



# Parts Manual

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Model 77F Roll Clamp

Serial Number 77F-RCF-02BR2

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**cascade**<sup>®</sup>  
corporation

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**Internet:** [www.cascorp.com](http://www.cascorp.com)

# Safety Decals

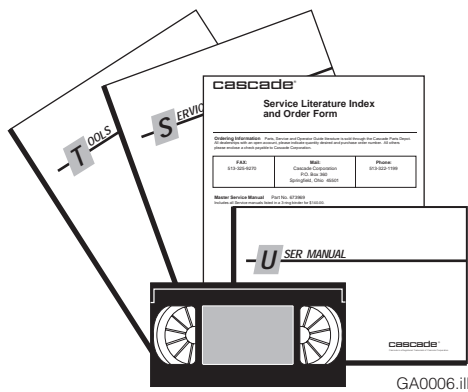


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Roll Clamp Safety Decals			
REF	QTY	PART NO.	DESCRIPTION
1	6	665595	No Hand Hold Decal
2	3	660269	Short Arm Rotation Position Decal
3	4	656038	Caution Decal
4	4	679150	No Step Decal
5	4	665677	Trapped Pressure Decal
6	1	679059	Quick-Change Hook Decal

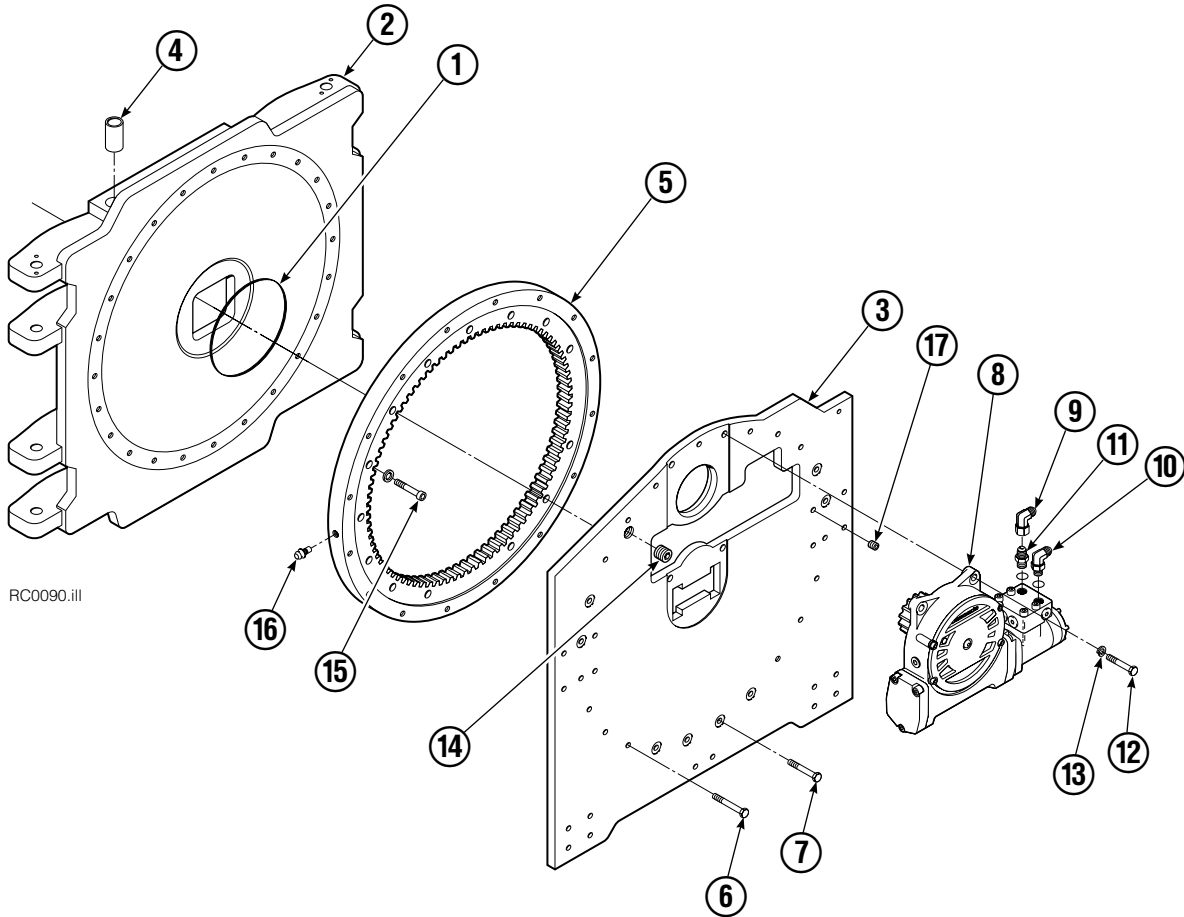
# Publications



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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



