



# Parts Manual

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Model 25F Roll Clamp (25F-RC-04A)

Serial Number 201095

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**cascade**<sup>®</sup>

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

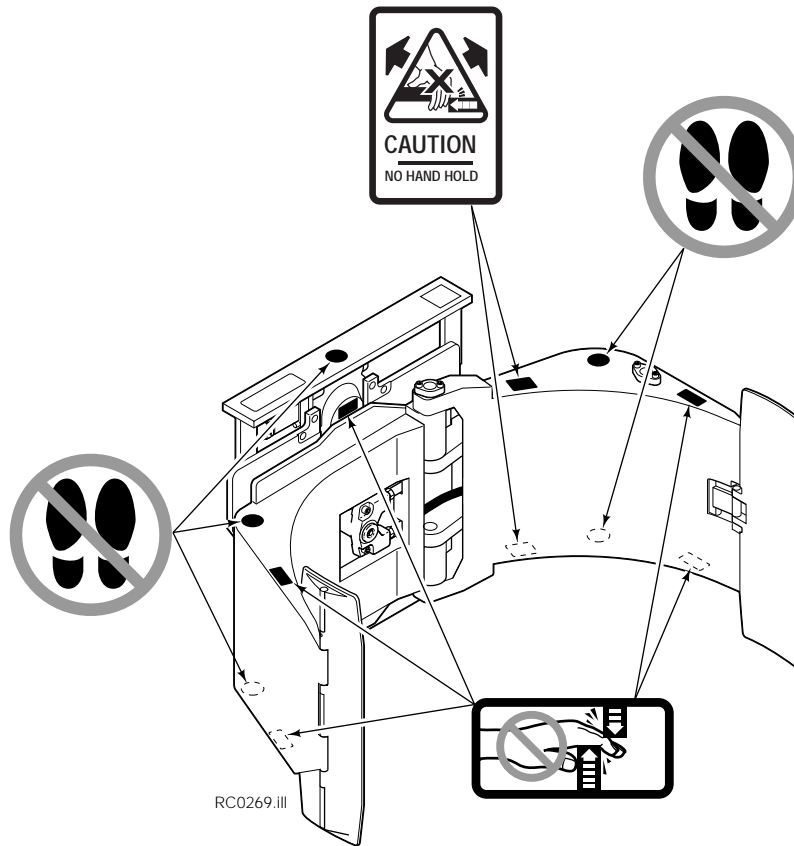
**To Order Parts call:** 888-227-2233, Fax: 888-329-0234

**OR**

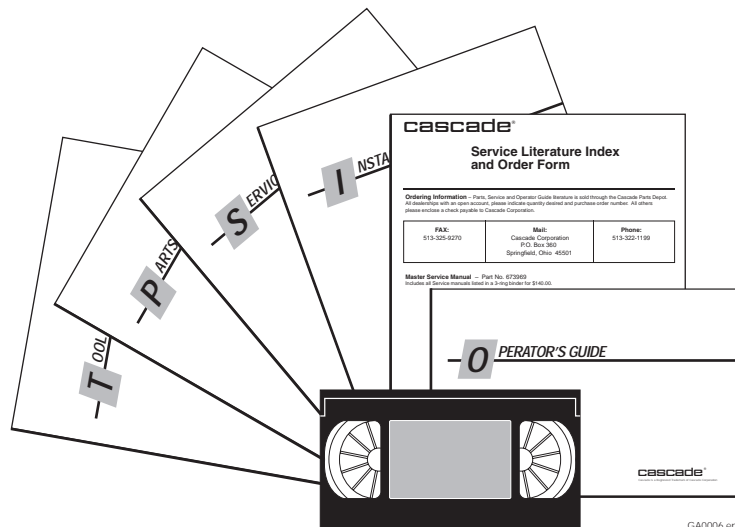
**Write:** Cascade Corporation, P.O. Box 20187, Portland, OR 97220

