

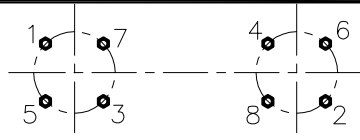


**McElroy Manufacturing, Inc.**  
 The leader by design.  
 Tulsa, Oklahoma U.S.A.

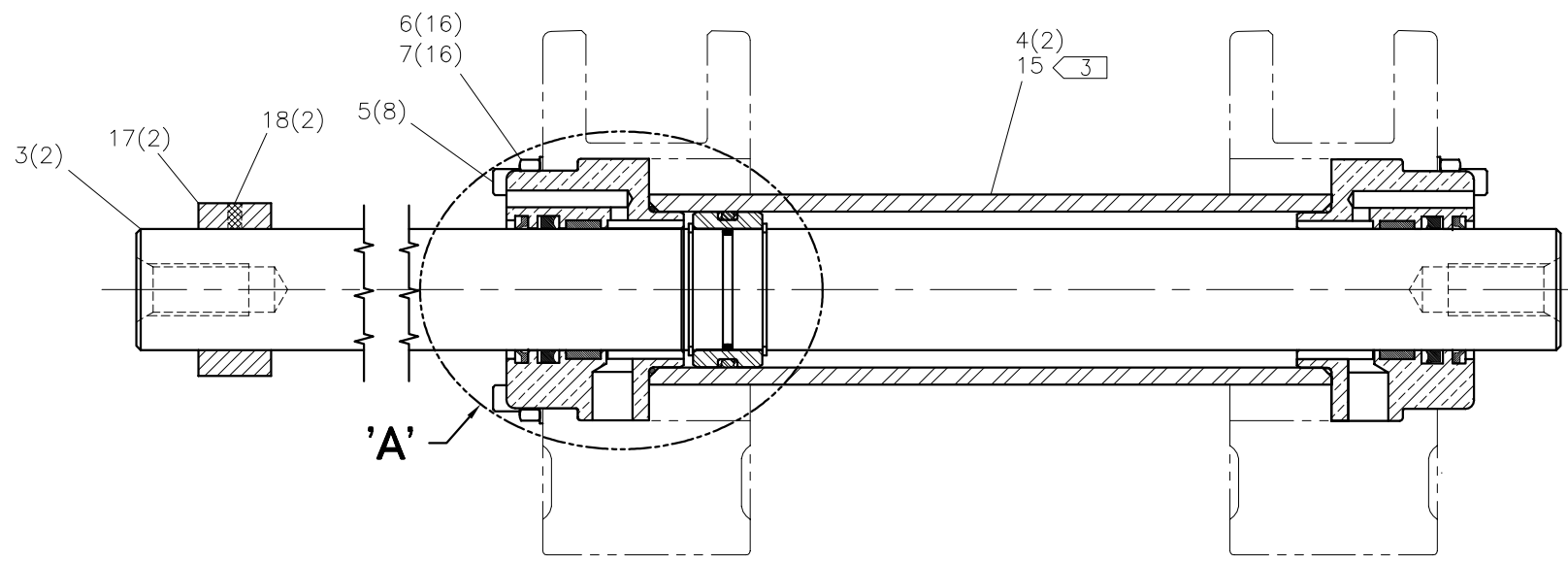
DRAWN: MRP CHECK: BWP APPRV'D: LJJ DATE: 5/28/99 SHT No: 1 REV No: B PART No: 1856801

#618 LOW FORCE CYLINDER ASSEMBLY SET

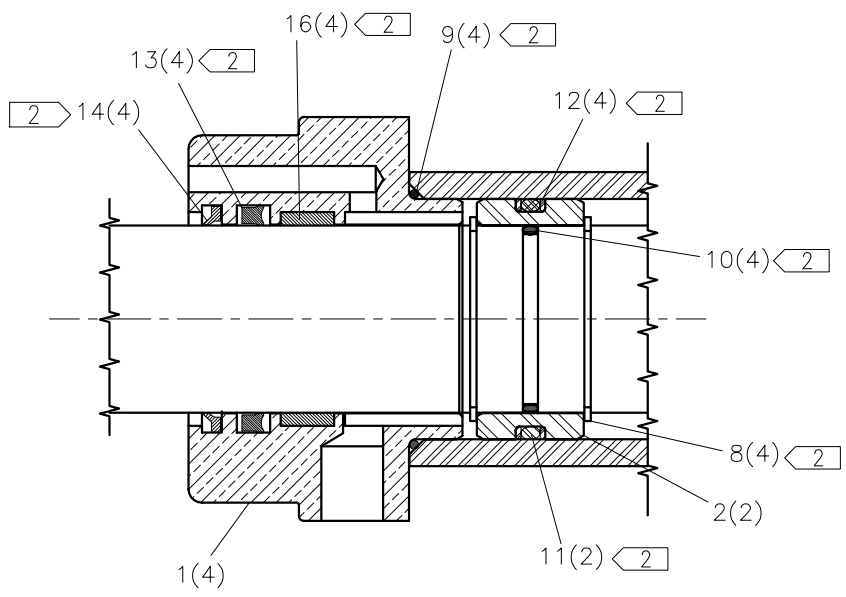
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TIE ROD TORQUE PROCEDURE:  
 TIGHTEN TIE ROD NUTS IN  
 SEQUENCE 16-20 Ft. Lbs.



'A'



NOTES:

1. TOTAL EFFECTIVE PISTON AREA = 3.14 SQ. IN.
2. THESE ITEMS ARE PART OF PART NUMBER A1856801 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 LOW FORCE CYLINDER ASSEMBLY SET**PARTS LIST

ITEM	PART NO.	QTY	DESCRIPTION
	<b>1856801</b>		<b>ASSEMBLY</b>
1	1205601	4	LOW FORCE ROD GLAND
2	1856802	2	LOW FORCE PISTON
3	1202301	2	GUIDE ROD
4	1205801	2	LOW FORCE 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	MDL00188	4	O-RING
10	MDL00003	2	O-RING
11	MDL00224	2	O-RING
12	MDL00225	4	BACK-UP RING
13	MDL00091	4	SEAL
14	MDL00092	4	SLOTTED WIPER
15	816374	1	3.14 SQ. IN. TEPA LABEL
16	MDM00279	2	2" OD GLAND BEARING RING
17	1856803	2	GUIDE ROD COLLAR
18	MAG00002	2	#10-24NC X 3/8 LG SOCKET SET SCREW

## DRAWING REVISION HISTORY LISTING

**PART NO:** 1856801  
**DESCRIPTION:** #618 LOW FORCE CYLINDER ASSEMBLY SET

<u>APPR.</u>	<u>REV</u>	<u>DATE</u>	<u>BY</u>	<u>DESCRIPTION OF REVISION</u>
DWP	A	11/20/00	MLM	ADDED ITEMS 14 & 15 - TO LIMIT TRAVEL.
SWB	B	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.