



# Parts Manual

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## 25F Paper Roll Clamp

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Serial Numbers 201093 through 680143

Manual Number 681329 R-2

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# How To Use This Manual

## Introduction

This manual illustrates service replacement parts for standard production Cascade 25F Paper Roll Clamps.

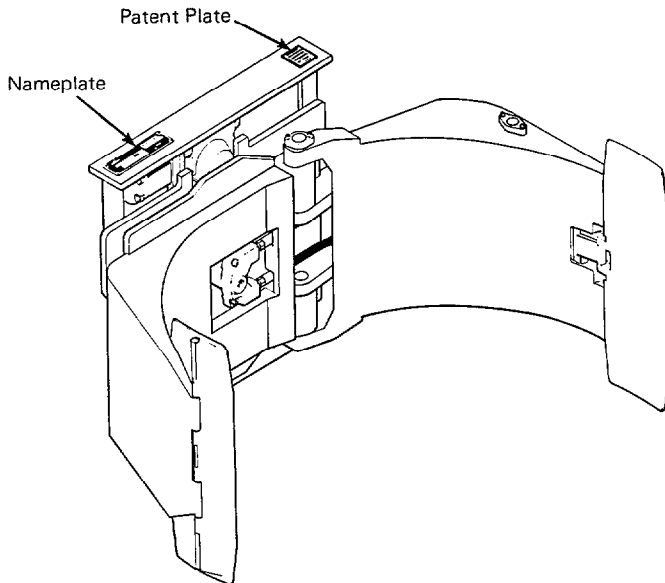
The parts manuals for attachments designed by the Application Engineering Department have an A.E.D. designation on the cover of the manual.

This standard attachment manual is not interchangeable with an A.E.D. manual since it does not reflect the special engineering of an A.E.D. attachment.

To locate a service replacement part for a standard attachment, follow these steps.

### 1. Locate the Nameplate

The nameplate is attached to the top baseplate cross-bar. If the nameplate is missing, all necessary information is stamped into the baseplate at the same location.



### 2. Note the Serial Number

Record the six-digit Serial Number. See the example.

### 3. Refer to Serial Number Index

Locate your Serial Number in the Serial Number Index on the following page.

**IMPORTANT: DO NOT USE THIS MANUAL TO ORDER PARTS FOR AN A.E.D. ATTACHMENT.** Contact Cascade Corporation to obtain the correct parts manual. You must supply the serial number and all additional equipment numbers to order the correct manual.

### 4. Ordering

**Retail Customers** - Cascade Service Replacement Parts and Service Literature are sold through authorized lift truck dealers. To order, contact the lift truck dealer of your choice.

**Lift Truck Dealers** - To order Service Replacement Parts or Service Literature, contact:

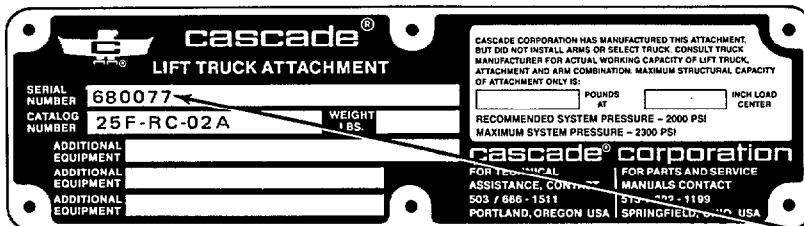
Cascade Parts Depot  
2501 Sheridan Avenue  
Springfield, Ohio 45505  
Telephone: 513-322-1199  
Telex: 279563  
FAX: 513-325-9270

### 5. Parts Log

We have supplied a parts ordering log located on the last page. Use this log as a permanent record of parts ordered from this manual.



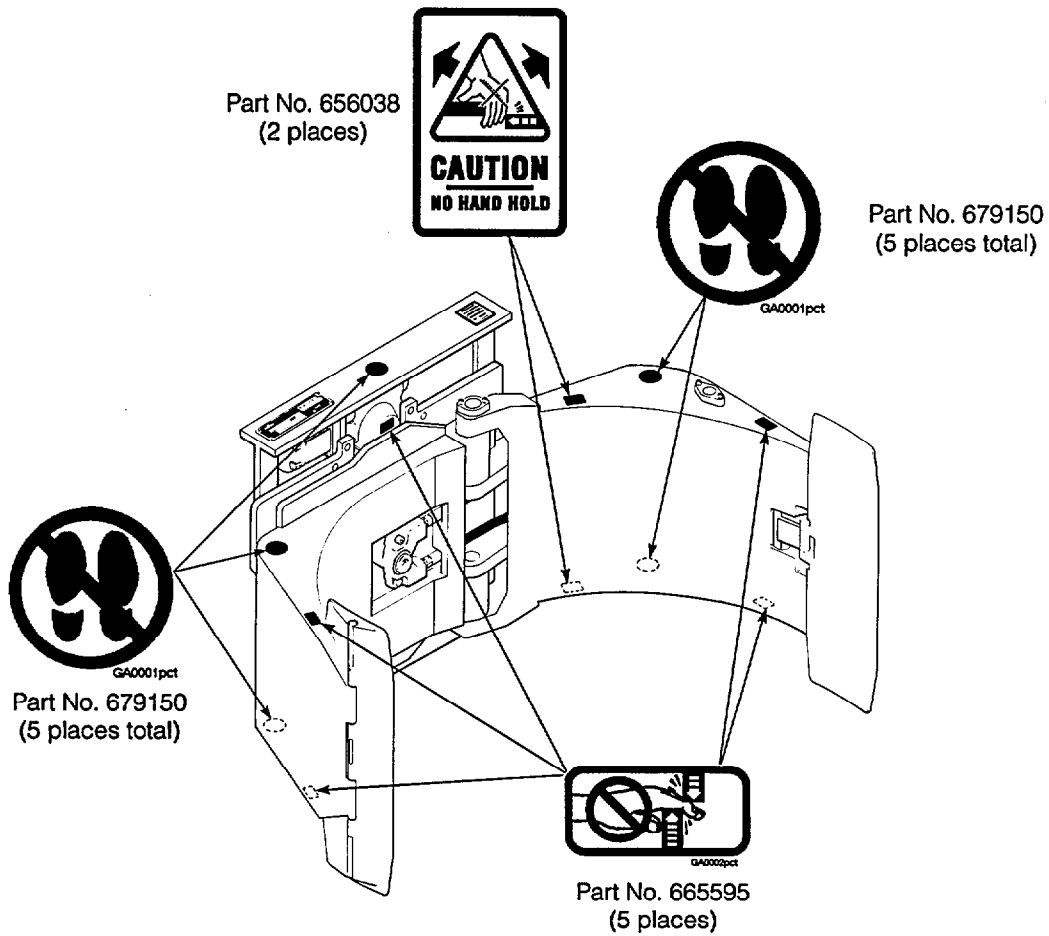
**WARNING:** For the safety of yourself and others, DO NOT install any parts, unless you have thoroughly reviewed the appropriate installation and service manuals. For additional information, call 1-800-CAS-CADE (227-2233)



