



Parts Manual

Model 50D Revolving Clamp

Serial Number 50D-CFR-255

cascade[®]
corporation

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OR

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

Internet: www.cascorp.com

Safety Decals



REF	QTY	PART NO.	DESCRIPTION
1	2	665595	No Hand Hold Decal
2	2	679150	No Step Decal

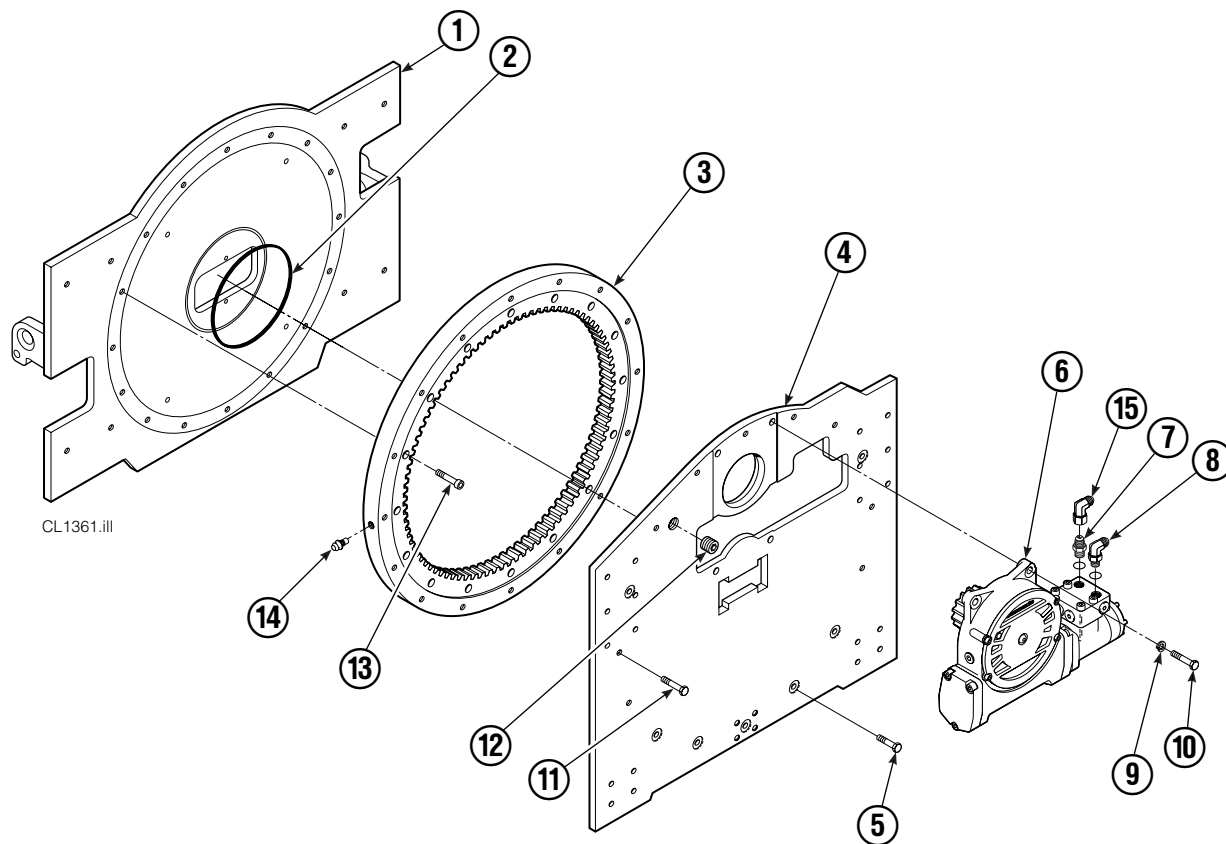


Publications



PART NO.	DESCRIPTION
672362	Service Manual
672903	Operators Guide
672361	Installation Instructions
680664	Servicing Cascade Cylinders-VHS
679929	Tool Catalog
673964	Literature Index Order Form

