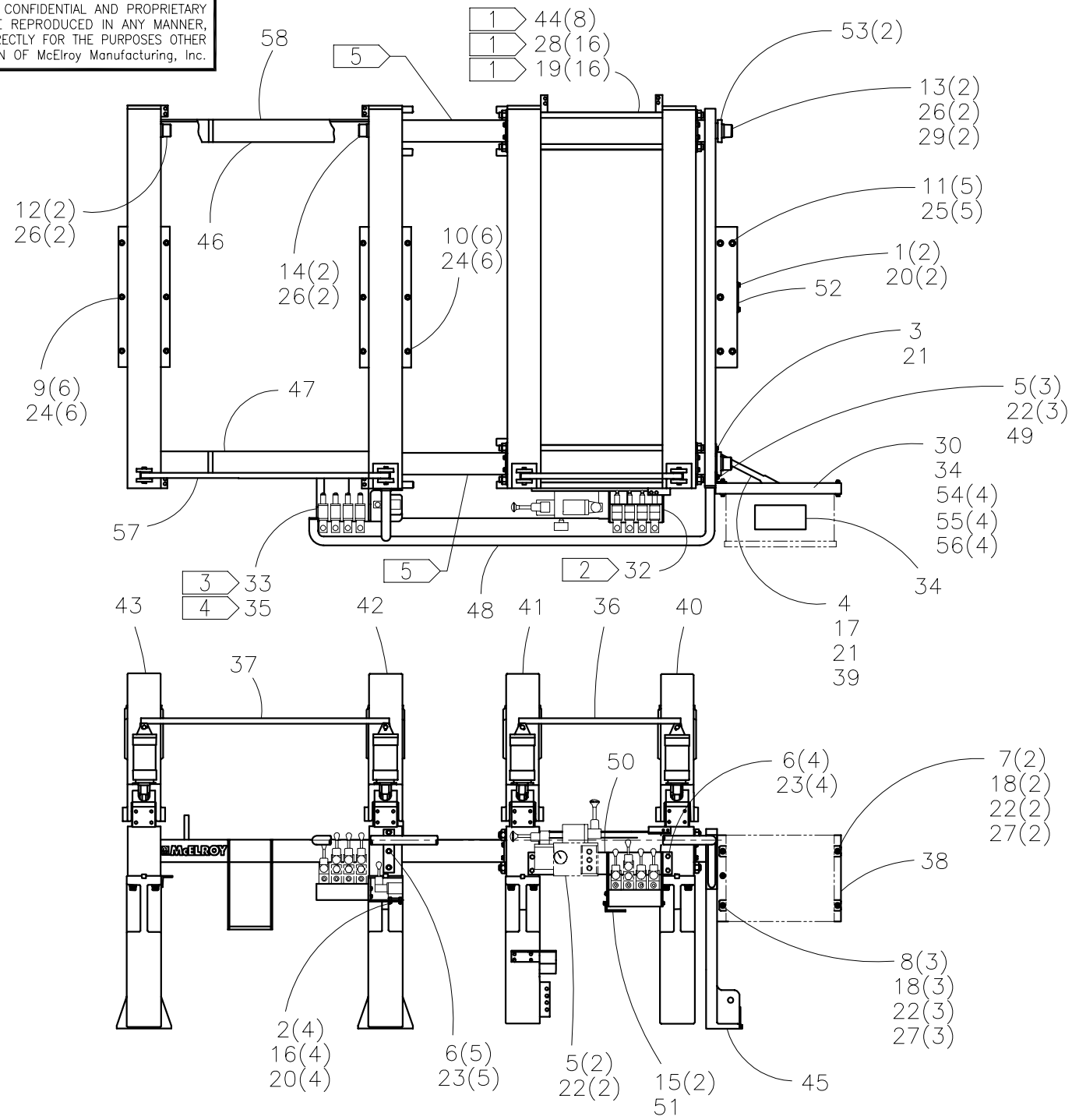




McElroy Manufacturing, Inc.
 The leader by design.
 Tulsa, Oklahoma U.S.A.

DRAWN: RLE	CHECK: TLW	APPRV'D: SWB	DATE: 03/22/99	DWG No: 4829200	SHT No: 1	REV No: D	PART No: 4829201
#1648 JAW SET ASSEMBLY							CAD No: 4829201

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TIE ROD TORQUE PROCEDURE:
 TIGHTEN TIE ROD NUTS IN
 SEQUENCE 8-10 Ft. Lbs.
 REPEAT 185-200 Ft. Lbs.

