

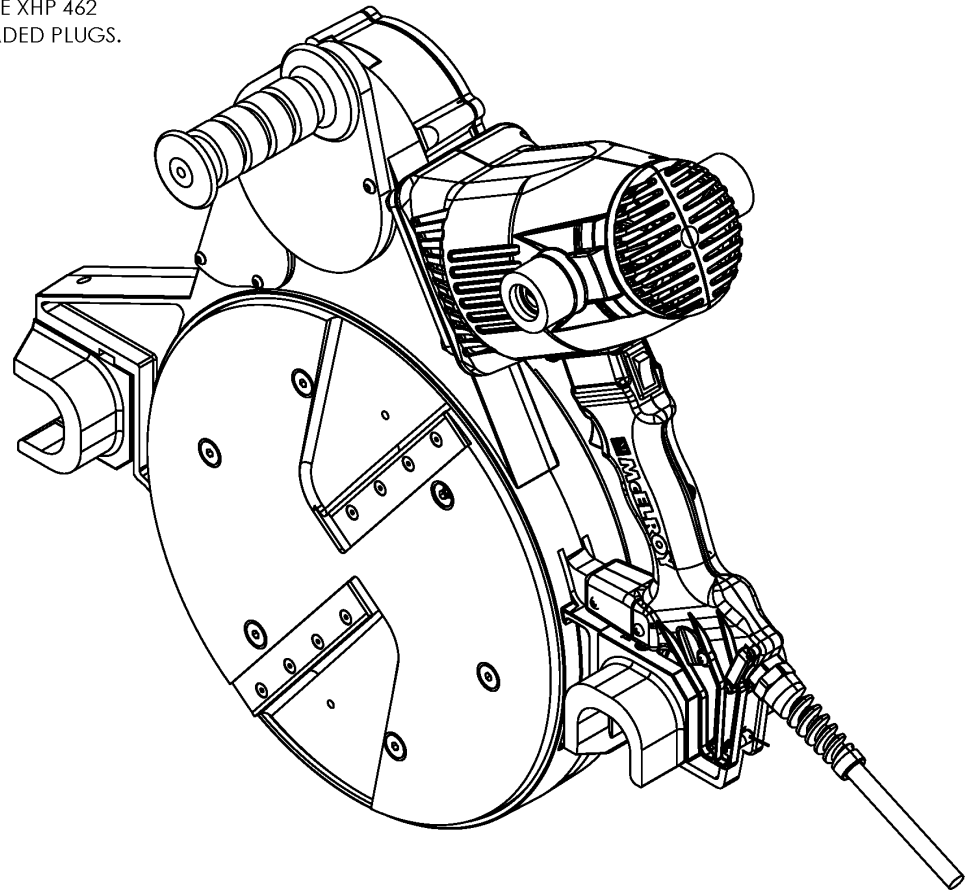


DRAWN:	CAA	CHECK:	SRB	APPRVD:	PJD	DATE:	02/23/2024	SHT No:	1 of 8	REV No:	D	PART No:	315P1018309
Acrobat™ 315 FACER ASSEMBLY 220-240V, 50/60 Hz, 1Ph													