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77F			
REF	QTY	PART NO.	DESCRIPTION
		682202	Frame Group
1	1	670931	Seal
2	1	682437	Faceplate
3	1	678381	Baseplate
4	8	675007	Bushing
5	1	672830	Bearing Assembly
6	13	643539	Capscrew, .50 x 1.75
7	11	643538	Capscrew, .50 x 1.50
8	1	795492	Drive Group ●
9	1	605761	Fitting, 8-8
10	1	601250	Fitting, 8-8
11	1	601377	Fitting, 8-8
12	4	661742	Capscrew, .50 x 1.25
13	17	6290	Lockwasher
14	1	6605	Plug
15	24	4507	Capscrew, .50 x 1.75
16	1	7401	Grease Fitting
17	4	631385	Plug
	1	672842	Bearing Service Kit (items 5 and 15)

● See Drive Group page for parts breakdown.

Reference: Common Parts Group 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			685227	Motor Kit-4.5 (items 4,14,18)

● 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.

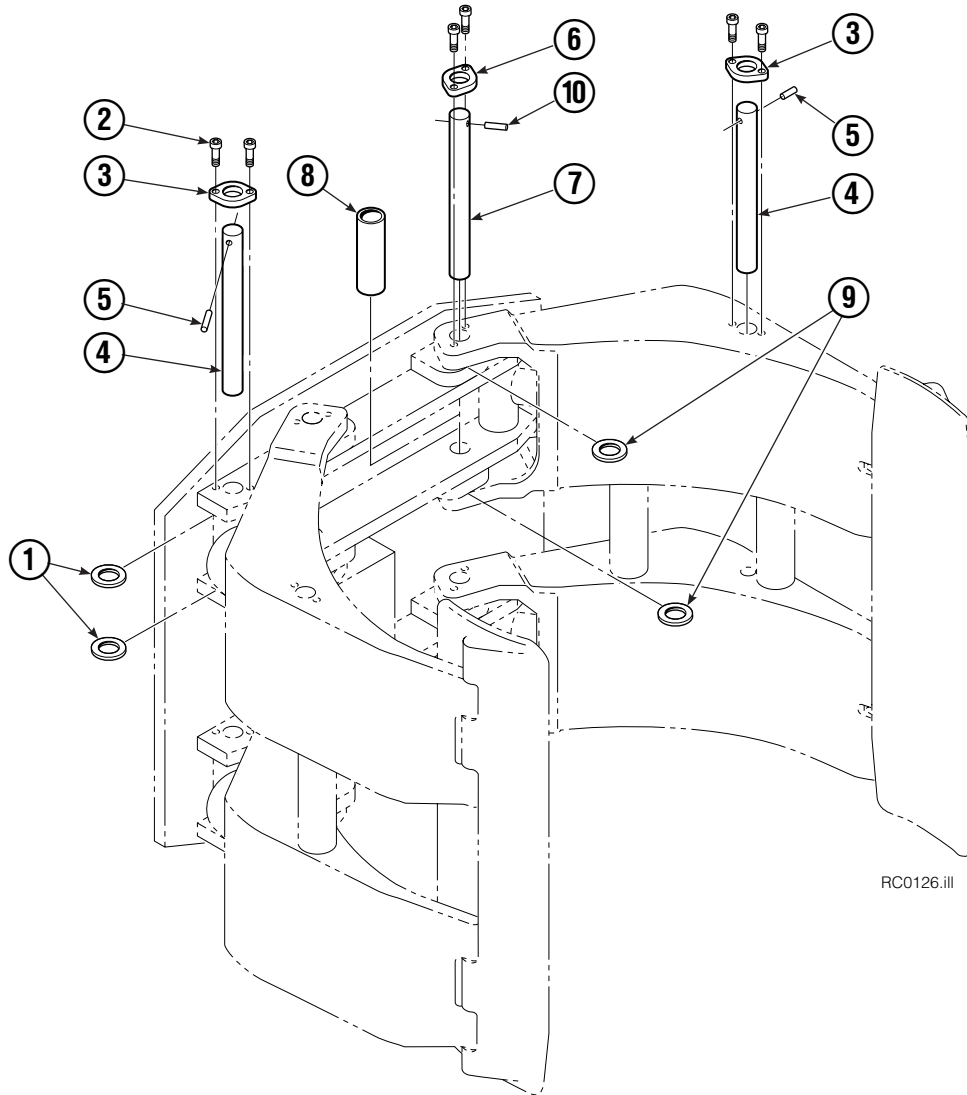
● Compatible with water glycol based hydraulic fluids.

