



Parts Manual

Model 25F Roll Clamp

Serial Number 25F-RCF-112

cascade[®]
corporation

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

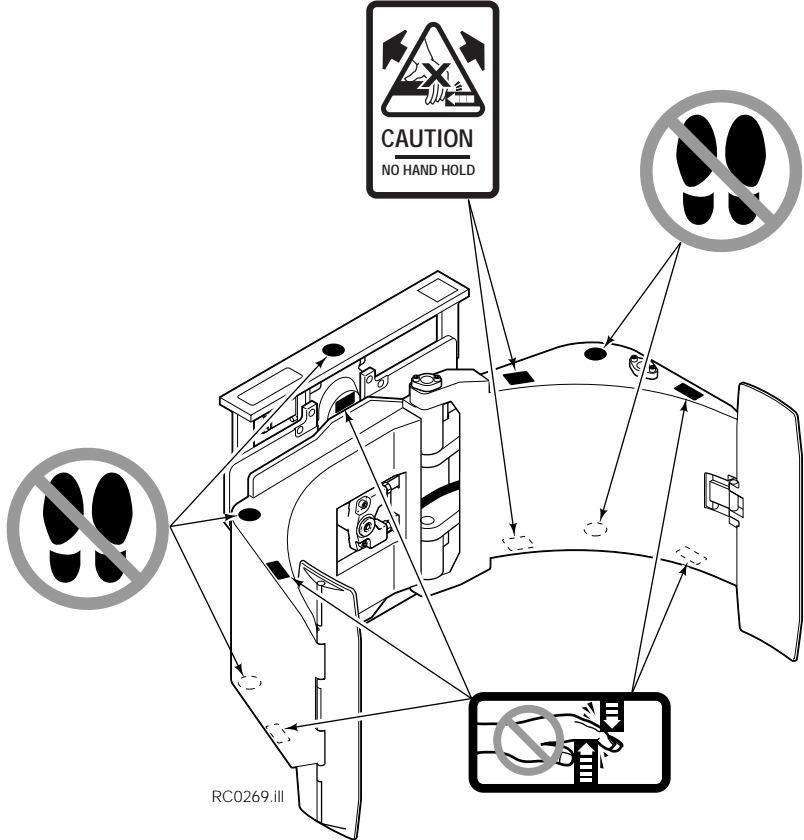
To Order Parts call: 888-227-2233, Fax: 888-329-0234

OR

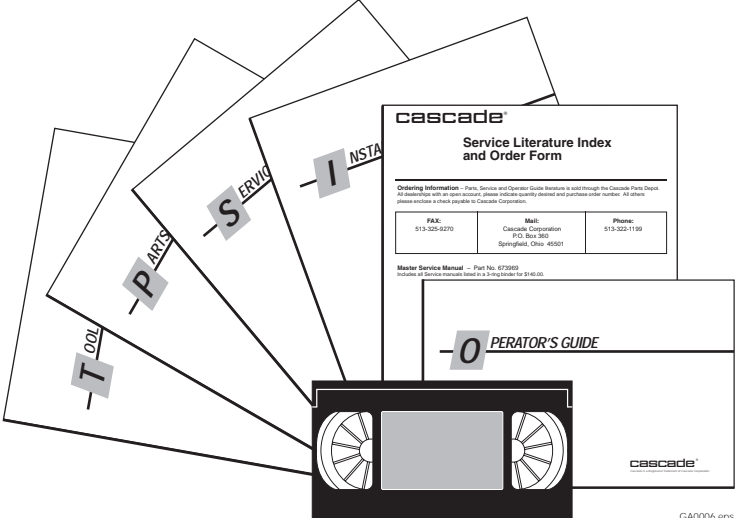
Write: Cascade Corporation, P.O. Box 20187, Portland, OR 97220

