



Parts Manual

Model 77F Roll Clamp

Serial Number 77F-RCS-107

cascade[®]
corporation

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OR

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

Internet: www.cascorp.com

Safety Decals



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Roll Clamp Safety Decals			
REF	QTY	PART NO.	DESCRIPTION
1	6	665595	No Hand Hold Decal
2	3	660269	Short Arm Rotation Position Decal
3	4	656038	Caution Decal
4	4	679150	No Step Decal
5	4	665677	Trapped Pressure Decal
6	1	679059	Quick-Change Hook Decal

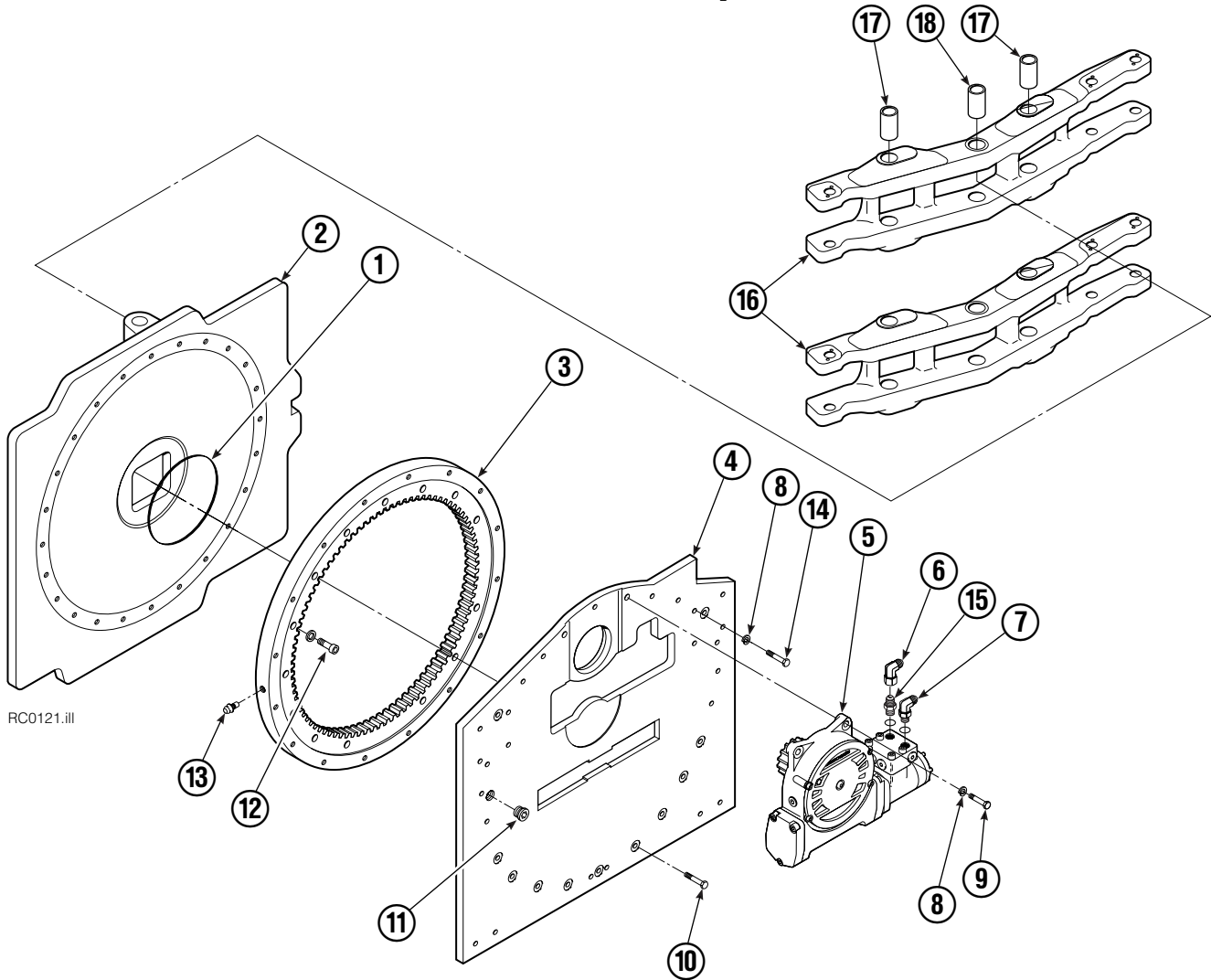
Publications



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Roll Clamp Publications	
674512	Service Manual
674509	Operator's Guide – Fixed Frame
676268	Operator's Guide – Swing Frame
674510	Installation Instructions – Fixed Frame
674511	Installation Instructions – Swing Frame
677555	Driver Training Video – VHS
678363	Troubleshooting Video – VHS
680664	Servicing Cascade Cylinders – VHS
679929	Tool Catalog
673964	Literature Index Order Form

