



McElroy Manufacturing, Inc.

The leader by design.

Tulsa, Oklahoma U.S.A.

DRAWN: MCB

CHECK: RLP

APPRVD: MRP

DATE: 07/29/14

SHT No: 1

REV No: A

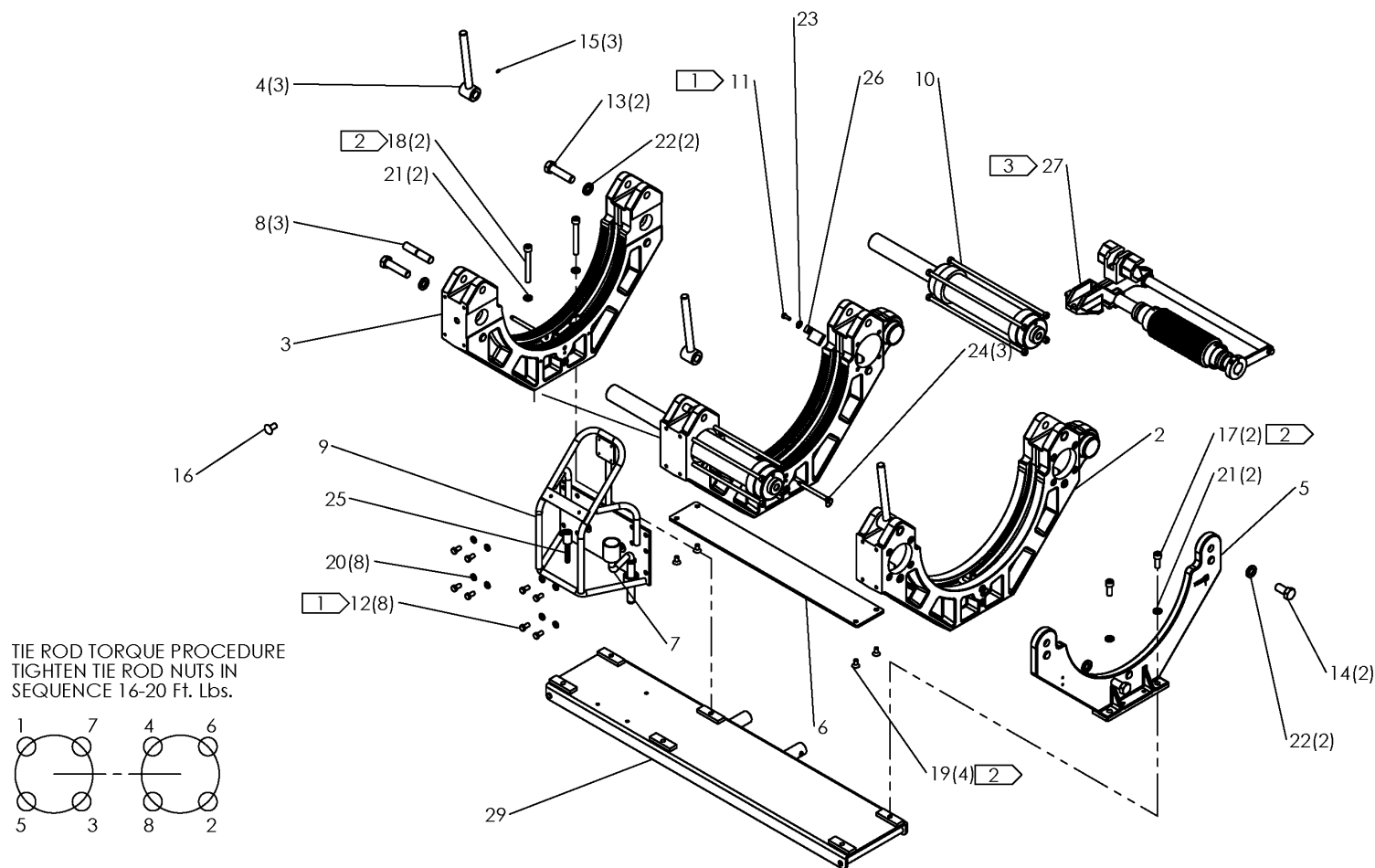
PART No: T1825501

618 LOW FORCE CARRIAGE CONVERSION ASSEMBLY

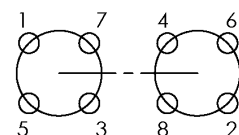
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NOTES:

1. INSTALL WITH HIGH STRENGTH THREAD LOCKING COMPOUND.
2. INSTALL WITH HIGH TEMP. ANTI-SEIZE.
3. THIS IS A SUB-ASSEMBLY ON A SEPERATE DRAWING.



