



# Parts Manual

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Model 25F Roll Clamp

Serial Number 25F-RCF-151

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**cascade**<sup>®</sup>  
**corporation**

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

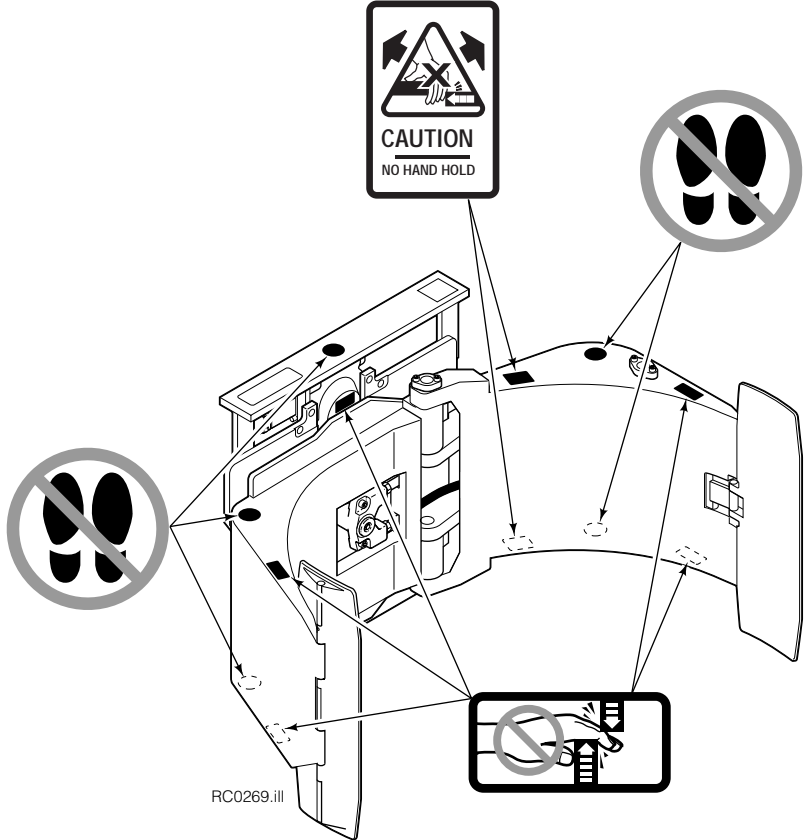
**To Order Parts call:** 888-227-2233, Fax: 888-329-0234

**OR**

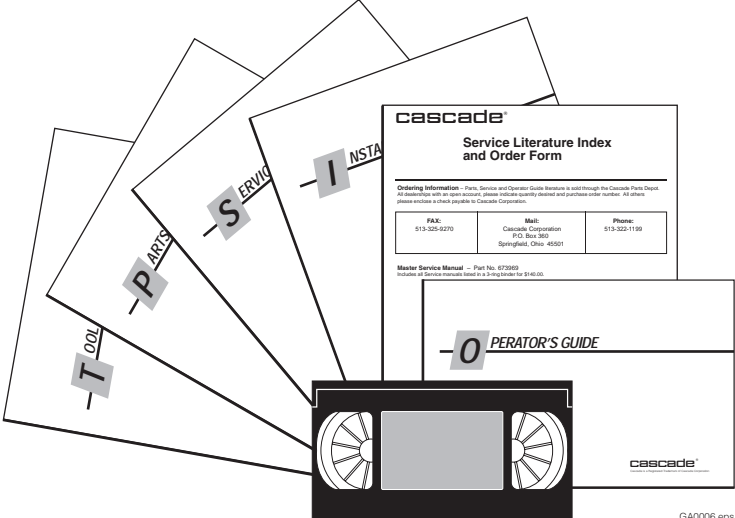
**Write:** Cascade Corporation, P.O. Box 20187, Portland, OR 97220

