



# Parts Manual

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Model 25D Drum Clamp

Serial Number 25D-DTB-01AR0

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**cascade**<sup>®</sup>  
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

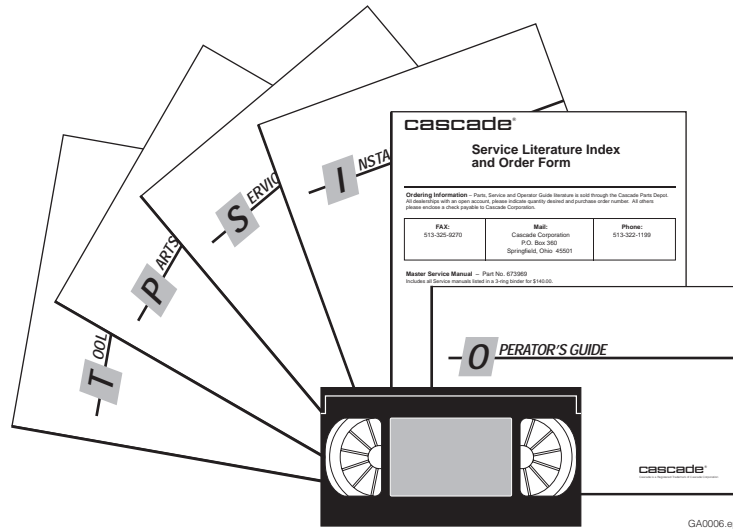
**Internet:** [www.cascorp.com](http://www.cascorp.com)

# Safety Decals



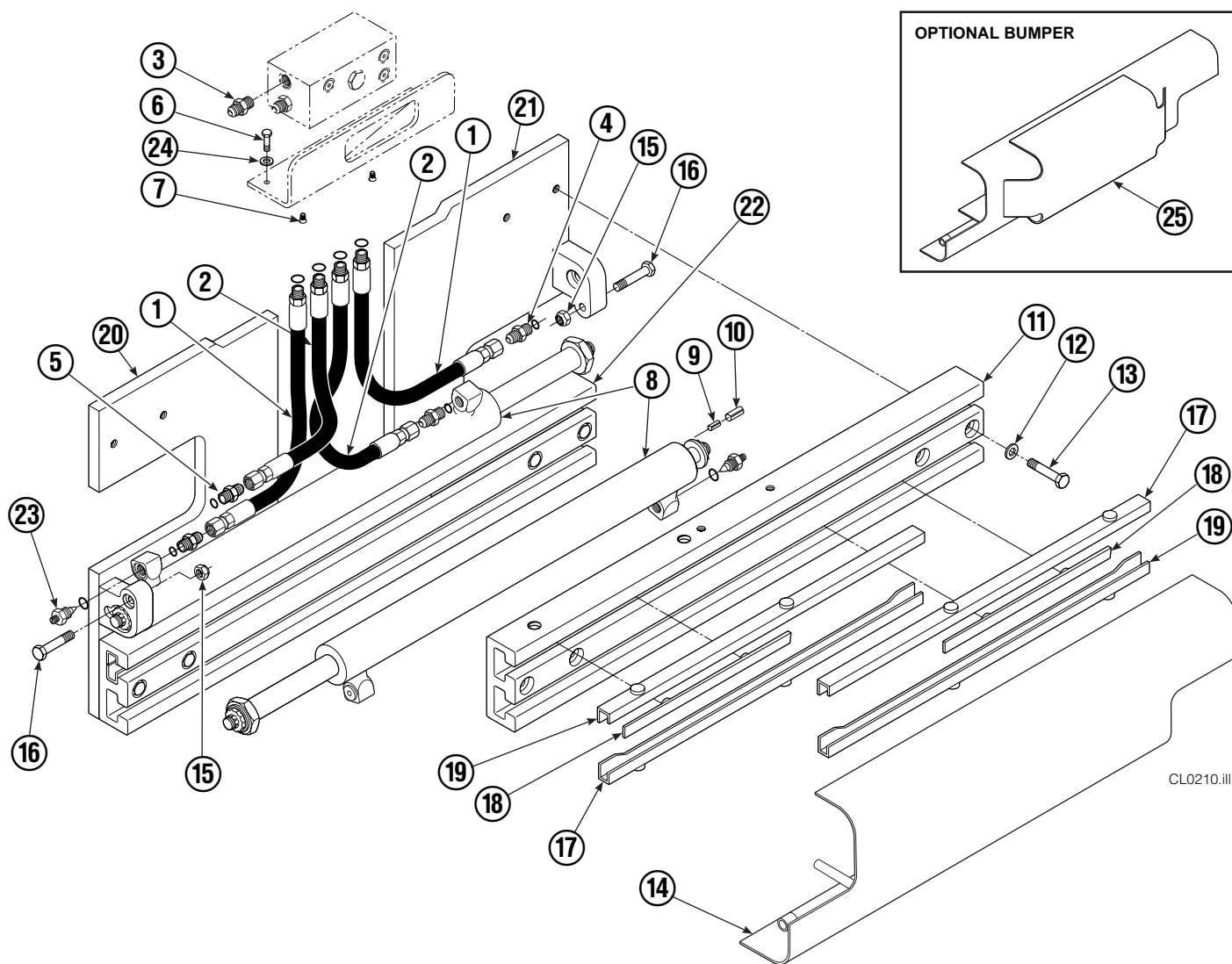
REF	QTY	PART NO.	DESCRIPTION
1	1	679150	No Step Decal
2	2	665595	No Hand Hold Decal
3	1	679059	Quick Change Hook Decal

