



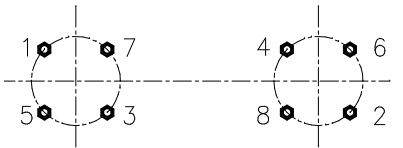
McElroy Manufacturing, Inc.
The leader by design.
Tulsa, Oklahoma U.S.A.

DRAWN: TLW CHECK: TMT APPRV'D: SWB DATE: 1/13/97 DWG No: 1822300 SHT No: 1 REV No: A PART No: 1822301

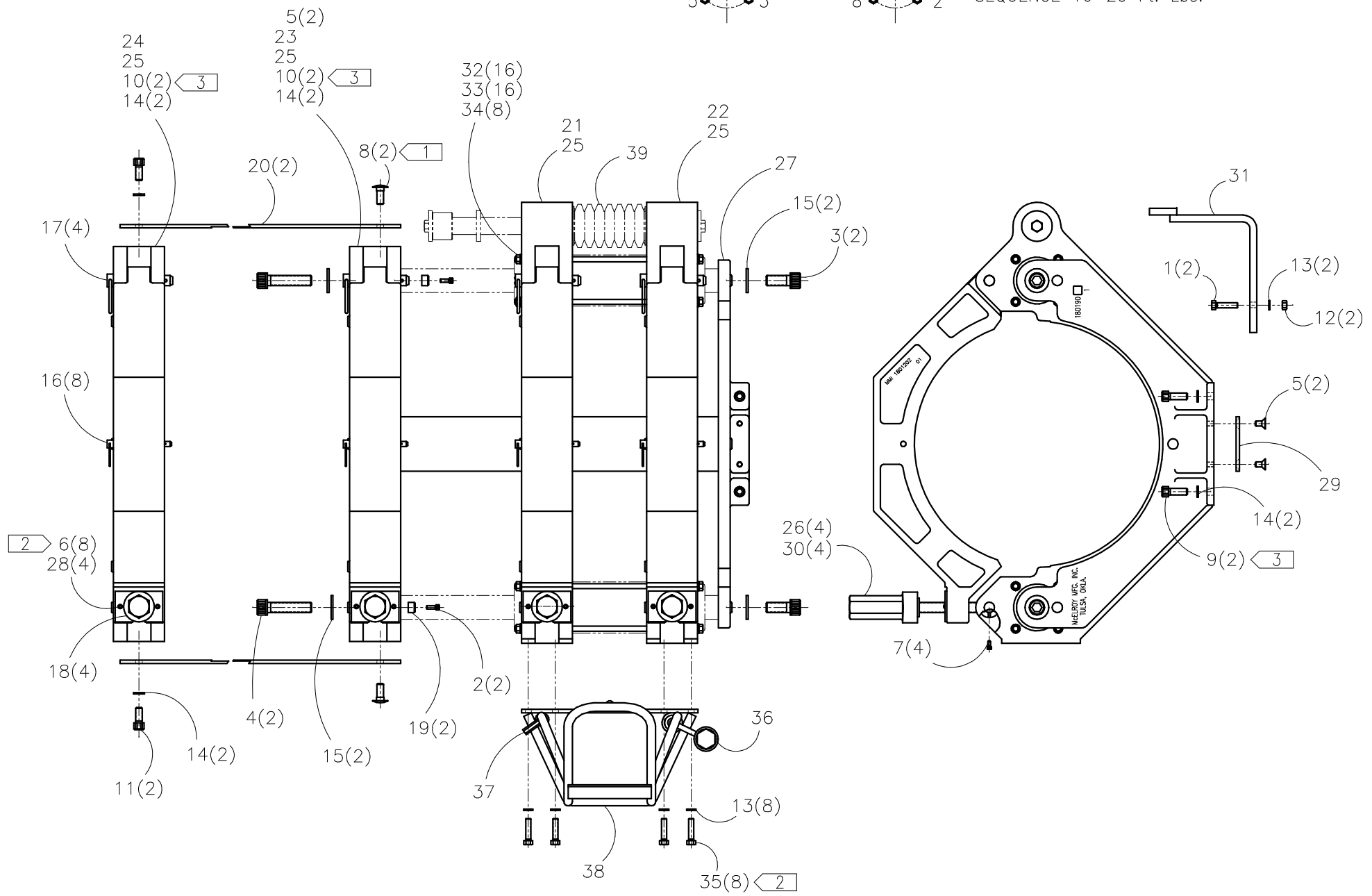
#618 JAW SET ASSEMBLY

CAD No: 1822301

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.



