



Parts Manual

Model 20H Roll Clamp

Catalog Number 20H-REP-B013-166

cascade®
corporation

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

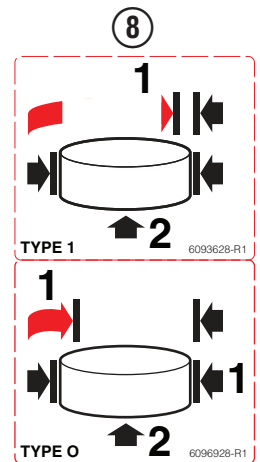
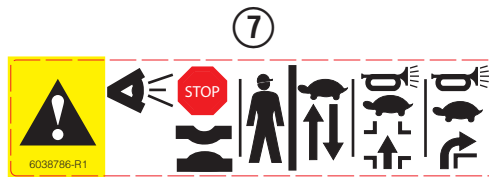
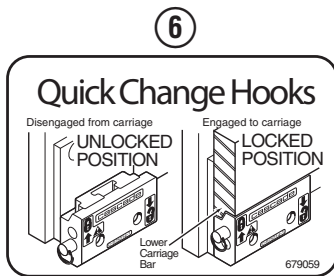
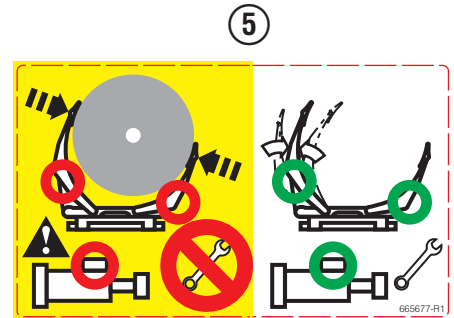
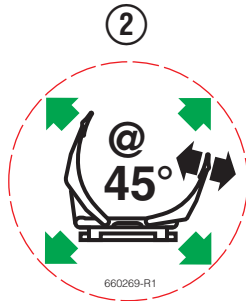
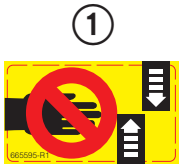
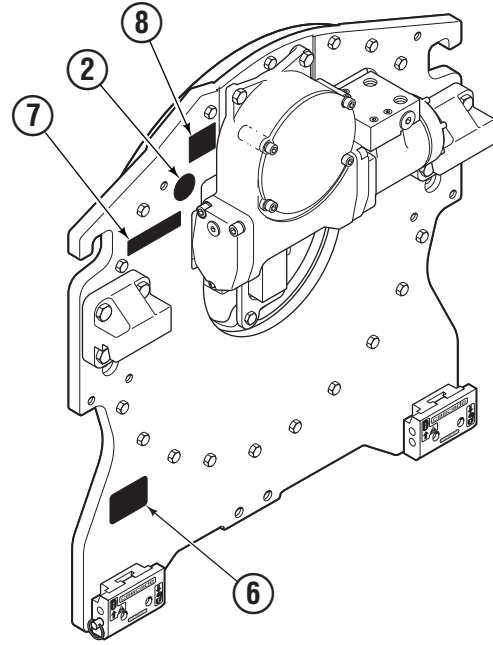
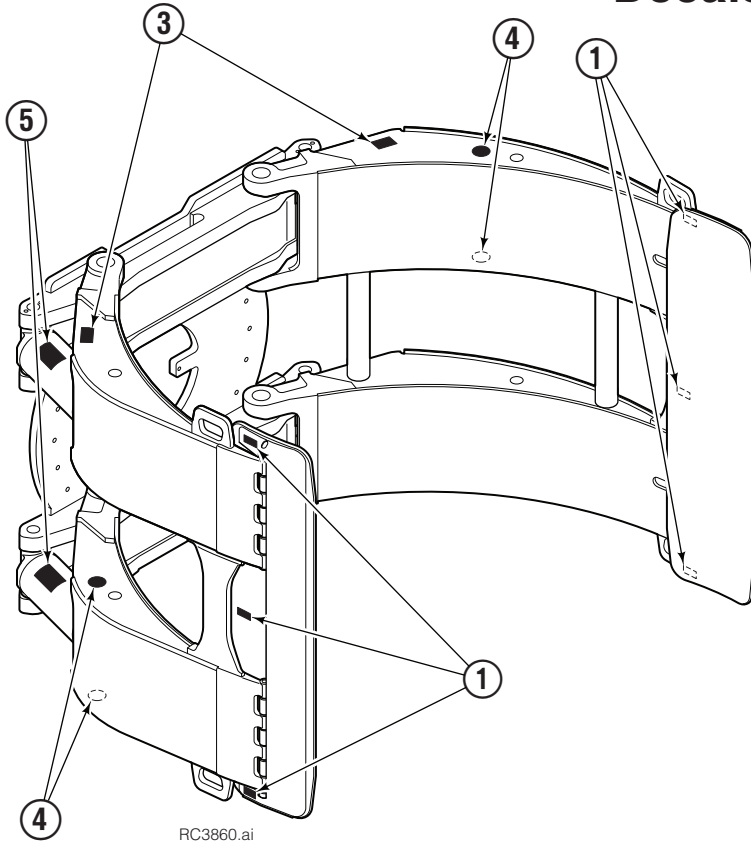
To Order Parts call: 888-227-2233, Fax: 888-329-0234

OR

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

Internet: www.cascorp.com

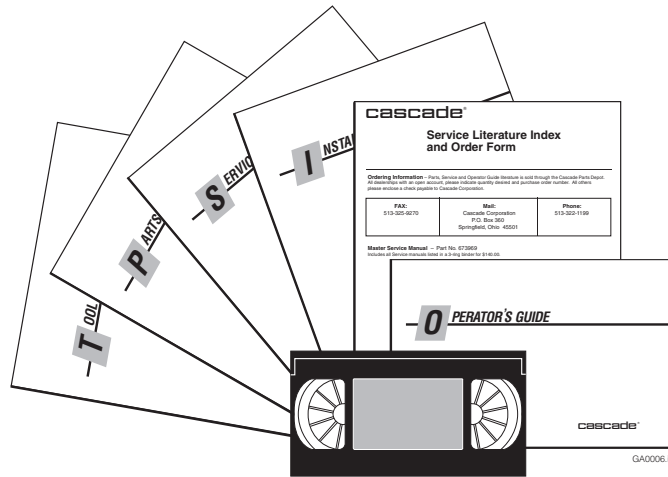
Decals



H-Series Roll Clamp				
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	
7	1	6038786	Visibility Warning Decal	
8	1	6093628	Split Arm Decal – Type 1 ♦	
	1	6096928	Split Arm Decal – Type 0 ♦	

