



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

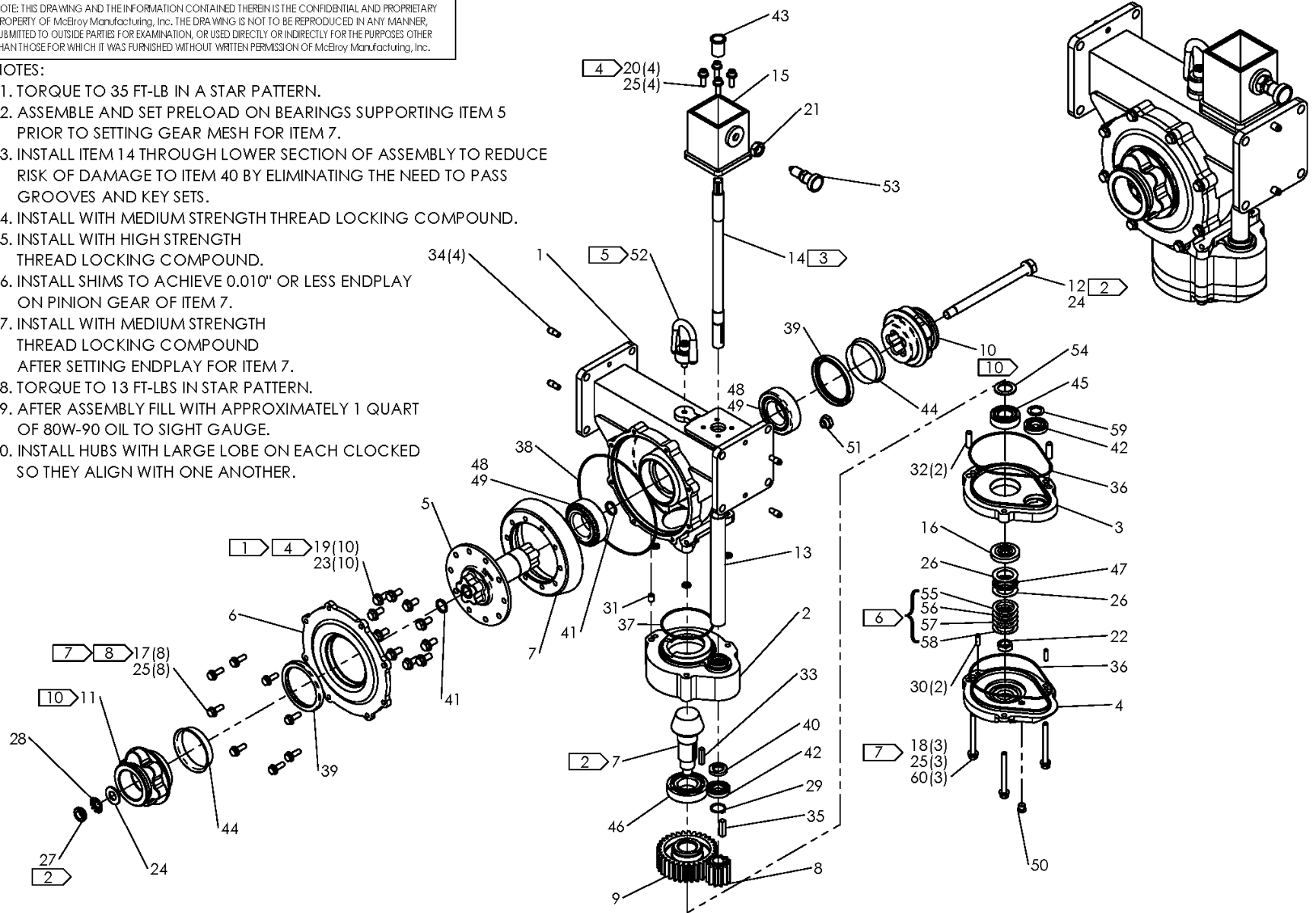
DRAWN: MRH CHECK: SPA APPRVD: PJD DATE: 4/6/18 SHT No: 1A REV No: D PART No: 2487101

Acrobat™ FACER GEARBOX ASSEMBLY

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.

