

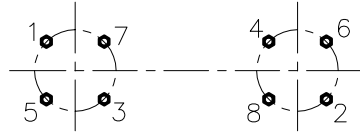


**McElroy Manufacturing, Inc.**  
The leader by design.  
Tulsa, Oklahoma U.S.A.

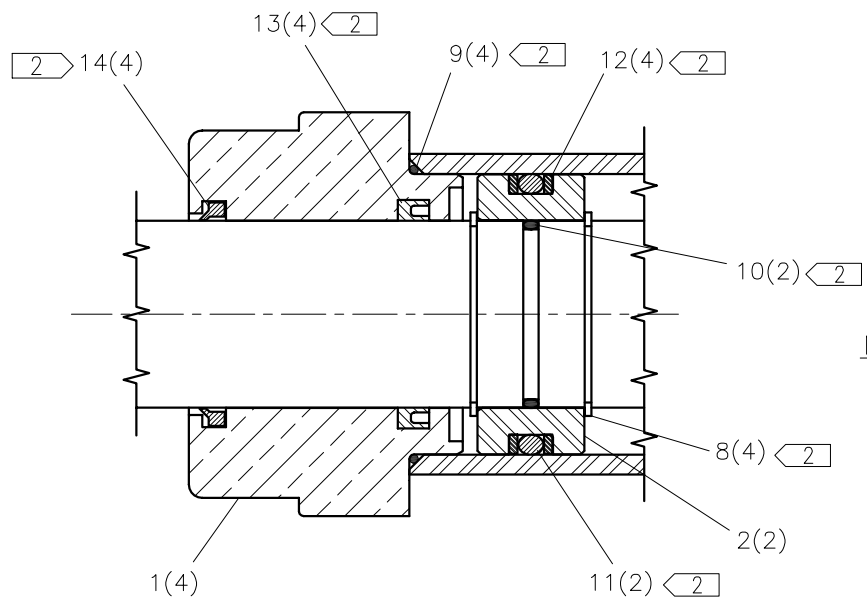
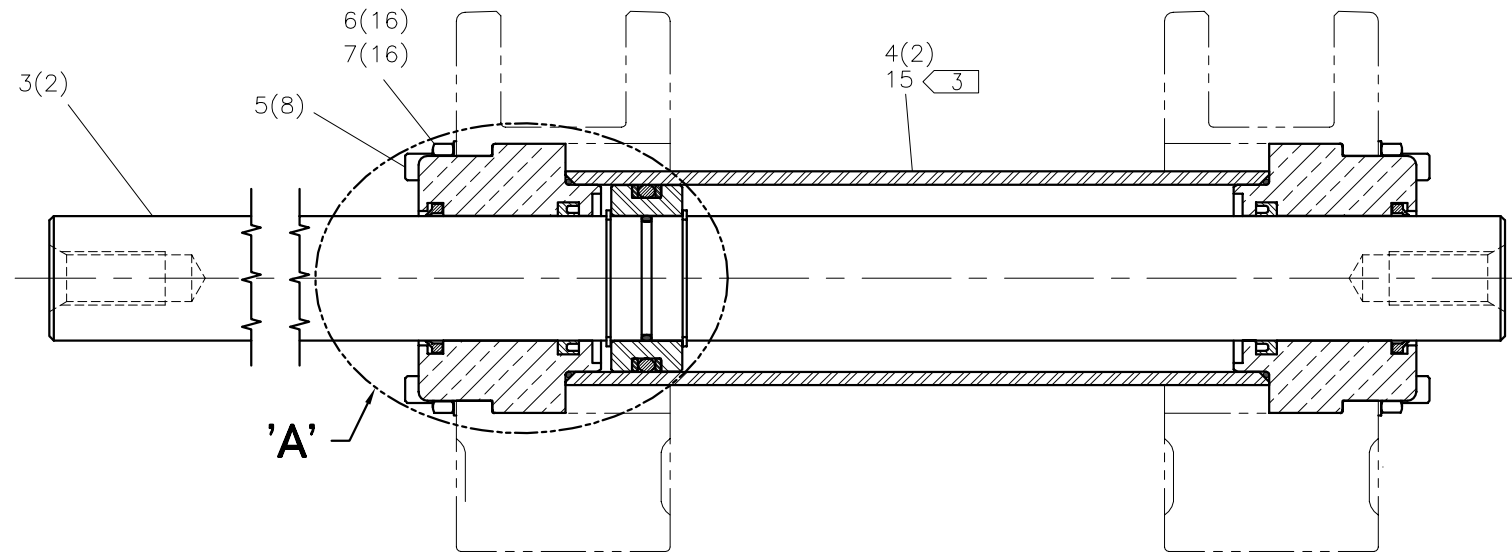
DRAWN: TLW    CHECK: TMT    APPRVD: SWB    DATE: 11/20/96    SHT No: 1    REV No: C    PART No: 1822601

#618 MEDIUM FORCE CYLINDER ASSEMBLY SET (HV)

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



- NOTES:
1. TOTAL EFFECTIVE PISTON AREA = 6.01 SQ. IN.
  2. THESE ITEMS ARE PART OF PART NUMBER A1811301 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 MEDIUM FORCE CYLINDER ASSEMBLY SET (HV)**PARTS LIST

ITEM	PART NO.	QTY	DESCRIPTION
	<b>1822601</b>		<b>ASSEMBLY</b>
1	1224701	4	MF ROD GLAND
2	1216501	2	MF PISTON
3	1202301	2	GUIDE ROD
4	1224801	2	MF 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	MDL00004	4	O-RING
10	MDL00003	2	O-RING
11	MDL00008	2	O-RING
12	MDL00026	4	BACK-UP RING
13	MDL00091	4	SEAL
14	MDL00092	4	SLOTTED WIPER
15	816345	1	6.01 SQ. IN. TEPA LABEL

## DRAWING REVISION HISTORY LISTING

**PART NO:** 1822601

**DESCRIPTION:** #618 MEDIUM FORCE CYLINDER ASSEMBLY SET (HV)

<u>APPR.</u>	<u>REV</u>	<u>DATE</u>	<u>BY</u>	<u>DESCRIPTION OF REVISION</u>
SWB	A	2/13/97	TLW	ADDED (HV) ON END OF DESCRIPTION FOR CLARITY.
TLW	B	02/19/98	RLE	ADDED ITEM 12, 816345 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