



Parts Manual

Model 90F Roll Clamp

Serial Number 90F-RCS-104

cascade[®]
corporation

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Safety Decals



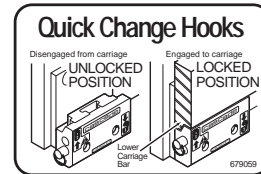
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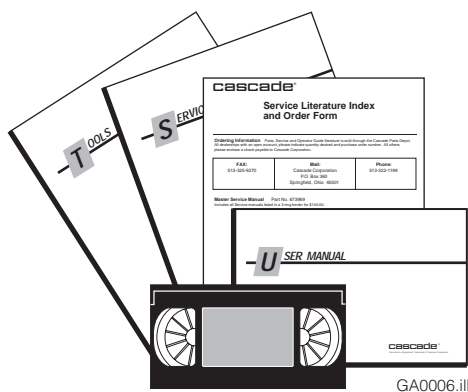


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Roll Clamp Safety Decals			
REF	QTY	PART NO.	DESCRIPTION
1	6	665595	No Hand Hold Decal
2	3	660269	Short Arm Rotation Position Decal
3	4	656038	Caution Decal
4	4	679150	No Step Decal
5	4	665677	Trapped Pressure Decal
6	1	679059	Quick-Change Hook Decal