NOTES:

1. TORQUE TO 35 FT-LB IN A STAR PATTERN.
2. ASSEMBLE AND SET PRELOAD ON BEARINGS SUPPORTING ITEM 5 PRIOR TO SETTING GEAR MESH FOR ITEM 7.
3. INSTALL ITEM 14 THROUGH LOWER SECTION OF ASSEMBLY TO REDUCE RISK OF DAMAGE TO ITEM 40 BY ELIMINATING THE NEED TO PASS GROOVES AND KEY SETS.
4. INSTALL WITH MEDIUM STRENGTH THREAD LOCKING COMPOUND.
5. INSTALL WITH HIGH STRENGTH THREAD LOCKING COMPOUND.
6. INSTALL SHIMS TO ACHIEVE 0.010" OR LESS ENDPLAY ON PINION GEAR OF ITEM 7.
7. INSTALL WITH MEDIUM STRENGTH THREAD LOCKING COMPOUND AFTER SETTING ENDPLAY FOR ITEM 7.
8. TORQUE TO 13 FT-LBS IN STAR PATTERN.
9. AFTER ASSEMBLY FILL WITH APPROXIMATELY 1 QUART OF 80W-90 OIL TO SIGHT GAUGE.
10. INSTALL HUBS WITH LARGE LOBE ON EACH CLOCKED SO THEY ALIGN WITH ONE ANOTHER.





