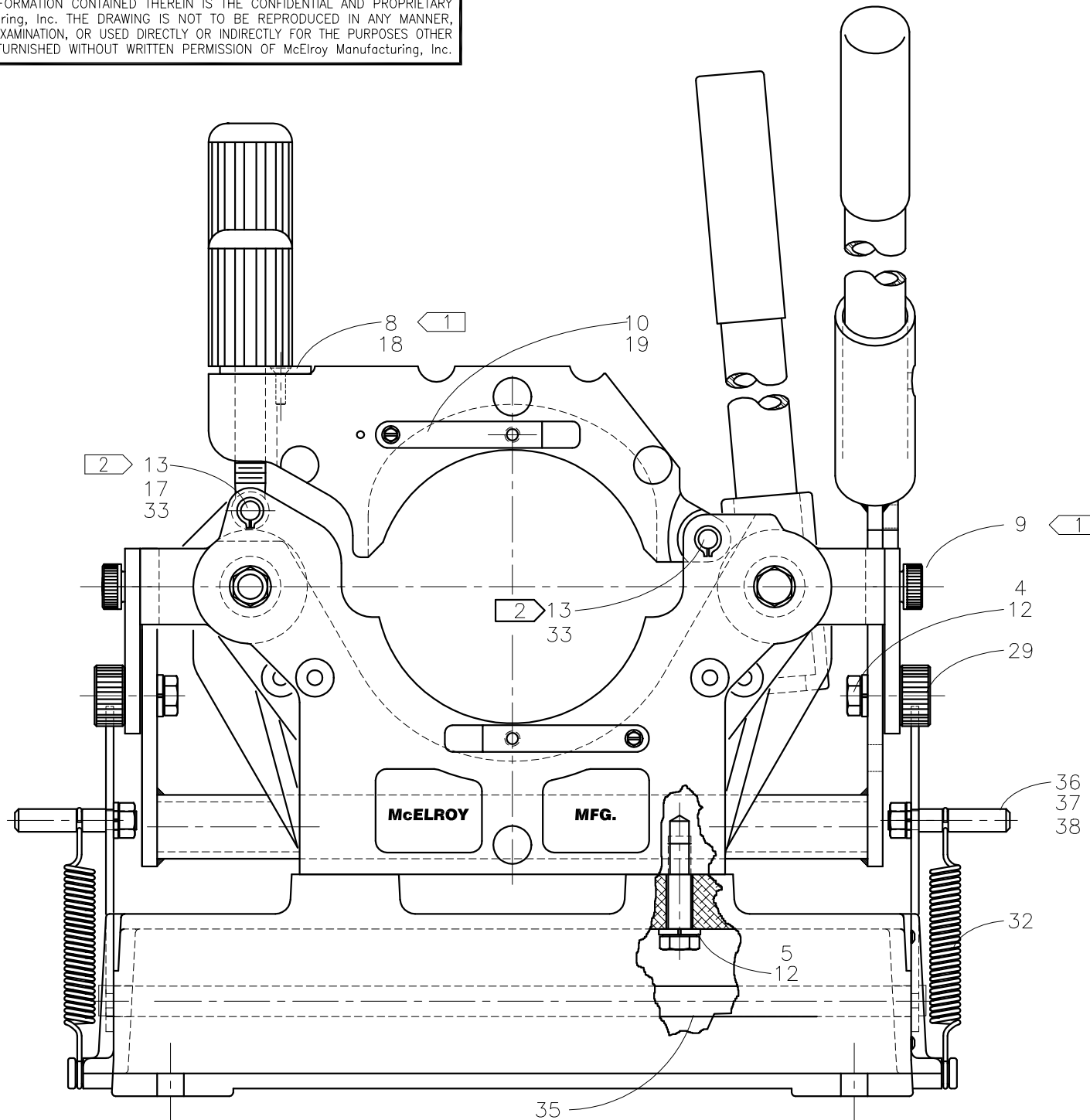




McElroy Manufacturing, Inc.
The leader by design.
Tulsa, Oklahoma U.S.A.

