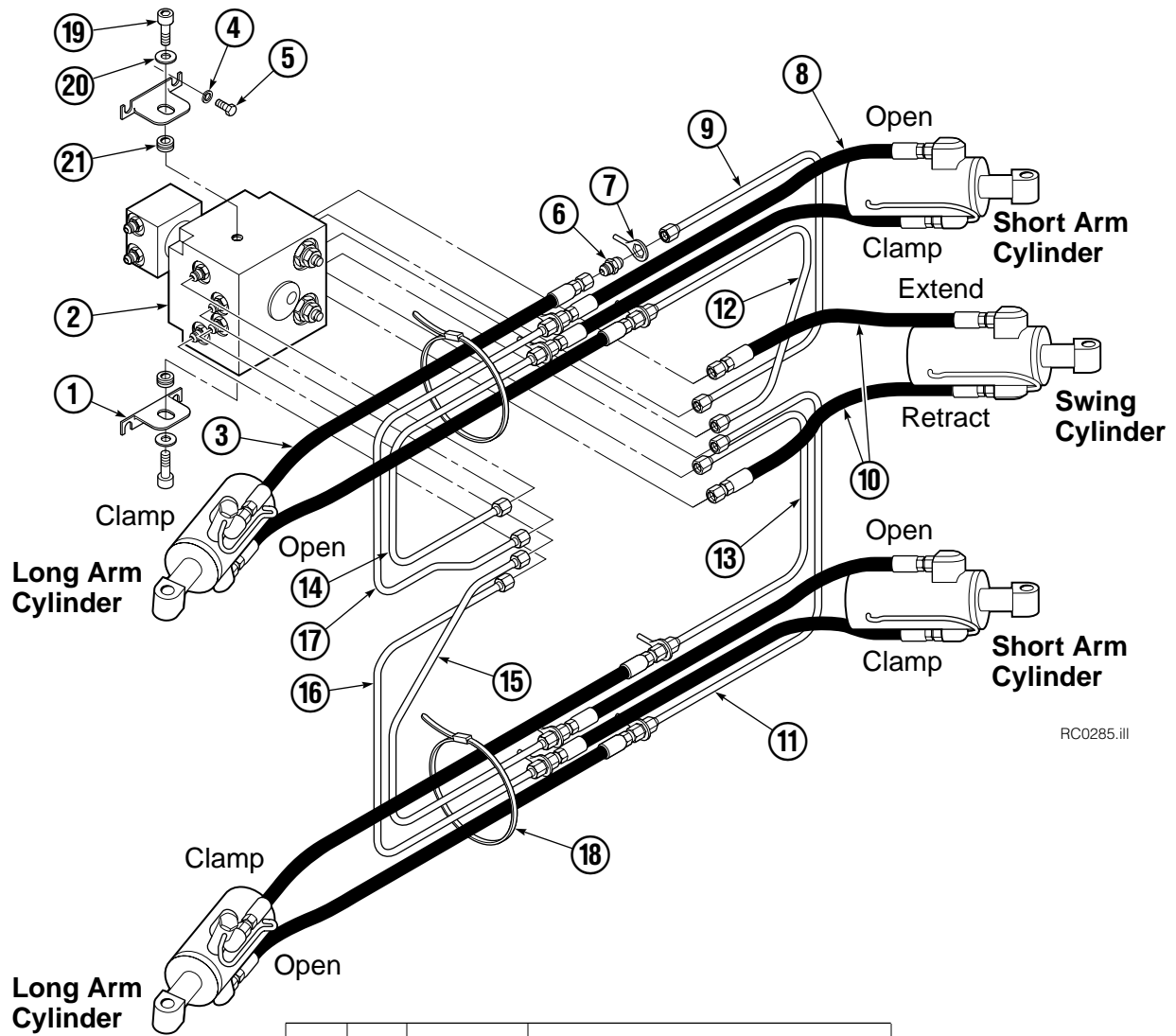


RC0099.iii

77F

REF	QTY	PART NO.	DESCRIPTION
		680638	Components Group
1	2	675024	Roller
2	1	675021	Pin
3	11	673385	Drive Pin
4	11	674828	Retainer
5	4	675018	Pin
6	30	4466	Capscrew, 3/8 NC x .50 GR8
7	2	643518	Capscrew, 5/16 NC x 2.25 GR8
8	2	675019	Pin
9	4	674830	Retainer
10	4	675022	Pin
11	16	673379	Shim
12	16	660200	Shim
13	4	680651	Pin
14	1	678521	Swing Casting
15	2	675023	Pin
16	2	6287	Lockwasher, 4/16 ID
17	4	675086	Drive Pin
18	2	681668	Spacer
19	4	681672	Spacer

