



Parts Manual

Model 77F-RC-23N

Serial Number 216666

cascade[®]
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

Safety Decals



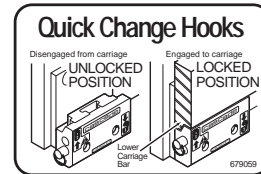
RC0636.ill



4



6



5



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

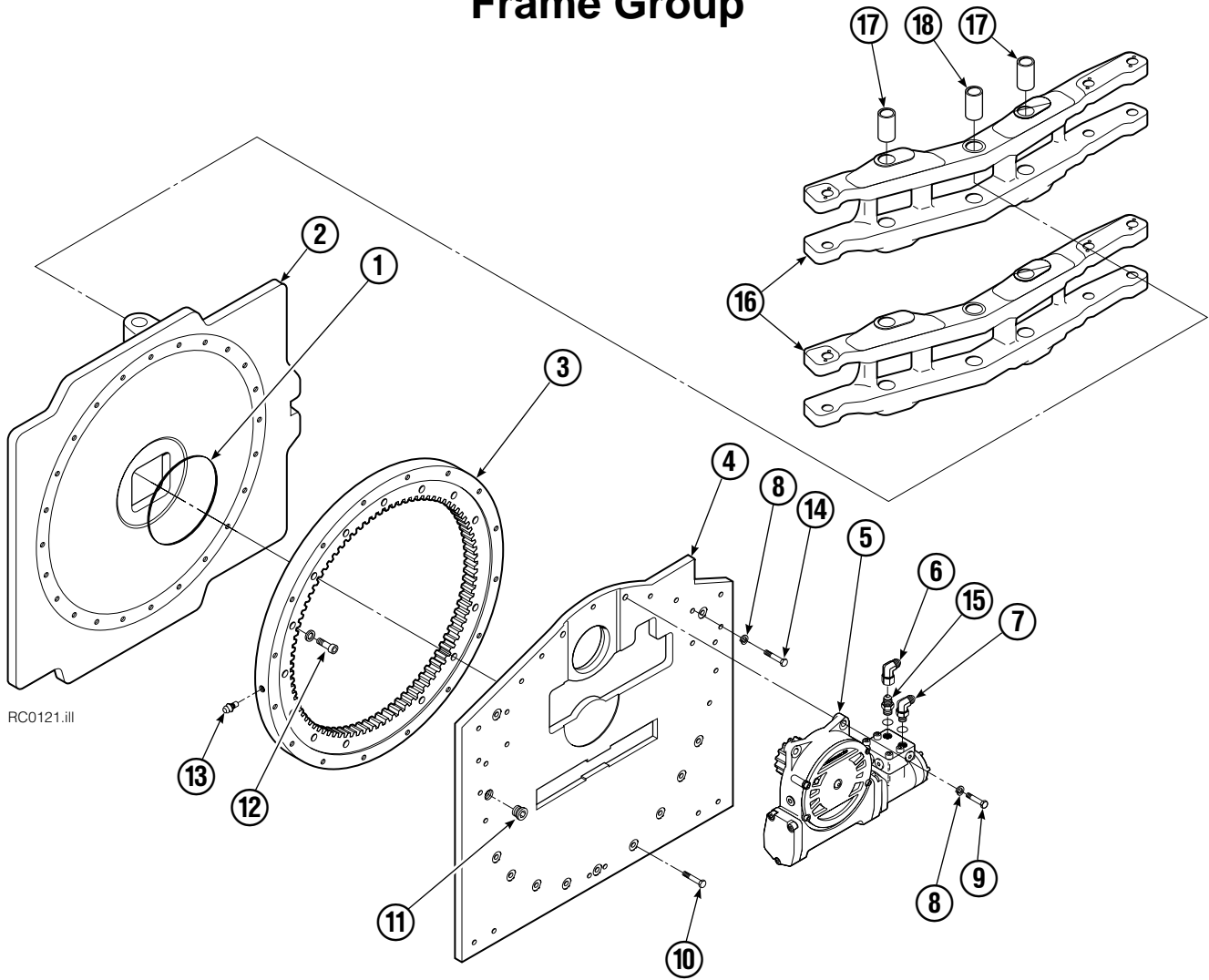
Publications



GA0006.ill

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



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	795492	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	678518	Swing Frame ▼
17	8	675008	Bushing ▼
18	4	675006	Bushing ▼

● See Drive Group page for parts breakdown.

▼ Included in Swing Frame Group 678517.

Reference: Common Parts 675069.

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			685227	Motor Kit-4.5 (items 4,14,18)

● 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.