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



#618 JAW SET ASSEMBLYParts List

ITEM	PART NO.	QTY.	DESCRIPTION
	1822301	1	ASSEMBLY
1	MAB00066	2	3/8-16NC X 1 1/2 LG HHCS
2	MAC00052	2	1/4-20NC X 5/8 LG SHCS
3	MAC00182	2	3/4-10NC X 1 1/2 LG SHCS
4	MAC00188	2	3/4-10NC X 3 LG SHCS
5	MAD00072	4	3/8-16NC X 3/4 LG FHSCS
6	MAH00111	8	#10-24NCX1/2LG HWH TF SCREW
7	MAG00002	4	#10-24NC X 3/8 LG SHSS NYL LK W/HALF DOG PT.
8	MAI00001	2	1/2-13NC X 1 LG CRG. BOLT
9	MAN00017	2	1/2-13NC X 1 1/4 LG SHCS SS
10	MAN00018	4	1/2-13NC X 4 LG SHCS SS
11	MAN00020	2	1/2-13NC X 1 LG SHCS SS
12	MBA00007	2	3/8-16NC HEX NUT
13	MBE00007	10	3/8 LOCK WASHER
14	MBE00009	8	1/2 LOCK WASHER
15	MBG00010	4	3/4 FLAT WASHER
16	MCE00004	8	3/8 DIA. X 3.75 GRIP DETENT PIN
17	MCE00010	4	3/4 DIA. X 3.75 GRIP DETENT PIN
18	A1811001	4	CLAMP KNOB ASSEMBLY
19	1225701	2	REST BUTTON
20	1242801	2	BRACE
21	1801113	1	INNER HYDRAULIC LOWER JAW
22	1801114	1	OUTER HYDRAULIC LOWER JAW
23	1801107	1	INNER FIXED LOWER JAW
24	1801108	1	OUTER FIXED LOWER JAW
25	1801202	4	UPPER JAW
26	1801801	4	EYE BOLT
27	1801902	1	GUIDE ROD SUPPORT PLATE
28	1806301	4	CLAMP PAD
29	1814601	1	CARRIAGE SUPPORT BRACKET
30	1819101	4	PIVOT PIN
31	1852101	1	FACER STOP
32	MBA00047	16	3/8-24NF HEX NUT
33	MBG00001	16	3/8 FLAT WASHER
34	1802001	8	TIE ROD
35	MAB00063	8	3/8-16NC X 3/4 LG HHCS
36	1818501	1	SPEED WRENCH
37	MJL00018	1	3/8 HEX KEY WRENCH - LONG
38	1853101	1	MANIFOLD BRACKET WELDMENT
39	1824001	1	#412/#618 FACER PIVOT SHAFT ASSEMBLY

#618 JAW SET ASSEMBLYParts List

ITEM	PART NO.	QTY.	DESCRIPTION
------	----------	------	-------------

NOTES:

1. INSTALL WITH LOCTITE #242 WITH HEAD 9/32" FROM JAW.
2. INSTALL WITH LOCTITE #242.
3. INSTALL WITH C-5A OR NEVER SEEZ ANTI-SEIZE LUBRICATION.

DRAWING REVISION HISTORY LISTING

PART NO: 1822301

DESCRIPTION: #618 JAW SET ASSEMBLY

<u>APPR.</u>	<u>REV</u>	<u>DATE</u>	<u>BY</u>	<u>DESCRIPTION OF REVISION</u>
SWB	-	07/22/97	BB	CORRECTED ITEM #38 1853101 DESCRIPTION FROM GUARD TO MANIFOLD BRACKET WELDMENT.
SWB	-	08/04/99	TLW	REVISED ITEM #6 MAE00023 TO SELF TAPPING SCREW MAH00111. TO COMPLY WITH REVISION TO UPPER JAW.
TLW	A	02/03/00	RLE	ADDED 1/2" LOCK WASHERS, ITEM #14 MBE00009, TO FIXED JAW BRACE TO MATCH AS BUILT.