



# Parts Manual

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Model 100F Roll Clamp

Serial Number 100F-RCS-110

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**cascade<sup>®</sup>**  
**corporation**

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

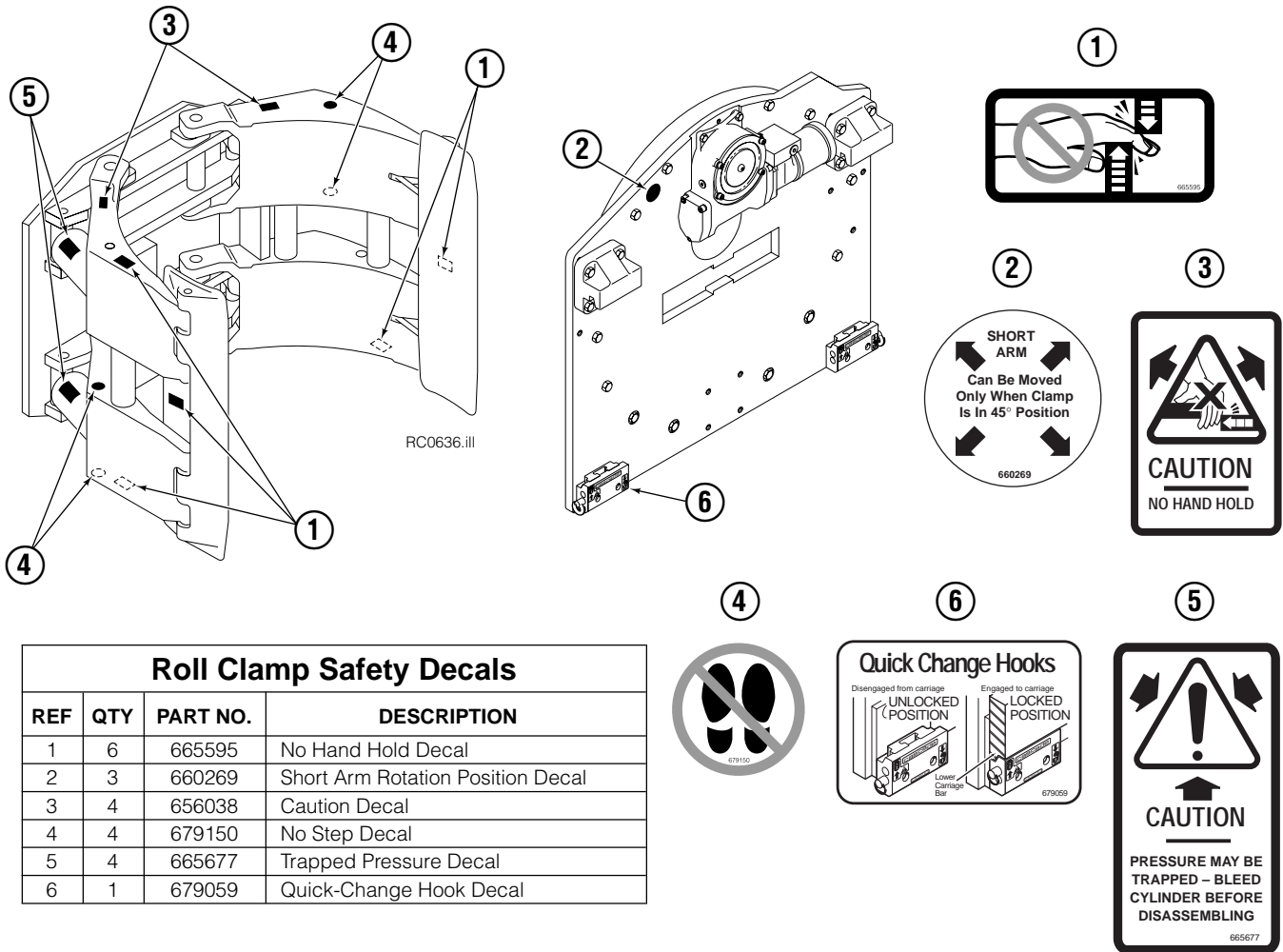
**To Order Parts call:** 888-227-2233, Fax: 888-329-0234

**OR**

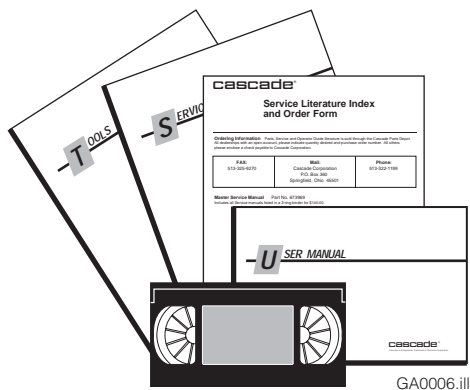
**Write:** Cascade Corporation, P.O. Box 20187, Portland, OR 97220