Frame Group



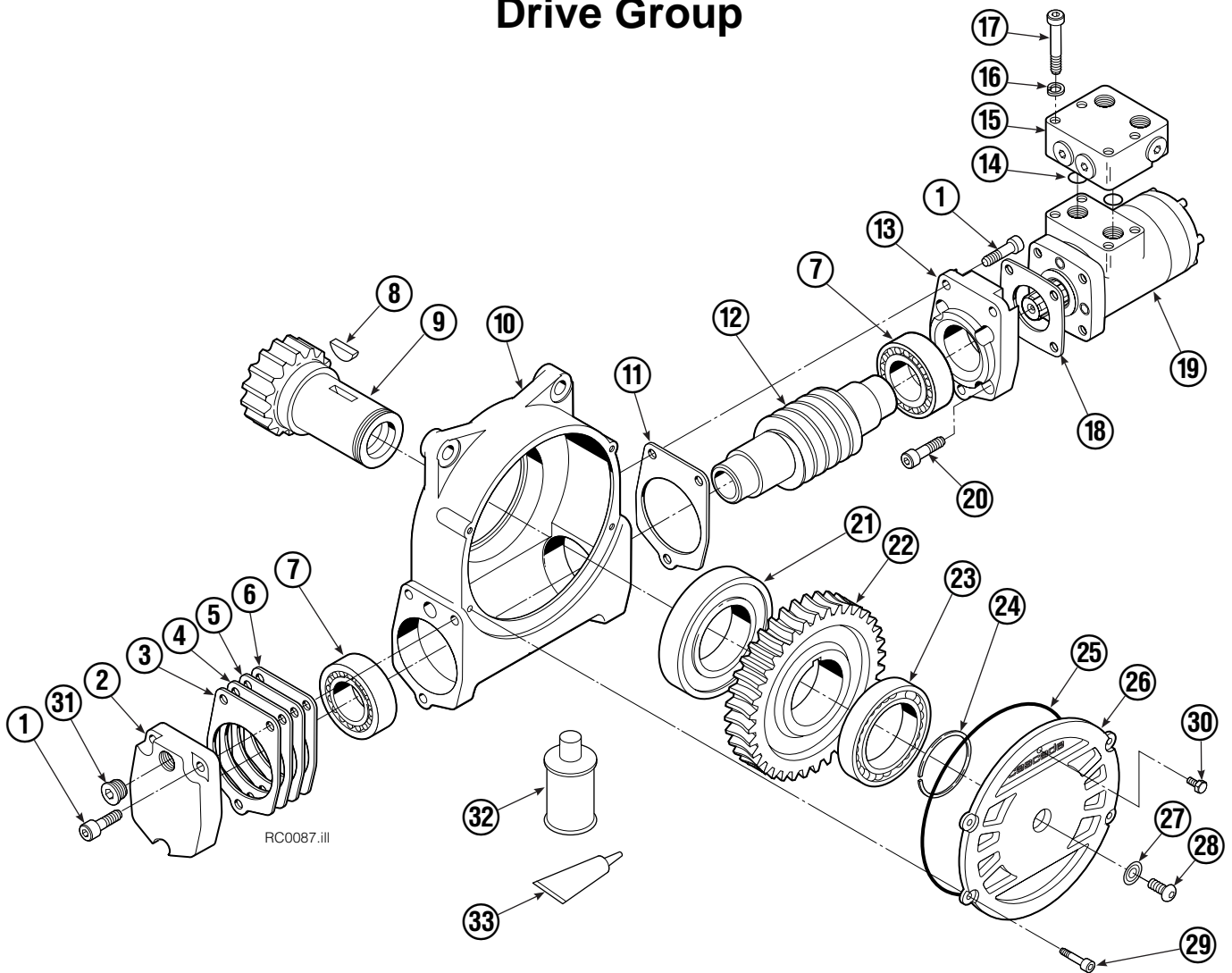
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77F			
REF	QTY	PART NO.	DESCRIPTION
		678499	Frame Group
1	1	670931	Seal
2	1	674976	Faceplate
3	1	672830	Bearing Assembly
4	1	678381	Baseplate
5	1	675639	Drive Group ●
6	1	605761	Fitting, 8-8
7	1	601250	Fitting, 8-8
8	17	6290	Lockwasher, 1/2 ID
9	4	661742	Capscrew, 1/2 NC x 1.25 GR5
10	11	643538	Capscrew, 1/2 NC x 1.50 GR8
11	1	6605	Plug
12	24	4507	Capscrew
13	1	7401	Grease Fitting
14	13	643539	Capscrew, 1/2 NC x 1.75 GR8
15	1	601377	Fitting, 8-8
16	2	678519	Swing Frame ▼
17	8	675008	Bushing ▼
18	4	675006	Bushing ▼

● See Drive Group page for parts breakdown.

▼ Included in Swing Frame Group 678516.

Drive Group



REF	QTY	PART NO.	DESCRIPTION	REF	QTY	PART NO.	DESCRIPTION
		675639	Drive Group with Motor	19	1	206392	Drive Motor ▲
	■	675633	Drive Group without 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" (blue)	23	1	670581	Bearing
4	●	670574	Shim - .010" (brown)	24	1	7214	Snap Ring
5	●	671757	Shim - .015" (pink)	25	1	643423	O-Ring
6	●	671758	Shim - .020" (yellow)	26	1	775552	Cover
7	2	670579	Bearing	27	1	603680	Seal
8	1	670582	Key	28	1	783608	Capscrew, 3/8 NC x .50 GR8
9	1	670556	Pinion	29	4	200882	Capscrew, M12 x 20
10	1	775551	Housing	30	1	644010	Relief Fitting
11	1	686465	Gasket	31	1	604510	Fitting, 6
12	1	675608	Worm	32	1	656300	Gear Box Lube - 48 oz.
13	1	775553	Adapter	33	1	668184	Sealant
14	2	2705	Seal	34		670578	Shim Service Kit (items 3-6,11,25 & 33)
15	1	670549	Check Valve			675637	Bearing Service Kit (items 21 & 34)
16	4	6444	Lockwasher			675638	Bearing Service Kit (items 7 & 34)
17	4	607059	Capscrew, 5/16 NC			206394	Motor Kit (items 11,14,18,19 & 33)
18	1	670575	Gasket				

■ Includes all items except 14,15,17 and 18.

● Quantity as required.

▲ See Drive Motor page for parts breakdown.

Reference: 675639 (Common Parts 675627, SK-5032.)