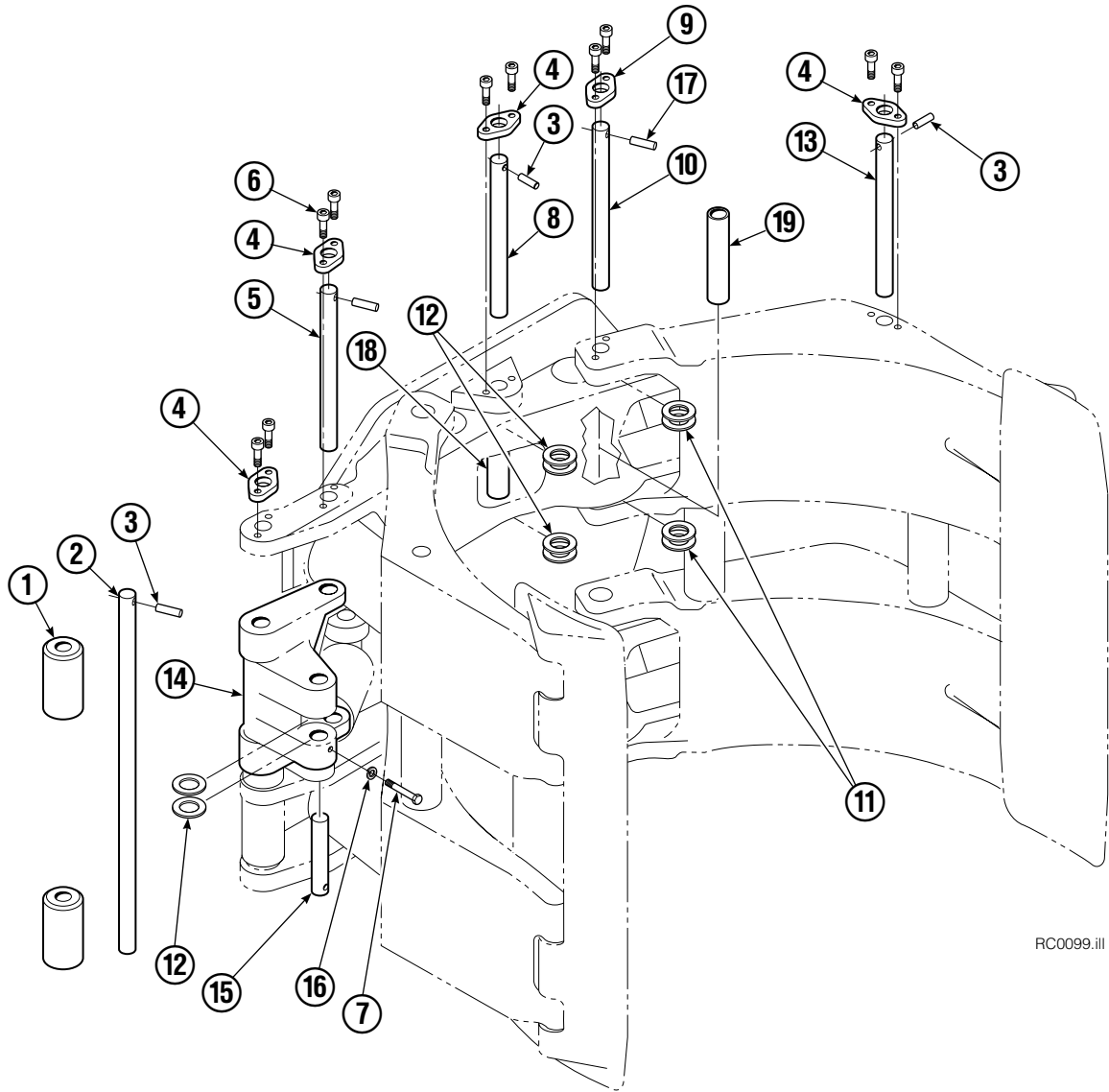
- See Nameplate under valve for correct part number of Gerotor Set and Flange.
- Compatible with water glycol based hydraulic fluids.

