



Parts Manual

Model 77F Roll Clamp

Serial Number 77F-RDP-123

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

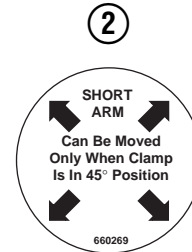
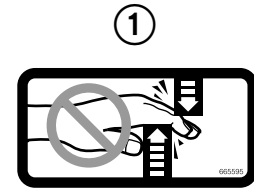
Write: Cascade Corporation, P.O. Box 20187, Portland, OR 97220

Internet: www.cascorp.com

Safety Decals



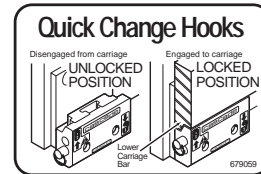
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Roll Clamp Safety Decals			
REF	QTY	PART NO.	DESCRIPTION
1	6	665595	No Hand Hold Decal
2	3	660269	Short Arm Rotation Position Decal
3	4	656038	Caution Decal
4	4	679150	No Step Decal
5	4	665677	Trapped Pressure Decal
6	1	679059	Quick-Change Hook Decal

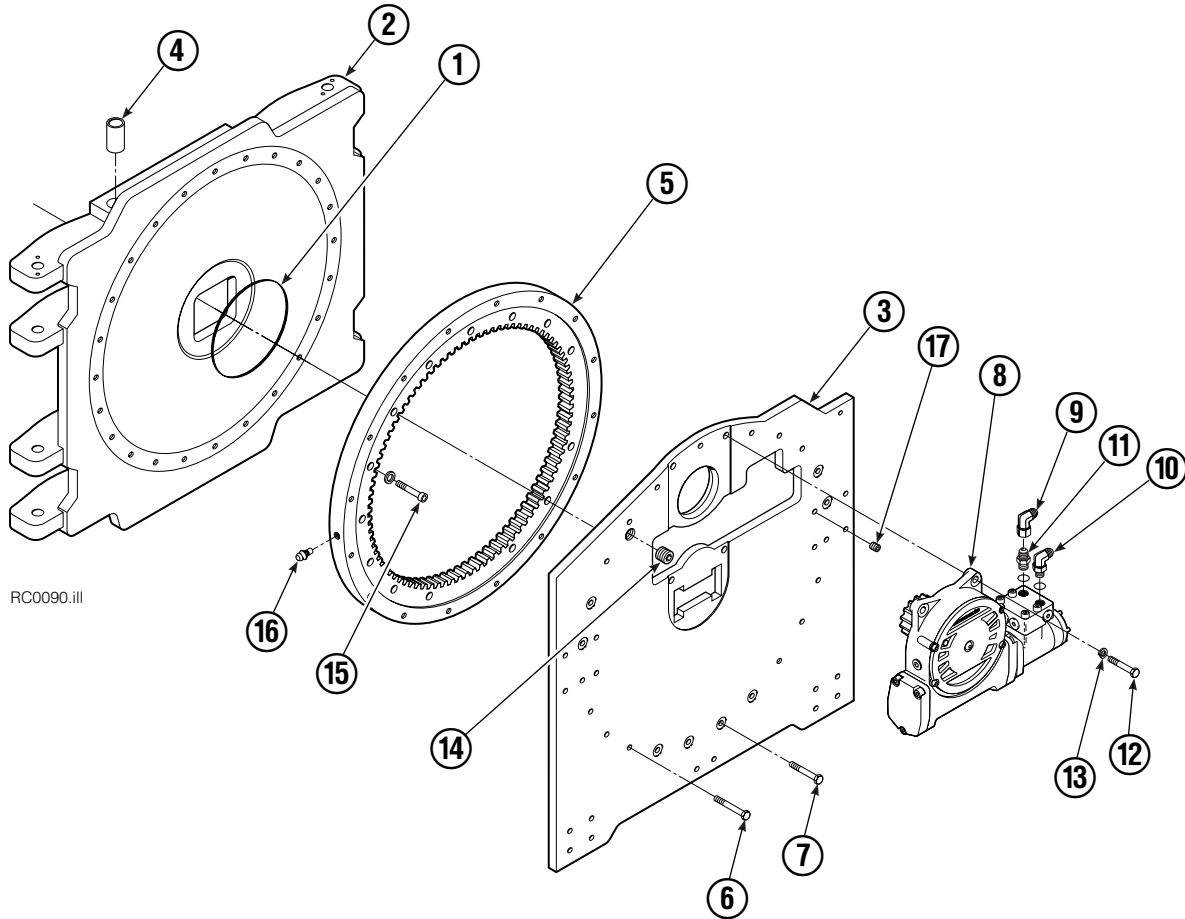
Publications



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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