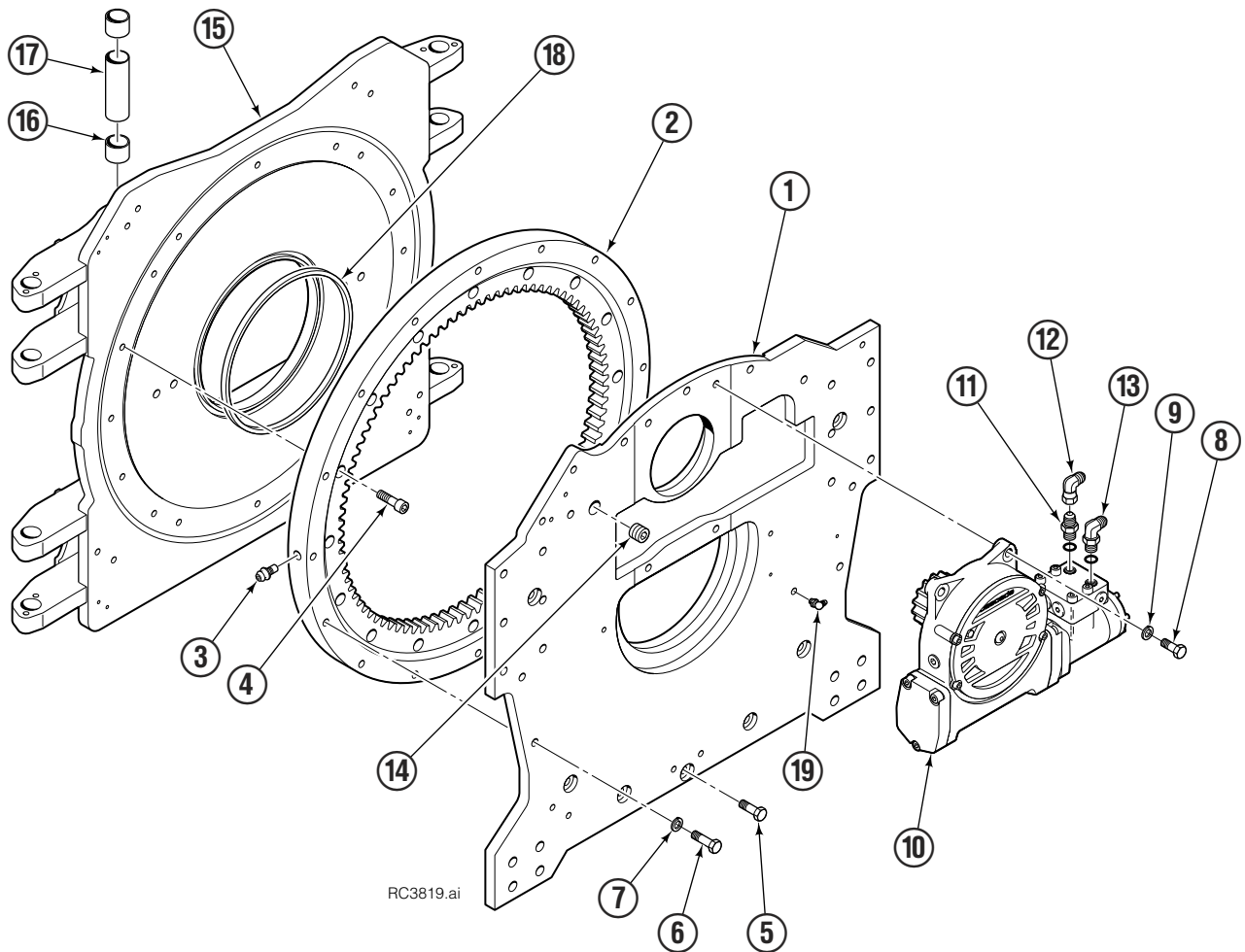
♦ See stamp on Revolving Connection for correct Type.

Publications



H-Series Roll Clamp	
PART NO.	DESCRIPTION
6078255	Service Manual
210135	Operators Guide – Fixed Frame
6077316	Installation Instructions – Fixed Frame
679929	Tool Catalog
673964	Literature Index Order Form

Rotator Group



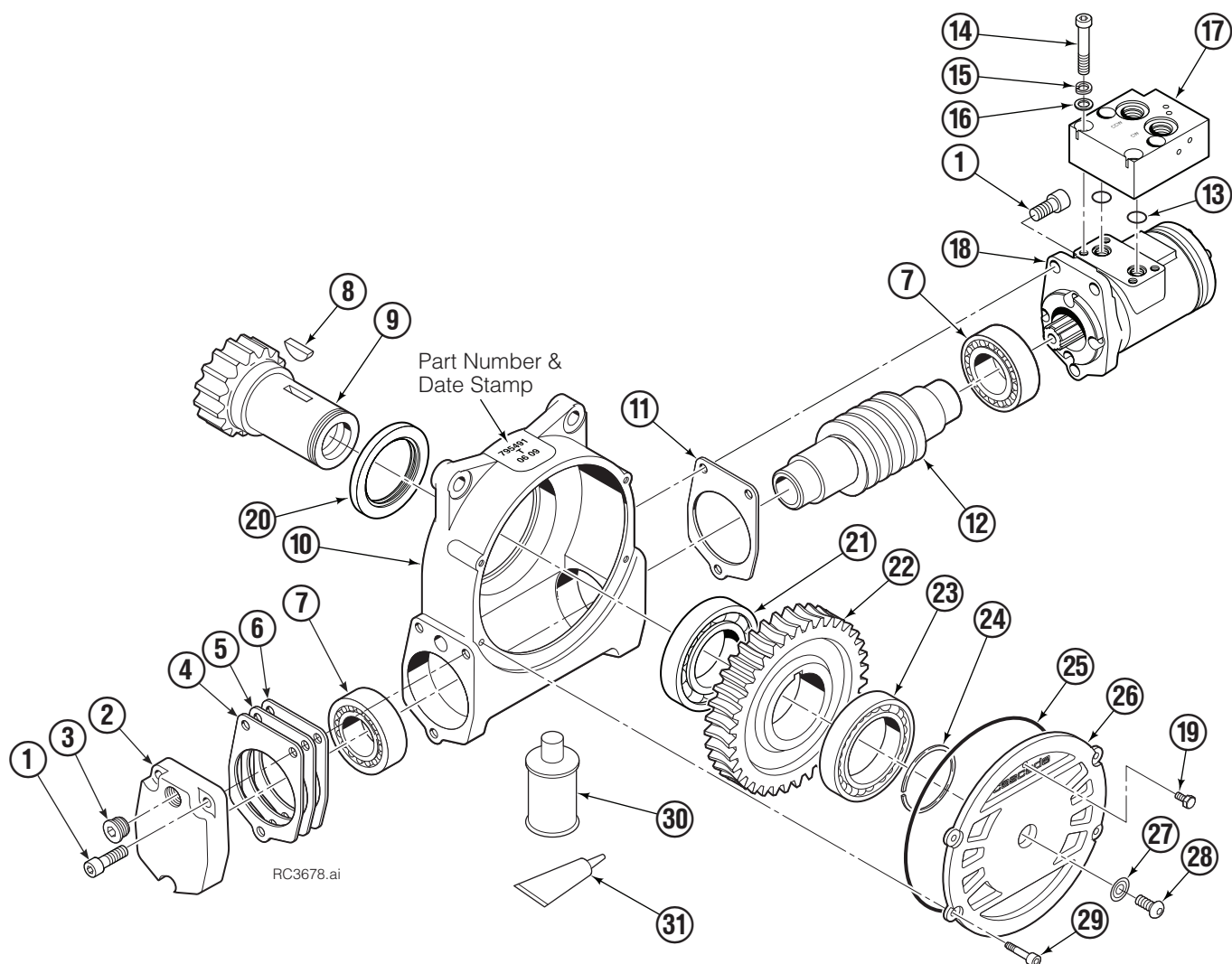
20H							
REF	QTY	PART NO.	DESCRIPTION	REF	QTY	PART NO.	DESCRIPTION
		6848182	Rotator Group	10	1	6255742	Drive Group ♦
		6806118	Frame Group ●	11	1	601377	Fitting, 8-8
1	1	6803140	Baseplate	12	1	605761	Fitting, 8-8
2	1	6044301	Bearing Assembly	13	1	601250	Fitting, 8-8
3	1	7401	Grease Fitting	14	1	6605	Plug
4	16	769572	Capscrew, M12 x 35	15	1	6806178	Frame
5	7	212305	Capscrew, M12 x 35	16	8	6800757	Bushing
6	9	214487	Capscrew, M12 x 40	17	4	6803833	Spacer
7	13	681473	Lockwasher, M12	18	1	670931	Seal
8	4	763021	Capscrew, M12 x 30	19	1	7406	Grease Fitting
9	4	681473	Lockwasher, M12				

● Includes items 15-17.

♦ See Drive Group page for parts breakdown.

Reference: Fastener Kit 6803944, Fitting Group 212367.

