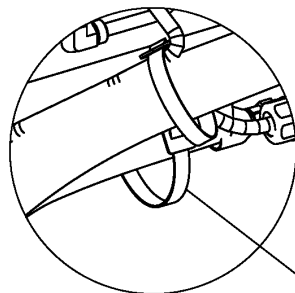
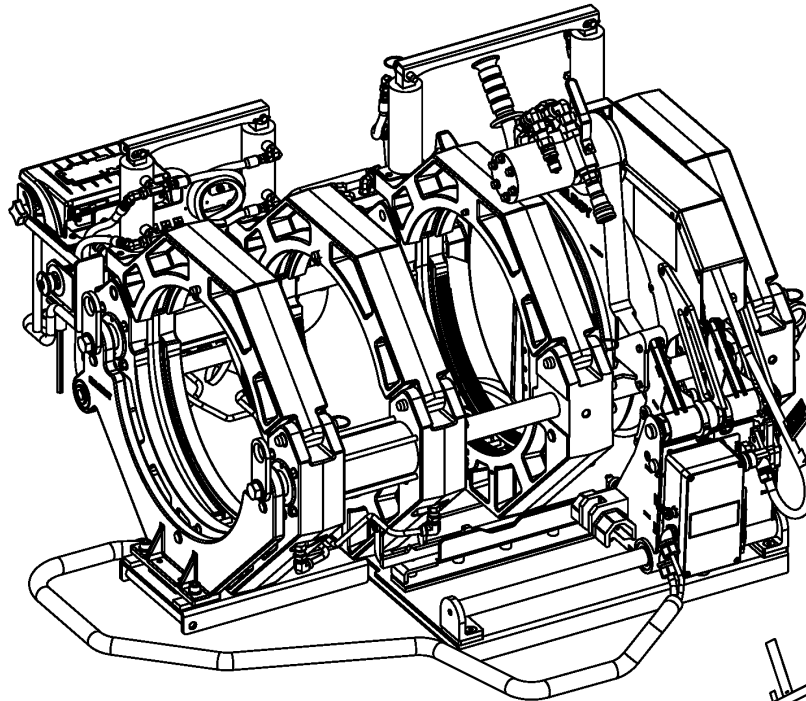


Pit Bul® 618i HYDRAULIC CLAMPING HIGH FORCE FUSION MACHINE PACKAGE

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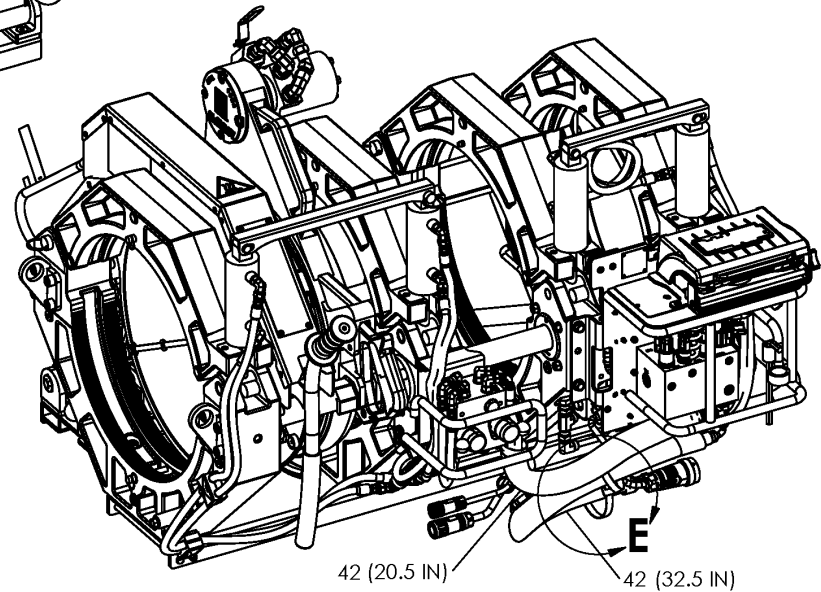
NOTES:

1. COMPONENTS MAY BE HIDDEN FROM VIEWS FOR CLARITY.
2. INSTALL WITH MEDIUM STRENGTH THREAD LOCKER.
3. INSTALL WITH HIGH TEMPERATURE ANTI-SEIZE COMPOUND.
4. LUBRICATE HYDRAULIC FITTING THREADS AND O-RINGS BEFORE ASSEMBLY.
5. TORQUE VALUES LISTED ARE MINIMUM, TOLERANCE -0/+10%.
6. INSTALL ITEM 53 FLUSH WITH SPOTFACE OF INNER JAWS.
7. ITEMS SHOWN IN PARENTHESIS REFLECT QUANTITIES IN A LOCAL GROUP AND MAY NOT INDICATE TOTAL ASSEMBLY QUANTITIES.
8. SEE DRAWING T18P1015528 FOR ELECTRICAL SCHEMATIC.
9. SEE DRAWING T18P1020924 FOR HYDRAULIC SCHEMATIC.



68 (2)

DETAIL E

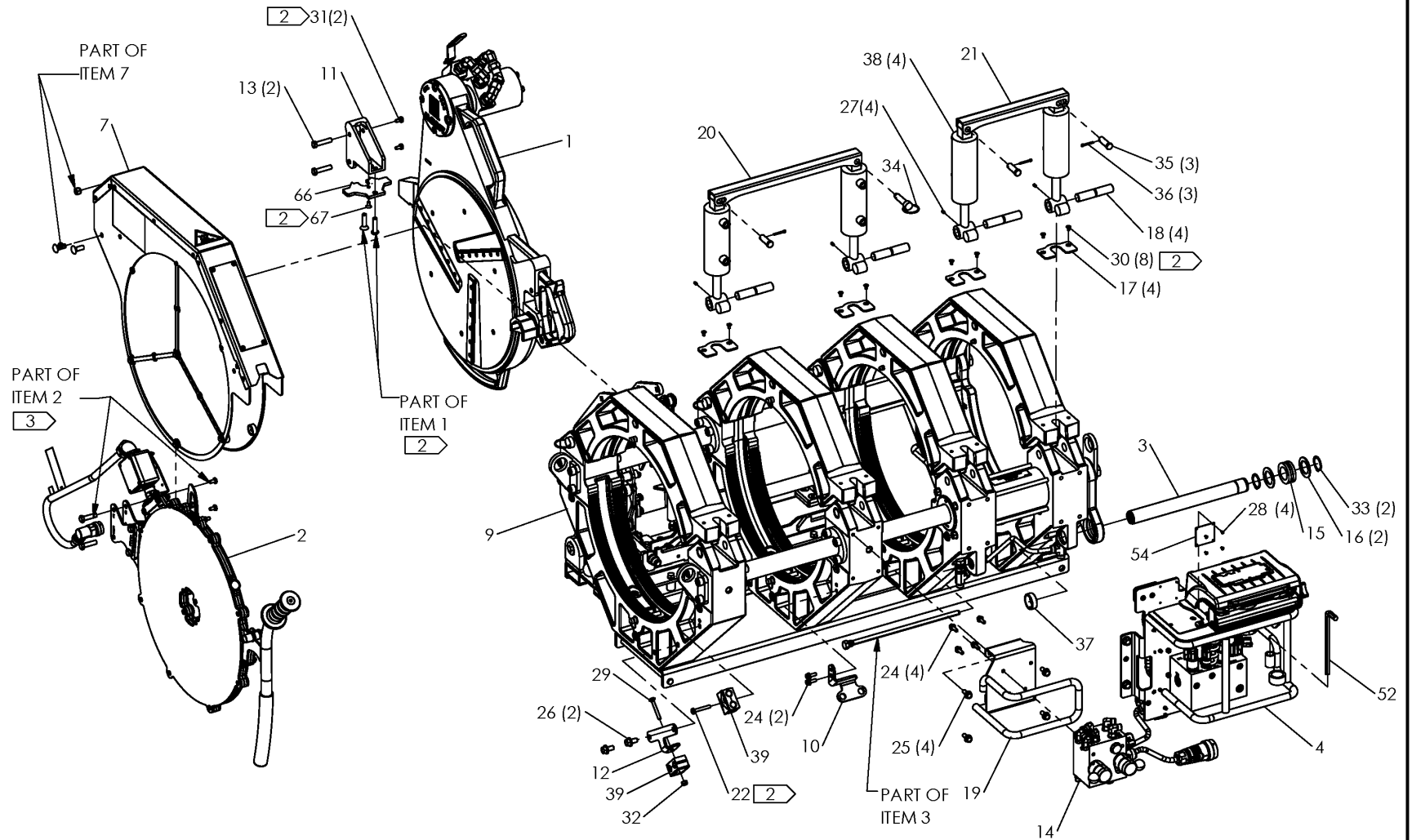


42 (20.5 IN)