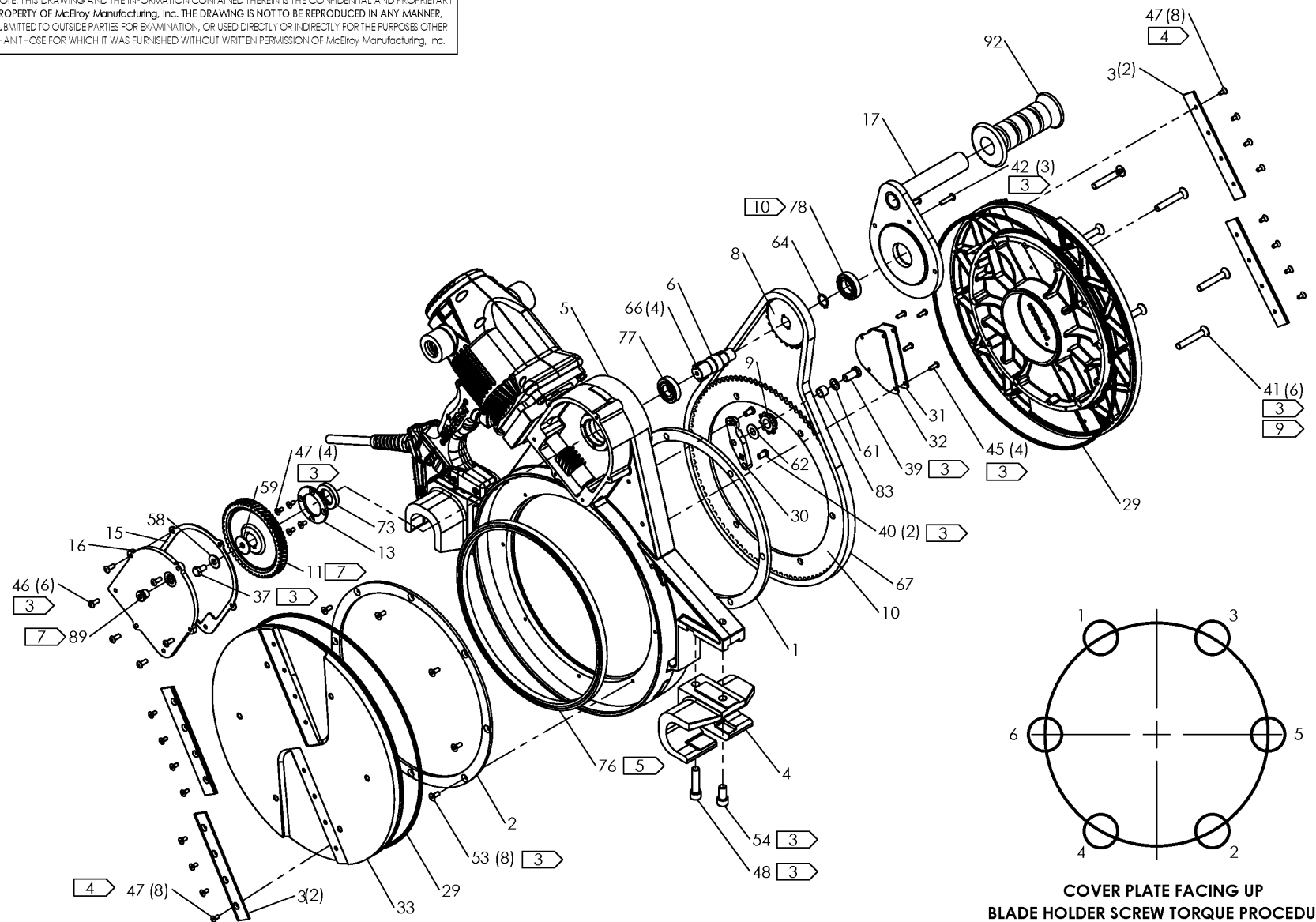
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NOTES:

1. TORQUE TO 20 IN-LBF.
2. ITEMS SHOWN IN PARENTHESIS REFLECT QUANTITIES IN LOCAL GROUPS AND MAY NOT INDICATE TOTAL ASSEMBLY QUANTITIES.
3. INSTALL WITH MEDIUM STRENGTH THREAD LOCKING COMPOUND.
4. INSTALL WITH HIGH TEMPERATURE ANTI-SEIZE COMPOUND.
5. PACK BEARING WITH EP GREASE.
6. STRIP CABLE JACKET BACK 9 INCHES, THEN CUT GROUND TO 4" FROM END OF JACKET.
7. PACK WORM GEARBOX AND MOTOR GEARBOX WITH MOBILGREASE XHP 462 DURING ASSEMBLY OR REPAIR. GREASE CAN BE CHECKED AT THREADED PLUGS.
8. COOL ITEM 7 AND HEAT ITEM 87 BEFORE PRESS FITTING.
9. TORQUE SCREWS IN SEQUENCE TO 150 IN-LB.
10. INSTALL WITH BEARING RETAINING COMPOUND ON BEARING OD.
11. WITH SNAP RING AGAINST THE BUSHING FLANGE
TURN CABLE ASSEMBLY INTO LOCKING PIN UNTIL
TENSION IN CABLE STARTS TO LIFT SNAP RING OFF
OF THE BUSHING, THEN TIGHTEN NUT AGAINST LOCKING PIN.
12. FOR BLADE SET ORDER 315P1024460
WHICH INCLUDES (4) T1208609.
13. FOR MOTOR BRUSHES ORDER (2) MDR00124.
14. ROUTE GROUND WIRE THROUGH SLOT IN SPINE OF HANDLE.