DRAWN: SWB	CHECK: BWP	APPRV'D: B	DATE: 5/16/95	DWG No: 420000	SHT No: 1A	REV No: P	PART No: 420001
#14 BUTT FUSION MACHINE ASSEMBLY							CAD No: 420001

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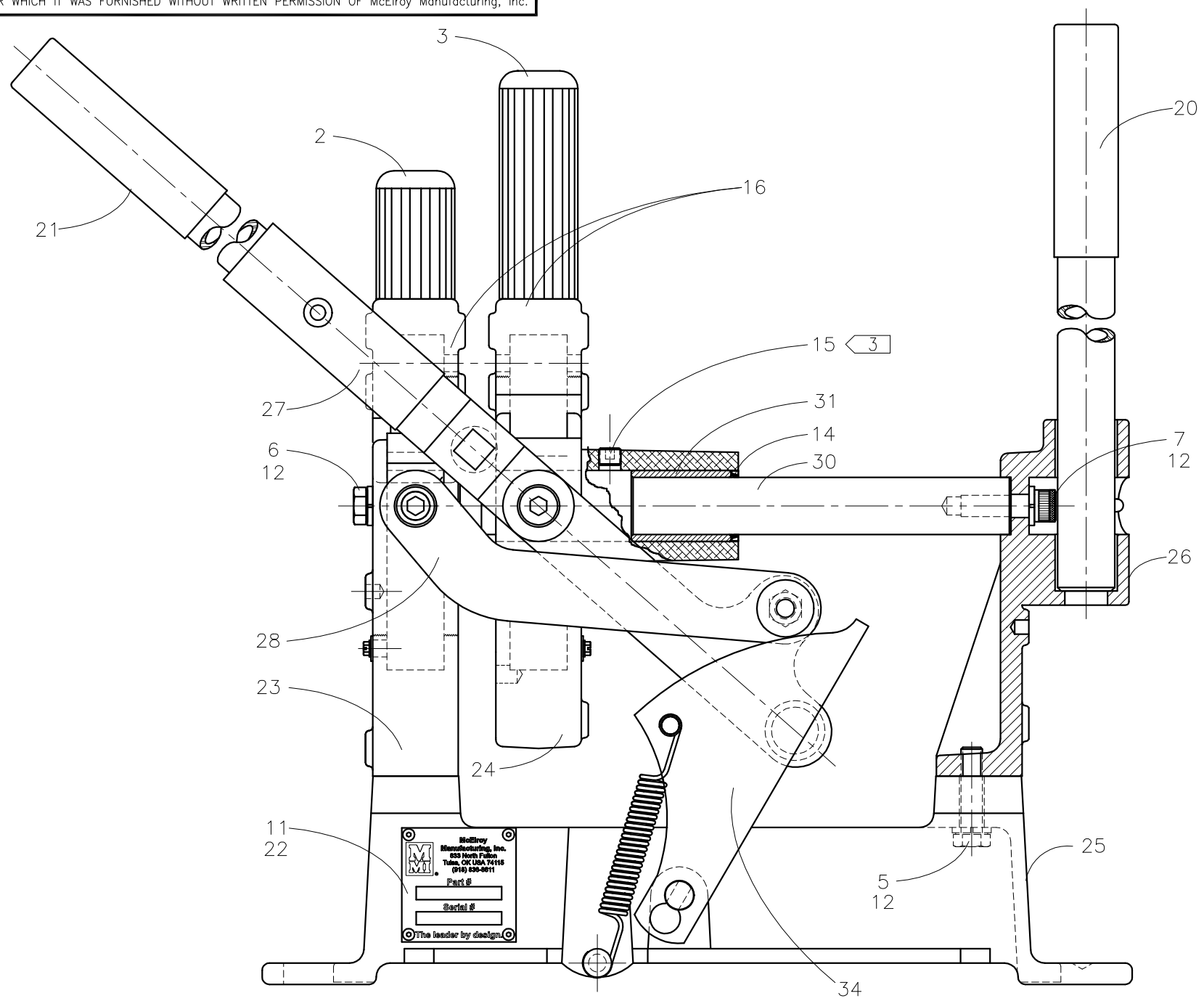




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McElroy Manufacturing, Inc.
 633 North Fulton
 Tulsa, OK USA 74116
 (918) 436-8011
 Part #
 Serial #
 The leader by design