Swing Frame Hosing Group

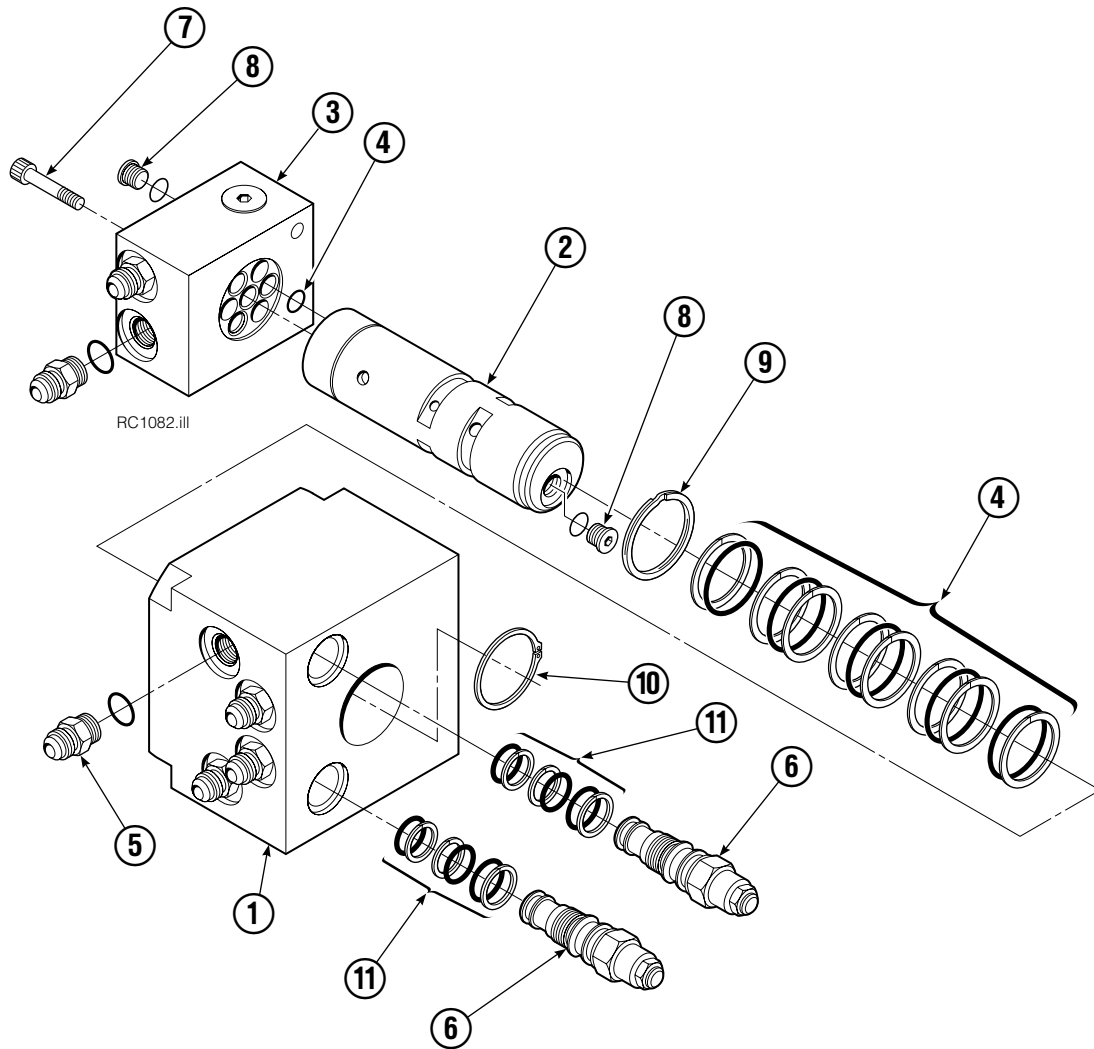


RC0285.iii

REF	QTY	PART NO.	DESCRIPTION
		3001225	Hosing Group
1	2	206606	Angle
2	1	396781	Revolving Connection ▲
3	4	678514	Hose, 31.5 in.
4	4	6288	Lockwasher, 3/8 in.
5	4	3600	Capscrew, 3/8 NC x .625
6	8	2347	Fitting, 6-6
7	8	674743	Eye Bolt
8	4	675053	Hose, 26.00 in.
9	1	675051	Tube
10	2	675055	Hose, 17.50 in.
11	1	675049	Tube
12	1	675050	Tube
13	1	675048	Tube
14	1	675047	Tube
15	1	675045	Tube
16	1	675044	Tube
17	1	675046	Tube
18	2	649086	Cable Tie
19	2	665992	Shoulder Bolt
20	2	209021	Washer
21	2	208765	Grommet

▲ See Revolving Connection page for parts breakdown.
Reference: SK-5831, Common Parts 396780.