Publications

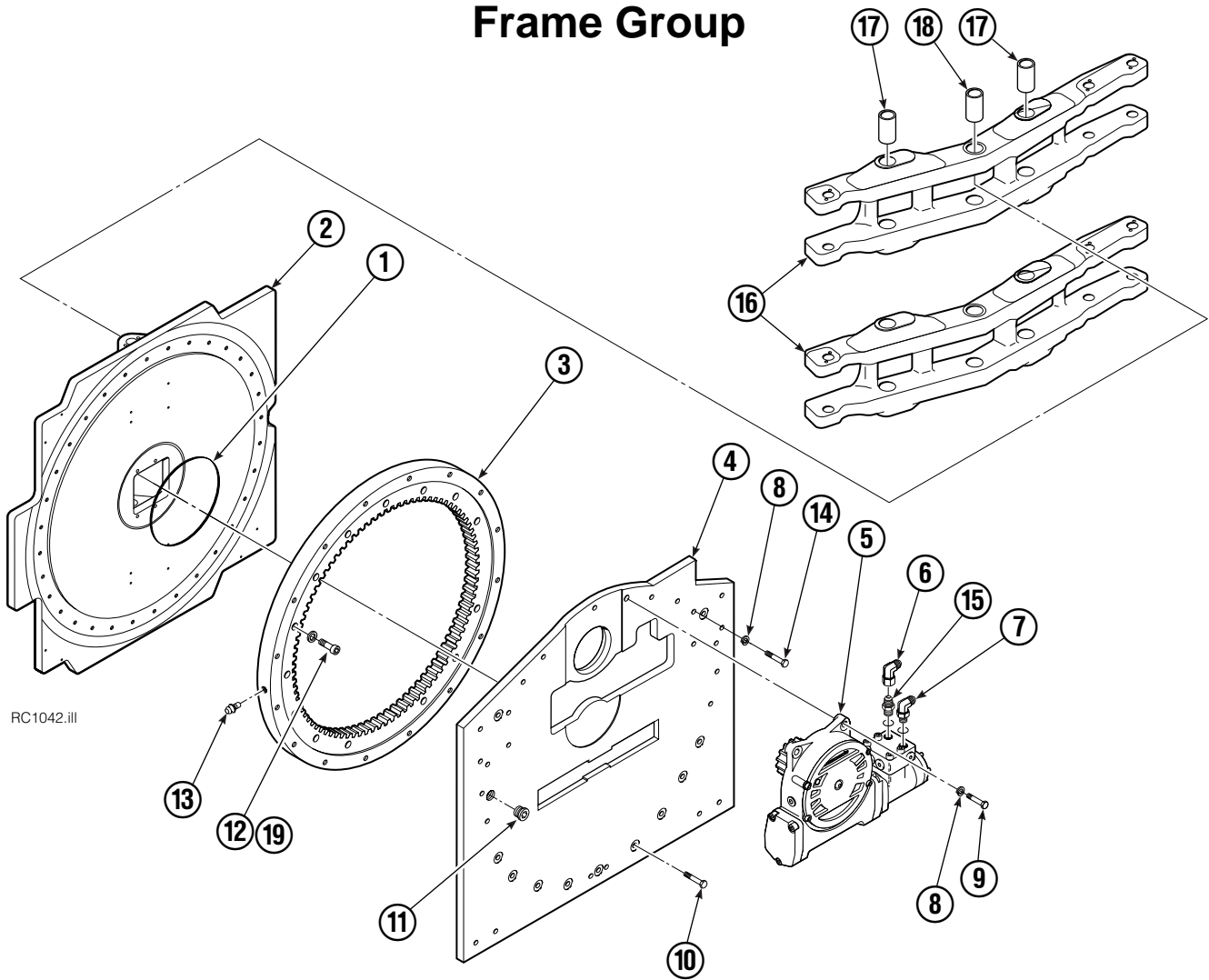


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Roll Clamp Publications

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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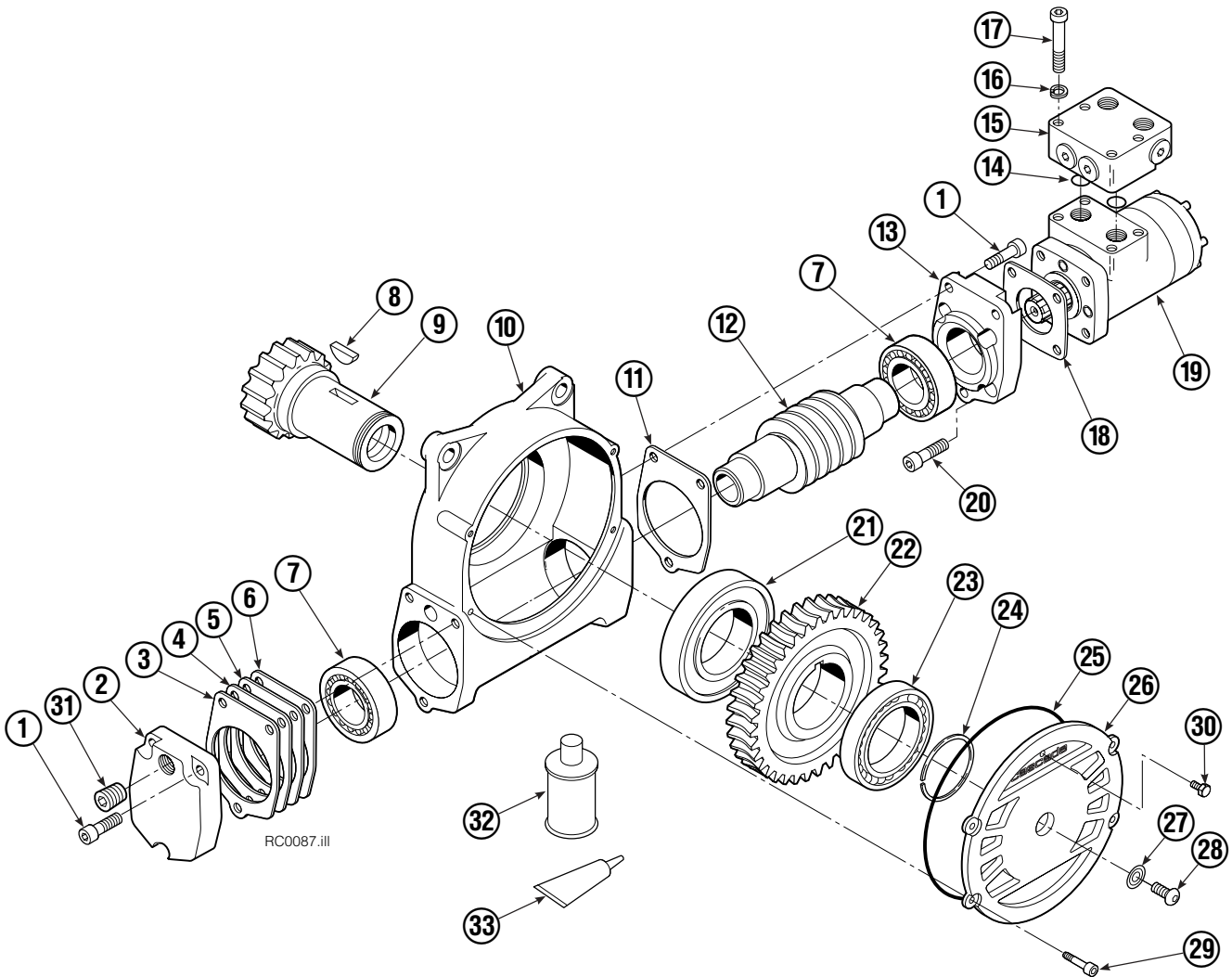
90F			
REF	QTY	PART NO.	DESCRIPTION
		394131	Frame Group
1	1	670931	Seal
2	1	6011193	Faceplate
3	1	214481	Bearing Assembly
4	1	214484	Baseplate
5	1	795492	Drive Group ●
6	1	605761	Fitting, 8-8
7	1	601250	Fitting, 8-8
8	4	6290	Lockwasher, 1/2 ID
9	4	763021	Capscrew, M12 x 30
10	13	206174	Capscrew, M12 x 45
11	1	664071	Plug
12	32	753221	Capscrew, M12 x 50
13	1	7401	Grease Fitting
14	19	213633	Capscrew, M12 x 55
15	1	601377	Fitting, 8-8
16	2	381130	Swing Frame ▲
17	8	675008	Bushing ▲
18	4	675006	Bushing ▲
19	32	681473	Lockwasher, M12

● See Drive Group page for parts breakdown.

▲ Included in Swing Frame Group 381129.

Reference: SK-6189, 393464, 223703.