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

# Safety Decals

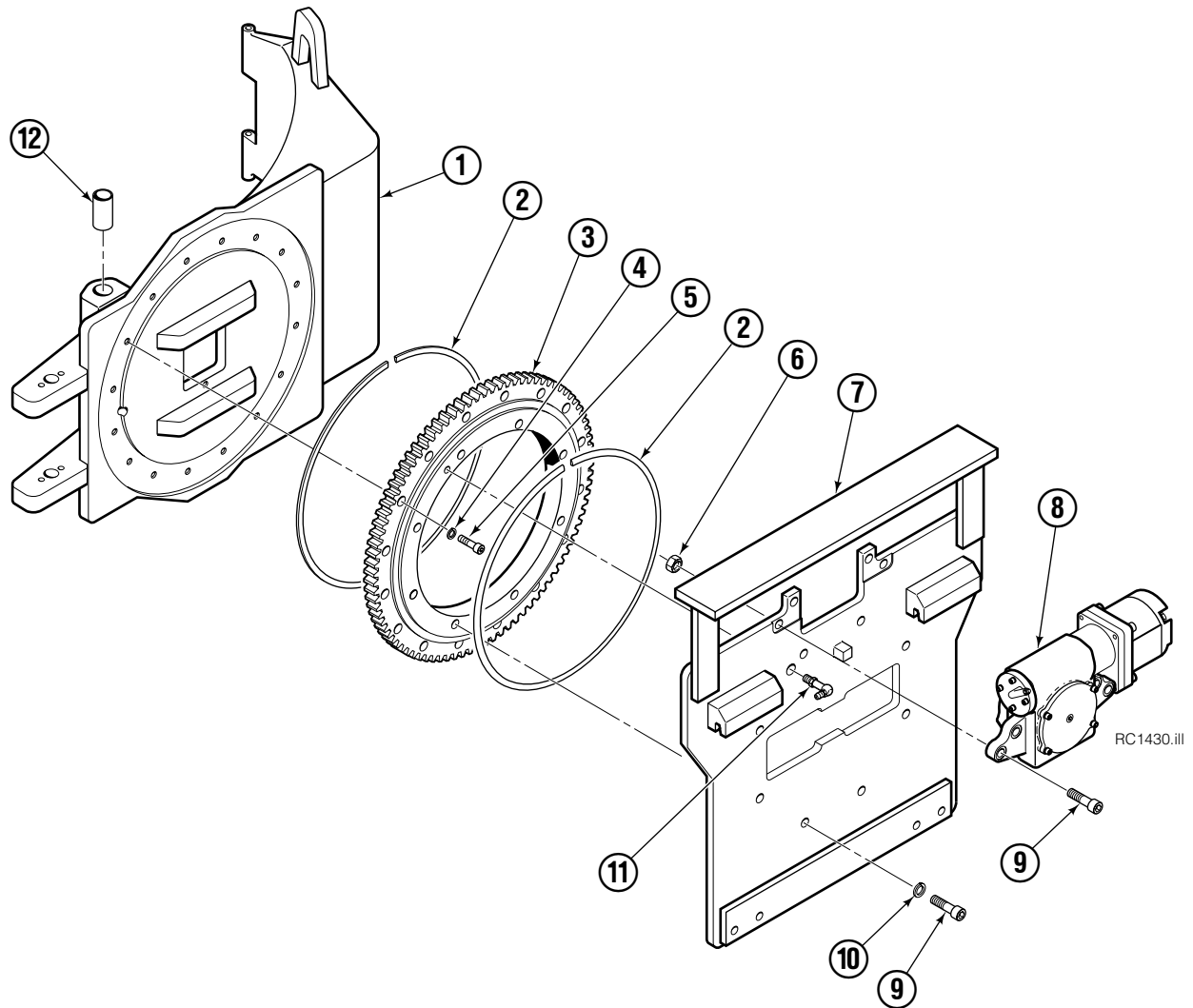


# Publications



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

# Base Unit



25F			
REF	QTY	PART NO.	DESCRIPTION
		6002620	Base Unit – 45 in. ◆
1	1	6002621	Frame – 45 in. ◆ ●
2	2	673043	Seal
3	1	201082	Bearing Assembly ■
4	16	678991	Lockwasher, M12
5	16	769571	Capscrew, M12 x 30
6	4	678990	Nut, M16
7	1	201099	Baseplate
8	1	679106	Drive Group ★
9	12	769577	Capscrew, M16 x 50
10	8	678992	Lockwasher, M16
11	1	201080	Grease Fitting
12	4	676163	Bushing

◆ Maximum roll diameter.

