



McElroy Manufacturing, Inc.

The leader by design.

Tulsa, Oklahoma U.S.A.

DRAWN: SWB

CHECK: BWP

APPRVD: B

DATE: 5/16/95

SHT No: 1

REV No: Y

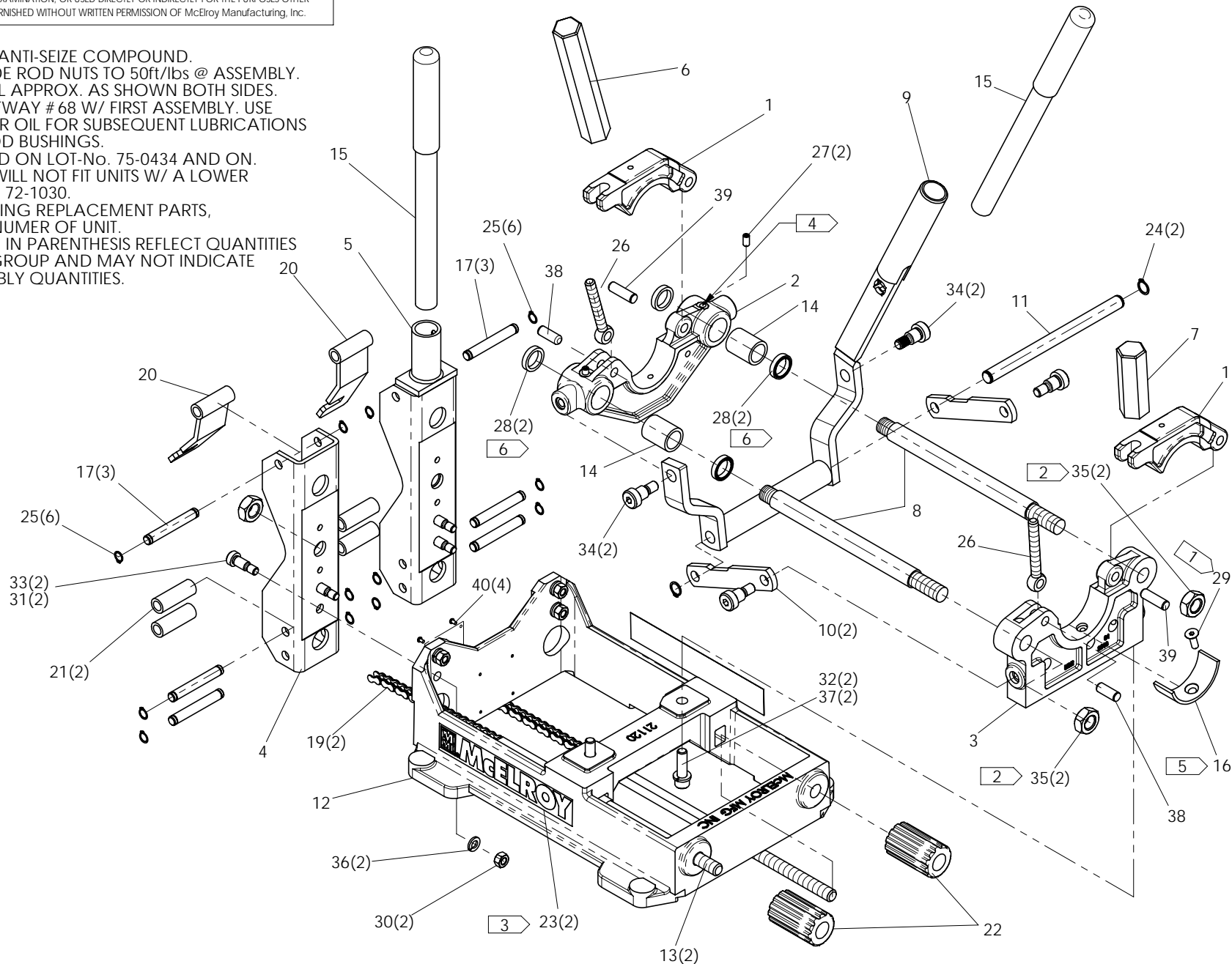
PART No: 200101

2" COMBINATION FUSION MACHINE ASSEMBLY

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NOTES:

