



Parts Manual

35D, 50D Revolving Clamps

Serial Numbers 675668 through 676139

Fork Clamps

Bale Clamps

Drum Clamps

Multi-Purpose/Rigid Arm Clamps

Clamps without Arms

Manual Number 676366 R-1

cascade[®]

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HOW TO USE THIS MANUAL

Introduction

This manual illustrates service replacement parts for standard production Cascade 35D and 50D Revolving Clamps.

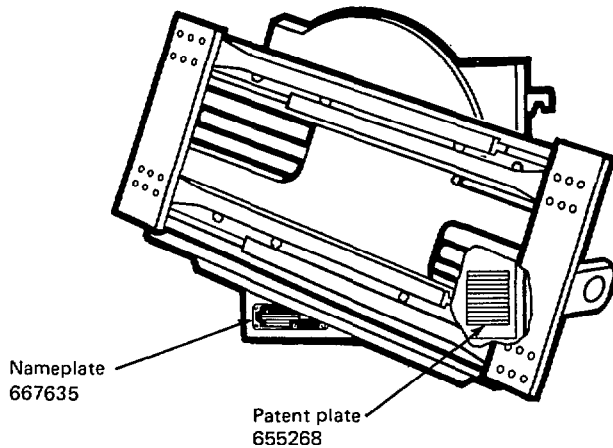
The parts manuals for attachments designed by the Application Engineering Department have an A.E.D. designation on the cover of the manual.

This standard attachment manual is not interchangeable with an A.E.D. Manual since it does not reflect the special engineering of an A.E.D. attachment.

To locate a service replacement part for a standard attachment follow the steps below.

1. Locate the Nameplate

The nameplate is attached to the lower right front face of the baseplate. If the nameplate is missing, all necessary information is stamped into the frame at the same location.



cascade LIFT TRUCK ATTACHMENT		ATTACHMENT CAPACITY	
SERIAL NUMBER	675668-P2	<input type="checkbox"/> POUNDS AT	<input type="checkbox"/> INCH LOAD CENTER
CATALOG NUMBER	35D-CN-20F	CAPACITY OF TRUCK AND ATTACHMENT COMBINATION MAY BE LESS THAN ATTACHMENT CAPACITY SHOWN ABOVE. CONSULT TRUCK NAMEPLATE.	
ADDITIONAL EQUIPMENT		RECOMMENDED SYSTEM PRESSURE - 2000 PSI	
ADDITIONAL EQUIPMENT		MAXIMUM SYSTEM PRESSURE - 2500 PSI	
ADDITIONAL EQUIPMENT		cascade corporation	
ADDITIONAL EQUIPMENT		FOR TECHNICAL ASSISTANCE, CONTACT	FOR PARTS AND SERVICE MANUALS CONTACT
		503 / 686 - 1511	513 / 322 - 1199
		PORTLAND, OREGON USA	SPRINGFIELD, OHIO USA

2. Note the Serial Number

Record the six-digit Serial Number. See the example.

3. Refer to Serial Number Index

Locate your Serial Number in the Serial Number Index on the following page.

IMPORTANT: DO NOT USE THIS MANUAL TO ORDER PARTS FOR AN A.E.D. ATTACHMENT. Contact Cascade Corporation to obtain the correct parts manual. You must supply the serial number and all additional equipment numbers to order the correct manual.

4. Ordering

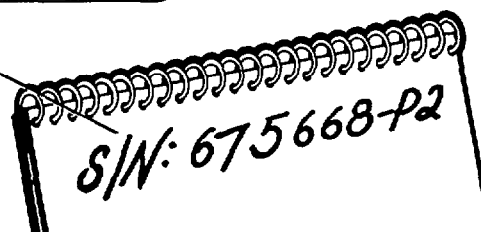
Retail Customers. Cascade Service Replacement Parts and Literature are sold through authorized lift truck dealers. To order, contact the lift truck dealer of your choice.

Lift Truck Dealers. To order Service Replacement Parts or Literature, contact:

Cascade Parts Depot
2501 Sheridan Avenue
P.O. Box 360
Springfield, Ohio 45505
(513) 322-1199
Telex: 279563
FAX: 8-1-513-325-9270

5. Parts Log

We have supplied a parts ordering log located on the last page. Use this log as a permanent record of parts ordered from this manual.



Serial Number Index

Serial Number	Model	Frame Group Page	Rotator Group Page	Cylinder Group Page	Drive Group Page	Revolving Connection Page	Arm Group Page	Mounting Group Page	Solenoid Adaption Page	180° Stop Group Page
675668	35D	1	3	5	6	9	10	15	18	20
675669	35D	1	3	5	6	9	10	15	18	20
675671	50D	2	4	5	6	9	10	15	18	20
675672	50D	2	4	5	6	9	10	15	18	20
675673	50D	2	4	5	6	9	10	16	18	20
675674	50D	2	4	5	6	9	10	16	18	20
675685	35D	1	3	5	6	9	13	15	18	20
675686	35D	1	3	5	6	9	13	15	18	20
675687	35D	1	3	5	6	9	13	15	18	20
675688	35D	1	3	5	6	9	13	15	18	20
675689	35D	1	3	5	6	9	13	15	18	20
675690	35D	1	3	5	6	9	13	15	18	20
675691	35D	1	3	5	6	9	13	15	18	20
675692	35D	1	3	5	6	9	13	15	18	20
675693	50D	2	4	5	6	9	13	15	18	20
675694	50D	2	4	5	6	9	13	15	18	20
675695	50D	2	4	5	6	9	13	16	18	20
675696	50D	2	4	5	6	9	13	16	18	20
675697	50D	2	4	5	6	9	13	15	18	20
675698	50D	2	4	5	6	9	13	15	18	20
675699	50D	2	4	5	6	9	13	16	18	20
675700	50D	2	4	5	6	9	13	16	18	20
675701	50D	2	4	5	6	9	13	15	18	20
675702	50D	2	4	5	6	9	13	15	18	20
675703	50D	2	4	5	6	9	13	16	18	20
675704	50D	2	4	5	6	9	13	16	18	20
675705	50D	2	4	5	6	9	13	15	18	20
675706	50D	2	4	5	6	9	13	15	18	20
675707	50D	2	4	5	6	9	13	16	18	20
675708	50D	2	4	5	6	9	13	16	18	20
675709	35D	1	3	5	6	9	12	15	18	20
675710	35D	1	3	5	6	9	12	15	18	20
675711	35D	1	3	5	6	9	12	15	18	20
675712	35D	1	3	5	6	9	12	15	18	20
675713	35D	1	3	5	6	9	12	15	18	20
675714	35D	1	3	5	6	9	12	15	18	20
675715	50D	2	4	5	6	9	12	15	18	20
675716	50D	2	4	5	6	9	12	15	18	20
675717	50D	2	4	5	6	9	12	16	18	20
675718	50D	2	4	5	6	9	12	16	18	20
675719	50D	2	4	5	6	9	12	15	18	20
675720	50D	2	4	5	6	9	12	15	18	20
675721	50D	2	4	5	6	9	12	16	18	20
675722	50D	2	4	5	6	9	12	16	18	20
675723	50D	2	4	5	6	9	12	15	18	20

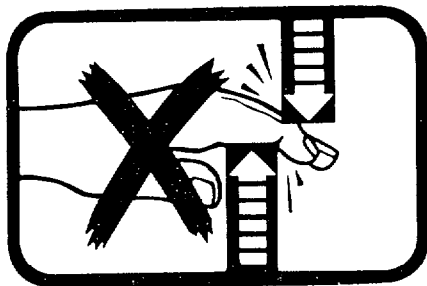
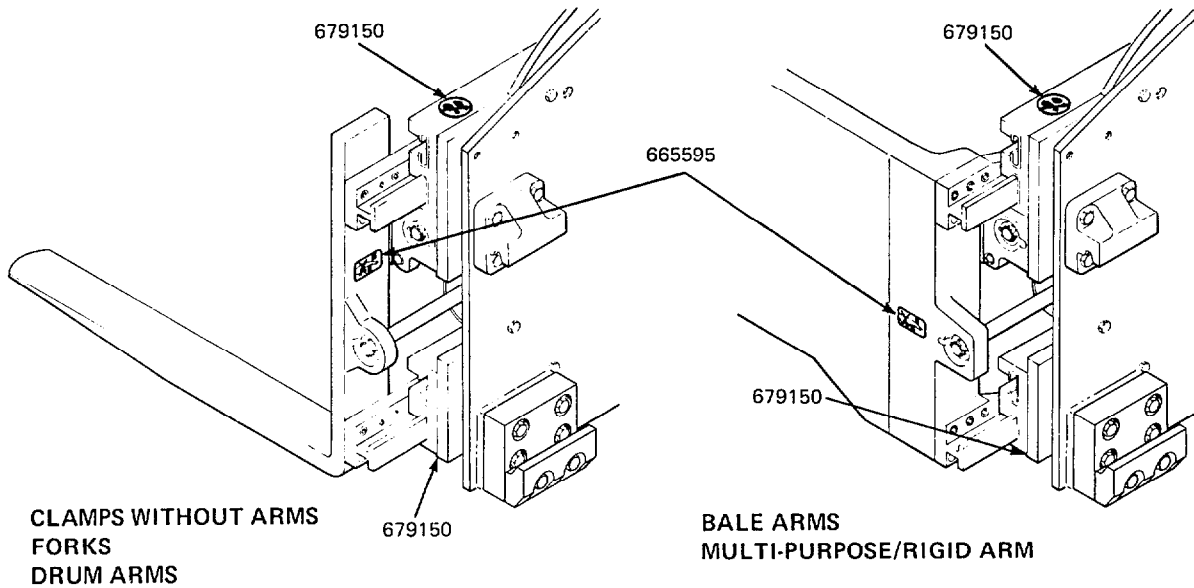
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Serial Number Index

Serial Number	Model	Frame Group Page	Rotator Group Page	Cylinder Group Page	Drive Group Page	Revolving Connection Page	Arm Group Page	Mounting Group Page	Solenoid Adaption Page	180° Stop Group Page
675724	50D	2	4	5	6	9	12	15	18	20
675725	50D	2	4	5	6	9	12	16	18	20
675726	50D	2	4	5	6	9	12	16	18	20
675727	35D	1	3	5	6	9	11	15	18	20
675728	35D	1	3	5	6	9	11	15	18	20
675729	35D	1	3	5	6	9	11	15	18	20
675730	35D	1	3	5	6	9	11	15	18	20
675731	35D	1	3	5	6	9	11	15	18	20
675732	35D	1	3	5	6	9	11	15	18	20
675733	50D	2	4	5	6	9	11	15	18	20
675734	50D	2	4	5	6	9	11	15	18	20
675735	50D	2	4	5	6	9	11	16	18	20
675736	50D	2	4	5	6	9	11	16	18	20
675737	50D	2	4	5	6	9	11	15	18	20
675738	50D	2	4	5	6	9	11	15	18	20
675739	50D	2	4	5	6	9	11	16	18	20
675740	50D	2	4	5	6	9	11	16	18	20
676136	35D	1	3	5	6	9	14	15	18	20
676137	35D	1	3	5	6	9	14	15	18	20
676138	35D	1	3	5	6	9	14	15	18	20
676139	35D	1	3	5	6	9	14	15	18	20

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Safety Decals

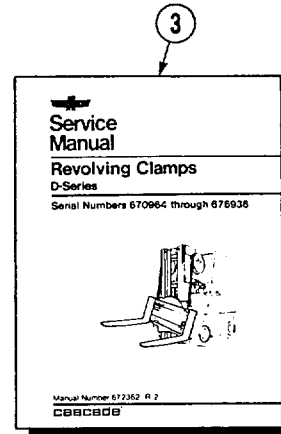
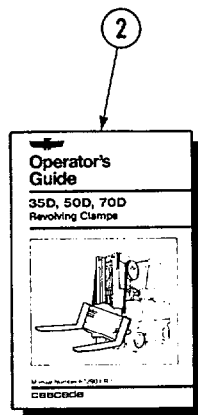
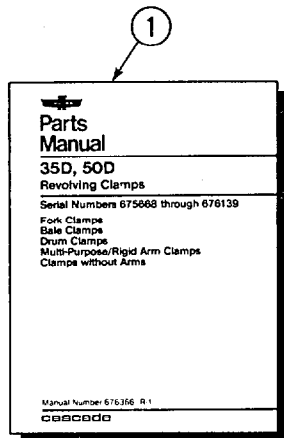