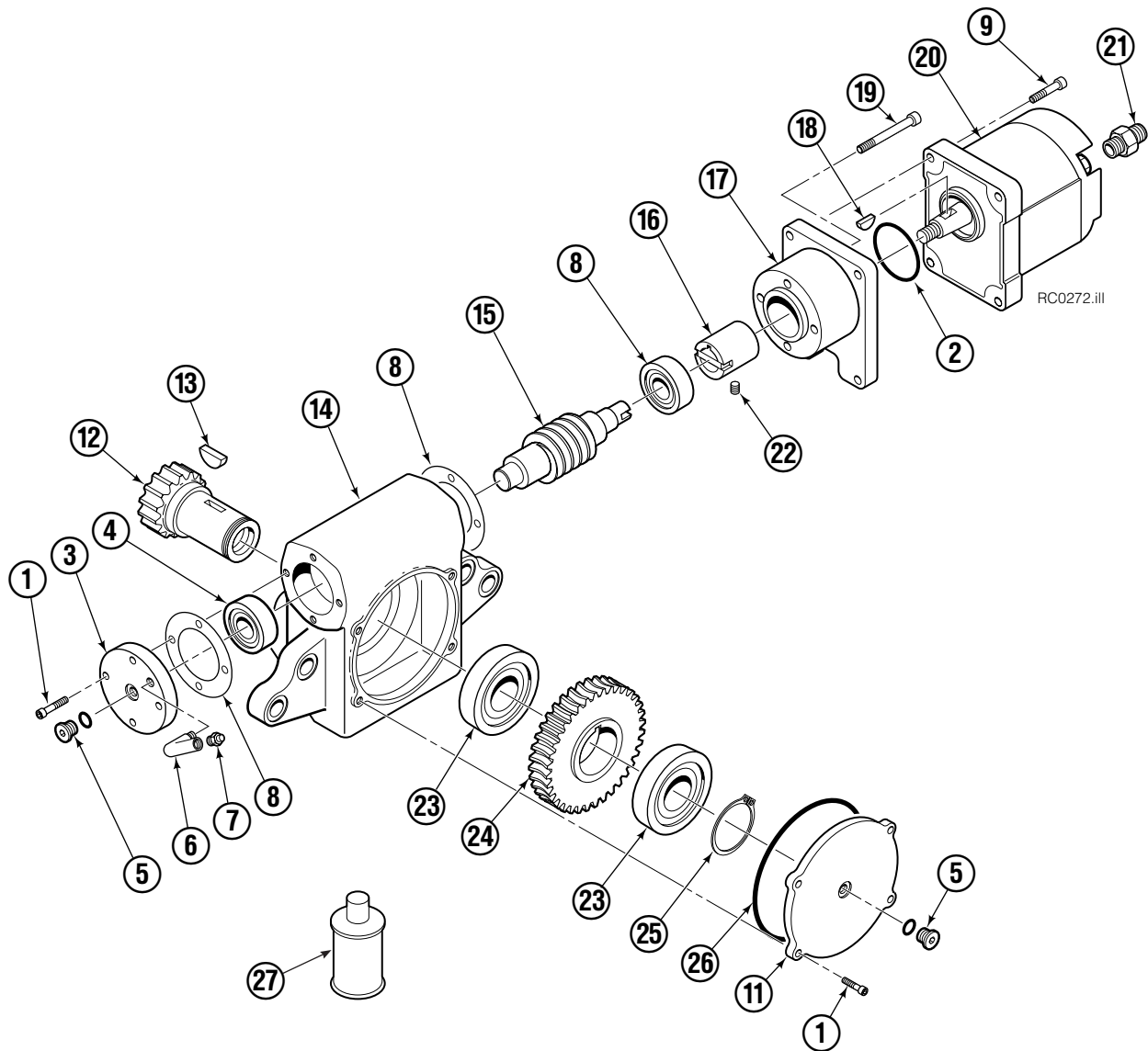
● Includes item 12.

■ Includes items 2 and 11.

★ See Drive Group page for parts breakdown.

Reference: Common Parts 201101.