# 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

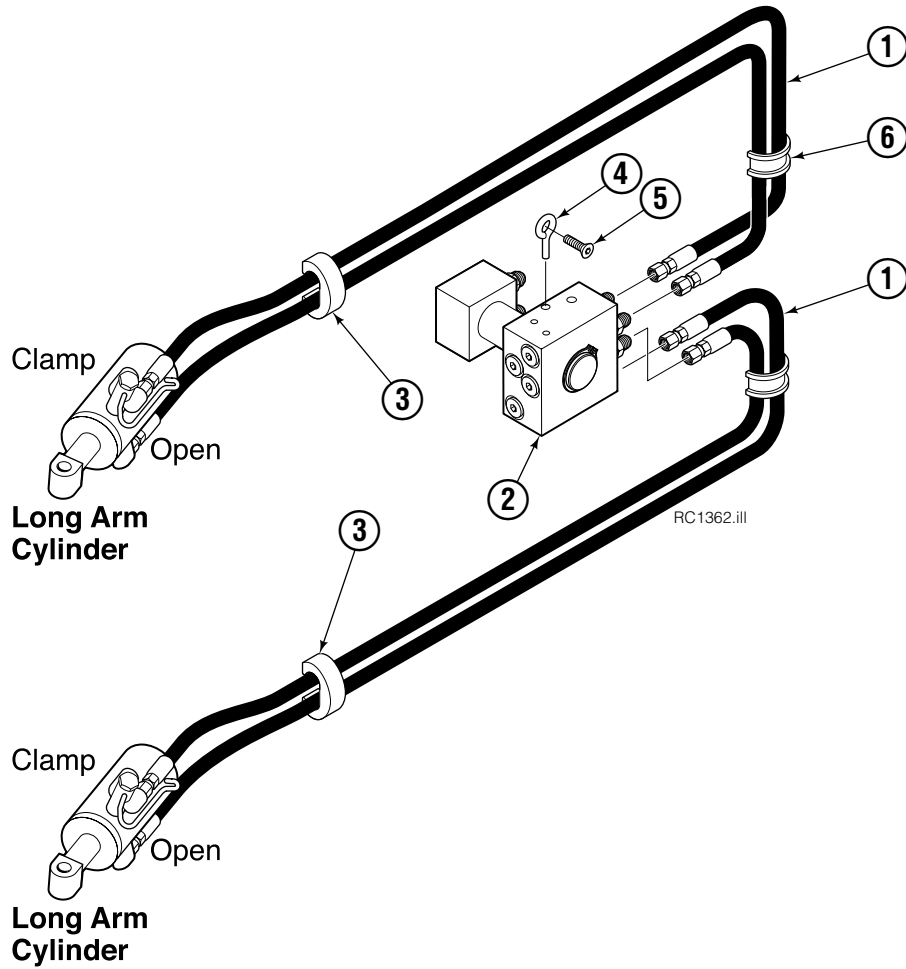
# Common Components Group



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77F			
REF	QTY	PART NO.	DESCRIPTION
		680637	Components Group
1	8	660200	Shim
2	24	4466	Capscrew, 3/8 NC x .50 GR8
3	8	674828	Retainer
4	8	680651	Pin
5	8	673385	Drive Pin
6	4	674830	Retainer
7	4	675022	Pin
8	4	681673	Spacer
9	16	673379	Shim
10	4	675086	Drive Pin

