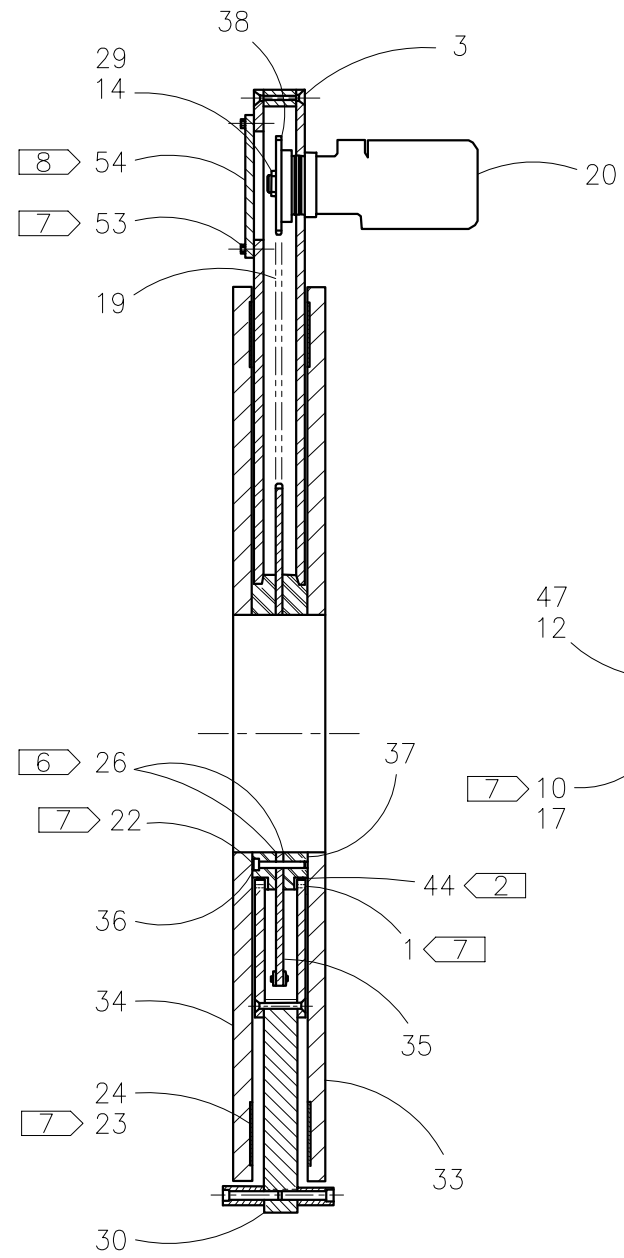




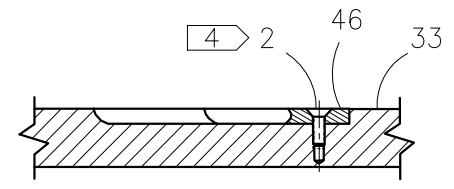
McElroy Manufacturing, Inc.
 The leader by design.
 Tulsa, Oklahoma U.S.A.

DRAWN: TLW	CHECK: BWP	APPRV'D: B	DATE: 5-22-95	DWG No: 4800700	SHT No: 1	REV No: R	PART No: 4800701
#1648A FACER ASSEMBLY							CAD No: 4800701