Internet: www.cascorp.com

Safety Decals

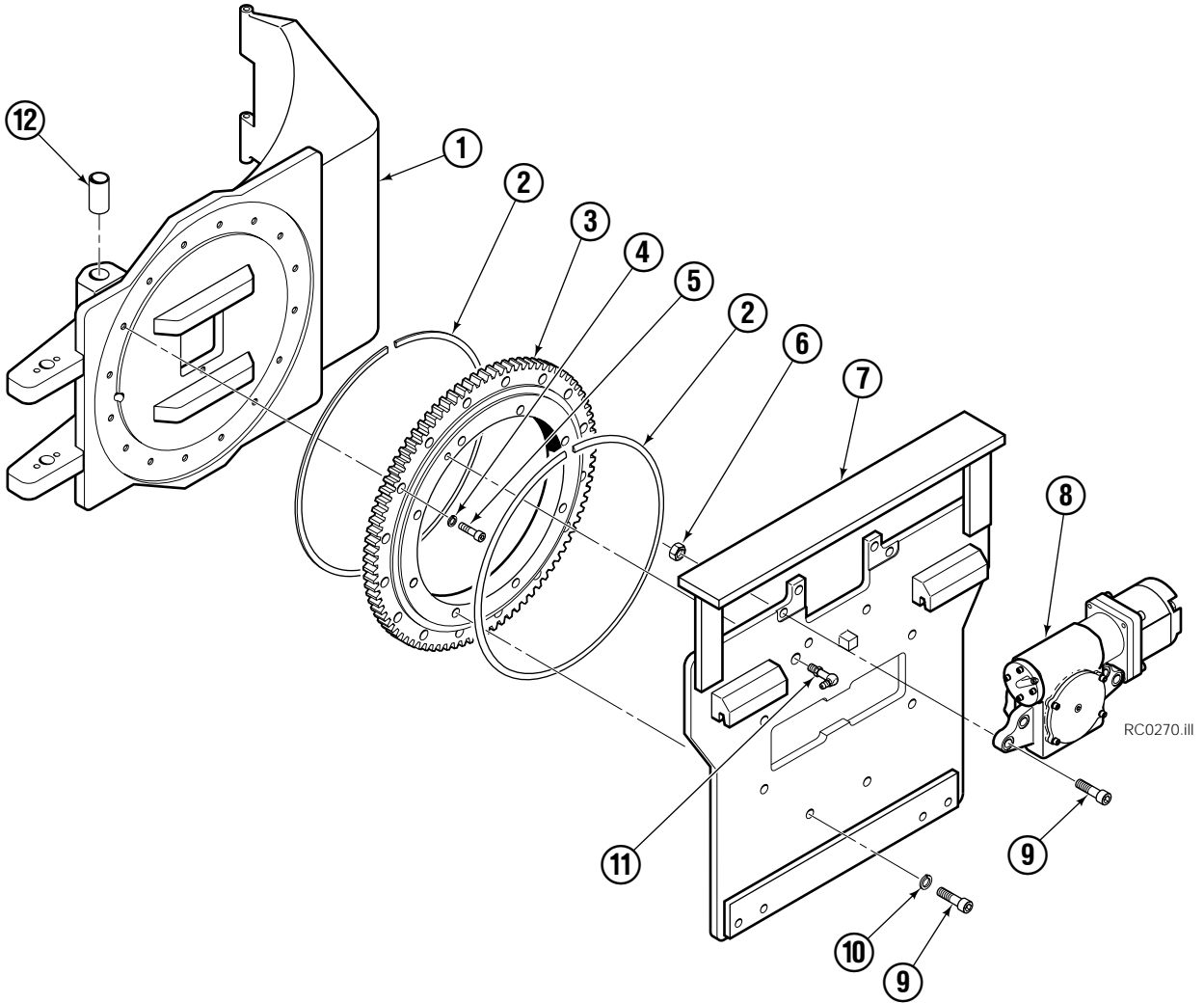


Publications



| 25F | |
|----------|-----------------------------|
| PART NO. | DESCRIPTION |
| 681466 | Service Manual |
| 210135 | Operators Guide |
| 674510 | Installation Instructions |
| 679929 | Tool Catalog |
| 673964 | Literature Index Order Form |