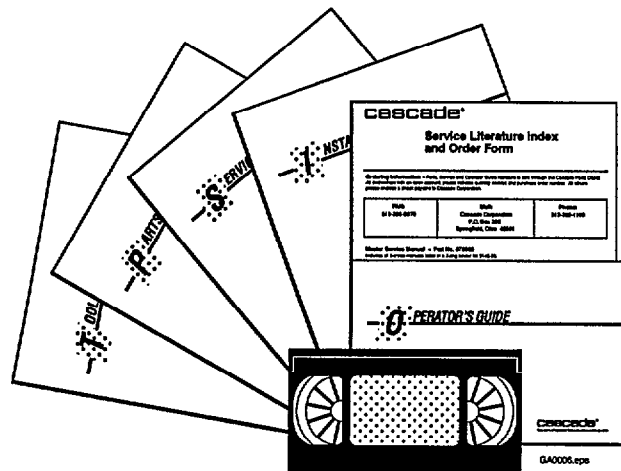
# Serial Number Index

Serial Number	Base Unit Page	Common Components Page	Drive Group Page	Revolving Connection Page	Cylinder Page	Arm Page	Mounting Group Page	Solenoid Group Page
680077	1	4	6	7	8	9	10	11
680078	1	4	6	7	8	9	10	11
680079	1	4	6	7	8	9	10	11
680080	1	4	6	7	8	9	10	11
680142	1	4	6	7	8	9	10	11
680143	1	4	6	7	8	9	10	11
201093	2	4	6	7	8	9	10	11
201094	2	4	6	7	8	9	10	11
201095	2	4	6	7	8	9	10	11
201096	2	4	6	7	8	9	10	11
201097	2	4	6	7	8	9	10	11
201098	2	4	6	7	8	9	10	11
206697	3	5	6	7	8	9	10	11
206698	3	5	6	7	8	9	10	11
206699	3	5	6	7	8	9	10	11
206700	3	5	6	7	8	9	10	11
206701	3	5	6	7	8	9	10	11
206702	3	5	6	7	8	9	10	11

## Safety Decals

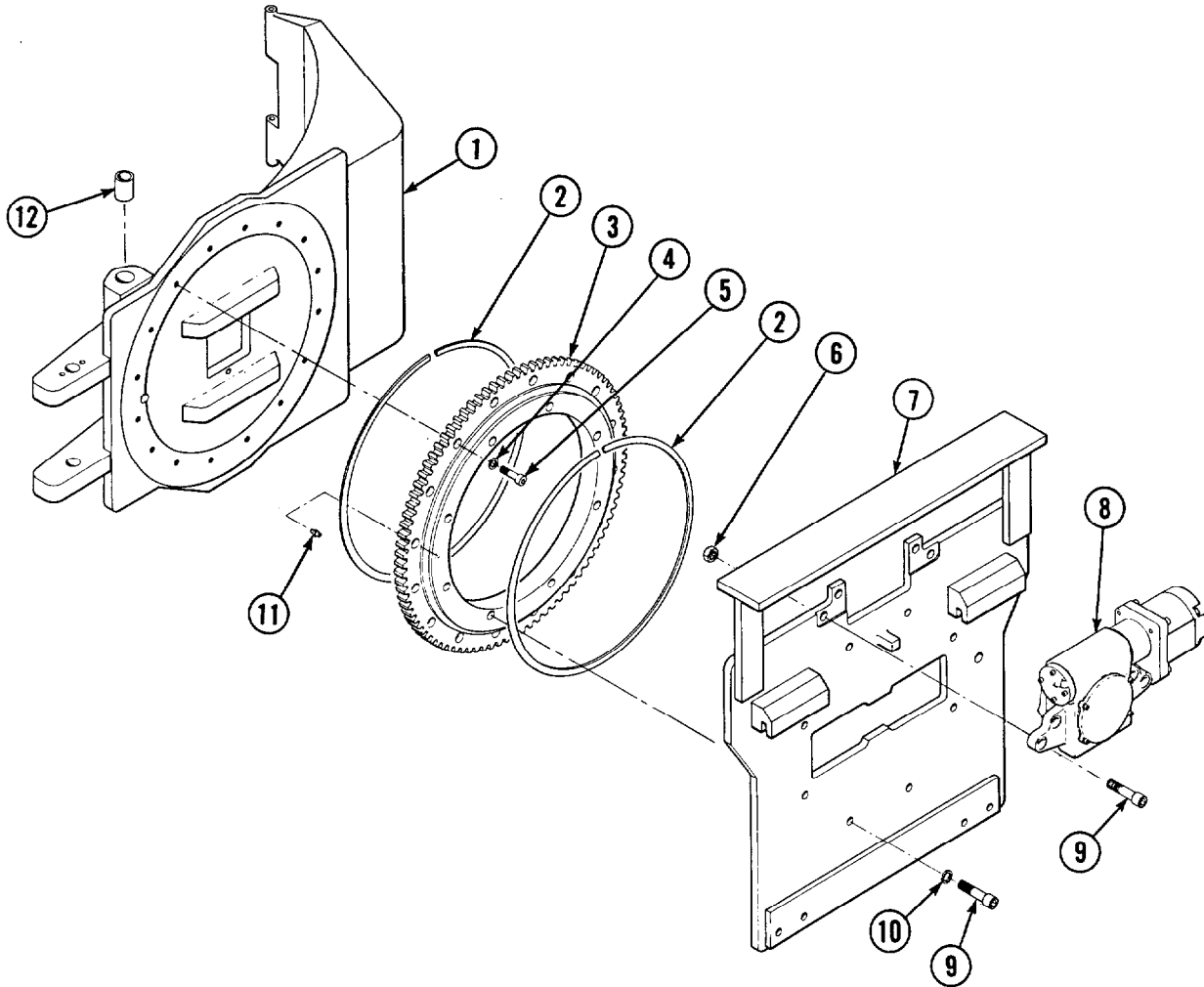


## Publications



PART NO.	DESCRIPTION
681329	Parts Manual
681433	Service Manual
674509	Operators Guide
674510	Installation Instructions
679929	Tool Catalog
673964	Literature Index Order Form