Drive Group



REF	QTY	PART NO.	DESCRIPTION	REF	QTY	PART NO.	DESCRIPTION
		6255742	Drive Group with 2.2 c.i. Motor	18	1	6097946	Drive Motor – 2.2 c.i. ■
1	6	769570	Capscrew, M12 x 25	19	1	644010	Relief Fitting
2	1	676855	Cover	20	1	3014870	Seal
3	1	604510	Fitting, 6	21	1	6033892	Bearing ★
4	●	670574	Shim – .010" (brown)	22	1	675609	Worm Gear
5	●	671757	Shim – .015" (pink)	23	1	670581	Bearing
6	●	671758	Shim – .020" (yellow)	24	1	7214	Snap Ring
7	2	670579	Bearing	25	1	643423	O-Ring
8	1	670582	Key	26	1	775552	Cover
9	1	670506	Pinion	27	1	783609	Seal
10	1	775551	Housing	28	1	783608	Capscrew, M10 x 16
11	1	686465	Gasket	29	4	200882	Capscrew, M8 x 20
12	1	675608	Worm	30	1	656300	Gear Box Lube – 48 oz.
13	2	2705	O-Ring	31	1	668184	Sealant
14	4	768798	Capscrew, M8 x 40			670578	Shim Service Kit
15	4	787384	Lockwasher, M8			675637	Bearing Service Kit
16	4	221494	Washer, M8			675638	Bearing Service Kit
17	1	6807931	Check Valve ◆				

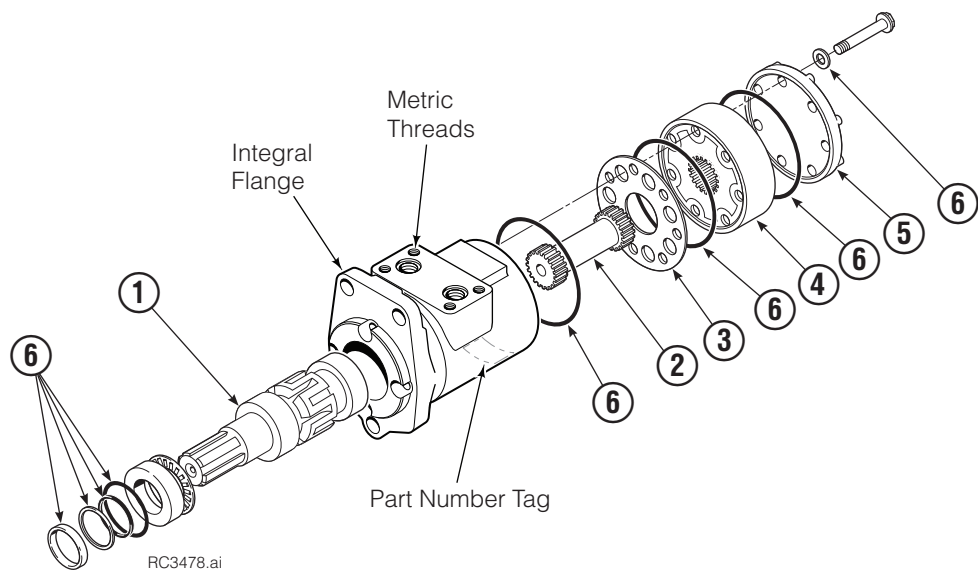
● Quantity as required.

◆ See Valve page for parts breakdown.

■ See Drive Motor page for parts breakdown.

★ For service replacement use Bearing 670580.

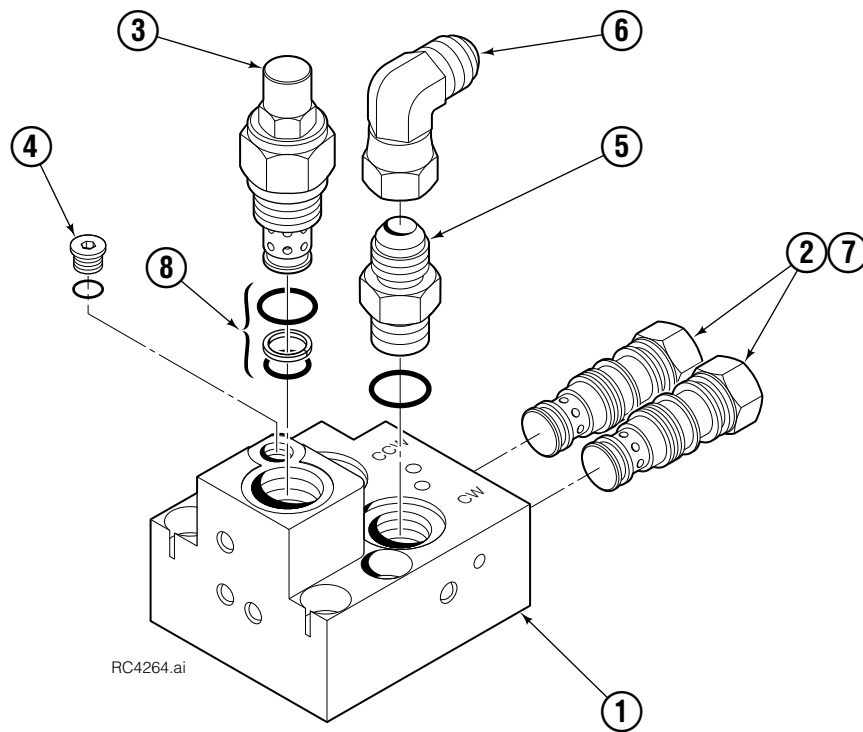
Drive Motor



REF	QTY	PART NO.	DESCRIPTION
		6097946	Drive Motor – 2.2 c.i.
1	1	675478	Shaft
2	1	675477	Drive
3	1	675479	Spacer Plate
4	1	685074	Gerotor Set
5	1	675482	End Cap
6	1	206405	Service Kit ■

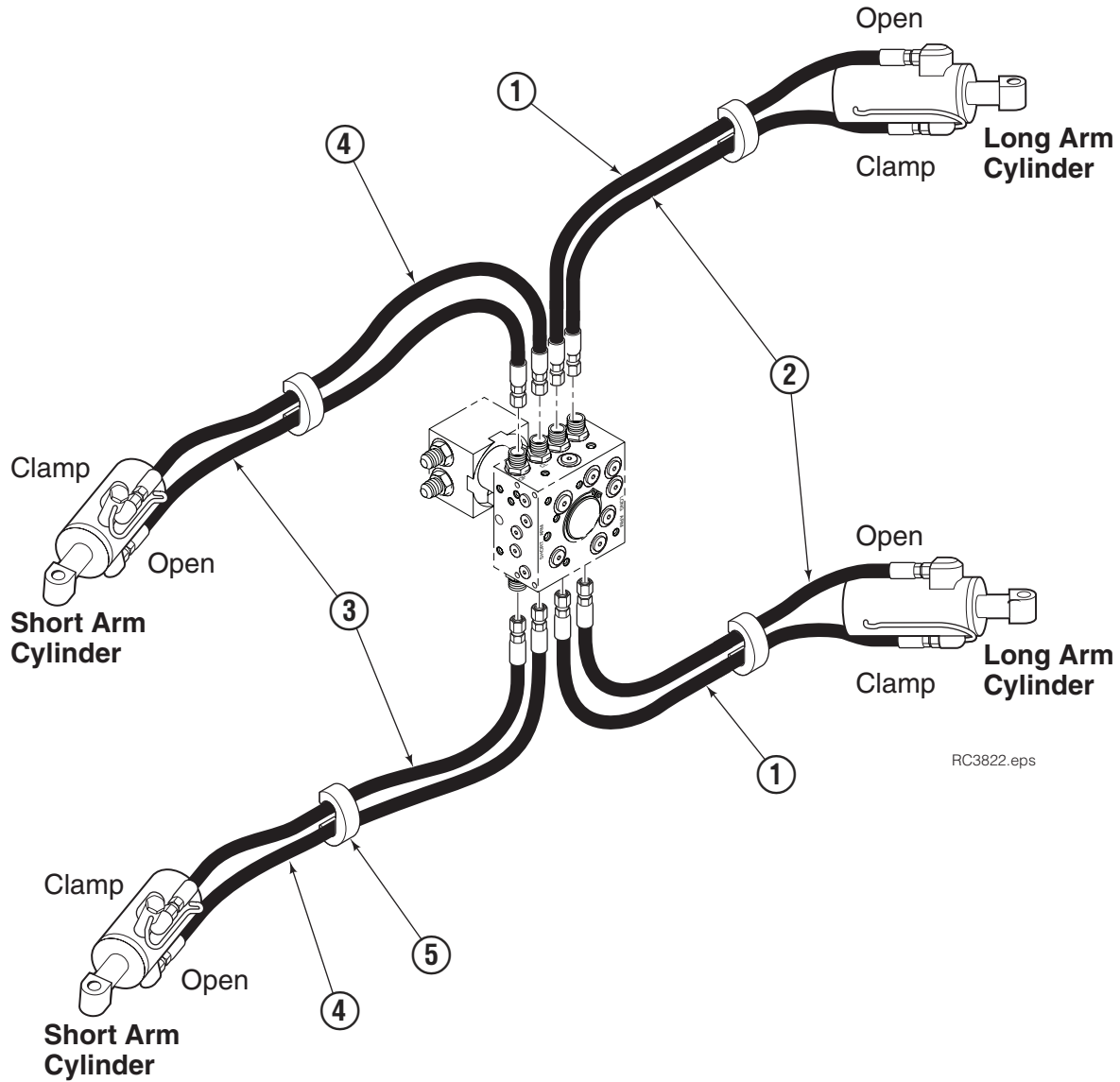
■ Compatible with water glycol based hydraulic fluids.
Cascade provides service replacement parts for the listed parts only. Due to cost, if other parts need replacement, the complete drive motor should be replaced.