Base Unit Group

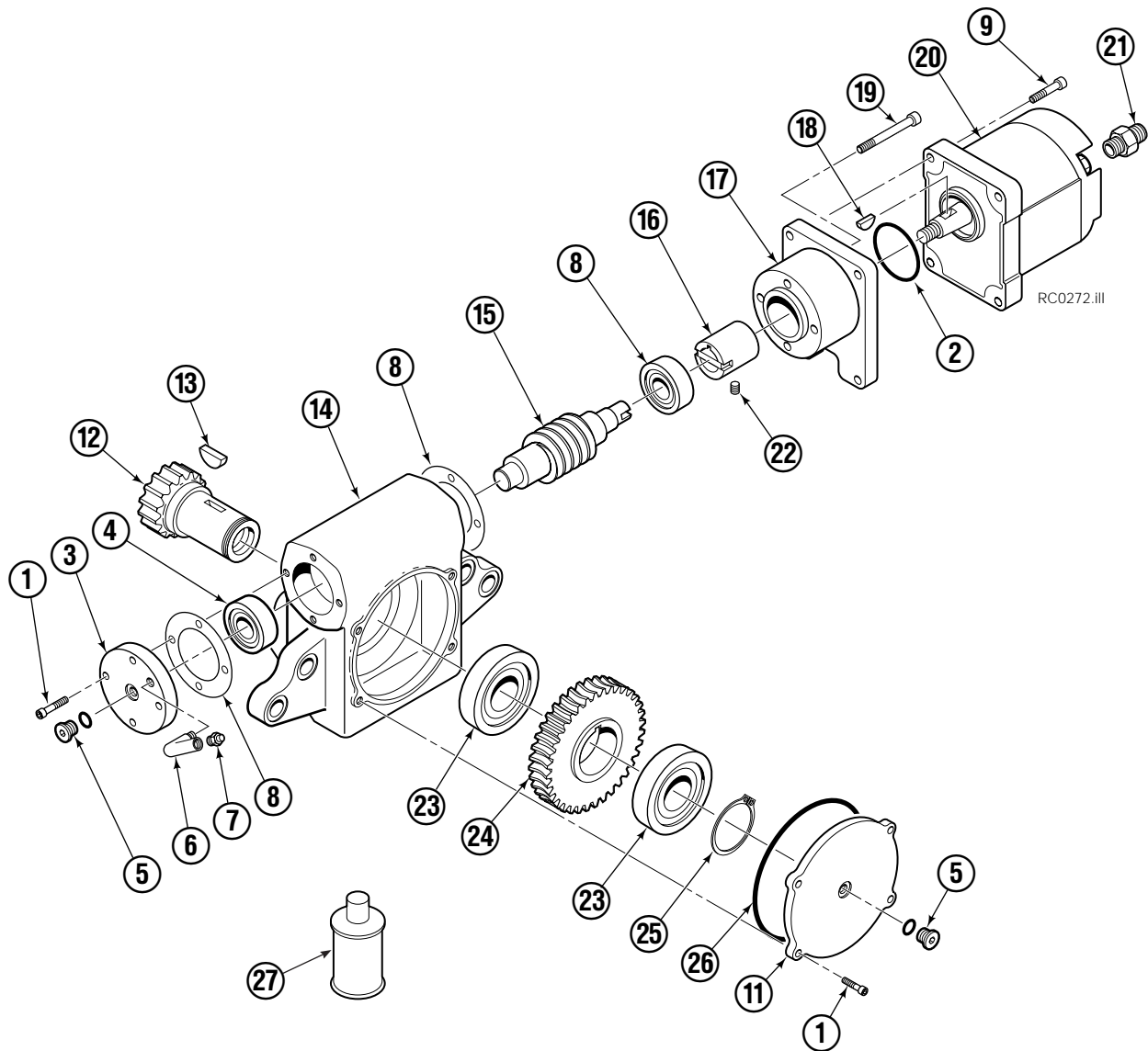


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| REF | QTY | PART NO. | DESCRIPTION |
|-----|-----|----------|--------------------|
| | | 381117 | Base Unit Group |
| 1 | 1 | 381119 | ● Frame |
| 2 | 2 | 673043 | Seal |
| 3 | 1 | 201082 | ■ Bearing Assembly |
| 4 | 16 | 678991 | Lockwasher |
| 5 | 16 | 769571 | Capscrew |
| 6 | 4 | 678990 | Nut |
| 7 | 1 | 201099 | Baseplate |
| 8 | 1 | 679106 | ▼ Drive Group |
| 9 | 12 | 769577 | Capscrew |
| 10 | 8 | 678992 | Lockwasher |
| 11 | 1 | 201080 | Grease Fitting |
| 12 | 4 | 676163 | Bearing |

- Includes item 12.
- Includes items 2 and 11.
- ▼ See Drive Group page for parts breakdown.