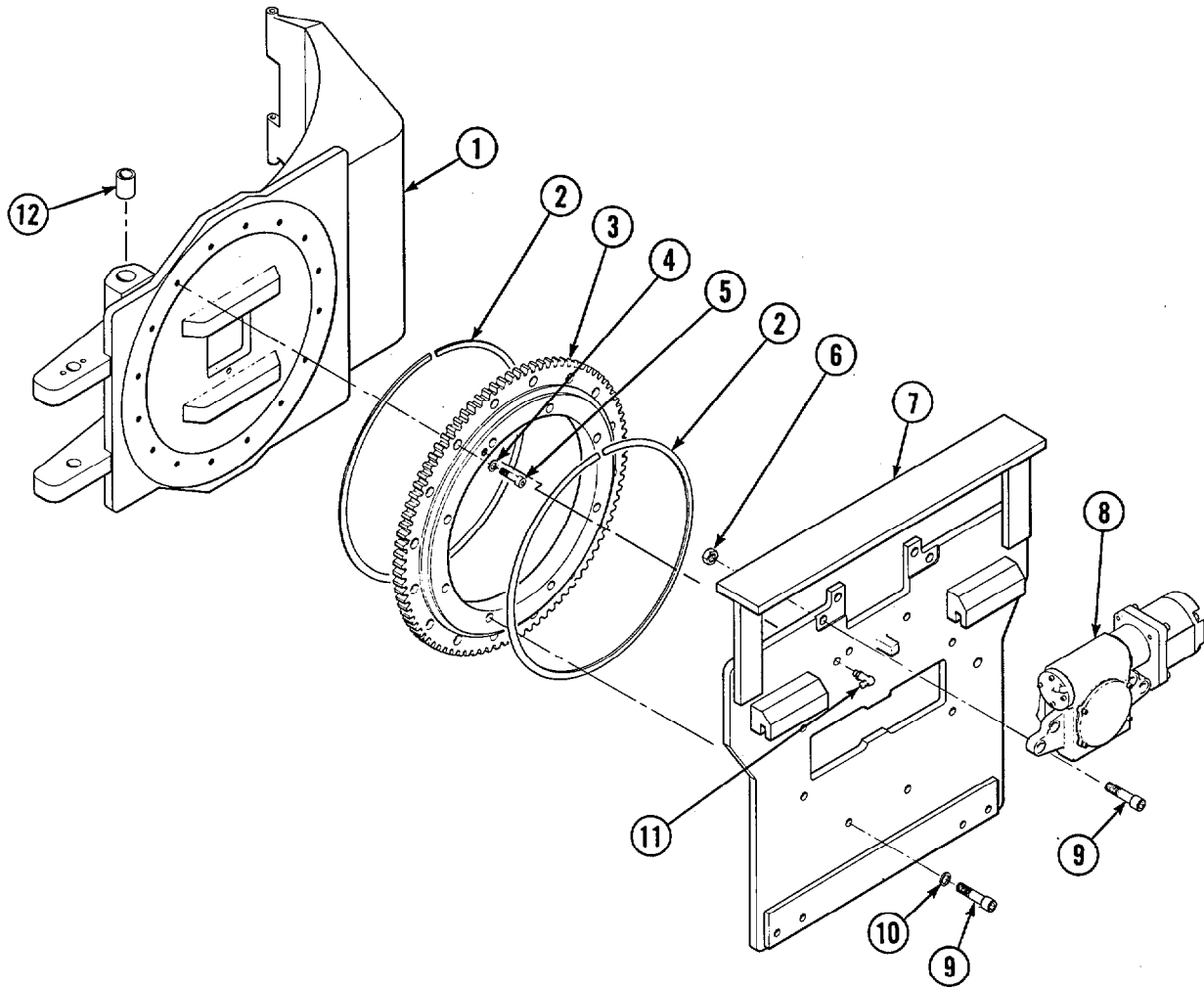
# Base Unit Group



25F			
REF	QTY	PART NO.	DESCRIPTION
		679133	Base Unit Group – 42 in.◆
		679132	Base Unit Group – 45 in.◆
		680144	Base Unit Group – 51 in.◆
1	1	679105	● Frame – 42 in.◆
1	1	679087	● Frame – 45 in.◆
1	1	679145	● Frame – 51 in.◆
2	2	673043	Seal
3	1	679121	■ Bearing Assembly
4	16	678991	Lockwasher
5	16	768827	Capscrew
6	4	678990	Nut
7	1	201063	Baseplate
8	1	679106	▼ Drive Group
9	12	762613	Capscrew
10	8	678992	Lockwasher
11	1	651853	Grease Fitting
12	4	676163	Bearing

- ◆ Maximum roll diameter.
- Includes item 12.
- Includes items 2 and 11.
- ▼ See page 6 for replacement parts breakdown.

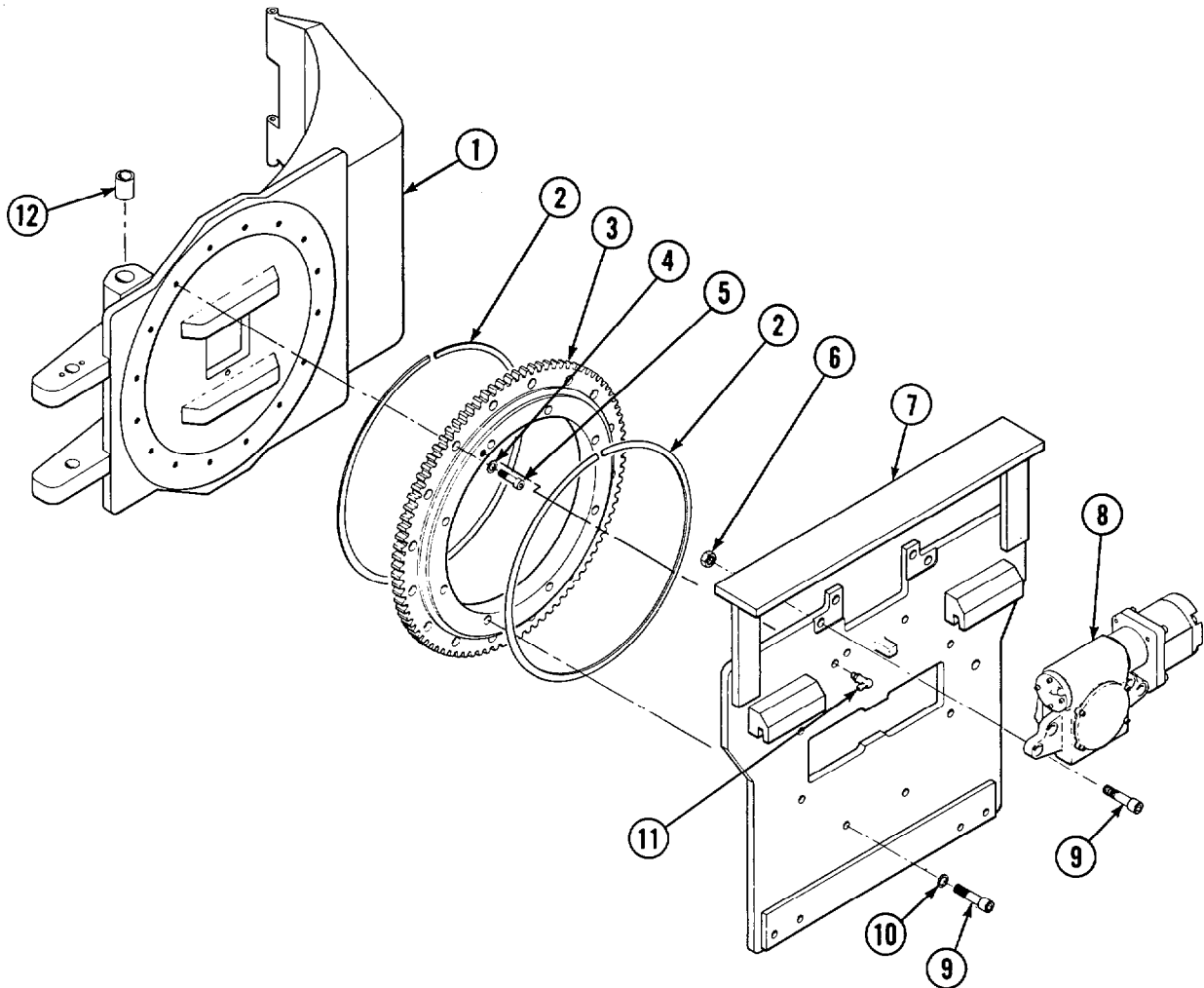
# Base Unit Group



25F			
REF	QTY	PART NO.	DESCRIPTION
		201795	Base Unit Group – 42 in.◆
		201796	Base Unit Group – 45 in.◆
		201797	Base Unit Group – 51 in.◆
1	1	201801	● Frame – 42 in.◆
1	1	201802	● Frame – 45 in.◆
1	1	201803	● Frame – 51 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 page 6 for replacement parts breakdown.