Check Valve



REF	QTY	PART NO.	DESCRIPTION
		6807931	Check Valve Assembly
1	1	6807932	Valve Body
2	2	6038929	Check Valve Cartridge – PO
3	1	214405	Relief Valve Cartridge
4	1	663694	Plug, 3
5	1	601377	Fitting, 8-8
6	1	605761	Fitting, 8-8
7	2	667516	Seal Kit
8	1	682170	Seal Kit

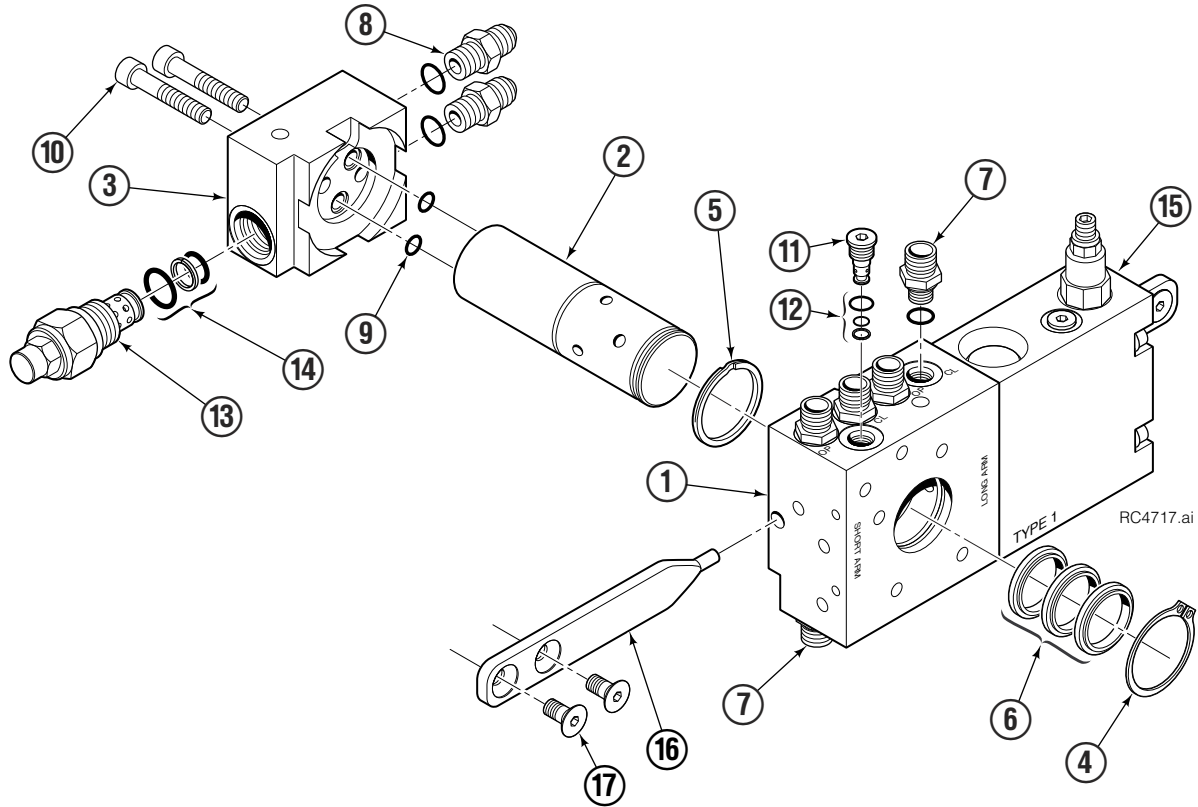
Hosing Group Positioned Short Arm



REF	QTY	PART NO.	DESCRIPTION
		6806794	Hose Group r4
1	2	6806831	Hose
2	2	6809796	Hose
3	2	6804517	Hose
4	2	6804517	Hose
5	4	673416	Segment

Reference: SK-29215.

Revolving Connection Group



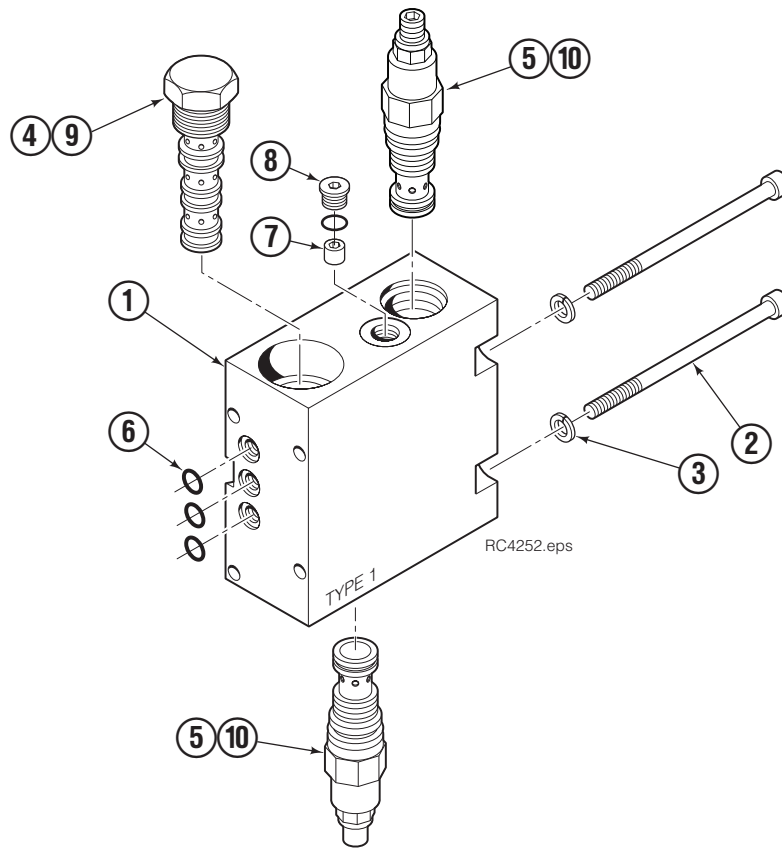
REF	QTY	PART NO.	DESCRIPTION
		6823118-r0	Revolving Connection Group
	1	6823119-r1	Revolving Connection Assembly ●
1	1	6843585	Valve Body
2	1	6823117	Shaft
3	1	6843598	End Block
4	1	3138	◆ Retaining Ring
5	1	7341	◆ Retaining Ring
6	3	214649	◆ Shaft Seal
7	8	777913	Fitting, 4-4
8	2	604511	Fitting, 6-6
9	2	684587	◆ O-Ring
10	2	766123	◆ Capscrew, M8 x 50
11	1	220869	Check Valve
12	1	6025595	Seal Kit
13	1	214405	Crossover Relief Cartridge
14	1	682170	Seal Kit
15	1	6823039	Valve ■
16	2	6037989	Support
17	4	6038809	Capscrew, M10 x 20
		6026296	Service Kit

● Includes items 1 – 15.

