

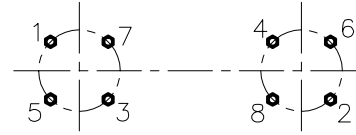


McElroy Manufacturing, Inc.
The leader by design.
Tulsa, Oklahoma U.S.A.

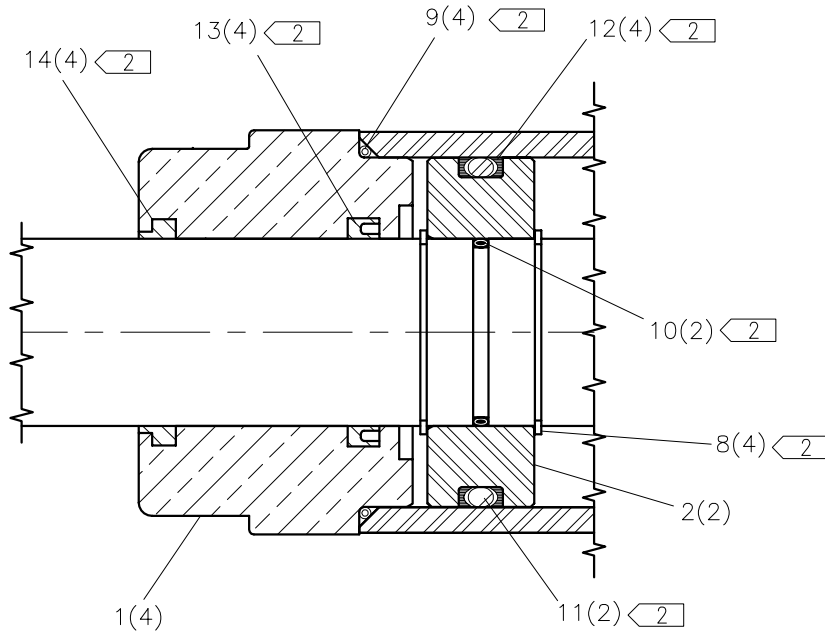
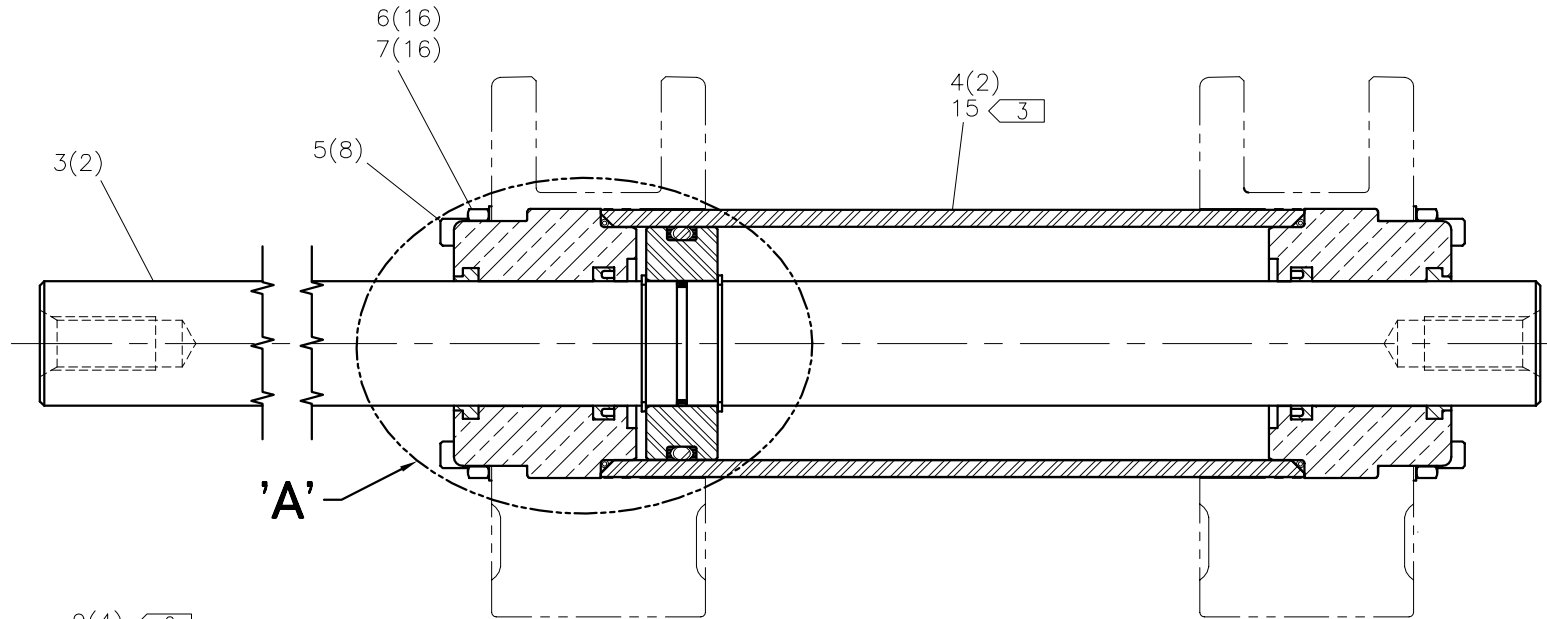
DRAWN: TLW	CHECK: TMT	APPRV'D: SWB	DATE: 11/20/96	SHT No: 1	REV No: C	PART No: 1822501
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#618 HIGH FORCE CYLINDER ASSEMBLY SET (STD)