TIE ROD TORQUE PROCEDURE
TIGHTEN TIE ROD NUTS IN
SEQUENCE 1-8 Ft. Lbs.



UNLESS
NOTED
OTHERWISE

(3) P.L.C. DIMS .XXX = ± 0.005 "
(2) P.L.C. DIMS .XX = ± 0.010 "
FRACTIONAL DIMS = $\pm 1/32$ "

ANGULAR DIMS = $\pm 1/4$ "
REMOVE ALL BURRS
BREAK ALL SHARP EDGES

STAMP OR ETCH PM
ON ALL DETAIL PARTS

MMI NUMBER

ITEM

QTY.

SIZE AND DESCRIPTION

McElroy Manufacturing Parts List

Part Number: T1825501 #618 LF Carriage Conversion Assembly

Part Number T1825501 Component List

Item	Component	Description	Quantity	Unit	Price
1	1801113	Lower Inner Movable Jaw	1.0	EA	2,905.00
2	1801114	Lower Outer Movable Jaw	1.0	EA	3,024.00
3	1801116	Hyd Clmp Lwr Inner Fixed Jaw	1.0	EA	2,624.00
4	1801801	8" Eye Bolt Clamp	3.0	EA	112.00
5	1801902	Rod Support	1.0	EA	660.00
6	1814601	Carriage Support Plate	1.0	EA	174.00
7	1818501	12/18 Speed Wrench Assy	1.0	EA	216.00
8	1819101	Pivot Pin	3.0	EA	26.37
9	1853101	Manifold Bracket Weldment	1.0	EA	425.00
10	1856801	618 LF Cylinder Assembly Set	1.0	S2	8,079.00
11	MAB00003	1/4-20NCX3/4LG Hhcs	1.0	EA	0.31
12	MAB00063	3/8-16NCX3/4LG Hhcs	8.0	EA	0.39
13	MAB00084	3/4-10NCX3LG Hhcs GR8	2.0	EA	9.82
14	MAB00091	3/4-10NCX1-1/2LG Hhcs	2.0	EA	5.04
15	MAG00002	#10-24NCX3/8LG Skt Set Scr	3.0	EA	1.24
16	MAI00001	1/2-13NCX1LG Crg Bolt	1.0	EA	1.90
17	MAN00017	1/2-13NCX1-1/4LG Shcs SS	2.0	EA	1.90
18	MAN00018	1/2-13NCX4LG Shcs SS	2.0	EA	10.01
19	MAN00057	3/8-16NCX3/4LG Fhcs SS	4.0	EA	1.41
20	MBE00007	3/8 Reg Splt Lck Wshr Stl PL	8.0	EA	0.12
21	MBE00009	1/2 Reg Splt Lck Washer Stl PL	4.0	EA	0.16
22	MBE00012	3/4 Reg Splt Lck Washer Stl PL	4.0	EA	0.50
23	MBF00005	1/4 TY 'a' Wide FL Wshr Stl PL	1.0	EA	0.11
24	MCE00004	3/8DIA X3.75 Grip Detent Pin	3.0	EA	5.89
25	MJL00018	3/8 Hex Key Wrench-long Ser PL	1.0	EA	11.38
26	T1208901	Facer Stop Pad	1.0	EA	46.72
27	T1801401	TracStar 618 Facer Pivot Shaft Assembly	1.0	EA	1,475.00
28	T1801005	TracStar 618 PPR Carriage Hydraulic/Plumbing Schematic	1.0	EA	0.00
29	T1202501	Carriage Skid	1.0	EA	1,063.00

Please visit <https://fusion.mcelroy.com/parts> to purchase parts or for more information.