Rotator Group



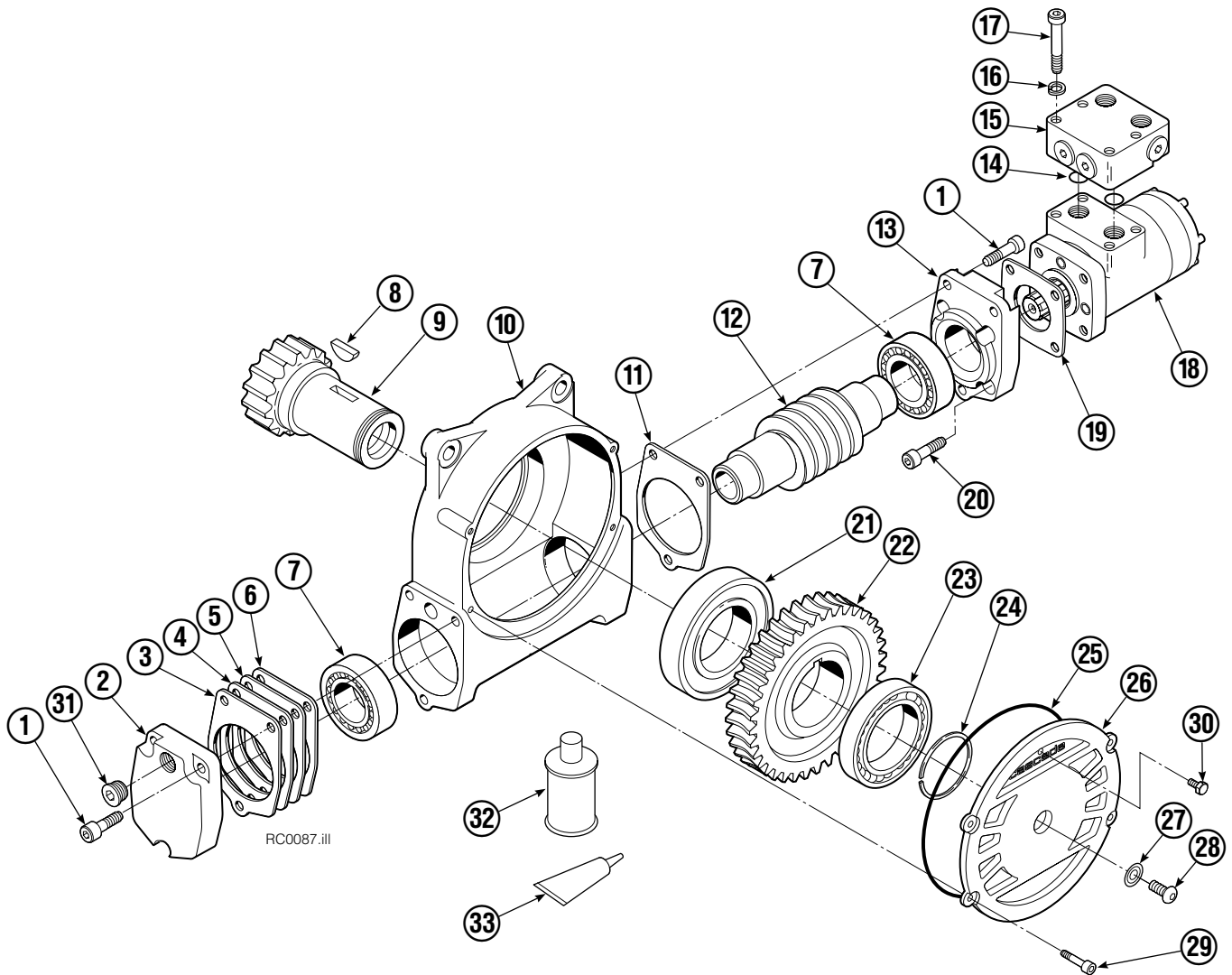
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50D			
REF	QTY	PART NO.	DESCRIPTION
		3009821	Rotator Group
1	1	687230	Faceplate
2	1	670931	Seal
3	1	672828	Bearing Assembly
4	1	687229	Baseplate
5	7	643538	Capscrew, 1/2 NC x 1.50 GR8
6	1	3007532	Drive Group ▲
7	1	601377	Fitting, 8-8
8	1	601250	Fitting, 8-8
9	4	6290	Lockwasher, 1/2 in. ID
10	4	661742	Capscrew, 1/2 NC x 1.25 GR5
11	9	643539	Capscrew, 1/2 NC x 1.75 GR8
12	1	6605	Plug
13	16	4505	Capscrew, 1/2 NC x 1.25
14	1	7401	Grease Fitting
15	1	605761	Fitting, 8-8
		672481	Bearing Service Kit

▲ See Drive Group page for parts breakdown.

Reference: Common Parts Group 6011091, Fastener Kit 699003, SK-5346, SK-5649.