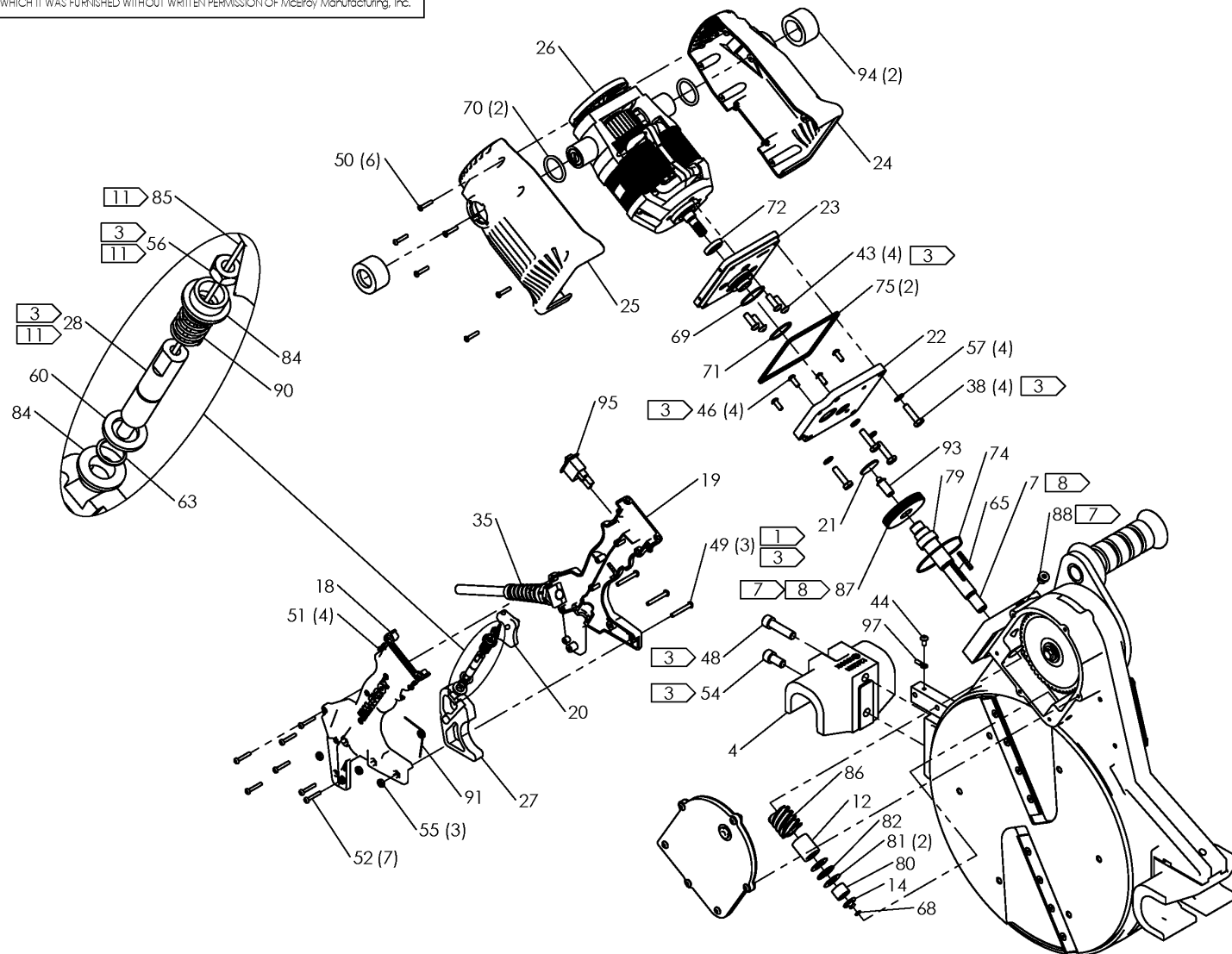


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COVER PLATE FACING UP
BLADE HOLDER SCREW TORQUE PROCEDURE:
HAND TIGHTEN SCREWS IN SEQUENCE THEN
TORQUE SCREWS IN SEQUENCE TO 150 IN-LB