◆ Included in Service Kit 6844758

■ See Valve page for parts breakdown.

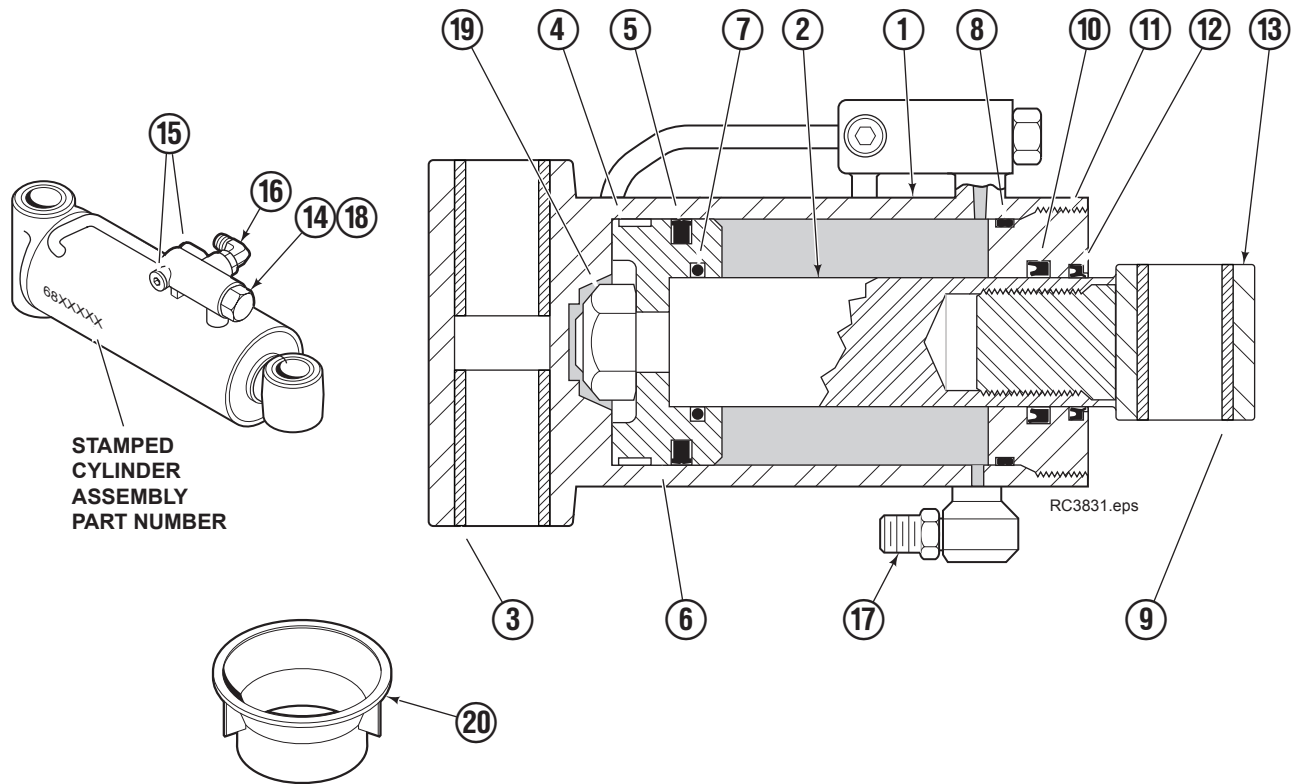
Valve Assembly



REF	QTY	PART NO.	DESCRIPTION
		6823039-r1	Valve Assembly
1	1	6823040	Valve Body ●
2	4	6405512	Capscrew, M6 x 100
3	4	206323	Lockwasher, M6
4	1	6024293	Flow Divider Cartridge
5	2	6043425	Relief Valve Cartridge
6	3	684587	O-Ring
7	1	6043250	Orifice, .015
8	1	663694	Plug, 3
9	1	6068554	Seal kit
10	1	669597	Seal kit

● Includes items 6-8.

Short Arm Cylinder



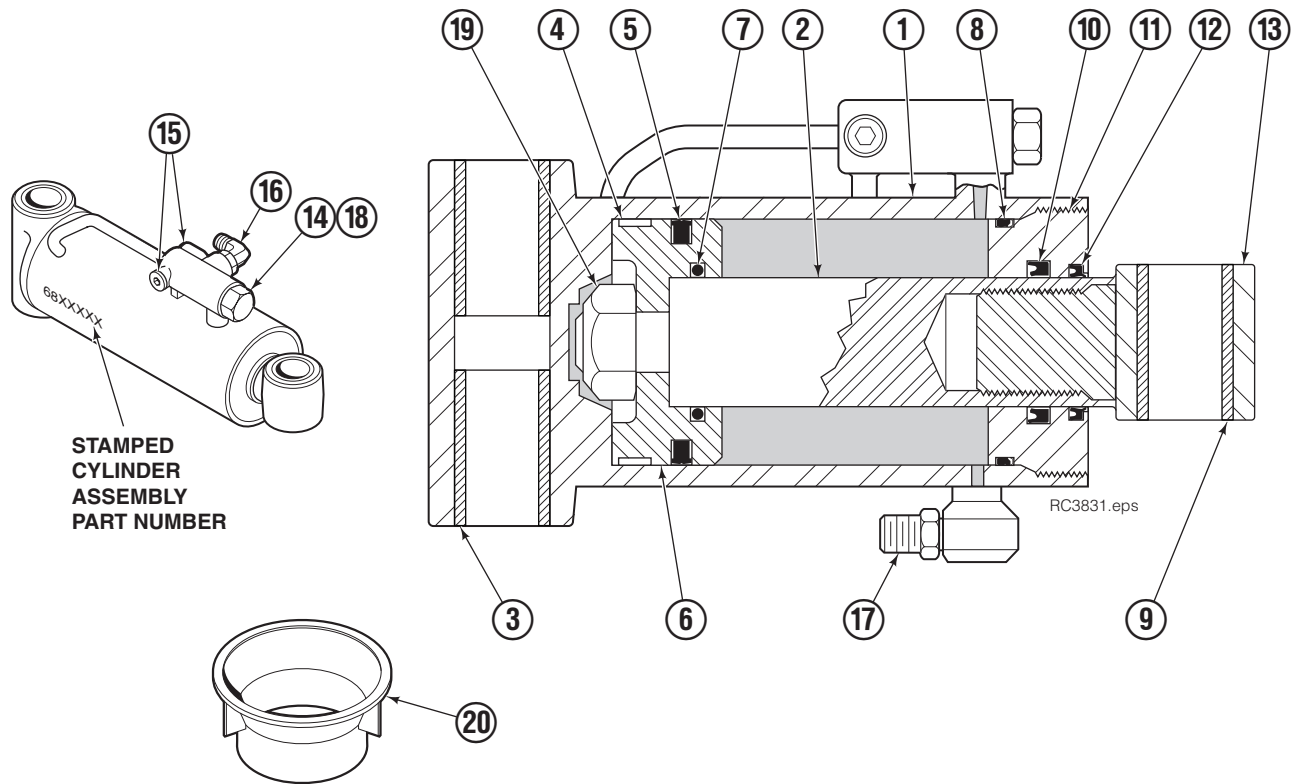
REF	QTY	PART NO.	DESCRIPTION	REF	QTY	PART NO.	DESCRIPTION
		6804140	Cylinder Assembly R9	11	1	6800403	Retainer
1	1	6804141	Shell	12	1	421356	◆ Wiper
2	1	6804145	Rod Assembly	13	1	6800463	Rod End ●
3	2	6802703	Bushing	14	1	6038929	Check Valve – PO
4	1	6084094	◆ Wear Ring	15	2	609234	Fitting, 4
5	1	6084070	◆ Seal	16	1	6803297	Fitting, SAE 6 – 14 mm L-Series
6	1	6800393	Piston	17	1	777915	Fitting, SAE 6 – 14 mm L-Series
7	1	6084135	◆ O-Ring	18	1	667516	Check Valve Service Kit
8	1	6808315	◆ Dual Seal	19	1	561012	Nut
9	1	6802703	Bushing ●	20	1	6064310	◆ Seal Loader
10	1	221866	◆ Seal			6804211	Service Kit