Drive Group



REF	QTY	PART NO.	DESCRIPTION	REF	QTY	PART NO.	DESCRIPTION
		795492	Drive Group with 2.8 c.i. Motor	19	1	206392	Drive Motor – 2.8 c.i. ■
1	6	769570	Capscrew, M12 x 25	20	4	4468	Capscrew, 3/8 NC x .75 GR8
2	1	676855	Cover	21	1	670580	Bearing
3	●	674513	Shim – .005" (blue)	22	1	675609	Worm Gear
4	●	670574	Shim – .010" (brown)	23	1	670581	Bearing
5	●	671757	Shim – .015" (pink)	24	1	7214	Snap Ring
6	●	671758	Shim – .020" (yellow)	25	1	643423	O-Ring
7	2	670579	Bearing	26	1	775552	Cover
8	1	670582	Key	27	1	783609	Seal
9	1	670556	Pinion	28	1	783608	Capscrew, M10 x 16
10	1	775551	Housing	29	4	200882	Capscrew, M8 x 20
11	1	686465	Gasket	30	1	644010	Relief Fitting
12	1	675608	Worm	31	1	604510	Fitting, 6
13	1	775553	Adapter	32	1	656300	Gear Box Lube – 48 oz.
14	2	2705	O-Ring	33	1	668184	Sealant
15	1	670549	Check Valve ▲			670578	Shim Service Kit (items 3-6,25,33)
16	4	6444	Lockwasher			675637	Bearing Service Kit (items 21 & 33)
17	4	607059	Capscrew, 5/16 NC x 1.75 GR8			675638	Bearing Service Kit (items 3-7,25)
18	1	670575	Gasket			206394	Motor Kit-2.8 c.i. (items 11,14,18,19)

● Quantity as required.

■ See Drive Motor page for parts breakdown.

▲ See Check Valve page for parts breakdown.

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.

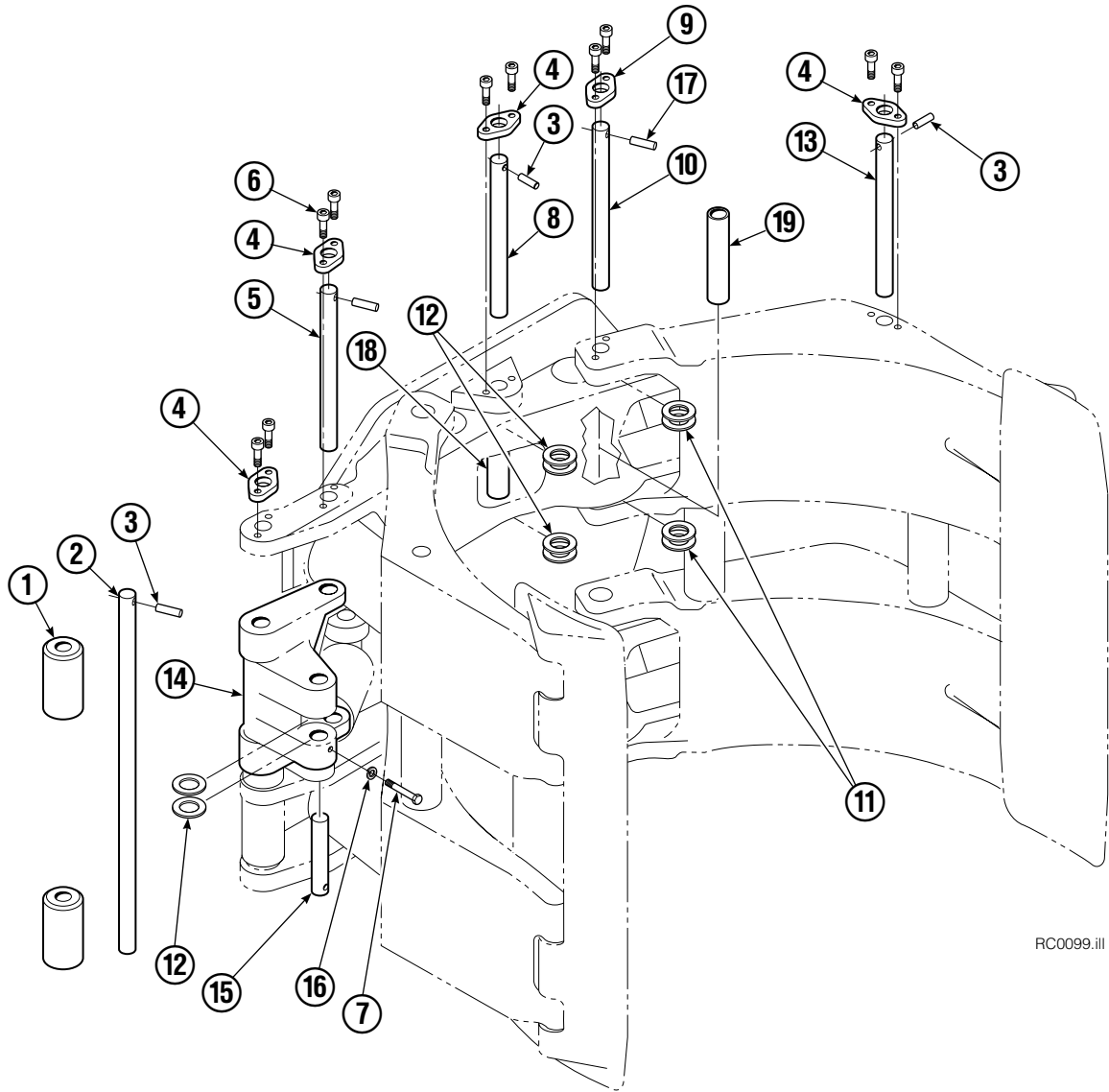
- See Nameplate under valve for correct part number of Gerotor Set and Flange.
- Compatible with water glycol based hydraulic fluids.