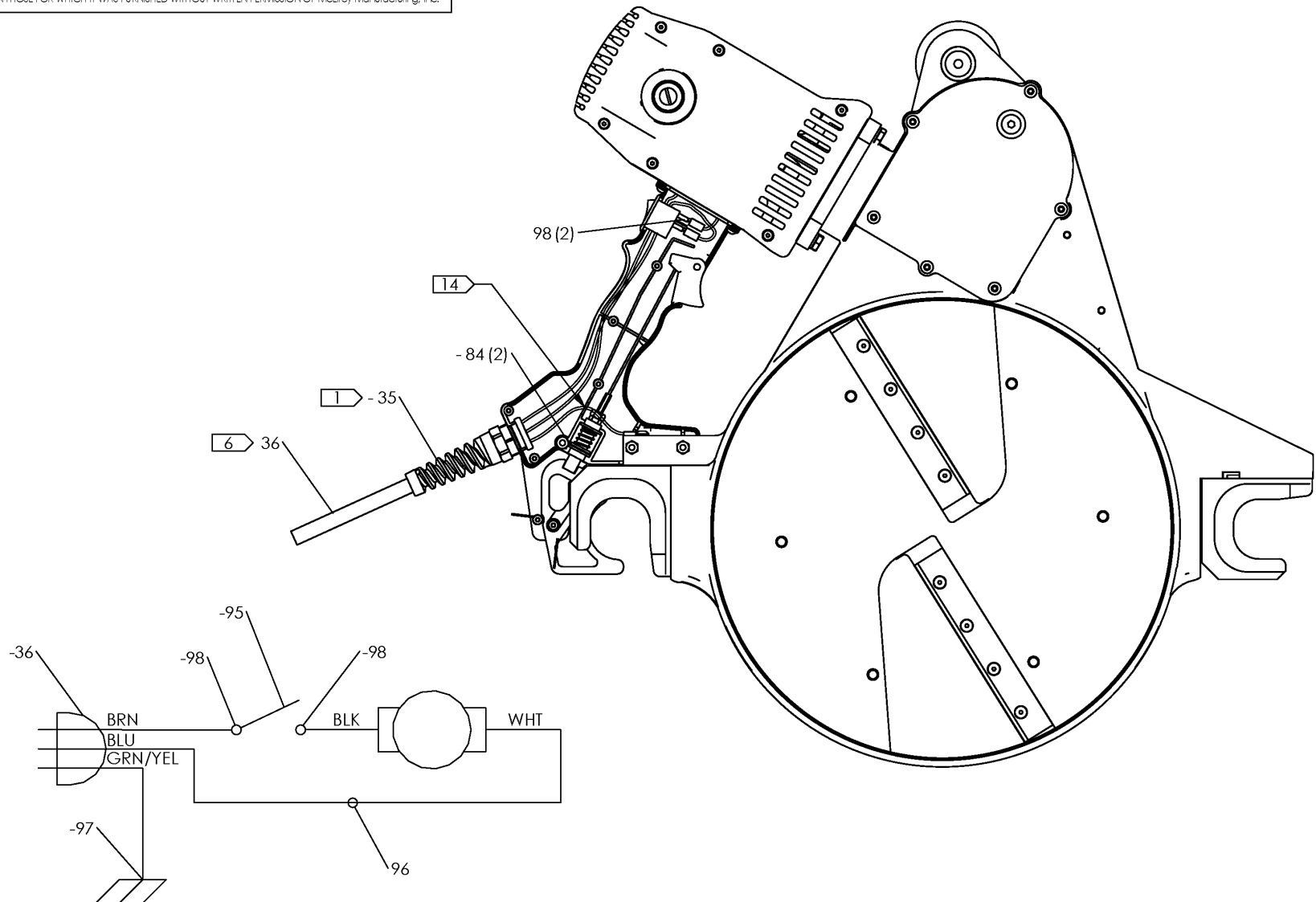
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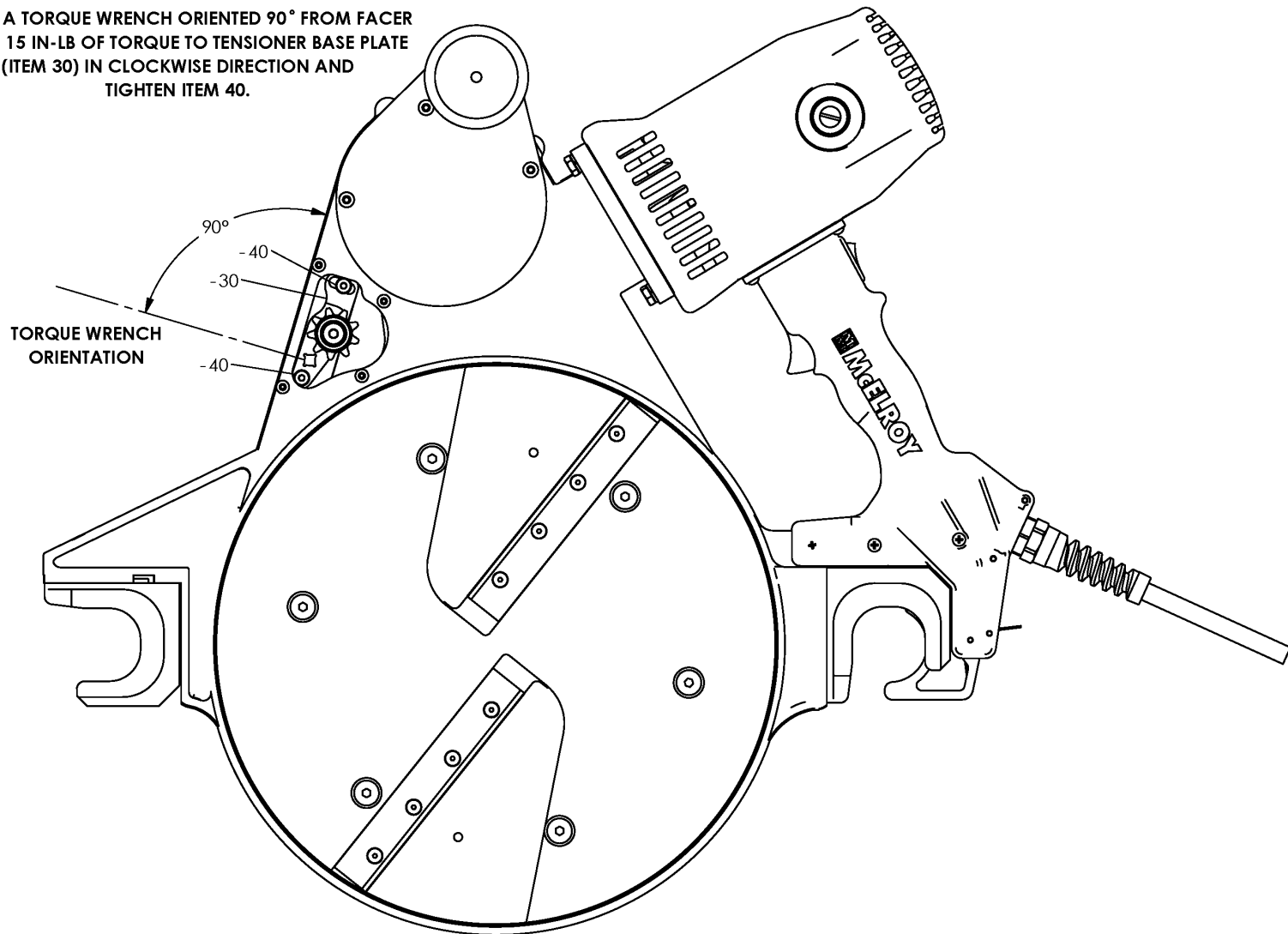
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**USING A TORQUE WRENCH ORIENTED 90° FROM FACER
APPLY 15 IN-LB OF TORQUE TO TENSIONER BASE PLATE
(ITEM 30) IN CLOCKWISE DIRECTION AND
TIGHTEN ITEM 40.**