◆ Included in Service Kit 6804211.

● Included in Rod Assembly.

Reference: S-24108, S-24193.

Long Arm Cylinder



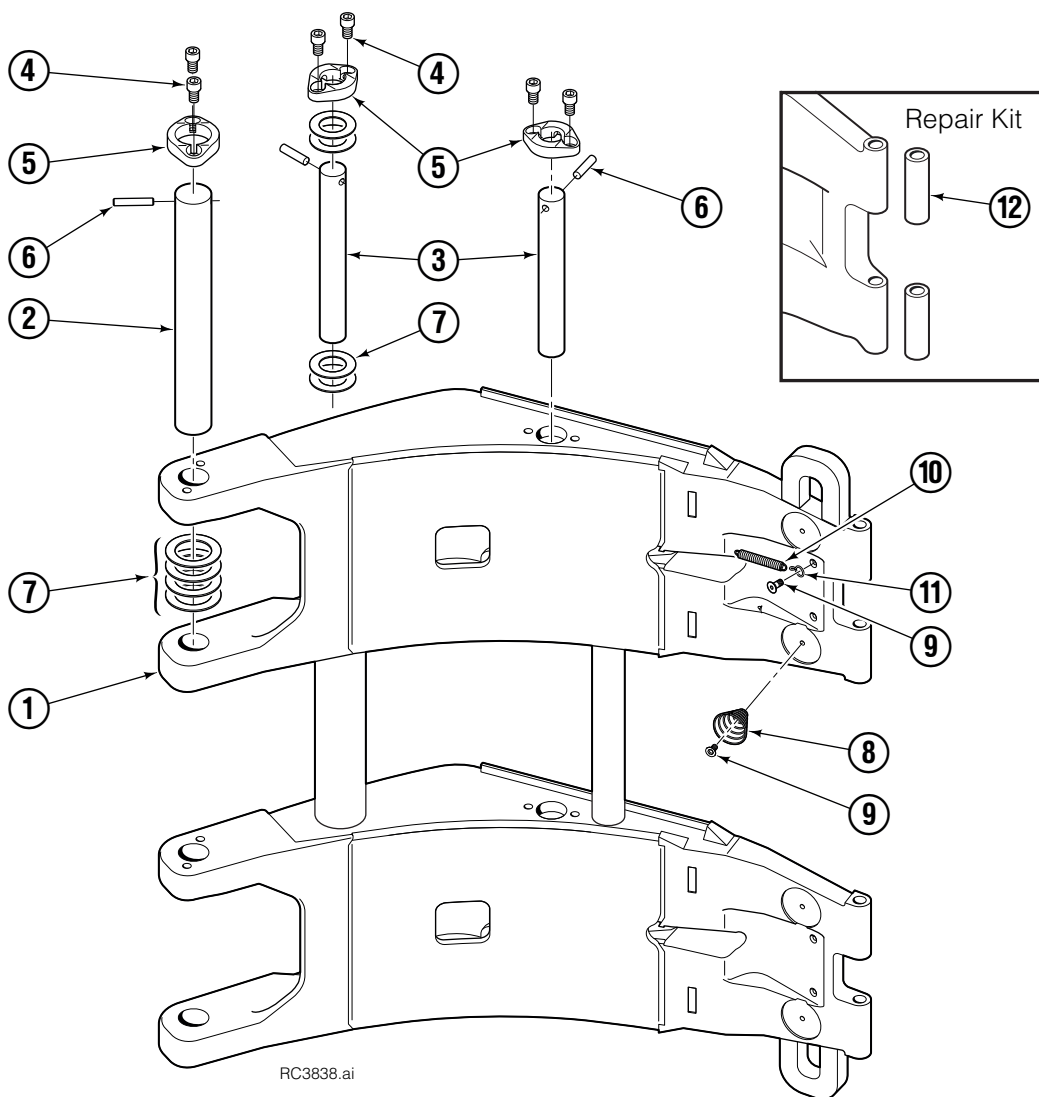
18H/20H							
REF	QTY	PART NO.	DESCRIPTION	REF	QTY	PART NO.	DESCRIPTION
		6806468	Cylinder Assembly (R6)	11	1	6800403	Retainer
1	1	6806473	Shell	12	1	421356	◆ Wiper
2	1	6806476	Rod Assembly	13	1	6800463	Rod End ★
3	2	6802703	Bushing	14	1	6038929	Check Valve – PO
4	1	6084094	◆ Wear Ring	15	2	609234	Fitting, 4
5	1	6084070	◆ Seal	16	1	6803297	Fitting, SAE 6 – 14 mm L-Series
6	1	6800393	Piston	17	1	777915	Fitting, SAE 6 – 14 mm L-Series
7	1	6084135	◆ O-Ring	18	1	667516	Check Valve Service Kit
8	1	6808315	◆ Dual Seal	19	1	561012	Nut
9	1	6802703	Bushing ★	20	1	6064310	◆ Seal Loader
10	1	221866	◆ Seal			6804211	Service Kit

◆ Included in Service Kit 6804211.

★ Included in Rod Assembly.