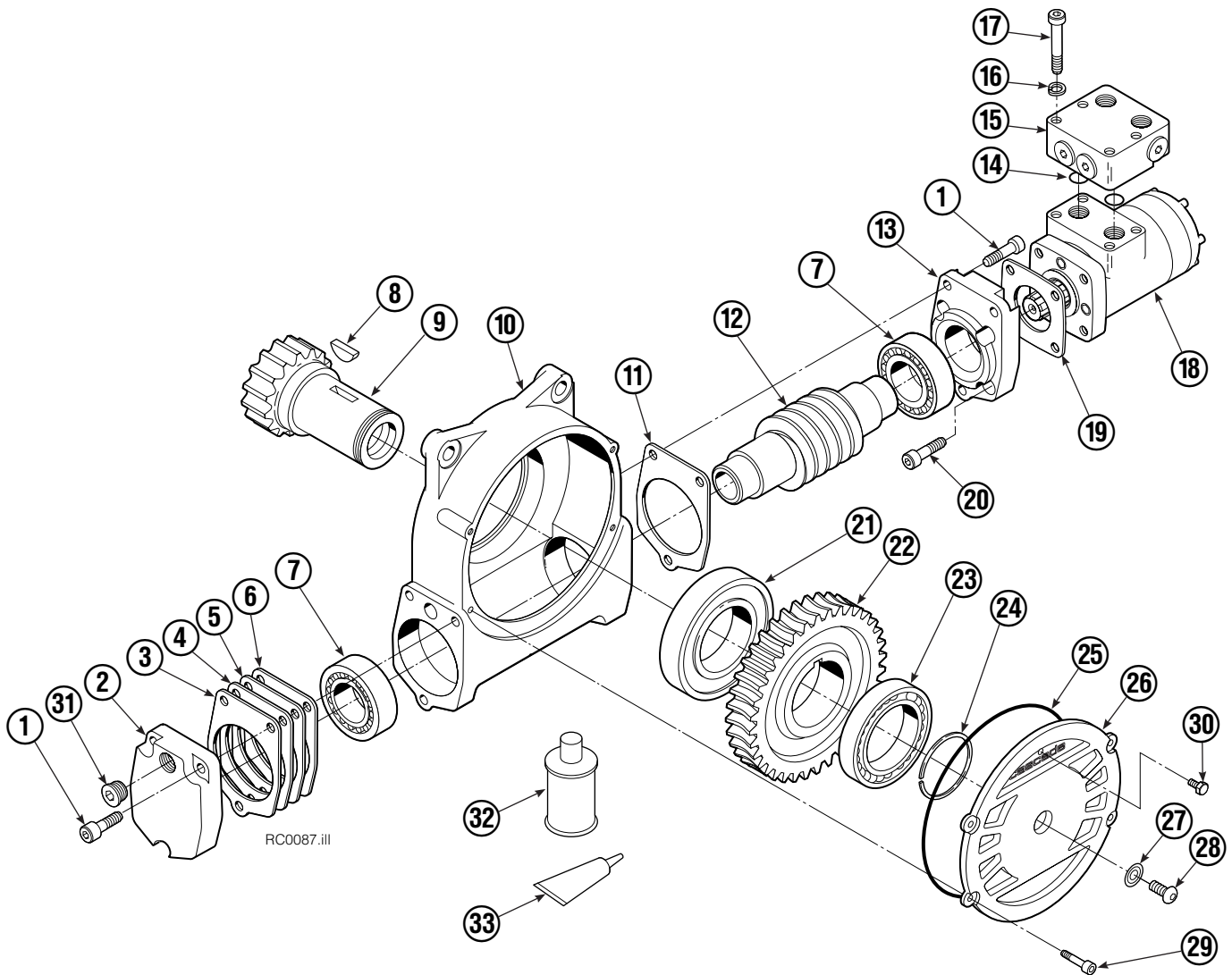


77F			
REF	QTY	PART NO.	DESCRIPTION
		399294	Frame Group
1	1	670931	Seal
2	1	682437	Faceplate
3	1	678381	Baseplate
4	8	675007	Bushing
5	1	672830	Bearing Assembly
6	13	643539	Capscrew
7	11	643538	Capscrew
● 8	1	399292	Drive Group
9	1	605761	Fitting, 8-8
10	1	601250	Fitting, 8-8
11	1	601377	Fitting, 8-8
12	4	661742	Capscrew
13	17	6290	Lockwasher
14	1	6605	Plug
15	24	4507	Capscrew
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 399293.

Drive Group



REF	QTY	PART NO.	DESCRIPTION	REF	QTY	PART NO.	DESCRIPTION
		399292	Drive Group with Motor	19	1	670575	Gasket
	■	675631	Drive Group without Motor	20	4	4468	Capscrew, 3/8 NC x .75 GR8
1	6	607071	Capscrew, 7/16 NC x 1.0 GR8	21	1	670580	Bearing
2	1	676855	Cover	22	1	675609	Worm Gear
3	●	674513	Shim – .005" (blue)	23	1	670581	Bearing
4	●	670574	Shim – .010" (brown)	24	1	7214	Snap Ring
5	●	671757	Shim – .015" (pink)	25	1	643423	O-Ring
6	●	671758	Shim – .020" (yellow)	26	1	670567	Cover
7	2	670579	Bearing	27	1	603680	Seal
8	1	670582	Key	28	1	4874	Capscrew
9	1	670556	Pinion	29	4	671535	Capscrew, 5/16 NC x .75
10	1	670565	Housing	30	1	644010	Relief Fitting
11	1	686465	Gasket	31	1	604510	Fitting, 6
12	1	675608	Worm	32	1	656300	Gear Box Lube - 48 oz.
13	1	775553	Adapter	33	1	668184	Sealant
14	2	2705	Seal			670578	Shim Service Kit (items 3-6, 11, 25 & 33)
15	1	670549	Check Valve ▲			675637	Bearing Service Kit (items 21 & 33)
16	4	6444	Lockwasher			675638	Bearing Service Kit (items 3-7, 11 & 25)
17	4	607059	Capscrew, 5/16 NC			206394	Motor Kit (items 11, 14, 18, 19, 20, 33)
18	1	215903	Drive Motor				

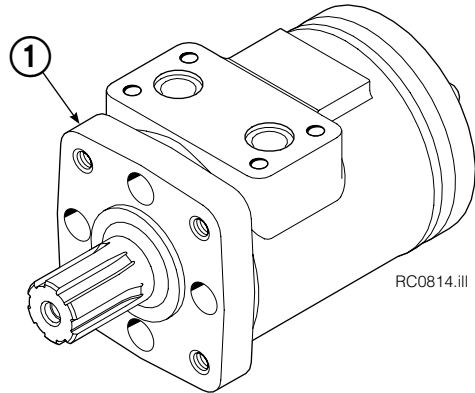
■ Includes all items except 15, 17 and 18.