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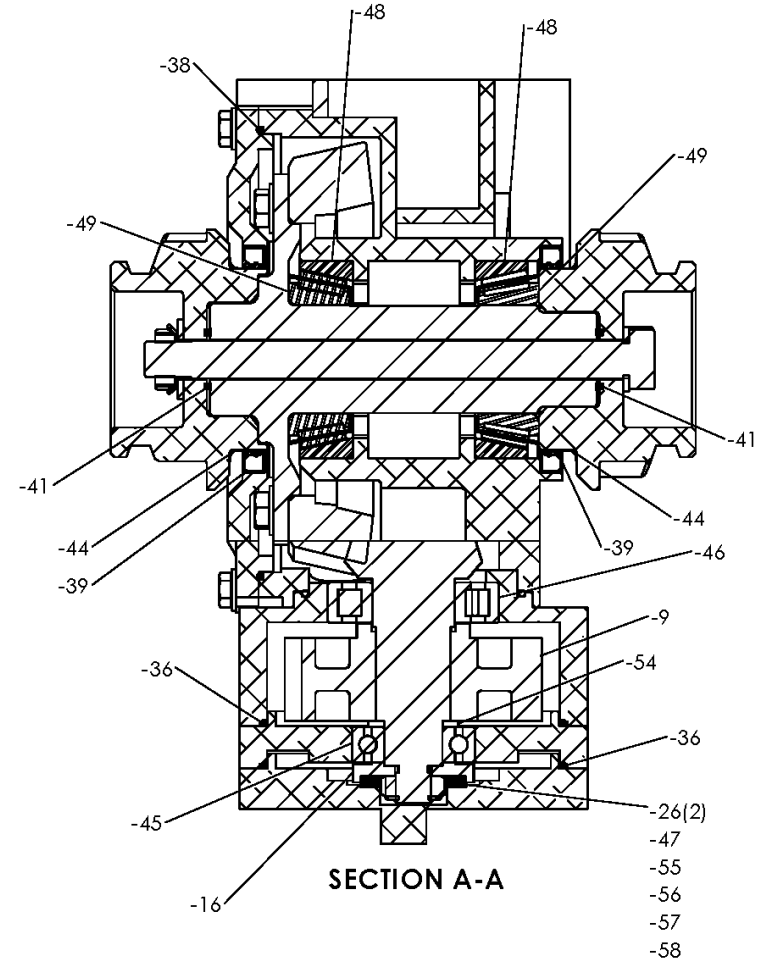
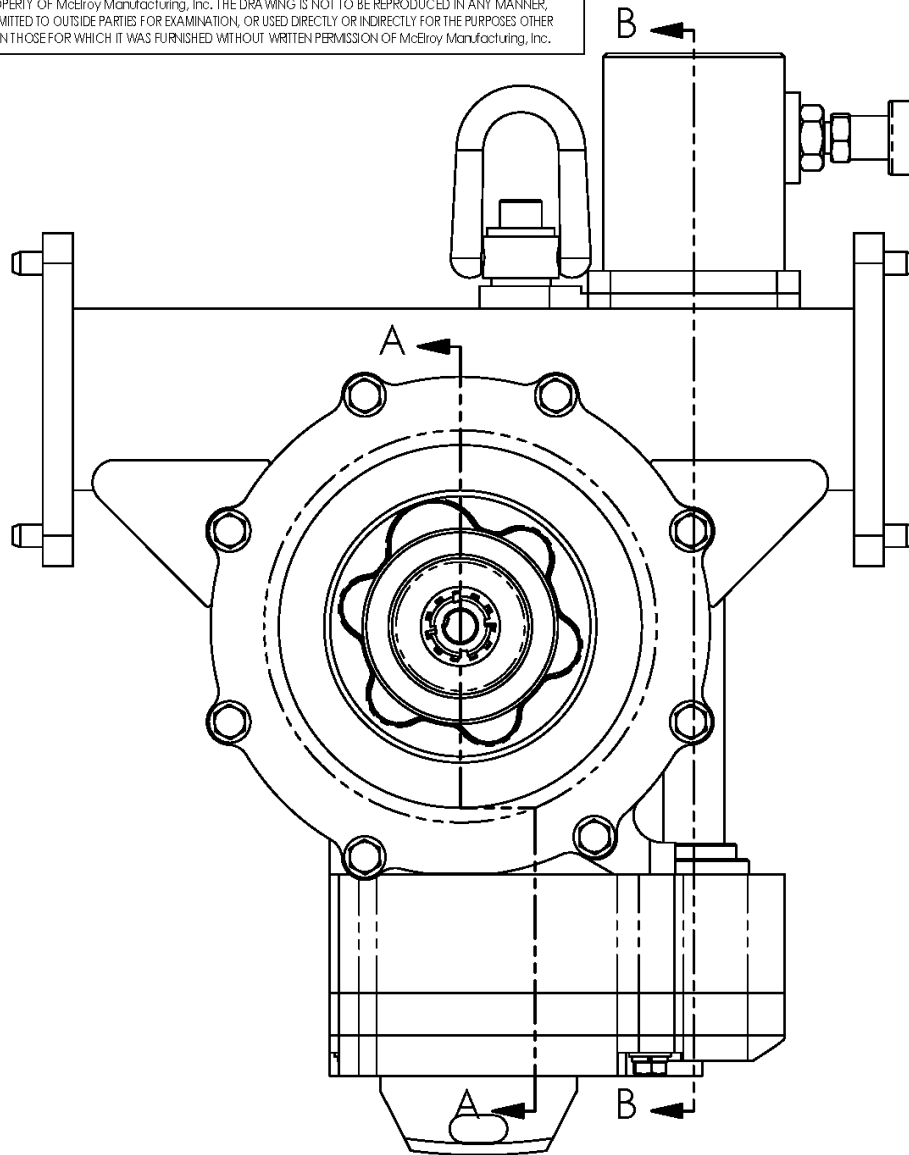