QTY.	PART NO.	DESCRIPTION
2	665595	No Hand Hold Decal

2258q

QTY	PART NO.	DESCRIPTION
2	679150	No Step Decal

Publications



REF	PART NO.	DESCRIPTION
1	672362	Service Manual
2	672903	Operator's Guide
3	676366	Parts Manual

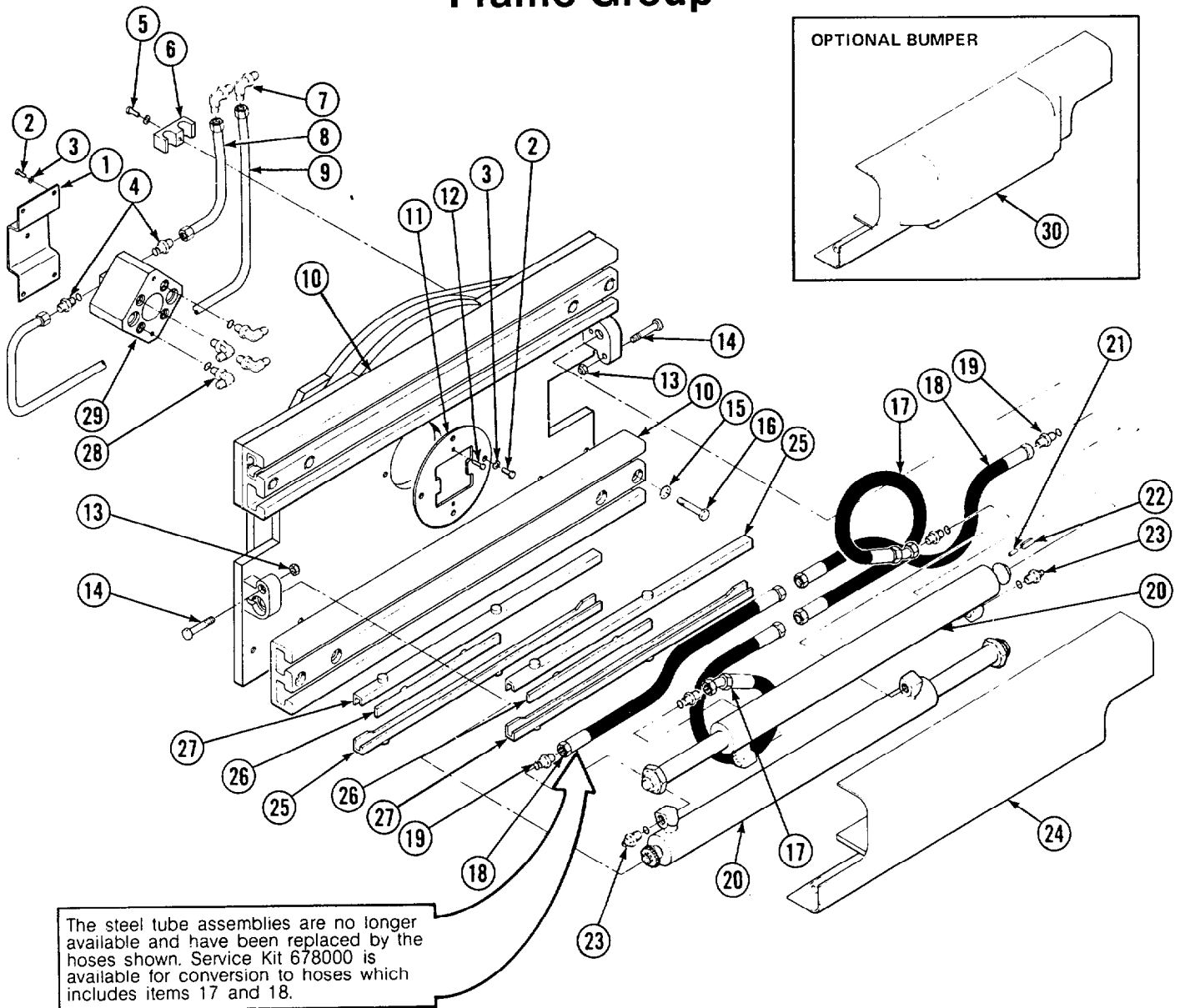
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Recommended Spare Parts List

35D & 50D REVOLVING CLAMPS					
PART NUMBER		DESCRIPTION	ATTACHMENTS SERVICED		
35D	50D		1-5	6-19	20-50
DRIVE GROUP					
675608	675608	Worm	0	1	2
670506	670506	Pinion	0	1	2
670581	670581	Bearing	0	1	1
7214	7214	Snap Ring	2	2	4
643423	643423	O-Ring	1	2	2
675329	675329	Drive Motor	0	1	1
675474	675474	Drive Motor Seal Kit	1	1	2
668184	668184	Sealant	1	1	2
675638	675638	Bearing Service Kit	1	1	2
675637	675637	Bearing Service Kit	1	2	2
656300	656300	Gear Box Lube	1	2	2
FRAME GROUP					
677995	677996	Hose	0	1	2
678027	678027	Hose	0	1	2
674166	674176	Frame	0	1	2
667908	667664	Bumper	0	0	1
667907	667661	Bearing	4	8	12
667663	667663	Bearing	4	8	12
667906	667662	Bearing	4	8	12
CYLINDER					
667911	667666	Cylinder Assembly	0	0	1
553758	553760	Shell	0	1	1
670891	670893	Piston	0	0	2
667917	667675	Retainer	0	0	2
667914	667670	Rod	0	1	2
668926	668925	Nut Service Kit	0	2	4
667995	667723	Service Kit	2	4	8
CHECK VALVE					
670549	670549	Check Valve Assembly	0	1	1
REVOLVING CONNECTION					
660476	660476	Shaft Service Kit	1	1	1
667516	667516	Check Valve Service Kit	2	4	4
ARMS					
607103	607105	Capscrews	24	24	24
TOOL					
667699	667699	Arm Capscrew Extension Tool	1	2	2
PAINT					
668209	668209	Cascade Yellow, 12 oz. Aerosol Can	1	1	1
PUBLICATIONS					
673952	673952	Service Manual	1	1	1
672903	672093	Operators Guide	1	1	1

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Frame Group



The steel tube assemblies are no longer available and have been replaced by the hoses shown. Service Kit 678000 is available for conversion to hoses which includes items 17 and 18.

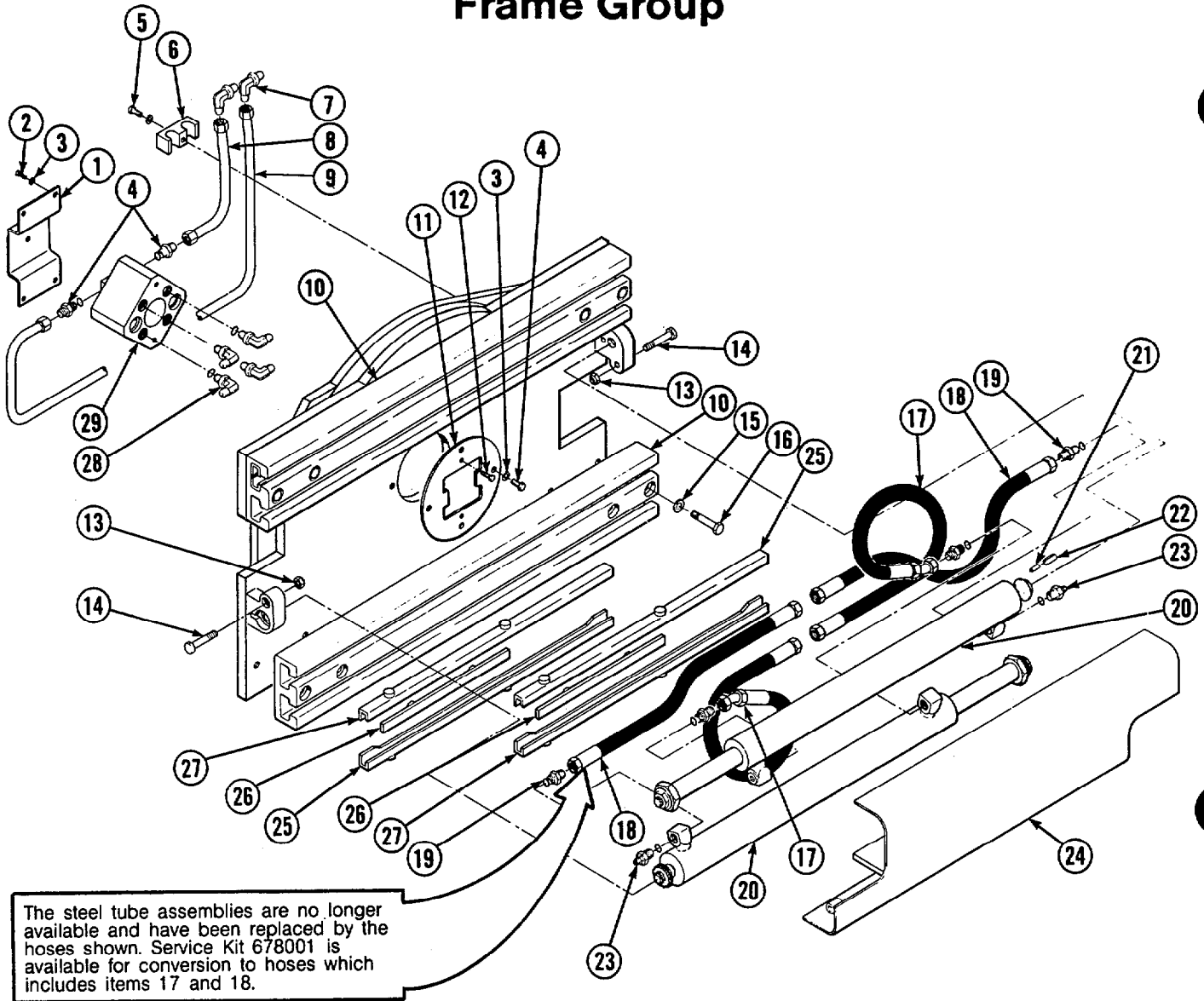
35D

REF	QTY	PART NO.	DESCRIPTION	REF	QTY	PART NO.	DESCRIPTION
		670946	Frame Group	17	2	677995	Hose
1	1	670939	Bracket	18	2	678027	Hose
2	8	3574	Capscrew, 5/16 NC x .62	19	4	611288	Fitting, 6-8
3	9	6287	Lockwasher	●20	2	667911	Cylinder
4	2	662187	Fitting, 8-6	21	2	7861	Roll Pin - Inner
5	1	3578	Capscrew, 5/16 NC x 1.25	22	2	7962	Roll Pin - Outer
6	1	629511	Bracket	■23	2	667609	Restrictor Cartridge
7	2	2440	Fitting, 8-8	24	1	667908	Bumper
8	1	670945	Tube	25	4	668910	Bearing
9	1	670944	Tube	25	4	667907	Bearing, Heavy Duty
10	2	674166	Frame	26	4	667663	Bearing
11	1	670938	Plate	27	4	668911	Bearing
12	2	4466	Capscrew, 3/8 NC x .50	27	4	667906	Bearing, Heavy Duty
13	2	665707	Nut	28	4	601676	Fitting, 6-6
14	2	3659	Capscrew, 1/2 NC x 2.50	★29	1	670940	Revolving Connection
15	8	667910	Washer	30	1	671519	Bumper, Optional
16	8	667909	Capscrew, 1/2 NC x 3.00	☆		678000	Hose Conversion Service Kit

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- See page 5 for replacement parts breakdown.
- See page 8 for replacement parts breakdown.
- ★ See page 9 for replacement parts breakdown.
- ☆ Includes items 17 and 18.

