

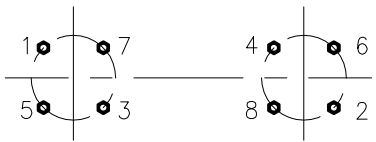


McElroy Manufacturing, Inc.
The leader by design.
Tulsa, Oklahoma U.S.A.

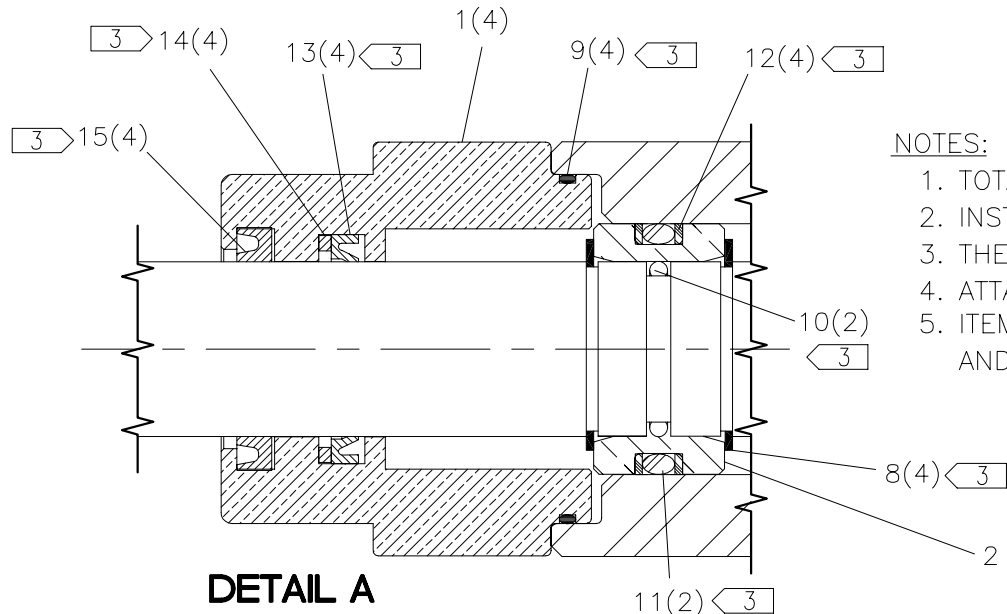
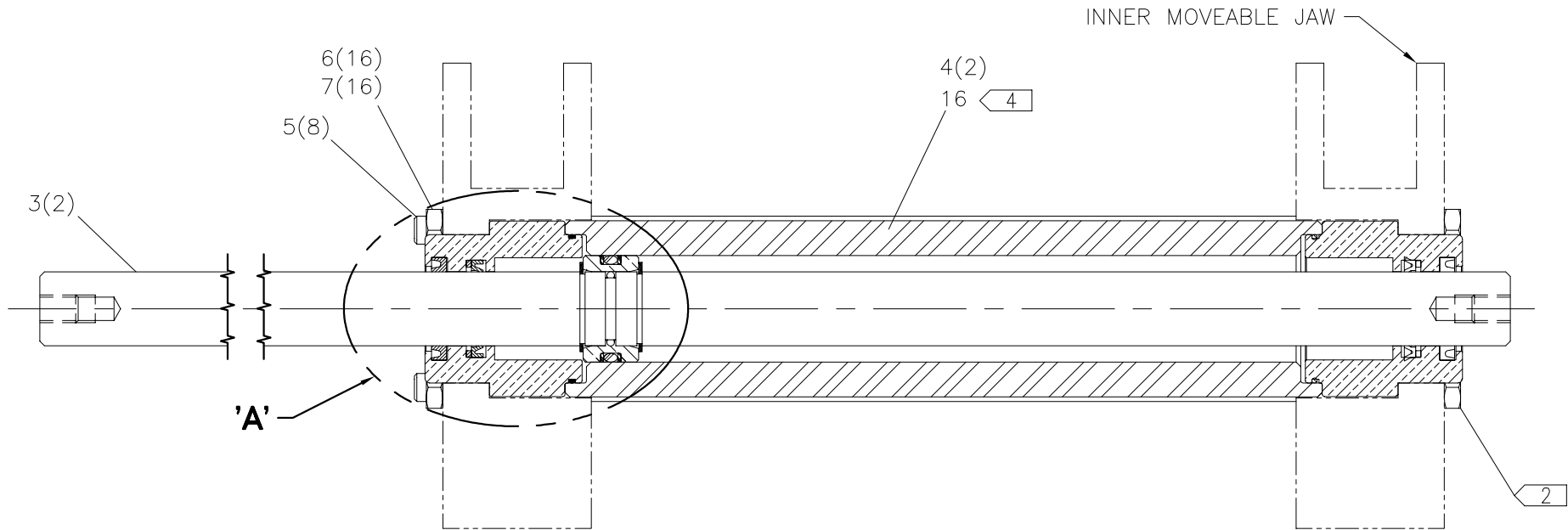
DRAWN: AH	CHECK: SWB	APPRV'D: B	DATE: 1/8/97	SHT No: 2	REV No: C	PART No: 840302
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#28 LOW FORCE CYLINDER ASSEMBLY SET (XHV)