# Publications



PART NO.	DESCRIPTION
669224	Service Manual
672944	Operators Guide
668987	Installation Instructions
680664	Servicing Cascade Cylinders-VHS
679929	Tool Catalog
673964	Literature Index Order Form

# Base Unit Group



CL0210.iii

25D							
REF	QTY	PART NO.	DESCRIPTION	REF	QTY	PART NO.	DESCRIPTION
		681352	Base Unit Group	13	8	668010	Capscrew
1	2	210442	Hose, 21.00 in.	14	1	669009	Bumper
2	2	210437	Hose, 17.25 in.	15	2	665707	Nut, 1/2 in. ID
3	1	601377	Fitting, 8-8	16	2	633523	Capscrew, 1/2 NC x 2.50
4	2	686369	Fitting	17	4	668910	Bearing
5	2	611288	Fitting, 6-8	18	4	667663	Bearing
6	2	671222	Capscrew, 3/8 NC x .75	19	4	668911	Bearing
7	2	4750	Capscrew, 3/8 NC x .75	20	1	680622	Mounting Plate - RH
8	2	553800	Cylinder ▲	21	1	680621	Mounting Plate - LH
9	2	7861	Roll Pin - Inner	22	1	674226	Frame - Lower
10	2	7962	Roll Pin - Outer	23	2	667609	Restrictor Cartridge ●
11	1	668008	Frame - Upper	24	2	6230	Washer
12	8	667910	Washer	25	1	671517	Optional Bumper