675633 (Sub Assy 220335, Common Parts 795490, SKN-5527)

Drive Motor



REF	QTY	PART NO.	DESCRIPTION
		206392	Drive Motor
1	1	675478	Shaft
2	1	675477	Drive
3	1	675479	Spacer Plate
■ 4	1	675480	Gerotor Set (101-1768-007)
■ 4	1	685075	Gerotor Set (101-1768-009)
5	1	675482	End Cap
● 6	1	206405	Service Kit
■ 7	1	685089	Flange (101-1768-007)
■ 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.

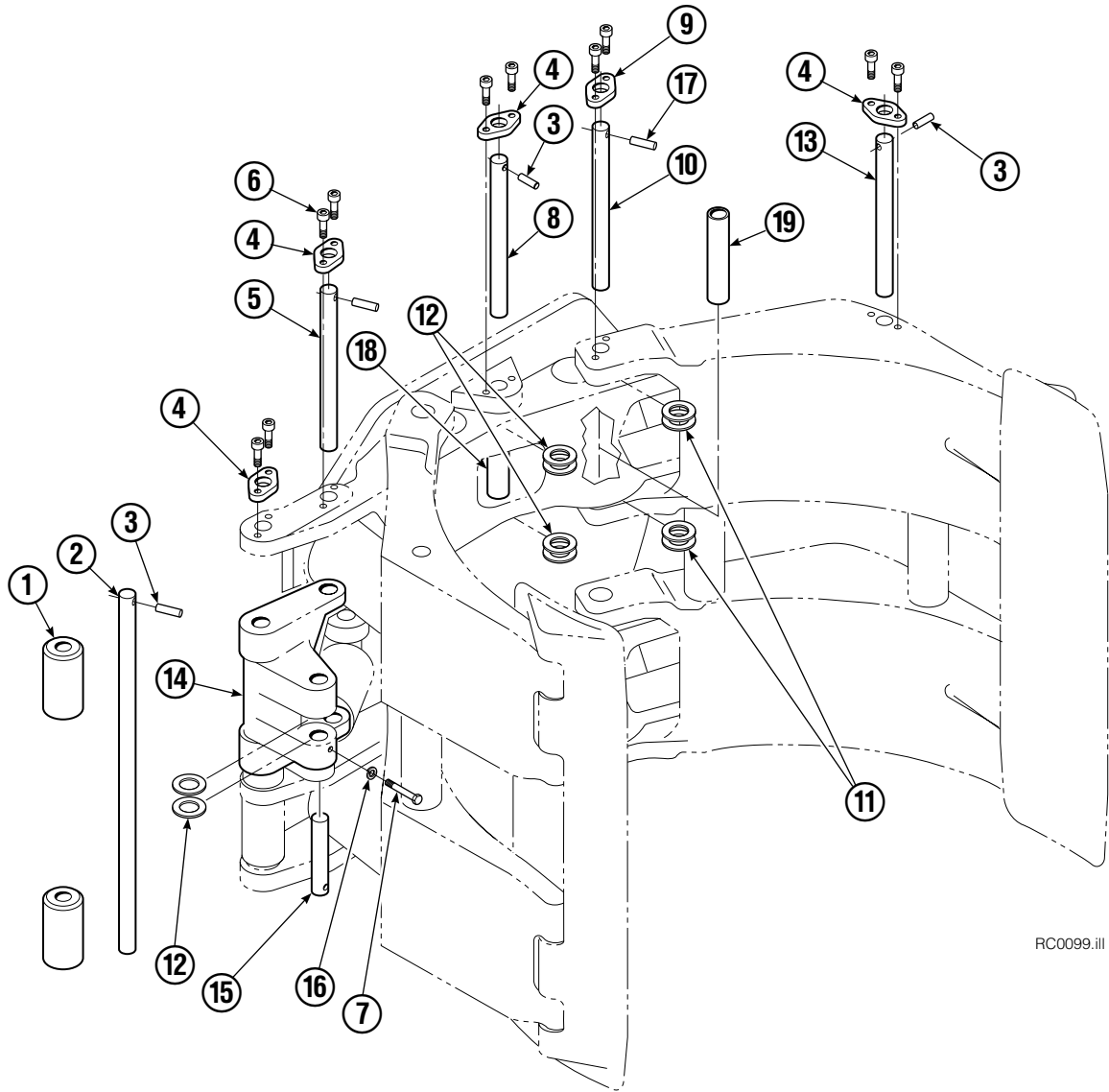
- See Nameplate under valve for correct part number of Gerotor Set and Flange.
- Compatible with water glycol based hydraulic fluids.