**Internet:** [www.cascorp.com](http://www.cascorp.com)

## Safety Decals

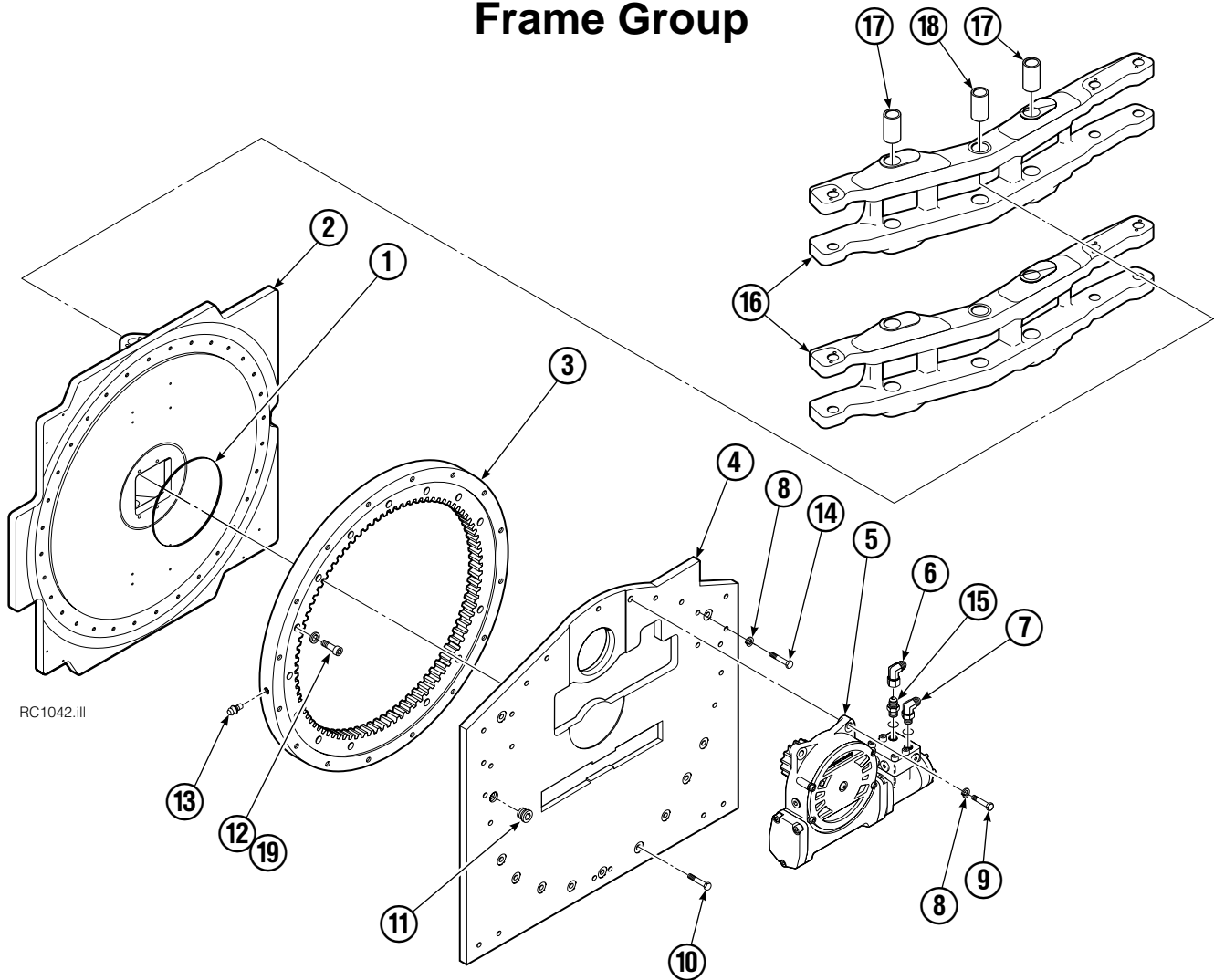


## Publications



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



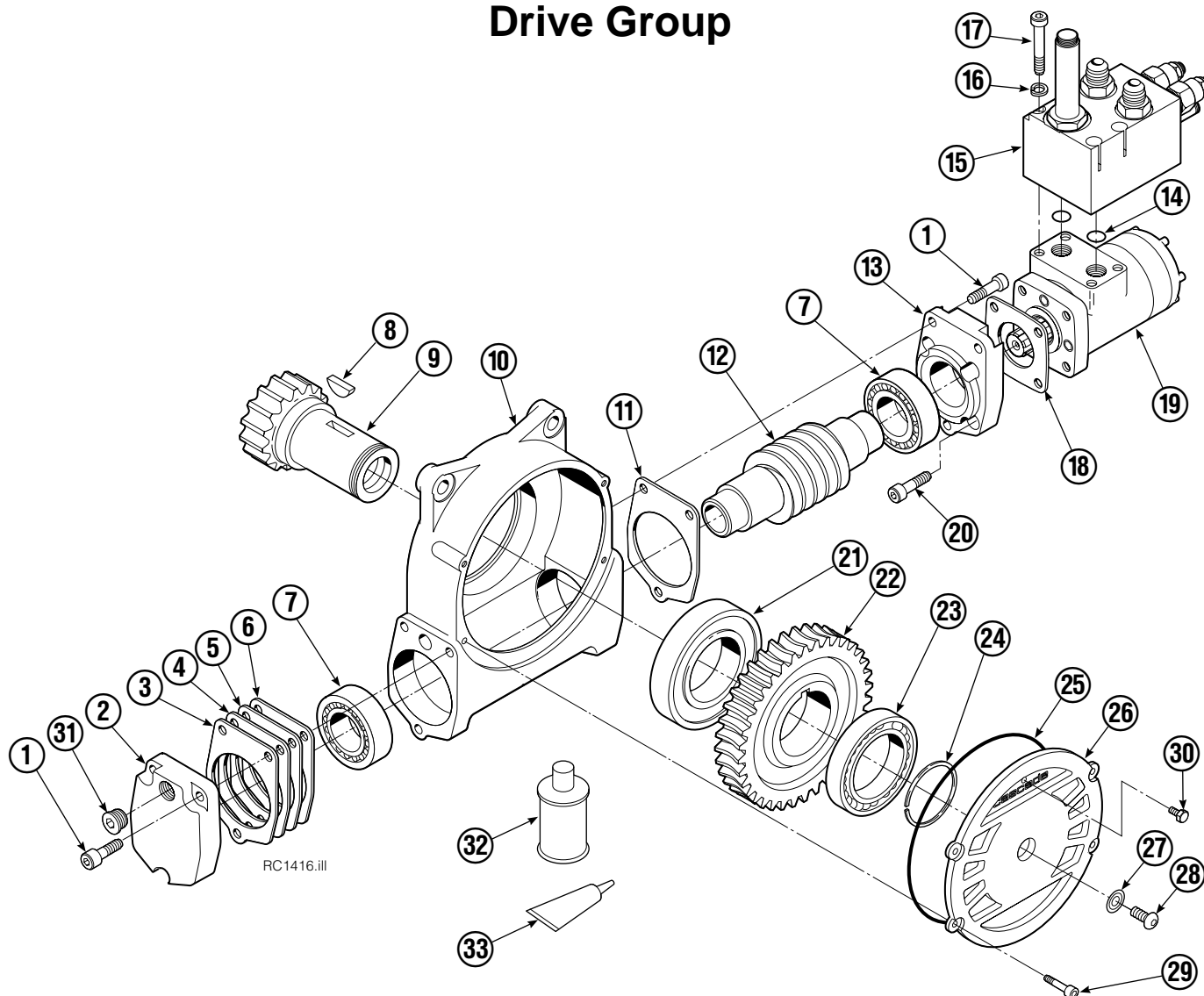
100F			
REF	QTY	PART NO.	DESCRIPTION
		6007950	Frame Group
1	1	670931	Seal
2	1	393460	Faceplate
3	1	214481	Bearing Assembly
4	1	214484	Baseplate
5	1	6001025	Drive Group ●
6	1	605761	Fitting, 8-8
7	1	601250	Fitting, 8-8
8	4	6290	Lockwasher, 1/2 ID
9	4	763021	Capscrew, M12 x 30
10	13	206174	Capscrew, M12 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	3004415	Swing Frame ▲
17	8	675008	Bushing ▲
18	4	384535	Bushing ▲
19	32	681473	Lockwasher, M12

● See Drive Group page for parts breakdown.

▲ Included in Swing Frame Group 3004414.

Reference: SK-6189, 6007952, 223703.

# Drive Group



100F							
REF	QTY	PART NO.	DESCRIPTION	REF	QTY	PART NO.	DESCRIPTION
		6001025	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, M12 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	6001035	Valve Assembly without Coils ◆			670578	Shim Service Kit (items 3-6,25,33)
16	4	6444	Lockwasher			675637	Bearing Service Kit (items 21 & 33)
17	4	607061	Capscrew, 5/16 NC x 2.25 GR8			675638	Bearing Service Kit (items 3-7,25)
18	1	670575	Gasket			206394	Motor Kit-2.8 (items 11,14,18,19)

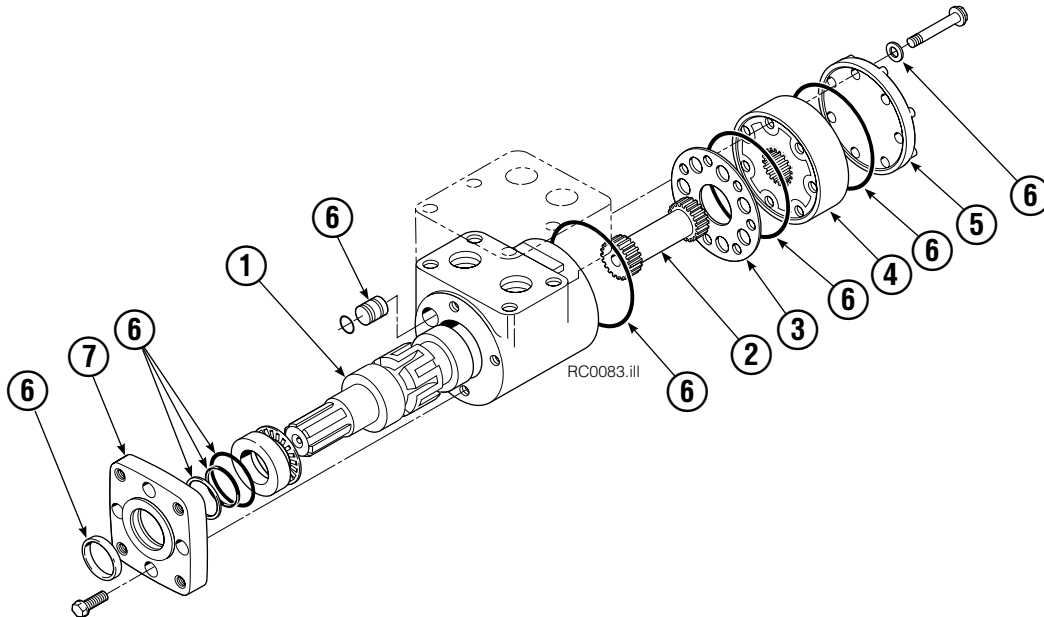
● Quantity as required.

◆ See Valve page for parts breakdown.

▲ See Drive Motor page for parts breakdown.

Reference: Common Parts 795490, SK-6864.