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

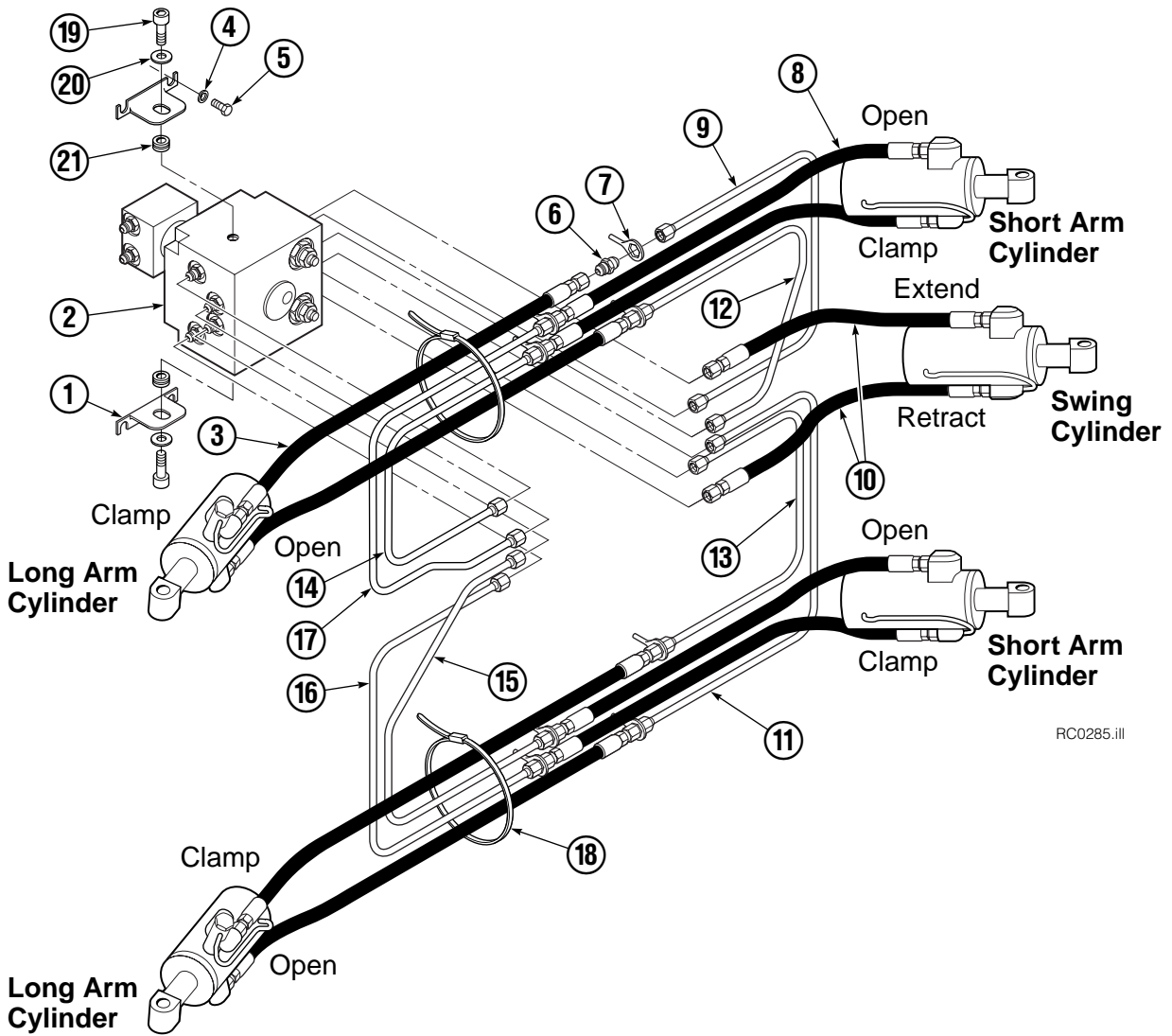
Common Components Group



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90F			
REF	QTY	PART NO.	DESCRIPTION
		356184	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	676088	Pin
14	1	356185	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