Frame Group



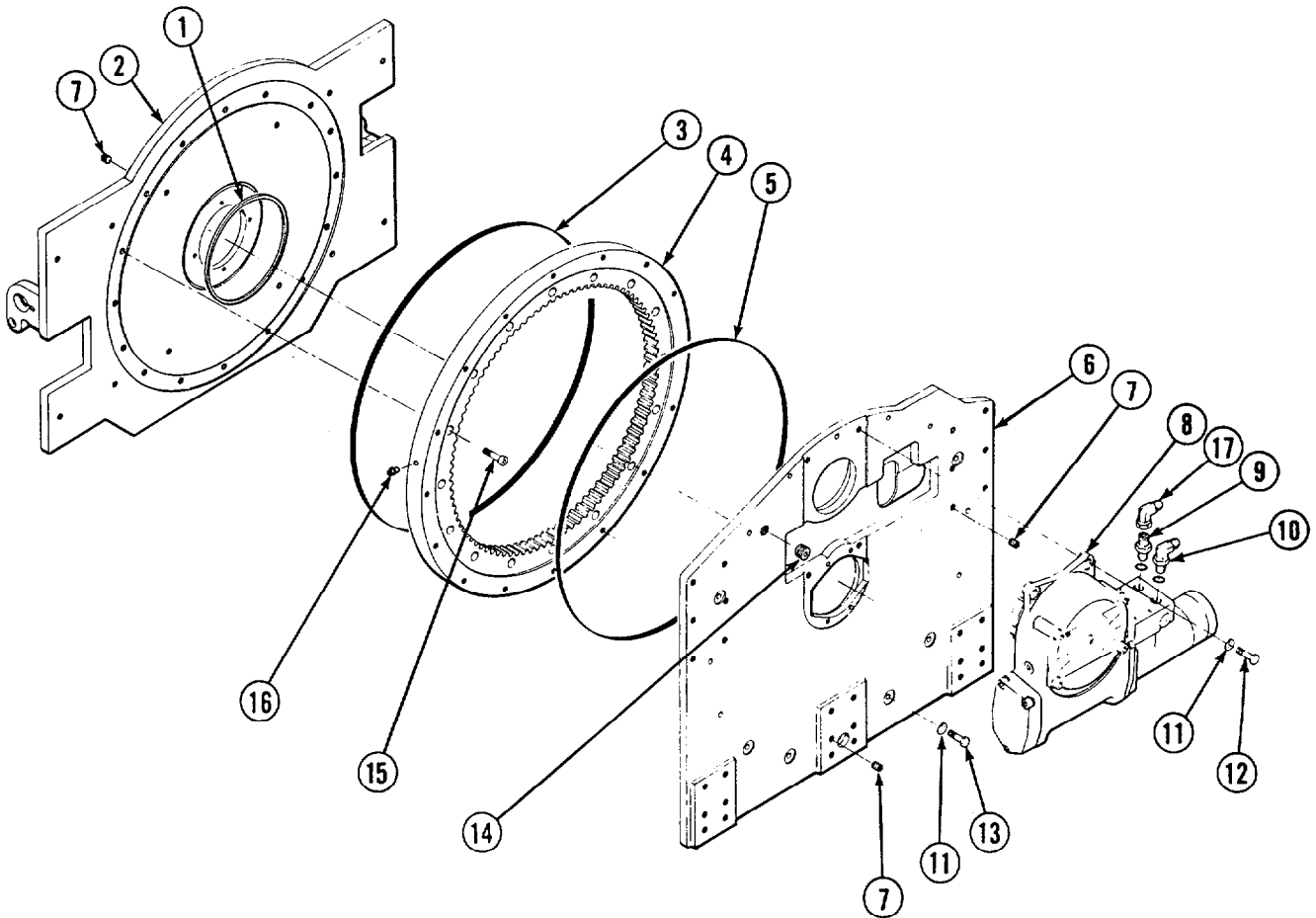
The steel tube assemblies are no longer available and have been replaced by the hoses shown. Service Kit 678001 is available for conversion to hoses which includes items 17 and 18.

50D							
REF	QTY	PART NO.	DESCRIPTION	REF	QTY	PART NO.	DESCRIPTION
		670935	Frame Group	17	2	677996	Hose
1	1	670939	Bracket	18	2	678027	Hose
2	8	3574	Capscrew, 5/16 NC x .62	19	4	611288	Fitting, 6-8
3	9	6287	Lockwasher, 5/16 ID	●20	2	667666	Cylinder
4	2	662187	Fitting, 8-6	21	2	7882	Roll Pin - Inner
5	1	3578	Capscrew, 5/16 NC x 1.25	22	2	7961	Roll Pin - Outer
6	1	629511	Bracket	■23	2	667609	Restrictor Cartridge
7	2	2440	Fitting, 8-8	24	1	667664	Bumper
8	1	670945	Tube	25	4	668904	Bearing
9	1	670944	Tube	25	4	667661	Bearing, Heavy Duty
10	2	674167	Frame	26	4	667663	Bearing
11	1	670938	Plate	27	4	668905	Bearing
12	2	4466	Capscrew, 3/8 NC x .50	27	4	667662	Bearing, Heavy Duty
13	2	665707	Nut	28	4	601676	Fitting, 6-6
14	2	3660	Capscrew, 1/2 NC x 2.75	★29	1	670940	Revolving Connection
15	8	667225	Washer	☆		678001	Hose Conversion Service Kit
16	8	667644	Capscrew, 5/8 NC x 3.25				

2567d

- See page 5 for replacement parts breakdown.
- See page 8 for replacement parts breakdown.
- ★ See page 9 for replacement parts breakdown.
- ☆ Includes items 17 and 18.

Rotator Group

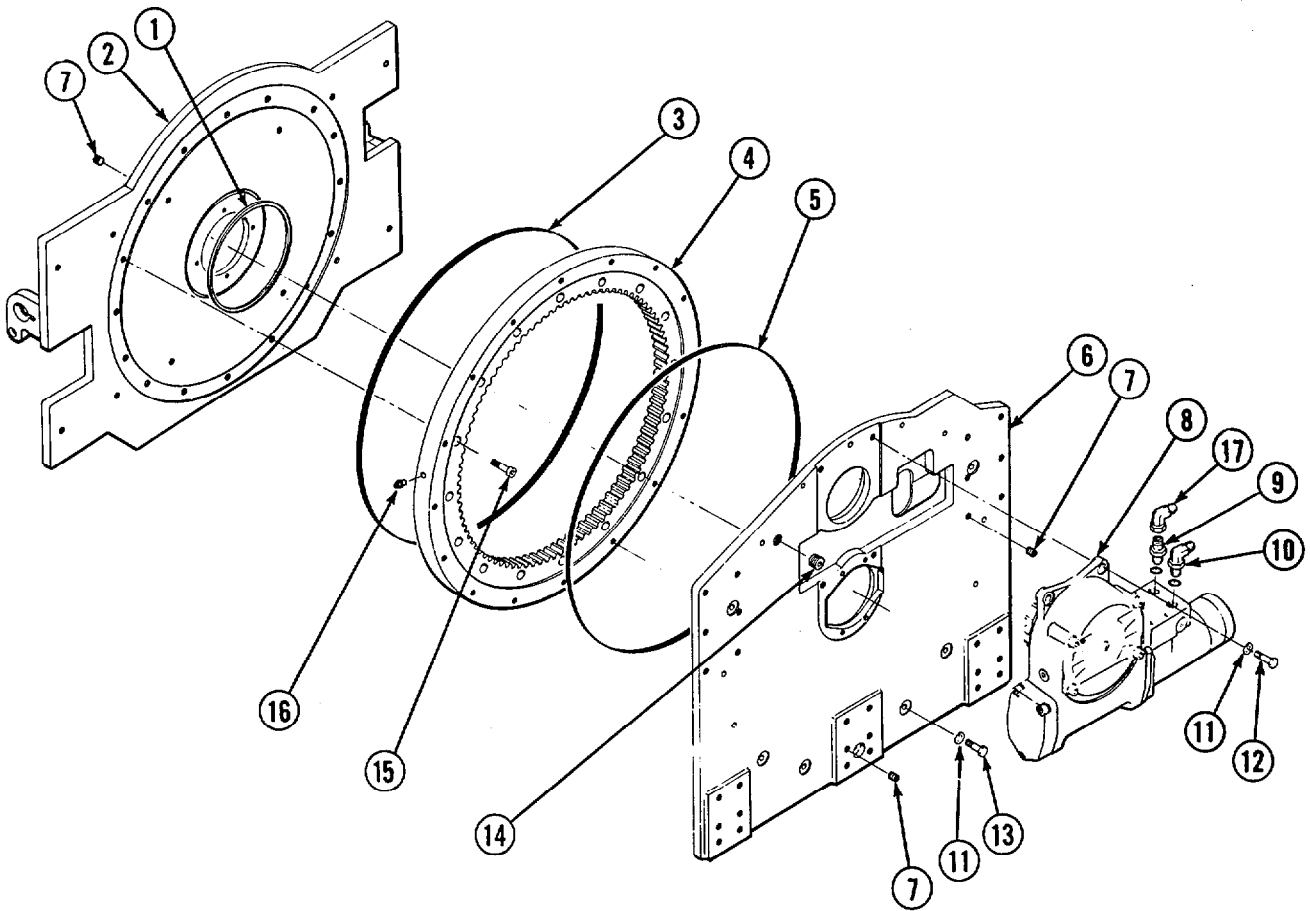


35D			
REF	QTY	PART NO.	DESCRIPTION
		675651	Rotator Group
1	1	670931	Seal
2	1	670933	Faceplate
3	1	670513	Seal
★ ■ 4	1	672828	Bearing Assembly
5	1	670514	Seal
6	1	670926	Baseplate
7	8	631385	Plug
● 8	1	675628	Drive Group
9	1	601377	Fitting, 8-8
10	1	601250	Fitting, 8-8
11	18	6290	Lockwasher, 1/2 ID
12	4	661742	Cap screw, 1/2 NC x 1.25 GR5
13	16	640013	Cap screw, 1/2 NC x 1.75 GR5
14	1	6605	Plug
★ 15	16	669322	Cap screw, 1/2 NC x 1.5
16	1	7401	Grease Fitting
17	1	605761	Fitting, 8-8
		672481	Bearing Service Kit

2567e

- Includes items 3 and 5.
- See page 6 for replacement parts breakdown.
- ★ Included in Bearing Service Kit 672481.