# Drive Motor

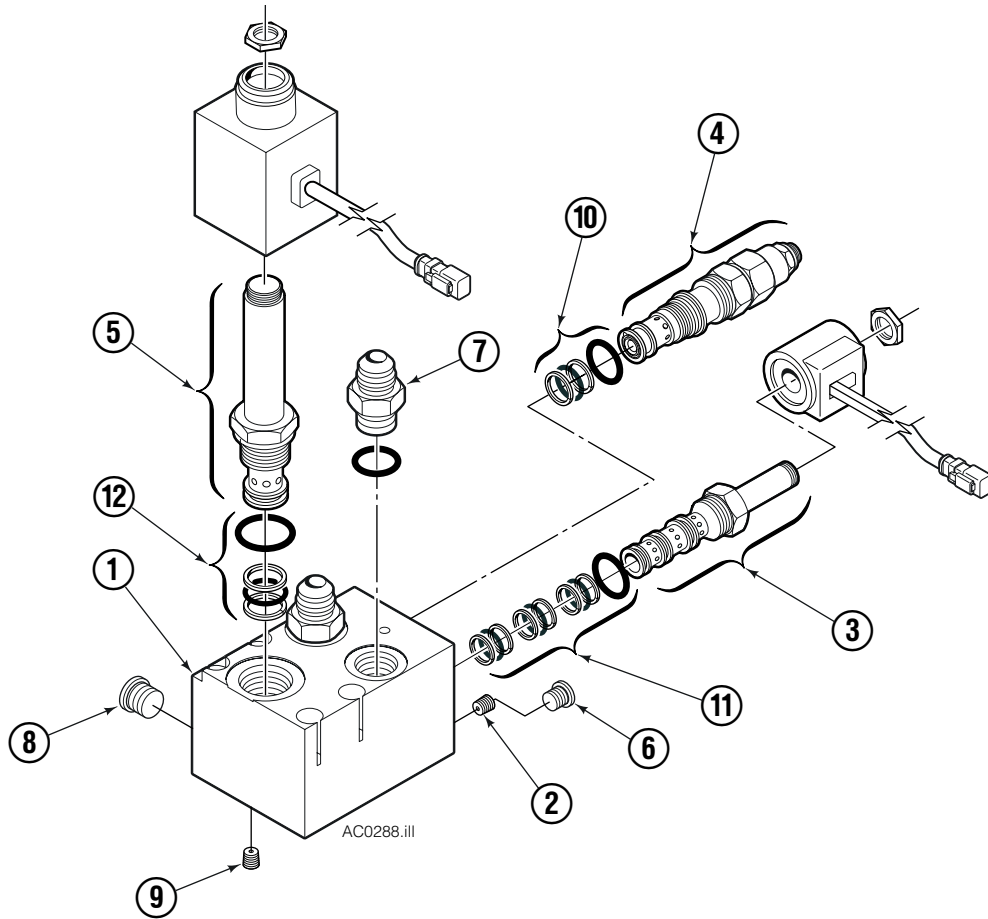


REF	QTY	PART NO.	DESCRIPTION
		206392	Drive Motor
1	1	675478	Shaft
2	1	675477	Drive
3	1	675479	Spacer Plate
■ 4	1	675480	Gerotor Set (101-1768-007)
■ 4	1	685075	Gerotor Set (101-1768-009)
5	1	675482	End Cap
● 6	1	206405	Service Kit
■ 7	1	685089	Flange (101-1768-007)
■ 7	1	685090	Flange (101-1768-009)

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.

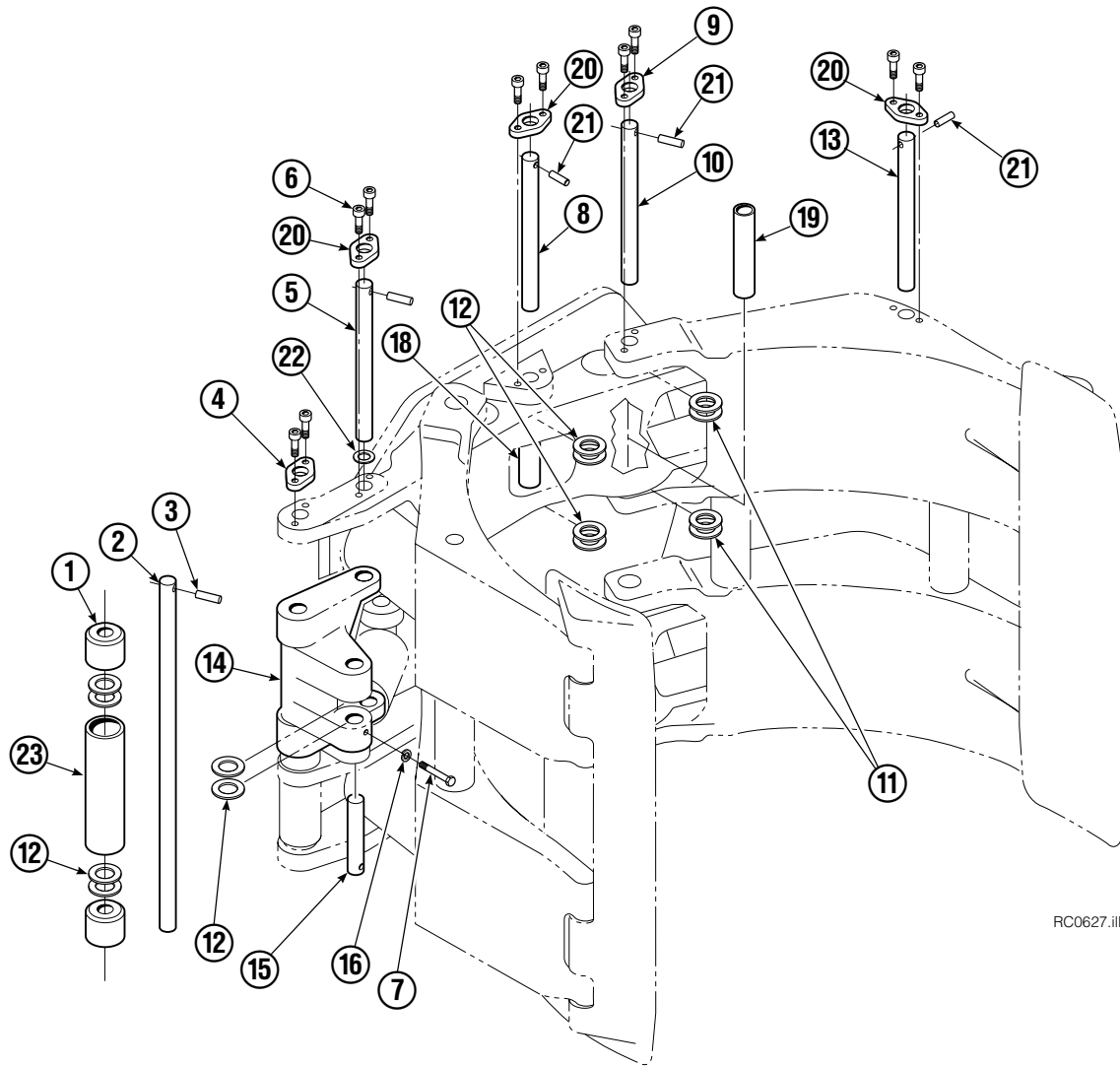
- See Nameplate under valve for correct part number of Gerotor Set and Flange.
- Compatible with water glycol based hydraulic fluids.