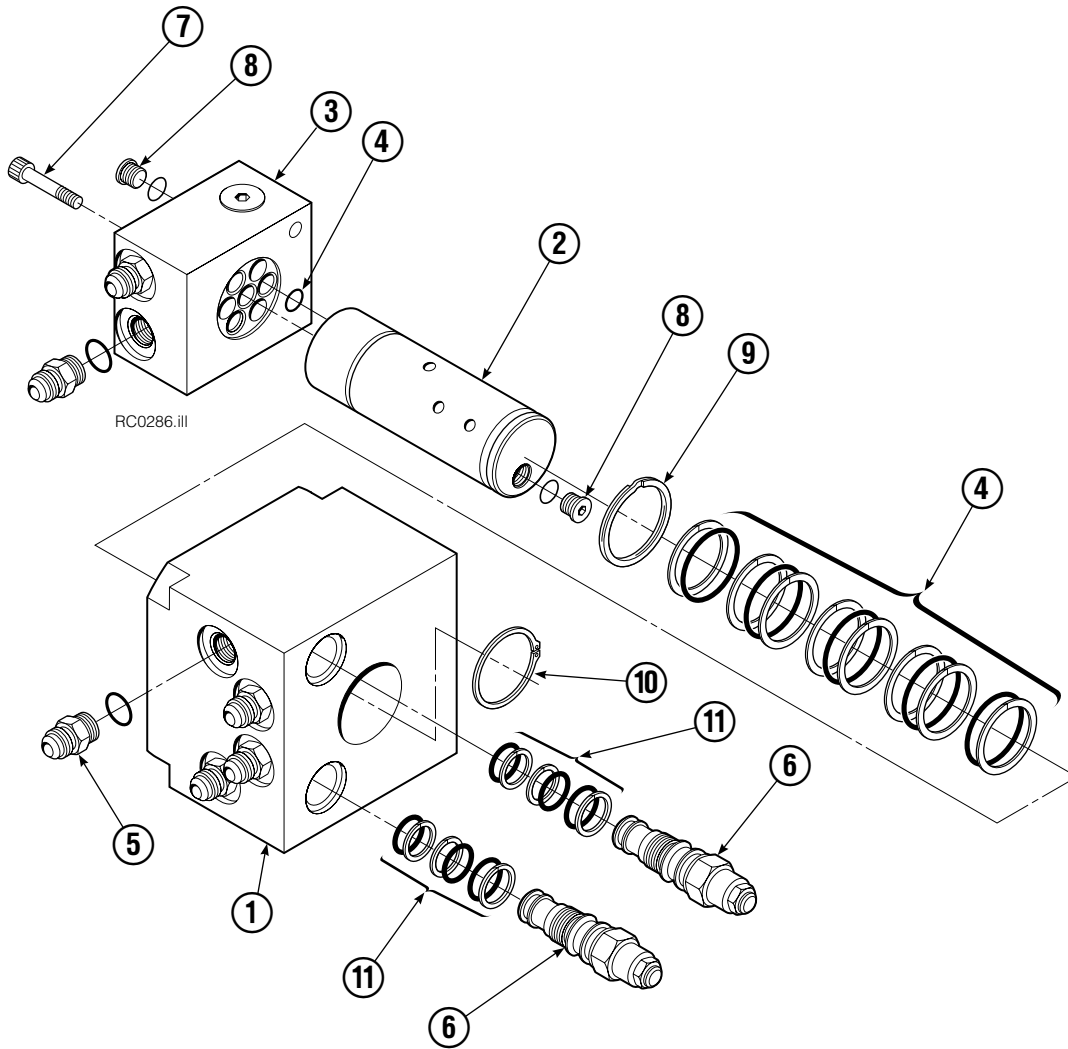


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REF	QTY	PART NO.	DESCRIPTION
		381128	Hosing Group
1	2	206606	Angle
● 2	1	208798	Revolving Connection
3	4	381145	Hose
4	4	6288	Lockwasher, 3/8"
5	4	3600	Capscrew, 3/8 NC x .62
6	8	2347	Fitting, 6-6
7	8	674743	Eye Bolt
8	4	381146	Hose
9	1	675051	Tube
10	2	675058	Hose
11	1	675049	Tube
12	1	675050	Tube
13	1	675048	Tube
14	1	675047	Tube
15	1	675045	Tube
16	1	675044	Tube
17	1	675046	Tube
18	2	649086	Cable Tie
19	2	665992	Shoulder Bolt
20	2	209021	Washer
21	2	208765	Grommet

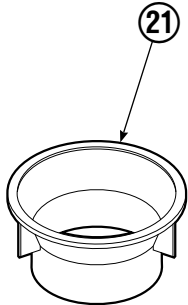
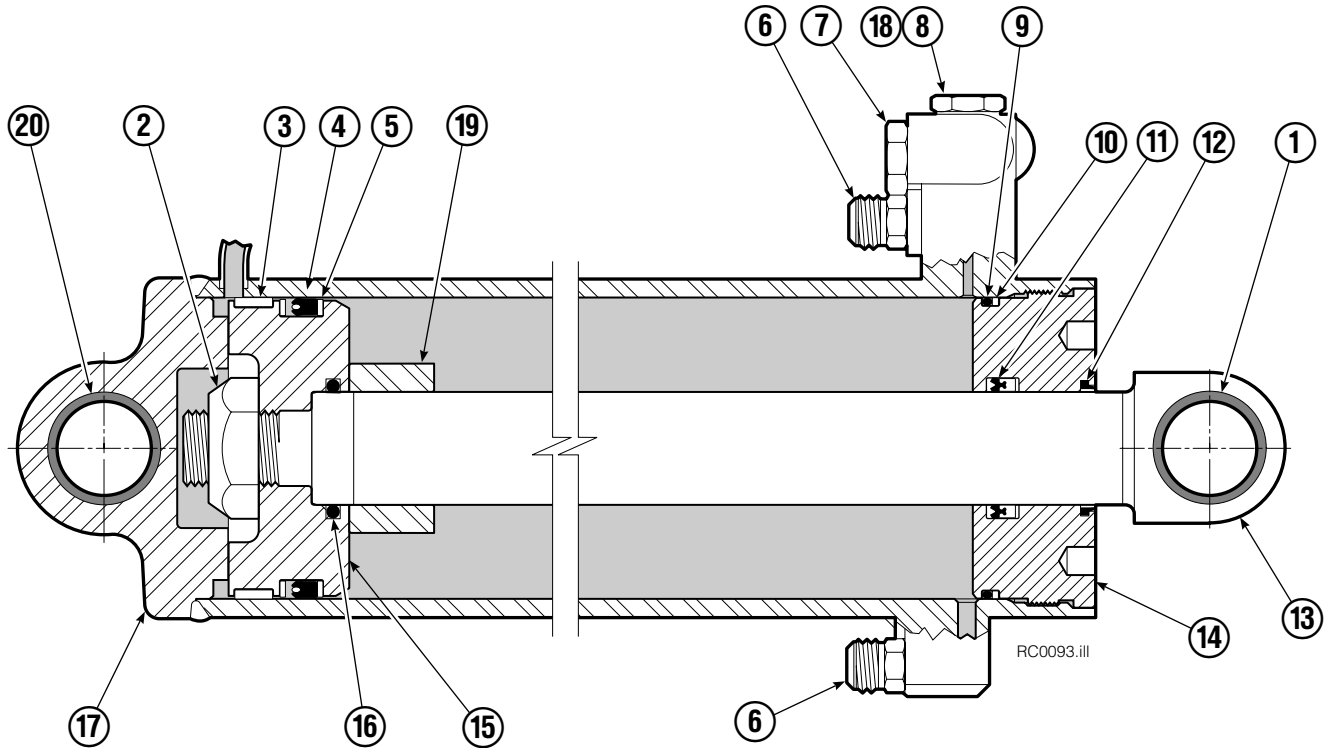
● See Revolving Connection page for parts breakdown.