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TIE ROD TORQUE PROCEDURE:
TIGHTEN TIE ROD NUTS IN
SEQUENCE 16-20 Ft. Lbs.



NOTES:

1. TOTAL EFFECTIVE PISTON AREA = 1.66 SQ. IN.
2. INSTALL TIE RODS FLUSH WITH FINISHED NUTS ON THIS END ONLY.
3. THESE ITEMS ARE PART OF PART NUMBER A840801 SEAL KIT.
4. ATTACH TO THE OUTSIDE OF ONE CARRIAGE CYLINDER.
5. ITEMS SHOWN IN PARENTHESIS REFLECT QUANTITIES IN A LOCAL GROUP AND MAY NOT INDICATE TOTAL ASSEMBLY QUANTITIES.

DETAIL A

#28 LOW FORCE CYLINDER ASSEMBLY SET (XHV)PARTS LIST

ITEM	PART NO.	QTY	DESCRIPTION
	840302		ASSEMBLY
1	800901	4	ROD GLAND
2	818801	2	LOW FORCE PISTON
3	813701	2	GUIDE ROD
4	819201	2	LOW FORCE CARRIAGE CYLINDER
5	1802001	8	TIE ROD
6	MBA00047	16	3/8-24NF FINISHED HEX NUT
7	MBG00001	16	3/8 TYPE 'AN' FLAT WASHER
8	MCB00006	4	EXTERNAL SNAP RING
9	MDL00001	4	O-RING
10	MDL00002	2	O-RING
11	MDL00020	2	O-RING
12	MDL00022	4	BACK-UP RING
13	MDL00030	4	SEAL
14	MDL00031	4	WASHER
15	MDL00032	4	WIPER
16	816371	1	1.66 SQ. IN. TEPA LABEL

DRAWING REVISION HISTORY LISTING

PART NO: 840302
DESCRIPTION: #28 LOW FORCE CYLINDER ASSEMBLY SET (XHV)

<u>APPR.</u>	<u>REV</u>	<u>DATE</u>	<u>BY</u>	<u>DESCRIPTION OF REVISION</u>
SWB	A	2/12/97	TLW	CHANGED DESCRIPTION FROM XH VELOCITY TO LOW FORCE AND PUT (XHV) ON THE END OF DESCRIPTION.
SWB	-	6/6/97	TLW	CHANGED ITEM #6 MBB00037 JAM NUT TO MBA00047 FINISHED NUT. PROBLEM WITH JAM NUT STRIPPING WHEN TIGHTEN TO TORQUE SPECIFIED.
SWB	-	7/22/97	BB	CHANGED ITEM #3 813901 TIE ROD TO 1802001. 8" TIE RODS WERE CONSOLIDATED W/18"
SWB	B	10/20/97	BB	ADDED ITEM #16 816371 TEPA LABEL & NOTE 5.
SWB	C	03/21/05	BWW	REVISED TO ADD DETAIL A AND NOTE 5 FOR CLARITY. ADDED ITEM QUANTITIES TO MATCH CURRENT STANDARDS.