# Solenoid Valve



REF	QTY	PART NO.	DESCRIPTION
		6001035	Valve Assembly without Coils
1	1	220565	Valve Body
2	4	220641	Orifice
3	1	220627	Solenoid Valve
4	2	6003173	Valve
5	1	221722	Solenoid Valve
6	2	663694	Fitting, 3
7	3	601377	Fitting, 8
8	3	604510	Fitting, 6
9	3	228698	Orifice
10	2	667516	Service Kit
11	1	221049	Service Kit
12	1	6031791	Service Kit

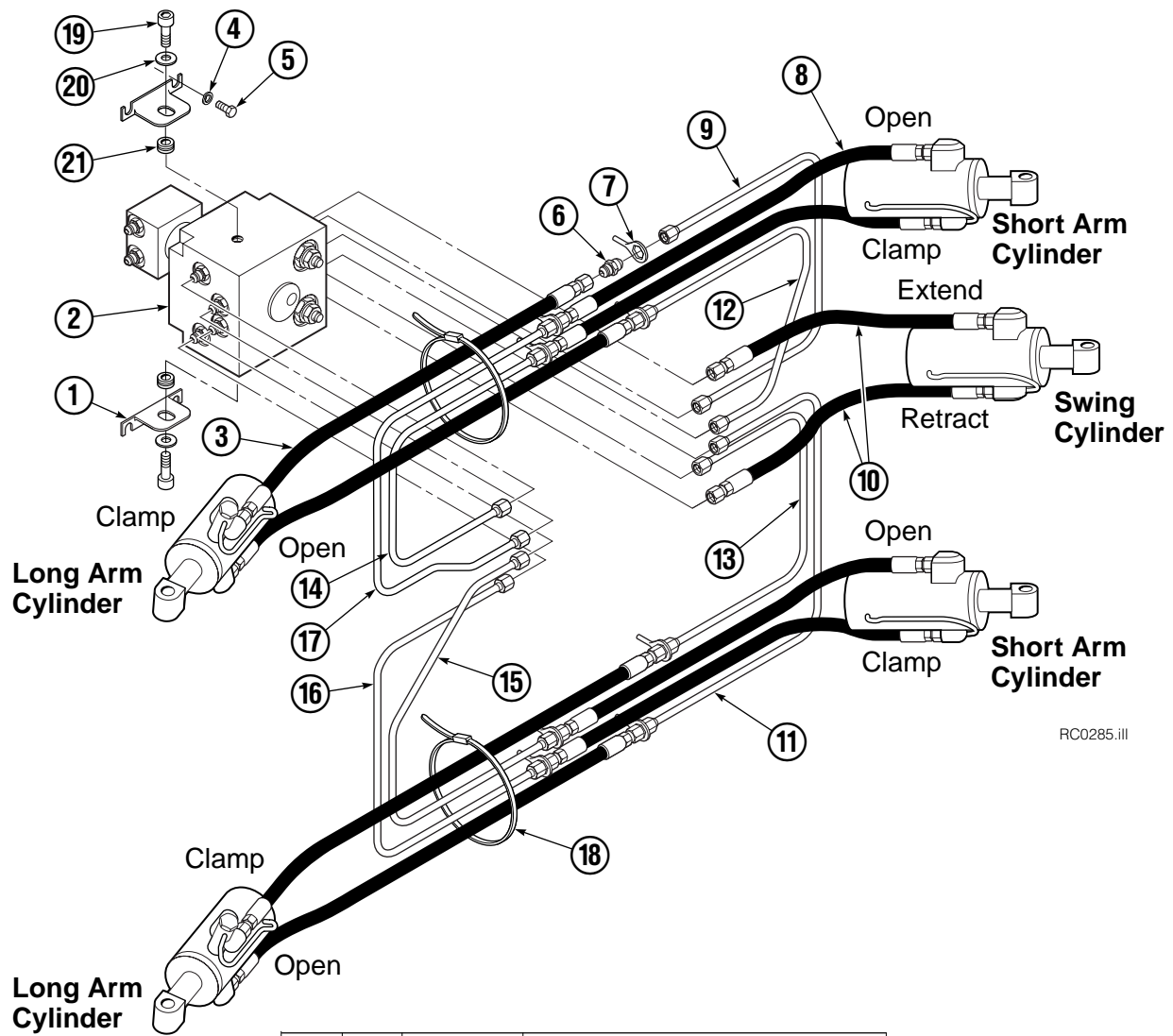
# Common Components Group



RC0627.iii

REF	QTY	PART NO.	DESCRIPTION	REF	QTY	PART NO.	DESCRIPTION
		3004416	Components Group	13	6	328994	Pin
1	4	3004431	Roller	14	1	3004417	Swing Casting
2	1	3004335	Pin	15	2	675023	Pin
3	1	673385	Drive Pin	16	2	6287	Lockwasher, 5/16 ID
4	1	674828	Retainer	17	6	675086	Drive Pin
5	2	384553	Pin	18	2	384552	Spacer
6	30	4466	Capscrew, 3/8 NC x .50 GR8	19	4	681672	Spacer
7	2	643518	Capscrew, 5/16 NC x 2.25 GR8	20	8	674829	Retainer
8	2	384550	Pin	21	8	674256	Pin
9	6	674830	Retainer	22	4	674257	Shim
10	4	675022	Pin	23	2	3003930	Spacer
11	24	673379	Shim	24	16	667103	Shim, not shown
12	20	660200	Shim				

# Swing Frame Hosing Group

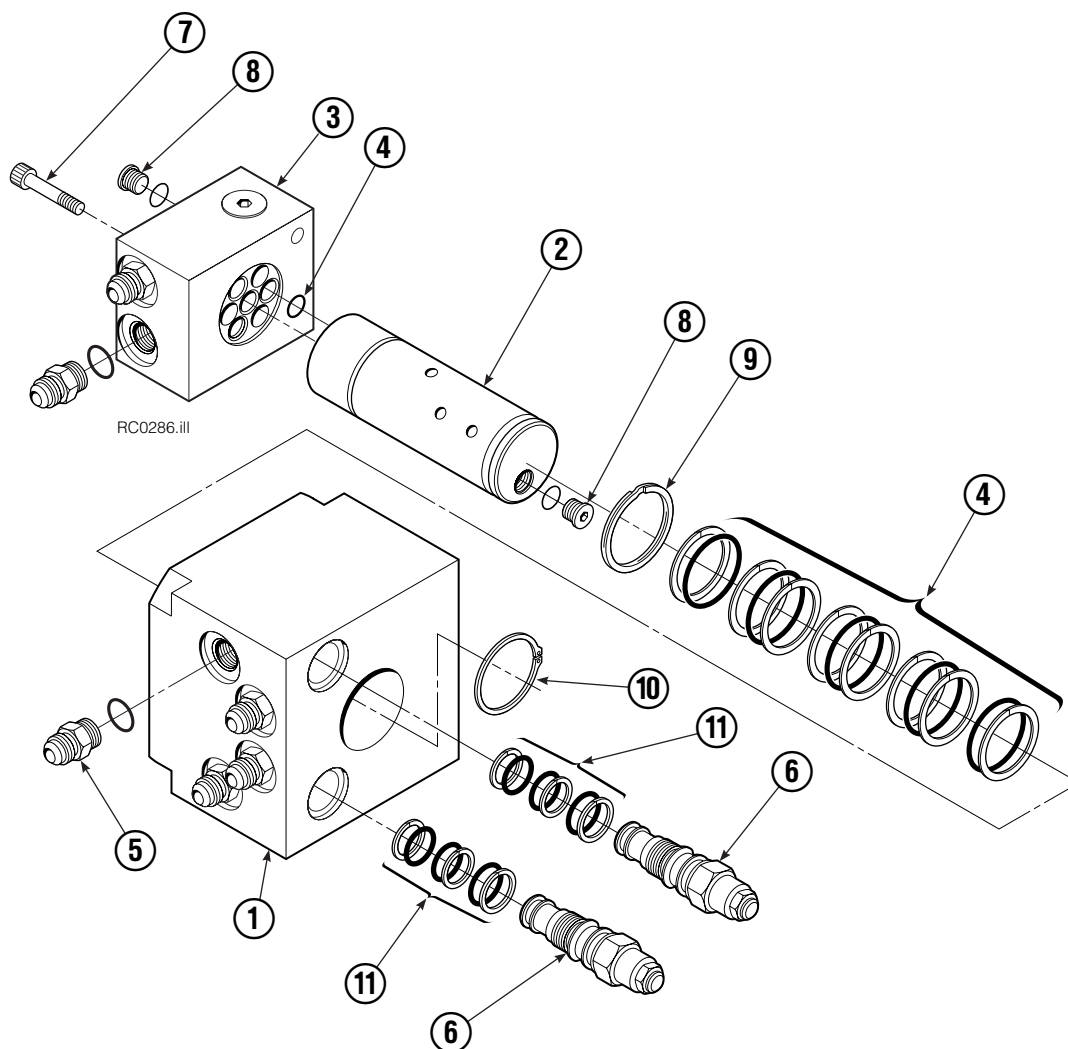


REF	QTY	PART NO.	DESCRIPTION
		399400	Hosing Group
1	2	206606	Angle
● 2	1	384555	Revolving Connection
3	4	680053	Hose 37.00 in.
4	4	6288	Lockwasher, 3/8"
5	4	3600	Capscrew, 3/8 NC x .62
6	8	2347	Fitting, 6-6
7	8	674743	Eye Bolt
8	4	204421	Hose 28.40 in.
9	1	675051	Tube
10	2	688695	Hose
11	1	675049	Tube
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.  
Reference: Common Parts 384558.