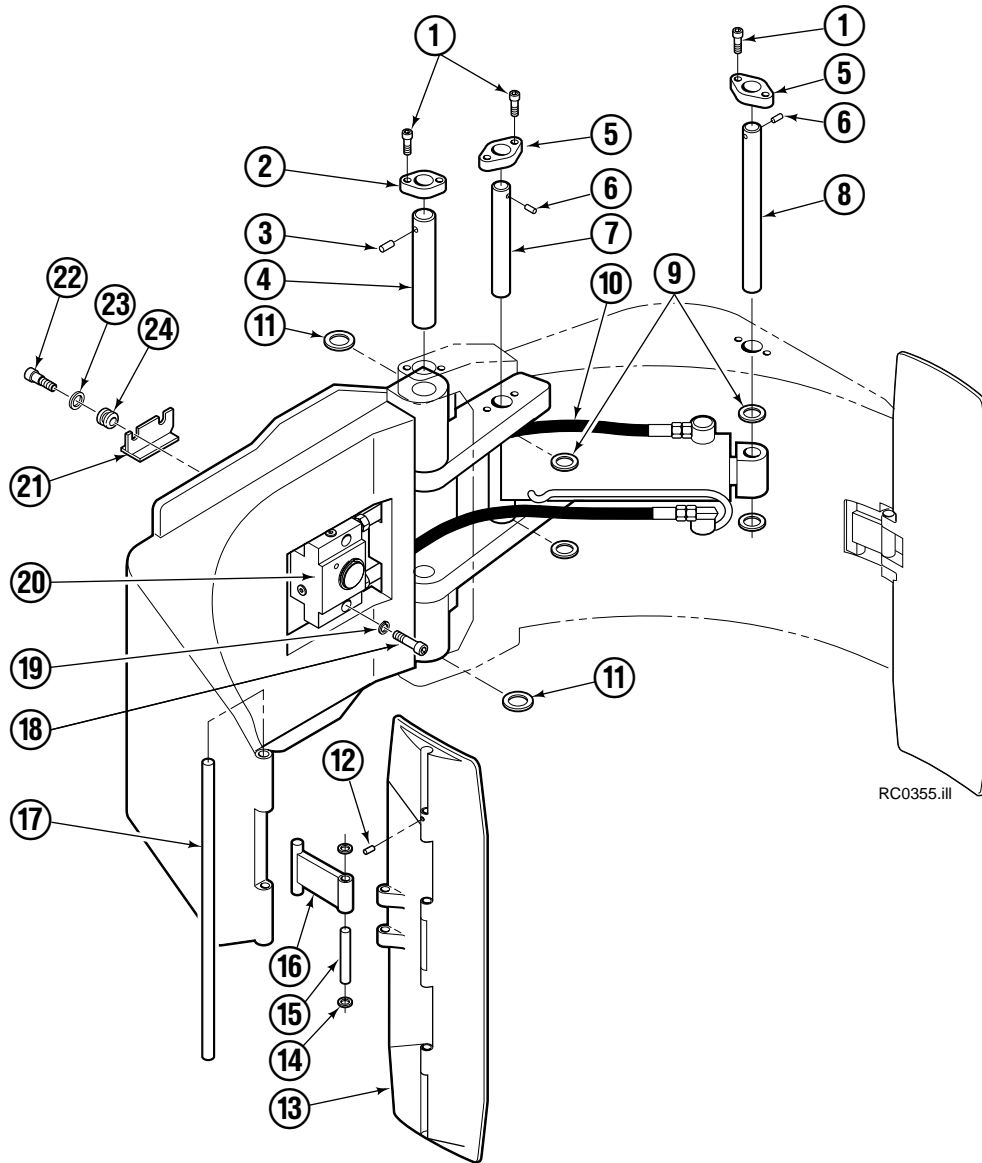
# Drive Group



## 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

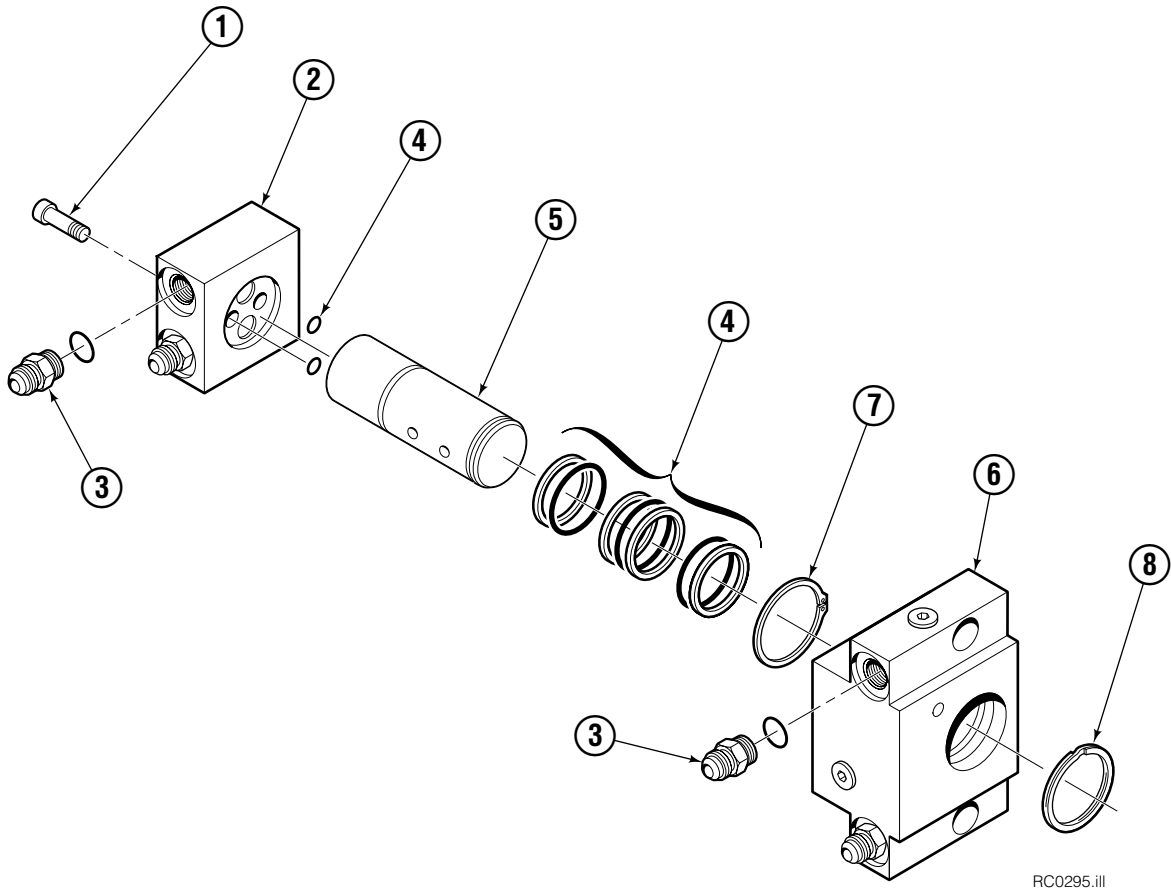


## 25F

REF	QTY	PART NO.	DESCRIPTION	REF	QTY	PART NO.	DESCRIPTION
		227930	Common Components	13	1	680031	Contact Plate - SA ●
1	8	768809	Capscrew, M10 x 16	13	1	207430	Contact Plate - LA ●
2	2	206590	Retainer	14	4	678988	Snap Ring
3	2	674256	Drive Pin	15	2	679812	Pin
4	2	680028	Pin	16	2	680033	Link
5	2	206589	Retainer	17	2	680032	Pin
6	2	673385	Drive Pin	18	2	768810	▲ Capscrew
7	1	680029	Pin	19	2	680030	▲ Lockwasher, M10
8	1	675018	Pin	20	1	206600	▲ Revolving Connection ■
9	12	674257	Shim, .06 in.	21	1	209067	▲ End Block Bracket
10	2	680027	▲ Hose, 6-6	22	2	208780	▲ Shoulder Bolt
11	4	660200	Shim, .06 in.	23	2	209043	▲ Flat Washer
12	2	201732	Drive Pin	24	2	208765	▲ Grommet

- See Revolving Connection page for parts breakdown.
- ▲ Included in Revolving Connection Hose Group 207444.
- Not Included in Common Components.