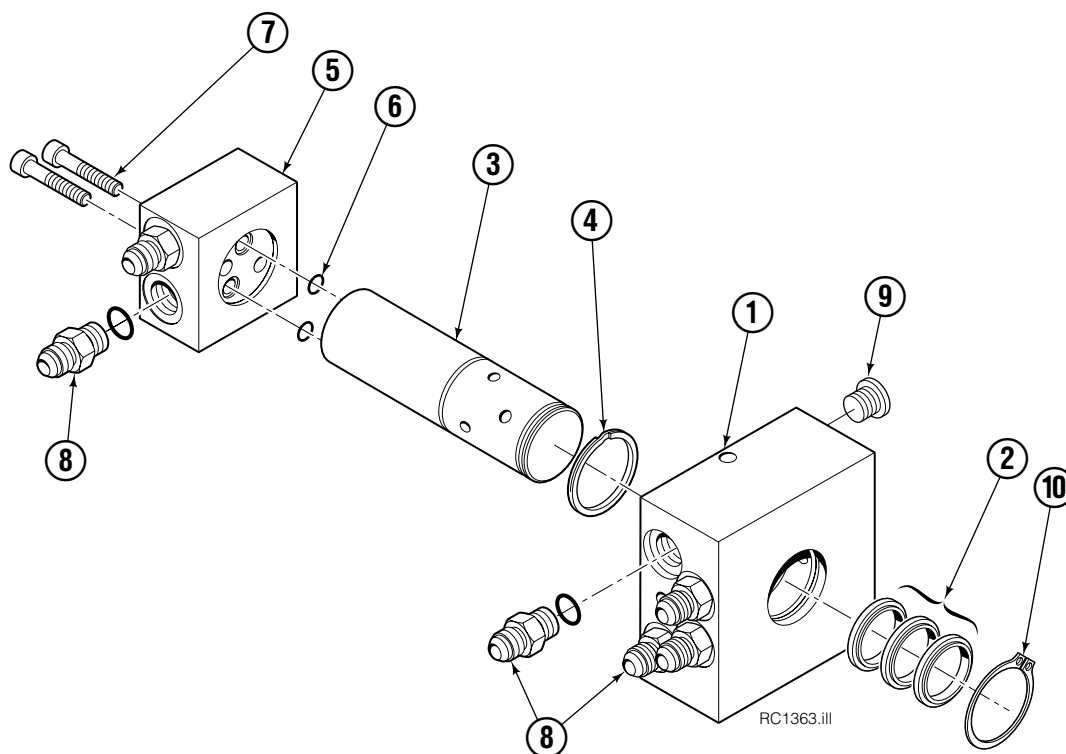
# Hosing Group Fixed Short Arm



REF	QTY	PART NO.	DESCRIPTION
		6025866	Hose Group
1	4	680238	Hose, 58.75 in.
2	1	6025589	Revolving Connection ▲
3	2	673417	Segment
4	2	227962	Eye Pin
5	2	4751	Capscrew
6	2	680114	Insert

▲ See Revolving Connection page for parts breakdown.

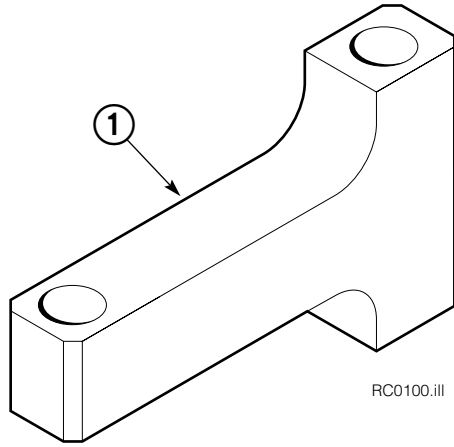
# Revolving Connection Fixed Short Arm



77F			
REF	QTY	PART NO.	DESCRIPTION
		6025589	Revolving Connection Group
1	1	6023358	Valve Body
2	3	214649	◆ Seal
3	1	6023343	Shaft
4	1	7341	◆ Retaining Ring
5	1	6023344	End Block
6	2	684587	◆ O-Ring
7	2	768798	Capscrew, M8 x 40
8	6	604511	Fitting, 6-6
9	4	604510	Fitting, 6-6
10	1	3138	◆ Retaining Ring

