



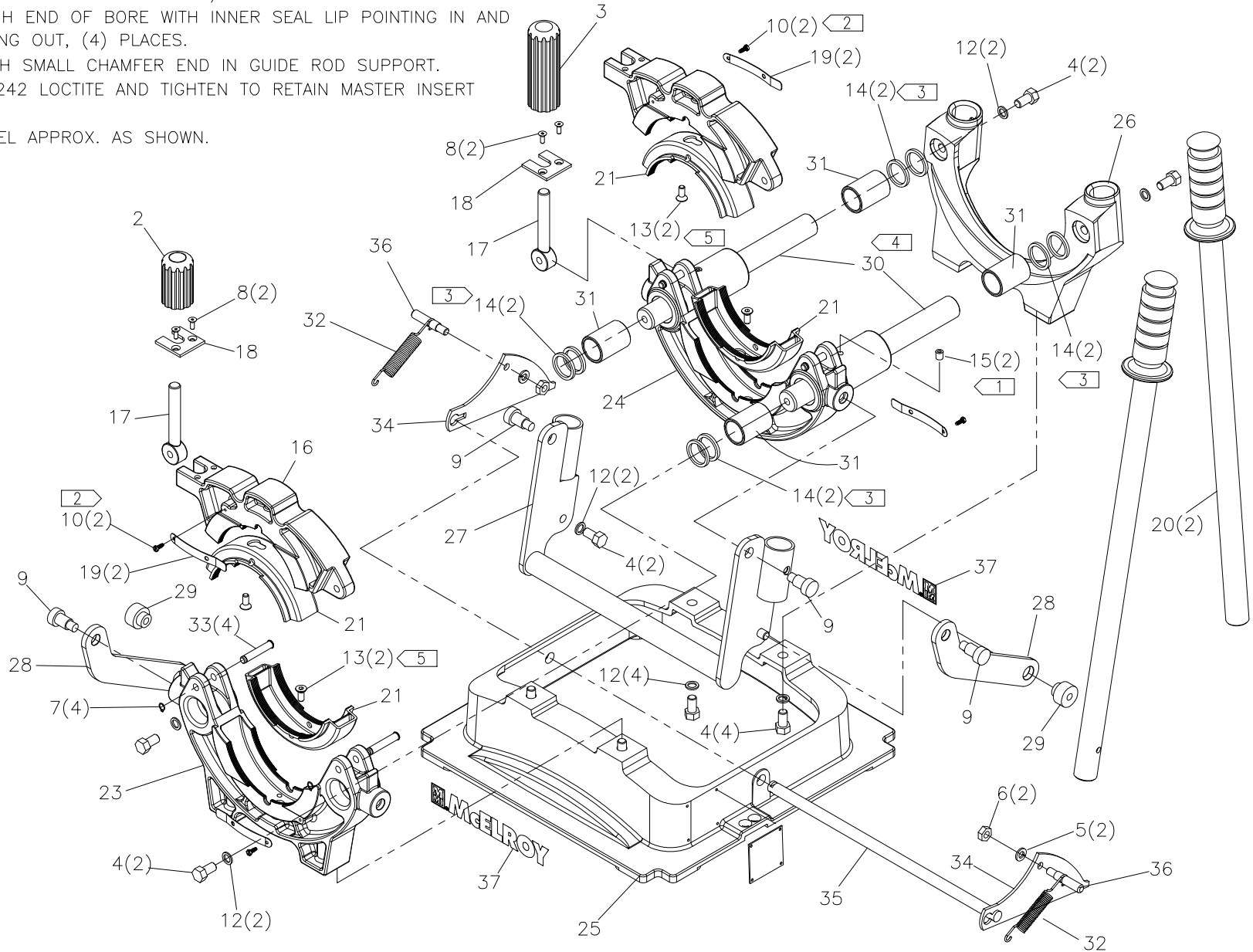
**McElroy Manufacturing, Inc.**  
The leader by design.  
Tulsa, Oklahoma U.S.A.

DRAWN: BWW	CHECK: TMT/BP	APPRV'D: SWB	DATE: 6/2/00	DWG No: 430100	SHT No: 1	REV No: F	PART No: 430101
PitBull® No. 14 FUSION MACHINE ASSEMBLY							CAD No: 430101

NOTE: THIS DRAWING AND THE INFORMATION CONTAINED THEREIN IS THE CONFIDENTIAL AND PROPRIETARY PROPERTY OF McElroy Manufacturing, Inc. THE DRAWING IS NOT TO BE REPRODUCED IN ANY MANNER, SUBMITTED OUTSIDE PARTIES FOR EXAMINATION, OR USED DIRECTLY OR INDIRECTLY FOR THE PURPOSES OTHER THAN THOSE FOR WHICH IT WAS FURNISHED WITHOUT WRITTEN PERMISSION OF McElroy Manufacturing, Inc.