Rotator Group

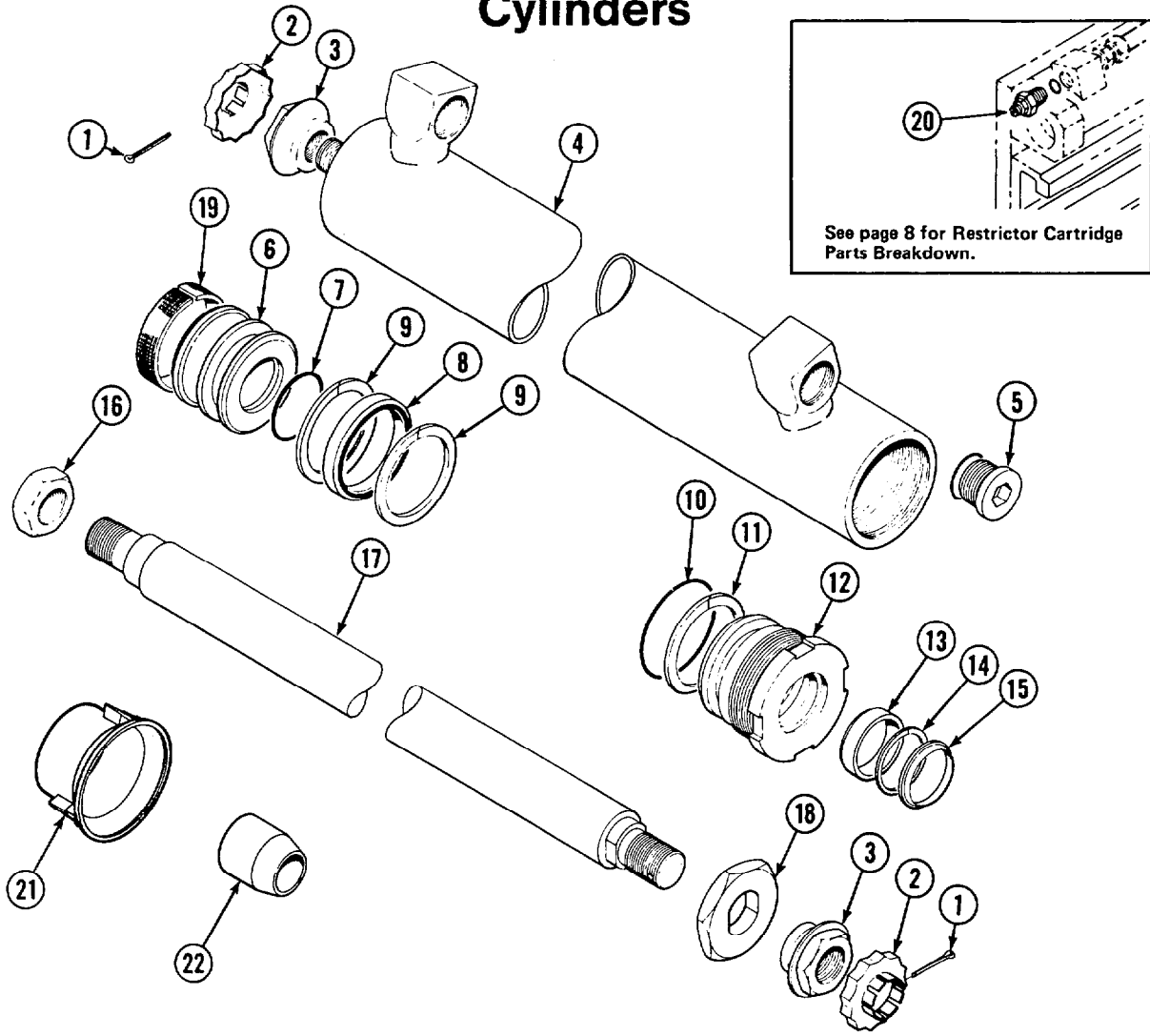


50D			
REF	QTY	PART NO.	DESCRIPTION
		675650	Rotator Group
1	1	670931	Seal
2	1	670924	Faceplate
3	1	670613	Seal
★■ 4	1	672828	Bearing Assembly
5	1	670514	Seal
6	1	670926	Baseplate
7	8	631385	Plug
● 8	1	675628	Drive Group
9	1	601377	Fitting, 8-8
10	1	601250	Fitting, 8-8
11	18	6290	Lockwasher, 1/2 ID
12	4	661742	Capscrew, 1/2 NC x 1.25 GR5
13	16	640013	Capscrew, 1/2 NC x 1.75 GR5
14	1	6605	Plug
★15	16	669322	Capscrew, 1/2 NC x 1.5
16	1	7401	Grease Fitting
17	1	605761	Fitting, 8-8
		672481	Bearing Service Kit

25671

- Includes items 3 and 5.
- See page 6 for replacement parts breakdown.
- ☆ Included in Bearing Service Kit 672481.

Cylinders



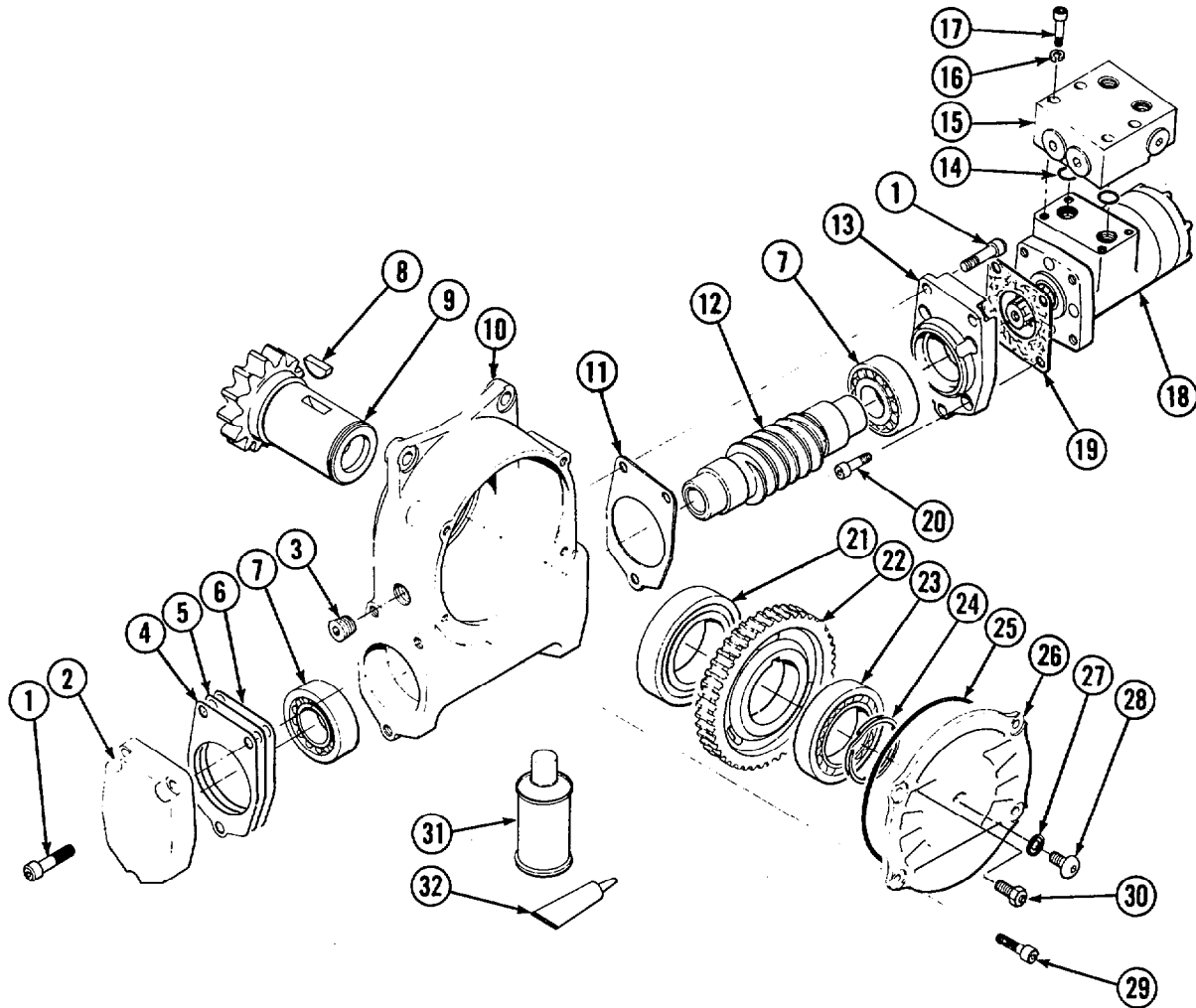
See page 8 for Restrictor Cartridge Parts Breakdown.

REF	QTY	35D PART NO.	50D PART NO.	DESCRIPTION
		667911	667666	Cylinder Assy.
■ 1	2	6510	6511	Cotter Pin, 3/32 x 1.25
■ 2	2	667624	667667	Retainer
■ 3	2	667625	667668	Nut
4	1	558758	553760	Shell
5	1	602580	602580	Plug
6	1	670891	670893	Piston
● 7	1	2716	2722	O-Ring
● 8	1	662454	662457	Seal
● 9	2	638249	638250	Nylon Ring
● 10	1	2787	2791	O-Ring
● 11	1	615130	615134	Back-Up Ring
12	1	667917	667675	Retainer
● 13	1	662448	662451	Seal
● 14	1	638243	638246	Nylon Ring
● 15	1	636853	628047	Wiper
16	1	667623	667665	Nut
17	1	667914	667670	Rod
18	1	667626	667676	Washer
● 19	1	660761	660764	Bearing
★ 20	2	667609	667609	Restrictor Cartridge
● 21	1	671049	671049	Seal Loader-Piston
● 22	1	671052	671052	Seal Loader-Retainer
		667995	667723	Service Kit
		668926	668925	Nut Service Kit

- Included in Service Kit.
- Included in Nut Service Kit.
- ★ Not included in Cylinder Assembly. See page 8 for replacement parts breakdown.

2258g

Drive Group



35D/50D

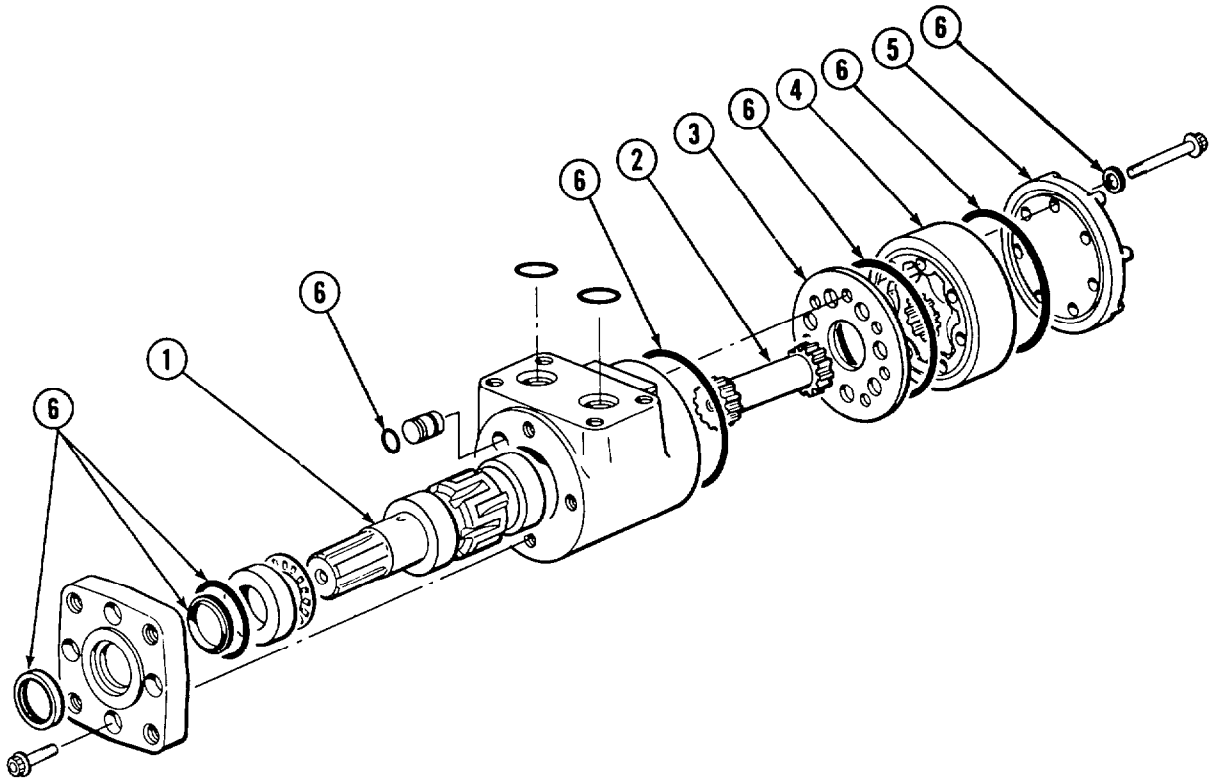
REF	QTY	PART NO.	DESCRIPTION	REF	QTY	PART NO.	DESCRIPTION
		675628	Drive Group with Motor	‡18	1	675329	Drive Motor
	□	675631	Drive Group without Motor	19	1	670575	Gasket
1	6	607071	Capscrew, 7/16 NC x 1.0 GR8	20	4	4468	Capscrew, 3/8 NC x .75
2	1	676855	Cover	■21	1	670580	Bearing
3	1	6609	Plug	22	1	675609	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	670567	Cover
8	1	670582	Key	27	1	603680	Seal
9	1	670506	Pinion	28	1	4874	Capscrew, 3/8 NC x .50 GR8
10	1	670565	Housing	29	4	671535	Capscrew, 5/16 NC x .75
11	1	670574	Shim - .010" (Brown)	30	1	644010	Relief Fitting
12	1	675608	Worm	31	1	656300	Gear Box Lube - 48 oz.
13	1	670570	Adapter	★ ■32	1	668184	Sealant
14	2	2705	Seal	†		670578	Shim Service Kit
☆15	1	670549	Check Valve			675637	Service Kit
16	4	6444	Lockwasher			675638	Service Kit
17	4	607059	Capscrew, 5/16 NC x 1.75 GR8	§		675343	Drive Motor Service Kit

2567h

- Quantity as required.
- Included in Bearing Service Kit 675637
- † Included in Bearing Service Kit 675638
- ★ Included in Shim Service Kit 670578.
- ☆ See page 8 for replacement parts breakdown.
- ‡ See page 7 for replacement parts breakdown.
- Includes all items except 15, 17, and 18.
- § Includes items 11, 14, 18, 19 and 32.