# Revolving Connection

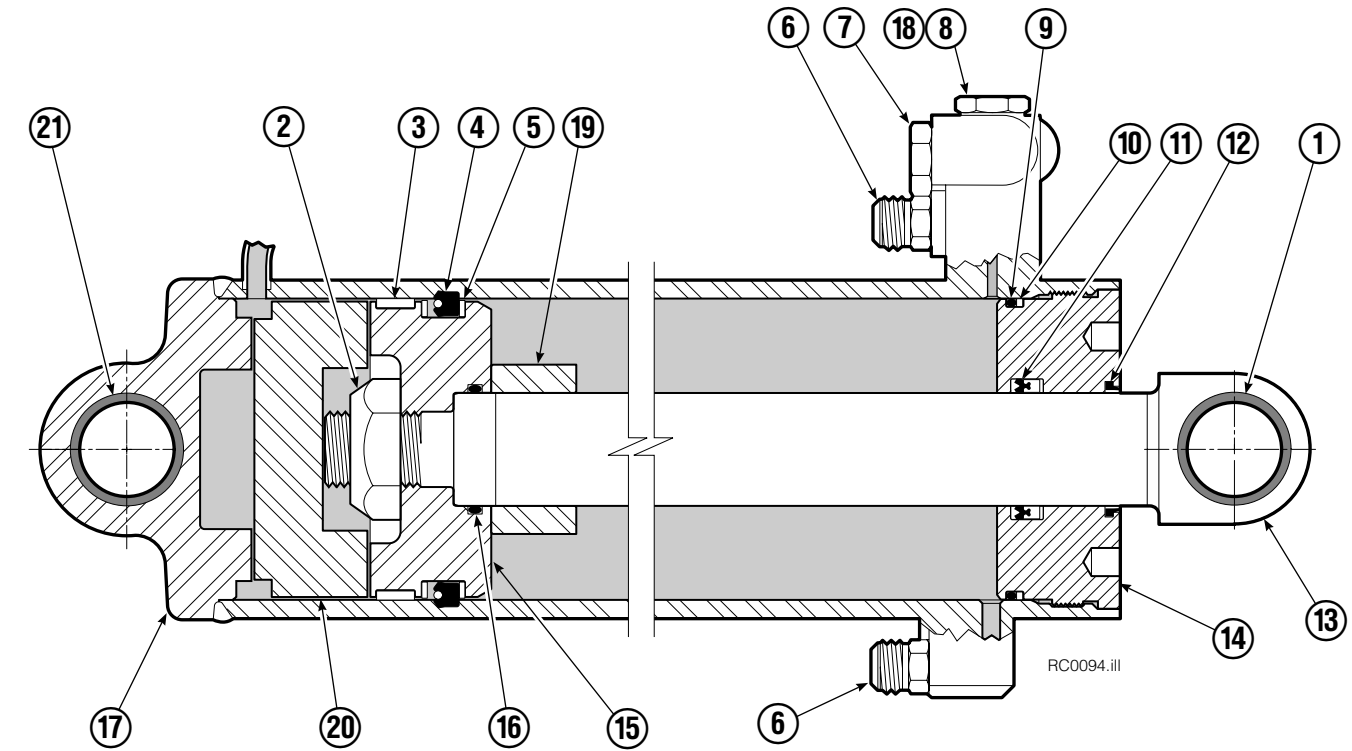


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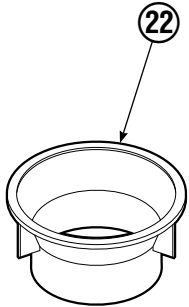
<b>25F</b>			
REF	QTY	PART NO.	DESCRIPTION
		206600	Revolving Connection Assembly ■
1	2	768796	Capscrew
2	1	687301	End Block
3	4	604511	Fitting, 6-6
4	1	206599	Service Kit
5	1	206594	Shaft
6	1	206595	Body
7	1	7341	Snap Ring
8	1	3138	Snap Ring

■ Body is stamped 206596.