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

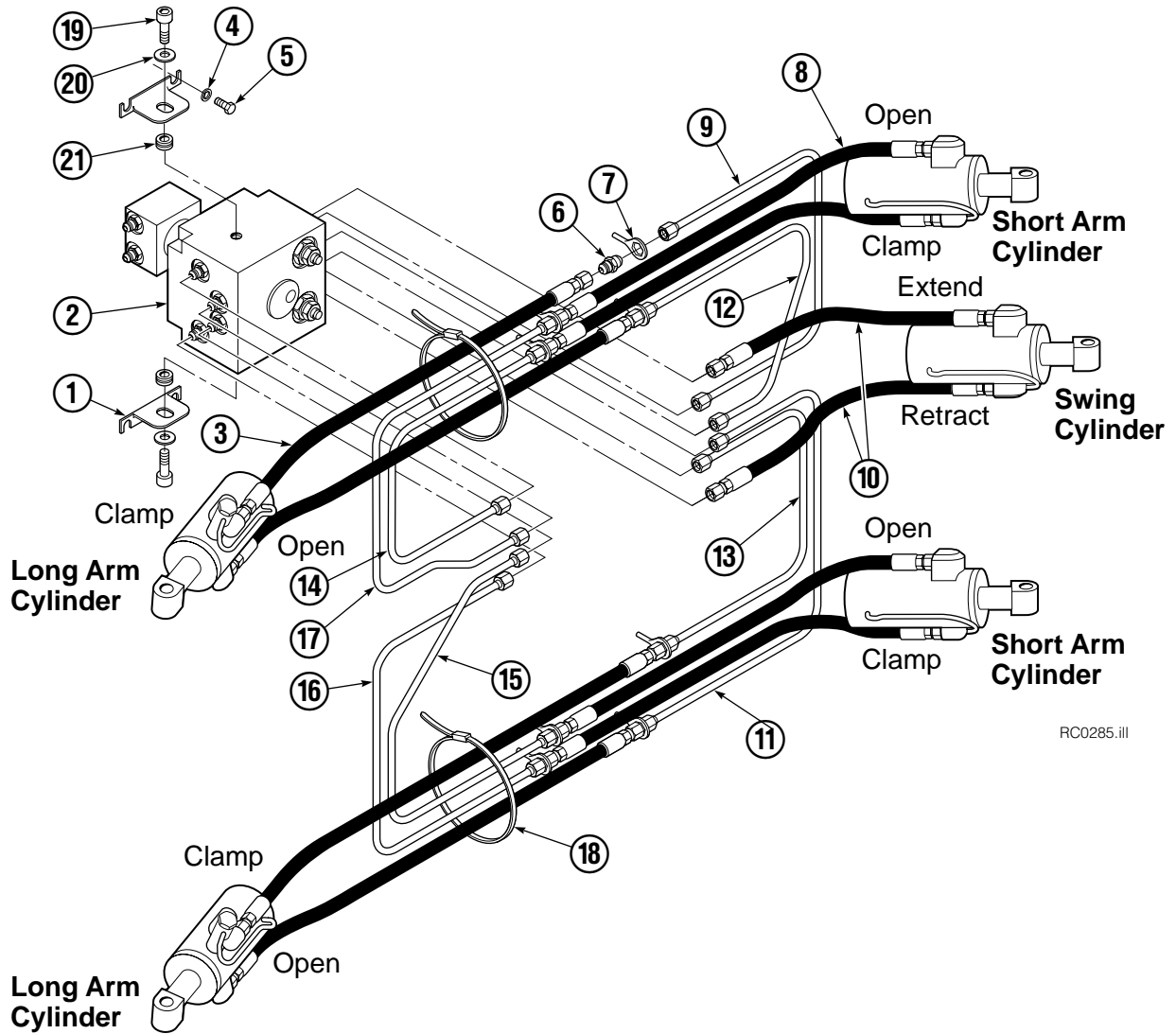
Common Components Group



RC0099.iii

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

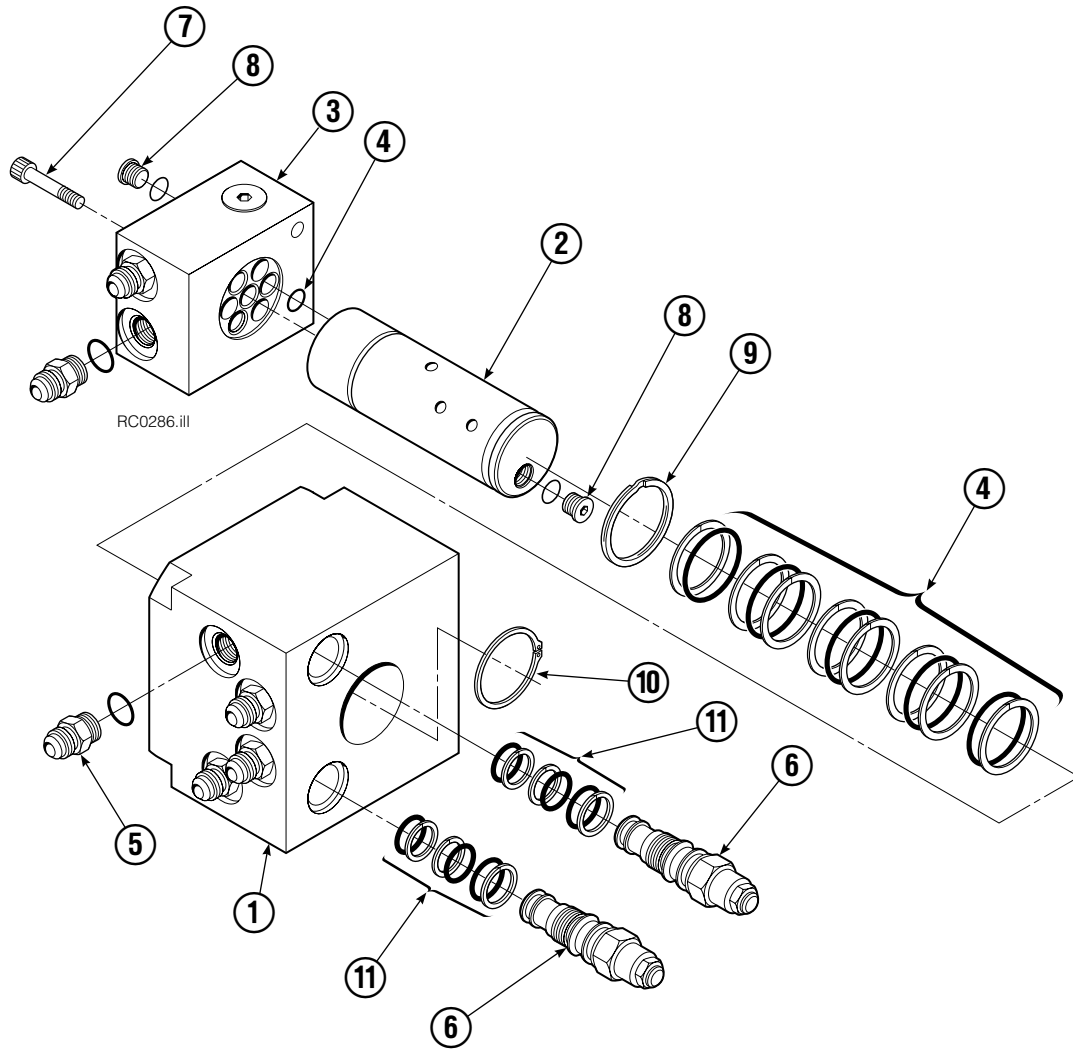


RC0285.ill

REF	QTY	PART NO.	DESCRIPTION
		201827	Hosing Group
1	2	206606	Angle