Drive Motor

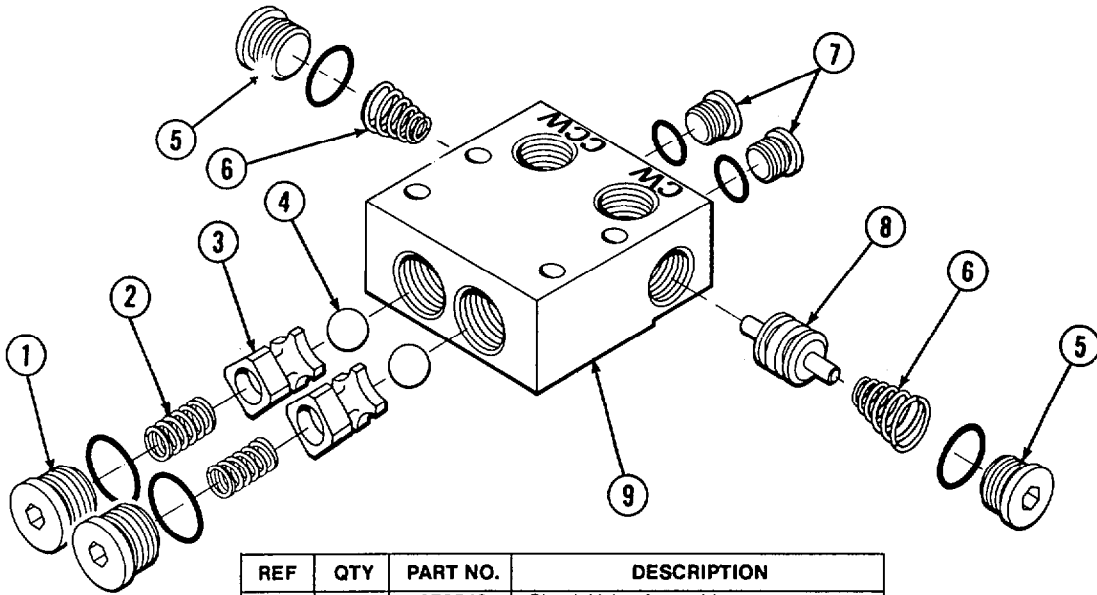


REF	QTY	PART NO.	DESCRIPTION
		675329	Drive Motor
1	1	675478	Shaft
2	1	675477	Drive
3	1	675479	Spacer Plate
4	1	675480	Gerotor Set
5	1	675482	End Cap
6	1	675474	Seal Kit

2258i

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.

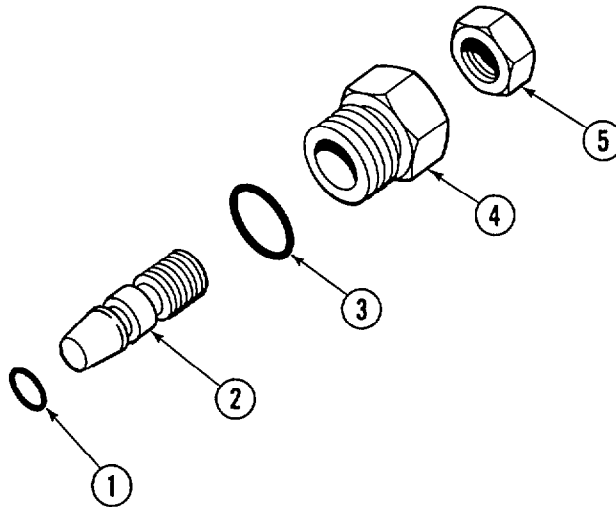
Check Valve



REF	QTY	PART NO.	DESCRIPTION
		670549	Check Valve Assembly
1	2	609453	Plug
2	2	670552	Spring
3	2	670551	Guide
4	2	7020	Ball
5	2	602580	Plug
6	2	673989	Spring
7	2	604510	Plug
8	1	670553	Spool
9	1	670550	Body

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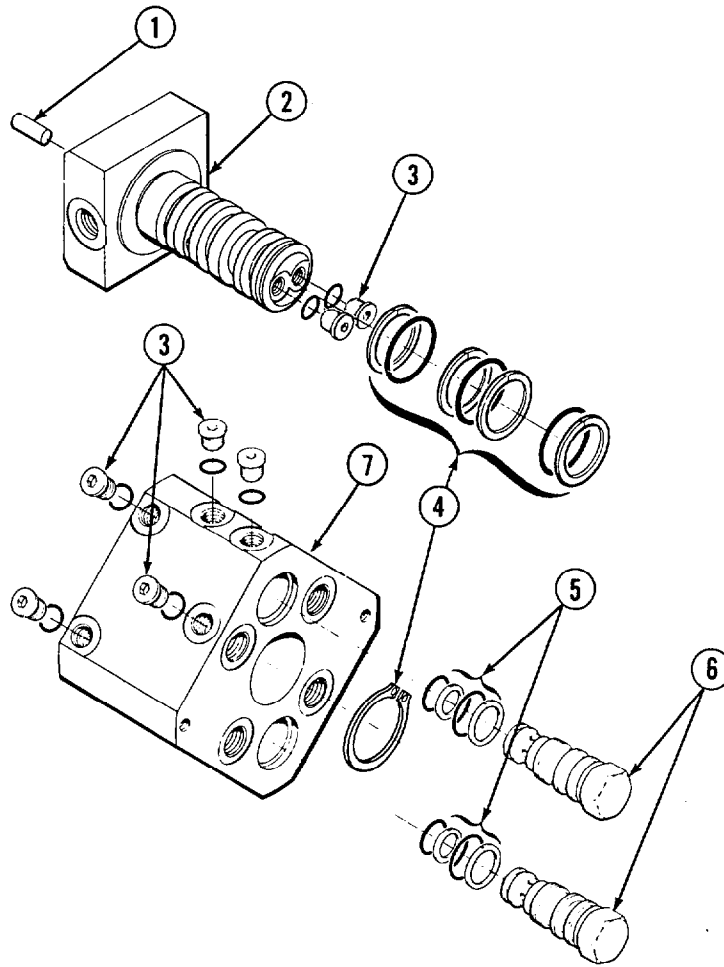
Restrictor Cartridge



REF	QTY	PART NO.	DESCRIPTION
	1	667609	Restrictor Cartridge
1	1	2701	O-Ring
2	1	667611	Plunger
3	1	2841	O-Ring
4	1	667610	Plug - Special
5	1	5716	Jam Nut

22581

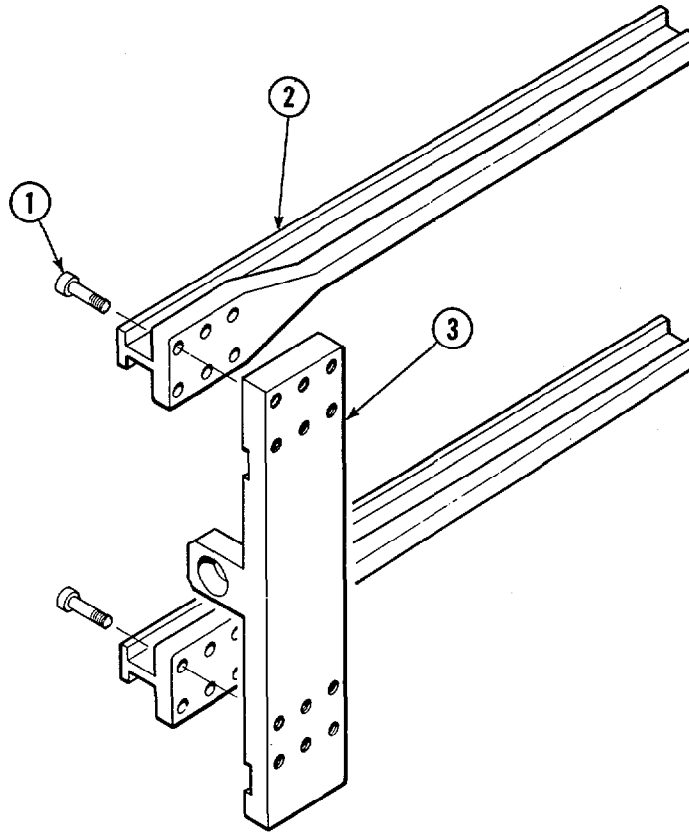
Revolving Connection




REF	QTY	PART NO.	DESCRIPTION
		670940	Revolving Connection
1	1	606805	Dowel Pin
2	1	670942	Shaft
3	7	663694	Plug
4	1	660476	Shaft Service Kit
5	2	667516	Check Valve Service Kit
6	2	678376	Check Valve
7	1	670941	Body

22581

Bolt-On Arm Bases



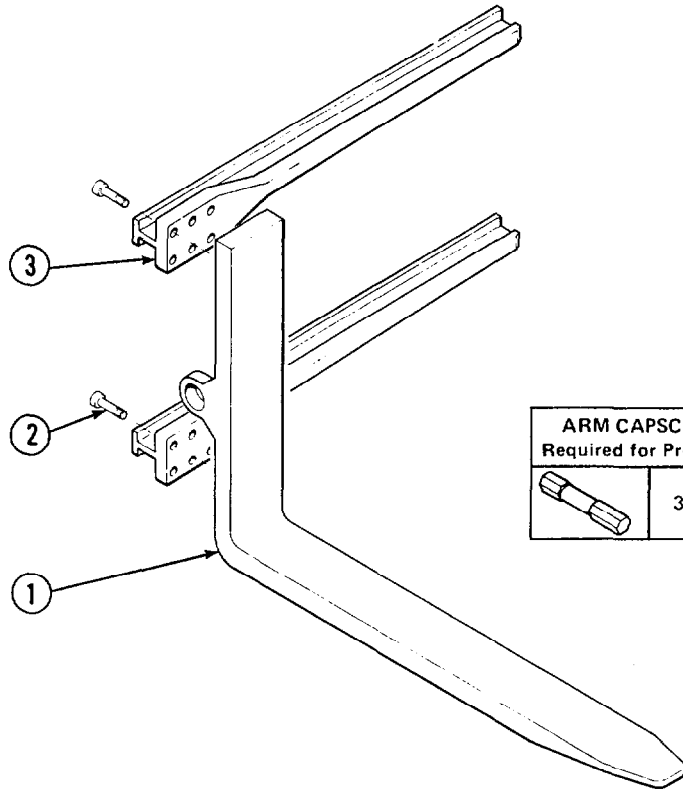
ARM CAPSCREW EXTENSION TOOL Required for Proper Torquing of Capscrews		
	35-50D	667699


REF	QTY	35D PART NO.	50D PART NO.	DESCRIPTION
		● 668329	● 668328	Arm Base Assy. (pair)
1	24	607103	—	Capscrew, 3/4 NC x 1.50 GR8
1	24	—	607105	Capscrew, 3/4 NC x 2.00 GR8
2	4	667905	667700	Arm Bar
3	2	668135	668134	Arm Base

2258j

● Includes items 1 and 3 only.