Swing Frame Revolving Connection



90F			
REF	QTY	PART NO.	DESCRIPTION
		208798	Revolving Connection
1	1	207443	Body
2	1	680449	Shaft
3	1	680451	End Block
4	1	674777	Service Kit
5	14	604511	Fitting, 6-6
6	2	674732	Counterbalance Valve
7	3	768800	Capscrew, M8 x 1.25 x 45-8.8
8	5	663694	Fitting, 3
9	1	7341	Snap Ring
10	1	3138	Snap Ring
11	1	667516	Service Kit

Long Arm Cylinder

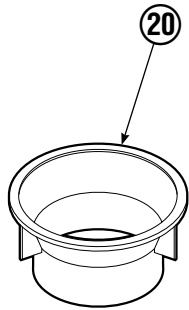
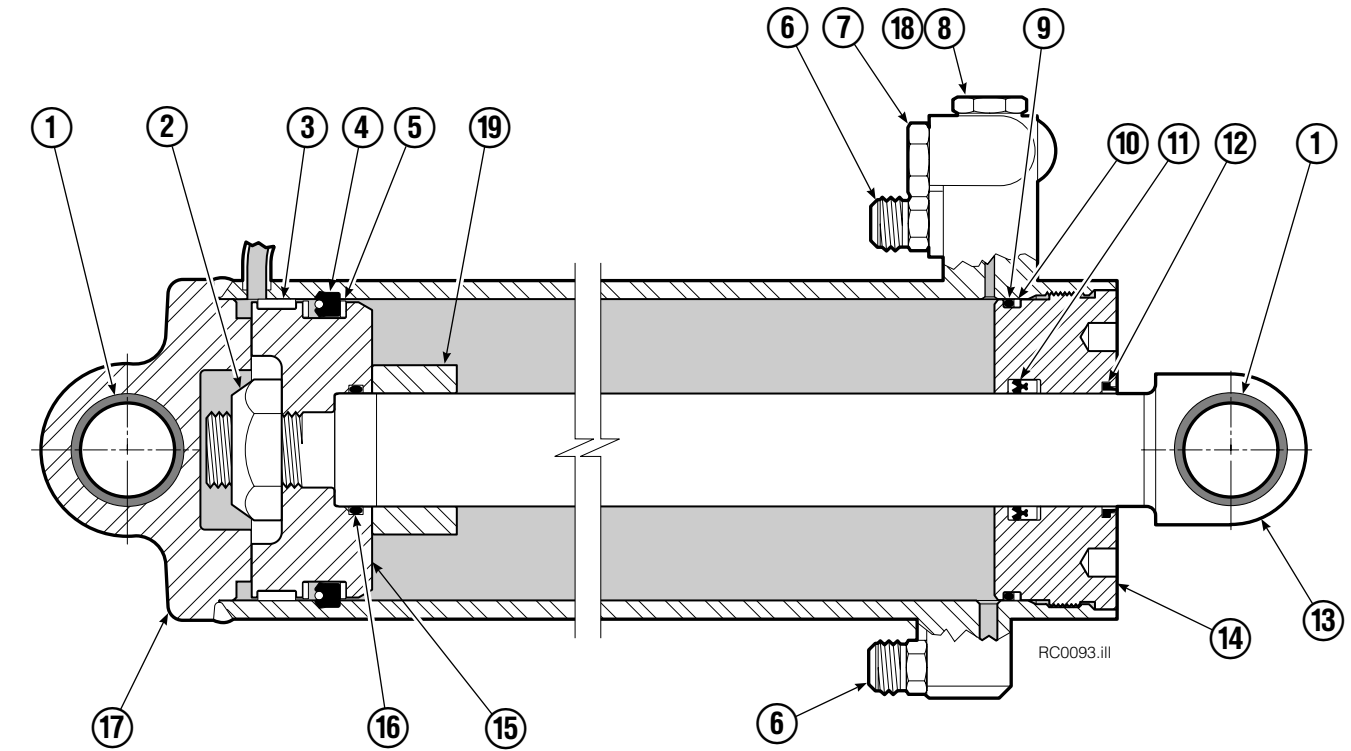