● Quantity as required.

▲ See Check Valve page for parts breakdown.

Reference: Common Parts Group 675627, SK-5032.

Drive Motor

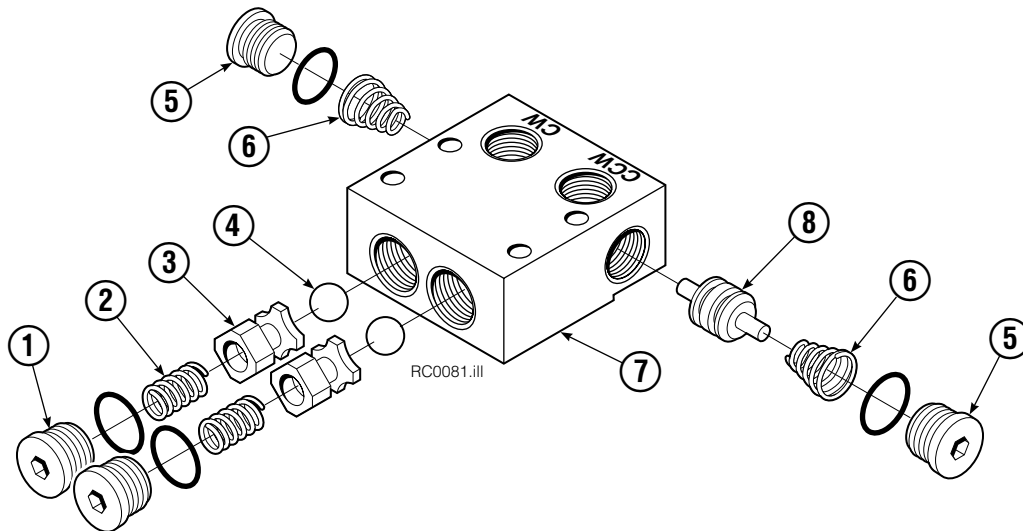


REF	QTY	PART NO.	DESCRIPTION
1	1	215903	Drive Motor
●	1	206405	Service Kit

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.

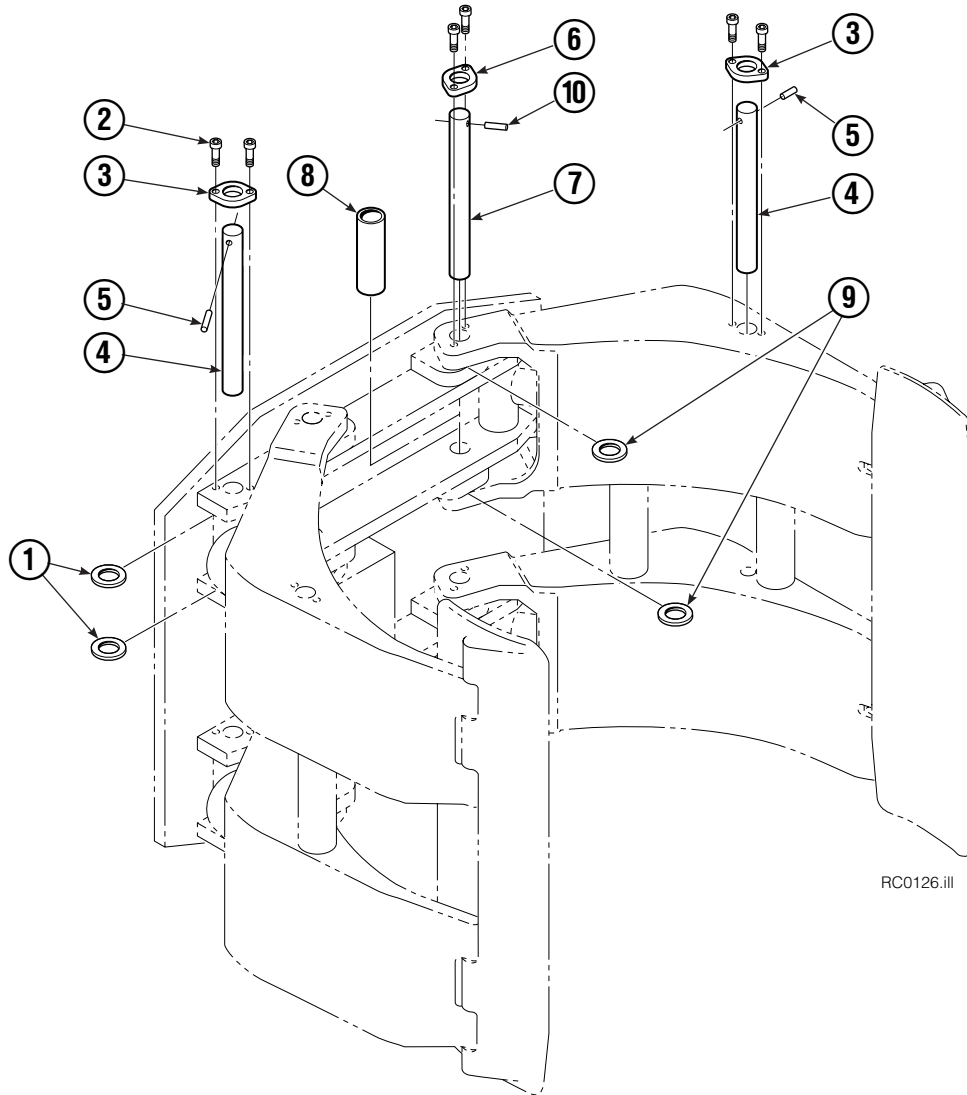
- Compatible with water glycol based hydraulic fluids.