Bolt-On Pallet Forks



ARM CAPSCREW EXTENSION TOOL Required for Proper Torquing of Capscrews		
	35-50D	667699

35D					
REF	QTY	36" PART NO.	42" PART NO.	48" PART NO.	DESCRIPTION
		●670958	●670959	●670960	Pallet Fork Assy. (pair)
1	1	670951	670952	670953	Pallet Fork R.H.
1	1	670948	670949	670950	Pallet Fork L.H.
2	24	607103	607103	607103	Capscrew, 3/4 NC x 1.50 GR8
3	4	667905	667905	667905	Arm Bar

● Includes Item 1 and 2 only

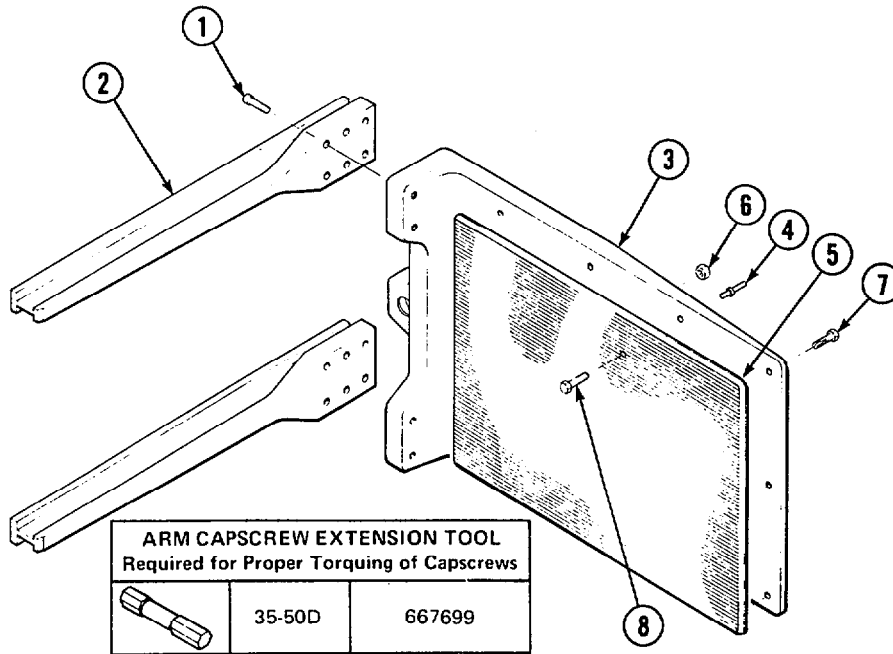
2258k


50D					
REF	QTY	42" PART NO.	48" PART NO.	DESCRIPTION	
		●670961	●670962	Pallet Fork Assy. (pair)	
1	1	670956	670957	Pallet Fork R.H.	
1	1	670954	670955	Pallet Fork L.H.	
2	24	607105	607105	Capscrew, 3/4 NC x 2.00 GR8	
3	4	667700	667700	Arm Bar	

● Includes Items 1 and 2 only

2258k

Bolt-on Multi-Purpose/Rigid Arms



ARM CAPSCREW EXTENSION TOOL Required for Proper Torquing of Capscrews		
	35-50D	667699

35D					
REF	QTY	18 x 30 [□] PART NO.	18 x 36 [□] PART NO.	18 x 46 [□] PART NO.	DESCRIPTION
		●671656	●671657	●671658	Arm Assy. (pair)
1	24	607103	607103	607103	Capscrew, 3/4 NC x 1.50 GR8
2	4	667905	667905	667905	Arm Bar
3	2	671672	671673	671674	Arm
4	24	667843	—	—	★Rivet
	30	—	667843	—	★Rivet
	36	—	—	667843	★Rivet
5	2	667877	671686	667879	Contact Pad
6	18	15250	—	—	Nut, 1/4 NF
	24	—	15250	—	Nut, 1/4 NF
	30	—	—	15250	Nut, 1/4 NF
7	6	677589	677589	677589	Capscrew, 1/4 NC x .50 GR5
8	18	3203	—	—	Capscrew, 1/4 NF x .75 GR5
	24	—	3203	—	Capscrew, 1/4 NF x .75 GR5
	30	—	—	3203	Capscrew, 1/4 NF x .75 GR5
		■669683	■672611	■669685	Service Kit, Contact Pad

- Includes items 1, 3, 4, and 5 only.
- Service Kit includes (1) Contact Pad and required rivets, capscrews and nuts.
- ★ Steel self-plugging rivets with steel mandrels, 3/16 dia. x 3/8-1/2 grip.
- Height x Length.

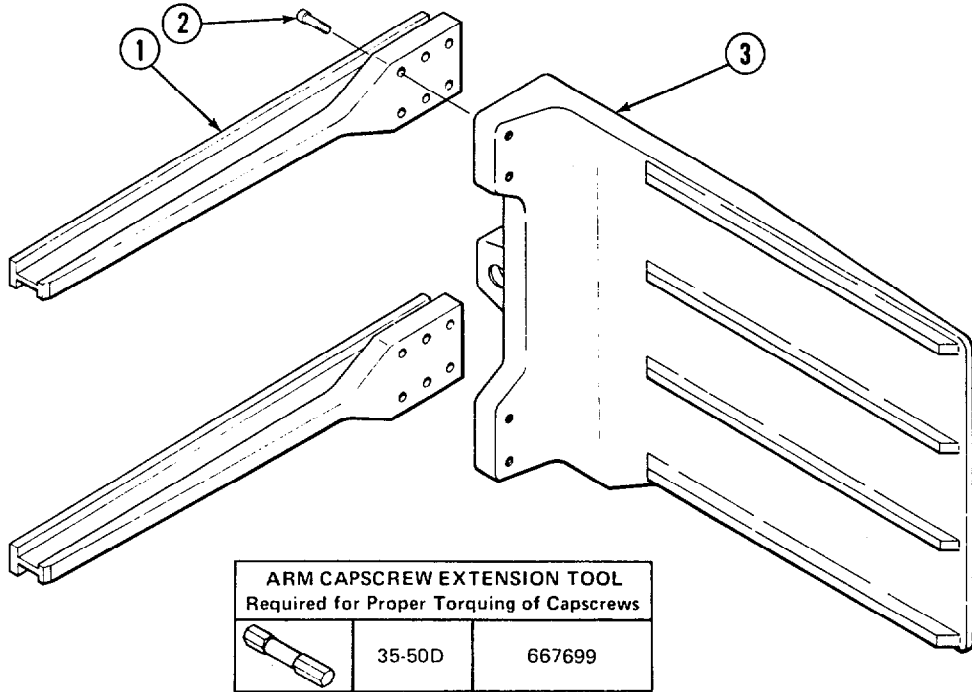
2567

50D					
REF	QTY	18 x 30 [□] PART NO.	18 x 38 [□] PART NO.	18 x 46 [□] PART NO.	DESCRIPTION
		●671659	●671660	●671661	Arm Assy. (pair)
1	24	607105	607105	607105	Capscrew, 3/4 NC x 2.00 GR8
2	4	667700	667700	667700	Arm Bar
3	2	671675	671676	671677	Arm
4	24	667843	—	—	★Rivet
	30	—	667843	—	★Rivet
	36	—	—	667843	★Rivet
5	2	667877	667878	667879	Contact Pad
6	18	15250	—	—	Nut, 1/4 NF
	24	—	15250	—	Nut, 1/4 NF
	30	—	—	15250	Nut, 1/4 NF
7	6	677589	677589	677589	Capscrew, 1/4 NC x .50 GR5
8	18	3203	—	—	Capscrew, 1/4 NF x .75 GR5
	24	—	3203	—	Capscrew, 1/4 NF x .75 GR5
	30	—	—	3203	Capscrew, 1/4 NF x .75 GR5
		■669683	■669684	■669845	Service Kit, Contact Pad

- Includes items 1, 3, 4, and 5 only.
- Service Kit includes (1) Contact Pad and required rivets, capscrews and nuts.
- ★ Steel self-plugging rivets with steel mandrels, 3/16 dia. x 3/8-1/2 grip.
- Height x Length.

2567

Bolt-On Bale Arms



35D						
REF	QTY	27" PART NO.	31" PART NO.	39" PART NO.	47" PART NO.	DESCRIPTION
		●671031	●671761	●671762	●671763	Bale Arm Assy. (pair)
1	4	667905	667905	667905	667905	Arm Bar
2	24	607103	607103	607103	607103	Capscrew, 3/4 NC x 1.50 GR8
3	2	672032	671770	671771	671772	Arm

2258m

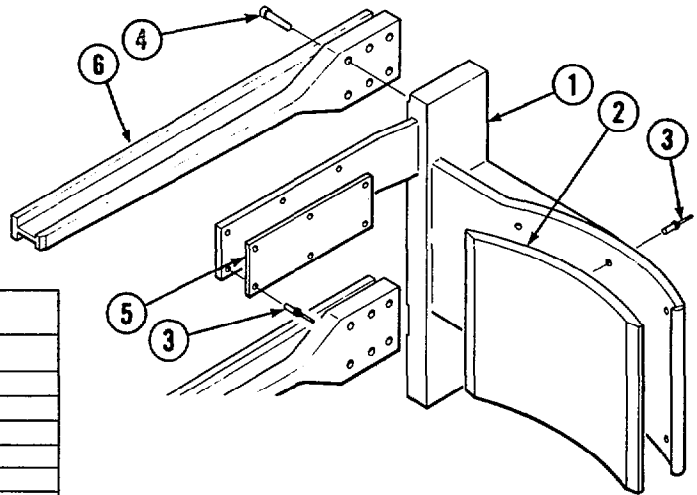
● Includes items 2 and 3 only.

50D						
REF	QTY	27" PART NO.	31" PART NO.	39" PART NO.	47" PART NO.	DESCRIPTION
		●671764	●671765	●671766	●671767	Bale Arm Assy. (pair)
1	4	667700	667700	667700	667700	Arm Bar
2	24	607105	607105	607105	607105	Capscrew, 3/4 NC x 2.00 GR8
3	2	671773	671774	671775	671776	Arm

2258m

● Includes items 2 and 3 only.

Two-Drum Arms




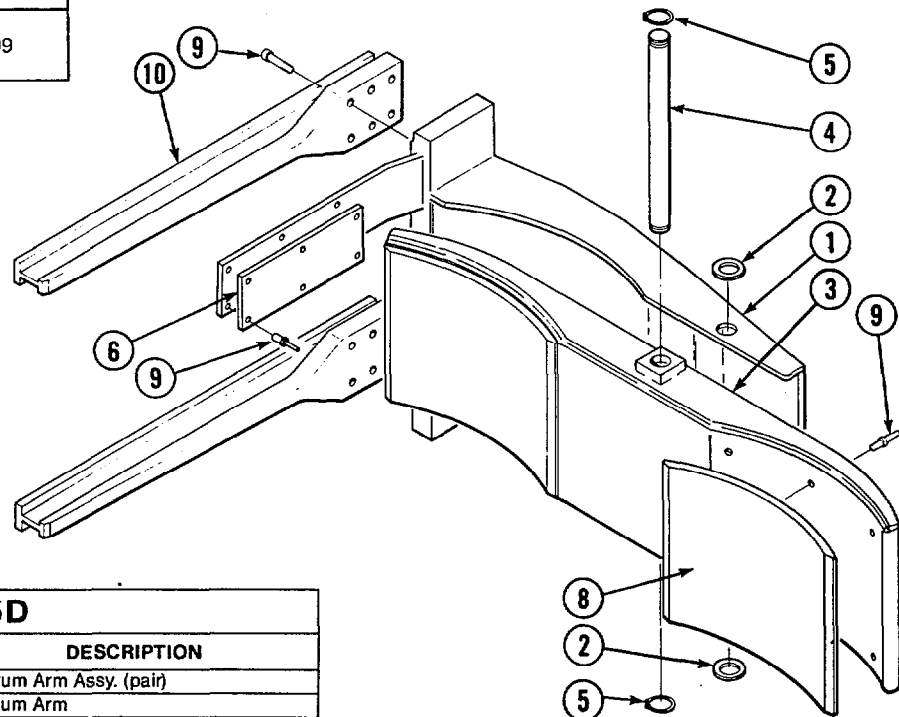
35D			
REF	QTY	PART NO.	DESCRIPTION
		●673087	Drum Arm Assy. (pair)
1	2	673121	Drum Arm
3	4	672932	Contact Pad
3	24	667843	★Rivet
4	24	607103	Capscrew
5	2	672929	Pad
6	4	667905	Arm Bar

2258n

- Includes items 1 through 5 only.
- ★ Steel self-plugging rivets with steel mandrels, 3/16 dia. x 3/8-1/2 grip.