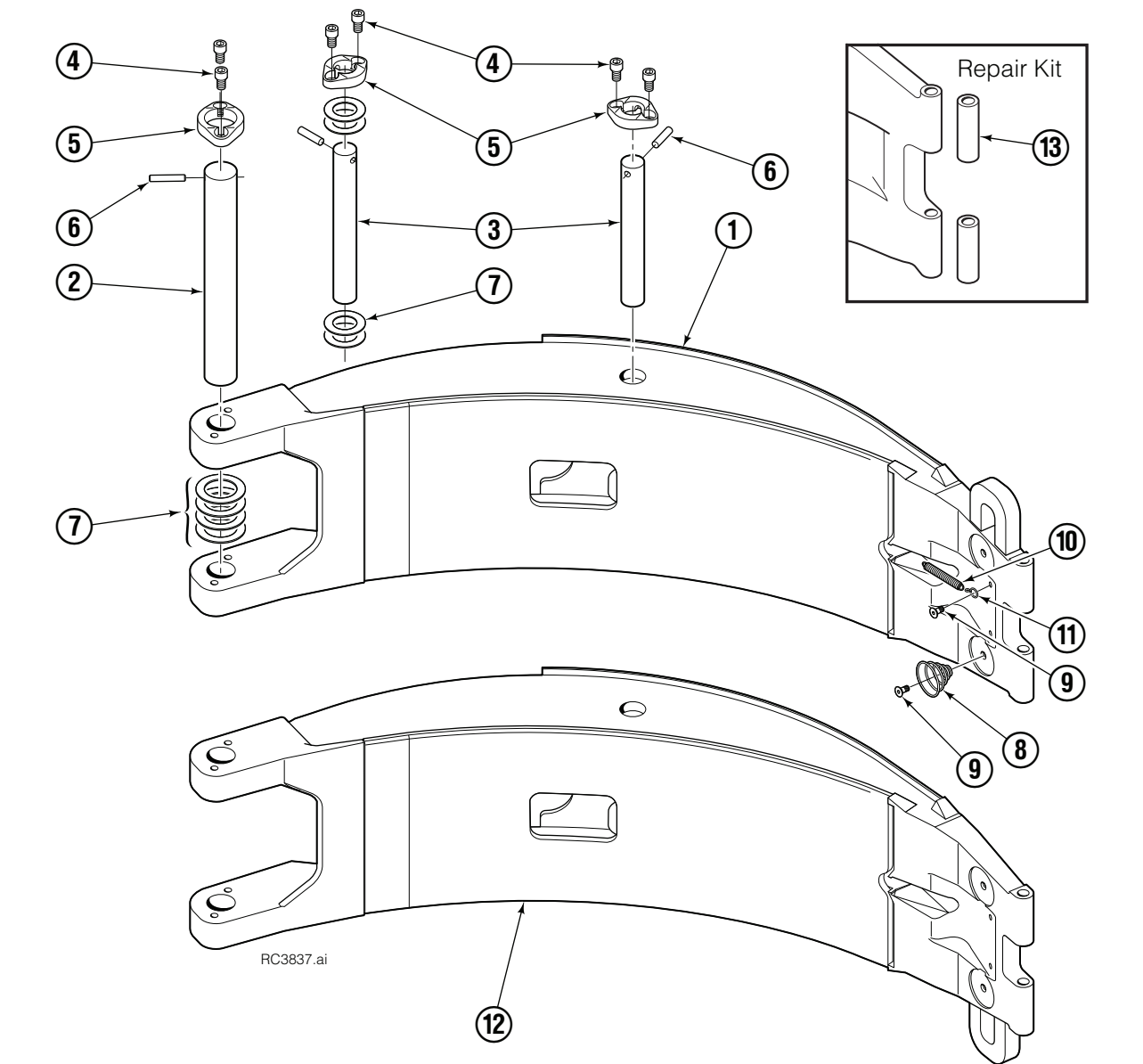
Reference: S-24108, S-24193.

Short Arm Group



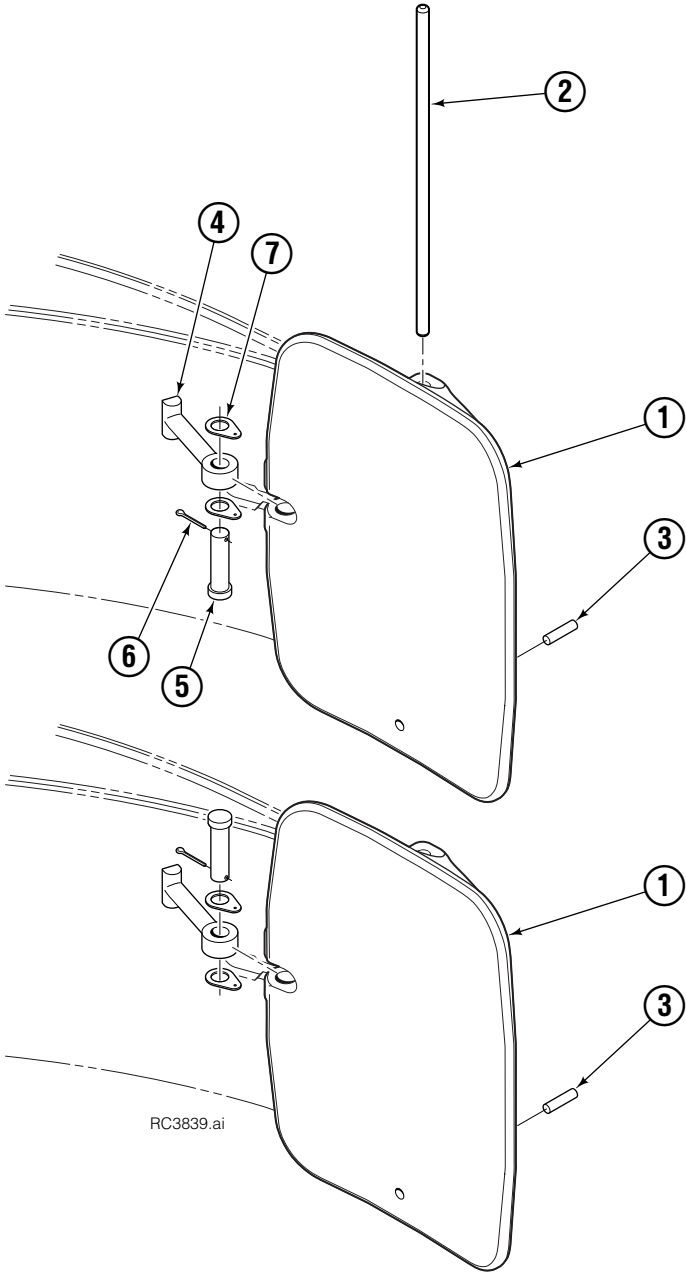
REF	QTY	PART NO.	DESCRIPTION	REF	QTY	PART NO.	DESCRIPTION
		6806133	Short Arm Group r2	7	12	674837	Shim
1	1	6806167	Short Arm	8	4	6081766	Pad Spring
2	2	6800792	Pin	9	8	766496	Capscrew
3	4	6800793	Pin	10	4	6802375	Spring
4	12	6089559	Capscrew	11	4	6802349	Spring Anchor
5	6	6803802	Retainer	12	1	6047539	Tip Repair Kit
6	6	6803315	Dowel Pin				

Long Arm Group



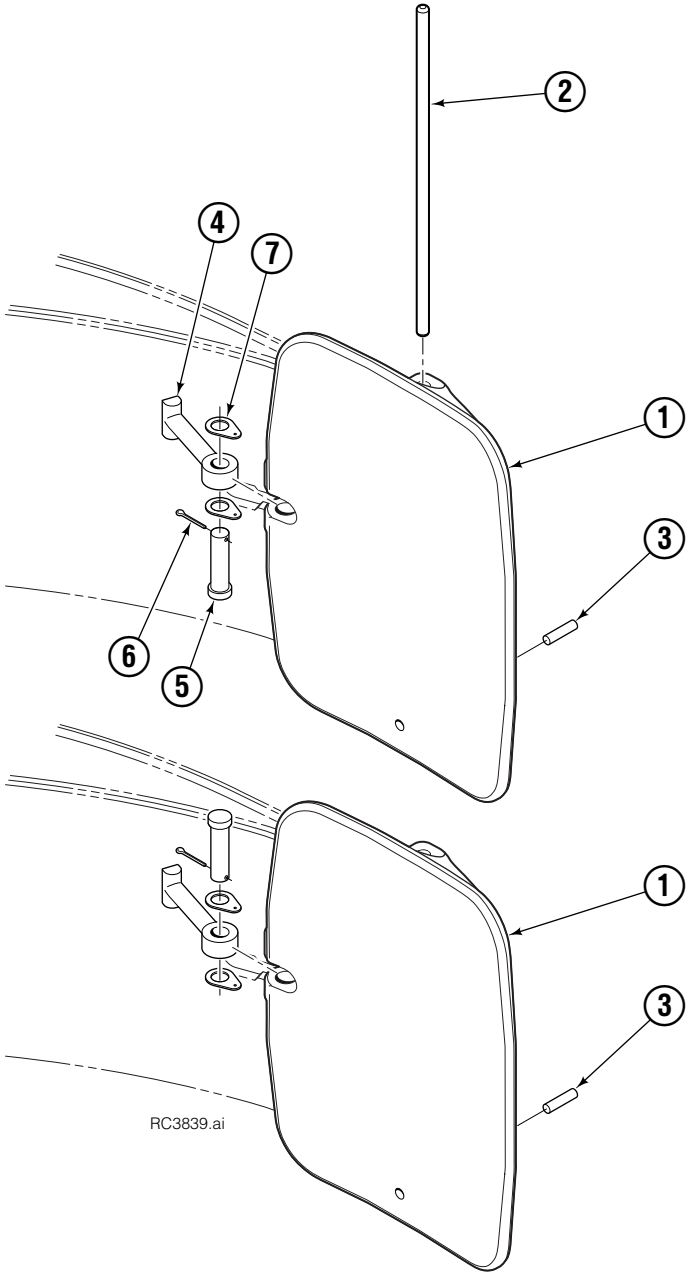
REF	QTY	PART NO.	DESCRIPTION	REF	QTY	PART NO.	DESCRIPTION
		6806690	Long Arm Group r2	7	12	674837	Shim
1	1	6806689	Long Arm, RH	8	4	6081766	Pad Spring
2	2	6800792	Pin	9	8	766496	Capscrew
3	4	6800793	Pin	10	4	6802375	Spring
4	12	6089559	Capscrew	11	4	6802349	Spring Anchor
5	6	6803802	Retainer	12	1	6806687	Long Arm, LH
6	6	6803315	Dowel Pin	13	1	6047539	Tip Repair Kit