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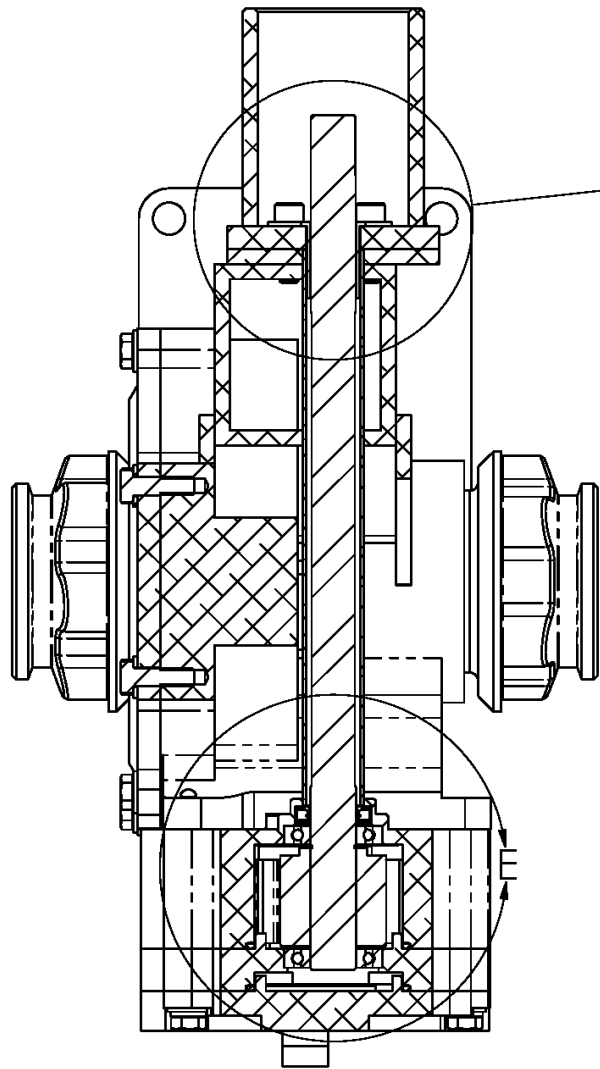