2	1	208798	Revolving Connection ▲
3	4	675085	Hose
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	675084	Hose
9	1	675051	Tube
10	2	675055	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

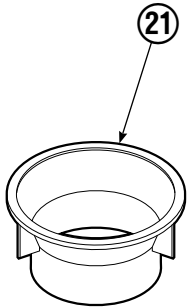
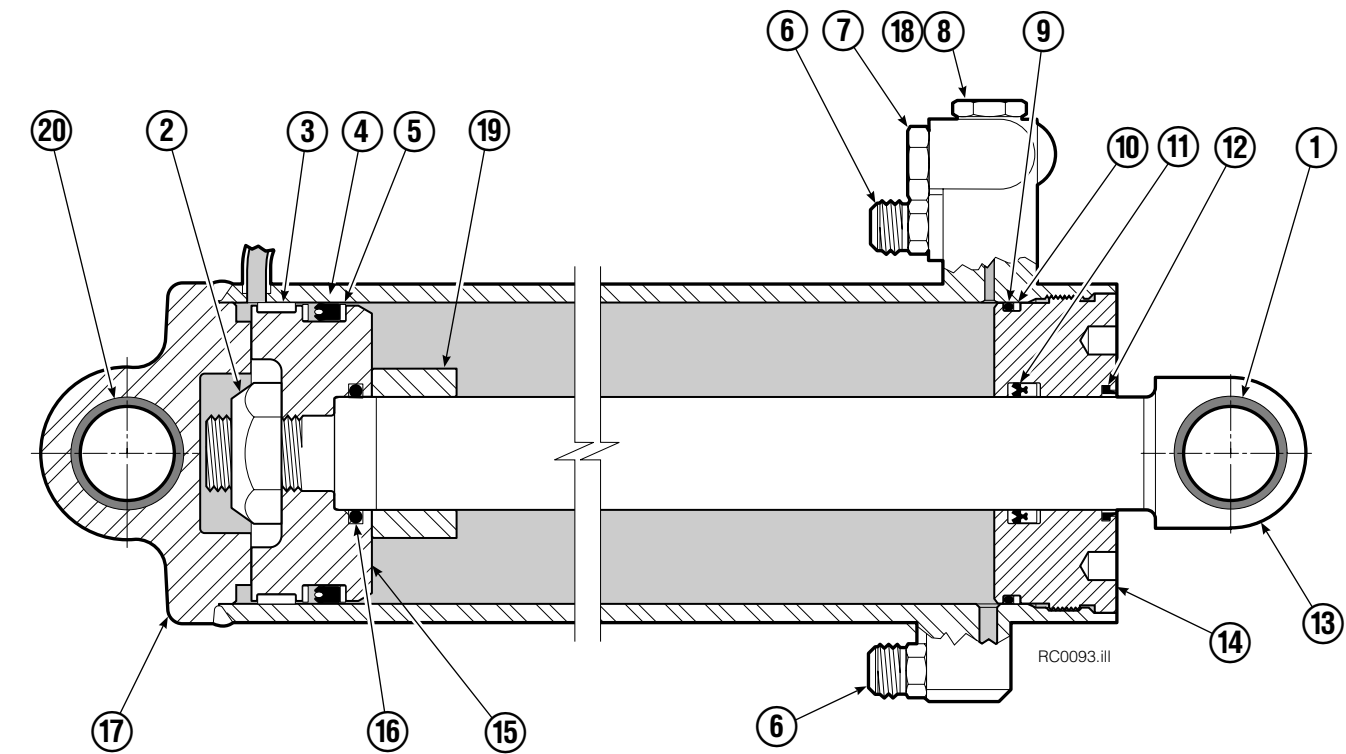
▲ See Revolving Connection page for parts breakdown