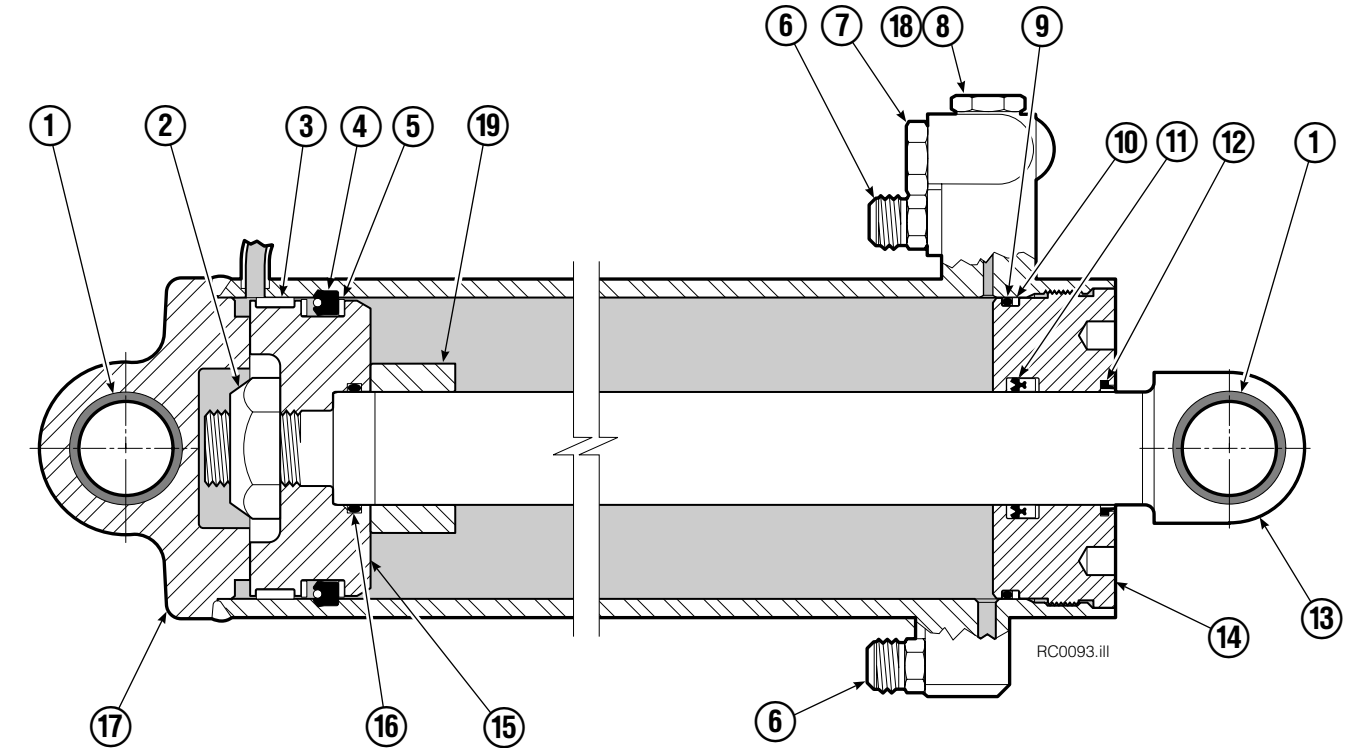
Swing Frame Revolving Connection



77F			
REF	QTY	PART NO.	DESCRIPTION
		396781	Revolving Connection
1	1	207443	Body
2	1	397513	Shaft
3	1	680451	End Block
4	1	674777	Service Kit
5	14	604511	Fitting, 6-6
6	2	674732	Counterbalance Valve
7	3	768800	Capscrew, M8 x 1.25 x 45-8.8
8	5	663694	Fitting, 3
9	1	7341	Snap Ring
10	1	3138	Snap Ring
11	1	667516	Service Kit

Reference: 208798.