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

## Safety Decals

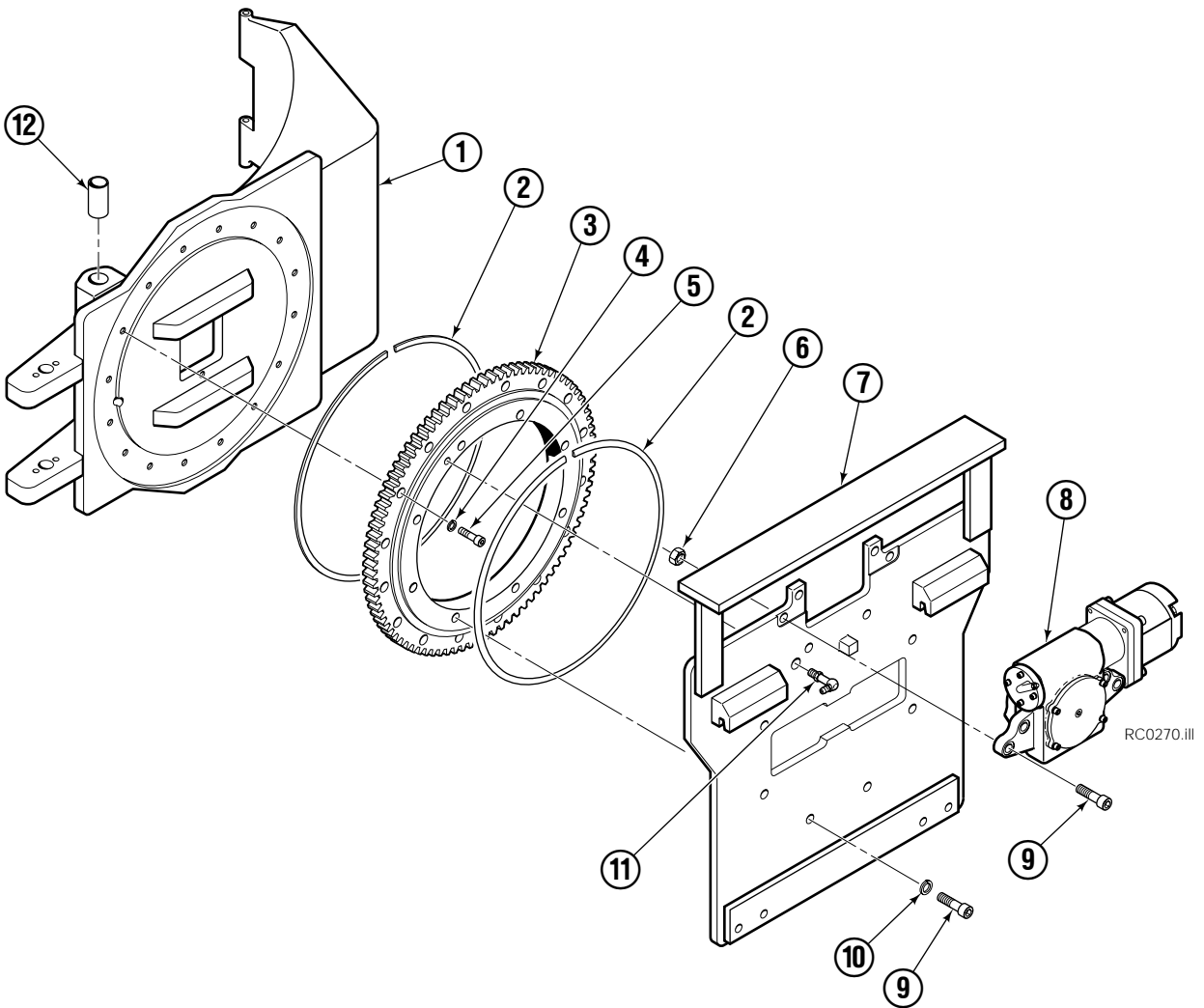


## Publications



25F	
PART NO.	DESCRIPTION
681466	Service Manual
674509	Operators Guide
674510	Installation Instructions
679929	Tool Catalog
673964	Literature Index Order Form