Four-Drum Arms

ARM CAPSCREW EXTENSION TOOL Required for Proper Torquing of Capscrews		
	35-50D	667699



35D			
REF	QTY	PART NO.	DESCRIPTION
		●672924	Drum Arm Assy. (pair)
1	2	672936	Drum Arm
2	4	672963	Washer
3	2	672935	Equalizer
4	2	672926	Pin
5	4	7190	Retaining Ring
6	2	672929	Pad
7	36	667843	★Rivet
8	4	672932	Contact Pad
9	24	607103	Capscrew
10	4	667905	Arm Bar

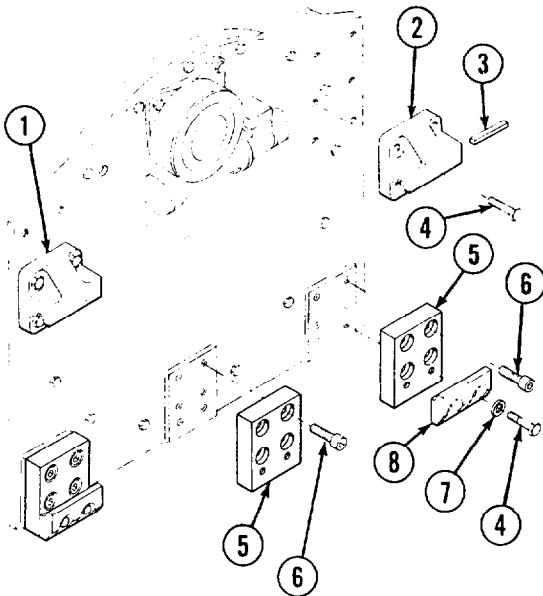
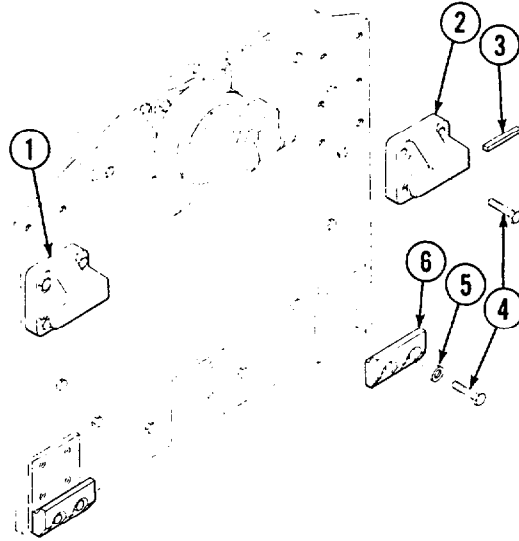
2258n

- Includes items 1 through 8 only.
- ★ Steel self-plugging rivets with steel mandrels, 3/16 dia. x 3/8-1/2 grip.

Mounting Groups

35/50D Class II, 4°			
REF	QTY	PART NO.	DESCRIPTION
		670519	Mounting Group
1	1	670523	Upper Hook - L.H.
2	1	670524	Upper Hook - R.H.
3	1	669344	Stop Kit
4	12	667765	Capscrew, 5/8 NC x 1.5 GR5
5	4	667225	Washer
6	2	667370	Lower Hook

2258o



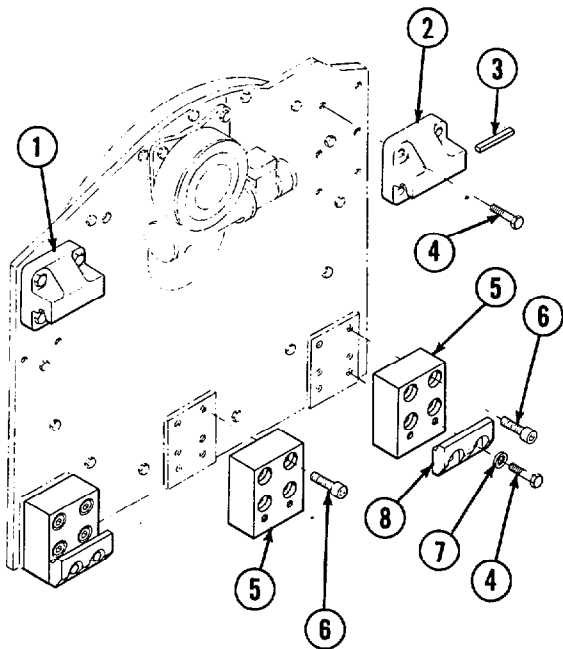
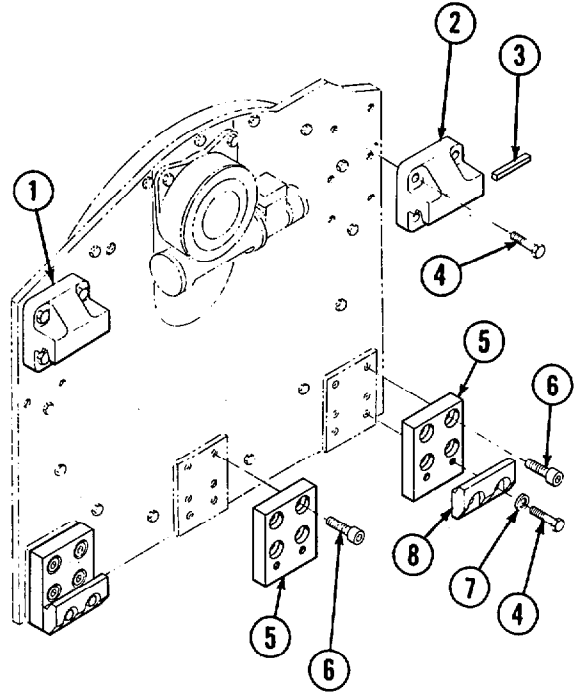
35/50D Class II, 0°			
REF	QTY	PART NO.	DESCRIPTION
		670520	Mounting Group
1	1	670523	Upper Hook - L.H.
2	1	670524	Upper Hook - R.H.
3	1	669344	Stop Kit
4	12	667765	Capscrew, 5/8 NC x 1.5 GR5
5	3	670526	Adapter Plate
6	12	622467	Capscrew, 5/8 NC x 1.25
7	4	667225	Washer
8	2	667370	Lower Hook

2258o

Mounting Groups

50D Class III, 4°			
REF	QTY	PART NO.	DESCRIPTION
		670521	Mounting Group
1	1	670527	Upper Hook - L.H.
2	1	670528	Upper Hook - R.H.
3	1	669344	Stop Kit
4	12	667369	Capscrew, 5/8 NC x 1.25 GR5
5	3	670530	Adapter Plate
6	12	622467	Capscrew, 5/8 NC 1.25
7	4	667225	Washer
8	2	667371	Lower Hook

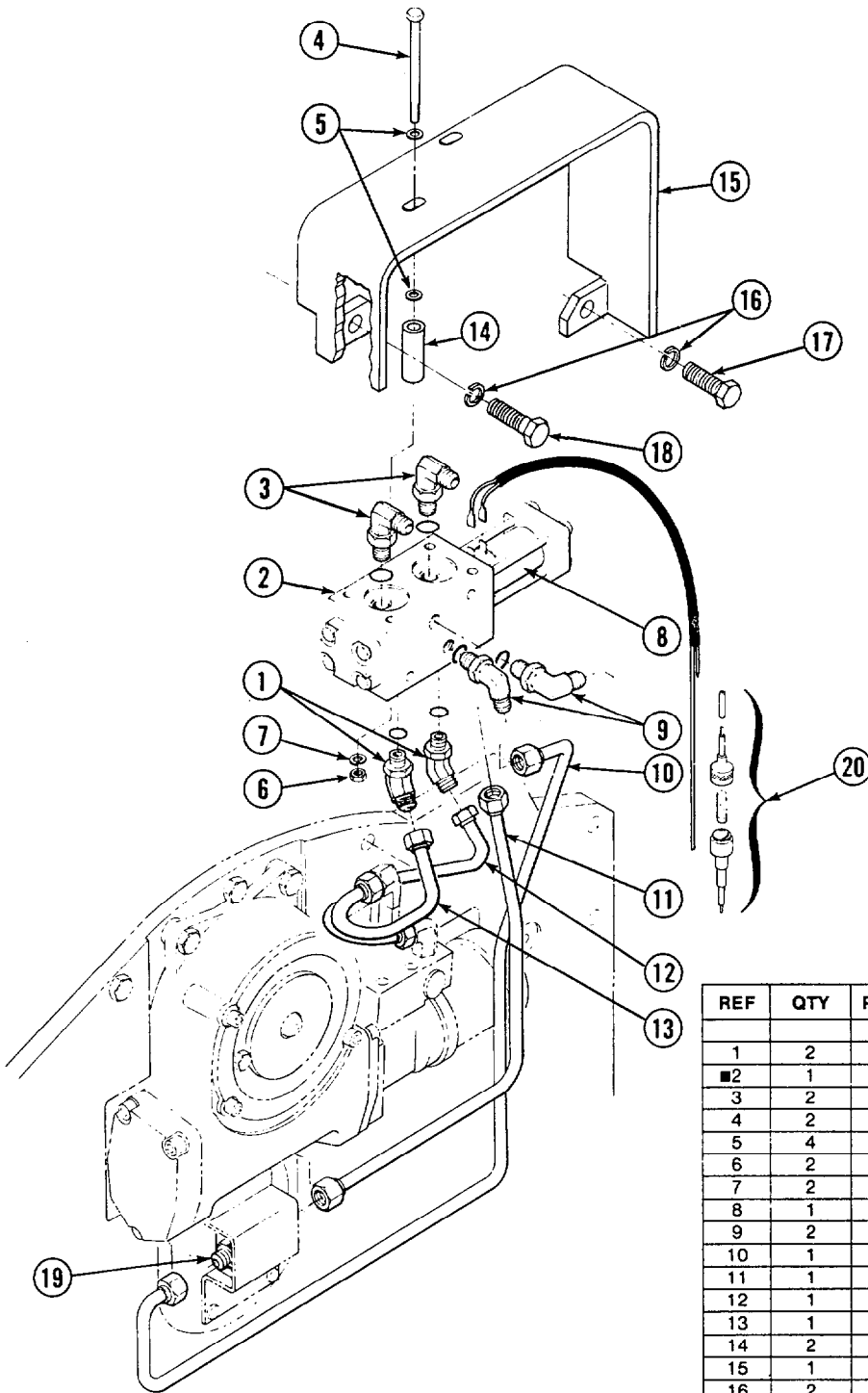
2258p



50D Class III, 0°			
REF	QTY	PART NO.	DESCRIPTION
		670522	Mounting Group
1	1	670527	Upper Hook - L.H.
2	1	670528	Upper Hook - R.H.
3	1	669344	Stop Kit
4	12	667369	Capscrew, 5/8 NC x 1.25 GR5
5	3	670532	Adapter Plate
6	12	624337	Capscrew, 5/8 NC x 2.25
7	4	667225	Washer
8	2	667371	Lower Hook