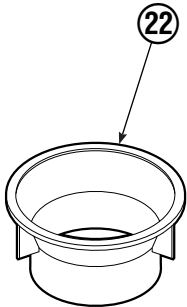
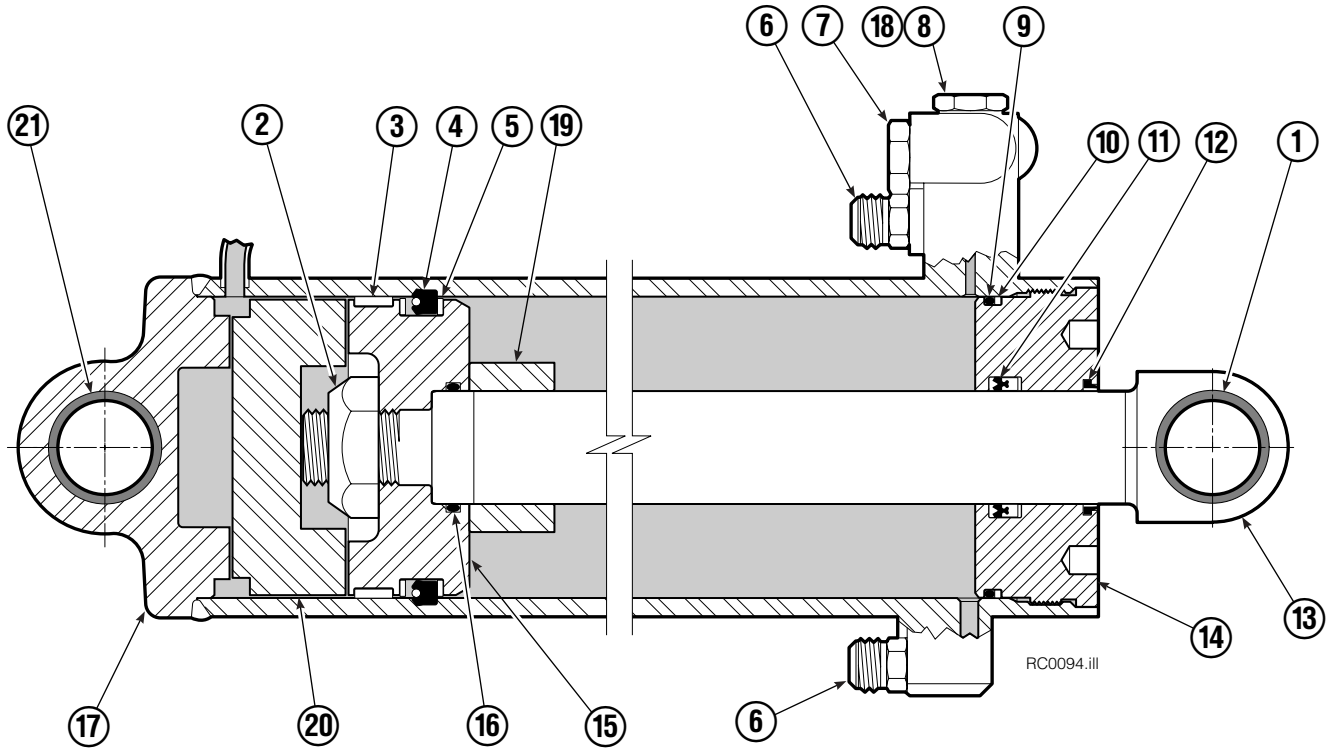
◆ Included in Service Kit 6026296.