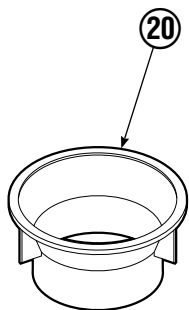
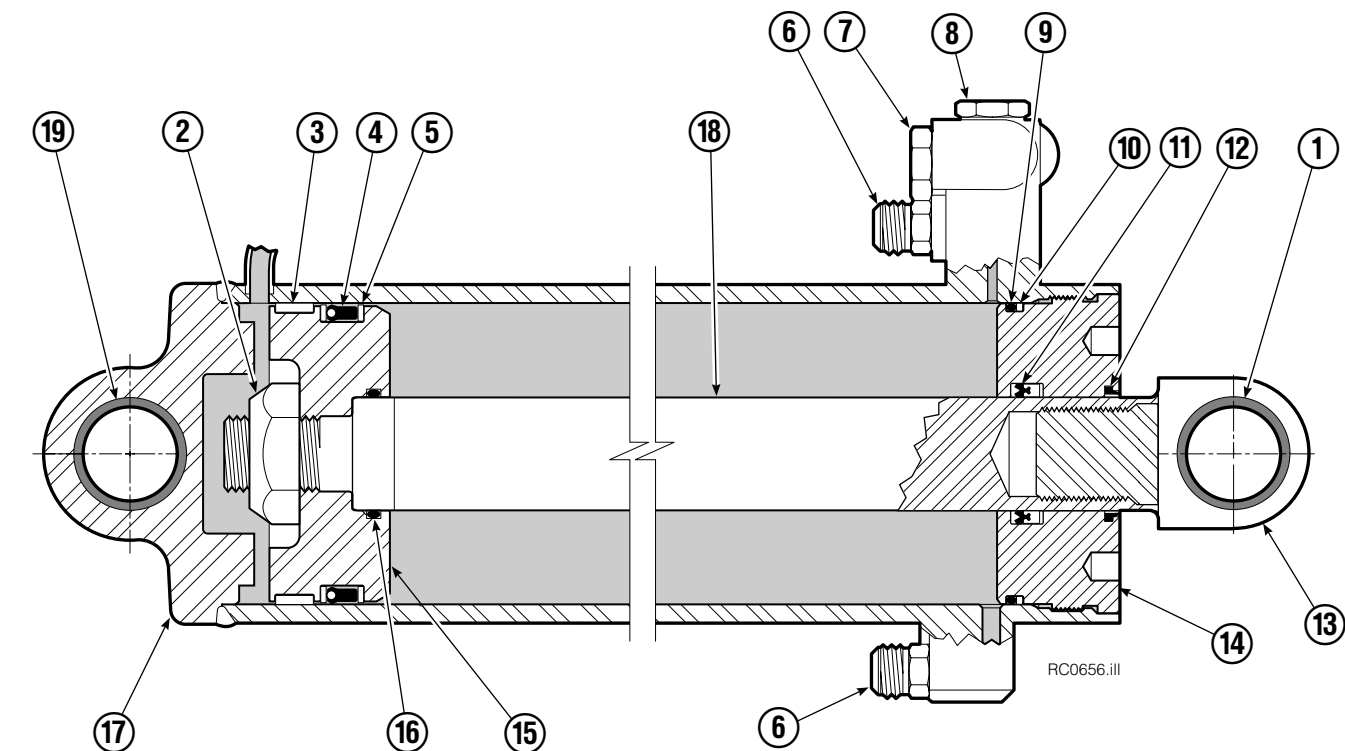


# Swing Frame Revolving Connection



100F			
REF	QTY	PART NO.	DESCRIPTION
		384555	Revolving Connection
1	1	207443	Body
2	1	384556	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

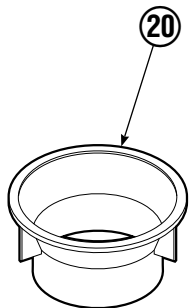
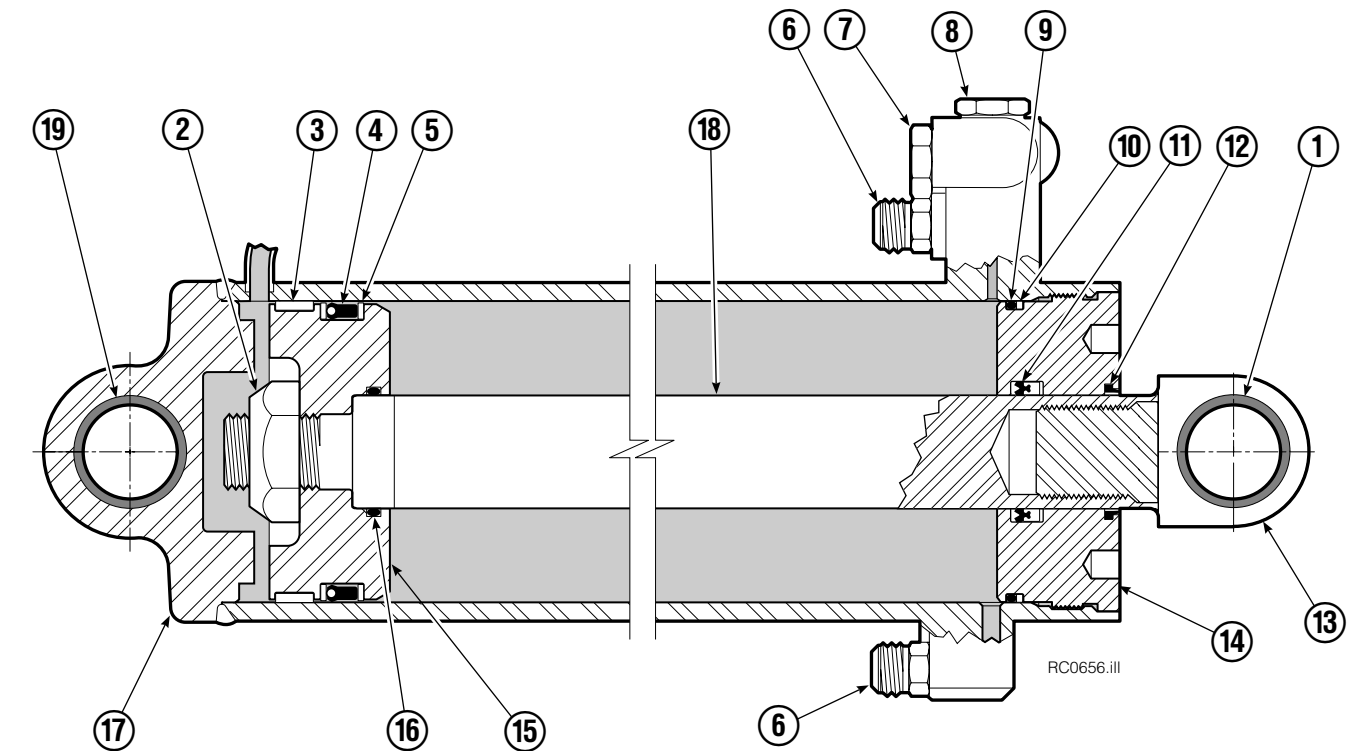
# Short Arm Cylinder



REF	QTY	PART NO.	DESCRIPTION
		384531	Cylinder Assembly
1	1	206764	Bearing
2	1	560997	Nut
3	1	660770	◆ Wear Ring
4	1	662464	◆ Seal
5	2	638223	◆ Nylon Ring
6	2	604511	Fitting, 6-6
7	1	556852	Fitting, 4
8	1	557212	Check Valve
9	1	2805	◆ O-Ring
10	1	615148	◆ Back-Up Ring
11	1	564442	◆ Seal
12	1	564443	◆ Wiper
13	1	565028	Rod End
14	1	565027	Retainer
15	1	560763	Piston
16	1	2722	◆ O-Ring
17	1	565061	Shell
18	1	565025	Rod
19	2	676163	◆ Bushing
20	1	672911	Seal Loader
		667516	Check Valve Service Kit
		212972	Service Kit

◆ Included in Service Kit 212972.