# Cylinder



RC0094.iii

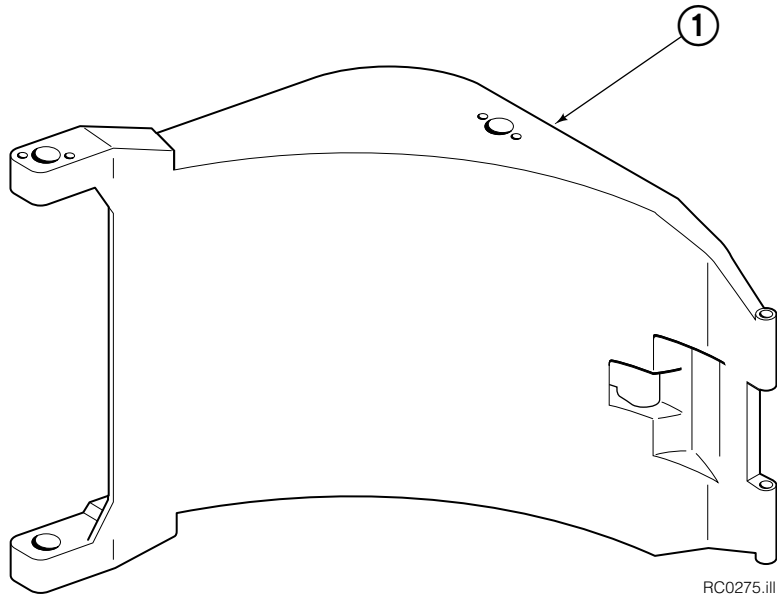


25F			
REF	QTY	PART NO.	DESCRIPTION
		557386	Cylinder Assembly
1	1	674843	Bearing
2	1	560997	Nut
3	1	660769	◆ Bearing
4	1	662462	◆ Seal
5	2	638295	◆ Back-Up Ring
6	2	604511	Fitting, 6-6
7	1	556852	Fitting, 4
8	1	557212	Check Valve
9	1	2801	◆ O-Ring
10	1	583977	◆ Back-Up Ring
11	1	554598	◆ Seal
12	1	628047	◆ 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.

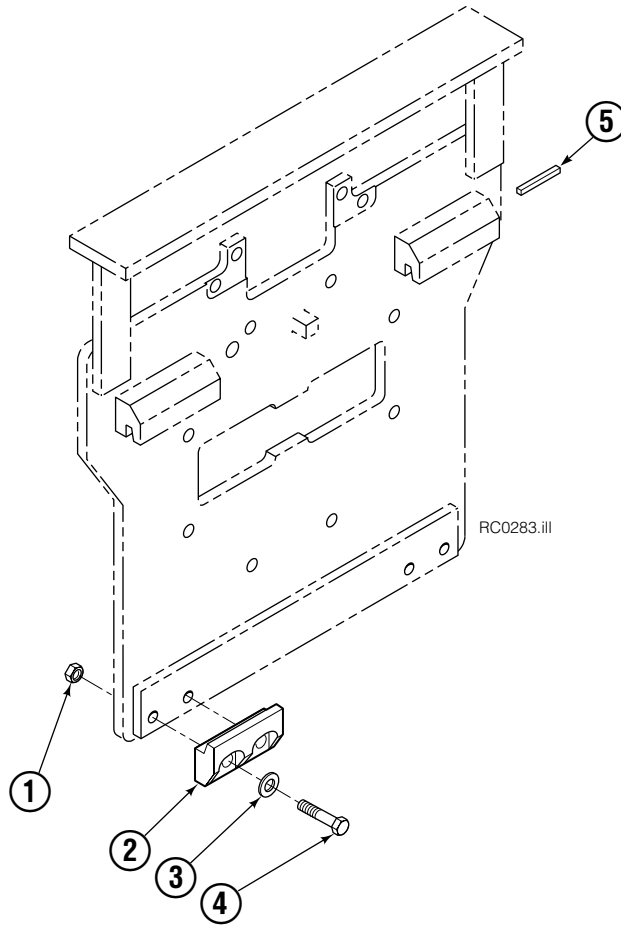
Ref: S-5320, S-5321

# Arms



25F			
REF	QTY	PART NO.	DESCRIPTION
1	1	6002550	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](http://www.cascorp.com)

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