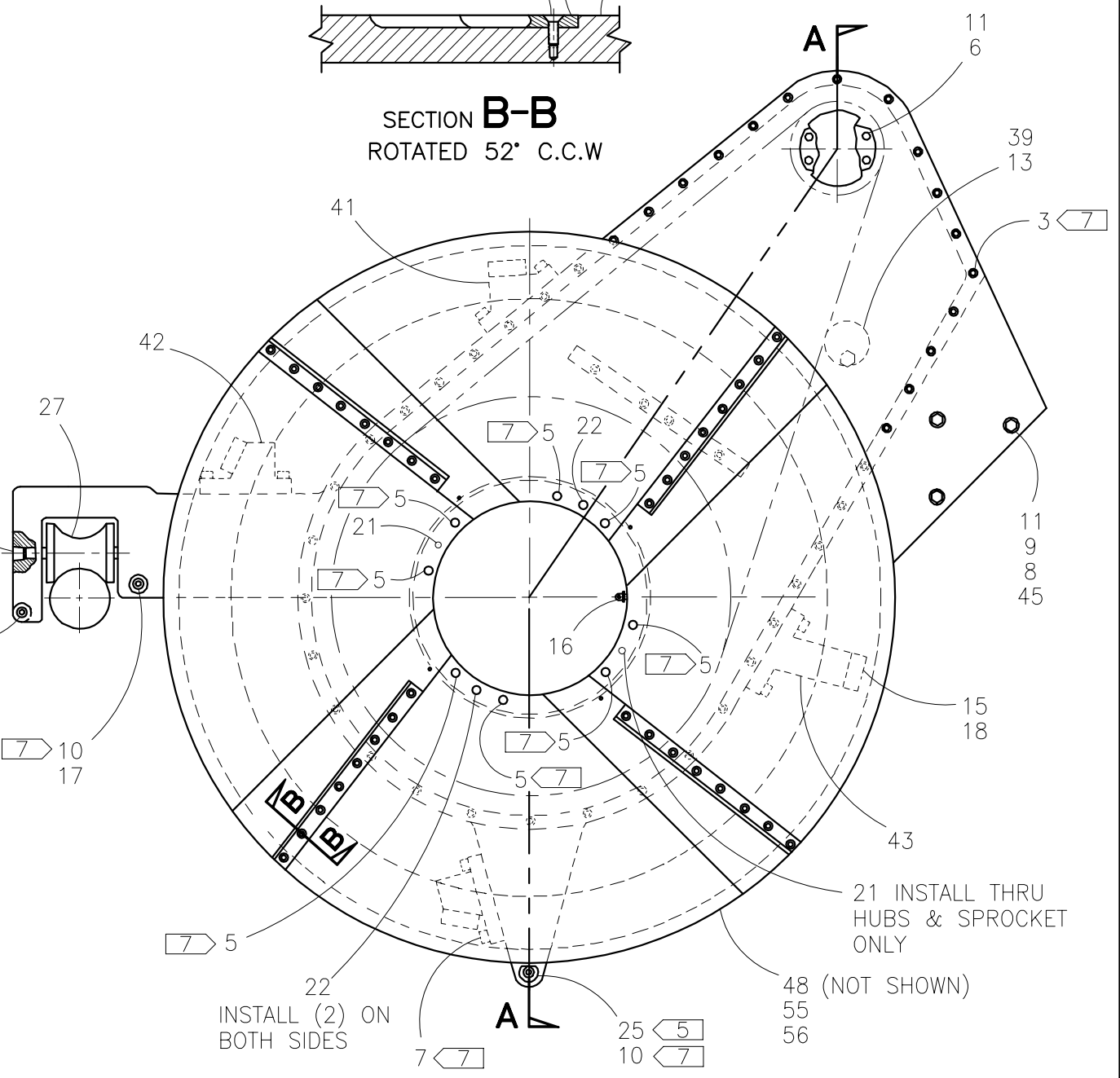
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SECTION **A-A**



SECTION **B-B**
 ROTATED 52° C.C.W



21 INSTALL THRU HUBS & SPROCKET ONLY

48 (NOT SHOWN)

55

56

INSTALL (2) ON BOTH SIDES

#1648A FACER ASSEMBLYPARTS LIST

ITEM	PART NO.	QTY	DESCRIPTION
	4800701		ASSEMBLY
1	MAD00002	16	#4-40NC x 3/8 LG. FHSCS
2	MAH00077	64	1/4-20NC x 3/4 LG. FHSCS SS
3	MAD00045	92	1/4-20NC x 1" LG. FHSCS
4			
5	MAC00106	8	3/8-16NC x 4-1/2 LG. SHCS
6	MAB00081	4	1/2-13NC x 1-1/4 LG. HHCS
7	MAC00142	8	1/2-13NC x 1-3/4 LG. SHCS
8	MAB00111	3	1/2-13NC x 3-3/4 LG. HHCS
9	MBA00009	3	1/2-13NC HEX NUT
10	MAC00100	10	3/8-16NC X 2-1/2 LG. SHCS
11	MBE00009	7	1/2" LOCK WASHER
12	MFA00039	1	12MPT PLUG
13	MBC00032	1	3/4-16NF HEX NYLON LOCK NUT
14	MCB00005	1	EXTERNAL SNAP RING
15	MFJ00007	8	GREASE ZERK
16	MFJ00008	2	1/4-28NF GREASE ZERK
17	3603625	4	REST BUTTON
18	MDM00060	8	CAM FOLLOWER
19	A4831101	1	FACER ROLLER CHAIN ASSEMBLY
20	4819301	1	FACER MOTOR SHAFT MODIFICATION
21	MCI00005	2	3/8 x 2-3/4 LG. DOWEL PIN
22	MAF00027	4	3/8 x 1-1/2 LG. SKT HD SHOULDER SCR
23	MAD00010	64	#6-32NC x 1/4 LG. FHSCS
24	4825001	2	WEAR RING
25	3603626	2	REST BUTTON
26	4824101	2	SHIM
27	4807501	1	ROLLER
28			
29	4808801	1	SPACER
30	4809101	1	FACER HOUSING W/ COVER PLATES & SPACER
31			
32			
33	4809402	1	C'BORED BLADE HOLDER
34	4809502	1	TAPPED BLADE HOLDER
35	4809601	1	FACER DRIVEN SPROCKET MODIFICATION