1. INSTALL WITH ANTI-SEIZE COMPOUND.
2. TORQUE GUIDE ROD NUTS TO 50ft/lbs @ ASSEMBLY.
3. LOCATE LABEL APPROX. AS SHOWN BOTH SIDES.
4. LUBE W/ GULFWAY # 68 W/ FIRST ASSEMBLY. USE 10W30 MOTOR OIL FOR SUBSEQUENT LUBRICATIONS OF GUIDE ROD BUSHINGS.
5. THIS PART USED ON LOT-NO. 75-0434 AND ON.
6. THESE PARTS WILL NOT FIT UNITS W/ A LOWER LOT No. THAN 72-1030.
7. WHEN ORDERING REPLACEMENT PARTS, SPECIFY LOT NUMBER OF UNIT.
8. ITEMS SHOWN IN PARENTHESIS REFLECT QUANTITIES IN A LOCAL GROUP AND MAY NOT INDICATE TOTAL ASSEMBLY QUANTITIES.



2" COMBINATION FUSION MACHINE ASSEMBLYPARTS LIST

| ITEM | PART NO. | QTY | DESCRIPTION |
|------|---------------|-----|--|
| | 200101 | | Assembly |
| 1 | 201102 | 2 | UPPER JAW |
| 2 | 201204 | 1 | MOVABLE JAW |
| 3 | 201302 | 1 | FIXED JAW |
| 4 | 201401 | 1 | TAILSTOCK |
| 5 | 201402 | 1 | TAILSTOCK WELDMENT |
| 6 | A211601 | 1 | LONG CLAMP KNOB ASSEMBLY |
| 7 | A211501 | 1 | SHORT CLAMP KNOB ASSEMBLY |
| 8 | 201601 | 2 | GUIDE ROD |
| 9 | 201701 | 1 | HANDLE YOKE |
| 10 | 201801 | 2 | LINK |
| 11 | 201901 | 1 | TORQUE TUBE SHAFT |
| 12 | 211202 | 1 | BASE |
| 13 | 202101 | 2 | CHAIN VISE SCREW |
| 14 | 202401 | 2 | GUIDE ROD BUSHING |
| 15 | 202501 | 2 | LEVER HANDLE ASSEMBLY |
| 16 | 207701 | 1 | 2" I.P.S. INSERT |
| 17 | SW04101 | 6 | TAILSTOCK PIVOT PIN |
| 18 | A214001 | 1 | C.U. SCREW/DRIVER KIT (NOT SHOWN) |
| 19 | A213601 | 2 | SW, 2 , 4, 8 TAILSTOCK CHAIN ASSEMBLY |
| 20 | 401701 | 2 | CHAIN HOOK |
| 21 | 402101 | 4 | CHAIN GUIDE |
| 22 | A829001 | 2 | SHORT CLAMP KNOB ASSEMBLY |
| 23 | 8163118 | 2 | SMALL McELROY BRANDING LABEL |
| 24 | MCB00001 | 2 | EXT. SNAP RING |
| 25 | MCB00017 | 12 | EXT. SNAP RING |
| 26 | MJB00001 | 2 | EYEBOLT |
| 27 | MFA00001 | 2 | 1MPT PLUG |
| 28 | MDL00050 | 4 | ROD WIPER |
| 29 | MAD00044 | 1 | 1/4-20 NC X 3/4 LG. FHCS |
| 30 | MBA00006 | 4 | 5/16-18 NC HEX NUT |
| 31 | MBG00001 | 8 | 3/8 TYPE 'AN' FLAT WASHER |
| 32 | MAC00095 | 2 | 3/8-16 NC X 1 1/4 LG. SHCS |
| 33 | MAF00023 | 4 | 3/8 X 5/8 LG. SOCKET HEAD SHOULDER SCREW |
| 34 | MAF00041 | 4 | 1/2 X 1/2 LG. SOCKET HEAD SHOULDER SCREW |
| 35 | MBB00011 | 4 | 5/8-11 NC JAM NUT |
| 36 | MBE00006 | 4 | 5/16 LOCK WASHER |
| 37 | MBE00007 | 2 | 3/8 LOCK WASHER |
| 38 | MCK00015 | 2 | 3/8DIA X 1LG LOCK PIN |
| 39 | MCK00016 | 2 | 3/8DIA X 1-1/4LG LOCK PIN |
| 40 | MAH00093 | 4 | #4-40NCX3/16LG LOCK SCREW |