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

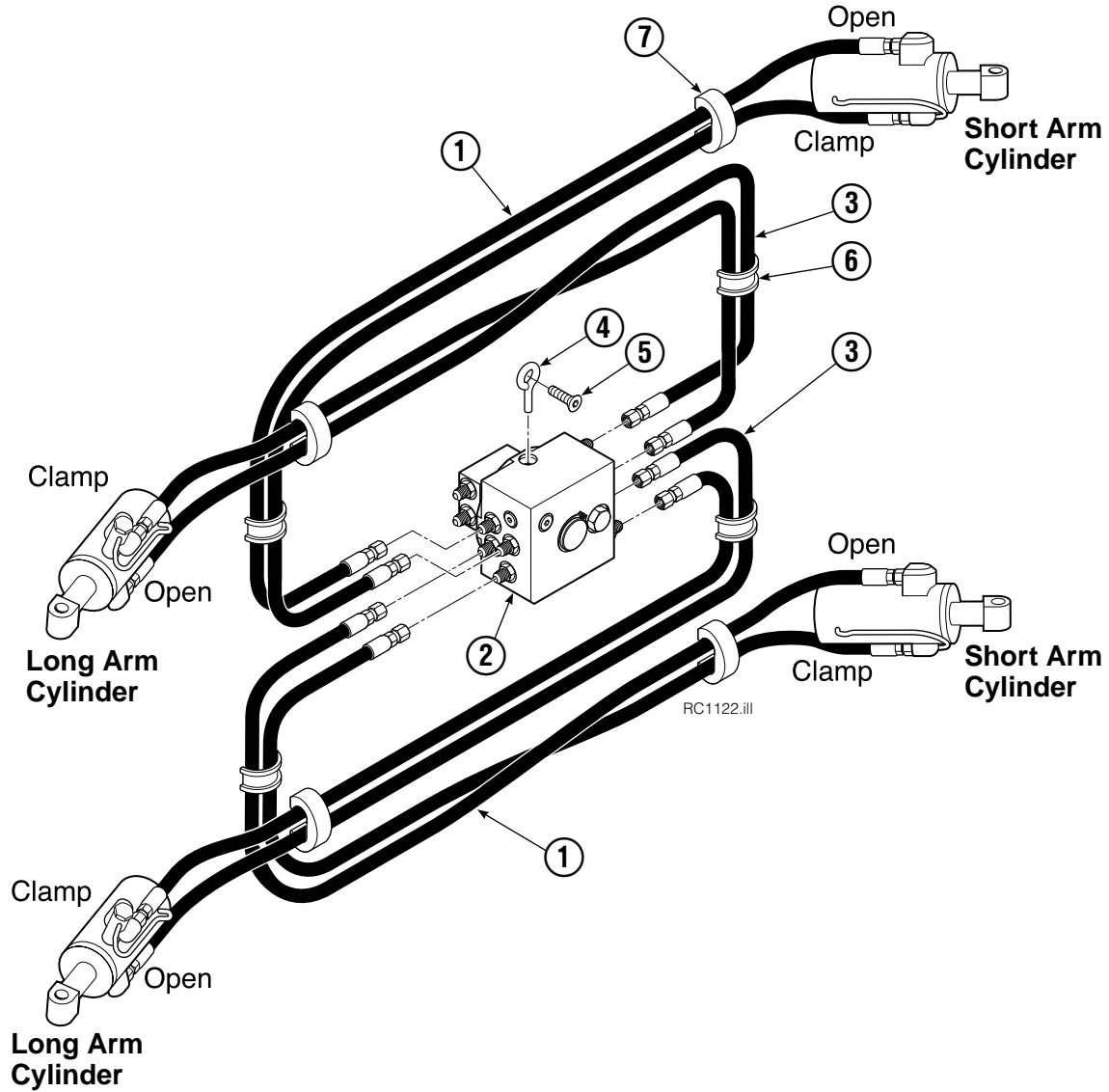
Common Components Group



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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