# Link



REF	QTY	PART NO.	DESCRIPTION
1	2	675098	Link

# Long Arm Cylinder

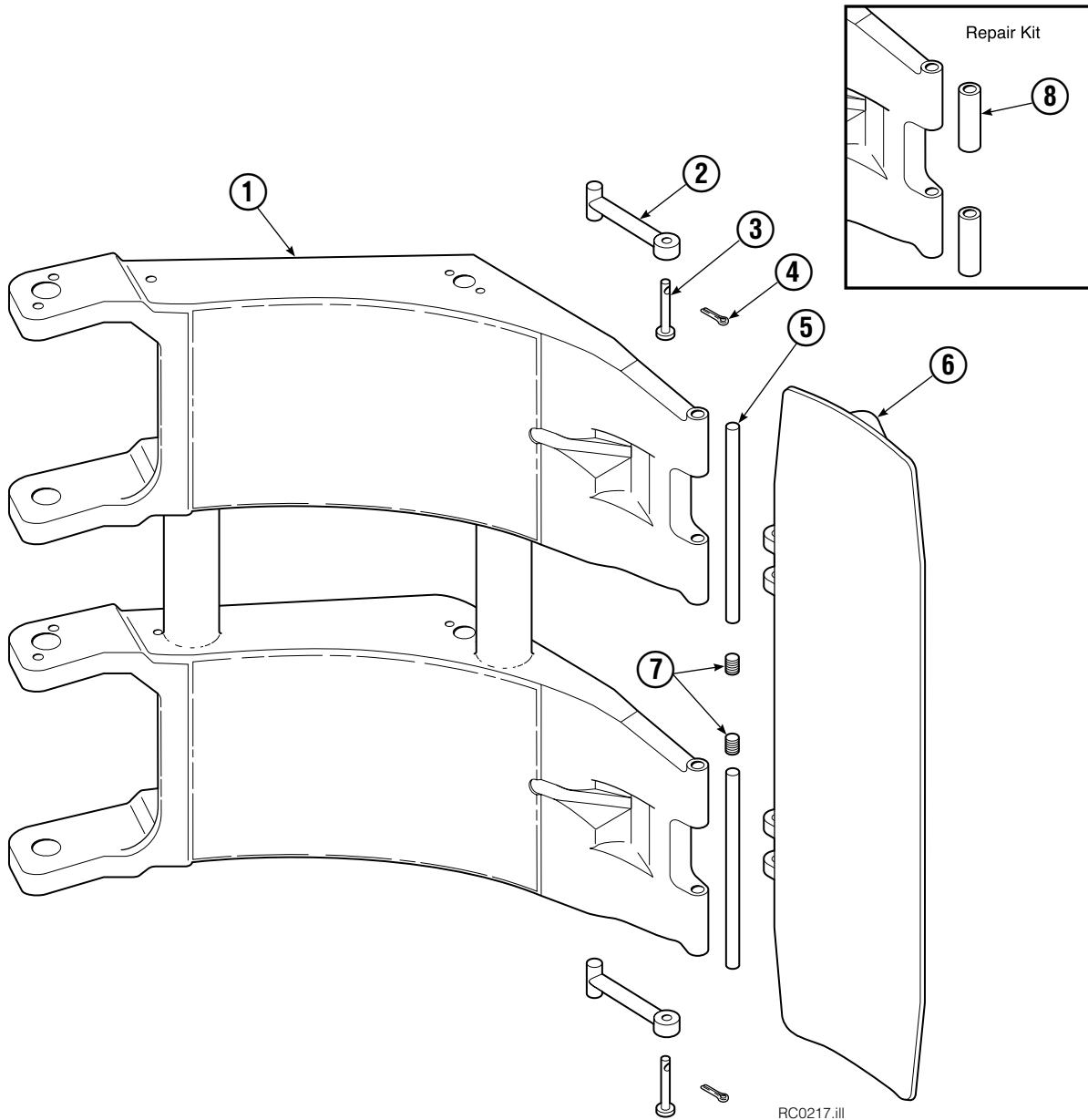


REF	QTY	PART NO.	DESCRIPTION
		557380	Cylinder Assembly
1	1	674843	Bearing
2	1	560997	Nut
3	1	660769	◆ Bearing
4	1	662462	◆ Seal
5	2	638295	◆ Back-Up Ring
6	2	604511	Fitting, 6-6
7	1	556852	Fitting, 4
8	1	557212	Check Valve
9	1	2801	◆ O-Ring
10	1	563977	◆ Back-Up Ring
11	1	554598	◆ Seal
12	1	564930	◆ Wiper
13	1	557399	Rod
14	1	555724	Retainer
15	1	557389	Piston
16	1	2722	◆ O-Ring
17	1	555718	Shell
18	1	667516	Check Valve Service Kit
19	1	—	Spacer
20	1	—	Spacer
21	2	675006	Bearing
22	1	669243	Seal Loader
		555725	Service Kit

◆ Included in Service Kit 555725.

Reference: S-5320, S-5321.