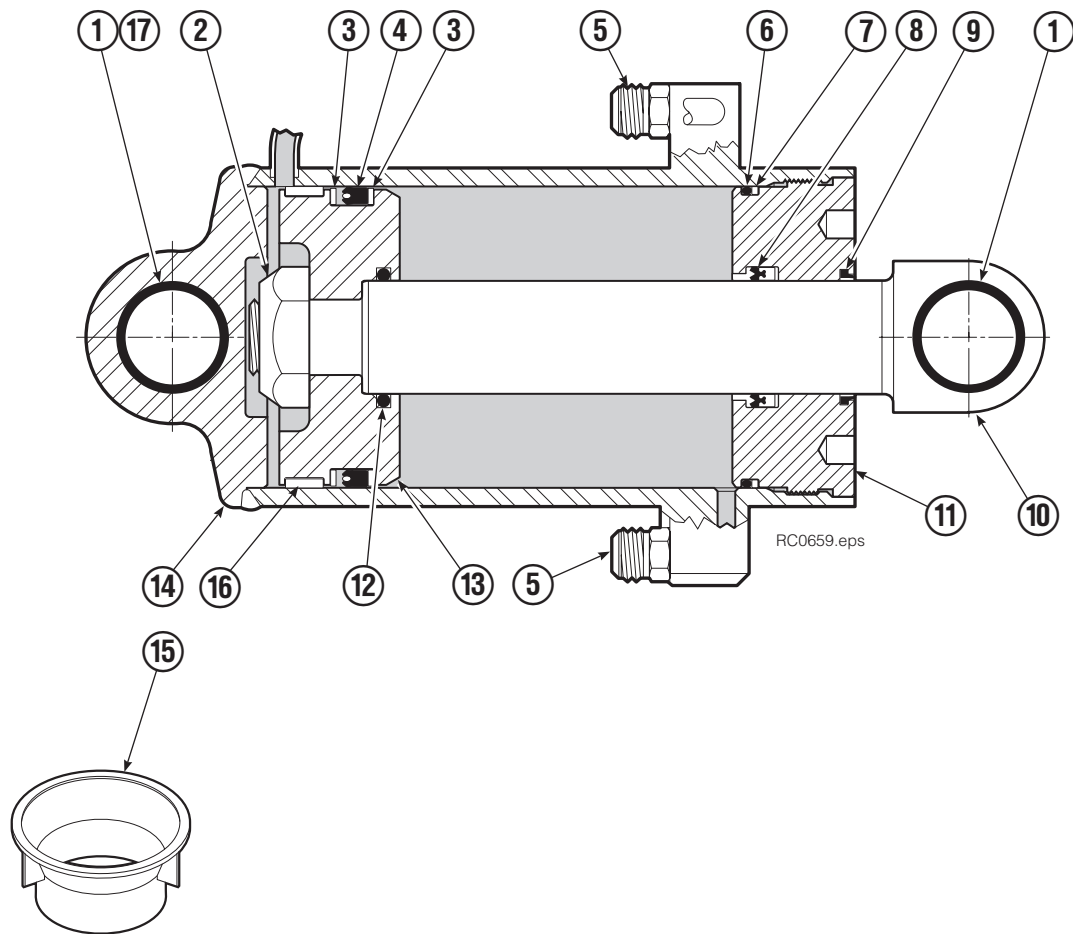
# Long Arm Cylinder



REF	QTY	PART NO.	DESCRIPTION
		384530	Cylinder Assembly
1	1	206764	Bearing
2	1	560997	Nut
3	1	660770	◆ Wear Ring
4	1	662464	◆ Seal ◆
5	2	638223	◆ Nylon Ring
6	2	604511	Fitting, 6-6
7	1	556852	Fitting, 4
8	1	557212	Check Valve
9	1	2805	◆ O-Ring
10	1	615148	◆ Back-Up Ring
11	1	564442	◆ Seal
12	1	564443	◆ Wiper
13	1	565028	Rod End
14	1	565027	Retainer
15	1	560763	Piston
16	1	2722	◆ O-Ring
17	1	565060	Shell
18	1	565024	Rod
19	2	676163	◆ Bushing
20	1	672911	Seal Loader
		667516	Check Valve Service Kit
		212972	Service Kit

◆ Included in Service Kit 212972.

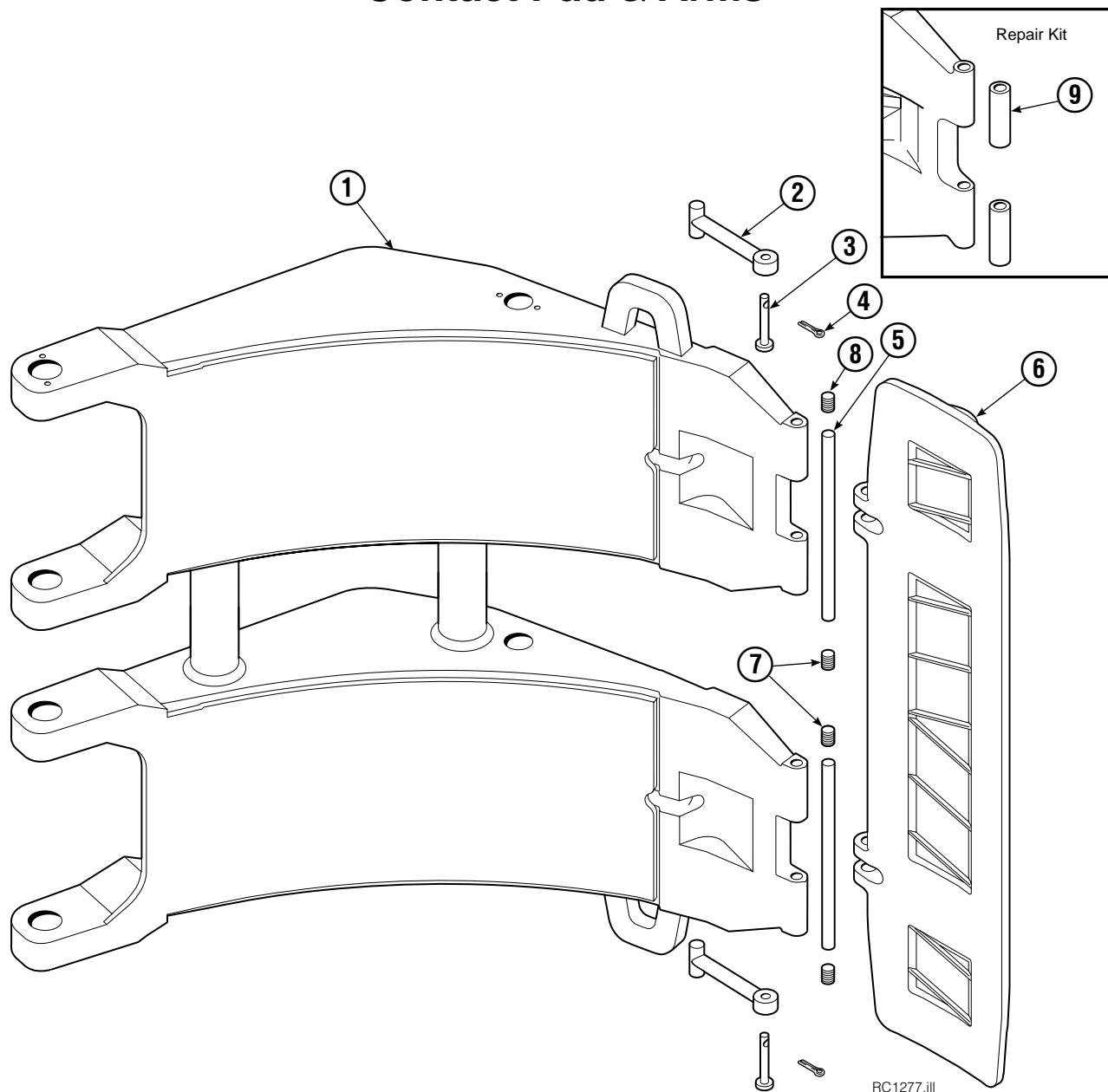
# Swing Cylinder Assembly



REF	QTY	PART NO.	DESCRIPTION
		385387	Cylinder Assembly
1	3	674843	Bearing
2	1	561997	Nut
3	2	638295	◆ Nylon Ring
4	1	662462	◆ 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	564993	Rod
11	1	555724	Retainer
12	1	2722	◆ O-Ring
13	1	557389	Piston
14	1	564992	Shell
15	1	672910	◆ Seal Loader
16	1	660769	◆ Wear Ring
17	1	558837	Sleeve
		555725	Service Kit

◆ Included in Service Kit 555725.