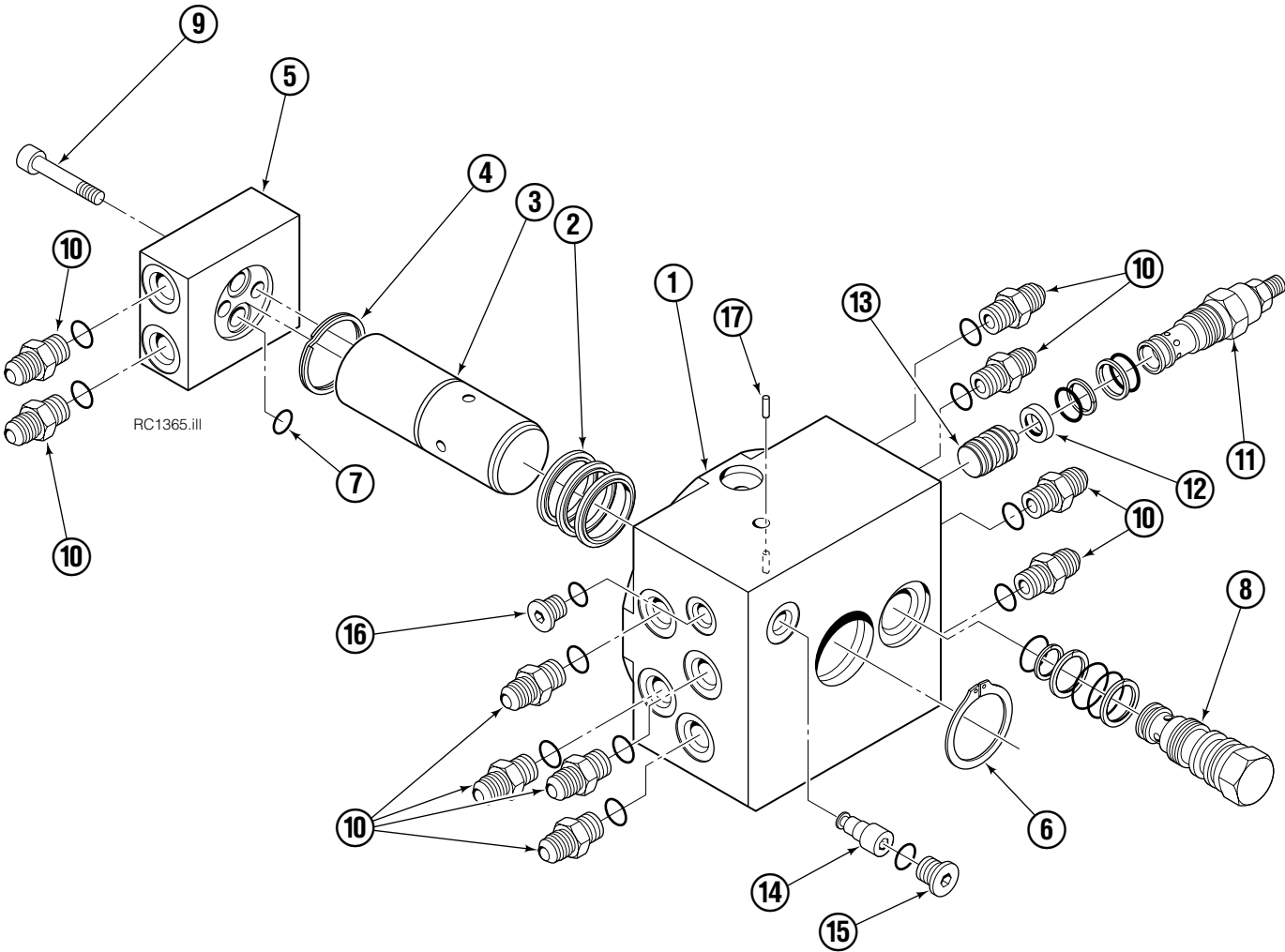
Hosing Group



77F			
REF	QTY	PART NO.	DESCRIPTION
		6026311	Hosing Group
1	4	680238	Hose, 58.75 in.
2	1	6025982	Revolving Connection ▲
3	4	680239	Hose, 63.75 in.
4	2	227962	Eye Pin
5	2	4751	Capscrew, M10 x 25
6	4	680114	Insert
7	4	673417	Segment

▲ See Revolving Connection page for parts breakdown.

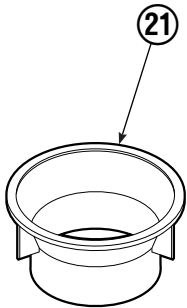
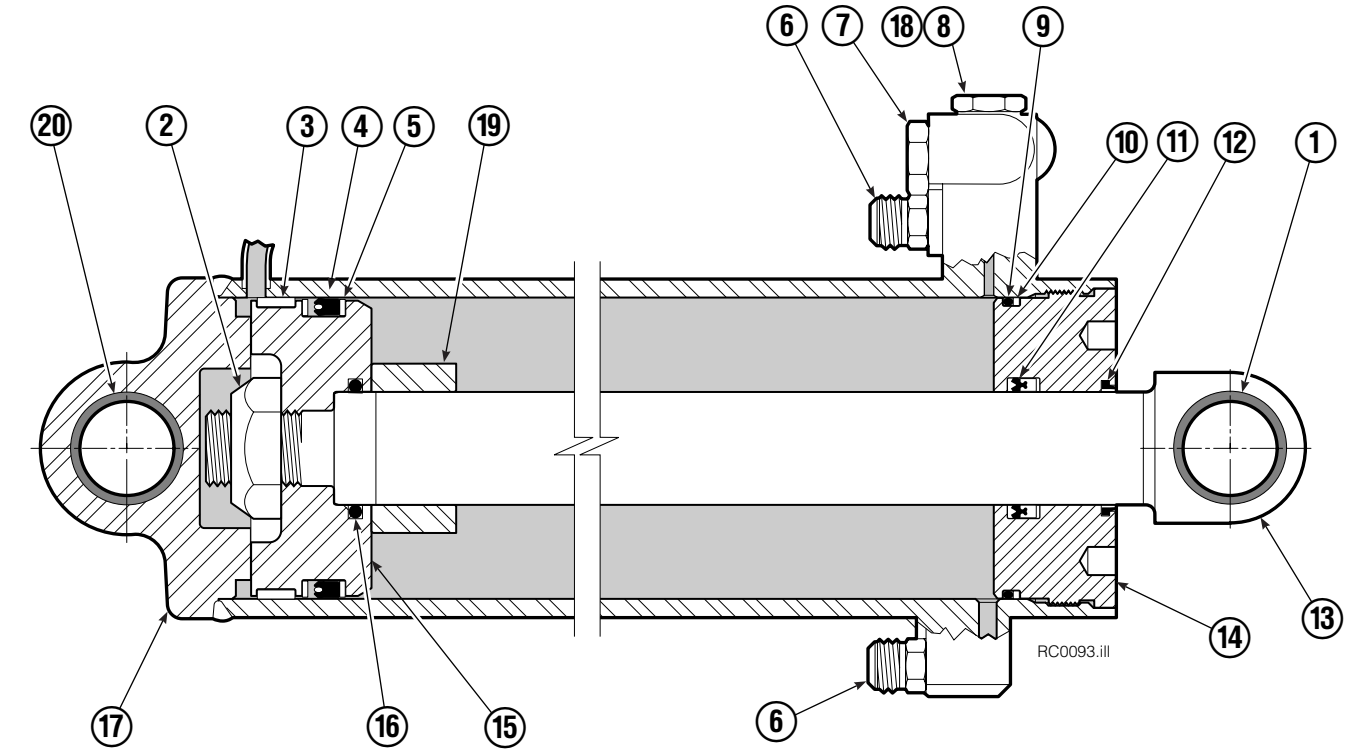
Revolving Connection