#1648A FACER ASSEMBLYPARTS LIST

ITEM	PART NO.	QTY	DESCRIPTION
36	4809701	1	AFT DRIVEN SPROCKET HUB
37	4809702	1	FORWARD DRIVEN SPROCKET HUB
38	4809801	1	FACER DRIVE SPROCKET MODIFICATION
39	4809901	1	CHAIN TENSIONER
40			
41	4811301	1	CAM FOLLOWER HOUSING
42	4811401	2	CAM FOLLOWER HOUSING
43	4811501	1	CAM FOLLOWER HOUSING
44	4813501	2	BEARING
45	3613302	6	PIVOT ARM SLEEVE
46	3615708	1	BLADE SET
47	4816701	1	HOUSING SHAFT & ROLLER
48	4817506	1	CHIP GUARD
49	4807703	1	PIVOT ARM (Ref.) (Not Shown)
50	4807704	2	PIVOT ARM BUSHING (Ref.) (Not Shown)
51			
52			
53	MAC00051	4	1/4-20NC x 1/2 LG. SHCS
54	1231102	1	CHAIN & SPROCKET ACCESS COVER
55	MAE00023	7	#10-24NC x 1/2 LG. BHSCS
56	MBE00004	7	#10 REGULAR SPLIT LOCK WASHER

NOTES:

1. USE ASSEMBLY PROCEDURE ES326A.
2. PACK BEARINGS WITH EP GREASE.
3. FILL FACER CAVITY 2/3 FULL WITH EP GREASE.
4. INSTALL WITH HIGH TEMPERATURE ANTI-SEIZE COMPOUND.
5. ON NEAR & FAR SIDES, LOCATE FLATS OF ITEM 25 REST BUTTONS AS SHOWN.
6. REFERENCE ASSEMBLY PROCEDURE ES326A FOR DETERMINING SHIM THICKNESS.
7. INSTALL WITH MEDIUM STRENGTH THREAD LOCKING COMPOUND.
8. INSTALL WITH GASKET SEALER.

DRAWING REVISION HISTORY LISTING

PART NO: 4800701
DESCRIPTION: #1648A FACER ASSEMBLY

<u>APPR.</u>	<u>REV</u>	<u>DATE</u>	<u>BY</u>	<u>DESCRIPTION OF REVISION</u>
SWB	G	05/22/95	TLW	SCANNED & REDUCED TO 'A' SIZE FORMAT. REMOVED PIVOT ARM.
SWB	H	05/01/96	TLW	CHANGED ITEM #4(MAC00099) TO (MAC00100), CHANGED #17(MJC00002) TO (3603625) & #25(4825101) TO (3603626).
TLW	J	04/01/98	RLE	ITEM #4 & ITEM #10 WERE BOTH CALLED OUT AS MAC00100, REMOVED ITEM #4 & CHANGED QTY. OF ITEM #10 FROM (4) TO (14).
SWB	--	09/14/98	TLW	ADDED W/ COVER PLATE & SPACER TO ITEM #30 DESCRIPTION.
TLW	K	11/03/98	TGW	ADDED (1231102) CHAIN & SPROCKET ACCESS COVER & (MAC00051) ATTACHING SCREWS. ADDED NOTES 7 & 8.
TLW	L	06/27/00	PB	REVISED ITEM #10 MAC00100 QTY. 14 TO QTY. 10 & ITEM #17 3603625 QTY. 8 TO QTY. 4. PICTORIAL UPDATE TO REFLECT REVISIONS MADE TO BLADE HOLDERS. ADDED NOTE 8 TO INSTALL W/GASKET SEALER.
TLW	-	10/23/00	BWW	REVISED ITEM #48 FROM 4817501 CHIP GUARD ASSEMBLY TO 4817506 CHIP GUARD. THIS ELIMINATES MULTIPLE PIECE ASSEMBLY.
SWB	M	8/20/02	RLE	CORRECTED DRAWING BY ADDING MAE00023 QTY. (7) & MBE00004 QTY. (7) TO ATTACH 4817506 CHIP GUARD. CORRECTED MAC00139 TO MAB00081 & MAD00010 FROM QTY. (32) TO QTY. (64). ADDED NOTE "USE ASSEMBLY PROCEDURE ES 326A" & REVISED NOTE #6 TO REFER TO ASSEMBLY PROCEDURE TO DETERMINE SHIM THICKNESS.
SWB	N	3/19/03	RLE	REVISED NOTES TO AGREE WITH ENGINEERING STANDARDS.
MLM	-	07/16/03	BWW	REMOVED ITEM 28 4807702 WHICH SHOULD HAVE BEEN REMOVED AT REV. G.
LAA	P	09/25/03	BWW	REVISED QTY OF ITEM 26 4824101 FROM 1 TO 2 TO FACILITATE ASSEMBLY.
SWB	R	5/5/06	RLE	REVISED ITEM #19 MDG00023 TO A4831101, DELETED ITEM #51 MDG00022 & ITEM #52 MDG00028. CHAIN & LINKS REPLACED BY CHAIN ASSEMBLY.