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

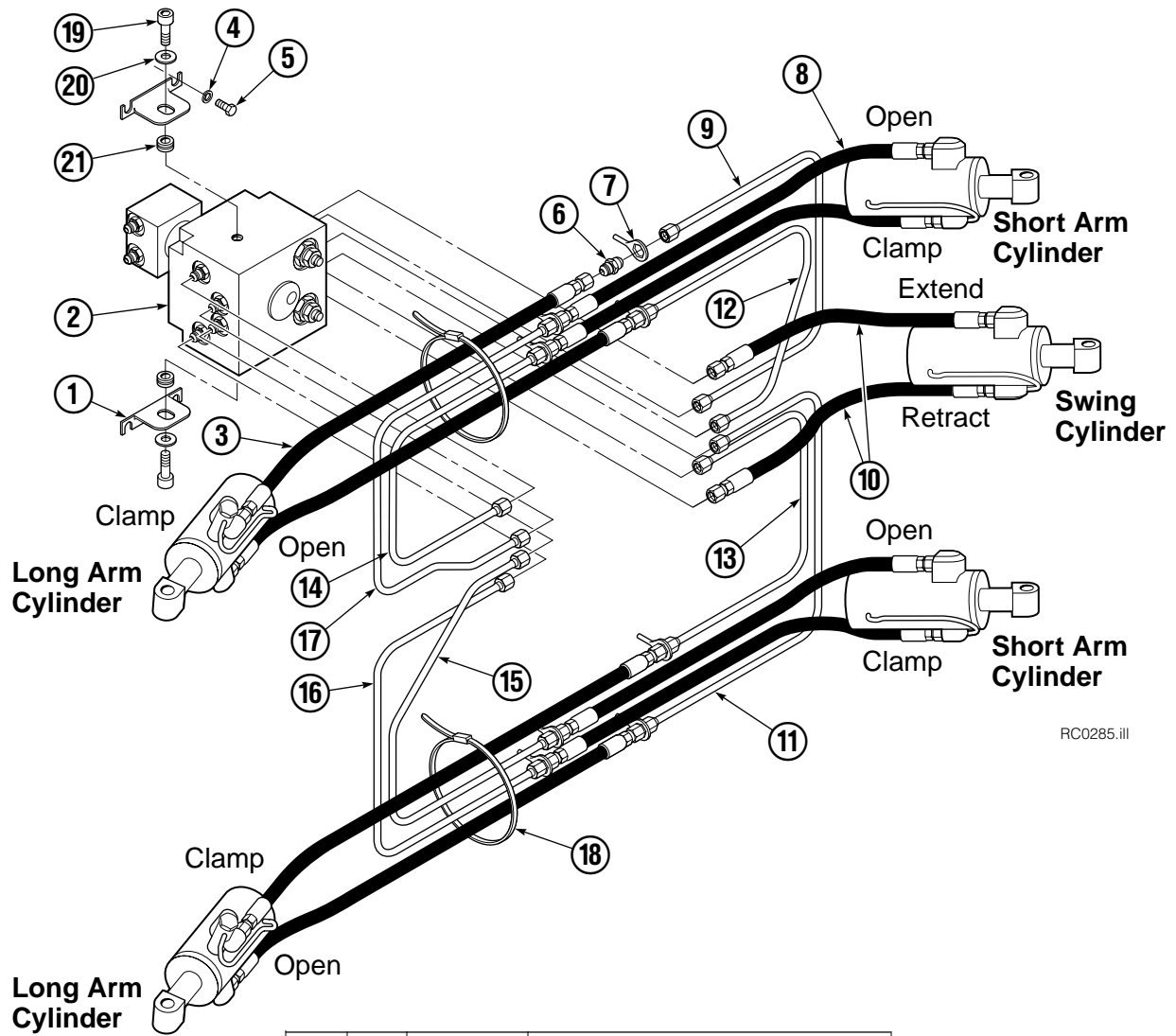
Common Components Group



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77F			
REF	QTY	PART NO.	DESCRIPTION
		680638	Components Group
1	2	675024	Roller
2	1	675021	Pin
3	11	673385	Drive Pin
4	11	674828	Retainer
5	4	675018	Pin
6	30	4466	Capscrew, 3/8 NC x .50 GR8
7	2	643518	Capscrew, 5/16 NC x 2.25 GR8
8	2	675019	Pin
9	4	674830	Retainer
10	4	675022	Pin
11	16	673379	Shim
12	16	660200	Shim
13	4	680651	Pin
14	1	678521	Swing Casting
15	2	675023	Pin
16	2	6287	Lockwasher, 4/16 ID
17	4	675086	Drive Pin
18	2	681668	Spacer
19	4	681672	Spacer

Swing Frame Hosing Group



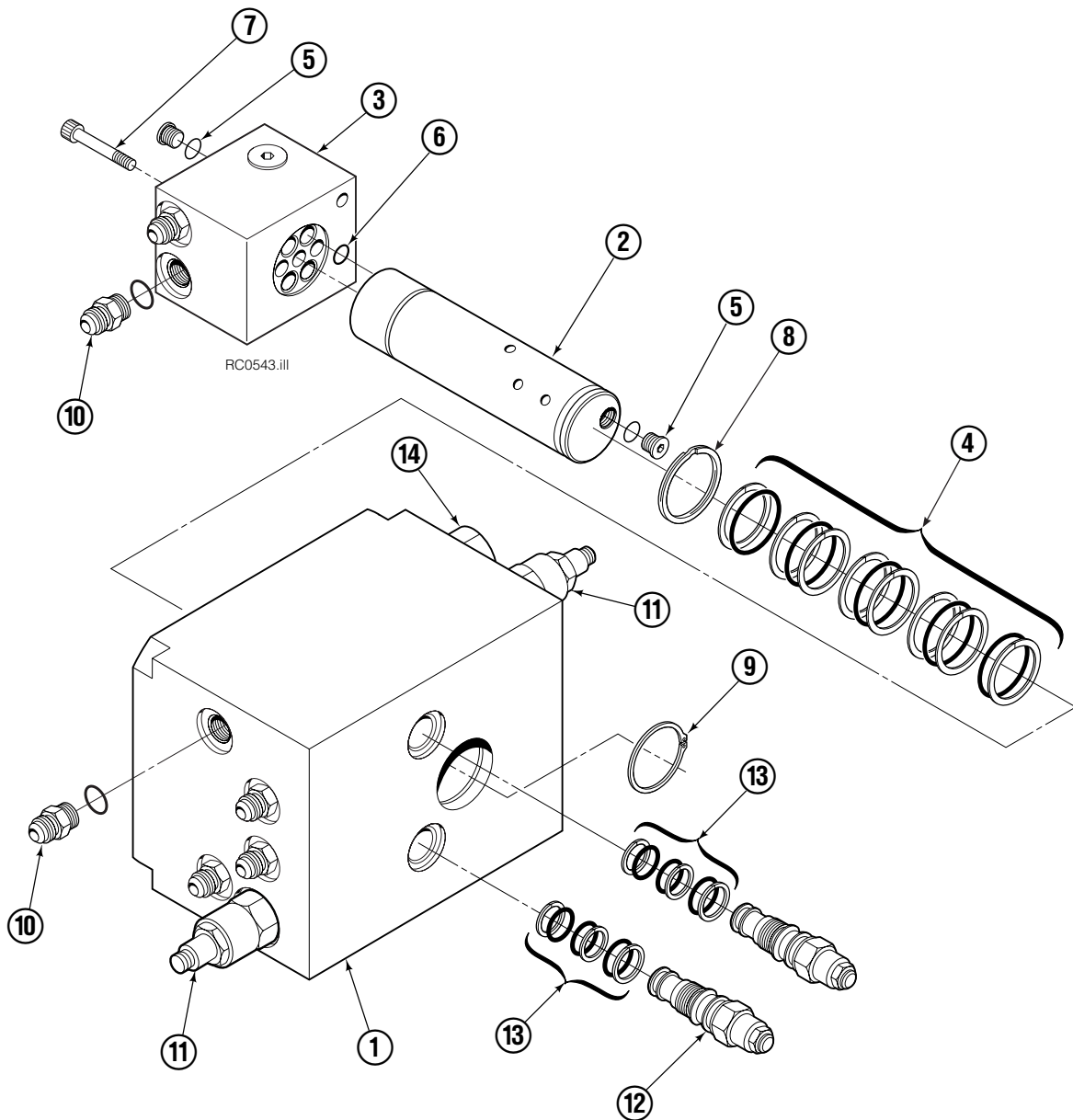
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REF	QTY	PART NO.	DESCRIPTION
		344150	Hosing Group
1	2	212851	Angle
2	1	212396	Revolving Connection ▲
3	4	675067	Hose, 34.00 in.
4	4	6288	Lockwasher, 3/8 in.
5	4	3600	Capscrew, 3/8 NC x .62
6	8	2347	Fitting, 6-6
7	8	674743	Eye Bolt
8	4	675053	Hose, 26.00 in.
9	1	675051	Tube
10	2	675055	Hose, 17.50 in.
11	1	675049	Tube
12	1	675050	Tube
13	1	675048	Tube
14	1	212846	Tube
15	1	212848	Tube
16	1	212849	Tube
17	1	212847	Tube
18	2	649086	Cable Tie
19	2	665992	Shoulder Bolt
20	2	209021	Washer
21	2	208765	Grommet