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



NOTES:

1. TOTAL EFFECTIVE PISTON AREA = 11.78 SQ. IN.
2. THESE ITEMS ARE PART OF PART NUMBER A1811201 SEAL KIT.
3. ATTACH TO THE OUTSIDE OF ONE CARRIAGE CYLINDER.
4. ITEMS SHOWN IN PARENTHESIS REFLECT QUANTITIES IN A LOCAL GROUP AND MAY NOT INDICATE TOTAL ASSEMBLY QUANTITIES.

#618 HIGH FORCE CYLINDER ASSEMBLY SET (STD)PARTS LIST

ITEM	PART NO.	QTY	DESCRIPTION
	1822501		ASSEMBLY
1	1202501	4	HF ROD GLAND
2	1202201	2	HF PISTON
3	1202301	2	GUIDE ROD
4	1202401	2	HF 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	MCB00011	4	EXTERNAL SNAP RING
9	MDL00009	4	O-RING
10	MDL00013	2	O-RING
11	MDL00003	2	O-RING
12	MDL00027	4	BACK-UP RING
13	MDL00091	4	SEAL
14	MDL00092	4	SLOTTED WIPER
15	816344	1	11.78 SQ. IN. TEPA LABEL

DRAWING REVISION HISTORY LISTING

PART NO: 1822501
DESCRIPTION: #618 HIGH FORCE CYLINDER ASSEMBLY SET (STD)

<u>APPR.</u>	<u>REV</u>	<u>DATE</u>	<u>BY</u>	<u>DESCRIPTION OF REVISION</u>
SWB	A	2/13/97	TLW	ADDED (STD) ON END OF DESCRIPTION FOR CLARITY.
TLW	B	02/19/98	RLE	ADDED ITEM 12, 816344 LABEL
SWB	C	07/26/05	BWW	REVISED TO ADD DETAIL A AND NOTE 4 FOR CLARITY. RENUMBERED ITEMS FOR CONSISTENCY AND ADDED ITEM QUANTITIES TO MATCH CURRENT STANDARDS. ADDED NEW ITEMS 5 1802001 QTY 8, 6 MBA00047 QTY 16 AND 7 MBG00001 QTY 16 FOR CONSISTENCY WITH OTHER CYLINDER ASSEMBLY SETS. REVISED DESCRIPTION TO BE #618 SPECIFIC.