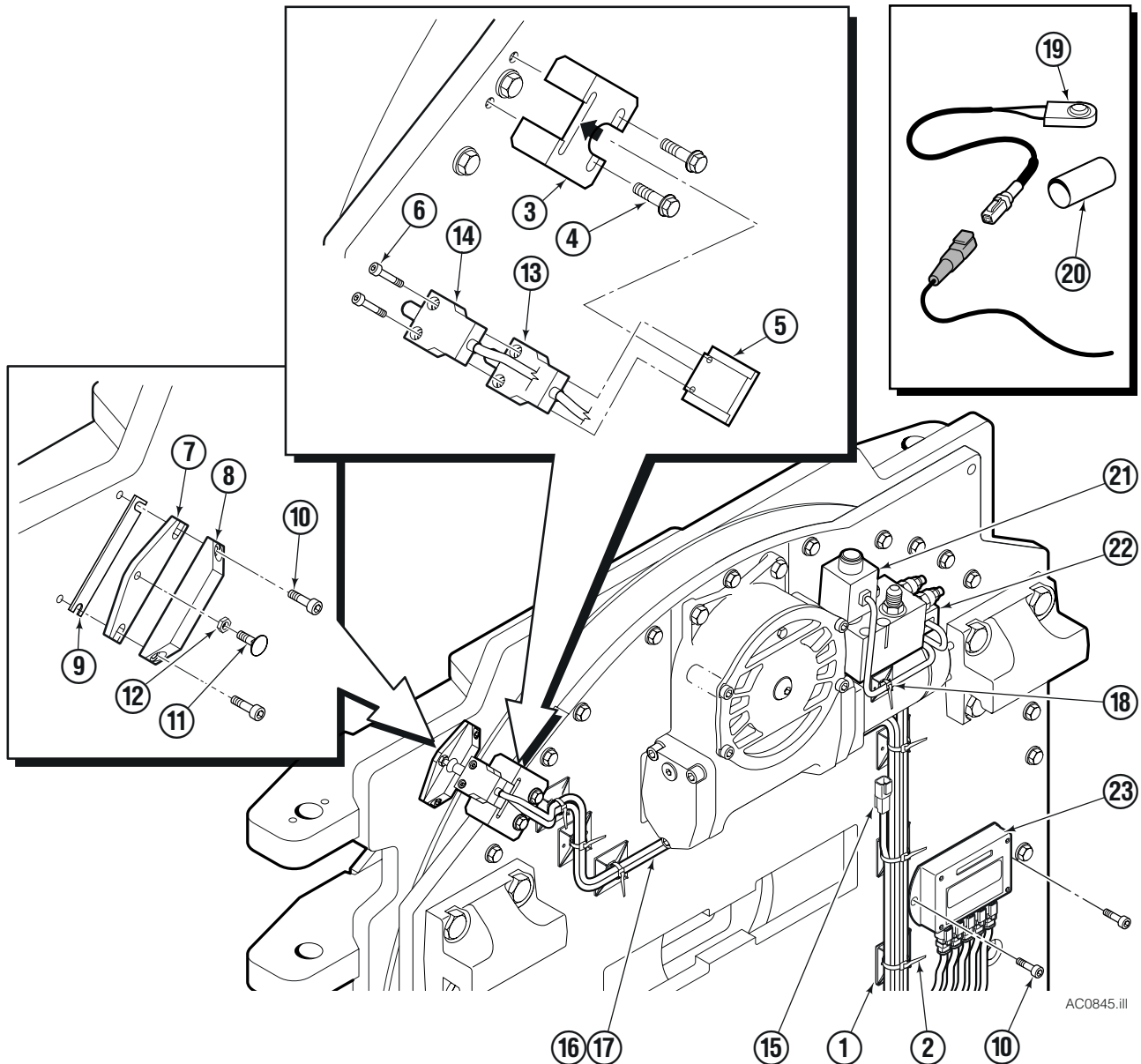
# Contact Pad & Arms



100F			
REF	QTY	PART NO.	DESCRIPTION
		398398	Contact Pad Group ▲
1	1	6020657	Long Arm
1	1	6020656	Short Arm
2	2	674994	Link
3	2	682978	Clevis Pin
4	2	6525	Cotter Pin
5	2	674993	Pin
6	1	338707	Contact Pad
7	2	689900	Plug
8	2	689900	Plug
9	1	674928	Arm Tip Repair Kit

▲ Includes items 2 through 8.

# Rotational Control Package



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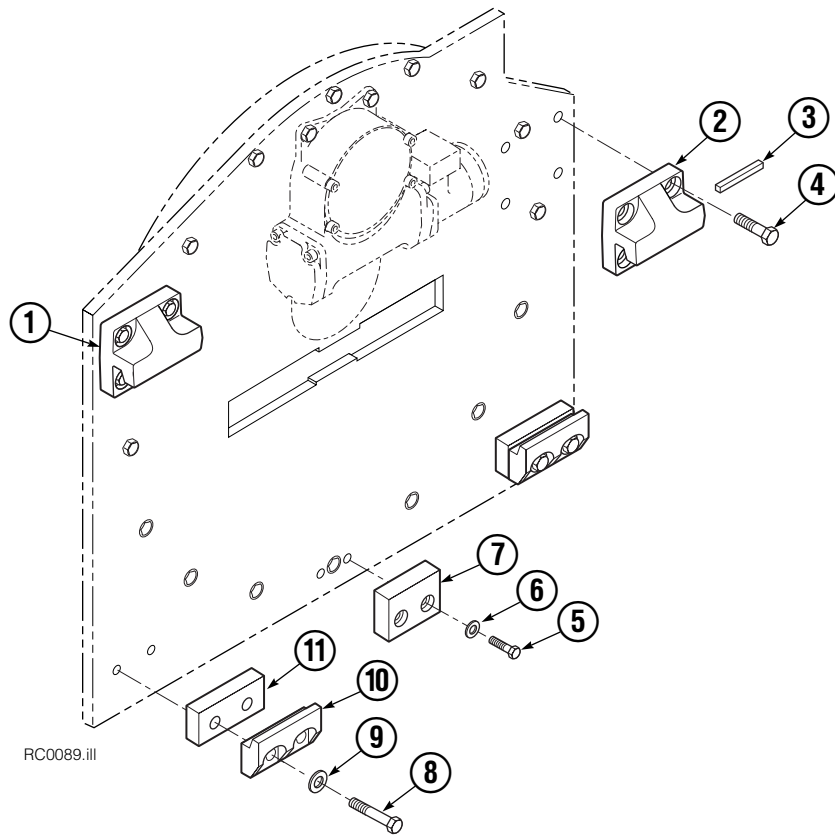
## 100F

REF	QTY	PART NO.	DESCRIPTION	REF	QTY	PART NO.	DESCRIPTION
		6001010	Rotational Control Group 1 ●	12	3	765718	Nut
		6001012	Rotational Control Group 2 ■	13	1	222024	Switch/Cable Assembly
1	7	6002451	Cable Tie Anchor	14	1	222256	Switch/Cable Assembly
2	9	6002479	Cable Tie	15	1	222023	Power Cable
3	1	222021	Switch Mounting Bracket	16	1	228720	Ext. Cable Assembly
4	2	6002668	Flange Screw	17	1	228721	Ext. Cable Assembly
5	1	222020	Switch Mounting Plate	18	2	6002501	Cable Tie Anchor
6	2	768784	Capscrew	19	1	6001663	Switch Assy
7	3	228700	Plate Stop	20	1	6001641	Shrink Tubing
8	3	228701	Block Decal	21	1	6003161	Solenoid/Cable Assembly
9	3	6009228	Shim	22	1	6003169	Solenoid/Cable Assembly
10	8	761170	Capscrew	23	1	227888	Relay Enclosure Assembly
11	3	228690	Carriage Bolt				

■ Includes items 1-18.