▲ See Revolving Connection page for parts breakdown.

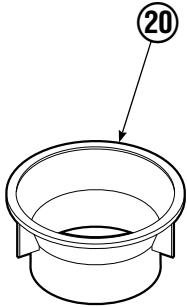
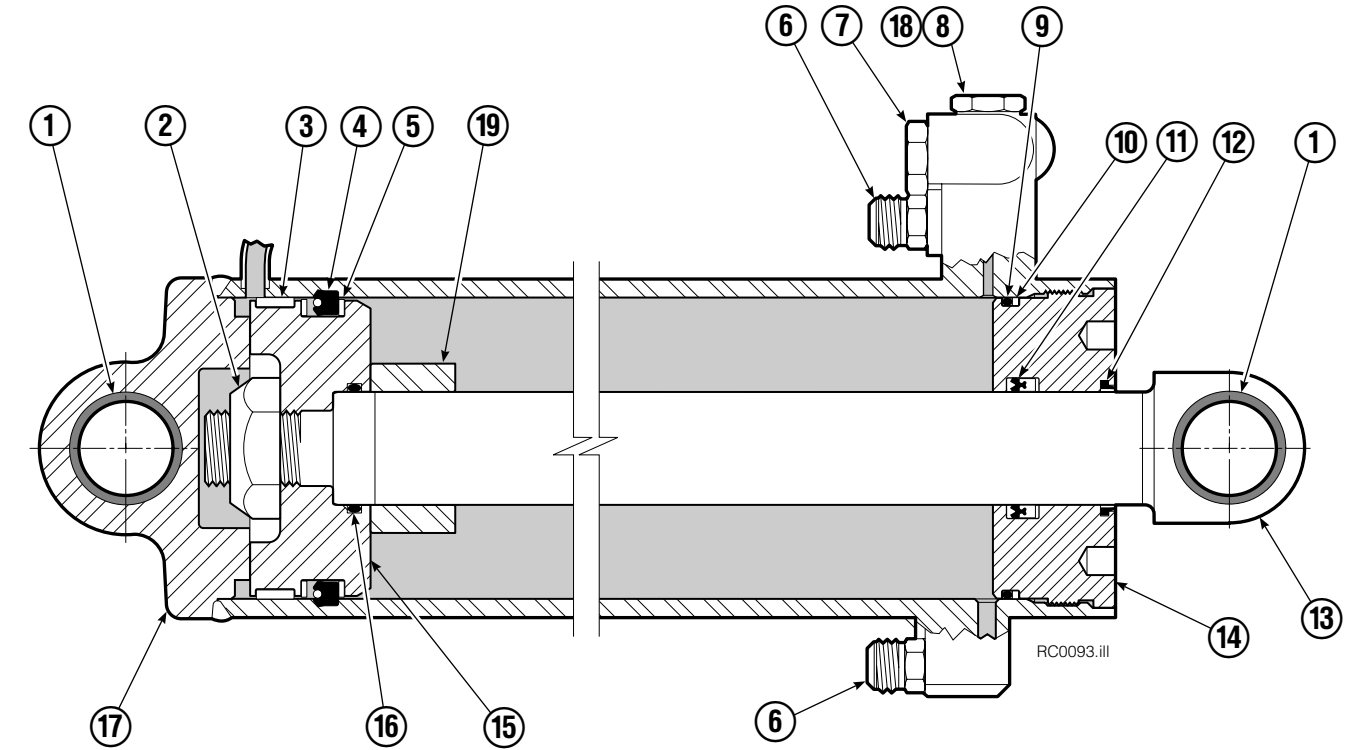
Reference: SK-5831, Common Parts 344151.