#14 BUTT FUSION MACHINE ASSEMBLYParts List

ITEM	PART NO.	QTY.	DESCRIPTION
	420001		ASSEMBLY
1	A214201	1	BUTT FUSION SCREW / DRIVER KIT (NOT SHOWN)
2	A829001	1	SHORT CLAMP KNOB ASSEMBLY
3	A829101	1	LONG CLAMP KNOB ASSEMBLY
4	MAB00064	2	3/8-16NC X 1LG HHCS
5	MAB00066	4	3/8-16NC X 1-1/2LG HHCS
6	MAB00068	2	3/8-16NC X 2LG HHCS
7	MAC00094	2	3/8-16NC X 1LG SHCS
8	MAH00074	4	#8-32NC X 3/8LG FHSCS SS
9	MAF00041	4	1/2DIA X 1/2LG SOCKET SHOULDER SCREW
10	MAH00036	4	#6-32NC X 3/8LG HEX WASHER HEAD TYP 'F' STL PL
11	MAH00093	4	#4-40NC X 3/16LG LOCK SCREW
12	MBE00007	10	3/8 REG SPLIT LOCK WASHER STL PL
13	MCB00022	4	EXT SNAP RING
14	MDL00051	8	SEAL
15	MFA00001	2	1MPT PLUG
16	401202	2	UPPER JAW
17	401601	2	EYEBOLT
18	402001	2	CLAMP PAD
19	402301	4	INSERT KEEPER SPRING PIN ASSY
20	402801	1	24" LONG LEVER ASSY
21	402802	1	18" LONG LEVER ASSY
22	PL1-420001	1	NAMEPLATE
23	420502	1	14 LOWER FIXED JAW
24	420603	1	14 LOWER MOVABLE JAW
25	420702	1	BASE
26	420802	1	14 TAILSTOCK
27	420901	1	14 YOKE
28	421001	2	14 LINK
29	421201	2	14 YOKE LOCK PIVOT
30	421301	2	14 GUIDE ROD
31	421701	4	GUIDE ROD BUSHING
32	421801	2	PIVOT LOCKING SPRING
33	426401	4	14 JAW PIVOT PIN
34	431601	2	#14 Pit Bull™ LOCK CAM
35	431401	1	#14 Pit Bull™ LOCK CAM SHAFT
36	433501	2	#14 Pit Bull™ SPRING POST
37	MBE00006	2	5/16 LOCK WASHER
38	MBA00006	2	5/16-18NC FINISH HEX NUT STL PL

NOTES:

1. INSTALL WITH #242 LOCTITE
2. INSTALL WITH SNAP RING ON THE OUTSIDE OF JAWS.
3. FILL WITH 10W-40 SAE OIL TO LUBRICATE GUIDE ROD BUSHINGS.

Replacement Assembly Part Numbers

<u>PART NO.</u>	<u>QTY.</u>	<u>DESCRIPTION</u>
A422101		14BM Lower Fixed Jaw Assembly, including:
MAH00036	1ea.	#6-32NCX3/8LG HWH TC SCR
MCB00022	2ea.	Ext. Snap Ring
402301	1 ea.	Insert Keeper Spring Pin Assembly
420502	1ea.	14 Lower Fixed Jaw
426401	2ea.	14 Jaw Pivot Pin
A412002		14BM Upper Jaw Assembly, including:
MAH00074	2ea.	#8-32NCX3/8LG FHSCS SS
MAH00036	1ea.	#6-32NCX3/8LG HWH TC SCR
MCB00022	1ea.	Ext. Snap Ring
401202	1 ea.	Upper Jaw
402001	1 ea.	Clamp Pad
402301	1ea.	Insert Keeper Spring Pin Assembly
426401	1ea.	14 Jaw Pivot Pin
A422201		14BM Lower Movable Jaw Assembly, including:
MAH00036	1ea.	#6-32NCX3/8LG HWH TC SCR
MCB00022	2ea.	Ext. Snap Ring
MDL00051	8ea.	Rod Wiper
MFA00001	2ea.	1MPT Plug
402301	1 ea.	Insert Keeper Spring Pin Assembly
420603	1ea.	14 Lower Movable Jaw
421701	4 ea.	Guide Rod Bushing
426401	2ea.	14 Jaw Pivot Pin
A829001		Short Clamp Knob Assembly, including:
403101	1ea.	Bearing Assembly
403201	1 ea.	Snap Ring
828901	1ea.	Short Clamp Knob
A829101		Long Clamp Knob Assembly, including:
403101	1 ea.	Bearing Assembly
403201	1 ea.	Snap Ring
828902	1ea.	Long Clamp Knob
A422401		14BM Upper/Lower Fixed Jaw Assembly, including:
A412002	1 ea.	14BM Upper Jaw Assembly
A422101	1 ea.	14BM Lower Fixed Jaw Assembly
A829001	1 ea.	Short Clamp Knob Assembly
401601	1ea.	Eyebolt
A422301		14BM Upper/Lower Movable Jaw Assembly, including:
A412002	1 ea.	14BM Upper Jaw Assembly
A422201	1 ea.	14BM Lower Movable Jaw Assembly
A829101	1ea.	Long Clamp Knob Assembly
401601	1 ea.	Eyebolt
A425102		14BM Eyebolt Kit, including:
MCB00022	1ea.	Ext. Snap Ring
401601	1 ea.	Eyebolt
426401	1ea.	14 Jaw Pivot Pin