McElroy Manufacturing Parts List

Part Number: 315P1018309 Acrobat 315 220-240V Facer Assembly

Part Number 315P1018309 Component List

Item	Component	Description	Quantity	Unit	Price
1	T1208202	Bearing Spacer	1.0	EA	120.00
2	T1208301	Bearing Retainer	1.0	EA	200.00
3	T1208609	6.12 LG Facer Blade	4.0	EA	135.00
4	1262201	Dynamc 412 Guide Rod Bracket	2.0	EA	144.00
5	31505501	Facer Body	1.0	EA	4,867.00
6	31505601	Worm Gear Shaft	1.0	EA	321.00
7	31505702	Worm Shaft	1.0	EA	970.00
8	31505801	Driving Sprocket	1.0	EA	248.00
9	31505803	Tensioner Sprocket	1.0	EA	178.00
10	31505901	Driven Sprocket	1.0	EA	334.00
11	31506001	Worm Gear	1.0	EA	1,059.00
12	31506201	Gearbox Bearing Spacer	1.0	EA	121.00
13	31506301	Gearbox Bearing Retainer	1.0	EA	150.00
14	31506401	Oil Drain Plug	1.0	EA	42.69
15	31506501	Gearbox Cover Plate Gasket	1.0	EA	18.72
16	31506601	Gearbox Cover Plate	1.0	EA	0.00
17	31506901	Bearing Cap Wld	1.0	EA	445.00
18	31507201	Handle Front	1.0	EA	146.00
19	31507203	Handle Back Mod	1.0	EA	66.23
20	31507301	Trigger	1.0	EA	9.91
21	31507901	Bumper	1.0	EA	27.70
22	31508201	Lower Motor Mount Plate	1.0	EA	210.00
23	31508301	Upper Motor Mount Plate	1.0	EA	503.00
24	31508401	Front Motor Housing	1.0	EA	71.57
25	31508501	Back Motor Housing	1.0	EA	71.57
26	31508701	Acrobat 315 240V Facer Motor	1.0	EA	1,415.00
27	31509801	Tumbler	1.0	EA	86.78
28	31509903	Locking Pin	1.0	EA	65.56
29	31510001	Facer Seal Ring	2.0	EA	148.00
30	31510101	Tensioner Base Plate	1.0	EA	122.00
31	31510201	Tensioner Access Cover Plate	1.0	EA	15.85
32	31510301	Tensioner Access Cover Gasket	1.0	EA	21.07
33	315P1008709	Acrobat 315 Tpd Blade Holder (Effective to 6/3/26)	1.0	EA	1,232.00
33	315P1025433	Acrobat 315 Tpd Blade Holder	1.0	EA	0.00
34	315P1009390	Acrobat 315 C'brd Blade Holder (Effective to 6/3/26)	1.0	EA	1,232.00
34	315P1026126	Acrobat 315 C'brd Blade Holder	1.0	EA	0.00
35	434302	Power Cord Strain Relief	1.0	EA	14.35
36	718502	16A, 250V Power Cord Assembly with CEE 7/7 Plug	1.0	EA	126.00
37	MAB00002	1/4-20NCX1/2LG Hhcs	1.0	EA	0.18
38	MAB00004	1/4-20NCX1LG Hhcs	4.0	EA	0.32
39	MAC00466	3/8-16NCX 3/4LG LP Shcs	1.0	EA	7.27
40	MAC00467	1/4-20NCX 1/2LG LP Shcs	2.0	EA	2.70
41	MAD00063	5/16-18NCX2LG Fhscs PL	6.0	EA	2.41
42	MAE00026	#10-24NCX7/8LG Bhscs	3.0	EA	0.49
43	MAE00123	1/4-20NCX3/4LG Bhscs SS	4.0	EA	0.34
44	MAE00125	#10-24NCX3/8LG Bhscs PL	1.0	EA	0.00
45	MAE00148	#8-32NCX1/2LG Bhscs Stl PL	4.0	EA	0.23
46	MAE00150	#10-24NCX1/2LG Bhscs PL	10.0	EA	0.97
47	MAH00074	#8-32NCX3/8LG Fhscs SS	20.0	EA	0.29
48	MAH00078	3/8-16NCX1-1/2LG Shcs SS	2.0	EA	2.09
49	MAH00300	#8-32NC X 1-1/4LG Phpms	3.0	EA	0.49
50	MAL00010	#6-19X3/4LG Torx T15 Pan Hdscr	6.0	EA	0.56
51	MAL00013	#6-19X1/2LG Torx T15 Pan Hdscr	4.0	EA	0.50