Swing Frame Revolving Connection



77F			
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

Short Arm Cylinder

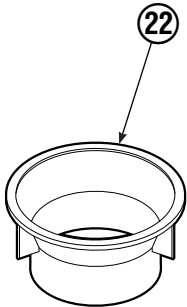
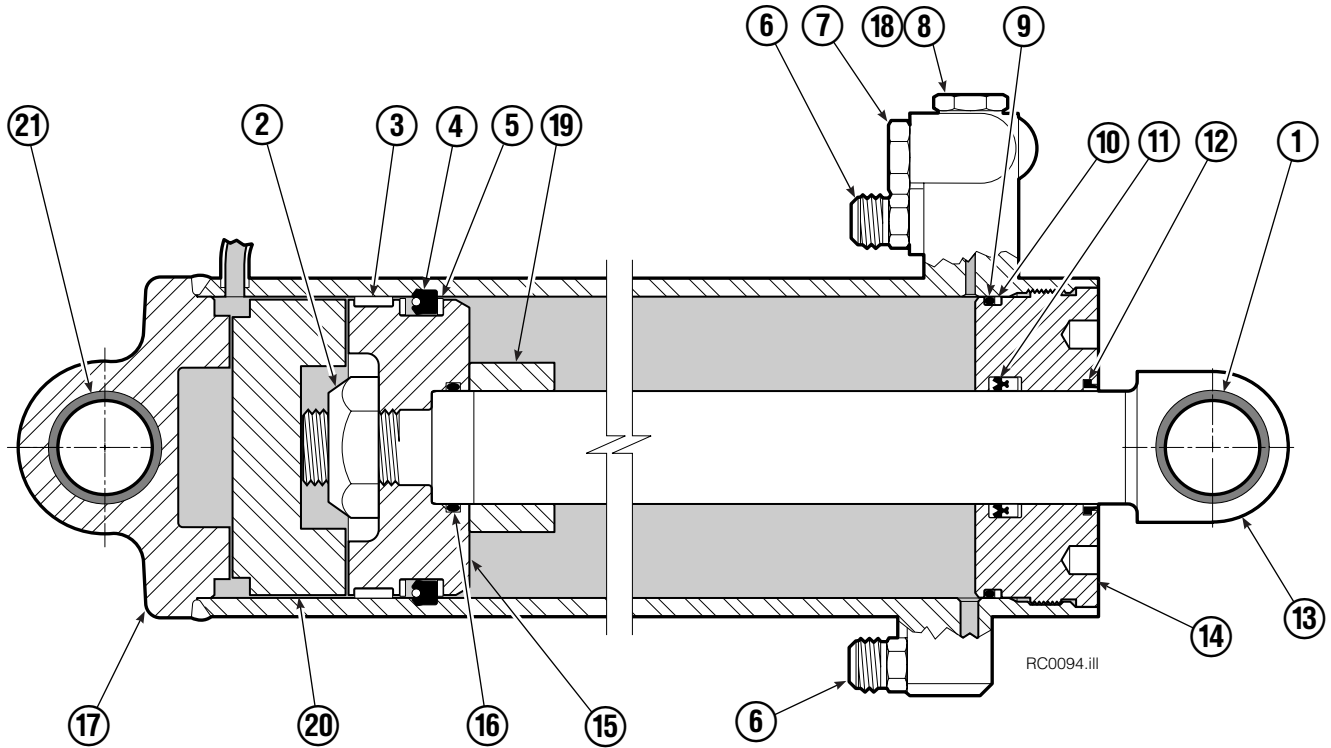


REF	QTY	PART NO.	DESCRIPTION
		216647	Cylinder Assembly
1	3	674843	Bearing
2	1	560997	Nut
3	1	674843	Bearing ♦
4	1	662462	Seal ♦
5	2	638295	Back-Up Ring ♦
6	2	604511	Fitting, 6-6
7	1	556852	Fitting, 4
8	1	557212	Check Valve
9	1	2801	O-Ring ♦
10	1	562731	Back-Up Ring ♦
11	1	554598	Seal ♦
12	1	628047	Wiper ♦
13	1	216646	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	555774	Spacer
20	1	669243	Seal Loader
		555725	Service Kit

♦ Included in Service Kit 555725.