A426401		14BM Pivot Pin Kit, Including:
426401	4 ea.	14 Jaw Pivot Pin
MCB00022	4 ea.	Ext. Snap Ring
A430109		#14 Pit Bull™ LOCK CAM Kit, Including:
431601	2 ea.	#14 Pit Bull™ LOCK CAM
431401	1 ea.	#14 Pit Bull™ LOCK CAM SHAFT
433501	2 ea.	#14 Pit Bull™ SPRING POST
MBE00006	2 ea.	5/16 LOCK WASHER
MBA00006	2 ea.	5/16-18NC FINISH HEX NUT STL PL
421801	2 ea.	Pivot locking spring

DRAWING REVISION HISTORY LISTING

PART NO: 420001

DESCRIPTION: #14 BUTT FUSION UNIT ASSEMBLY (FRONT VIEW)

<u>APPR.</u>	<u>REV</u>	<u>DATE</u>	<u>BY</u>	<u>DESCRIPTION OF REVISION</u>
B	J	5/16/95	SWB	Scanned & reduced to 'A' size format. Moved side view to sheet 2.
B	K	3/25/97	SS	PUT 4200S01.DWG & 4200S02.DWG FILES IN ONE 420001.DWG
TLW	--	01/16/98	RLE	ADDED ITEM 44, A214201 SCR/DRIVER KIT, & ADDED NOTE 4.
TLW	L	04/24/98	RLE	UPDATED DRAWING TO SHOW CURRENT STYLE OF CLAMP KNOBS (828901 & 828902), YOKE WELDMENT (420901) & LINK (421001).
SWB	M	02/15/99	AH	REDRAWN FROM SCAN FORMAT. RENUMBERED PARTS LIST. DELETED PART NUMBERS (828901), (828902), (403101), (403201), (MJM00006) AND REPLACED THEM WITH ITEMS #2(A829001) & #3(A829101) SHORT & LONG CLAMP KNOB ASSEMBLYS. DELETED PART NUMBERS (420702) & (421603), AND REPLACED THEM WITH ITEM #25(420703) BASE WELDMENT. REVISED ITEM #10(MAH00036) QTY 8 TO QTY 4.
TLW	-	05/12/99	LBK	ADDED REPLACEMENT ASSEMBLY PART KIT.
SWB	N	09/29/00	DWK	CHANGED ITEM #8 FROM (MAD00022) TO (MAH00074) FOR A 3/8 LG SS SCREW INSTEAD OF 1/2 LG. ALSO MADE SAME CHANGE TO A412002 UNDER REPLACEMENT ASSEMBLY PARTS LIST. REMOVED FLAG 1 FROM ITEM 4, 5, 6 & 7. SCREWS WITH LOCK WASHERS DO NOT NEED LOCTITE. ADDED FLAG 1 TO ITEM 8. THESE CHANGES MADE TO MATCH AS BUILT CONDITIONS.
TMT	P	10/16/00	MLM	ADDED ITEMS 34-38, ITEM 25 WAS 420703 CHANGED TO 420702 BASE. ADDED A430109 LOCK CAM KIT.
TLW	--	12/07/00	RLE	CORRECTED ITEM #7 FROM MAH00094 TO MAC00094.
TLW	-	01/04/01	BWW	REVISED TO CHANGE ITEM # 22 FROM 410904 TO PL1-420001 TO COMPLY WITH NEW NAME PLATE STANDARD.