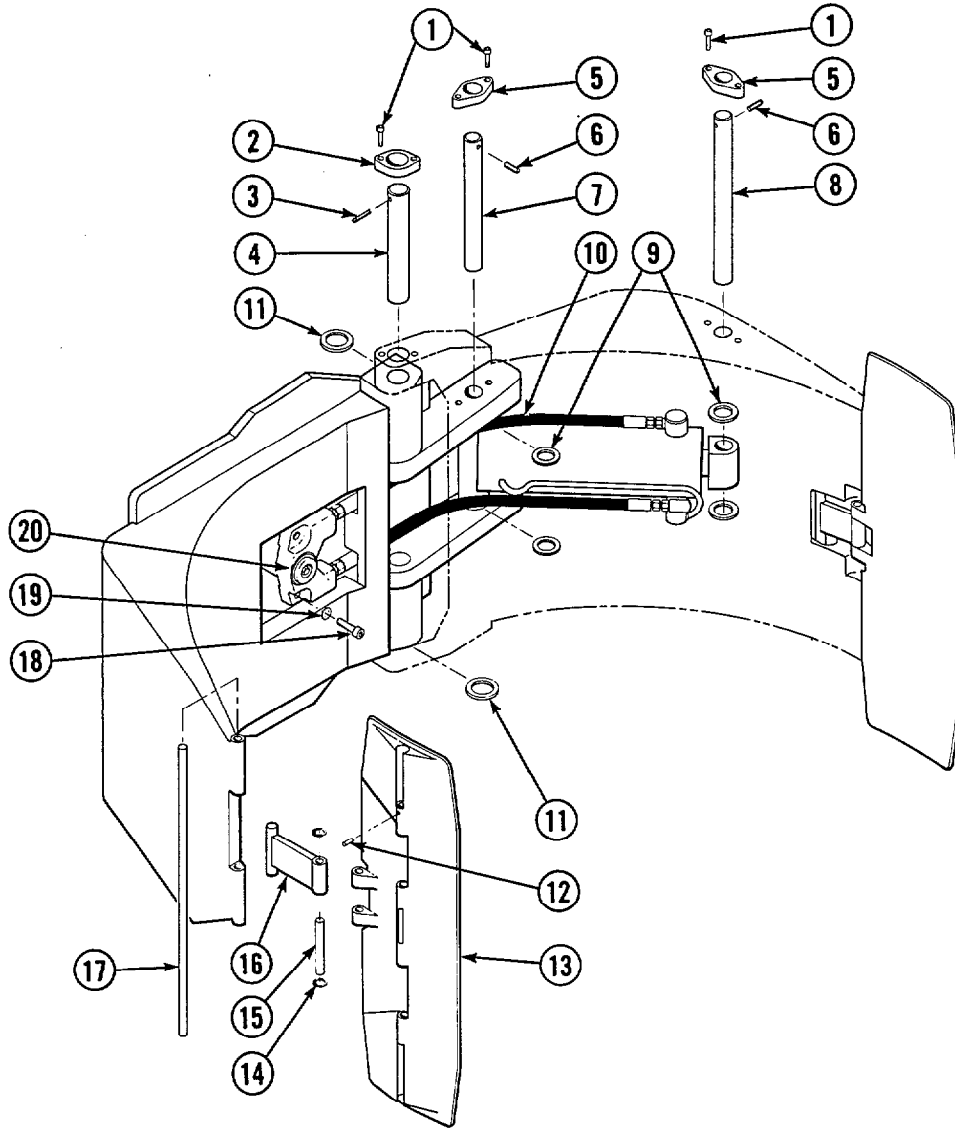
# Base Unit Group



25F			
REF	QTY	PART NO.	DESCRIPTION
		206765	Base Unit Group - 42 in.◆
		206766	Base Unit Group - 45 in.◆
		206767	Base Unit Group - 51 in.◆
1	1	206704	● Frame - 42 in.◆
1	1	206705	● Frame - 45 in.◆
1	1	206706	● Frame - 51 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.
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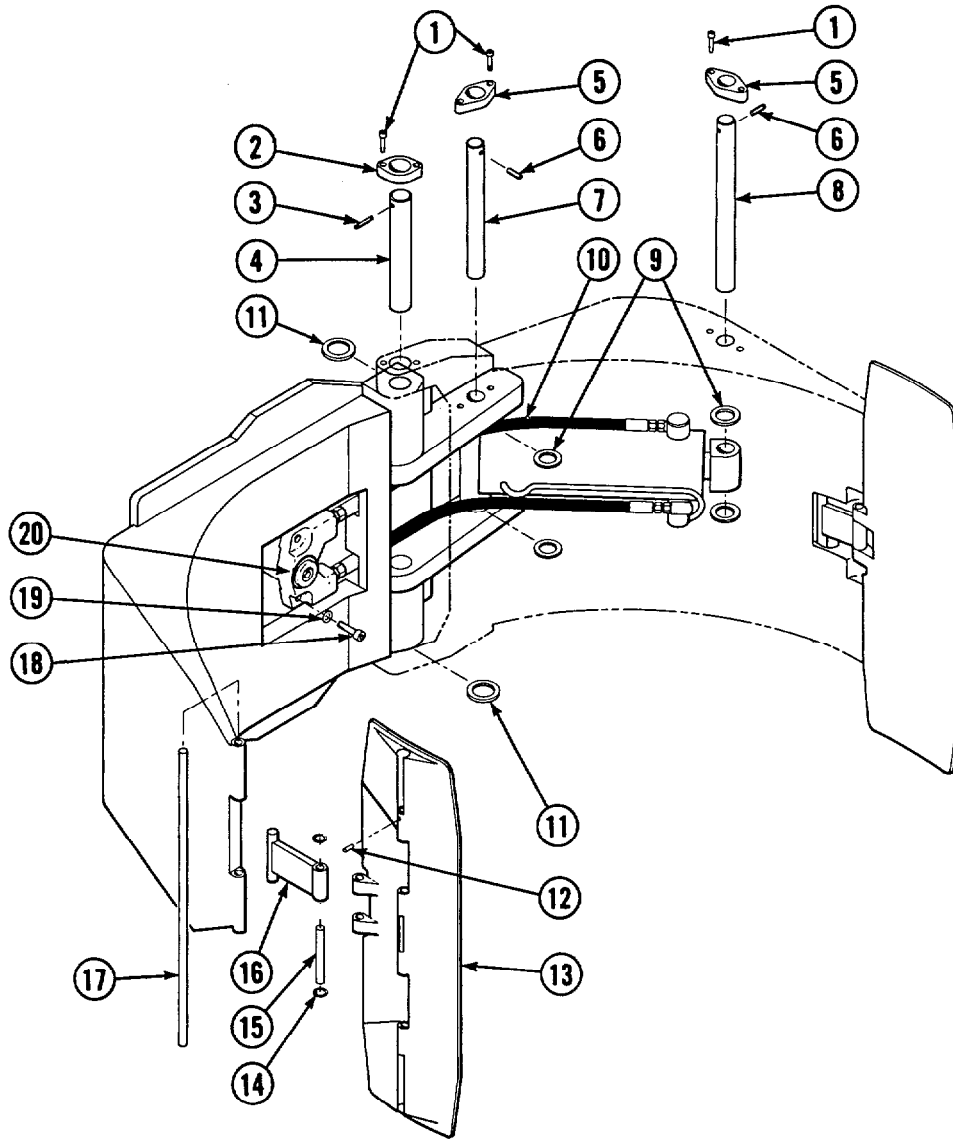
# Common Components Group



25F							
REF	QTY	PART NO.	DESCRIPTION	REF	QTY	PART NO.	DESCRIPTION
		680026	Common Components Group	11	4	660200	Shim, .06 in.
1	8	768793	Capscrew	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 page 7 for replacement parts breakdown.