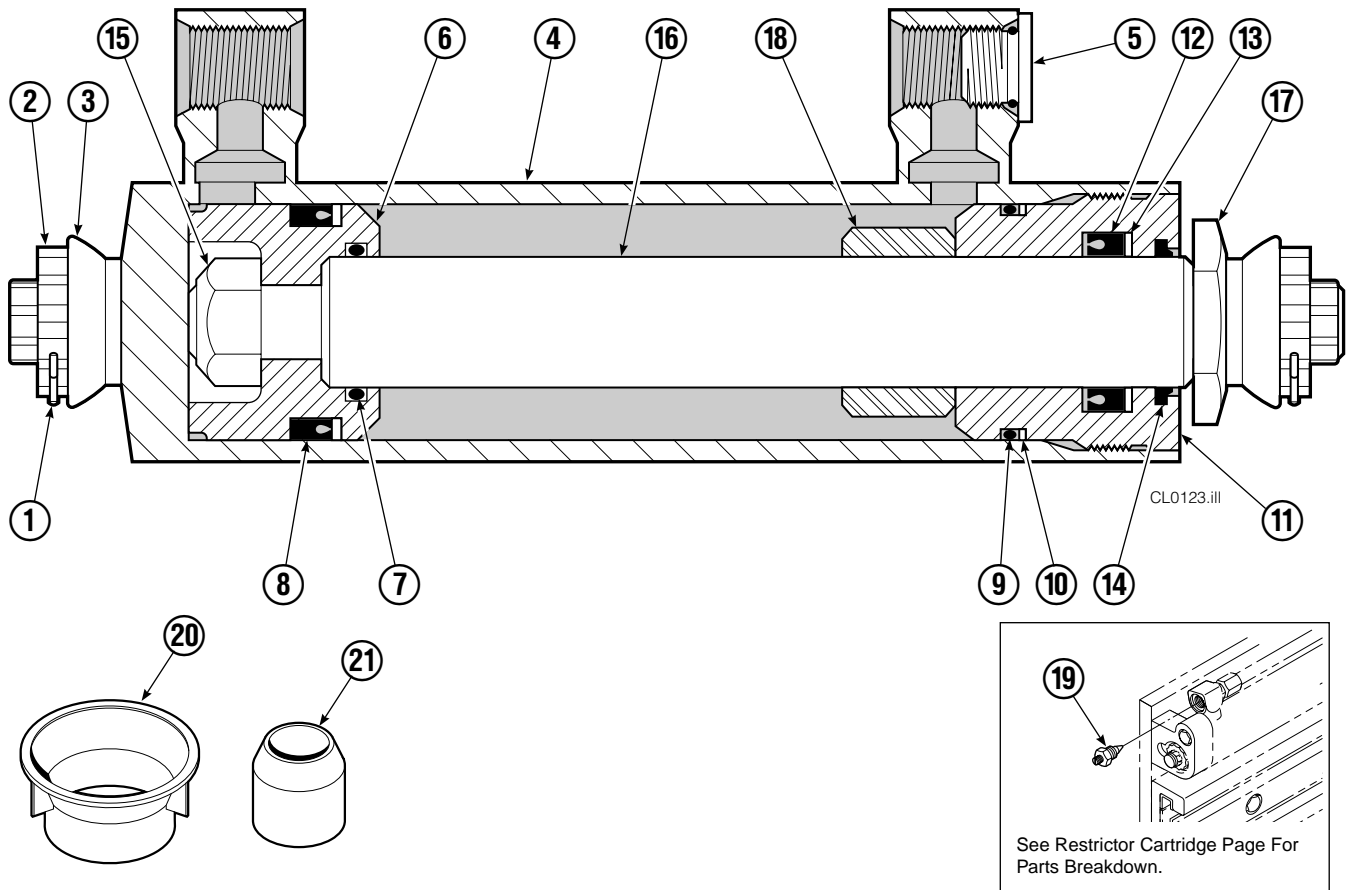
▲ See Cylinder page for parts breakdown.

● Not included in Base Unit Group.

See Restrictor Cartridge page for parts breakdown.

Reference: SK-5318, Basic Group 681350.