# Base Unit Group

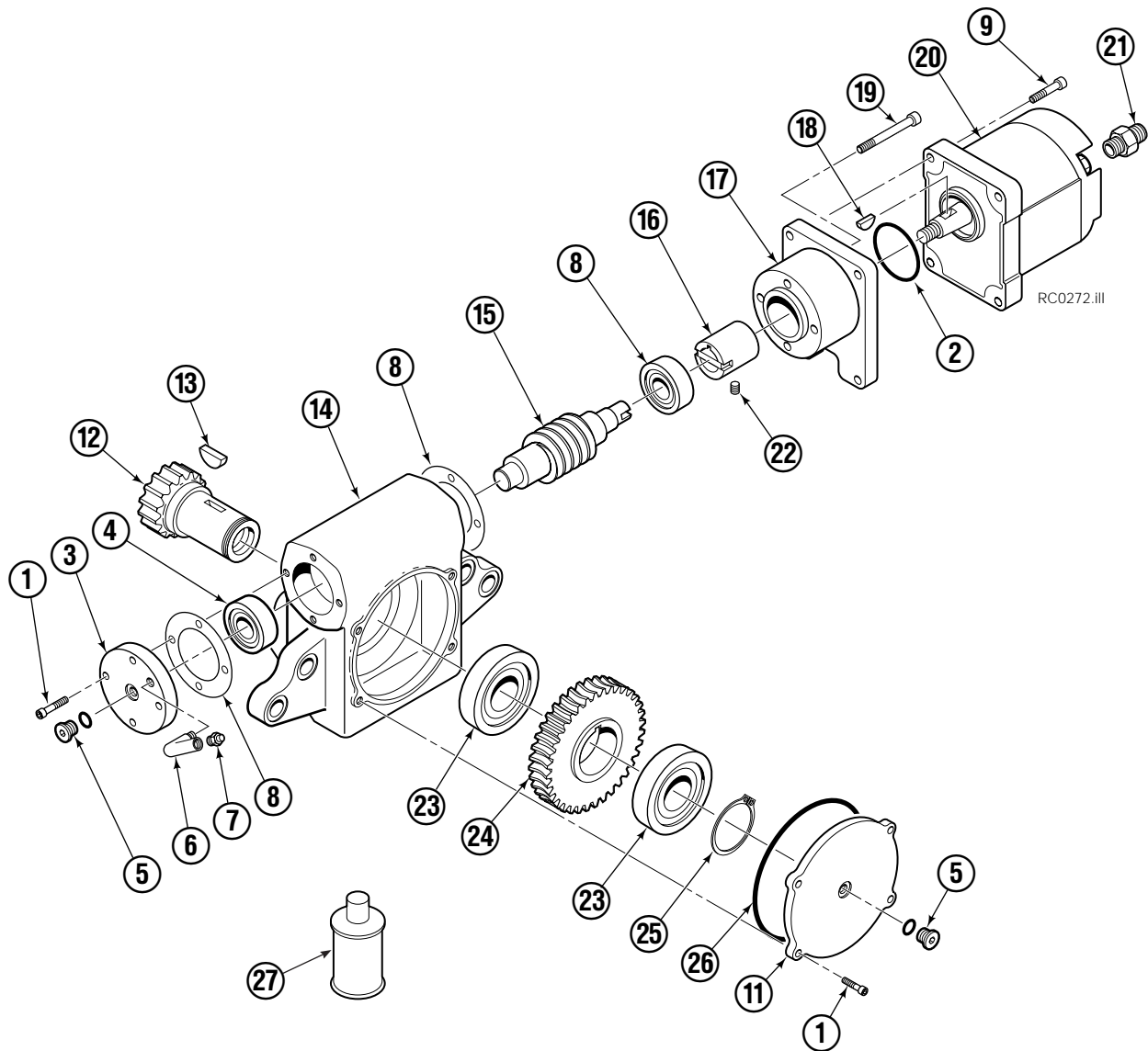


## 25F

REF	QTY	PART NO.	DESCRIPTION
		206766	Base Unit Group – 45 in.◆
1	1	206705	● Frame – 45 in.◆
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

- ◆ Maximum roll diameter.
  - Includes item 12.
  - Includes items 2 and 11.
  - ▼ See Drive Group page for parts breakdown.
- Reference: Common Parts 201101.