Drive Group



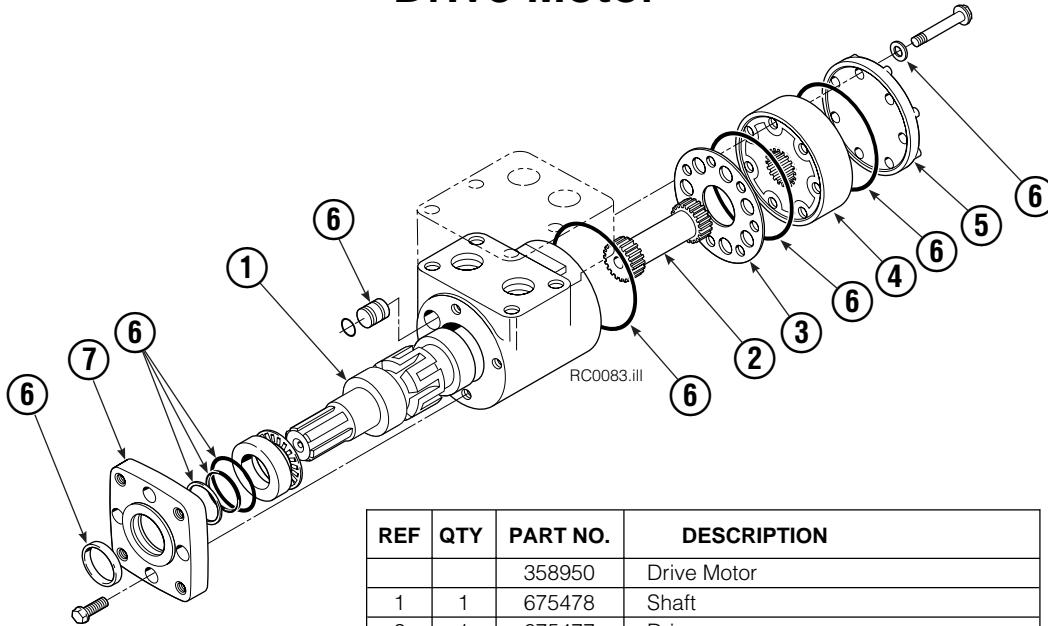
REF	QTY	PART NO.	DESCRIPTION	REF	QTY	PART NO.	DESCRIPTION
		3007532	Drive Group with Motor	20	4	4468	Capscrew, 3/8 NC x .75 GR8
1	6	769570	Capscrew, M12 x 25	21	1	670580	Bearing
2	1	676855	Cover	22	1	675609	Worm Gear
3	●	674513	Shim – .005 in. (blue)	23	1	670581	Bearing
4	●	670574	Shim – .010 in. (brown)	24	1	7214	Snap Ring
5	●	671757	Shim – .015 in. (pink)	25	1	643423	O-Ring
6	●	671758	Shim – .020 in. (yellow)	26	1	775552	Cover
7	2	670579	Bearing	27	1	783609	Seal
8	1	670582	Key	28	1	783608	Capscrew
9	1	670506	Pinion	29	4	200882	Capscrew, M8 x 20
10	1	775551	Housing	30	1	644010	Relief Fitting
11	1	686465	Gasket	31	1	6609	Plug
12	1	358953	Worm	32	1	656300	Gear Box Lube - 48 oz.
13	1	358952	Adapter	33	1	668184	Sealant
14	2	2705	Seal	34	1	358954	Seal, install in item 13.
15	1	670549	Check Valve ◆	35	1	359300	Plug, install in item 12.
16	4	6444	Lockwasher			670578	Shim Service Kit (items 3-6,11,25 & 33)
17	4	607059	Capscrew, 5/16 NC			675637	Bearing Service Kit (items 21 & 33)
18	1	358950	Drive Motor ◆			675638	Bearing Service Kit (items 3-7,11 & 25)
19	1	670575	Gasket			206394	Drive Motor Kit (items 11,14,18,19 & 33)

● Quantity as required.

◆ See Drive Motor page for parts breakdown.

Reference: Common Parts Group 3007531.