90F							
REF	QTY	PART NO.	DESCRIPTION	REF	QTY	PART NO.	DESCRIPTION
		6025982	Revolving Connection	9	2	768798	◆ Capscrew, M8 x 45
1	1	6025914	Body	10	10	604511	Fitting, 6-6
2	3	214649	◆ Seal	11	1	227331	Sequence Valve
3	1	6023274	Shaft	12	1	227318	◆ Quad Ring
4	1	7341	◆ Retaining Ring	13	1	227320	Spool
5	1	6023344	End Block	14	1	220865	Shuttle Check
6	1	3138	◆ Retaining Ring	15	1	609234	Fitting
7	2	684587	◆ O-ring	16	1	663694	Fitting
8	1	6024293	Flow Divider Cartridge	17	1	6020466	Pin Restrictor

◆ Included in Seal Kit 6025987.

Short Arm Cylinder

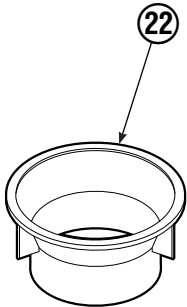
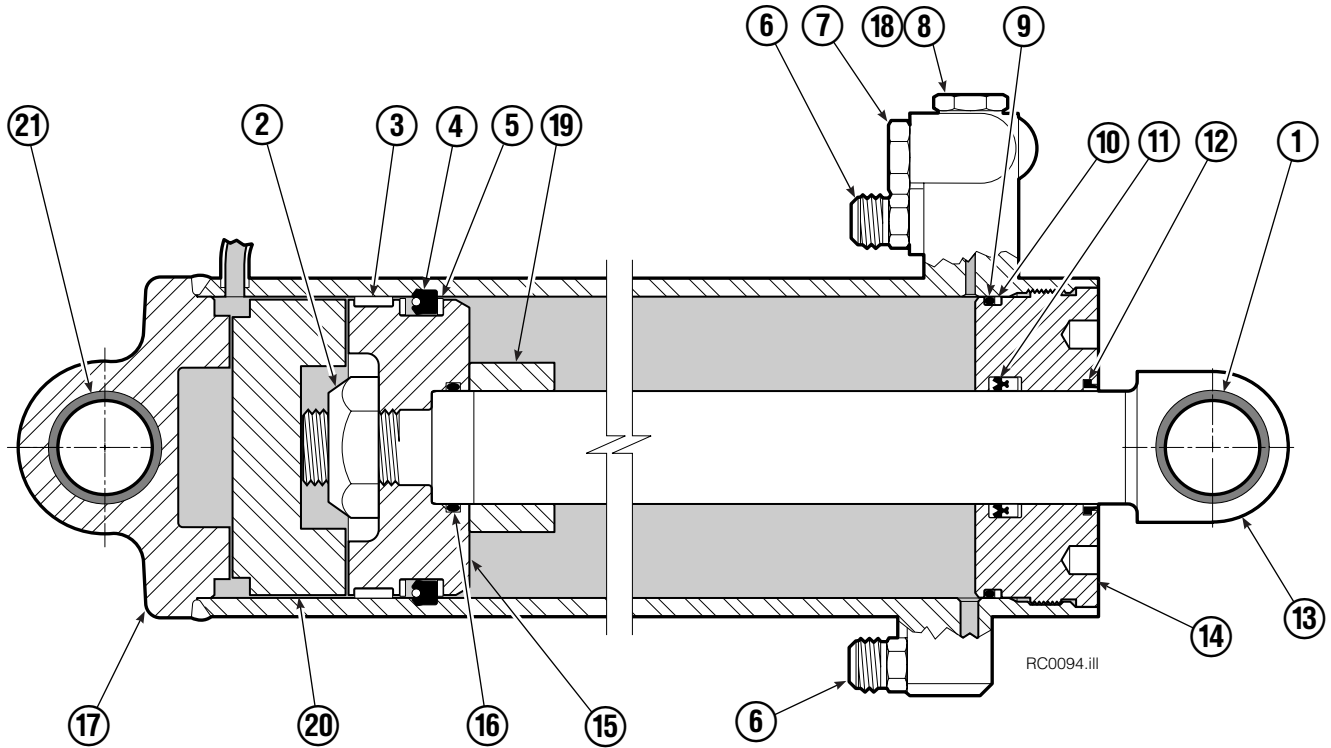


REF	QTY	PART NO.	DESCRIPTION
		557360	Cylinder Assembly
1	1	674843	Bearing
2	1	560997	Nut
3	1	660769	Bearing ♦
4	1	662462	Seal ♦
5	2	638295	Back-Up Ring ♦
6	2	604511	Fitting, 6-6
7	1	556852	Fitting, 4
8	1	557212	Check Valve
9	1	2801	O-Ring ♦
10	1	563977	Back-Up Ring ♦
11	1	554598	Seal ♦
12	1	564930	Wiper ♦
13	1	557390	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	555774	Spacer
20	2	675006	Bearing
21	1	669243	Seal Loader
		555725	Service Kit

♦ Included in Service Kit 555725.