#1648 JAW SET ASSEMBLYParts List

ITEM	PART NO.	QTY.	DESCRIPTION
	4829201		ASSEMBLY
1	MAB00004	2	1/4-20NC x 3/4 LG. HHCS
2	MAB00005	4	1/4-20NC x 1-1/4 LG. HHCS
3	MAB00032	1	5/16-18NC x 3/4 LG. HHCS
4	MAB00036	1	5/16-18NC x 1-3/4 LG. HHCS
5	MAB00064	5	3/8-16NC x 1" LG. HHCS
6	MAB00081	9	1/2-13NC x 1-1/4 LG. HHCS
7	MAC00094	2	3/8-16NC x 1" LG. SHCS
8	MAC00101	3	3/8-16NC x 2-3/4 LG. SHCS
9	MAC00163	6	5/8-11NC x 1-1/2 LG. SHCS
10	MAC00164	6	5/8-11NC x 1-3/4 LG. SHCS
11	MAC00183	5	3/4-10NC x 1-3/4 LG. SHCS
12	MAC00228	2	1-1/2-6NC x 4" LG. SHCS
13	MAC00231	2	1-1/2-6NC x 5-1/2 LG. SHCS
14	MAC00236	2	1-1/2-6NC x 8" LG. SHCS
15	MAH00062	2	U-BOLT W/NUTS
16	MBA00005	4	1/4-20NC HEX NUT
17	MBA00006	1	5/16-18NC HEX NUT
18	MBA00007	5	3/8-16NC HEX NUT
19	MBA00055	16	1-14NS HEX NUT
20	MBE00005	6	1/4" LOCK WASHER
21	MBE00006	2	5/16" LOCK WASHER
22	MBE00007	10	3/8" LOCK WASHER
23	MBE00009	9	1/2" LOCK WASHER
24	MBE00011	12	5/8" LOCK WASHER
25	MBE00012	5	3/4" LOCK WASHER
26	MBE00015	6	1-1/2" LOCK WASHER
27	MBF00007	5	3/8" FLAT WASHER
28	MBG00011	16	FLAT WASHER BLACK
29	MBG00039	2	FLAT WASHER BLACK
30	MJQ00260	1	STD. 8-1/2 x 11" LITERATURE COMPARTMENT
31			
32	816302	1	FACER VALVE LABEL (CAP)
33	816313	1	INDEXING CYLINDER LOCK LABEL (CAP)
34	816342	2	SAFETY INSTRUCTION MANUAL LABEL
35	816366	1	INDEXING CYLINDER LOCK NOTICE LABEL
36	2414211	1	48" MOVABLE JAW CLAMP CYLINDER HANDLE
37	2414212	1	48" FIXED JAW CLAMP CYLINDER HANDLE
38	3607902	1	ELECTRICAL BOX MOUNTING BRACKET WELDMENT

#1648 JAW SET ASSEMBLYParts List

ITEM	PART NO.	QTY.	DESCRIPTION
39	3608101	1	MOUNTING BRACKET ELECTRICAL BOX BRACE
40	4800501	1	OUTER MOVABLE JAW ASSEMBLY
41	4800502	1	INNER MOVABLE JAW ASSEMBLY
42	4800503	1	INNER FIXED JAW ASSEMBLY
43	4800504	1	OUTER FIXED JAW ASSEMBLY
44	4803401	8	TIE ROD
45	4803502	1	ROD SUPPORT
46	4803701	1	OPPOSITE OPERATOR SIDE FIXED JAW TIE BAR
47	4803702	1	OPERATOR SIDE FIXED JAW TIE BAR
48	4814801	1	GUIDE RAIL
49	4814901	1	ELECTRICAL BOX BRACKET MOUNTING ANGLE
50	4815002	1	MOVABLE MANIFOLD MOUNTING BRACKET
51	4818602	1	FACER OPERATING VALVE MOUNTING BRACKET
52	4819101	1	FRONT BULKHEAD PLATE
53	4823601	2	FRONT END LIFT PLATE
54	MBF00004	4	#10 TY 'A' WIDE FLAT WASHER
55	MCK00003	4	3/16DIA X 3/8 GRIP BLIND RIVET
56	MLN00175	4	1/4 X 1/2 O.D. SEAL WASHER
57	8163119	1	MEDIUM McELROY BRANDING LABEL
58	8163120	1	LARGE McELROY BRANDING LABEL

NOTES:

1. SEE TIE ROD TORQUE PROCEDURE.
2. ATTACH ITEM 32 LABEL (CAP) TO VALVE BEHIND FACER MANIFOLD.
3. ATTACH ITEM 33 LABEL (CAP) TO VALVE BEHIND FIXED JAW VALVE STACK.
4. ATTACH ITEM 35 LABEL TO BRACKET ABOVE BALL VALVE.
5. INSTALL GUIDE ROD END WITH "FWD" IDENTIFICATION IN GUIDE ROD SUPPORT PLATE OR END WITH LONGEST DIMENSION FROM SNAP RING GROOVE TO END OF GUIDE ROD.

DRAWING REVISION HISTORY LISTING

PART NO: 4829201
DESCRIPTION: #1648 JAW SET ASSEMBLY

<u>APPR.</u>	<u>REV</u>	<u>DATE</u>	<u>BY</u>	<u>DESCRIPTION OF REVISION</u>
TLW	A	8/5/99	DJL	REVISED TO REMOVE ITEM 31 MJU00001(VHB TAPE) AND ADD ITEMS 4,55, AND 56 TO SECURE LITERATURE COMPARTMENT.
SWB	B	9/7/01	RLE	ADDED NOTE 5 TO ASSURE PROPER ASSEMBLY.
SWB	C	3/8/04	ALK	ADDED ADDITIONAL INFORMATION TO NOTE 5 TO ELIMINATE CONFUSION.
SWB	D	01/06/05	BWW	ADDED ITEM #57 8163119 QTY. (1) MEDIUM BRANDING LABEL& #58 8163120 QTY. (1) LARGE BRANDING LABEL.