Short Arm Cylinder

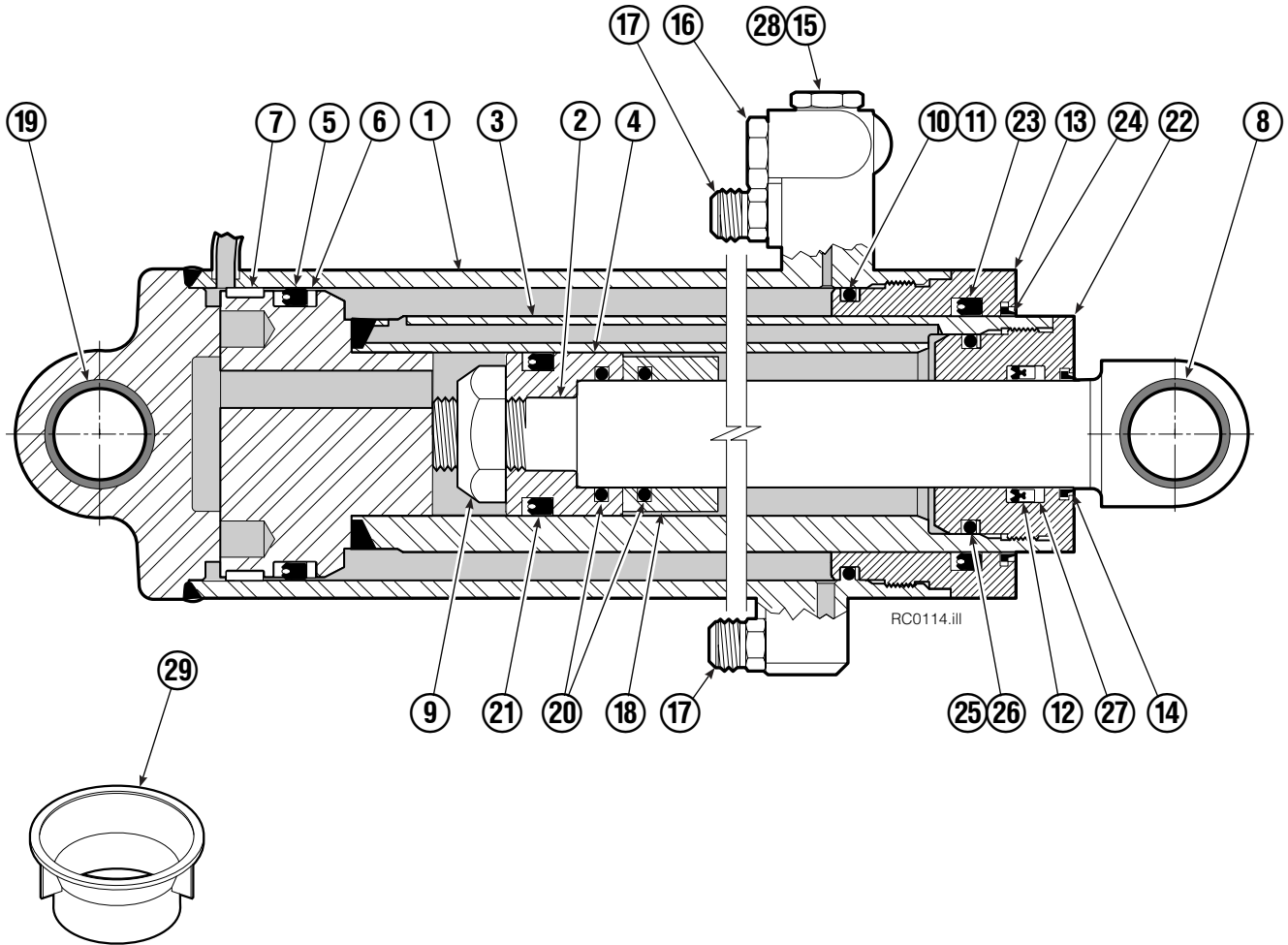


REF	QTY	PART NO.	DESCRIPTION
		557362	Cylinder Assembly
1	3	674843	Bearing
2	1	560997	Nut
3	1	674843	◆ Bearing
4	1	662462	◆ Seal
5	2	638295	◆ Back-Up Ring
6	2	604511	Fitting, 6-6
7	1	556852	Fitting, 4
8	1	557212	Check Valve
9	1	2801	◆ O-Ring
10	1	562731	◆ Back-Up Ring
11	1	554598	◆ Seal
12	1	628047	◆ Wiper
13	1	555392	Rod
14	1	555724	Retainer
15	1	557389	Piston
16	1	2722	◆ O-Ring
17	1	555741	Shell
18	1	667516	Check Valve Service Kit
19	1	—	Spacer
20	1	669243	Seal Loader
		555725	Service Kit

◆ Included in Service Kit 555725.

Reference: S-5313, S-5314.