● Includes items 19-20.

# Bolt-On Mounting Group

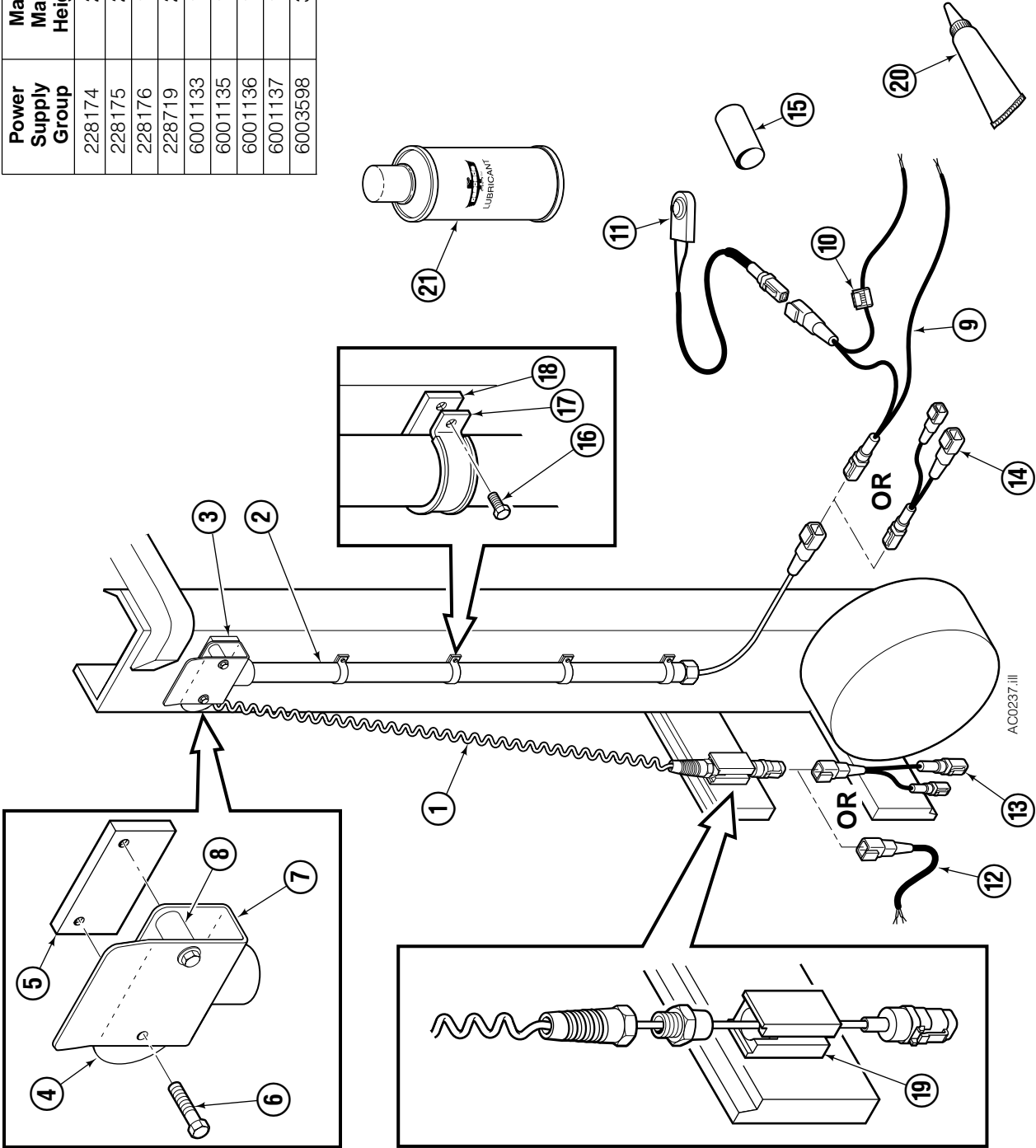


Class IV, 1.8°			
REF	QTY	PART NO.	DESCRIPTION
		684880	Mounting Group
1	1	684877	Upper Hook – LH
2	1	675061	Upper Hook – RH
3	1	670704	Stop Kit
4	8	679082	Capscrew, M20 x 35
5	2	768810	Capscrew, M10 x 30
6	2	680030	Lockwasher, M10
7	1	681057	Center Spacer
8	4	676854	Capscrew, M20 x 60
9	4	670692	Washer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

Reference: SK-5286.

Power Supply Groups

Power Supply Group	Maximum Mast Fork Height (in.)	Conductors (No. @ AWG)	Supply Application
228174	240	2 @ 20	Switched
228175	240	4 @ 26	Unswitch
228176	188	2 @ 20 & 4 @ 26	Unswitch
228719	240	2 @ 20	Unswitch
6001133	188	2 @ 20	Switched
6001135	188	4 @ 26	Unswitch
6001136	188	2 @ 20 & 4 @ 26	Unswitch
6001137	188	2 @ 20	Unswitch
6003598	320	4 @ 26	Unswitch





# Power Supply Groups

REF	QTY	PART NO.	PART NO.	PART NO.	PART NO.	PART NO.	PART NO.	PART NO.	PART NO.	PART NO.	PART NO.	PART NO.	PART NO.	PART NO.	PART NO.	PART NO.	DESCRIPTION
		228174	228175	228176	228719	6001133	6001135	6001136	6001137	6003598							Power Supply Group
1	1	223690	228181	223647	223690	6001140	6001142	6001143	6001140	6003600							Cable Assembly
2	1	223684	223684	223684	223684	6001138	6001138	6001138	6001138	6003601							Conduit
3	1	223678	223678	223678	223678	223678	223678	223678	223678	223678							Sheave Assembly ●
4	1	223680	223680	223680	223680	223680	223680	223680	223680	223680							Sheave
5	1	228679	228679	228679	228679	228679	228679	228679	228679	228679							Plate
6	2	228704	228704	228704	228704	228704	228704	228704	228704	228704							Capscrew, M8 x 45
7	1	223679	223679	223679	223679	223679	223679	223679	223679	223679							Bracket
8	2	223681	223681	223681	223681	223681	223681	223681	223681	223681							Bearing
9	1	6001647	—	6001647	6001647	6001647	—	6001647	6001647	—							Wire Harness
10	1	219414	—	219414	219414	219414	—	219414	219414	—							Fuse, ATC-10
11	1	6001637	—	—	—	6001637	—	—	—	—							Switch
12	1	224459	—	224459	—	224459	—	224459	—	—							Pigtail
13	1	—	—	6001544	—	—	—	6001544	—	—							Cable Adapter
14	1	—	—	6001545	—	—	—	6001545	—	—							Cable Adapter
15	1	6001641	—	—	—	6001641	—	—	—	—							Shrink Tube
16	■	753159	753159	753159	753159	753159	753159	753159	753159	753159							Capscrew, M6 x 10
17	■	6001442	6001442	6001442	6001442	6001442	6001442	6001442	6001442	6001442							Clamp
18	■	6001452	6001452	6001452	6001452	6001452	6001452	6001452	6001452	6001452							Block
19	1	223698	223698	223698	223698	223698	223698	223698	223698	223698							Anchor
20	1	222267	222267	222267	222267	222267	222267	222267	222267	222267							Adhesive
21		6014684	6014684	6014684	6014684	6014684	6014684	6014684	6014684	6014684							Dry Film Lubricant

● Includes items 4 thru 8.

■ Quantity as required.

**Do you have questions you need answered right now?** Call your nearest Cascade Parts Department. Visit us online at [www.cascorp.com](http://www.cascorp.com)

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