REF	QTY	PART NO.	DESCRIPTION
		381131	Cylinder Assembly
1	1	674843	Bearing
2	1	667990	Nut
3	1	660769	Bearing ♦
4	1	557446	Seal ♦
5	2	638295	Back-Up Ring ♦
6	2	604511	Fitting, 6-6
7	1	556852	Fitting, 4
8	1	557212	Check Valve
9	1	2801	O-Ring ♦
10	1	615144	Back-Up Ring ♦
11	1	554598	Seal ♦
12	1	628047	Wiper ♦
13	1	584299	Rod
14	1	555724	Retainer
15	1	557389	Piston
16	1	2722	O-Ring ♦
17	1	584297	Shell
18	1	667516	Check Valve Service Kit
19	1	—	Spacer
20	2	674843	Bearing
21	1	672910	Seal Loader
		555725	Service Kit

♦ Included in Service Kit 555225.

Reference: S-5320.

Short Arm Cylinder

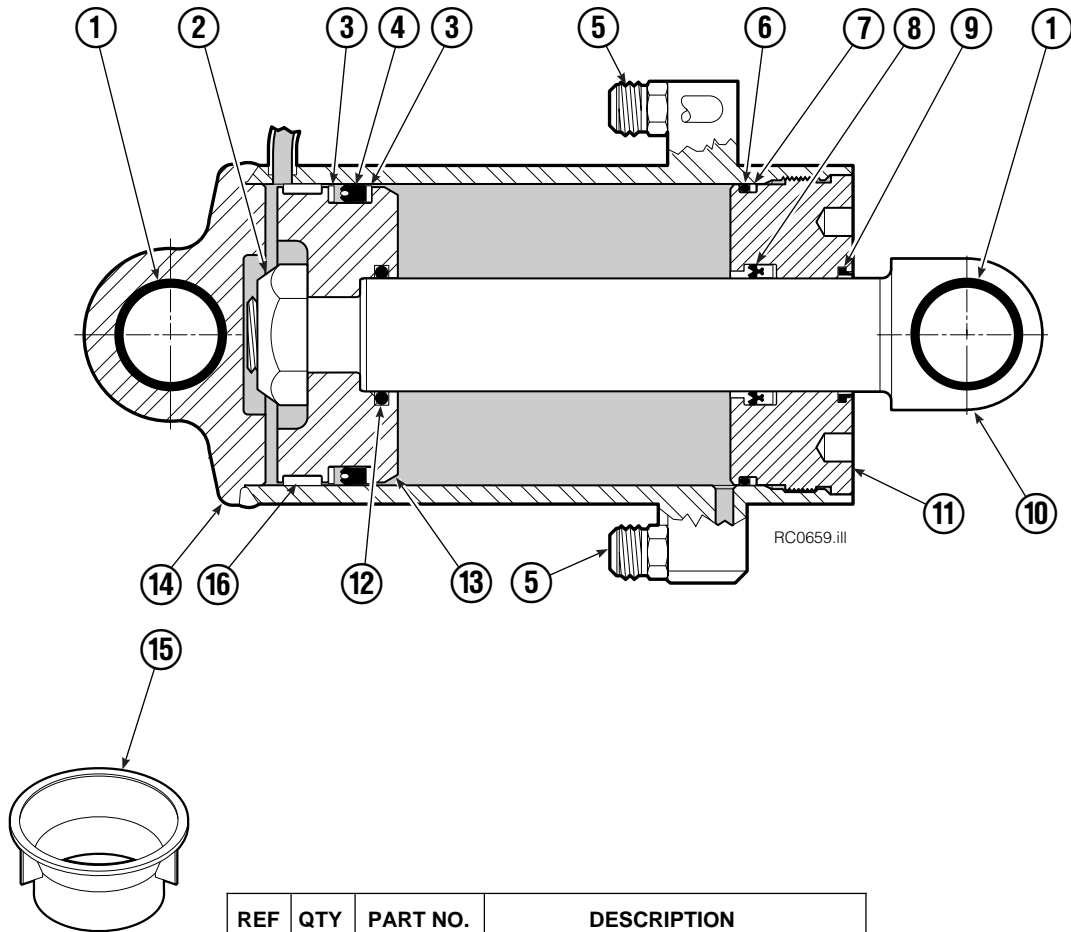


REF	QTY	PART NO.	DESCRIPTION
		385089	Cylinder Assembly
1	3	674843	Bearing
2	1	667990	Nut
3	1	660769	Bearing ♦
4	1	557446	Seal ♦
5	2	638295	Back-Up Ring ♦
6	2	604511	Fitting, 6-6
7	1	556852	Fitting, 4
8	1	557212	Check Valve
9	1	2801	O-Ring ♦
10	1	615144	Back-Up Ring ♦
11	1	554598	Seal ♦
12	1	628047	Wiper ♦
13	1	584302	Rod
14	1	555724	Retainer
15	1	557389	Piston
16	1	2722	O-Ring ♦
17	1	584300	Shell
18	1	667516	Check Valve Service Kit
19	1	—	Spacer
20	1	672910	Seal Loader
		555725	Service Kit

♦ Included in Service Kit 555725.