Reference: S-5313, S-5314

Long Arm Cylinder

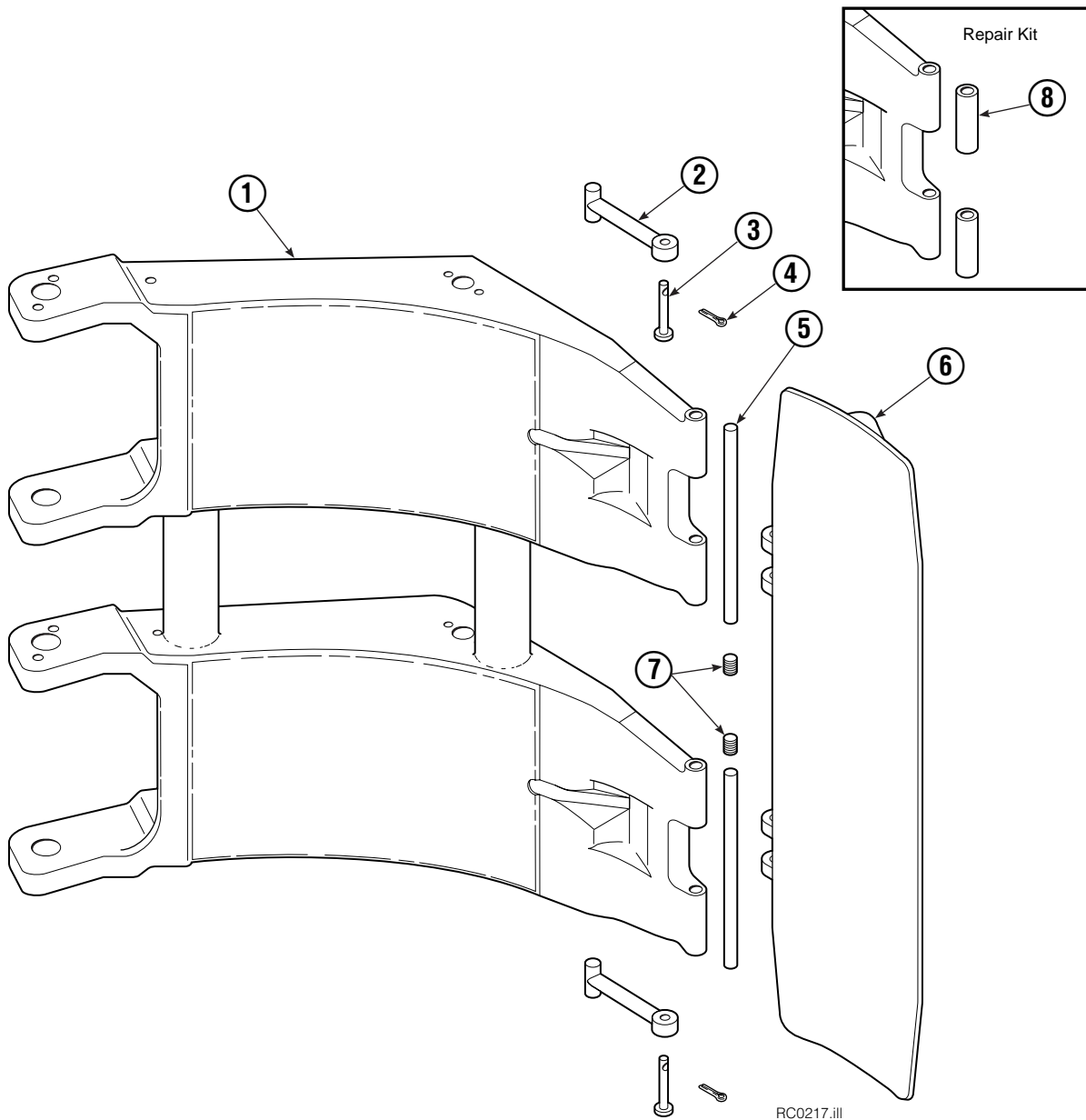


REF	QTY	PART NO.	DESCRIPTION
		557380	Cylinder Assembly
1	1	674843	Bearing
2	1	560997	Nut
◆3	1	660769	Bearing
◆4	1	662462	Seal
◆5	2	638295	Back-Up Ring
6	2	604511	Fitting, 6-6
7	1	556852	Fitting, 4
8	1	557212	Check Valve
◆9	1	2801	O-Ring
◆10	1	563977	Back-Up Ring
◆11	1	554598	Seal
◆12	1	564930	Wiper
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.