Ref: S-5313, S-5314

Long Arm Cylinder

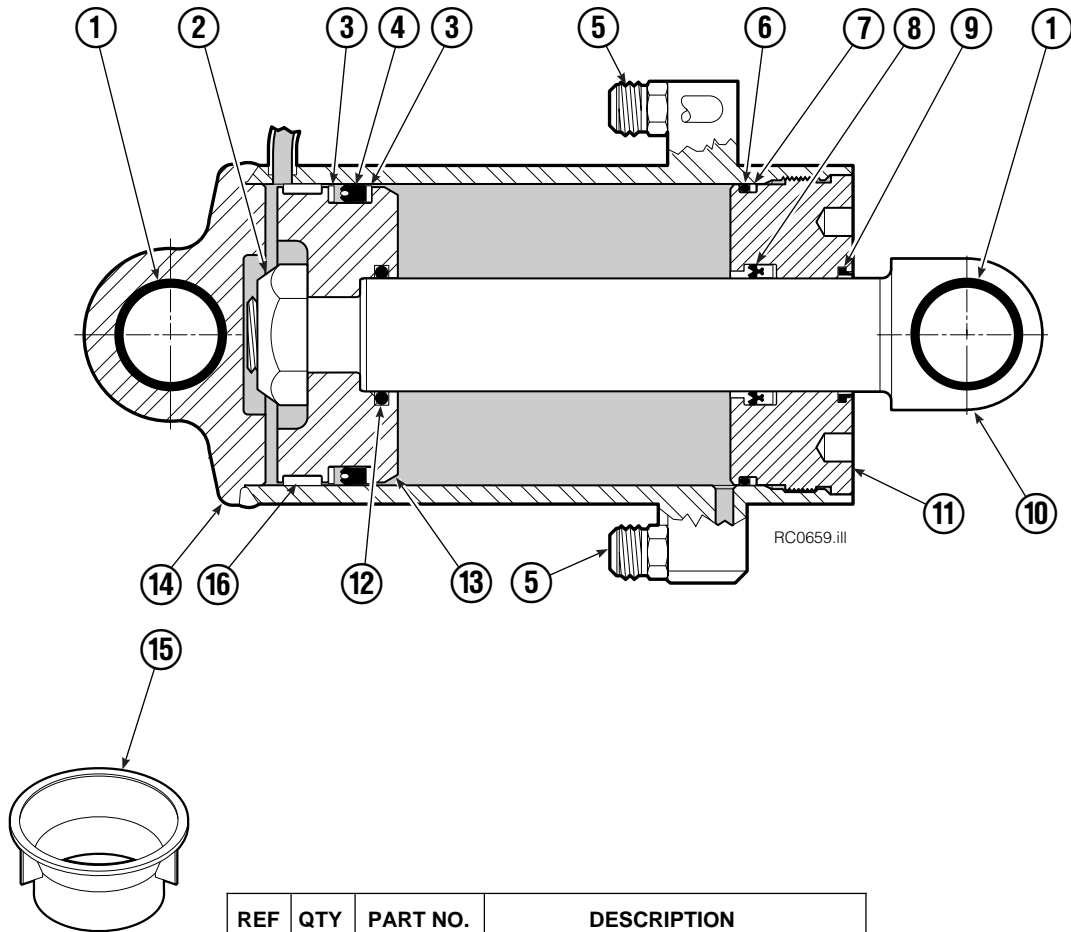


REF	QTY	PART NO.	DESCRIPTION
		557380	Cylinder Assembly
1	1	674843	Bearing
2	1	560997	Nut
◆3	1	660769	Bearing
◆4	1	662462	Seal
◆5	2	638295	Back-Up Ring
6	2	604511	Fitting, 6-6
7	1	556852	Fitting, 4
8	1	557212	Check Valve
◆9	1	2801	O-Ring
◆10	1	563977	Back-Up Ring
◆11	1	554598	Seal
◆12	1	564930	Wiper
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

