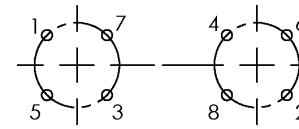
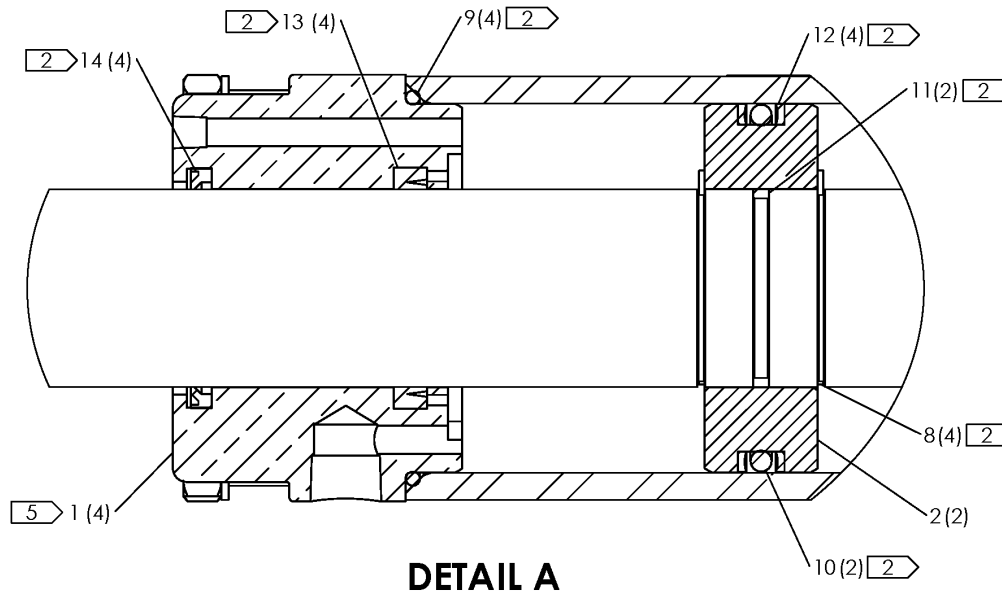
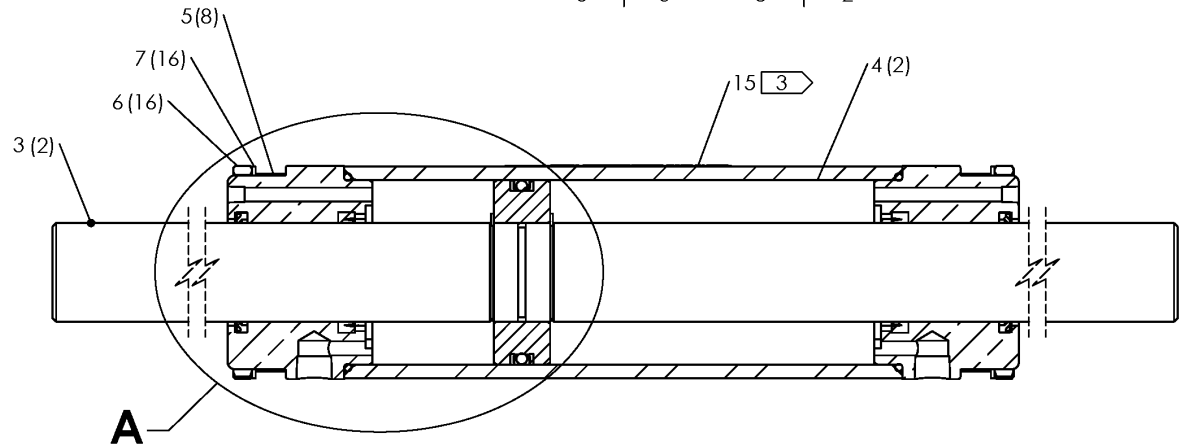


412 HIGH FORCE CYLINDER ASSEMBLY SET

NOTE: THIS DRAWING AND THE INFORMATION CONTAINED THEREIN IS THE CONFIDENTIAL AND PROPRIETARY PROPERTY OF McElroy Manufacturing, Inc. THE DRAWING IS NOT TO BE REPRODUCED IN ANY MANNER, SUBMITTED TO OUTSIDE PARTIES FOR EXAMINATION, OR USED DIRECTLY OR INDIRECTLY FOR THE PURPOSES OTHER THAN THOSE FOR WHICH IT WAS FURNISHED WITHOUT WRITTEN PERMISSION OF McElroy Manufacturing, Inc.



TIE ROD TORQUE PROCEDURE:
TIGHTEN TIE ROD NUTS IN
SEQUENCE 16-20 ft-lbs.



DETAIL A

NOTES:

1. TOTAL EFFECTIVE PISTON AREA = 11.78 SQ. IN.
2. THESE ITEMS ARE PART OF PART NUMBER A1811201 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.
5. FOR REPLACEMENT BLEED PORT FITTING ORDER PART NUMBER MFA00001.
6. INSTALL PISTON USING CHAMFER ON THE I.D. TO EASE INSTALLATION OVER O-RING. CHAMFER ON PISTON SHOULD FACE INNER FIXED JAW WHEN INSTALLED IN CARRIAGE, RESULTANT DIRECTION OF SINGLE SIDED CHAMFER ON PISTON MAKE STRONGEST RETAINING RING JOINT CLOSING CARRIAGE CYLINDERS

McElroy Manufacturing Parts List

Part Number: 1251701 412 HF Cylinder Assembly Set

Part Number 1251701 Component List

Item	Component	Description	Quantity	Unit	Price
1	1202501	HF Rod Gland	4.0	EA	574.00
2	1202201	HF Piston	2.0	EA	148.00
3	1202301	Guide Rod	2.0	EA	686.00
4	1202401	HF Carriage Cylinder	2.0	EA	331.00
5	1204301	Tie Rod	8.0	EA	33.02
6	MBA00047	3/8-24NF Fnsh Hex Nut GR8 PL	16.0	EA	0.42
7	MBG00001	3/8 Type 'an' FL Wshr Stl PL	16.0	EA	0.26
8	MCB00011	Ext Snap Ring	4.0	EA	2.54
9	MDL00009	O-ring	4.0	EA	1.96
10	MDL00013	O-ring	2.0	EA	2.08
11	MDL00003	O-ring	2.0	EA	0.91
12	MDL00027	Contoured Back -up Ring	4.0	EA	2.40
13	MDL00091	Seal	4.0	EA	30.92
14	MDL00092	Wiper	4.0	EA	6.32
15	816344	11.78 SQ IN Tega Label	1.0	EA	6.16

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