# Common Components Group

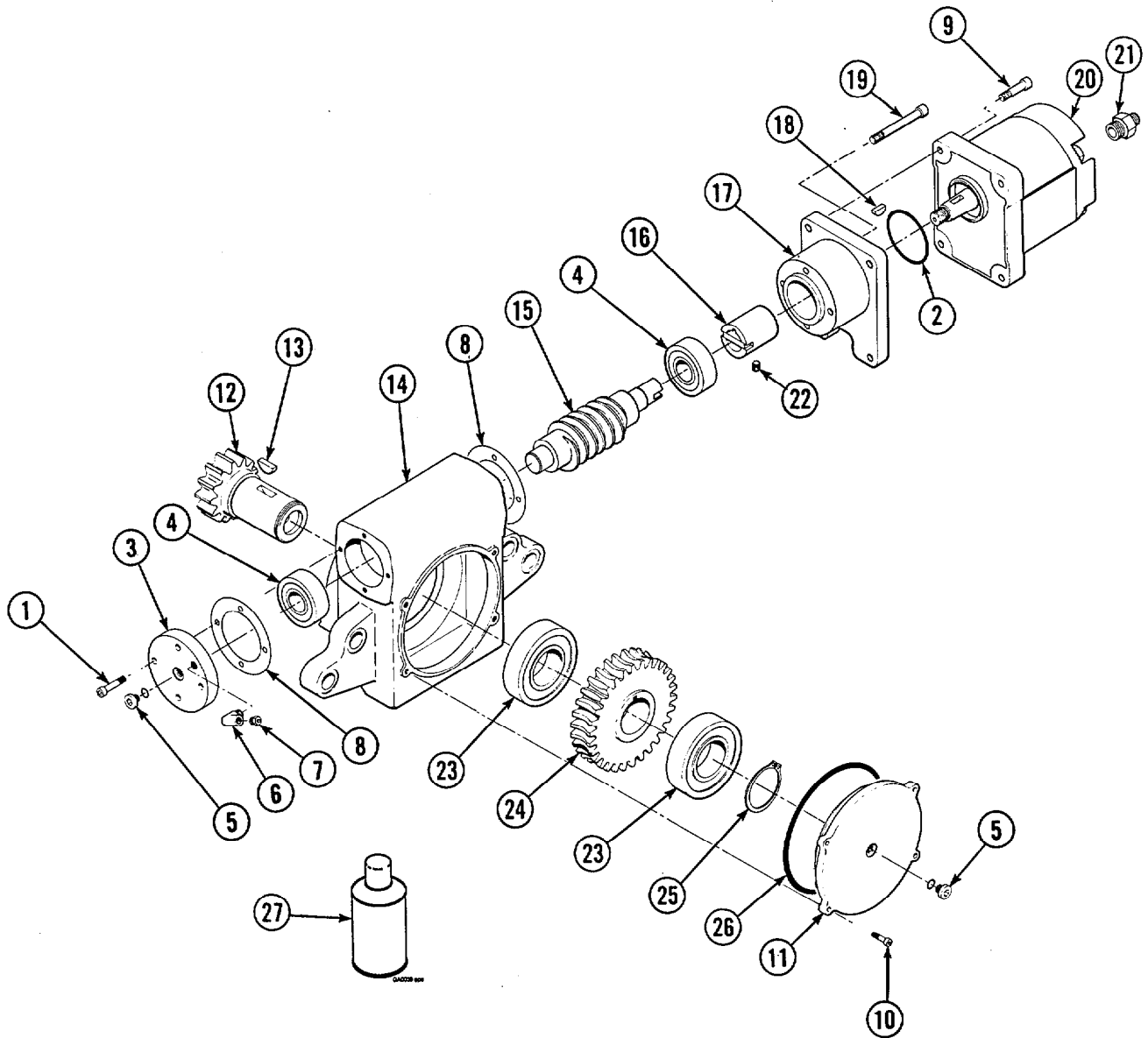


## 25F

REF	QTY	PART NO.	DESCRIPTION	REF	QTY	PART NO.	DESCRIPTION
		206688	Common Components Group	11	4	660200	Shim, .06 in.
1	8	768809	Capscrew	12	2	201732	Drive Pin
2	2	206590	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	206589	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 page 7 for replacement parts breakdown.