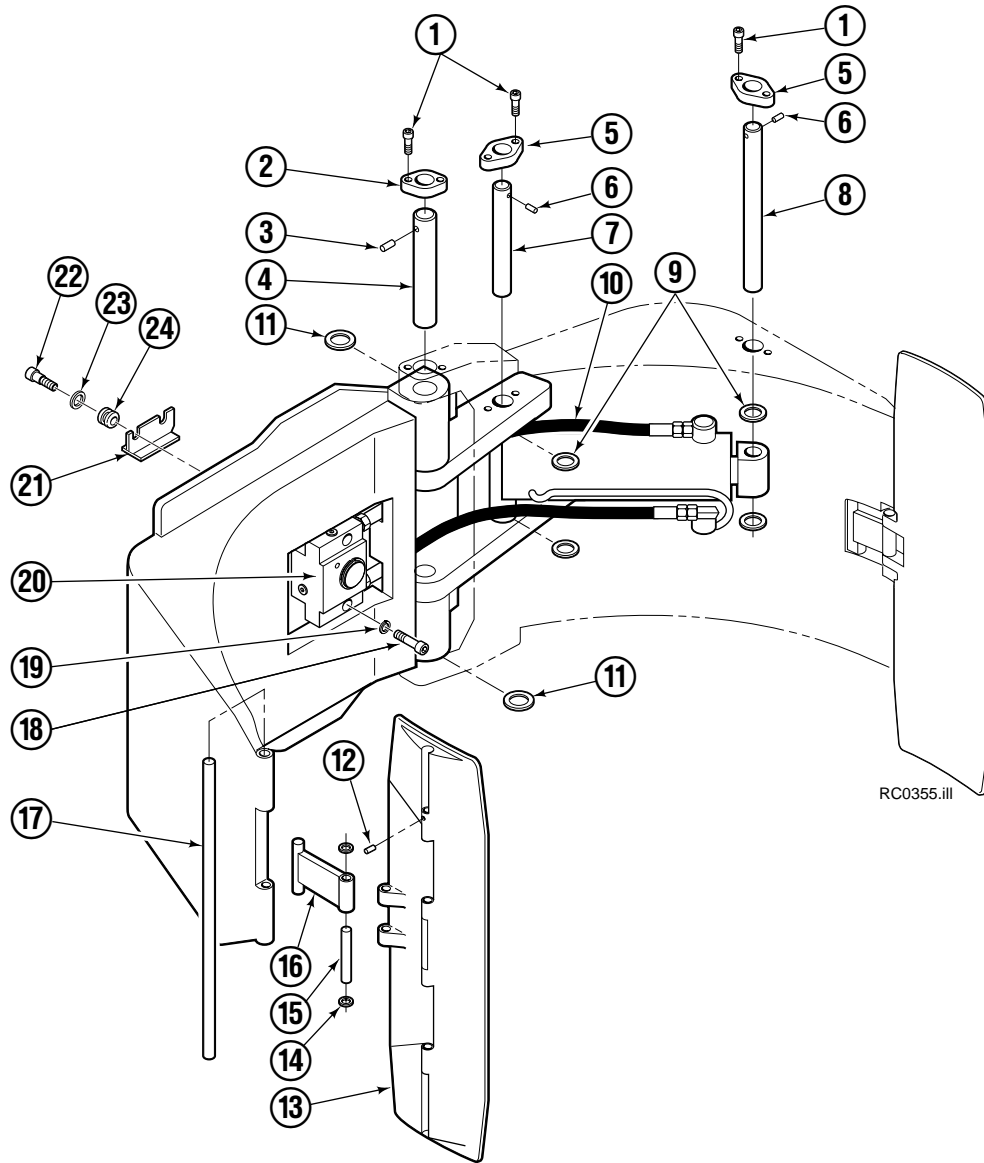
Drive Group



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| REF | QTY | PART NO. | DESCRIPTION | REF | QTY | PART NO. | DESCRIPTION |
|-----|-----|----------|-----------------------|-----|-----|----------|-----------------------|
| | | 679106 | Drive Group | 15 | 1 | 679109 | Worm |
| 1 | 4 | 768786 | Capscrew, M6 X 25-8.8 | 16 | 1 | 679118 | Coupling |
| 2 | 1 | 643352 | O-Ring | 17 | 1 | 679115 | Adapter |
| 3 | 1 | 679114 | End Cap | 18 | 1 | 678999 | Key |
| 4 | 2 | 678985 | Bearing | 19 | 4 | 768792 | Capscrew, M6 X 60-8.8 |
| 5 | 2 | 663694 | Fitting, 3 | 20 | 1 | 206418 | Motor |
| 6 | 1 | 6688 | Fitting, 2 | 21 | 2 | 626505 | Fitting, 10-6 |
| 7 | 1 | 644010 | Relief Fitting | 22 | 1 | 678994 | Setscrew |
| 8 | 2 | 679808 | Shim-.002 in.(.05mm) | 23 | 2 | 678986 | Bearing |
| 9 | 4 | 768787 | Capscrew, M6 X 30-8.8 | 24 | 1 | 679110 | Worm Gear |
| 10 | 4 | 752845 | Capscrew, M6 X 16-8.8 | 25 | 1 | 678987 | Snap Ring |
| 11 | 1 | 679112 | Cover | 26 | 1 | 643368 | O-ring |
| 12 | 1 | 679111 | Pinion | 27 | 1 | 656300 | Gear Lube (48 oz.) |
| 13 | 1 | 201815 | Key | | | 206419 | Motor Shaft Seal Kit |
| 14 | 1 | 679107 | Gear Case | | | 206421 | Motor Service Kit |