Swing Frame Revolving Connection



REF	QTY	PART NO.	DESCRIPTION
		212396	Revolving Connection
1	1	212397	Body
2	1	212869	Shaft
3	1	680451	End Block
4	1	674777	Service Kit
5	5	663694	Fitting, 3
6	4	684587	Seal
7	3	768800	Capscrew
8	1	7341	Snap Ring
9	1	3138	Snap Ring
10	14	604511	Fitting, 6-6
11	2	211771	Relief Valve
12	2	674732	Counterbalance Valve
13	1	667516	Service Kit
14	1	211231	Flow Divider

Short Arm Cylinder

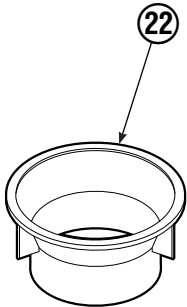
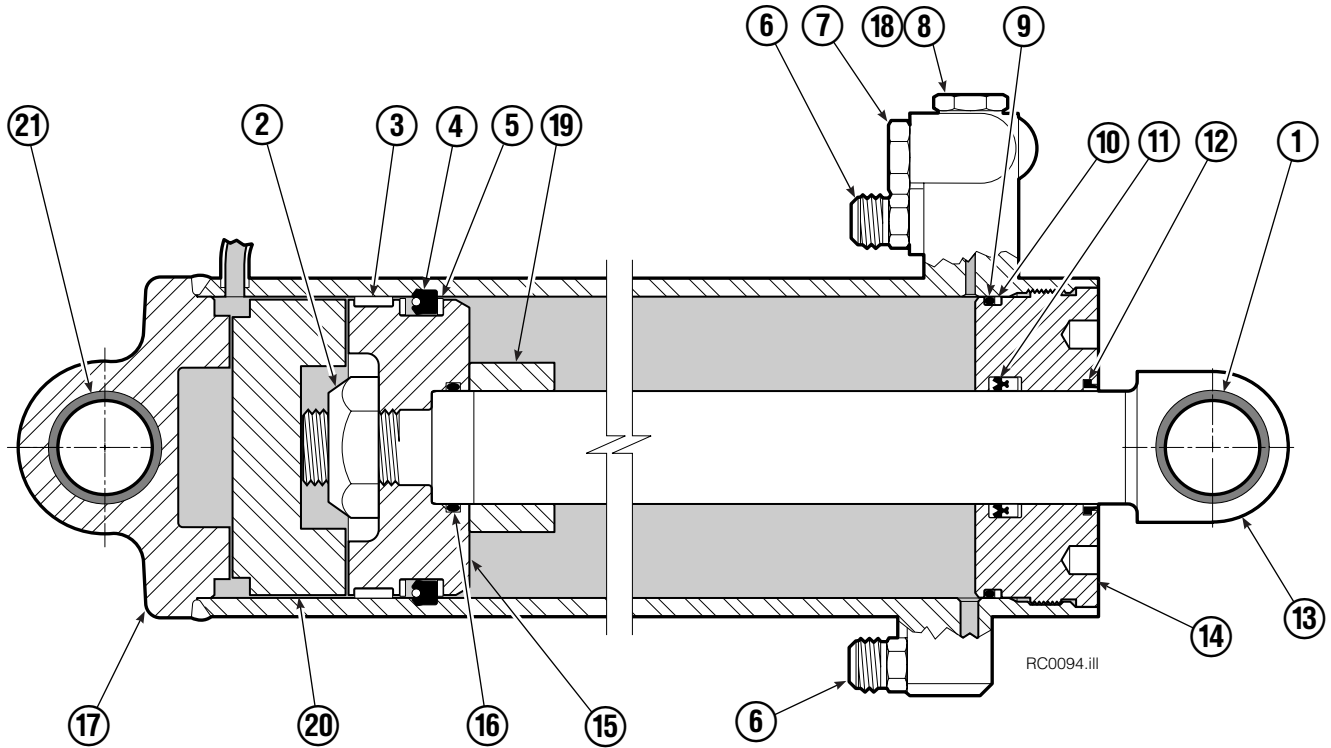


REF	QTY	PART NO.	DESCRIPTION
		557362	Cylinder Assembly
1	3	674843	Bearing
2	1	560997	Nut
3	1	674843	Bearing ♦
4	1	662462	Seal ♦
5	2	638295	Back-Up Ring ♦
6	2	604511	Fitting, 6-6
7	1	556852	Fitting, 4
8	1	557212	Check Valve
9	1	2801	O-Ring ♦
10	1	562731	Back-Up Ring ♦
11	1	554598	Seal ♦
12	1	628047	Wiper ♦
13	1	555392	Rod
14	1	555724	Retainer
15	1	557389	Piston
16	1	2722	O-Ring ♦
17	1	555741	Shell
18	1	667516	Check Valve Service Kit
19	1	—	Spacer
20	1	669243	Seal Loader
		555725	Service Kit

♦ Included in Service Kit 555725.

Reference: S-5313, S-5314.