Ref: S-5320, S-5321

Short Arm

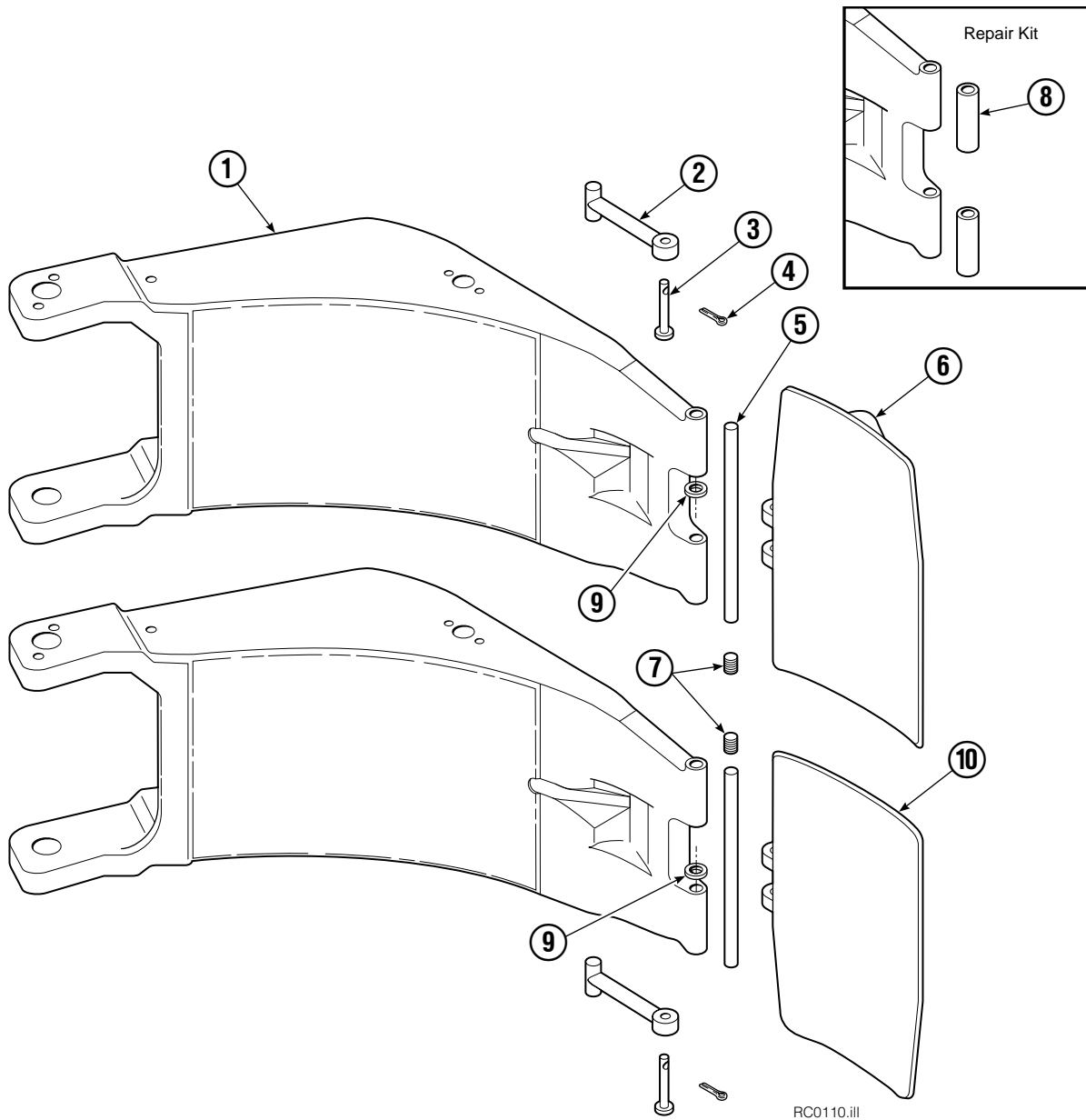


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REF	QTY	PART NO.	DESCRIPTION
		674948	Contact Pad Group ■
1	1	678544	Short Arm
2	2	674994	Link
3	2	682978	Clevis Pin
4	2	6525	Cotter Pin
5	2	674993	Pin
6	1	674962	Contact Pad
7	2	689900	Plug
8	1	676810	Arm Tip Repair Kit

■ Includes items 2 thru 7.

Contact Pad Group & Long Arm

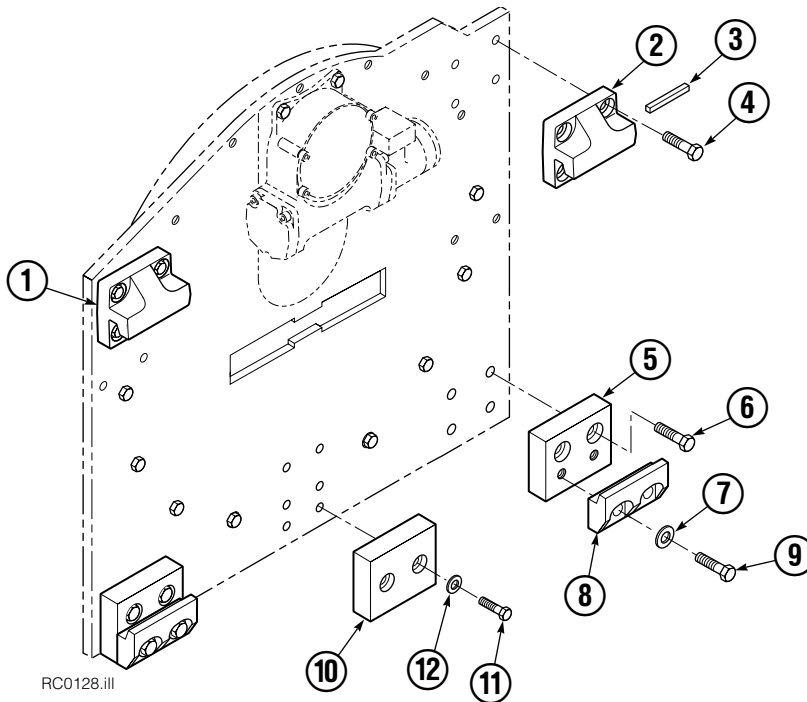


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REF	QTY	PART NO.	DESCRIPTION
		386612	Contact Pad Group (items 2-10)
1	2	675134	Arm
2	2	674994	Link
3	2	682978	Clevis Pin
4	2	6525	Cotter Pin
5	2	674993	Pin
6	1	339724	Contact Pad
7	2	689900	Plug
8	1	676810	Arm Tip Repair Kit
9	■	667910	Washer
10	1	339723	Contact Pad

■ Quantity as required.

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.

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