**NOTES:**

1. FILL WITH 10W-40 SAE OIL TO LUBRICATE GUIDE ROD BUSHINGS.
2. INSTALL WITH #242 LOCTITE. LOOSEN SCREW 1/4 TURN TO ALLOW SPRING TO PIVOT.
3. USE TWO SEALS IN EACH END OF BORE WITH INNER SEAL LIP POINTING IN AND OUTER SEAL LIP POINTING OUT, (4) PLACES.
4. INSTALL GUIDE ROD WITH SMALL CHAMFER END IN GUIDE ROD SUPPORT.
5. INSTALL SCREW WITH #242 LOCTITE AND TIGHTEN TO RETAIN MASTER INSERT (DO NOT OVERTIGHTEN)
6. CENTRALLY LOCATE LABEL APPROX. AS SHOWN.



**PitBull® No. 14 FUSION MACHINE ASSEMBLY**Parts List

ITEM	PART NO.	QTY.	DESCRIPTION
	<b>430101</b>		<b>ASSEMBLY</b>
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	MAB00077	10	3/8-16NC X 1" LG. HHCS
5	MBE00006	2	5/16 LOCK WASHER
6	MBA00006	2	5/16-18NC FINISH HEX NUT
7	MCB00022	4	EXTERNAL SNAP RING
8	MAH00074	4	#8-32NC X 3/8 LG. FHSCS SS
9	MAF00041	4	1/2 DIA X 1/2 LG. SOCKET SHOULDER SCREW
10	MAH00036	4	#6-32NC X 3/8 LG. HEX WASHER HEAD TYP 'F'
11	MAH00093	4	#4-40NC X 3/16 LG. LOCK SCREW
12	MBE00007	10	3/8 REGULAR SPLIT LOCK WASHER
13	MAH00073	4	1/4-20NC X 5/8 LG. FHSCS SS
14	MDL00051	8	SEAL
15	MFA00001	2	1 MPT PLUG
16	430301	2	PitBull® No. 14 4" DIPS UPPER JAW
17	430501	2	PitBull® No. 14 EYEBOLT
18	402001	2	CLAMP PAD
19	402301	4	INSERT KEEPER SPRING PIN ASSY
20	402801	2	LEVER HANDLE ASSEMBLY
21	430701	4	#14 Pit Bull® 4" IPS/DIPS MASTER INSERT
22			
23	430201	1	PitBull® No. 14 4" DIPS LOWER FIXED JAW
24	430401	1	PitBull® No. 14 4" DIPS LOWER MOVABLE JAW
25	432601	1	PitBull® No. 14 4" DIPS BASE
26	431001	1	PitBull® No. 14 GUIDE ROD SUPPORT
27	431101	1	PitBull® No. 14 YOKE WELDMENT
28	421001	2	LINK
29	421201	2	YOKE LOCK PIVOT
30	421301	2	GUIDE ROD
31	421701	4	GUIDE ROD BUSHING MODIFICATION
32	421801	2	LOCK SPRING
33	426401	4	JAW PIVOT PIN
34	431601	2	PitBull® No. 14 LOCK CAM
35	431401	1	PitBull® No. 14 LOCK CAM SHAFT
36	433501	2	PitBull® No. 14 SPRING POST
37	8163118	2	SMALL McELROY BRANDING LABEL