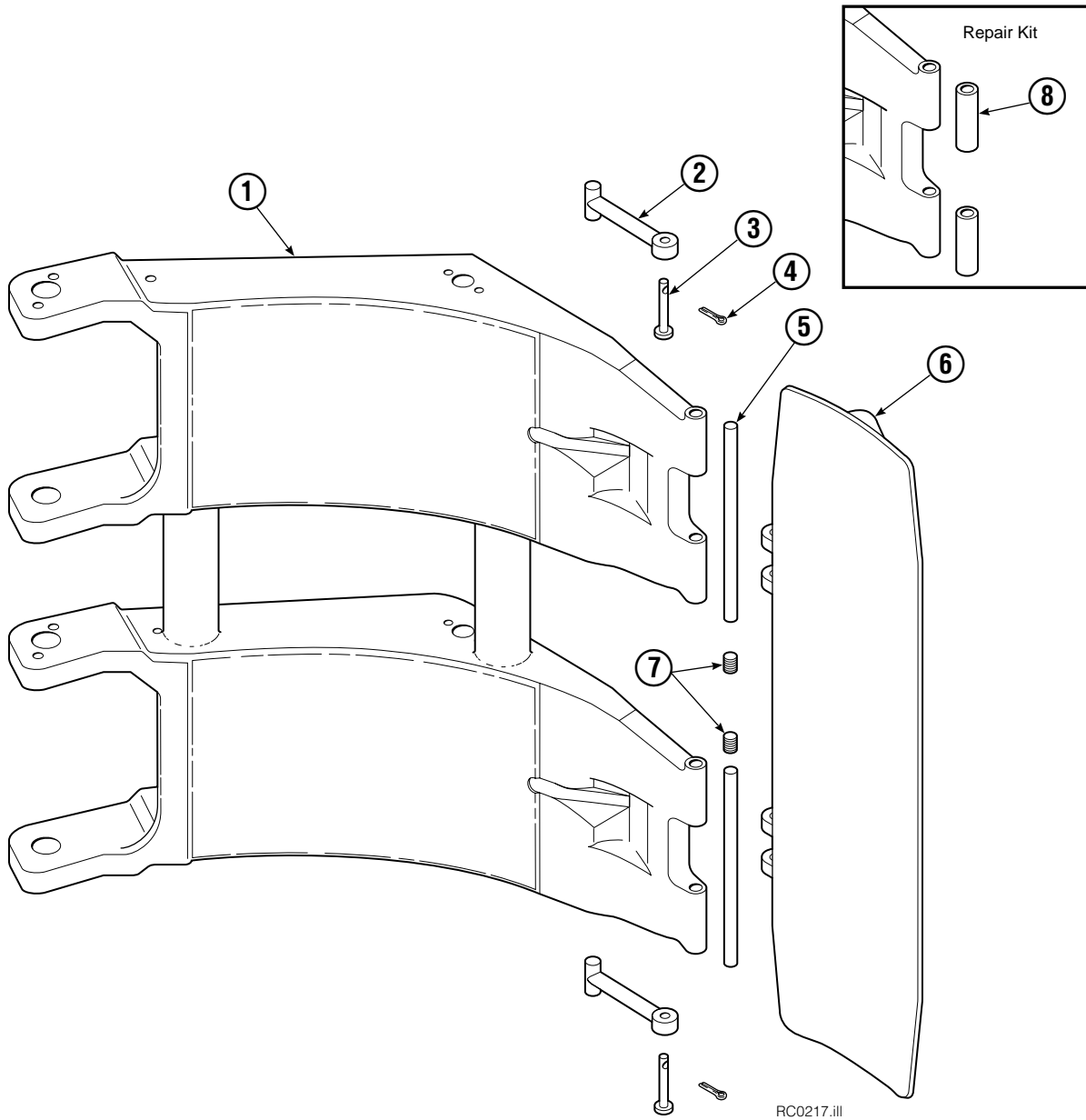
Swing Cylinder



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.