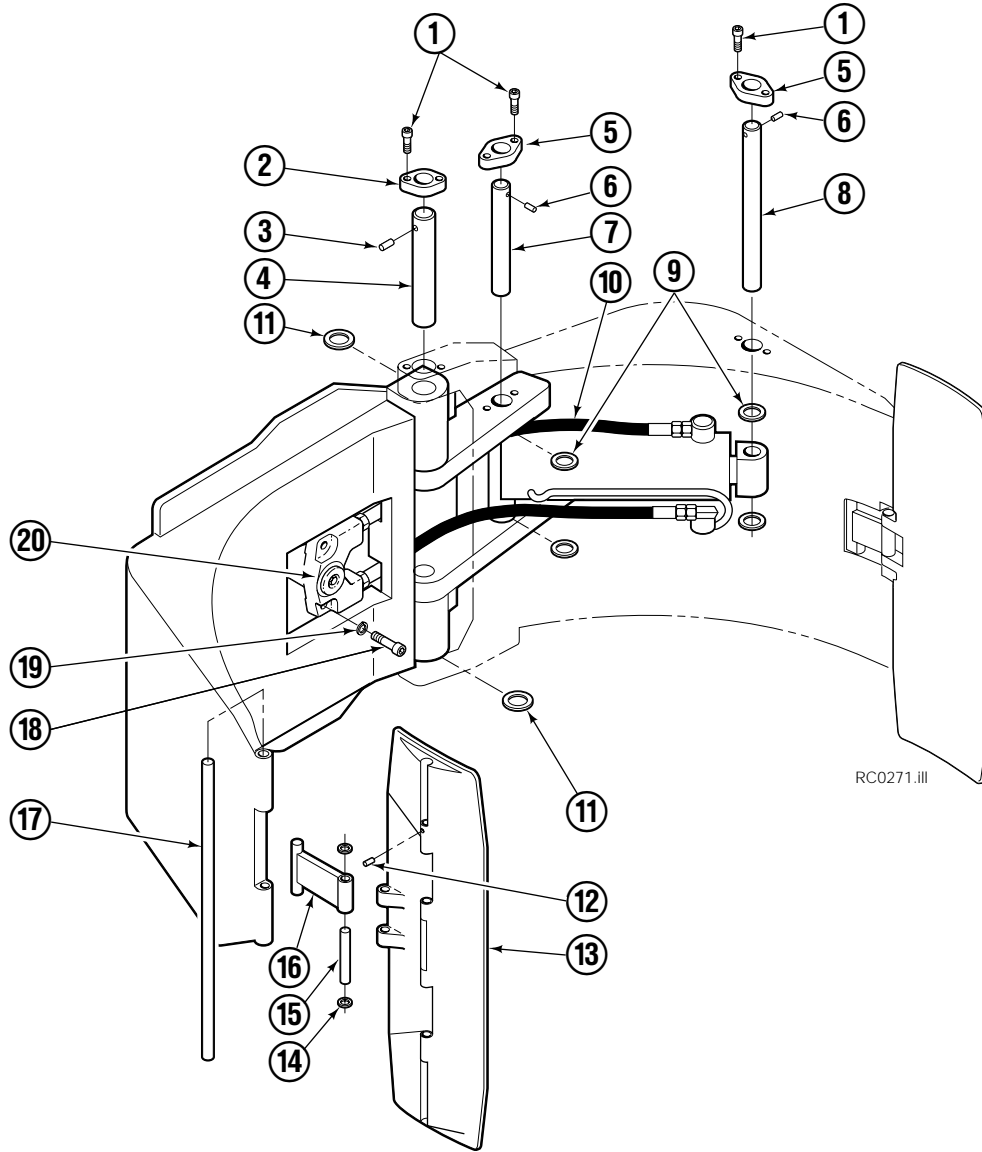
# Drive Group



## 25F

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

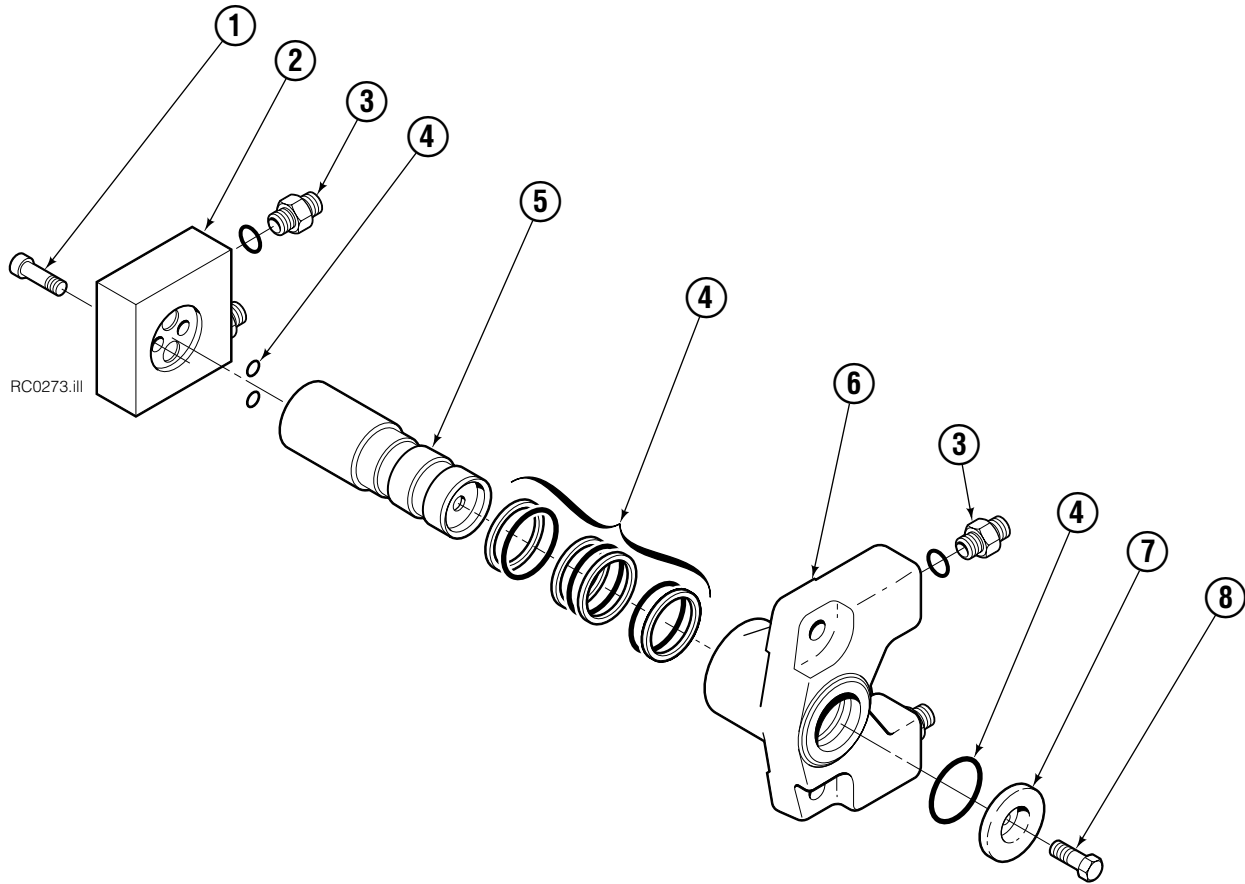


## 25F

REF	QTY	PART NO.	DESCRIPTION	REF	QTY	PART NO.	DESCRIPTION
		680026	Common Components Group	11	4	660200	Shim, .06 in.
1	8	768809	Capscrew, M10 x 16	12	2	201732	Drive Pin
2	2	674829	Retainer	13	2	680031	Contact Pad
3	2	674256	Drive Pin	14	4	678988	Snap Ring
4	2	680028	Pin	15	2	679812	Pin
5	2	674828	Retainer	16	2	680033	Link
6	2	673385	Drive Pin	17	2	680032	Pin
7	1	680029	Pin	18	2	768810	Capscrew
8	1	675018	Pin	19	2	680030	Lockwasher, M10
9	6	674257	Shim, .06 in.	20	1	679952	■ Revolving Connection
10	2	680027	Hose, 6-6				