Drive Motor

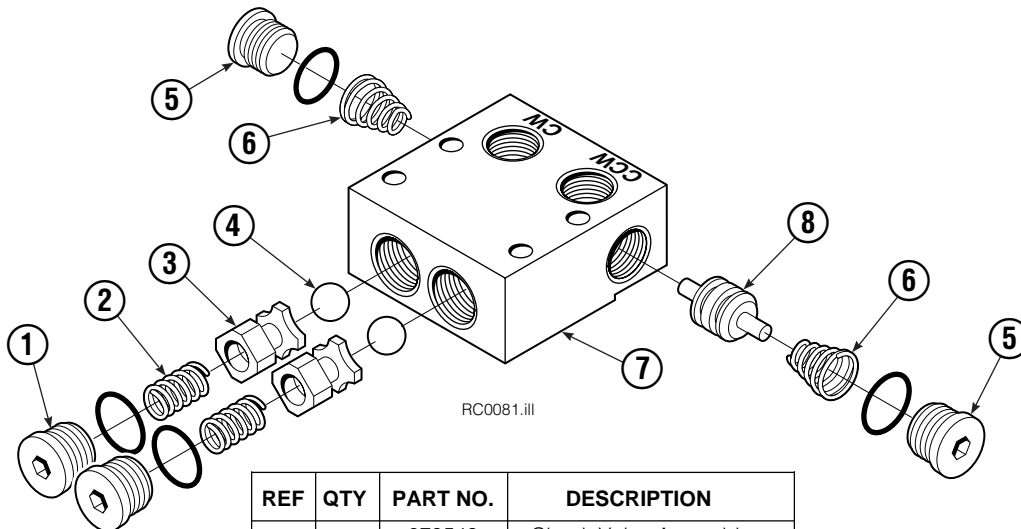


REF	QTY	PART NO.	DESCRIPTION
		358950	Drive Motor
1	1	675478	Shaft
2	1	675477	Drive
3	1	675479	Spacer Plate
4	1	675480	Gerotor Set (101-1768-007)
5	1	675482	End Cap
6	1	374612	Service Kit ●
7	1	685090	Flange (101-1768-009)

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.

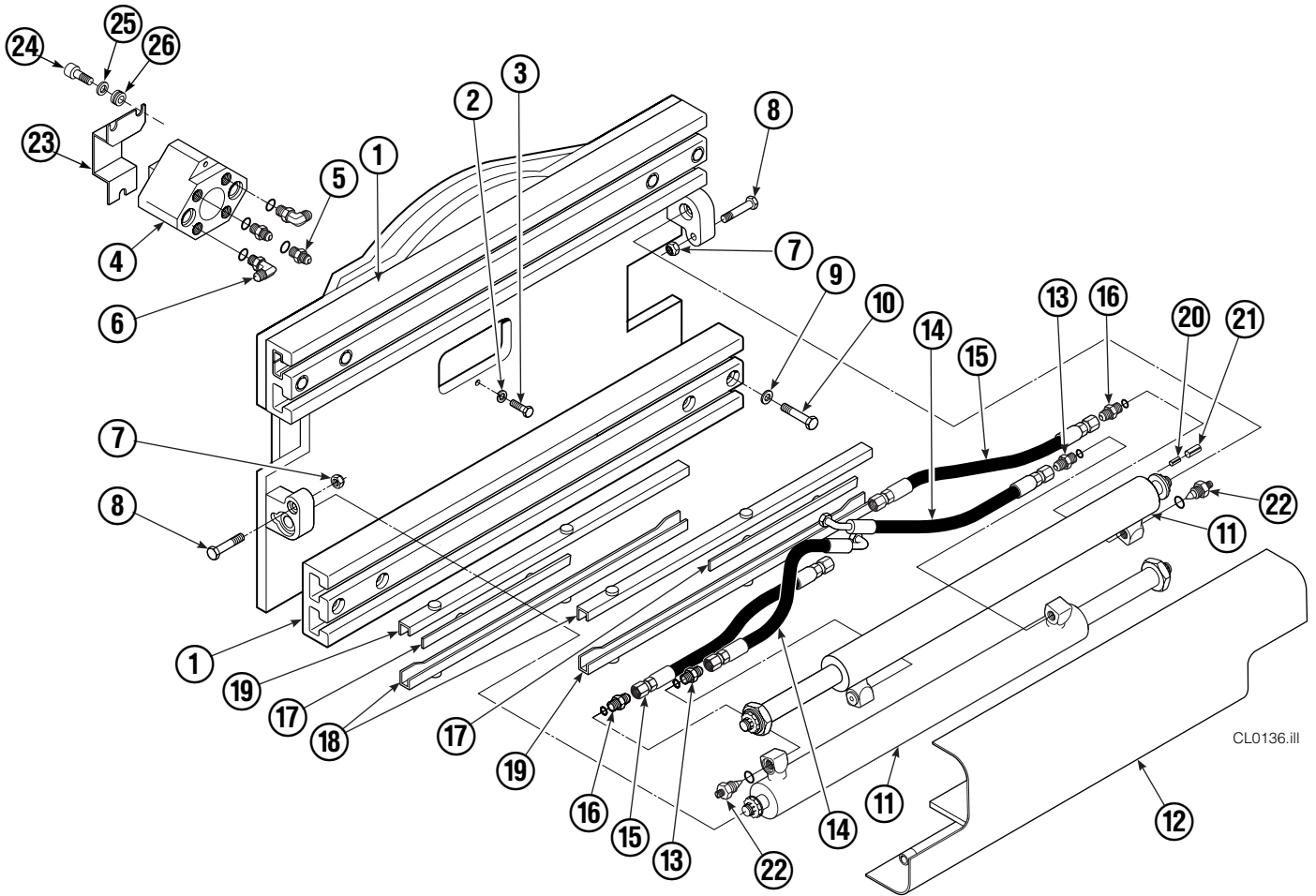
- Compatible with water glycol based hydraulic fluids.