Reference: S-5313, S-5314.

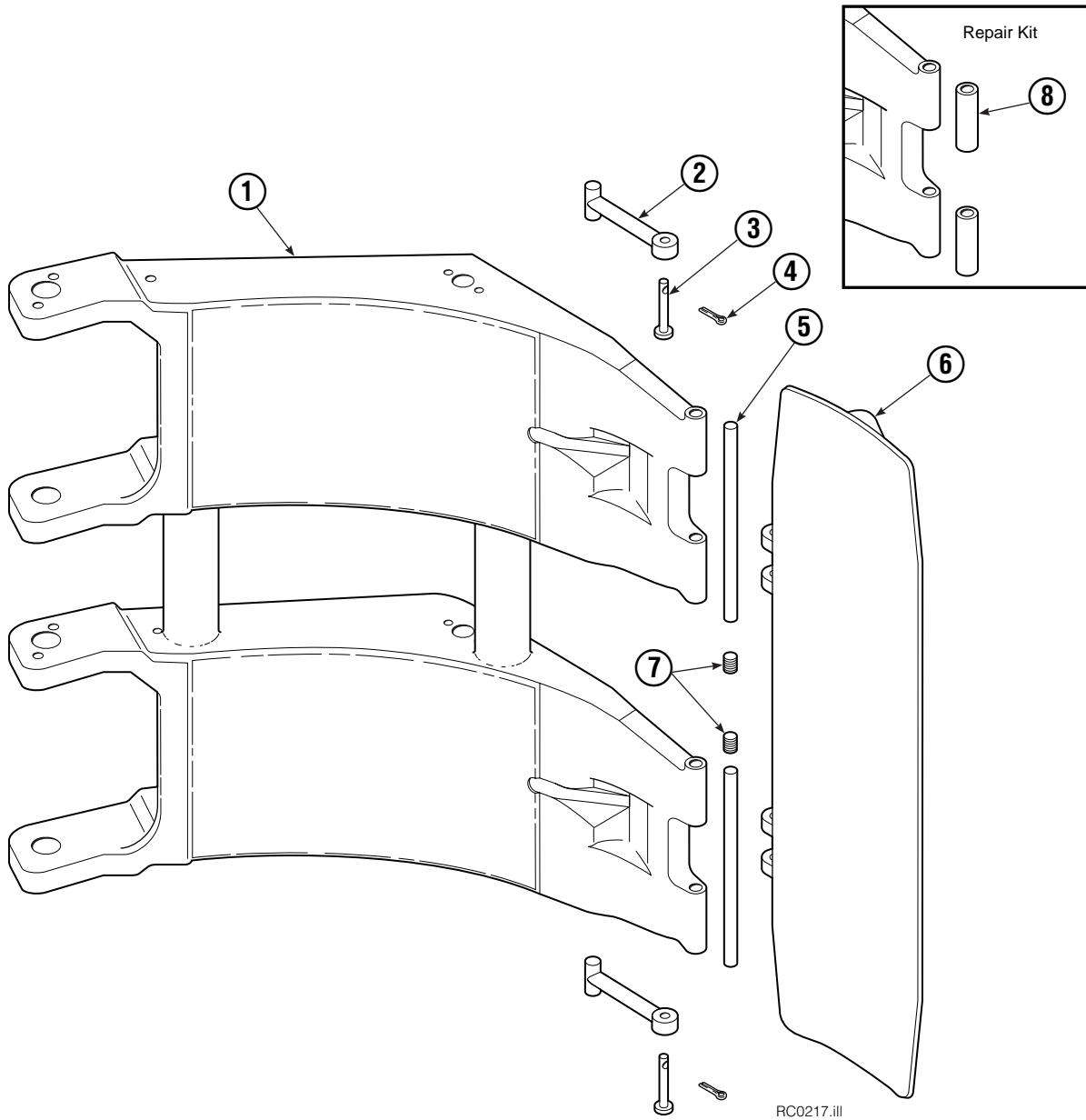
Swing Cylinder



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.

Contact Pad Group



90F			
REF	QTY	PART NO.	DESCRIPTION
		398938	Contact Pad Group (2 thru 7)
1	1	385093	Short Arm
1	1	381133	Long Arm
2	4	674994	Link
3	4	682978	Clevis Pin
4	4	6525	Cotter Pin
5	4	674993	Pin
6	2	338707	Contact Pad
7	4	689900	Plug
8	1	676810	Arm Tip Repair Kit

Bolt-On Mounting Group



Class IV, 1.8°			
REF	QTY	PART NO.	DESCRIPTION
		684880	Mounting Group
1	1	684877	Upper Hook – LH
2	1	675061	Upper Hook – RH
3	1	670704	Stop Kit
4	8	679082	Capscrew, M20 x 35
5	2	768810	Capscrew, M10 x 30
6	2	680030	Lockwasher, M10
7	1	681057	Center Spacer
8	4	676854	Capscrew, M20 x 60
9	4	670692	Washer
10	2	679832	Lower Hook
11	2	681056	Spacer

Reference: SK-5286.

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