Contact Pad Group - Short Arm



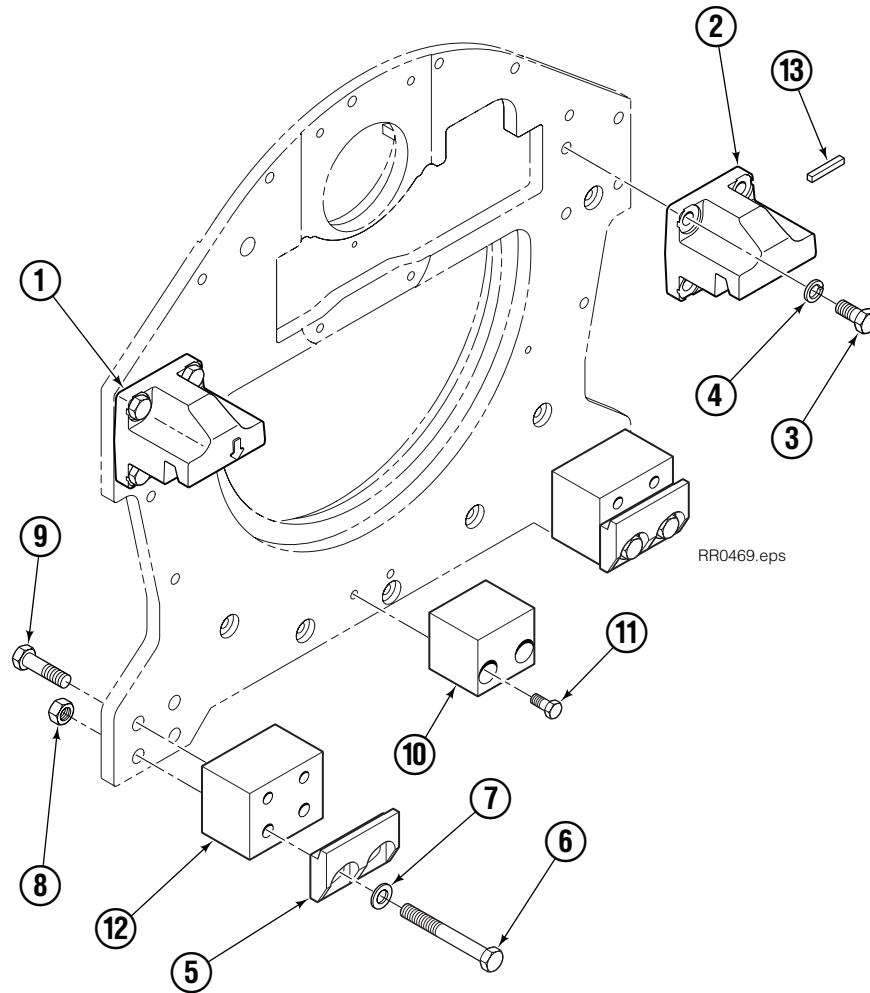
REF	QTY	PART NO.	DESCRIPTION
		6800248	Contact Pad Group
1	2	6800239	Contact Pad
2	2	674701	Pin
3	2	6061694	Drive Pin, .312 x 1.5
4	2	674700	Link
5	2	674265	Clevis Pin
6	2	6525	Cotter Pin
7	4	6802119	Spring Anchor

Contact Pad Group - Long Arm



REF	QTY	PART NO.	DESCRIPTION
		6800190	Contact Pad Group
1	2	6800192	Contact Pad
2	2	674701	Pin
3	2	6061694	Drive Pin, .312 x 1.5
4	2	674700	Link
5	2	674265	Clevis Pin
6	2	6525	Cotter Pin
7	4	6802119	Spring Anchor

Bolt-On Mounting Group



Class III, 0°			
REF	QTY	PART NO.	DESCRIPTION
		6803732	Mounting Group (R3)
1	1	670527	Upper Hook – LH
2	1	670528	Upper Hook – RH
3	8	684295	Capscrew, M16 x 35
4	8	684586	Lockwasher, M16
5	2	675969	Lower Hook
6	4	768572	Capscrew, M16 x 130
7	4	217637	Washer, M16
8	4	781534	Nut, M16
9	4	689997	Capscrew, M16 x 60
10	1	6803882	Center Spacer
11	2	767810	Capscrew, M12 x 25
12	2	6803885	Spacer
13	1	669344	Stop Block Kit

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AMERICAS

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Parts Sales**

2501 Sheridan Ave.
Springfield, OH 45505
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Fax: 888-329-0234

Cascade Canada Inc.

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

Cascade do Brasil

Rua João Guerra, 134
Macuco, Santos - SP
Brasil 11015-130
Tel: 55-13-2105-8800
Fax: 55-13-2105-8899

EUROPE-AFRICA

**Cascade Italia S.R.L.
European Headquarters**

Via Dell'Artigianato 1
37050 Vago di Lavagno (VR)
Italy
Tel: 39-045-8989111
Fax: 39-045-8989160

Cascade (Africa) Pty. Ltd.

PO Box 625, Isando 1600
60A Steel Road
Sparton, Kempton Park
South Africa
Tel: 27-11-975-9240
Fax: 27-11-394-1147

ASIA-PACIFIC

Cascade Japan Ltd.

2-23, 2-Chome,
Kukuchi Nishimachi
Amagasaki, Hyogo
Japan, 661-0978
Tel: 81-6-6420-9771
Fax: 81-6-6420-9777

Cascade Korea

121B 9L Namdong Ind.
Complex, 691-8 Gojan-Dong
Namdong-Ku
Inchon, Korea
Tel: +82-32-821-2051
Fax: +82-32-821-2055

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 India Material
Handling Private Limited**

No 34, Global Trade Centre
1/1 Rambaugh Colony
Lal Bahadur Shastri Road,
Navi Peth, Pune 411 030
(Maharashtra) India
Phone: +91 020 2432 5490
Fax: +91 020 2433 0881

Cascade Australia Pty. Ltd.

1445 Ipswich Road
Rocklea, QLD 4107
Australia
Tel: 1-800-227-223
Fax: +61 7 3373-7333

Cascade New Zealand

15 Ra Ora Drive
East Tamaki, Auckland
New Zealand
Tel: +64-9-273-9136
Fax: +64-9-273-9137

**Sunstream Industries
Pte. Ltd.**

18 Tuas South Street 5
Singapore 637796
Tel: +65-6795-7555
Fax: +65-6863-1368