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

Frame Group



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50D							
REF	QTY	PART NO.	DESCRIPTION	REF	QTY	PART NO.	DESCRIPTION
		687284	Frame Group	14	2	631443	Hose
1	2	674167	Frame	15	2	678027	Hose
2	2	686119	Lockwasher, M8	16	2	686369	Fitting
3	2	765352	Capscrew, M8 x 30	17	4	667663	Bearing
4	1	686420	Revolving Connection ■	18	4	668904	Bearing
5	2	604511	Fitting, 6-6	19	4	668905	Bearing
6	2	601676	Fitting, 6-6	20	2	7882	Roll Pin - Inner
7	2	665707	Nut, 1/2 in. ID	21	2	7961	Roll Pin - Outer
8	2	3660	Capscrew, 1/2 NC x 2.50	22	2	667609	Restrictor Cartridge ●
9	8	667225	Washer, 5/8 in. ID	23	1	209067	End Block Bracket
10	8	667644	Capscrew, 5/8 NC x 3.25	24	3	665992	Shoulder Bolt
11	2	667666	Cylinder ▲	25	3	209021	Washer, M10
12	1	667664	Bumper	26	3	208765	Grommet
13	2	611288	Fitting, 6-8				

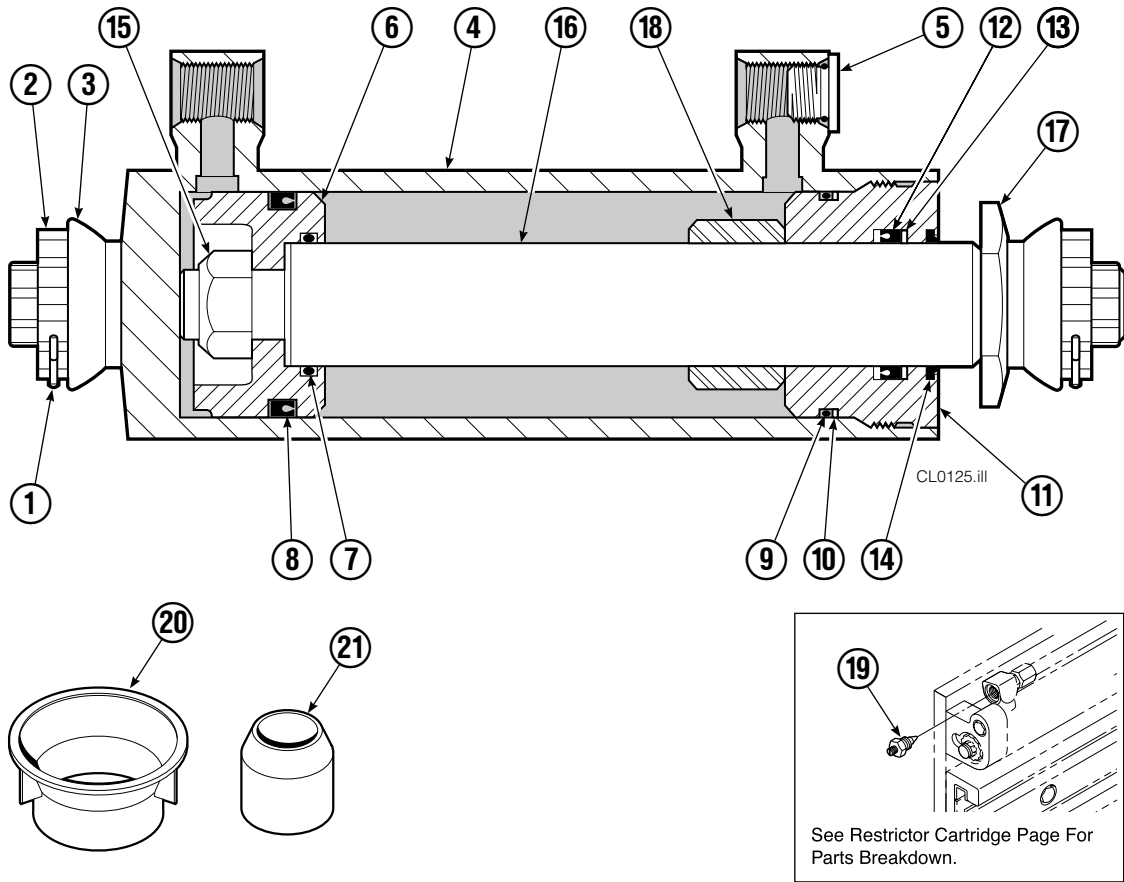
■ See Revolving Connection page for parts breakdown.