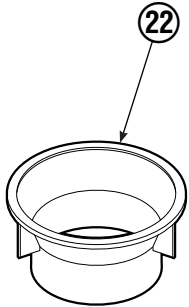
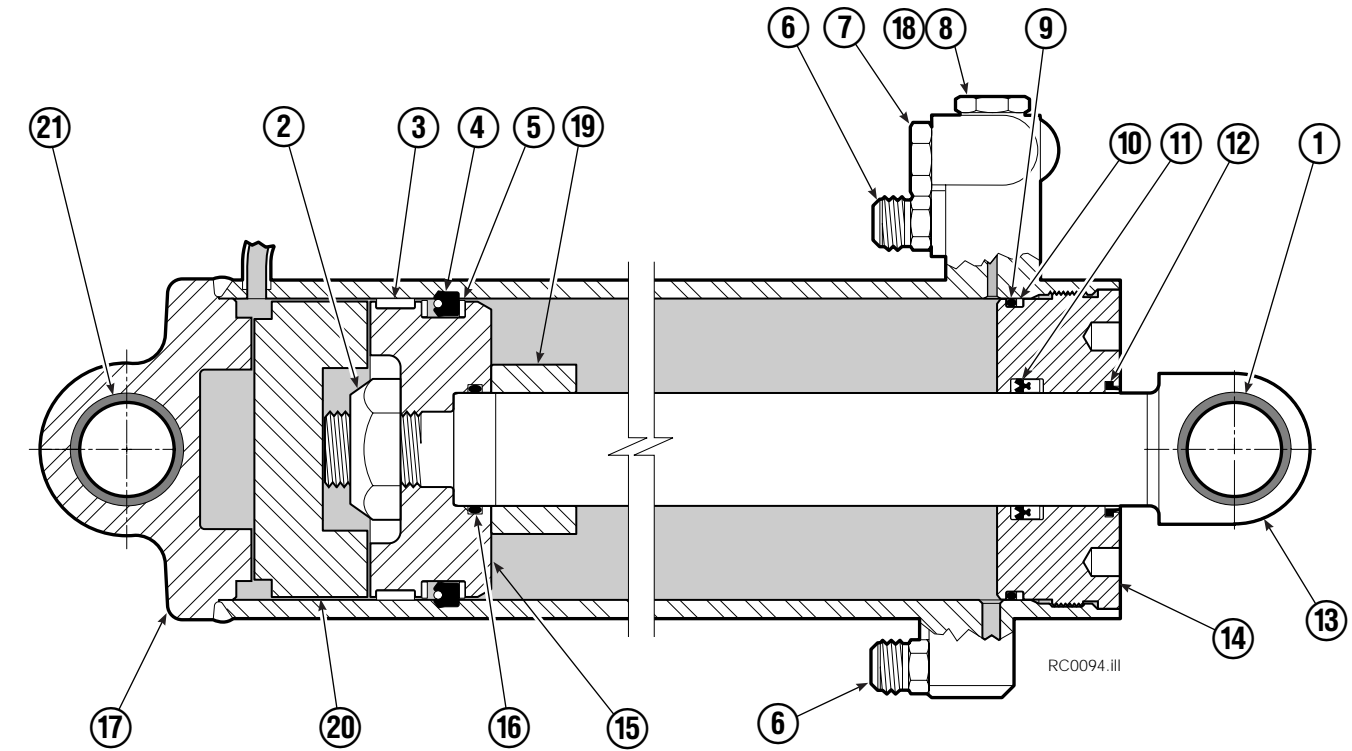
■ See Revolving Connection page parts breakdown.