Cylinder

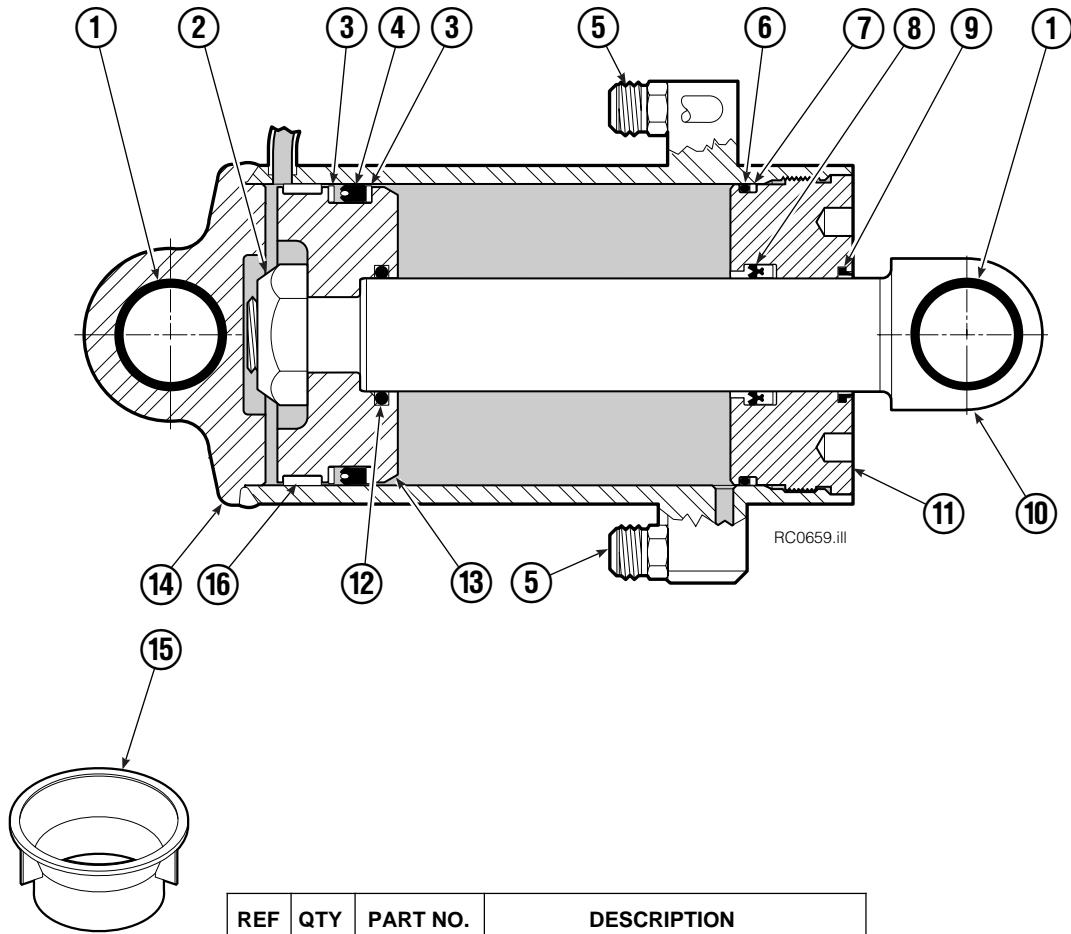


REF	QTY	PART NO.	DESCRIPTION	REF	QTY	PART NO.	DESCRIPTION
		342735	Cylinder Assembly	16	1	556852	Fitting, 4
1	1	556597	Shell	17	2	604511	Fitting, 6-6
2	1	559680	Rod	18	1	559735	Spacer
3	1	559681	Plunger	19	2	675006	Bearing
4	1	559684	Piston	20	2	2722	◆ O-Ring
5	1	662462	◆ Seal	21	1	647870	◆ Seal
6	2	638295	◆ Nylon Ring	22	1	667675	Retainer
7	1	660789	◆ Ring - Wear	23	1	553524	◆ Seal
8	1	674843	◆ Bearing	24	1	636860	◆ Wiper
9	1	580997	Nut	25	1	2791	◆ O-Ring
10	1	2801	◆ O-Ring	26	1	615134	◆ Back-up Ring
11	1	583977	◆ Back-up Ring	27	1	638246	◆ Nylon Ring
12	1	554598	◆ Seal	28	1	667516	Check Valve Service Kit
13	1	559685	Retainer	29	1	672910	Seal Loader Kit
14	1	564930	◆ Wiper			559837	Service Kit
15	1	557212	Check Valve				

◆ Included in Service Kit 559837.

Ref: S-6114, S-6115.