2258p

Solenoid Adaption

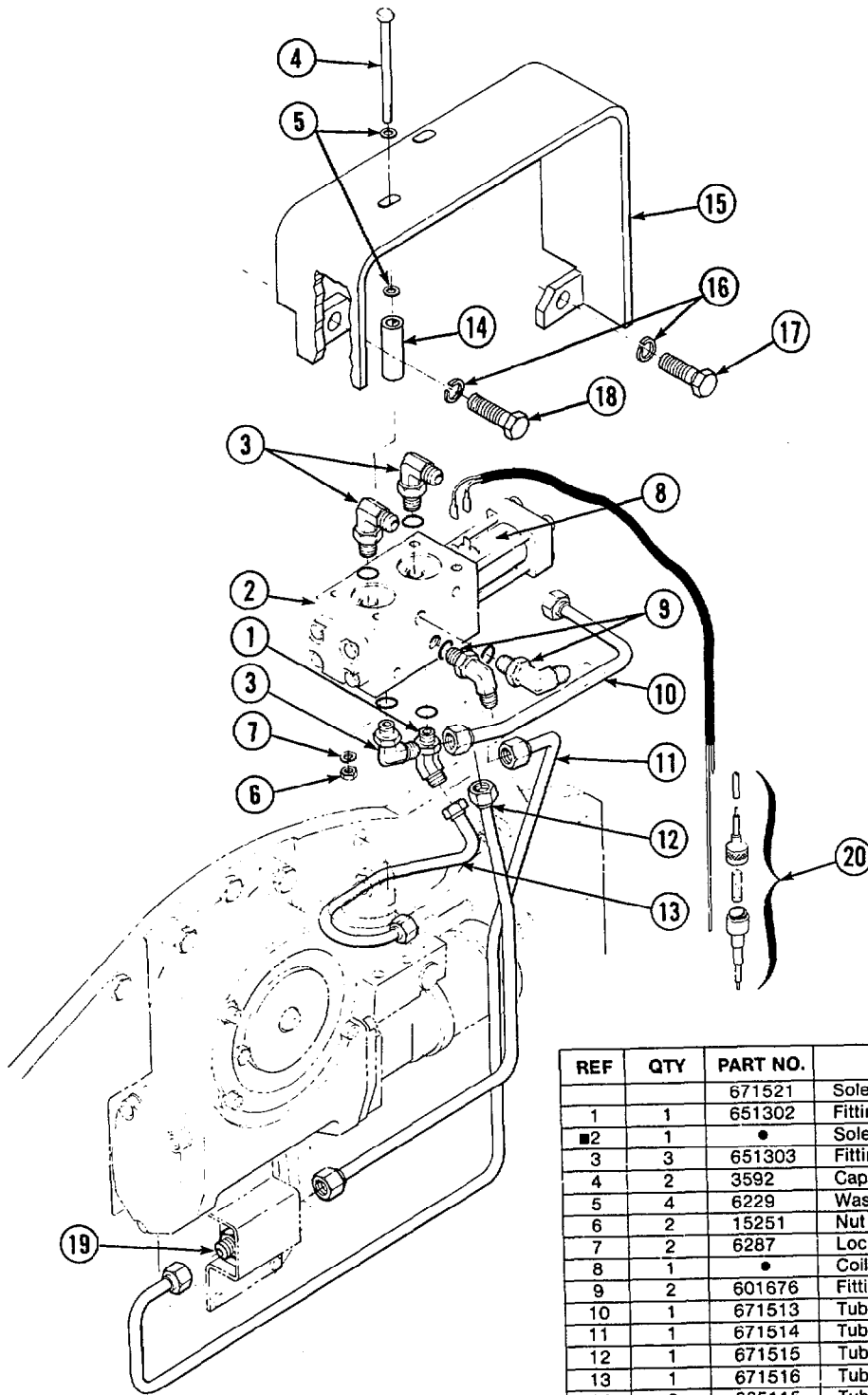


REF	QTY	PART NO.	DESCRIPTION
		671520	Solenoid Adaption Group
1	2	651302	Fitting
■2	1	●	Solenoid Valve
3	2	651303	Fitting
4	2	3592	Capscrew, 5/16 NC x 5.50
5	4	6229	Washer
6	2	15251	Nut
7	2	6287	Lockwasher
8	1	●	Coil
9	2	601676	Fitting
10	1	671514	Tube
11	1	671515	Tube
12	1	671516	Tube
13	1	671512	Tube
14	2	665115	Tube
15	1	675411	Guard
16	2	6290	Lockwasher
17	1	601854	Capscrew, 1/2 NC x 1.0
18	1	636408	Capscrew, 1/2 NC x 2.0
19	2	604511	Fitting
20	1	677573	Fuse Assembly (7.5 AMP)

2567s

- See page 19.
- Includes item 8.

Solenoid Adaption for 180° Stop Group

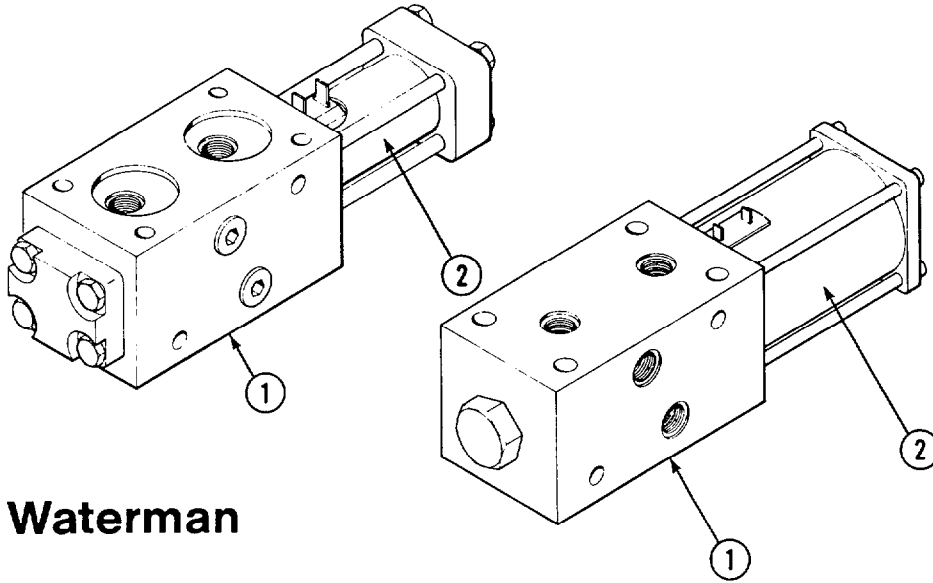


REF	QTY	PART NO.	DESCRIPTION
		671521	Solenoid Adaption Group
1	1	651302	Fitting
■2	1	●	Solenoid Valve
3	3	651303	Fitting
4	2	3592	Capcrew, 5/16 NC x 5.50
5	4	6229	Washer
6	2	15251	Nut
7	2	6287	Lockwasher
8	1	●	Coil
9	2	601676	Fitting
10	1	671513	Tube
11	1	671514	Tube
12	1	671515	Tube
13	1	671516	Tube
14	2	665115	Tube
15	1	675411	Guard
16	2	6290	Lockwasher
17	1	601854	Capcrew, 1/2 NC x 1.0
18	1	636408	Capcrew, 1/2 NC x 2.0
19	2	604511	Fitting
20	1	677573	Fuse Assembly (7.5 AMP)

25671

- See page 19.
- Includes item 8.

Solenoid Valves



Waterman

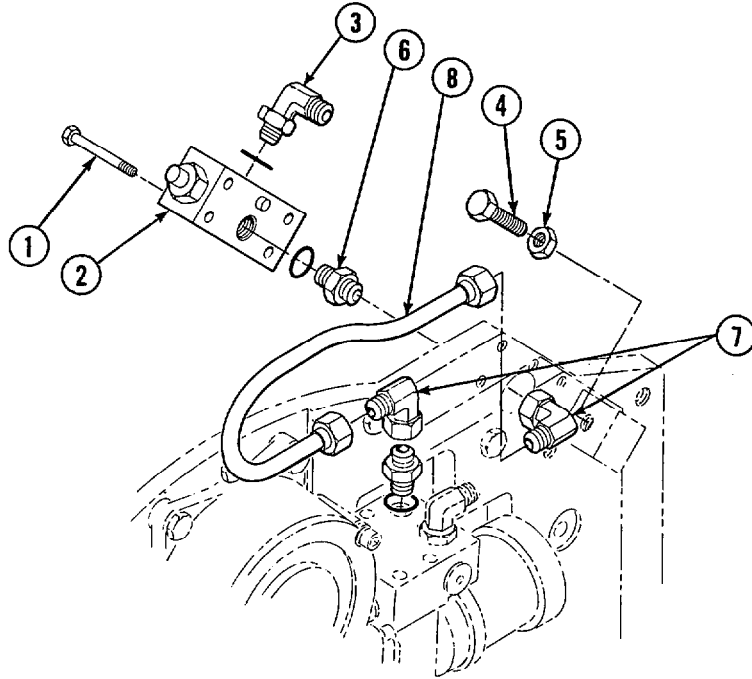
Racine

Note: Racine and Waterman Solenoid Valve assemblies are interchangeable as a unit. Coils must match valve.

REF	QTY	Waterman PART NO.	Racine PART NO.	DESCRIPTION
	1	614089	614089	Solenoid Valve - 12V
1	1	614091	614091	Solenoid Valve - 24V
1	1	614092	614092	Solenoid Valve - 36V
1	1	614093	614093	Solenoid Valve - 48V
1	1	614094	—	Solenoid Valve - 72V
2	1	611458	665044	Coil - 12V
2	1	611460	665045	Coil - 24V
2	1	611461	665046	Coil - 36V
2	1	614097	665047	Coil - 48V
2	1	614098	—	Coil - 72V

2258x

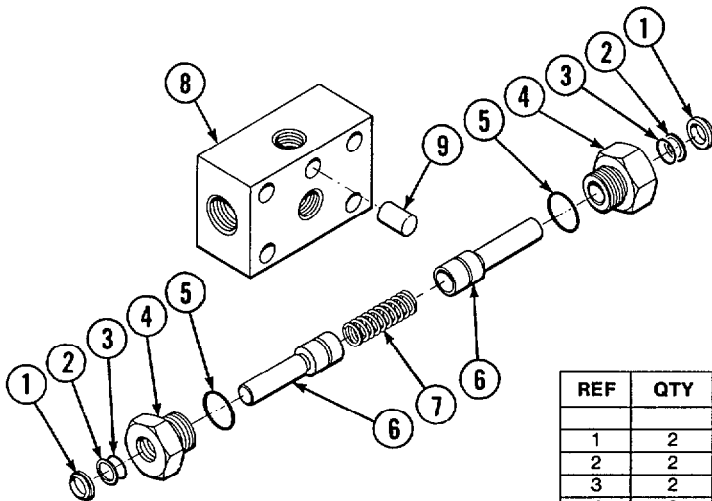
180° Stop Group



REF	QTY	PART NO.	DESCRIPTION
		670545	Stop Group
1	4	670544	Capscrew, 3/8 NC x 1.75
2	1	670537	Stop Valve Assembly
3	1	651303	Fitting, 8-6
4	2	3710	Capscrew, 5/8 NC x 1.75
5	2	5932	Nut, 5/8 NC
6	1	662187	Fitting, 8-6
7	2	605761	Fitting, 8-8
8	1	670543	Tube Assembly

2 36q

Stop Valve



REF	QTY	PART NO.	DESCRIPTION
		670537	Stop Valve Assembly
1	2	670541	Wiper Ring
2	2	615006	Back-Up Ring
3	2	2702	O-Ring
4	2	670540	Gland
5	2	2841	O-Ring
6	2	670539	Plunger
7	1	670542	Spring
8	1	670538	Body
9	1	611210	Pin

2258q

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