Common Components



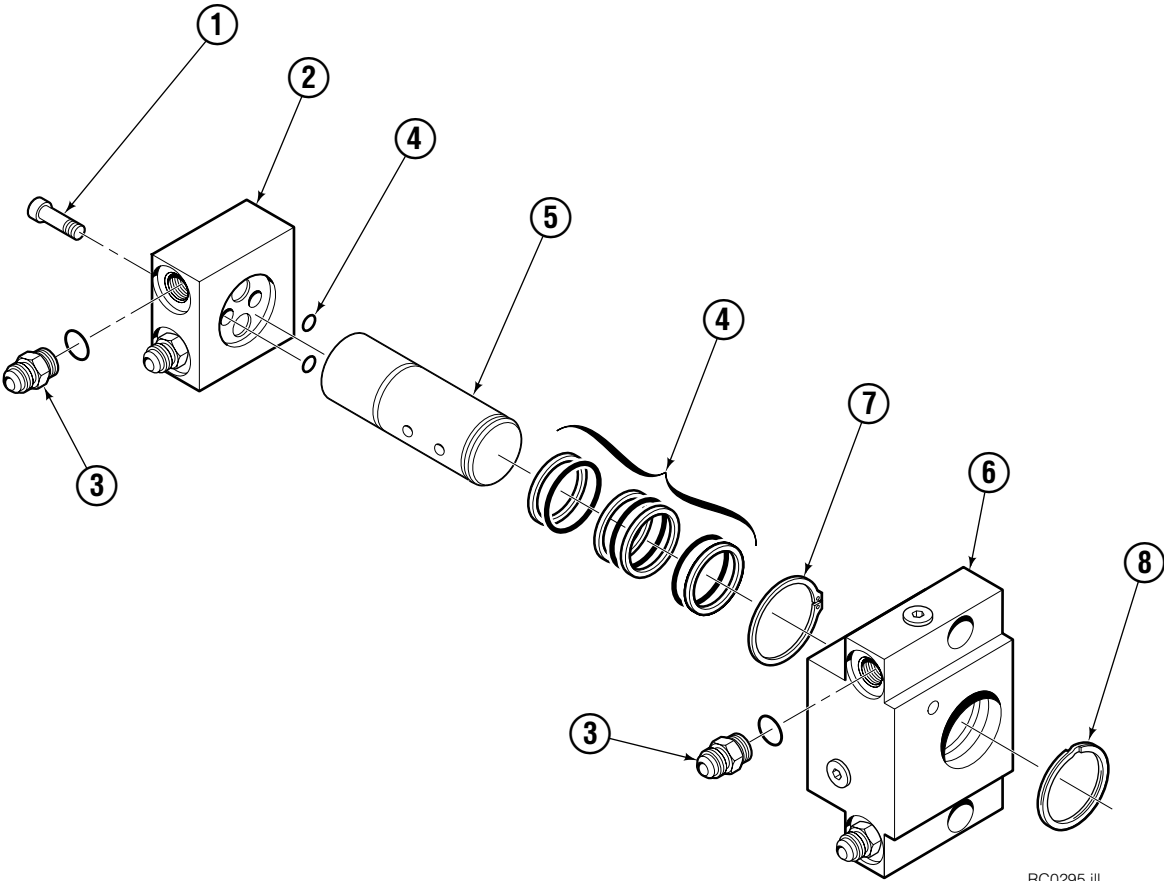
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| REF | QTY | PART NO. | DESCRIPTION | REF | QTY | PART NO. | DESCRIPTION |
|-----|-----|----------|------------------------------------|-----|-----|----------|-------------------------|
| | | 381125 | Common Components (Items 1-9 & 11) | 12 | 2 | 201732 | Drive Pin |
| | | 369321 | Contact Pad Group (Items 12-17) | 13 | 2 | 369363 | Contact Pad |
| 1 | 8 | 768809 | Capscrew, M10 x 16 | 14 | 4 | 678988 | Snap Ring |
| 2 | 2 | 206590 | Retainer | 15 | 2 | 679812 | Pin |
| 3 | 2 | 674256 | Drive Pin | 16 | 2 | 680033 | Link |
| 4 | 2 | 680028 | Pin | 17 | 2 | 355166 | Pin |
| 5 | 2 | 206589 | Retainer | 18 | 2 | 768810 | Capscrew ◆ |
| 6 | 2 | 673385 | Drive Pin | 19 | 2 | 680030 | Lockwasher, M10 ◆ |
| 7 | 1 | 680029 | Pin | 20 | 1 | 206600 | Revolving Connection ■◆ |
| 8 | 1 | 675018 | Pin | 21 | 1 | 209067 | End Block Bracket ◆ |
| 9 | 12 | 674257 | Shim, .06 in. | 22 | 2 | 208780 | Shoulder Bolt ◆ |
| 10 | 2 | 207425 | Hose, 24.00 in. ◆ | 23 | 2 | 209043 | Flat Washer ◆ |
| 11 | 4 | 660200 | Shim, .06 in. | 24 | 2 | 208765 | Grommet ◆ |

■ See Revolving Connection page parts breakdown.

◆ Included in Revolving Connection Hose Group 383394.