▲ See Cylinder page for parts breakdown.

● See Restrictor Cartridge page for parts breakdown.

Reference: SK-5659.

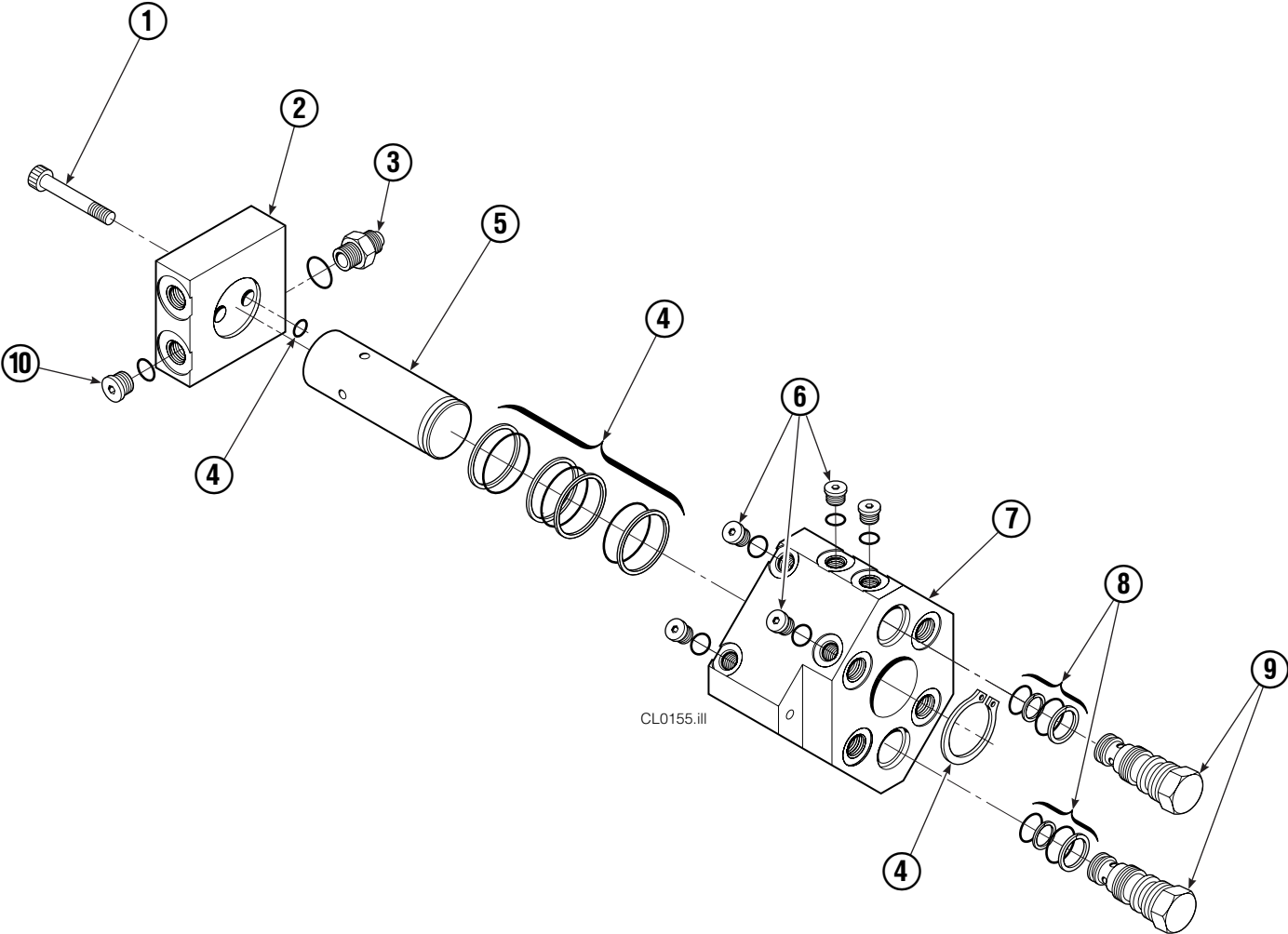
Cylinder



50D			
REF	QTY	PART NO.	DESCRIPTION
		667666	Cylinder Assembly
1	2	6511	■ Cotter Pin
2	2	667667	■ Nut Retainer
3	2	667668	■ Nut
4	1	553760	Shell
5	1	602580	Fitting
6	1	558402	Piston
7	1	2722	▲ O-Ring
8	1	557376	▲ Seal
9	1	2791	▲ O-Ring
10	1	615134	▲ Back-Up Ring
11	1	667675	Retainer
12	1	662451	▲ Seal
13	1	638246	▲ Nylon Ring
14	1	564930	▲ Wiper
15	1	561012	Nut
16	1	667670	Rod
17	1	667676	Washer
18	1	—	Spacer
19	1	667609	Restrictor Cartridge ●
20	1	671049	▲ Seal Loader, Piston
21	1	671052	▲ Seal Loader, Retainer
		667723	Service Kit

- ▲ Included in Service Kit 667723.
 - Included in Nut Service Kit 668925.
 - Not included in Cylinder Assembly.
- Reference: S-7666.