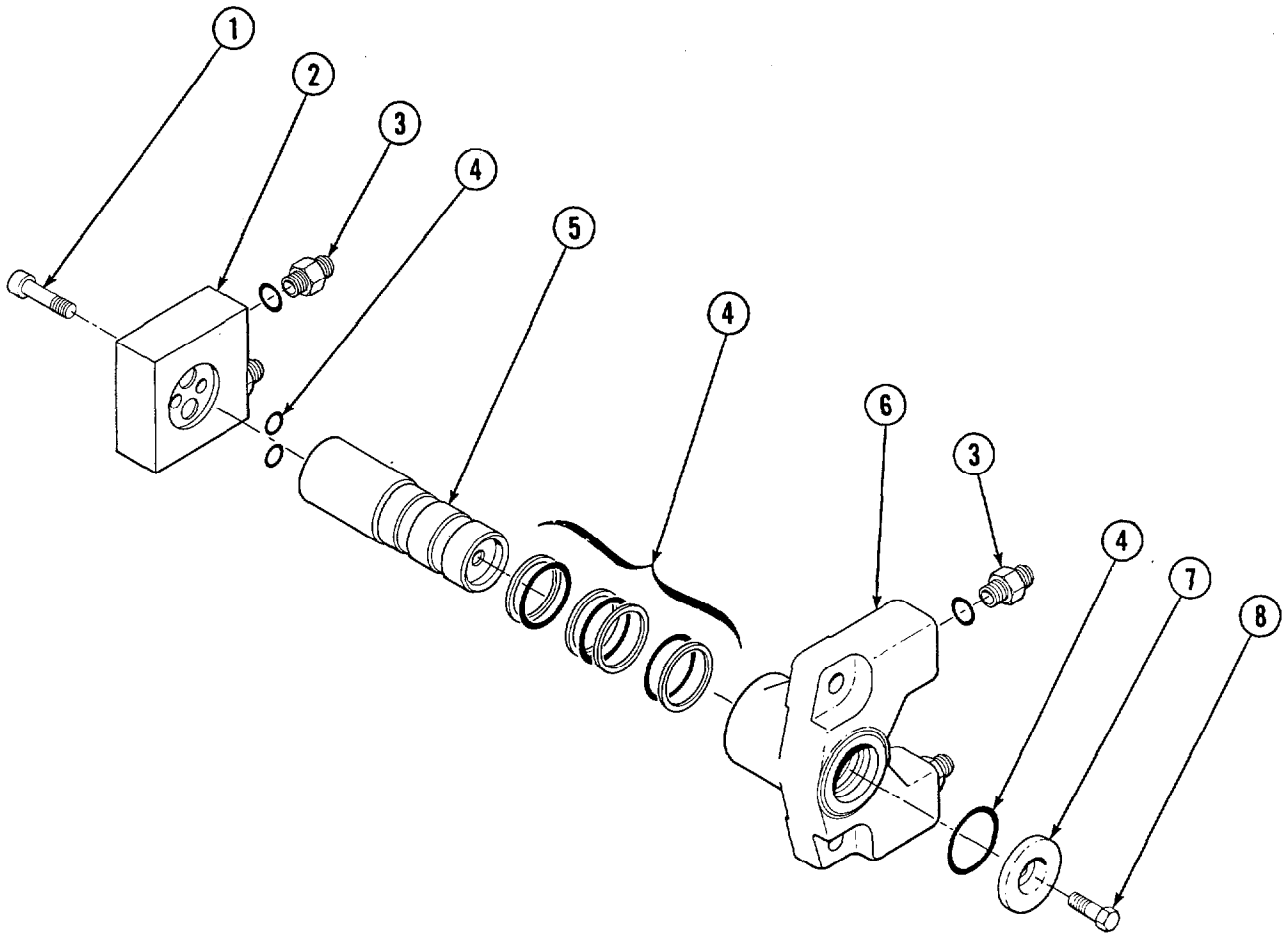
# Drive Group



## 25F

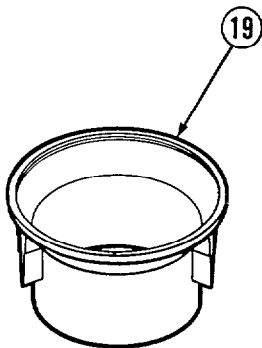
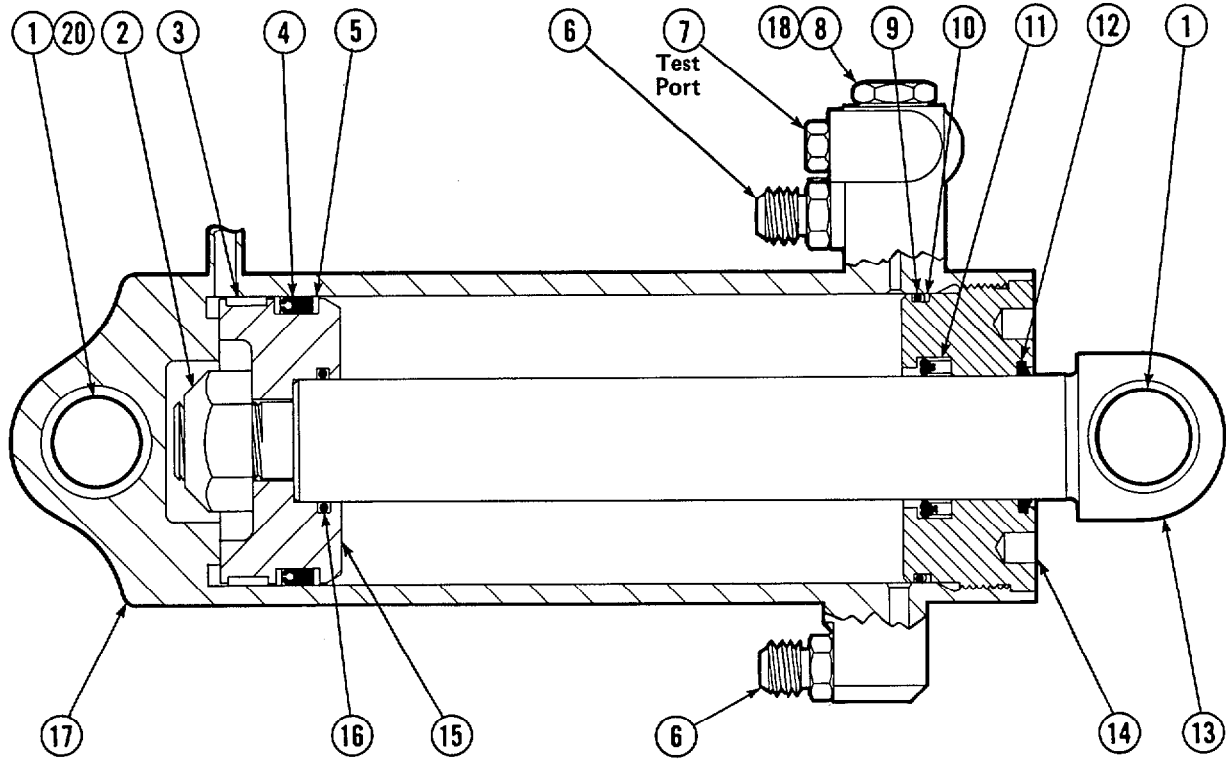
REF	QTY	PART NO.	DESCRIPTION	REF	QTY	PART NO.	DESCRIPTION
		679106	Drive Group	15	1	679109	Worm
1	4	768786	Cap screw, M6x25-8.8	16	1	679118	Coupling
2	1	643352	O-Ring	17	1	679115	Adapter
3	1	679114	End Cap	18	1	678999	Key
4	2	678985	Bearing	19	4	768792	Cap screw, M6x60-8.8
5	2	663694	Fitting, 3	20	1	206418	Motor
6	1	6688	Fitting, 2	21	2	626505	Fitting, 10-6
7	1	644010	Relief Fitting	22	1	678994	Set screw
8	2	679808	Shim-.002 in. (.05mm)	23	2	678986	Bearing
9	4	768787	Cap screw, M6x30-8.8	24	1	679110	Worm Gear
10	4	752845	Cap screw, M6x16-8.8	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

# 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

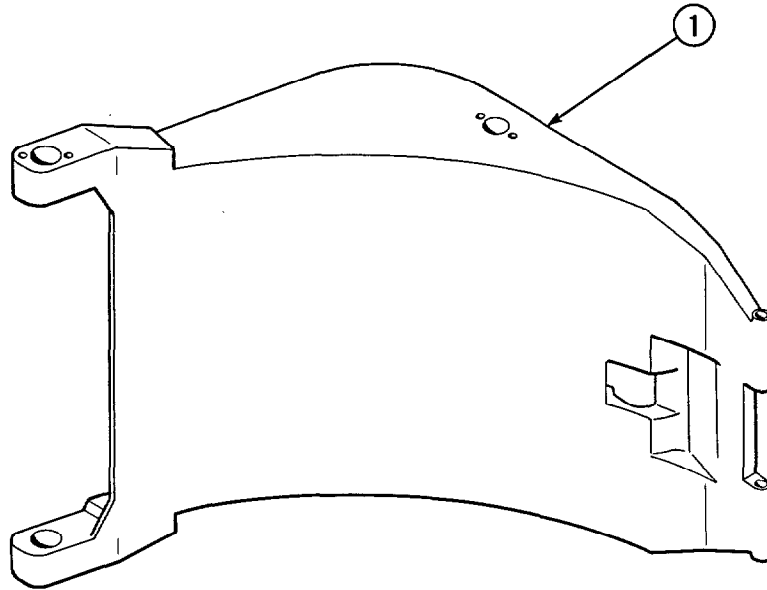
# Cylinder



25F			
REF	QTY	PART NO.	DESCRIPTION
		557386	Cylinder Assembly - 42-45 in.
		580137	Cylinder Assembly - 51 in.
1	3	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	562731	Back-Up Ring
◆11	1	554598	Seal
◆12	1	628047	Wiper
13	1	557404	Rod - 42-45 in.
13	1	557399	Rod - 51 in.
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	669243	Seal Loader
20	1	558835	Spacer
		557725	Service Kit

◆ Included in Service Kit 555725.

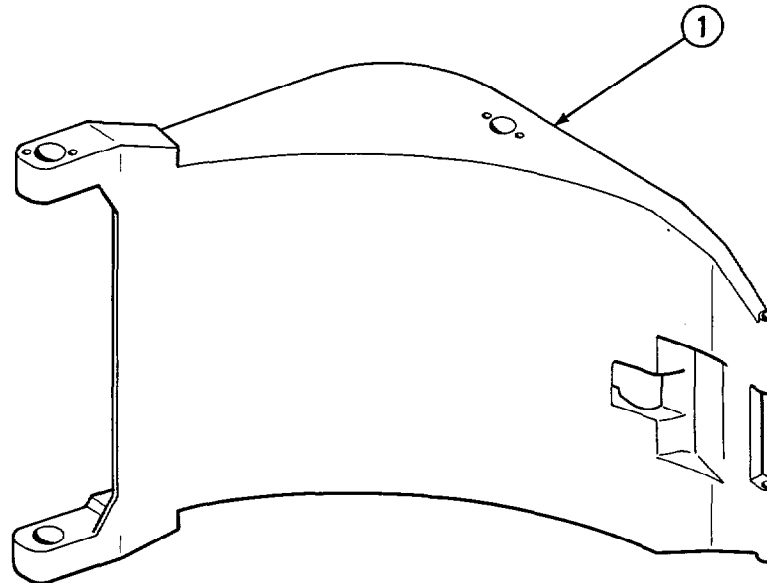
# Arms



**NOTE:** Use these arms for serial numbers 680077-201098.

25F			
REF	QTY	PART NO.	DESCRIPTION
1	1	679813	Arm - 42-45 in. ♦
1	1	680151	Arm - 51 in. ♦

♦ Maximum roll diameter.