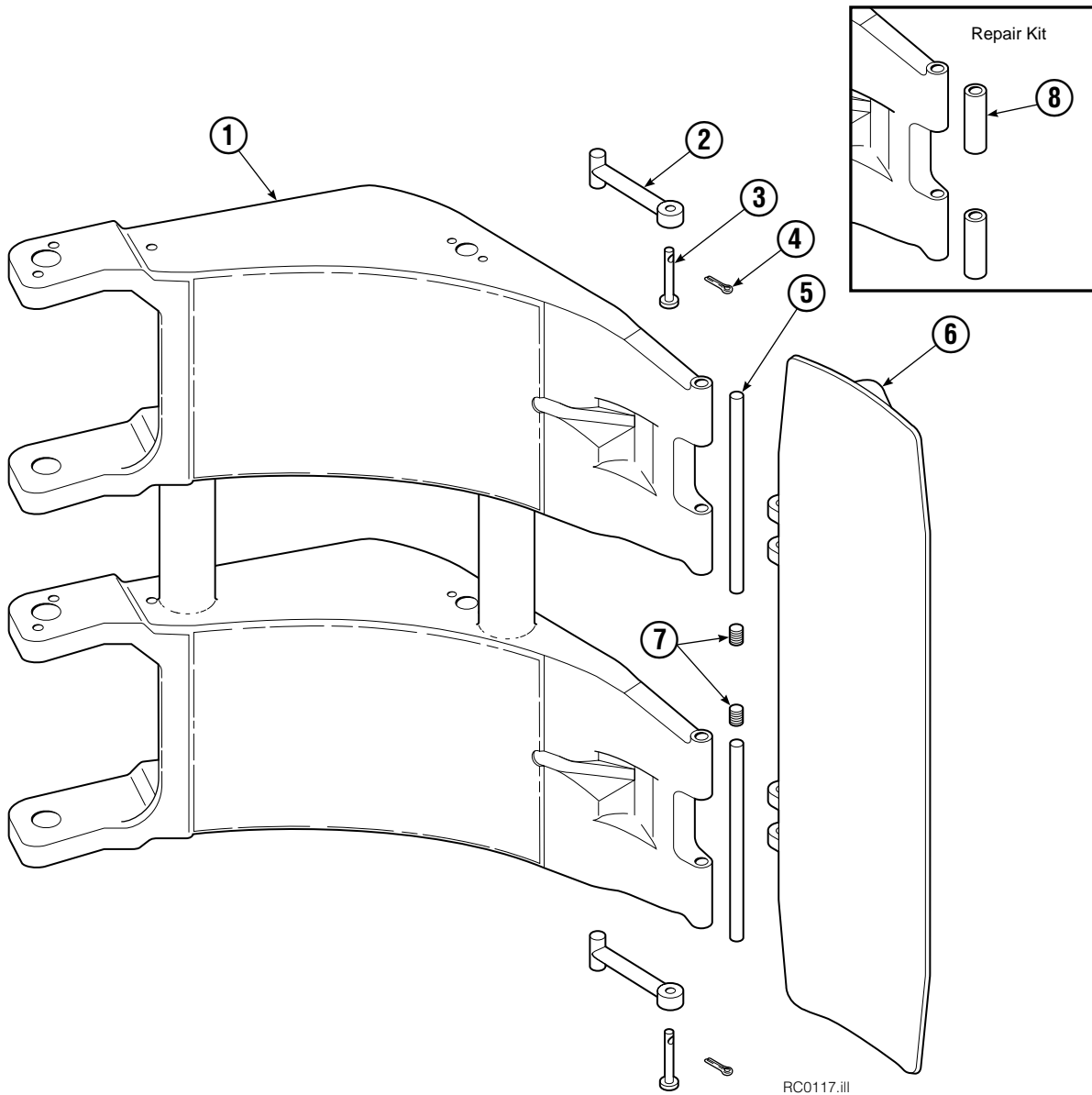
Short Arm



RC0217.ill

77F			
REF	QTY	PART NO.	DESCRIPTION
		678543	Short Arm Assembly
		674948	Contact Pad Group – 2-7
1	1	678544	Short Arm
2	2	674994	Link
3	2	682978	Clevis Pin
4	2	6525	Cotter Pin
5	2	674993	Pin
6	1	674962	Contact Pad
7	2	689900	Plug
8	1	676810	Arm Tip Repair Kit

Long Arm



RC0117.ill

90F			
REF	QTY	PART NO.	DESCRIPTION
		680478	Arm Assembly
1	1	680485	Arm
2	2	674994	Link
3	2	682978	Clevis Pin
4	2	6525	Cotter Pin
5	2	674993	Pin
6	1	674962	Contact Pad
7	2	689900	Plug
8	1	676810	Arm Tip Repair Kit

Do you have questions you need answered right now? Call your nearest Cascade Parts Department. Visit us online at www.cascorp.com

Cascade Corporation
2501 Sheridan Avenue
Springfield, OH 45505
Tel: 888-CASCADE (227-2233)
FAX: 888-329-0234

Cascade Canada Inc.
5570 Timberlea Blvd.
Mississauga, Ontario
Canada L4W-4M6
Tel: 905-629-7777
FAX: 905-629-7785

Cascade GmbH
D-41199 Monchengladbach
Klosterhofweg 52
Germany
Tel: 49-216-668230
FAX: 49-216-6682323

Cascade Finland
Albert Petreliuksenkatu 3
01370 Vantaa
Finland
Tel: 358-9-836-1925
FAX: 358-9-836-1935

**Cascade N.V.
European Headquarters**
P.O. Box 3009
1300 El Almere
Damluisweg 56
1332 ED Almere
The Netherlands
Tel: 31-36-5492911
FAX: 31-36-5492964

**Cascade N.V.
Benelux Sales and Service**
P.O. Box 3009
1300 El Almere
Damluisweg 56
1332 ED Almere
The Netherlands
Tel: 31-36-5492950
FAX: 31-36-5492974

Cascade (UK) Ltd.
15, Orgreave Crescent
Dore House Industrial Estate
Handsworth
Sheffield S13 9NQ
England
Tel: 742-697524
FAX: 742-695121

Cascade Scandinavia AB
Box 124
Hammarvägen 10
567 23 Vaggeryd
Sweden
Tel: 42-0-393-36950
FAX: 46-0-393-36959

Cascade Norway
Østerliveien 37A
1153 Oslo
Norway
Tel: 47-22-743160
FAX: 47-22-743157

Cascade France S.A.R.L.
1D Rue De Charaintru
BP 18, 91360 Epinay-Sur-Orge
Morangis Cedex, France
Tel: 33-1- 64547500
FAX: 33-1-64547501

Cascade Hispania S.A.
Carrer 5 Sector C
Zona Franca Duanera
Poligono de la Zon Franca
08040 Barcelona, Spain
Office No. 256
Tel: 93-264-07-30
FAX: 93-264-07-31

Cascade Japan Ltd.
5-5-41,
Torikai Kami
Settsu, Osaka
Japan, 566
Tel: 81-726-53-3490
FAX: 81-726-53-3497

Cascade Korea
108B, Namdong Ind Complex
658-3 Gojan-Dong
Namdong-Gu
Inchon, 405-310 Korea
Tel: 82-32-821-2051
FAX: 82-32-821-2055

Cascade Australia
1445 Ipswich Road
Rocklea, QLD 4106
Australia
Tel: 1-800227-223
FAX: (07) 3373-7333

Cascade New Zealand
15 Ra Ora Drive
East Tamaki, Auckland
New Zealand
Tel: 9-273-9136
FAX: 9-273-9137

Cascade (Africa) Pty. Ltd.
P.O. Box 625, Isando 1600
60A Steel Road
Sparton, Kempton Park
South Africa
Tel: 27-11-975-9240
FAX: 27-11-394-1147

Cascade-Xiamen
No. 668 Yangguang Rd.
Xinyang Industrial Zone
Haicang, Xiamen City
Fujian Province
P.R. China 361026
Tel: 86-592-651-2500
FAX: 86-592-651-2571

**Cascade (Singapore)
Trading Co.**
Four Seasons Park
Autumn Block - Apt. 1802
12 Cuscaden Walk
Singapore
Tel: 65-834-1935
FAX: 65-834-1936