**PitBull® No. 14 FUSION MACHINE ASSEMBLY**

## Replacement Assembly Part Numbers

<u>PART NO.</u>	<u>QTY.</u>	<u>DESCRIPTION</u>
A430110		PitBull® No. 14 Lower Fixed Jaw Assembly, including:
MAH00036	1	#6-32NCX3/8LG HWH TC SCR
402301	1	Insert Keeper Spring Pin Assembly
430201	1	#14 Pit Bull™ Lower Fixed Jaw
MAH00073	1	1/4-20NC x 5/8 LG FHSCS SS
430701	1	#14 Pit Bull™ 4" IPS Master Insert
A430103		PitBull® No. 14 Upper Jaw Assembly, including:
MAH00074	2	#8-32NCX3/8 LG FHSCS SS
MAH00036	1	#6-32NCX3/8LG HWH TC SCR
MCB00022	1	External Snap Ring
430301	1	#14 Pit Bull™ Upper Jaw
402001	1	Clamp Pad
402301	1	Insert Keeper Spring Pin Assembly
426401	1	Jaw Pivot Pin
MAH00073	1	1/4-20NC x 5/8 LG FHSCS SS
430701	1	#14 Pit Bull™ 4" IPS Master Insert
A430104		PitBull® No. 14 Lower Movable Jaw Assembly, including:
MAH00036	1	#6-32NCX3/8LG HWH TC SCR
MDL00051	8	Seal
MFA00001	2	1MPT Plug
402301	1	Insert Keeper Spring Pin Assembly
430401	1	#14 Pit Bull™ Lower Movable Jaw
421701	4	Guide Rod Bushing
MAH00073	1	1/4-20NC x 5/8 LG FHSCS SS
430701	1	PitBull® No. 14 4" IPS Master Insert
A829001		Short Clamp Knob Assembly, including:
403101	1	Bearing Assembly
403201	1	Snap Ring
828901	1	Short Clamp Knob
A829101		Long Clamp Knob Assembly, including:
403101	1	Bearing Assembly
403201	1	Snap Ring
828902	1	Long Clamp Knob
A430105		PitBull® No. 14 Upper/Lower Fixed Jaw Assembly, including:
A430103	1	#14 Pit Bull™ Upper Jaw Assembly
A430110	1	#14 Pit Bull™ Lower Fixed Jaw Assembly
A829001	1	Short Clamp Knob Assembly
A430107	1	#14 Pit Bull™ Eyebolt Ass'y
A430106		PitBull® No. 14 Upper/Lower Movable Jaw Assembly, including:
A430103	1	#14 Pit Bull™ Upper Jaw Assembly
A430104	1	#14 Pit Bull™ Lower Movable Jaw Assembly
A829101	1	Long Clamp Knob Assembly
A430107	1	#14 Pit Bull™ Eyebolt Ass'y
A430107		PitBull® No. 14 Eyebolt Kit, including:
MCB00022	1	External Snap Ring

**PitBull® No. 14 FUSION MACHINE ASSEMBLY**

430501	1	PitBull® No. 14 Eyebolt
426401	1	Jaw Pivot Pin
A426401		14BM JAW PIVOT PIN KIT, Including:
426401	4	Jaw Pivot Pin
MCB00022	4	External Snap Ring
A430109		PitBull® No. 14 Lock Cam Kit, including:
431601	2	PitBull® No. 14 Lock Cam
431401	1	PitBull® No. 14 Lock Cam Shaft
433501	2	PitBull® No. 14 Spring Post
421801	2	Lock Spring
MBE00006	2	5/16 Lock Washer
MBA00006	2	5/16-18NC Finish Hex Nut

## DRAWING REVISION HISTORY LISTING

**PART NO:** 430101  
**DESCRIPTION:** PitBull® No. 14 FUSION MACHINE ASSEMBLY

<u>APPR.</u>	<u>REV</u>	<u>DATE</u>	<u>BY</u>	<u>DESCRIPTION OF REVISION</u>
TMT	A	7/31/00	BWW	REVISED TO CHANGE 24" LEVER ASSEMBLY FROM 433601 TO 402801. DECIDED TO REVISE EXISTING LEVER ASS'Y RATHER THAN CREATE A NEW ONE. ADDED NOTE 7. TO LOCTITE MASTER INSERT SCREWS. THIS WILL ALLOW SCREW TO BE LOOSE SO INSERT CAN BE REMOVED BUT SCREW WILL NOT FALL OUT DURING SHIPPING.
TMT	B	10/9/00	RLE	REMOVED NOTE #1, INSTALL WITH #242 LOCTITE. LOCTITE NOT NEEDED ON 3/8-16NC SCREWS WITH LOCK WASHERS. REVISED ITEM #8 FROM MAD00022 TO MAH00074 & REVISED ITEM #13 FROM MAD00043 TO MAH00073. THESE SCREW ALSO REVISED ON REPLACEMENT ASSEMBLIES. CHANGED FROM BLACK STEEL TO STAINLESS TO REDUCE COST & PREVENT RUST. REVISED NOTE #7 FROM 1/2 TURN TO 1 FULL TURN.
TLW	-	01/04/01	BWW	REVISED TO CHANGE ITEM #22 FROM 410904 TO PL1-430101 TO COMPLY WITH NEW NAME PLATE STANDARD.
TMT	C	03/01/01	BWW	CHANGED NOTE 2 FROM "BACK OUT BALL PLUNGER 1/16 TURN..." TO "SCREW IN FULLY...." AND USE #242 LOCTITE. CHANGED NOTE 7 FROM "LOOSEN SCREW ONE FULL TURN..." TO "TIGHTEN".
SWB	D	2/27/02	ALK	REVISED 430801 JAW PIVOT PIN & MJN00004 BALL PLUNGER TO 426401 JAW PIVOT PIN & MCB00022 SNAP RING PER PCR99077. UPDATED ATTACHED REPLACEMENT PARTS LIST ACCORDINGLY.
SWB	E	01/11/05	BWW	REVISED TO ADD ITEM 37 8163118 QTY 2 SMALL BRANDING LABEL AND NOTE 6 FOR LOCATING LABEL.
SWB	F	06/01/05	BWW	CONSOLIDATED TO 1 SHEET AND CREATED ISOMETRIC VIEW FOR CLARITY.