# Revolving Connection



25F			
REF	QTY	PART NO.	DESCRIPTION
		679952	Revolving Connection
1	2	672550	Capscrew
2	1	679951	Block
3	4	604511	Fitting, 6-6
4	1	680062	Service Kit
5	1	679950	Shaft
6	1	679949	Body
7	1	672544	Cap
8	1	672542	Capscrew

# Cylinder

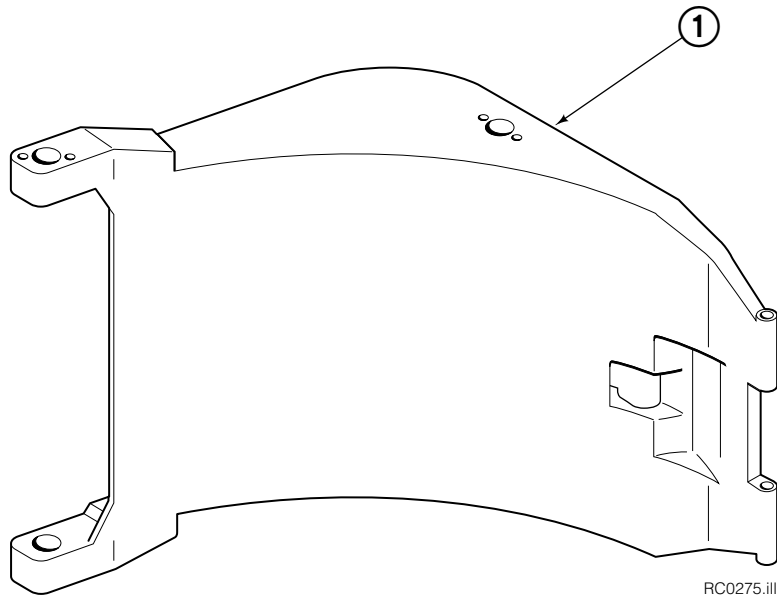


25F			
REF	QTY	PART NO.	DESCRIPTION
		557386	Cylinder Assembly
1	1	674843	Bearing
2	1	560997	Nut
◆ 3	1	660769	Bearing
◆ 4	1	662462	Seal
◆ 5	2	638295	Back-Up Ring
6	2	604511	Fitting, 6-6
7	1	556852	Fitting, 4
8	1	557212	Check Valve
◆ 9	1	2801	O-Ring
◆ 10	1	583977	Back-Up Ring
◆ 11	1	554598	Seal
◆ 12	1	628047	Wiper
13	1	557404	Rod
14	1	555724	Retainer
15	1	557389	Piston
◆ 16	1	2722	O-Ring
17	1	557411	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.

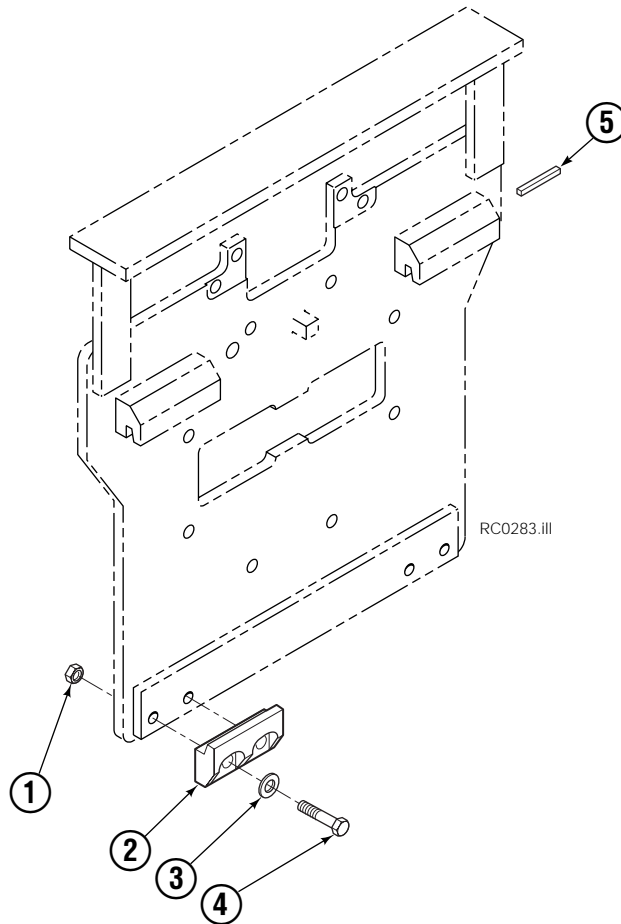
Ref: S-5320, S-5321

# Arms



25F			
REF	QTY	PART NO.	DESCRIPTION
1	1	679813	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.

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