Long Arm Cylinder

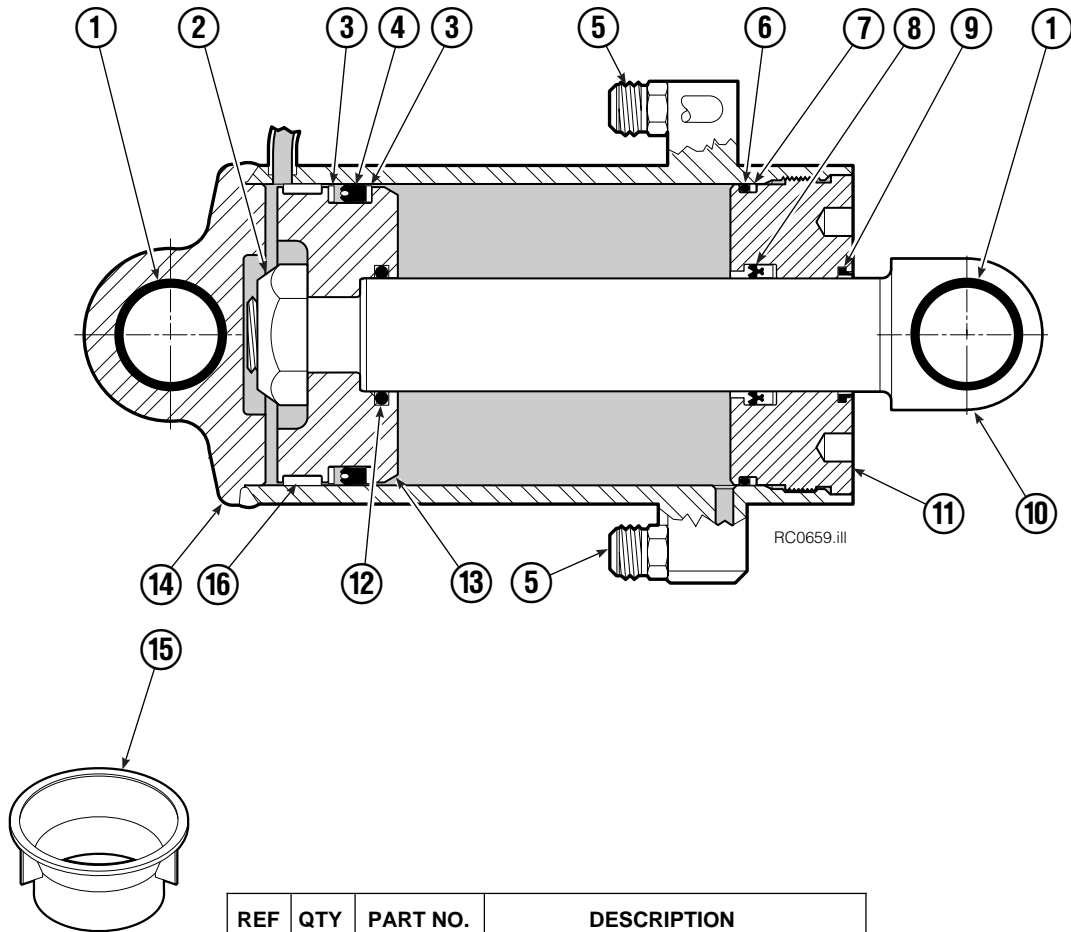


REF	QTY	PART NO.	DESCRIPTION
		557380	Cylinder Assembly
1	1	674843	Bearing
2	1	560997	Nut
◆3	1	660769	Bearing
◆4	1	662462	Seal
◆5	2	638295	Back-Up Ring
6	2	604511	Fitting, 6-6
7	1	556852	Fitting, 4
8	1	557212	Check Valve
◆9	1	2801	O-Ring
◆10	1	563977	Back-Up Ring
◆11	1	554598	Seal
◆12	1	564930	Wiper
13	1	557399	Rod
14	1	555724	Retainer
15	1	557389	Piston
◆16	1	2722	O-Ring
17	1	555718	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

Swing Cylinder



REF	QTY	PART NO.	DESCRIPTION
		580034	Cylinder Assembly
1	3	674843	Bearing
2	1	561997	Nut
3	2	638295	Back-Up Ring ♦
4	1	557446	Seal ♦
5	2	604511	Fitting, 6-6
6	1	2801	O-Ring ♦
7	1	563977	Back-Up Ring ♦
8	1	554598	Seal ♦
9	1	564930	Wiper ♦
10	1	557713	Rod
11	1	555724	Retainer
12	1	2722	O-Ring ♦
13	1	557389	Piston
14	1	555776	Shell
15	1	672910	Seal Loader ♦
16	1	660769	Bearing
		555725	Service Kit