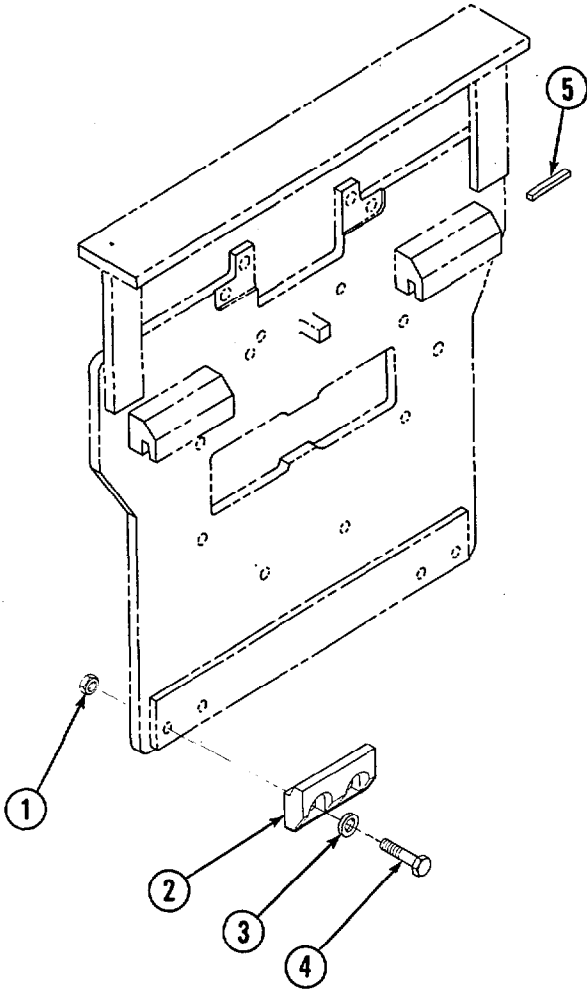


**NOTE:** Use these arms for serial numbers 206697-206702.

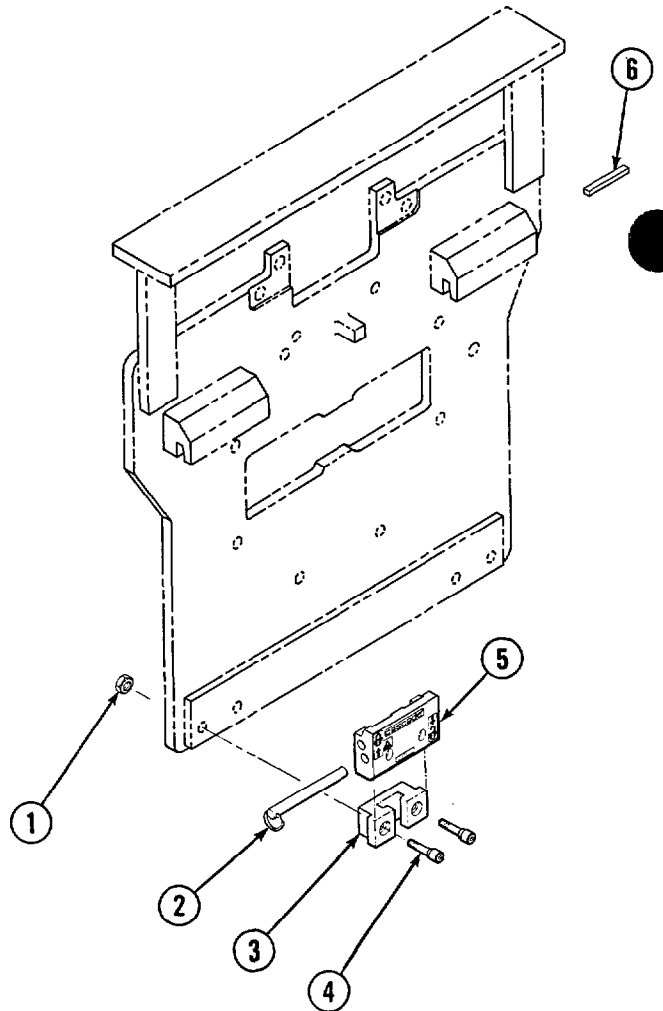
25F			
REF	QTY	PART NO.	DESCRIPTION
1	1	206680	Arm - 42-45 in. ♦
1	1	206681	Arm - 51 in. ♦

♦ Maximum roll diameter.

# Mounting Group ITA II - 1.5°

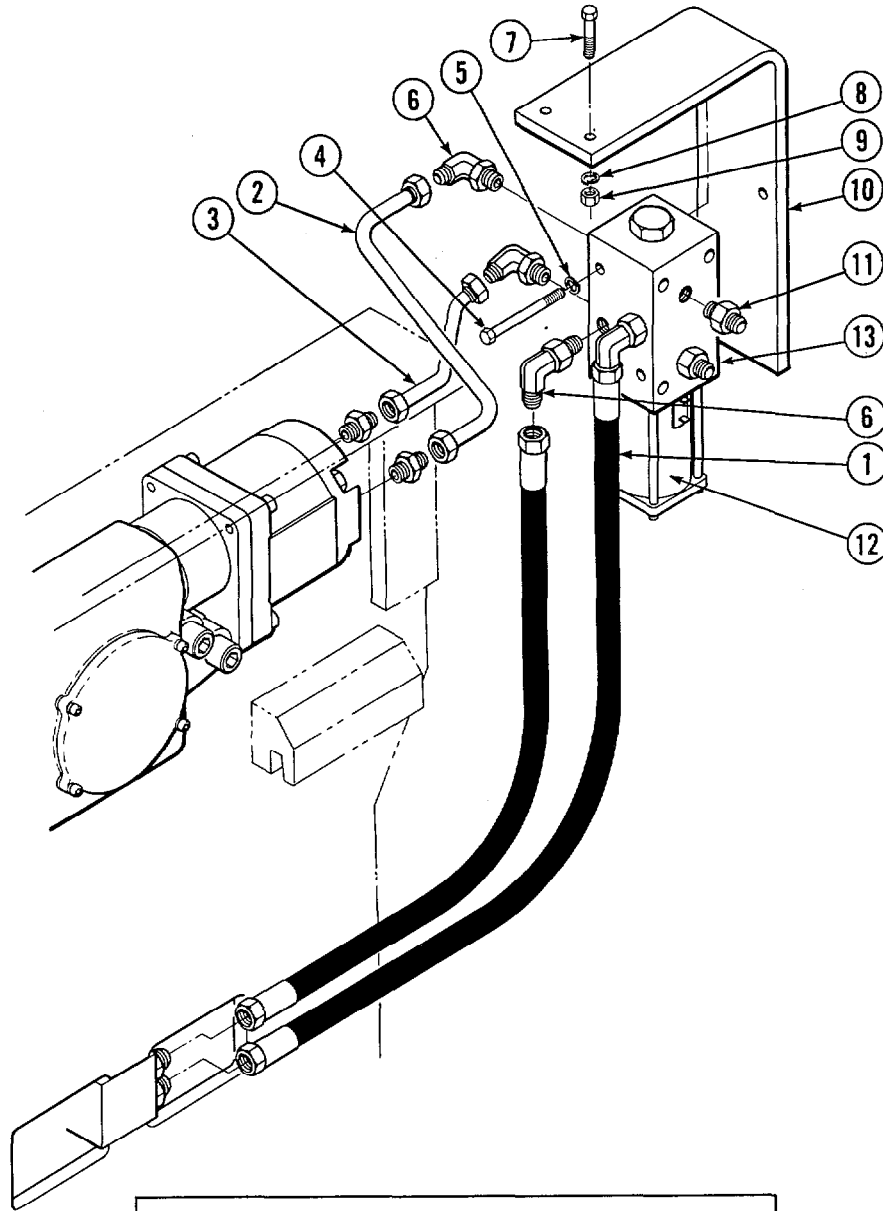


25F			
REF	QTY	PART NO.	DESCRIPTION
		680022	Mounting Group
1	4	678990	Nut
2	2	675968	Hook
3	4	667225	Washer
4	4	678996	Capscrew
5	1	669344	Stop Kit



25F			
REF	QTY	PART NO.	DESCRIPTION
		680023	Mounting Group
1	4	678990	Nut
2	2	678832	Pin
3	2	675715	Guide
4	4	679816	Capscrew
5	2	675514	Hook
6	1	669344	Stop Kit