Revolving Connection



35D/50D			
REF	QTY	PART NO.	DESCRIPTION
		686420	Revolving Connection
1	2	768795	Capscrew, M8 x 1,25 x 30 x 8.8
2	1	686421	End Block
3	2	604511	Fitting, 6-6
4	1	687237	Service Kit
5	1	686422	Shaft
6	5	663694	Fitting, 3
7	1	686423	Body
8	2	667516	Check Valve Service Kit
9	2	678376	Check Valve
10	2	604510	Fitting, 6

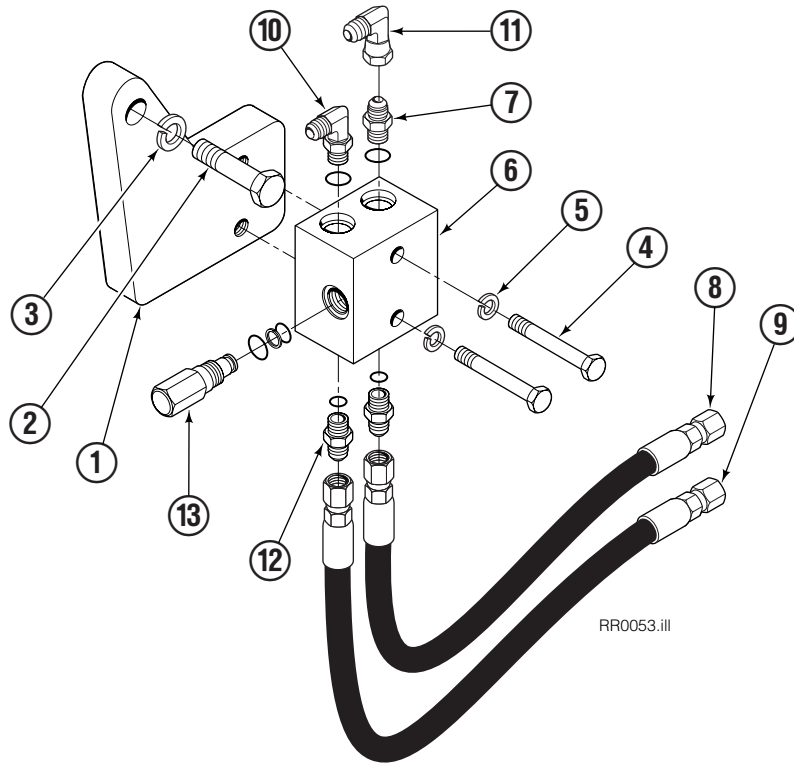
Restrictor Cartridge



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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