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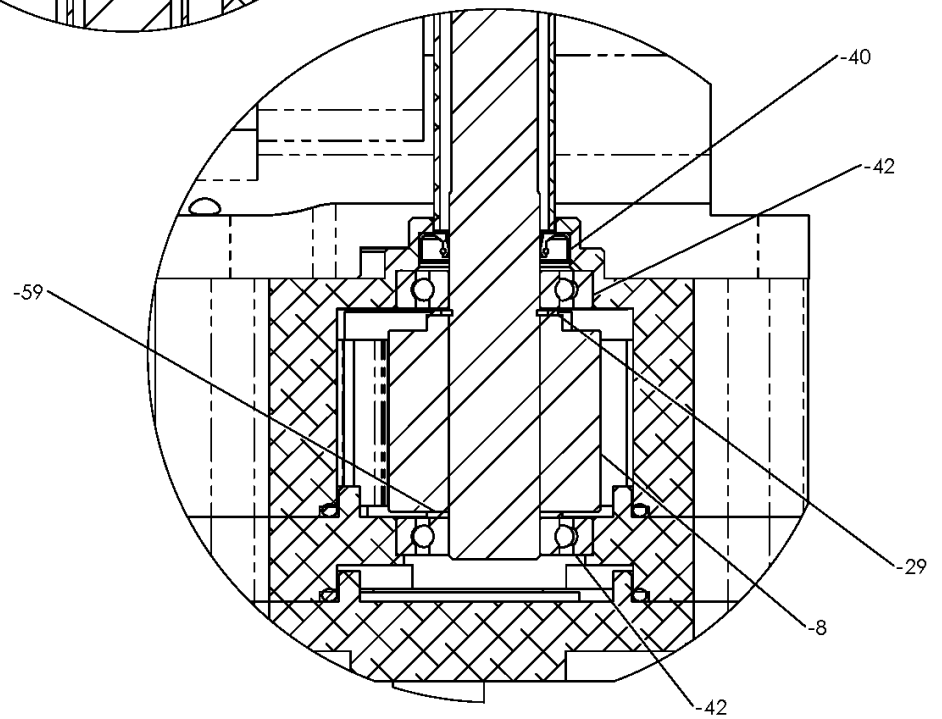
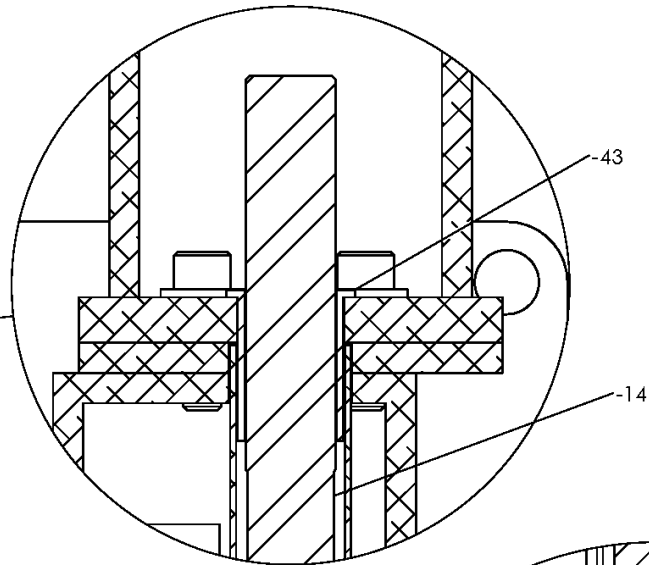
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SECTION B-B