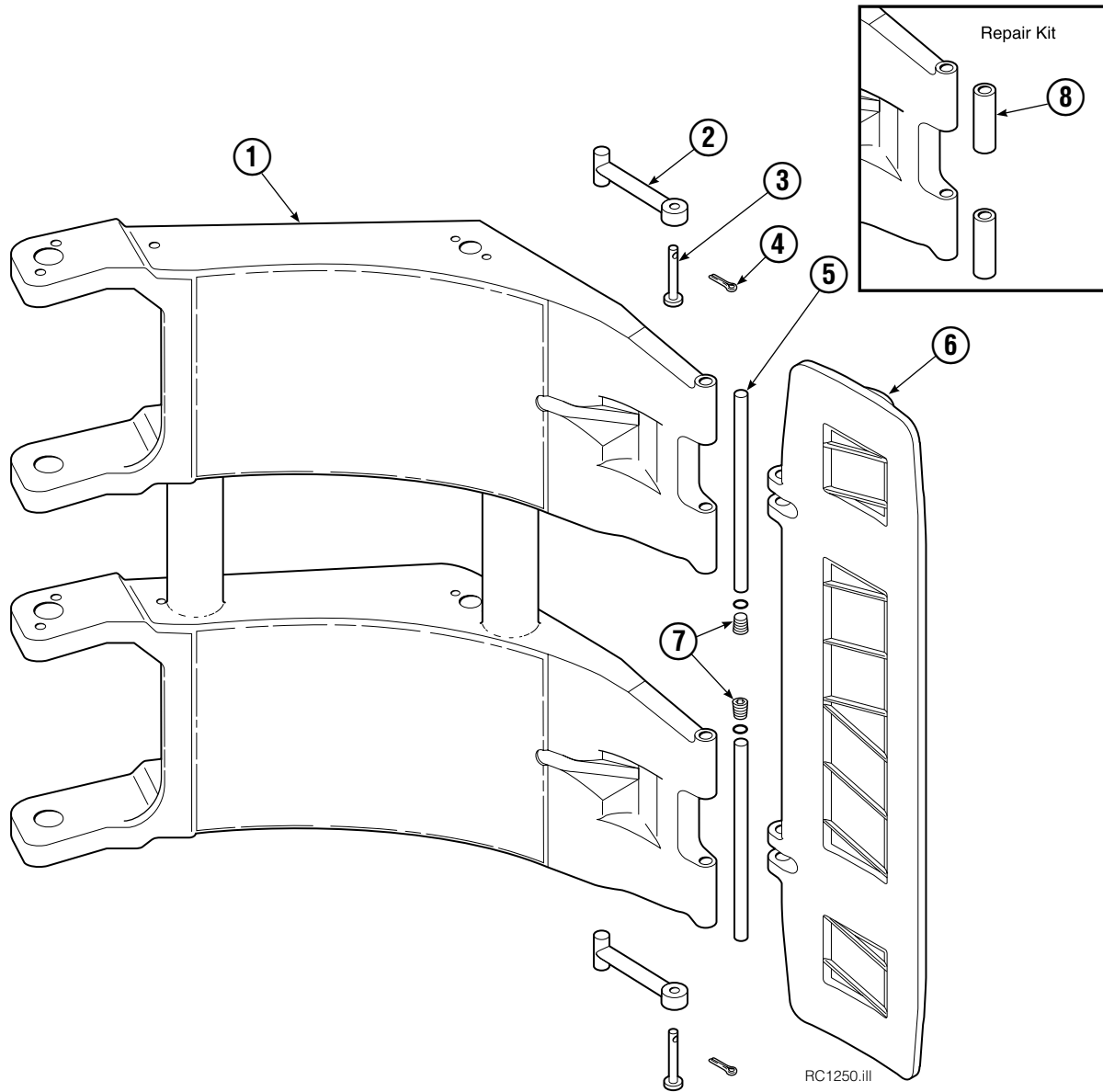
Swing Cylinder



REF	QTY	PART NO.	DESCRIPTION
		580034	Cylinder Assembly
1	3	674843	Bearing
2	1	561997	Nut
3	2	638295	◆ Back-Up Ring
4	1	557446	◆ Seal
5	2	604511	Fitting, 6-6
6	1	2801	◆ O-Ring
7	1	563977	◆ Back-Up Ring
8	1	554598	◆ Seal
9	1	564930	◆ Wiper
10	1	557713	Rod
11	1	555724	Retainer
12	1	2722	◆ O-Ring
13	1	557389	Piston
14	1	555776	Shell
15	1	672910	◆ Seal Loader
16	1	660769	Bearing
		555725	Service Kit

◆ Included in Service Kit 555725.

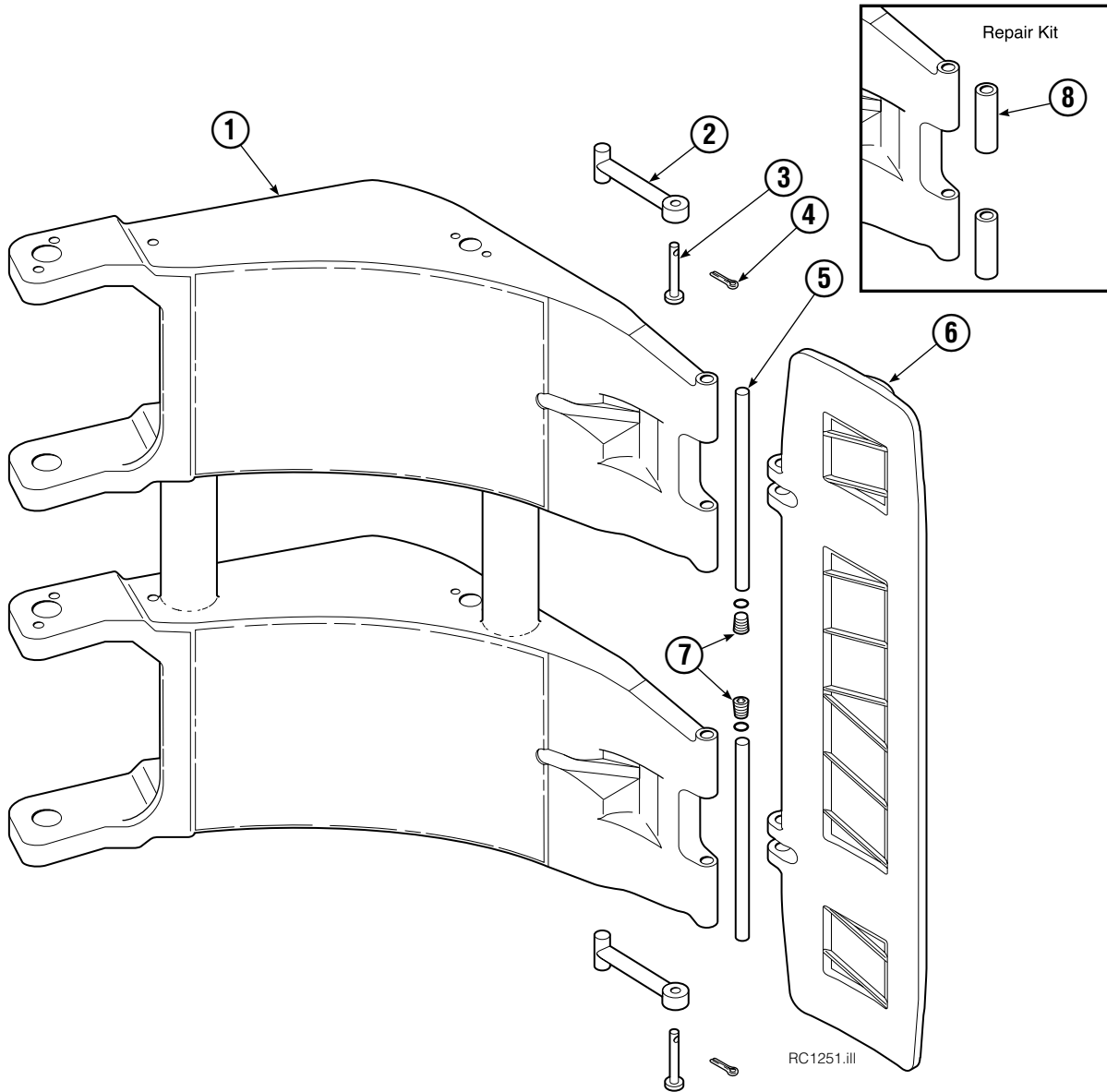
Contact Pad and Short Arm



77F			
REF	QTY	PART NO.	DESCRIPTION
		398938	Contact Pad Group ●
1	1	678537	Short Arm
2	2	674994	Link
3	2	682978	Clevis Pin
4	2	6525	Cotter Pin
5	2	674993	Pin
6	1	338707	Contact Pad
7	2	689900	Plug
8	1	676810	Arm Tip Repair Kit

● Includes items 2 through 7 only.