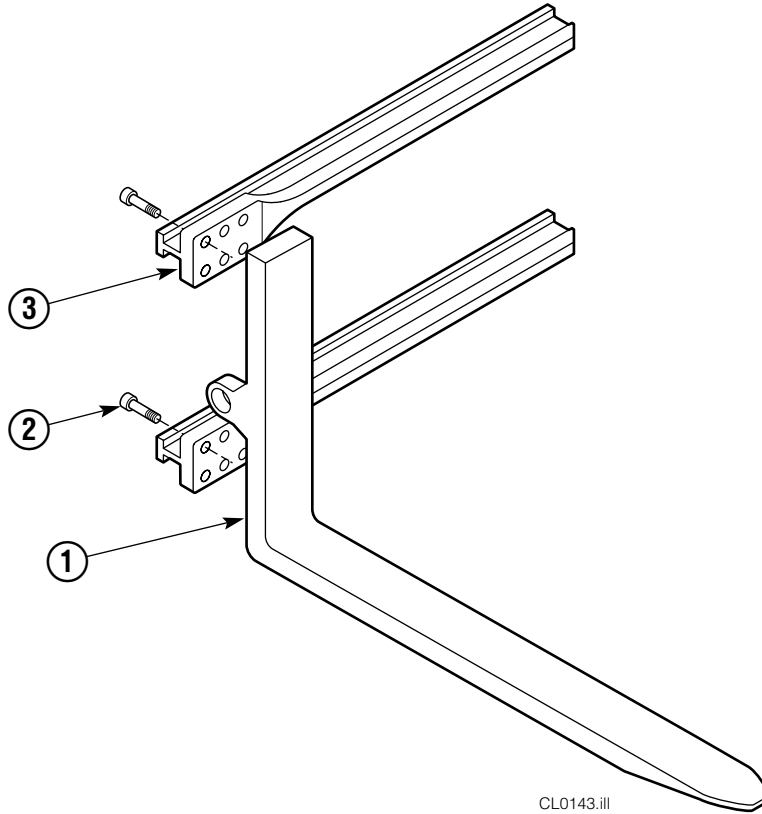
Valve Group



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REF	QTY	PART NO.	DESCRIPTION
		689952	Valve Group
		679888	Valve Assembly (Items 6 & 13)
1	1	679934	Plate
2	1	645636	Capscrew
3	1	6290	Lockwasher
4	2	643519	Capscrew
5	2	6287	Lockwasher
6	1	679889	Valve Body
7	1	601377	Fitting, 8-8
8	1	206479	Hose
9	1	210351	Hose
10	1	601250	Fitting, 8-8
11	1	605761	Fitting, 8-8
12	2	611288	Fitting, 6-8
13	1	679890	Relief Valve

Bolt-On Pallet Forks



ARM CAPSCREW EXTENSION TOOL
Required for proper torquing of capscrews



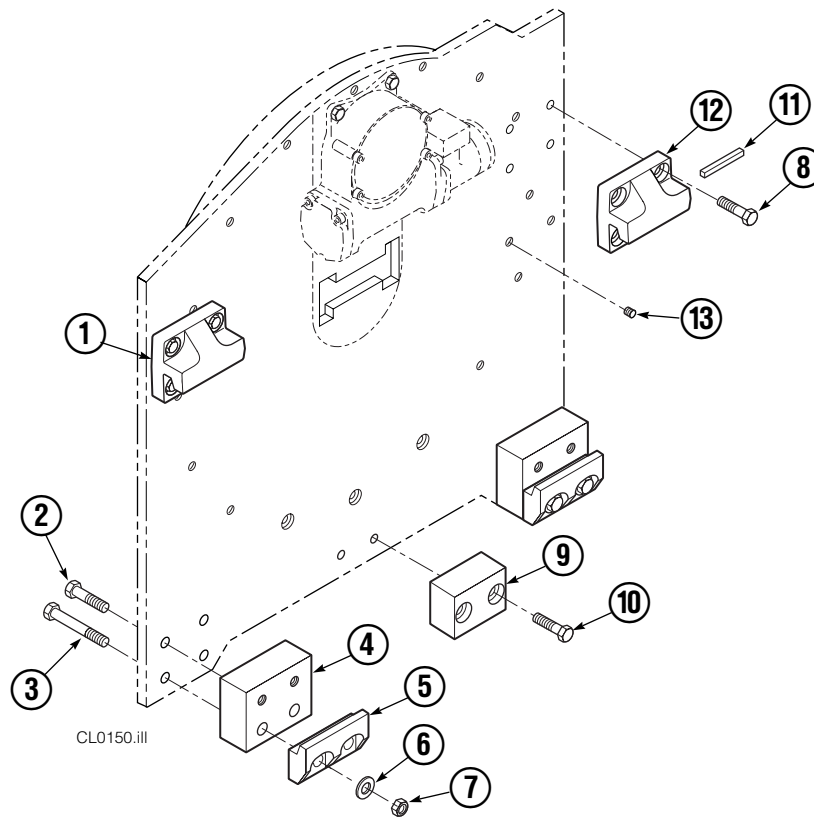
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50D			
REF	QTY	PART NO.	DESCRIPTION
		●670962	Pallet Fork Assembly (pair)
1	1	670955	Pallet Fork – LH
	1	670957	Pallet Fork – RH
2	24	607105	Capscrew
3	4	667700	Arm Bar

● Includes items 1 & 2 only.

Bolt-On Mounting Group



Class III, 0°

REF	QTY	PART NO.	DESCRIPTION
		680632	Mounting Group
1	1	670527	Upper Hook – LH
2	4	641284	Capscrew, 5/8 NC x 2.25
3	4	669305	Capscrew, 5/8 NC x 5.00
4	2	682068	Spacer
5	2	675969	Lower Hook
6	4	667225	Washer
7	4	676281	Nut, 5/8
8	8	667369	Capscrew, 5/8 NC x 1.25
9	1	682067	Center Spacer
10	2	677828	Capscrew, 1/2 NC x 1.00
11	1	669344	Stop Kit
12	1	670528	Upper Hook – RH
13	2	631385	Plug, 5/8

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