McElroy Manufacturing Parts List

Part Number: 2487101 Acrobat Facer Gearbox Assembly

Part Number 2487101 Component List

Item	Component	Description	Quantity	Unit	Price
1	2487301	Facer Gearbox Housing	1.0	EA	0.00
2	2487401	Fcr Grbx Upper Pinion Housing	1.0	EA	0.00
3	2487501	Fcr Grbx Middle Pinion Housing	1.0	EA	834.00
4	2487601	Fcr Grbx Lower Pinion Housing	1.0	EA	685.00
5	2487701	Facer Gearbox Output Shaft (Effective to 12/2/18)	1.0	EA	0.00
5	2487702	Facer Gearbox Output Shaft	1.0	EA	1,319.00
6	2487801	Facer Gearbox Cover	1.0	EA	0.00
7	2487901	Facer Gearbox Pinion Mod	1.0	EA	0.00
8	2490701	Input Spur Gear	1.0	EA	0.00
9	2490801	Output Spur Gear	1.0	EA	0.00
10	2490901	Body Side Drive Hub (Effective to 12/2/18)	1.0	EA	0.00
10	2490902	Body Side Drive Hub	1.0	EA	487.00
11	2491001	Cover Side Drive Hub (Effective to 12/2/18)	1.0	EA	0.00
11	2491002	Cover Side Drive Hub	1.0	EA	812.00
12	2491101	Spindle Bolt	1.0	EA	261.00
13	2491201	Input Shaft Guard	1.0	EA	0.00
14	2491301	14.13 Input Shaft	1.0	EA	0.00
15	2491501	Motor Mount Socket	1.0	EA	0.00
16	2491901	Pinion Bearing Seat	1.0	EA	213.00
17	MAB00033	5/16-18NCX1LG Hhcs	8.0	EA	0.42
18	MAB00043	5/16-18NCX3-1/2LG Hhcs	3.0	EA	0.00
19	MAB00240	3/8-24NFX3/4LG Hhcs GR8	10.0	EA	0.00
20	MAC00075	5/16-18NCX1LG Shcs PL	4.0	EA	1.22
21	MBC00055	5/8-11NC Prev Trq Flg Lck Nut (Effective to 8/23/18)	1.0	EA	0.00
21	MBB00011	5/8-11NC Fnsh Jam Nut Stil PL	1.0	EA	0.89
22	MBC00079	5/8-11UNC Thin Nylock Hex Nut	1.0	EA	0.00
23	MBG00001	3/8 Type 'an' FL Wshr Stil PL	10.0	EA	0.26
24	MBG00003	5/8 Type 'an' Type Wshr Stil PL	2.0	EA	0.65
25	MBG00048	5/16 Type 'an' Flat Washer SS	15.0	EA	2.44
26	MBG00136	1-1/8 ID Thrust Washer	2.0	EA	7.13
27	MBH00154	Bearing Lock Nut	1.0	EA	15.14
28	MBH00155	Bearing Lock Washer	1.0	EA	8.27
29	MCB00003	Ext Snap Ring	1.0	EA	0.43
30	MCI00003	1/4 Dia X 3/4 Long Dowel Pin (Effective to 10/23/18)	2.0	EA	0.51
30	MCI00041	1/4DIA X 7/8LG Dowel Pin	2.0	EA	0.00
31	MCI00008	3/8DIA X 1/2LG Dowel Pin	1.0	EA	1.40
32	MCI00012	3/8DIA X 1-1/4LG Dowel Pin	2.0	EA	0.00
33	MCK00032	1/4X1/4X1-1/4LG Key,sq Ends	1.0	EA	3.65
34	MCK00119	3/8 Dia Locating Pin	4.0	EA	0.00
35	MCK00123	3/16X3/16X1LG Key,sq Ends	1.0	EA	0.00
36	MDL00161	Buna-n 70 Duro O-ring	2.0	EA	10.35
37	MDL00354	3.487 ID X .103 W O-ring	1.0	EA	1.14
38	MDL00356	7.487 ID X .103 W O-ring	1.0	EA	2.90
39	MDL00357	3.00 ID Oil Seal	2.0	EA	54.79
40	MDL00358	.75 ID Oil Seal	1.0	EA	35.41
41	MDL00371	1" Square Profile O-ring	2.0	EA	0.25
42	MDM00543	Ball Bearing	2.0	EA	0.00
43	MDM00567	3/4" Id, 7/8 OD Flange Bushing	1.0	EA	0.00
44	MDM00568	2.993 ID Wear Sleeve	2.0	EA	103.00
45	MDM00569	25MM Ball Bearing	1.0	EA	0.00
46	MDM00570	35MM ID Roller Bearing	1.0	EA	0.00
47	MDM00571	1-1/8ID Needle Roller Bearing	1.0	EA	11.06
48	MDM00572	Taper Roller Bearing Cup	2.0	EA	0.00

McElroy Manufacturing Parts List

Part Number: 2487101 Acrobat Facer Gearbox Assembly

49	MDM00573	Taper Roller Bearing Cone	2.0 EA	0.00
50	MFC00029	4MSAE Plug	1.0 EA	2.88
51	MFJ00013	Oil Eye Lense & O-ring	1.0 EA	22.41
52	MJH00005	3/8-16 1000LB WL Hoist Ring	1.0 EA	0.00
53	MJN00025	5/8-11NC Spring Plunger	1.0 EA	49.00
54	MJQ00657	1" ID X .093 Thick Shim	1.0 EA	0.00
55	MJQ00659	1-1/4" ID X .002 Thick Shim	1.0 EA	0.00
56	MJQ00660	1-1/4" ID X .005 Thick Shim	1.0 EA	0.00
57	MJQ00661	1-1/4" ID X .010 Thick Shim	1.0 EA	0.00
58	MJQ00662	1-1/4" ID X .020 Thick Shim	1.0 EA	0.00
59	MJQ00663	3/4" ID X .093 Thick Shim (Effective to 10/23/18)	1.0 EA	0.00
59	MJQ00674	3/4" ID X .047 Thick Shim	1.0 EA	0.00
60	MBE00006	5/16 Reg Splt Lck Wshr Stl PL	3.0 EA	0.11

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