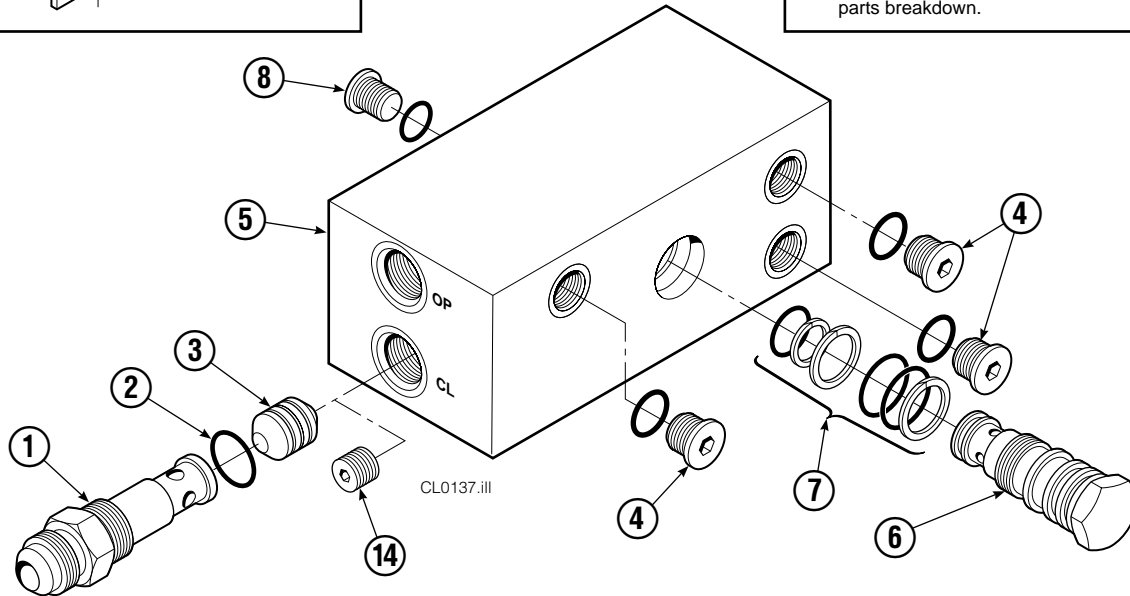
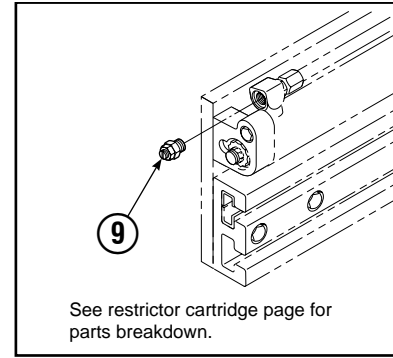
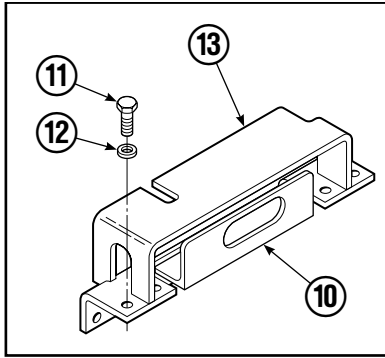
# Cylinder



25D			
REF	QTY	PART NO.	DESCRIPTION
		553800	Cylinder Assembly
1	2	6510	■ Cotter Pin
2	2	667624	■ Nut Retainer
3	2	667625	■ Nut
4	1	553833	Shell
5	1	602580	Fitting
6	1	558200	Piston
7	1	2716	▲ O-Ring
8	1	662452	▲ Seal
9	1	2785	▲ O-Ring
10	1	615128	▲ Back-Up Ring
11	1	563906	Retainer
12	1	662448	▲ Seal
13	1	638243	▲ Nylon Ring
14	1	636853	▲ Wiper
15	1	667623	Nut
16	1	553834	Rod
17	1	667626	Washer
18	1	—	Spacer
19	1	667609	Restrictor Cartridge ●
20	1	671047	▲ Seal Loader, Piston
21	1	671051	▲ Seal Loader, Retainer
		668021	Service Kit

- ▲ Included in Service Kit 668021.
  - Included in Nut Service Kit 668926.
  - Not included in Cylinder Assembly.
- Reference: S-7605, S-7658