2" COMBINATION FUSION MACHINE ASSEMBLYPARTS LIST

| ITEM | PART NO. | QTY | DESCRIPTION |
|--|-------------|--|-------------|
| Replacement Assembly Part Numbers | | | |
| <u>PART NO.</u> | <u>QTY.</u> | <u>DESCRIPTION</u> | |
| A211901 | | 2 Lower Movable Jaw Assembly, including: | |
| MDL00050 | 4 ea. | Rod Wiper | |
| MFA00001 | 2 ea. | 1MPT Plug | |
| 201204 | 1ea. | Lower Movable Jaw | |
| 202401 | 2 ea. | Guide Rod Bushing | |
| A212001 | | 2 Lower Fixed Jaw Assembly, including: | |
| MAD00044 | 1ea. | 1/4-20NCX3/4LG FHSCS | |
| 201302 | 1 ea. | Lower Fixed Jaw | |
| 207701 | 1 ea. | 2" IPS Lower Insert | |
| A211601 | | Long Clamp Knob Assembly, including: | |
| 201501 | 1 ea. | Long Clamp Knob | |
| 202201 | 1 ea. | Bearing Assembly | |
| 202301 | 1 ea. | Clamp Knob Snap Ring | |
| A211501 | | Short Clamp Knob Assembly, including: | |
| 201502 | 1 ea. | Short Clamp Knob | |
| 202201 | 1 ea. | Bearing Assembly | |
| 202301 | 1 ea. | Clamp Knob Snap Ring | |
| A829001 | | Short Clamp Knob Assembly, including: | |
| 403101 | 1 ea. | Bearing Assembly | |
| 403201 | 1 ea. | Snap Ring | |
| 828901 | 1ea. | Short Clamp Knob | |
| A212101 | | 2 Upper/Lower Movable Jaw Assembly, including: | |
| A211601 | 1 ea. | Long Clamp Knob Assembly | |
| A211901 | 1 ea. | 2 Lower Movable Jaw Assembly | |
| MCK00015 | 1ea. | 3/8DIAX1LG Lock Pin | |
| MCK00016 | 1ea. | 3/8DIAX1-1/4LG Lock Pin | |
| MJB00001 | 1ea. | Eyebolt | |
| 201102 | 1ea. | Upper Jaw | |
| A212201 | | 2 Upper/Lower Fixed Jaw Assembly, including: | |
| A211501 | 1ea. | Short Clamp Knob Assembly | |
| A212001 | 1 ea. | 2 Lower Fixed Jaw Assembly | |
| MCK00015 | 1 ea. | 3/8DIAX1LG Lock Pin | |
| MCK00016 | 1 ea. | 3/8DIAX1-1/4LG Lock Pin | |
| MJB00001 | 1 ea. | Eyebolt | |
| 201102 | 1 ea. | Upper Jaw | |
| A213601 | | Tailstock Chain Assembly, including: | |
| MDG00011 | 2.5Ft. | #40 Roller Chain | |
| MDG00012 | 1 ea. | #40 Conn. Link | |

DRAWING REVISION HISTORY LISTING

PART NO: 200101
DESCRIPTION: 2" COMBINATION FUSION MACHINE ASSEMBLY

| <u>APPR.</u> | <u>REV</u> | <u>DATE</u> | <u>BY</u> | <u>DESCRIPTION OF REVISION</u> |
|--------------|------------|-------------|-----------|---|
| B | U | 5/16/95 | SWB | Scanned & reduced to 'A' size format. |
| SWB | V | 2/12/97 | SS | CHANGED ITEM #29 (410901) TO (410904) |
| SWB | W | 12/2/98 | DJL | ADDED ITEM 55 MAH00093 SCREWS FOR NAME PLATE. |
| TLW | -- | 5/13/99 | LBK | REMOVED * (ASTERISK) FROM ITEMS, 2, 3, AND 4, ALSO REMOVED " *See separate sheet for replacement assembly numbers and individual parts " FROM PARTS LIST, UPDATED DESCRIPTIONS TO CURRENT ENGINEERING STANDARDS, AND ADDED SHEET 3 REPLACEMENT ASSY PART NUMBERS. |
| TLW | - | 01/04/01 | BWW | REVISED TO CHANGE ITEM # 29 FROM 410904 TO PL1-200101 TO COMPLY WITH NEW NAME PLATE STANDARD. |
| SWB | X | 01/11/05 | BWW | REVISED TO ADD ITEM 56 8163118 QTY 2 SMALL BRANDING LABEL AND NOTE 8 FOR LOCATING LABEL. |
| SWB | Y | 08/29/05 | BWW | CREATED EXPLODED ISOMETRIC VIEW AND NEW NOTE 8 FOR CLARITY. CHANGED QTY OF MBG00001 FROM 4 TO 8 TO MATCH AS BUILT CONDITION. RENUMBERED DRAWING |