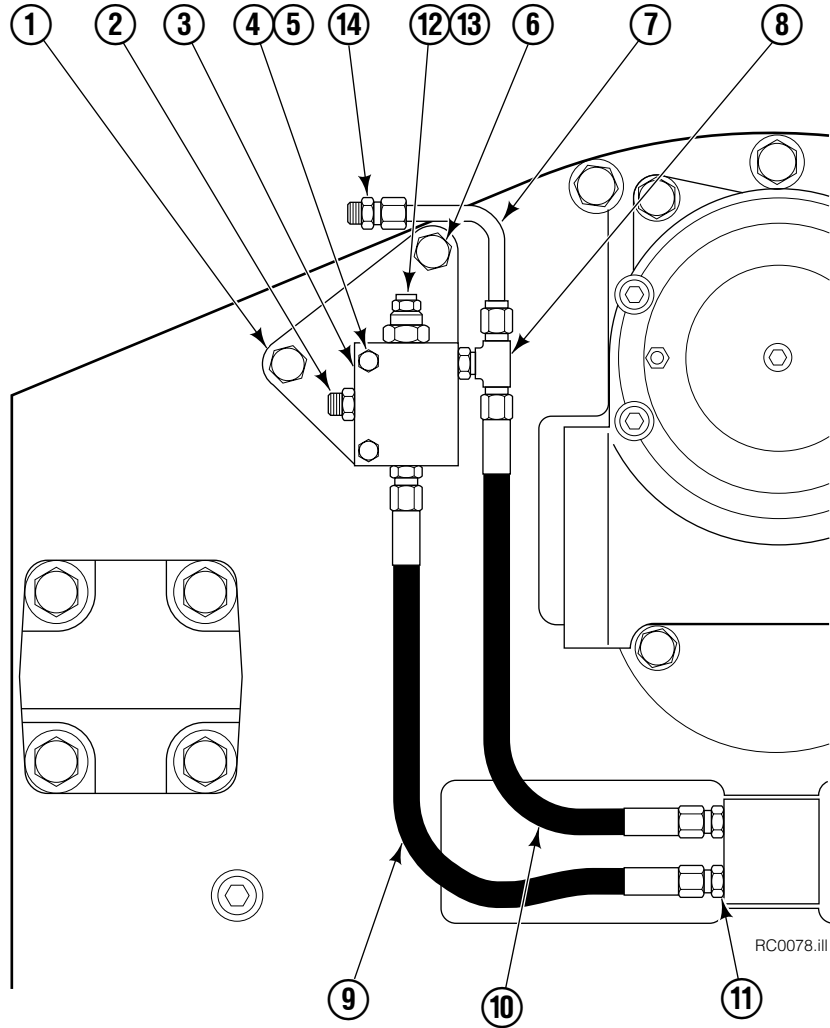
Contact Pad and Long Arm



77F			
REF	QTY	PART NO.	DESCRIPTION
		398938	Contact Pad Group ●
1	1	680481	Long Arm
2	2	674994	Link
3	2	682978	Clevis Pin
4	2	6525	Cotter Pin
5	2	674993	Pin
6	1	338707	Contact Pad
7	2	689900	Plug
8	1	676810	Arm Tip Repair Kit

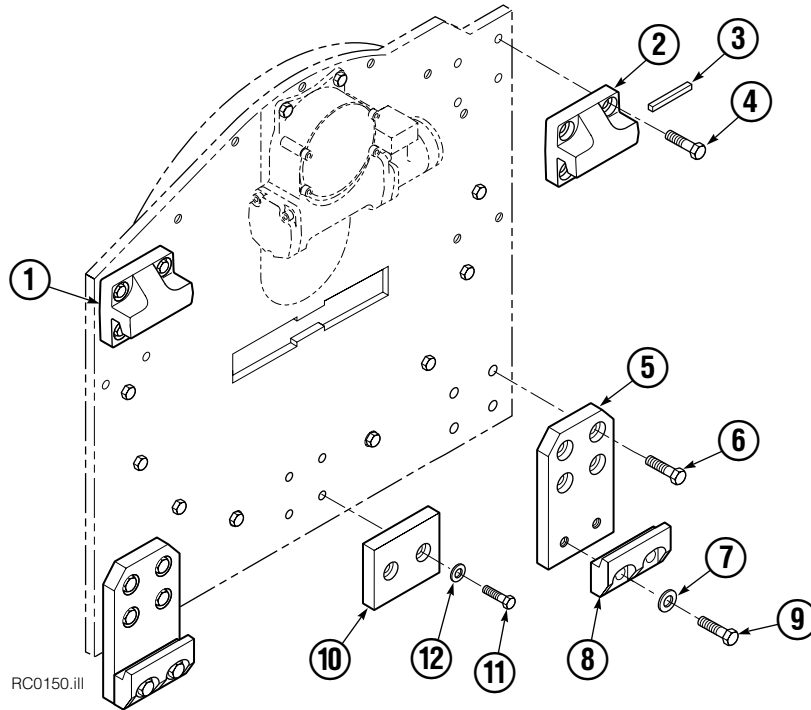
● Includes items 2 through 7 only.