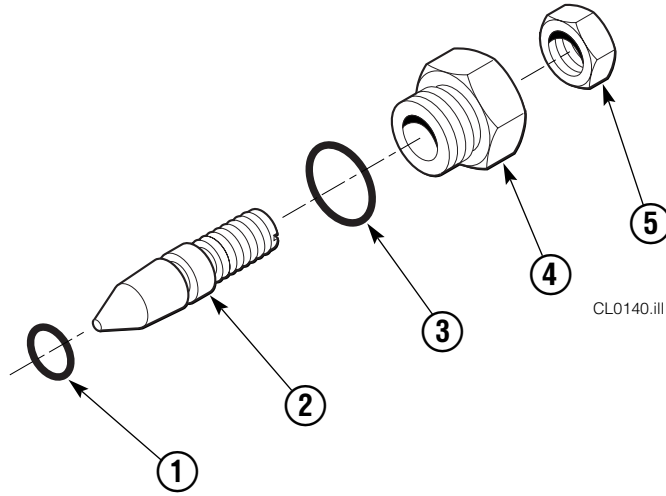
# Valve Group Non-Sideshift



REF	QTY	PART NO.	DESCRIPTION
		668914	Valve Group – Non-Sideshift
		668861	Check Valve – Non-Sideshift ▲
1	1	667490	Special Fitting
2	1	2841	O-Ring ●
3	1	667471	Spool
4	3	609455	Fitting, 5
5	1	668862	Valve Body
6	1	678270	Check Valve – VPO
7	1	661347	Service Kit ●
8	1	604510	Fitting, 6
9	2	667609	Restrictor Cartridge
10	1	669999	Bracket
11	4	677828	Capscrew, .5 x 1.0
12	4	667910	Washer, .5
13	1	670002	Guard – 25D/35D
13	1	670000	Guard – 40D/50D
14	1	676343	Regeneration Elimination Plug ■
		668864	Service Kit

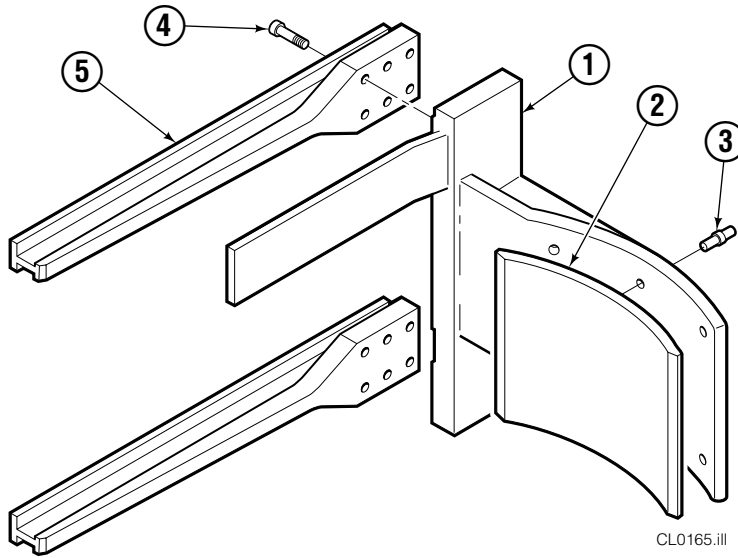
▲ Includes items 1– 8 only.  
 ● Included in Service Kit 668864.  
 ■ For eliminating regeneration circuit only. See Tech. Bulletin 121.  
 Reference: SK-5302, Valve Guard Groups 670005, 670006.

# Restrictor Cartridge



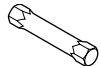
REF	QTY	PART NO.	DESCRIPTION
		667609	Restrictor Cartridge
1	1	2701	O-Ring
2	1	667611	Plunger
3	1	2841	O-Ring
4	1	667610	Plug - Special
5	1	5716	Jam Nut

# Two-Drum Arms



## ARM CAPSCREW EXTENSION TOOL

Required for proper torquing of capscrews



25D

668020

25D			
REF	QTY	PART NO.	DESCRIPTION
		673086	Drum Arm Group ●
1	2	673120	Drum Arm
2	4	672932	Contact Pad
3	24	667843	Rivet ★
4	24	607085	Capscrew, .75 NC x 1.50 GR8
5	4	671693	Arm Bar
6	2	672929	Pad (not shown)

● Includes items 1 thru 4 only.

★ Steel self-plugging rivets with steel mandrels,  
3/16 dia. x 3/8-1/2 grip.

# Bolt-On Mounting Group



Class II			
REF	QTY	PART NO.	DESCRIPTION
		678934	Lower Hook Group
1	2	675968	Lower Hook
2	4	667225	Washer, 5/8 in. ID
3	4	667369	Capscrew, 5/8 NC x 1.25 GR 5

Reference: S-3197.

# Mounting Plates with Bolt-On Upper Hooks



REF	QTY	PART NO.	DESCRIPTION
1	1	680621	Mounting Plate Assembly-LH ●
2	1	680622	Mounting Plate Assembly-RH ■
3	1	6002330	Upper Hook-LH
4	1	210491	Upper Hook-RH
5	4	768577	Capscrew, M20 x 35

● Includes items 3 and 5.

■ Includes items 4 and 5.

**Do you have questions you need answered right now?** Call your nearest Cascade Parts Department.

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