# Contact Pad Group & Short Arm

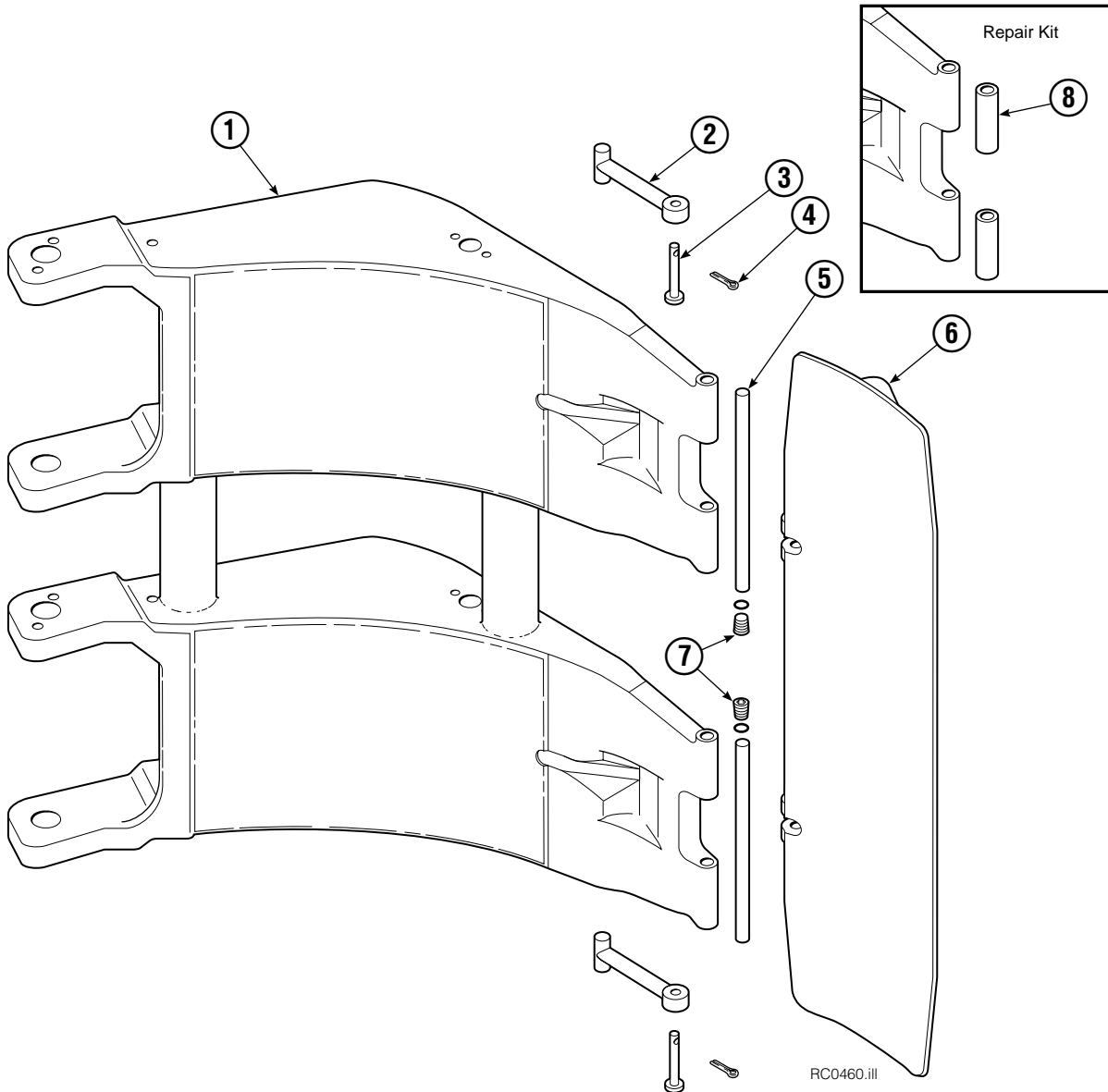


REF	QTY	PART NO.	DESCRIPTION
		674948	Contact Pad Group ●
1	1	678537	Short Arm ▲
2	2	674994	Link
3	2	682978	Clevis Pin
4	2	6525	Cotter Pin
5	2	674993	Pin
6	1	674962	Contact Pad
7	2	689900	Plug
8	1	676810	Arm Tip Repair Kit

● Includes items 2–7.

▲ Not included in Contact Pad Group.

# Contact Pad Group & Long Arm

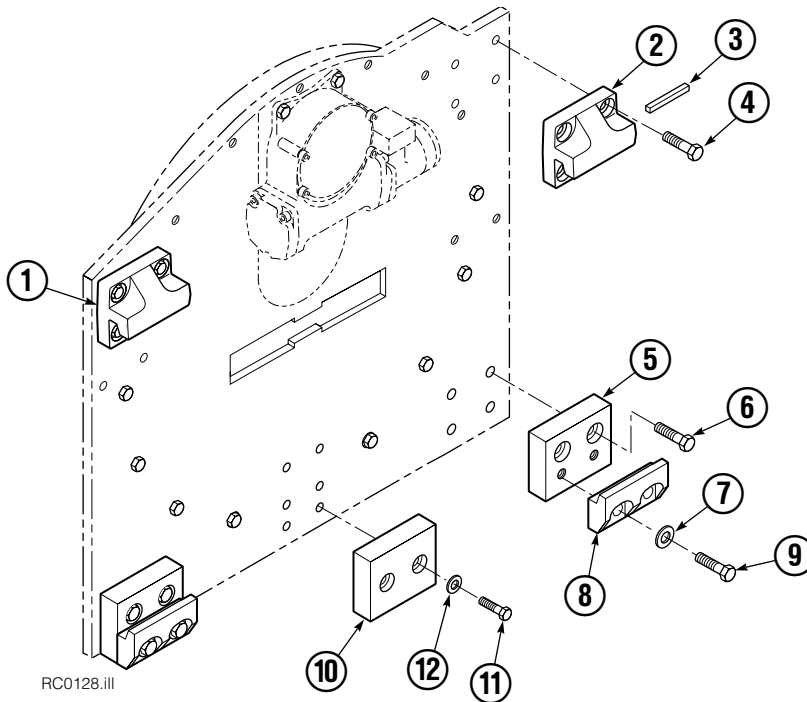


REF	QTY	PART NO.	DESCRIPTION
		206598	Contact Pad Group ●
1	1	680479	Long Arm ▲
2	2	674994	Link
3	2	682978	Clevis Pin
4	2	6525	Cotter Pin
5	2	674701	Pin
6	1	206601	Contact Pad
7	2	689900	Plug
8	1	676810	Arm Tip Repair Kit

● Includes items 2-7.

▲ Not included in Contact Pad Group.

# Bolt-On Mounting Group



Class III, 0°			
REF	QTY	PART NO.	DESCRIPTION
		678502	Mounting Group
1	1	670684	Upper Hook – LH
2	1	670685	Upper Hook – RH
3	1	670704	Stop Kit
4	8	667765	Capscrew, 5/8 NC x 1.50
5	2	675080	Spacer
6	4	673387	Capscrew, 5/8 NC x 1.75
7	4	667225	Washer
8	2	675969	Lower Hook
9	4	674252	Capscrew, 5/8 NC x 2.75
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](http://www.cascorp.com)

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