McElroy Manufacturing Parts List

Part Number: 315P1018309 Acrobat 315 220-240V Facer Assembly

52	MAL00028	#6-19X7/8LG Torx T15 Pan Hdscr	7.0 EA	0.41
53	MAN00006	#10-24NCX1/2LG Fhscs SS	8.0 EA	0.39
54	MAN00122	3/8-16NC X 3/4LG Shcs SS	2.0 EA	0.00
55	MBA00003	#8-32NC Hex Nut Stl PL	3.0 EA	0.32
56	MBA00004	#10-24NC Hex Nut Stl PL	1.0 EA	0.35
57	MBE00005	1/4 Reg Splt Lck Washer Stl PL	4.0 EA	0.10
58	MBF00005	1/4 TY 'a' Wide FL Wshr Stl PL	1.0 EA	0.11
59	MBF00040	1/4 Flat Steel Fender Washer	1.0 EA	0.57
60	MBG00001	3/8 Type 'an' FL Wshr Stl PL	1.0 EA	0.26
61	MBH00159	Washer Shim 316 SS	1.0 EA	3.22
62	MBH00160	Washer Shim	1.0 EA	3.49
63	MCB00017	Ext Snap Ring	1.0 EA	0.49
64	MCB00021	Ext Snap Ring	1.0 EA	0.49
65	MCK00087	1/8X1/8X1LG Key, SQ Ends	1.0 EA	1.00
66	MCK00092	3/16X3/16X1/2LG Ovrstd SQ Key	4.0 EA	2.43
67	MDG00056	#35 Fcr Rlr Chain Continuous	1.0 EA	333.00
68	MDL00015	O-ring	1.0 EA	0.42
69	MDL00104	Buna 70 O-ring	1.0 EA	0.84
70	MDL00148	O-ring	2.0 EA	0.57
71	MDL00296	O-ring	1.0 EA	0.71
72	MDL00340	Seal	1.0 EA	7.48
73	MDL00345	.875 IDX1.379 ODX.250 LG Seal	1.0 EA	20.62
74	MDL00346	O-ring	1.0 EA	1.77
75	MDL00368	4.489 ID X .070 W O-ring	2.0 EA	7.46
76	MDM00304	10" ID X 10.75" OD Bearing	1.0 EA	2,518.00
77	MDM00544	Ball Bearing	1.0 EA	62.99
78	MDM00549	Ball Bearing	1.0 EA	27.89
79	MDM00550	Needle Roller Bearing	1.0 EA	21.88
80	MDM00552	Needle Roller Bearing	1.0 EA	16.86
81	MDM00554	Thrust Washer	2.0 EA	2.95
82	MDM00555	Thrust Bearing	1.0 EA	8.43
83	MDM00583	3/8" Bronze Sleeve Bearing	1.0 EA	2.59
84	MDM00586	3/8IDX1/2ODX1/4LG FL Bushing	2.0 EA	1.09
85	MDP00016	Pull cable assembly	1.0 EA	26.93
86	MDQ00062	1.00PD, 12DP, 4 Lead Worm	1.0 EA	622.00
87	MDQ00071	96TH, 48 DP Helical Gear	1.0 EA	104.00
88	MFC00001	3MSAE Plug	1.0 EA	2.81
89	MFC00029	4MSAE Plug	1.0 EA	2.88
90	MJE00069	Compression Spring	1.0 EA	6.35
91	MJE00070	Torsion Spring	1.0 EA	3.99
92	MJJ00009	1" Black Gloss Hand Grip	1.0 EA	3.86
93	MJN00017	3/8 Dia PF Ball Plunger SS	1.0 EA	11.62
94	MJQ00689	40MM OD 23MM LG C'brd Bumper	2.0 EA	51.46
95	MKE00117	Rocker On-off Switch	1.0 EA	3.06
96	MLM00003	14-16 Butt Splice	1.0 EA	0.42
97	MLM00011	14-16X#10 Ring Term, Non-insu	1.0 EA	0.00
98	MLM00124	14-16 X 1/4 Fem Part Ins Disc	2.0 EA	3.53

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