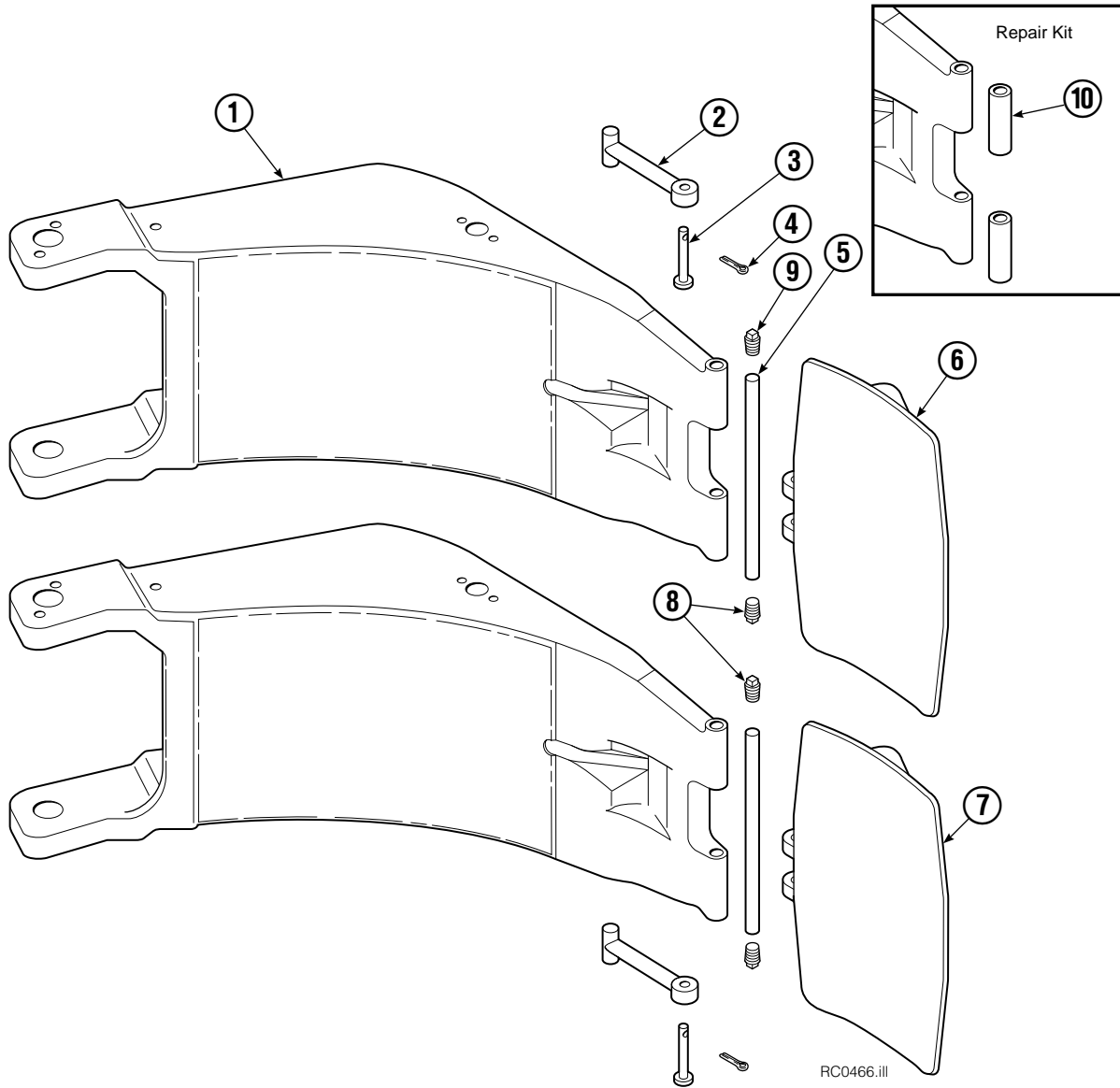
♦ Included in Service Kit 555725.

Short Arm



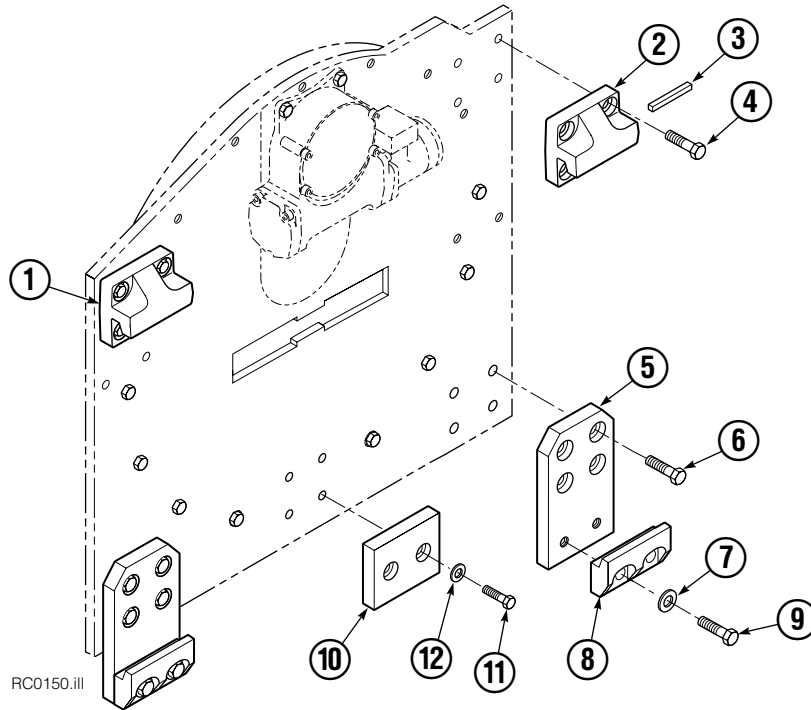
77F			
REF	QTY	PART NO.	DESCRIPTION
		351934	Contact Pad Group – items 2 thru 8
1	1	678537	Short Arm
2	2	674994	Link
3	2	682978	Clevis Pin
4	2	6525	Cotter Pin
5	2	674993	Pin
6	1	351935	Contact Pad
7	2	689900	Plug
8	2	201102	Plug
9	1	676810	Arm Tip Repair Kit

Long Arm – Split



77F			
REF	QTY	PART NO.	DESCRIPTION
		6000521	Contact Pad Group – items 2 thru 9
1	2	675133	Long Arm
2	2	674994	Link
3	2	682978	Clevis Pin
4	2	6525	Cotter Pin
5	2	674993	Pin
6	1	6000416	Contact Pad
7	1	6000415	Contact Pad
8	2	689900	Plug
9	2	201102	Plug
10	1	676810	Arm Tip Repair Kit

Bolt-On Mounting Group



Class IV, 0°			
REF	QTY	PART NO.	DESCRIPTION
		678504	Mounting Group
1	1	675062	Upper Hook – LH
2	1	675061	Upper Hook – RH
3	1	670704	Stop Kit
4	8	675078	Capscrew, 3/4 NC x 1.50
5	2	675082	Extension
6	8	673387	Capscrew, 5/8 NC x 1.75
7	4	670692	Washer
8	2	679832	Lower Hook
9	4	675079	Capscrew, 3/4 NC x 2.00
10	1	675081	Center Spacer
11	2	4472	Capscrew, 3/8 NC x 1.50
12	2	6372	Lockwasher, 3/8 in. ID

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