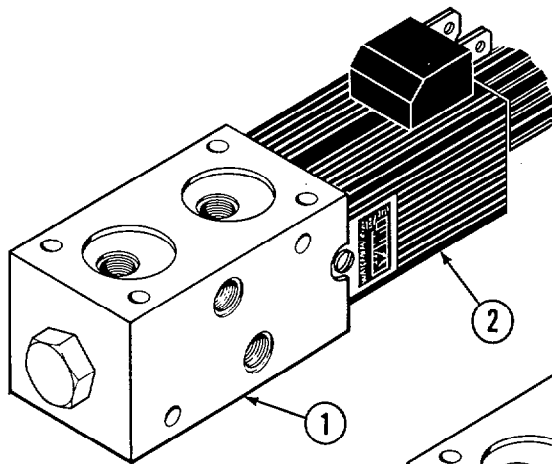
# Solenoid Adaption



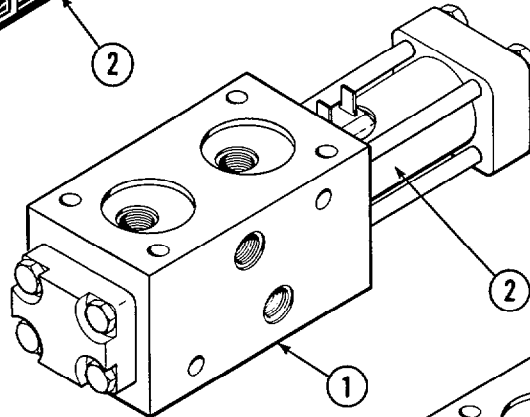
25F			
REF	QTY	PART NO.	DESCRIPTION
		681234	Solenoid Adaption
1	2	675953	Hose, 6
2	1	681235	Tube
3	1	681236	Tube
4	2	681444	Capscrew, M6x75 - 8.8
5	2	680217	Lockwasher, M6
6	4	601676	Fitting, 6-6
7	2	763022	Capscrew, M10x35 - 8.8
8	2	681238	Lockwasher, M10
9	2	763023	Nut, M10
10	1	681237	Plate
11	2	604511	Fitting, 6-6
12	1	■	Coil
13	1	■	Solenoid Valve

■ See page 12 for replacement parts breakdown.

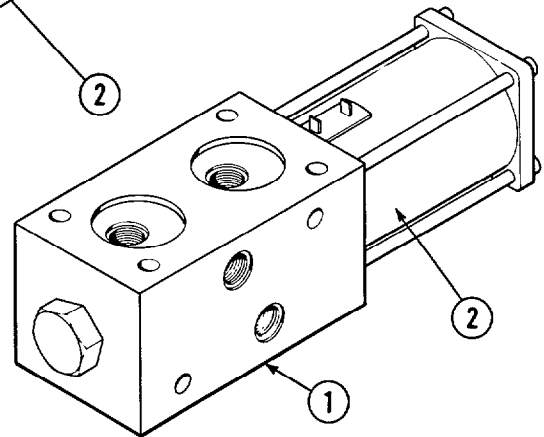
# Solenoid Valves



**New Style  
Waterman**



**Old Style  
Waterman**



**Racine**

**NOTE:** The Waterman new style solenoid with black coil, Waterman old style solenoid and Racine solenoid valve assemblies are interchangeable as a unit. Replacement coils **must** match the valves. If one brand is preferred over another you must specify both the part number and brand name.

25F						
REF	QTY	New Style Waterman		Old Style Waterman	Racine	DESCRIPTION
		No. 6 SAE	No. 8 SAE			
PART NO.	PART NO.	PART NO.	PART NO.	PART NO.	PART NO.	
1	1	200585	200548	614089	614089	Solenoid Valve-12V
1	1	200586	200549	614091	614091	Solenoid Valve-24V
1	1	200587	200550	614092	614092	Solenoid Valve-36V
1	1	200588	200254	614093	614093	Solenoid Valve-48V
1	1	—	—	614094	—	Solenoid Valve-72V
2	1	200255	200255	611458	665044	Coil-12V
2	1	200256	200256	611460	665045	Coil-24V
2	1	200257	200257	611461	665046	Coil-36V
2	1	200258	200258	614097	665047	Coil-48V
2	1	—	—	614098	—	Coil-72V
		—	—	685072	685012	Service Kit

# Recommended Spare Parts List

<b>25F Paper Roll Clamps</b>				
PART NUMBER	DESCRIPTION	ATTACHMENTS SERVICED		
		1-5	6-19	20-50
676163	<b>BASE UNIT GROUP</b> Bearing	4	8	8
680028 680029 675018 680032 674256 673385 674257 660200 600031	<b>COMMON COMPONENTS GROUP</b> Pin Pin Pin Pin Drive Pin Drive Pin Shim - .06 in. Shim - .06 in. Contact Pad	2 1 1 2 2 2 6 4 0	4 2 2 4 4 4 12 8 1	4 2 2 4 4 4 12 8 2
679109 679110 678985 679111 678986 678987 643368 206418 679118 678999 656300 206419 206421	<b>DRIVE GROUP</b> Worm Worm Gear Worm Bearings Pinion Pinion Bearings Snap Ring O-Ring Motor Coupling Key Gear Lube (48 oz.) Motor Shaft Service Kit Complete Motor Service Kit	0 0 2 0 2 1 1 1 1 1 1 1 1 1	1 1 4 1 4 2 5 2 2 2 2 2 2	2 2 6 2 6 4 5 4 4 4 2 2 2 2
680062	<b>REVOLVING CONNECTION</b> Service Kit	1	2	2
555725	<b>CYLINDER</b> Service Kit	1	2	2
669344	<b>MOUNTING GROUP</b> Stop Kit	1	2	2
681329 681433 674509 674510 673964 677555 678363 680664 679929	<b>PUBLICATIONS</b> Parts Manual Service Manual Operator Guide Installation Instruction Literature Index Order Form Driver Training Video - VHS Troubleshooting Video - VHS Servicing Cascade Cylinders Video - VHS Tool Catalog	1 1 1 1 1 1 1 1 1 1	1 1 1 1 1 1 1 1 1 1	1 1 1 1 1 1 1 1 1 1
685660	<b>PAINT</b> 12 oz. Aerosol Can Heritage White	1	2	2



**Do you have questions you need answered right now?** Call your nearest Cascade Parts Department.

**Cascade Corporation**  
2501 Sheridan Avenue  
Springfield, Ohio 45505  
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5570 Timberlea Blvd.  
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FAX: 31-3240-14223

**Cascade N.V.**  
**Benelux Sales and Service**  
P.O. Box 170  
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Weesperstraat 110  
1112 AP Diemen  
The Netherlands  
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FAX: 742-695121

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FAX: 42-152997

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Telex: cascade 604016 f  
FAX: (1) 69345705

**Cascade Hispania S.A.**  
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Barcelona  
Spain  
Tel: 93-3355158  
Telex: 54018 casc e  
FAX: 93-3354756

**Cascade Japan Ltd.**  
5-5-41,  
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Settsu, Osaka  
Japan, 566  
Tel: 81-726-53-3490  
Telex: 781-5332128 CASC FE  
FAX: 81-726-53-3497

**Cascade Materials Handling**  
**(Aust.) Pty. Ltd.**  
**(Incorporated In N.S.W.)**  
121 Long Street  
Smithfield, N.S.W. 2164  
Australia  
Tel: 2-604-6222  
Te/Ac: 790-24302  
Cable: Cascaus  
FAX: 61-2-609-2742

**Cascade Materials Handling**  
**(Aust.) Pty. Ltd.**  
44E Winterton Road  
Clayton, Victoria 3168  
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Tel: 3-543-4344  
Cable: Casmel

**Cascade (Africa) Pty. Ltd.**  
P.O. Box 625, Isando 1600  
60A Steel Road,  
Sparton, Kempton Park  
South Africa  
Tel: 974-5611/2/3/4/5  
Telex: 4-29718 S.A.

