



McElroy Manufacturing, Inc.

The leader by design.

Tulsa, Oklahoma U.S.A.

DRAWN:

MRH

CHECK:

RJK

APPR'D:

JBC

DATE: 8/15/17

SHT No: 2

REV No: D

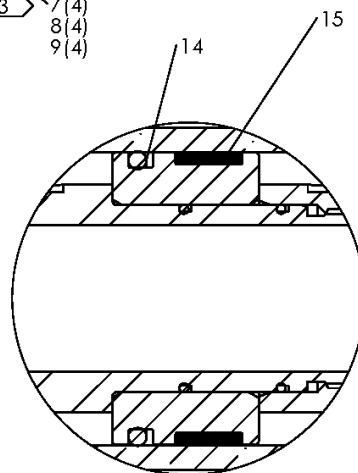
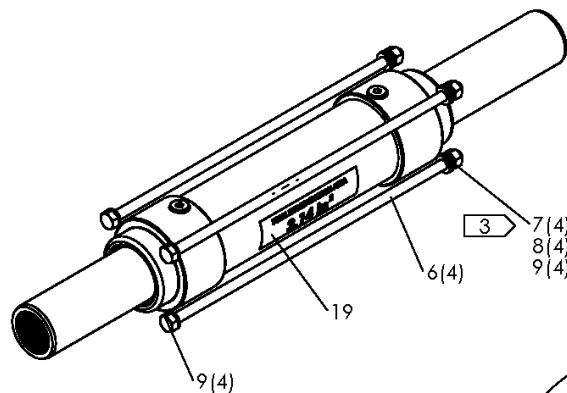
PART No: 31500302

Acrobat™ 315mm HIGH FORCE CYLINDER SET ASSEMBLY

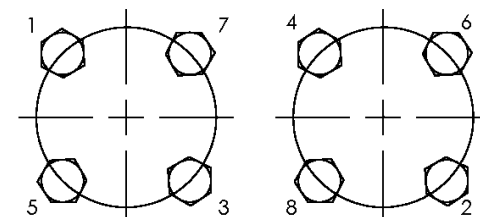
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NOTES:

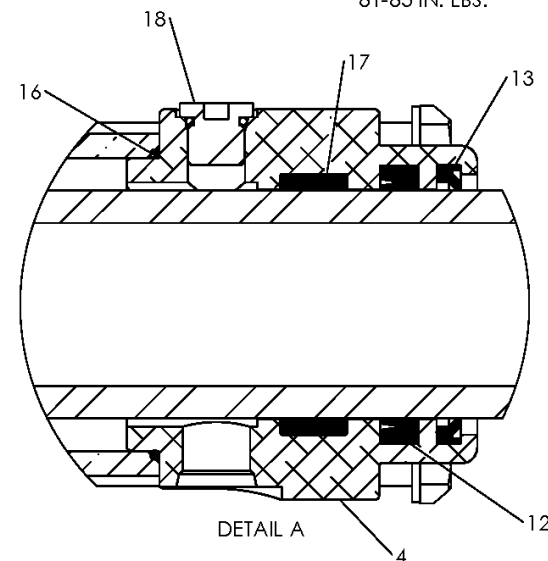
1. TOTAL EFFECTIVE PISTON AREA = 3.14 SQ. IN.
2. ITEMS IN PARENTHESES REFLECT A LOCAL GROUP AND MAY NOT BE INDICATIVE OF TOTAL ASSEMBLY QUANTITIES.
3. APPLY MEDIUM STRENGTH THREAD LOCKER.



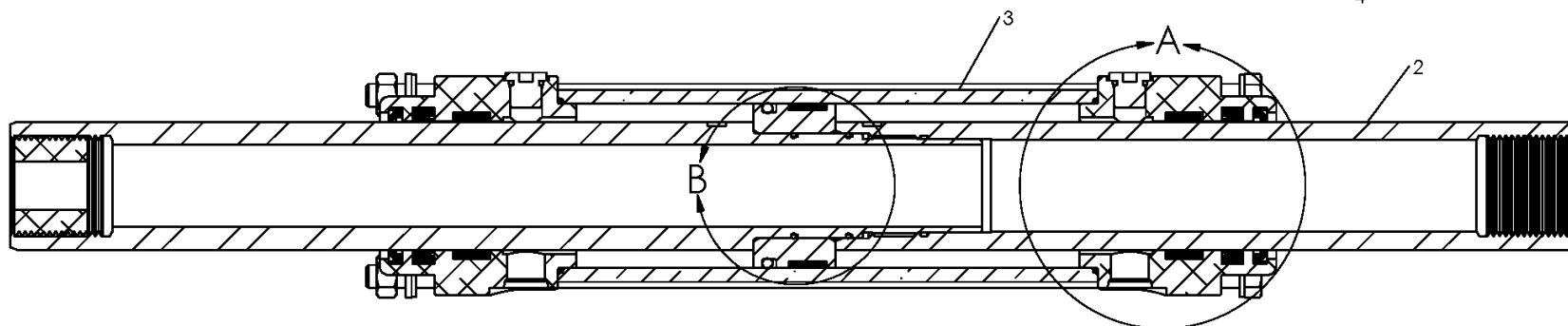
DETAIL B



TIE ROD TORQUE PROCEDURE:
TIGHTEN TIE RODS IN SEQUENCE
81-85 IN. LBS.



DETAIL A



McElroy Manufacturing Parts List

Part Number: 31500302 Acrobat 315 HF Cylinder Set Assembly

Part Number 31500302 Component List

Item	Component	Description	Quantity	Unit	Price
1	31501901	Piston (Effective to 9/24/19)	2.0	EA	0.00
2	31502102	HF Guide Rod (Effective to 9/24/19)	2.0	EA	0.00
2	31510602	315 HF Guide Rod Assy	2.0	EA	0.00
3	31502202	HF Cylinder Tube	2.0	EA	0.00
4	31502302	HF Rod Gland	4.0	EA	181.00
6	MAB00255	5/16-18NCX12LG Hhcs GR8	8.0	EA	0.00
7	MBA00006	5/16-18NC Fnsh Hex Nut Stl PL	8.0	EA	0.33
8	MBE00006	5/16 Reg Splt Lck Wshr Stl PL	8.0	EA	0.11
9	MBG00048	5/16 Type 'an' Flat Washer SS	16.0	EA	2.44
10	MCB00069	1-3/4 Spiral Retaining Ring (Effective to 9/24/19)	4.0	EA	8.05
11	MDL00003	O-ring (Effective to 9/24/19)	2.0	EA	0.91
12	MDL00091	Seal (Effective to 11/10/21)	4.0	EA	30.92
12	MDL00380	1.75" Ultrathane Rod Seal	4.0	EA	0.00
13	MDL00092	Wiper (Effective to 11/10/21)	4.0	EA	6.32
13	MDL00381	1.75" Ultrathane Wiper	4.0	EA	0.00
14	MDL00224	O-ring (Effective to 9/17/17)	2.0	EA	1.56
14	MDL00349	1.984 ID X .139 Wide O-ring	2.0	EA	0.90
15	MDL00343	2.250 Low Friction Wear Band	2.0	EA	71.70
16	MDL00344	2.239 ID X 2.379 OD O-ring	4.0	EA	0.39
17	MDM00279	2 OD Gland Bearing Ring	4.0	EA	4.31
18	MFC00029	4MSAE Plug	4.0	EA	2.88
19	8163337	3.14 SQ IN Tapa Label	2.0	EA	0.00

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