Counterbalance Valve Kit



77F			
REF	QTY	PART NO	DESCRIPTION
		359317	Counterbalance Valve Kit
1	1	358454	Bracket
2	2	611288	Fitting, 6-8
2	1	607486	Fitting, 8-8
3	1	358455	Valve Assembly
4	2	360785	Capscrew
5	2	6287	Lockwasher
6	2	201266	Capscrew
7	1	321589	Tube
8	1	611311	Fitting, 6-6-6
9	1	200012	Hose
10	1	360795	Hose
11	2	604511	Fitting, 6-6
12	1	201267	Valve Cartridge
13	1	667516	Valve Cartridge Service Kit
14	1	2347	Fitting, 6-6
14	1	607486	Fitting, 8-8

Bolt-On Mounting Group



RC0150.iii

Class IV, 0°			
REF	QTY	PART NO.	DESCRIPTION
		678504	Mounting Group
1	1	675062	Upper Hook – LH
2	1	675061	Upper Hook – RH
3	1	670704	Stop Kit
4	8	675078	Capscrew, 3/4 NC x 1.50
5	2	675082	Extension
6	8	673387	Capscrew, 5/8 NC x 1.75
7	4	670692	Washer
8	2	679832	Lower Hook
9	4	675079	Capscrew, 3/4 NC x 2.00
10	1	675081	Center Spacer
11	2	4472	Capscrew, 3/8 NC x 1.50
12	2	6372	Lockwasher, 3/8 in. ID

Do you have questions you need answered right now? Call your nearest Cascade Parts Department. Visit us online at www.cascorp.com

Cascade Corporation
2501 Sheridan Avenue
Springfield, OH 45505
Tel: 888-CASCADE (227-2233)
FAX: 888-329-0234

Cascade Canada Inc.
5570 Timberlea Blvd.
Mississauga, Ontario
Canada L4W-4M6
Tel: 905-629-7777
FAX: 905-629-7785

Cascade GmbH
D-41199 Monchengladbach
Klosterhofweg 52
Germany
Tel: 49-216-668230
FAX: 49-216-6682323

Cascade Finland
Albert Petreliuksenkatu 3
01370 Vantaa
Finland
Tel: 358-9-836-1925
FAX: 358-9-836-1935

**Cascade N.V.
European Headquarters**
P.O. Box 3009
1300 El Almere
Damluisweg 56
1332 ED Almere
The Netherlands
Tel: 31-36-5492911
FAX: 31-36-5492964

**Cascade N.V.
Benelux Sales and Service**
P.O. Box 3009
1300 El Almere
Damluisweg 56
1332 ED Almere
The Netherlands
Tel: 31-36-5492950
FAX: 31-36-5492974

Cascade (UK) Ltd.
15, Orgreave Crescent
Dore House Industrial Estate
Handsworth
Sheffield S13 9NQ
England
Tel: 742-697524
FAX: 742-695121

Cascade Scandinavia AB
Box 124
Hammarvägen 10
567 23 Vaggeryd
Sweden
Tel: 42-0-393-36950
FAX: 46-0-393-36959

Cascade Norway
Østerliveien 37A
1153 Oslo
Norway
Tel: 47-22-743160
FAX: 47-22-743157

Cascade France S.A.R.L.
1D Rue De Charaintru
BP 18, 91360 Epinay-Sur-Orge
Morangis Cedex, France
Tel: 33-1- 64547500
FAX: 33-1-64547501

Cascade Hispania S.A.
Carrer 5 Sector C
Zona Franca Duanera
Poligono de la Zon Franca
08040 Barcelona, Spain
Office No. 256
Tel: 93-264-07-30
FAX: 93-264-07-31

Cascade Japan Ltd.
5-5-41,
Torikai Kami
Settsu, Osaka
Japan, 566
Tel: 81-726-53-3490
FAX: 81-726-53-3497

Cascade Korea
108B, Namdong Ind Complex
658-3 Gojan-Dong
Namdong-Gu
Inchon, 405-310 Korea
Tel: 82-32-821-2051
FAX: 82-32-821-2055

Cascade Australia
1445 Ipswich Road
Rocklea, QLD 4106
Australia
Tel: 1-800227-223
FAX: (07) 3373-7333

Cascade New Zealand
15 Ra Ora Drive
East Tamaki, Auckland
New Zealand
Tel: 9-273-9136
FAX: 9-273-9137

Cascade (Africa) Pty. Ltd.
P.O. Box 625, Isando 1600
60A Steel Road
Sparton, Kempton Park
South Africa
Tel: 27-11-975-9240
FAX: 27-11-394-1147

Cascade-Xiamen
No. 668 Yangguang Rd.
Xinyang Industrial Zone
Haicang, Xiamen City
Fujian Province
P.R. China 361026
Tel: 86-592-651-2500
FAX: 86-592-651-2571

**Cascade (Singapore)
Trading Co.**
Four Seasons Park
Autumn Block - Apt. 1802
12 Cuscaden Walk
Singapore
Tel: 65-834-1935
FAX: 65-834-1936