Revolving Connection

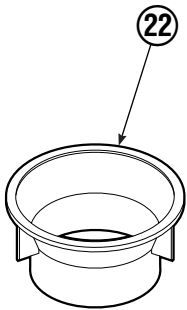
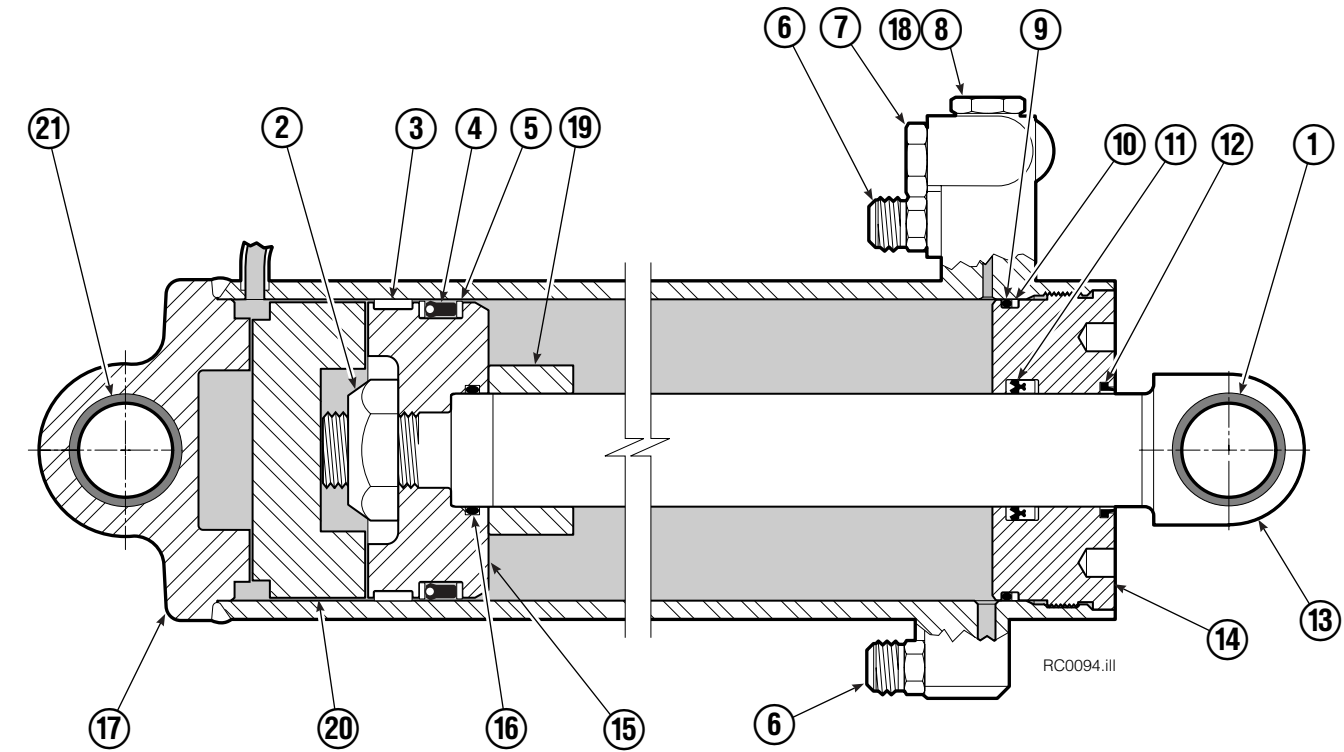


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| 25F | | | |
|------------|-----|----------|---------------------------------|
| REF | QTY | PART NO. | DESCRIPTION |
| | | 206600 | Revolving Connection Assembly ■ |
| 1 | 2 | 768796 | Capscrew |
| 2 | 1 | 687301 | End Block |
| 3 | 4 | 604511 | Fitting, 6-6 |
| 4 | 1 | 206599 | Service Kit |
| 5 | 1 | 206594 | Shaft |
| 6 | 1 | 206595 | Body |
| 7 | 1 | 7341 | Snap Ring |
| 8 | 1 | 3138 | Snap Ring |

■ Body is stamped 206596.

Long Arm Cylinder

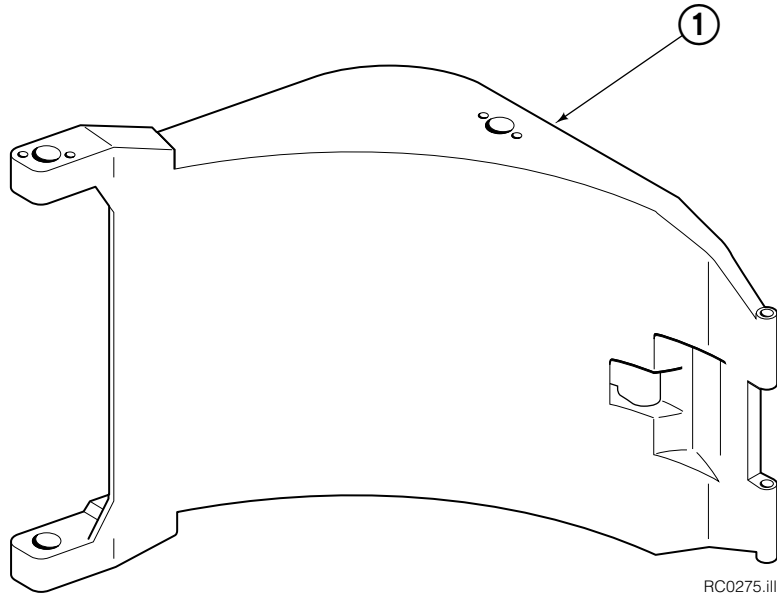


| REF | QTY | PART NO. | DESCRIPTION |
|-----|-----|----------|-------------------------|
| | | 583939 | Cylinder Assembly |
| 1 | 1 | 674843 | Bearing |
| 2 | 1 | 560997 | Nut |
| 3 | 1 | 660769 | ◆ Bearing |
| 4 | 1 | 662462 | ◆ Seal |
| 5 | 2 | 638295 | ◆ Back-Up Ring |
| 6 | 2 | 604511 | Fitting, 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 | 557401 | Rod |
| 14 | 1 | 555724 | Retainer |
| 15 | 1 | 557389 | Piston |
| 16 | 1 | 2722 | ◆ O-Ring |
| 17 | 1 | 564122 | Shell |
| 18 | 1 | 667516 | Check Valve Service Kit |
| 19 | 1 | 558484 | Spacer |
| 20 | 1 | — | Spacer |
| 21 | 2 | 675006 | Bearing |
| 22 | 1 | 669243 | ◆ Seal Loader |
| | | 555725 | Service Kit |

◆ Included in Service Kit 555725.

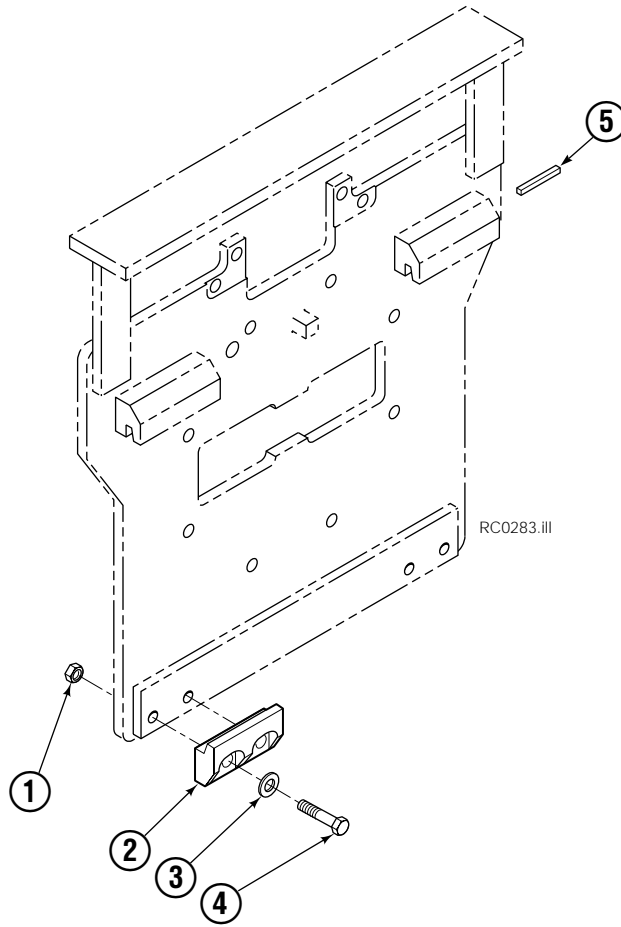
Reference: S-5320.

Arms



| 25F | | | |
|-----|-----|----------|-------------|
| REF | QTY | PART NO. | DESCRIPTION |
| 1 | 1 | 381110 | Arm |

Bolt-On Mounting Group



| Class II, 1.5° | | | |
|----------------|-----|----------|--------------------|
| REF | QTY | PART NO. | DESCRIPTION |
| | | 680022 | Mounting Group |
| 1 | 4 | 678990 | Nut, M16 |
| 2 | 2 | 675968 | Hook |
| 3 | 4 | 667225 | Washer, 5/8 |
| 4 | 4 | 678996 | Capscrew, M16 x 60 |
| 5 | 1 | 669344 | Stop Kit |

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

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