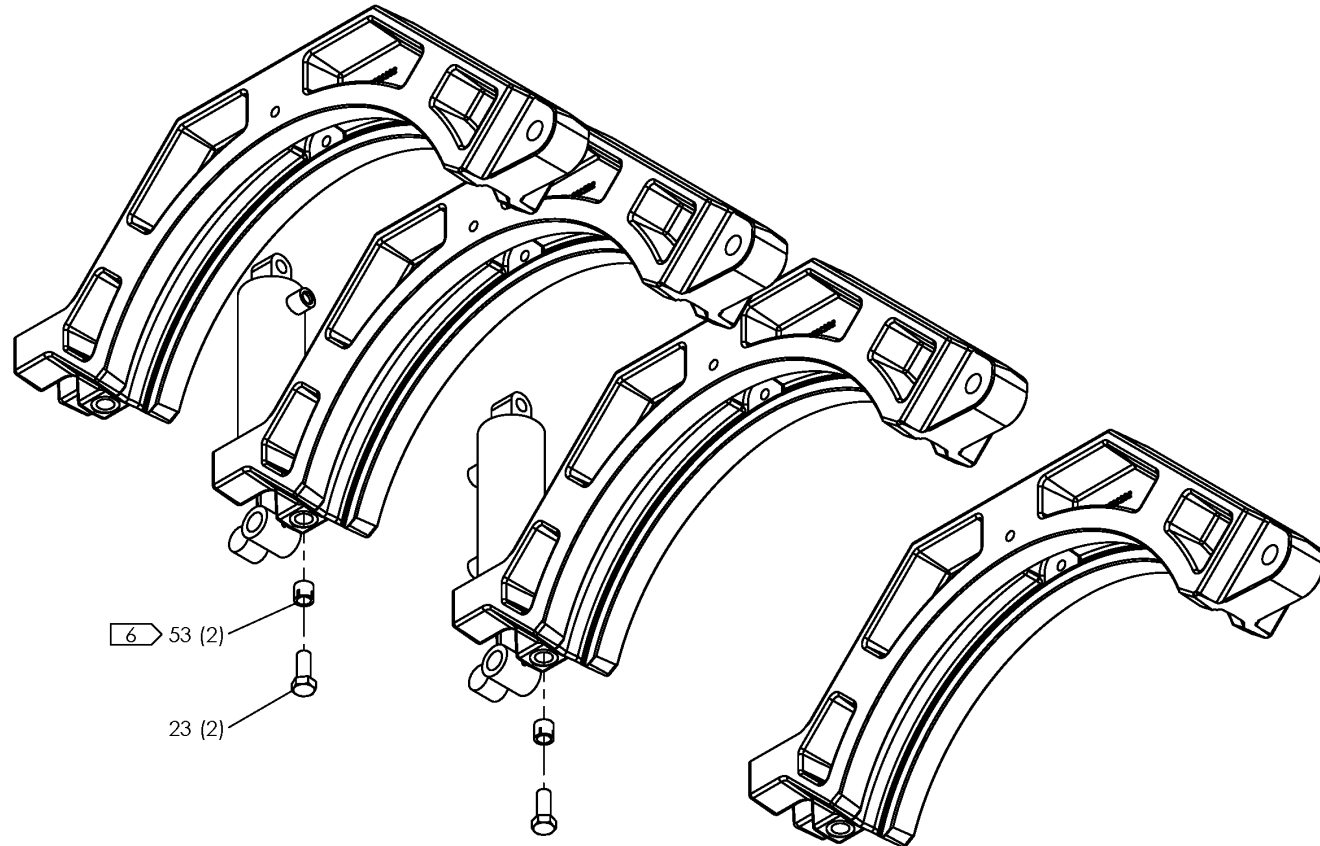
42 (32.5 IN)

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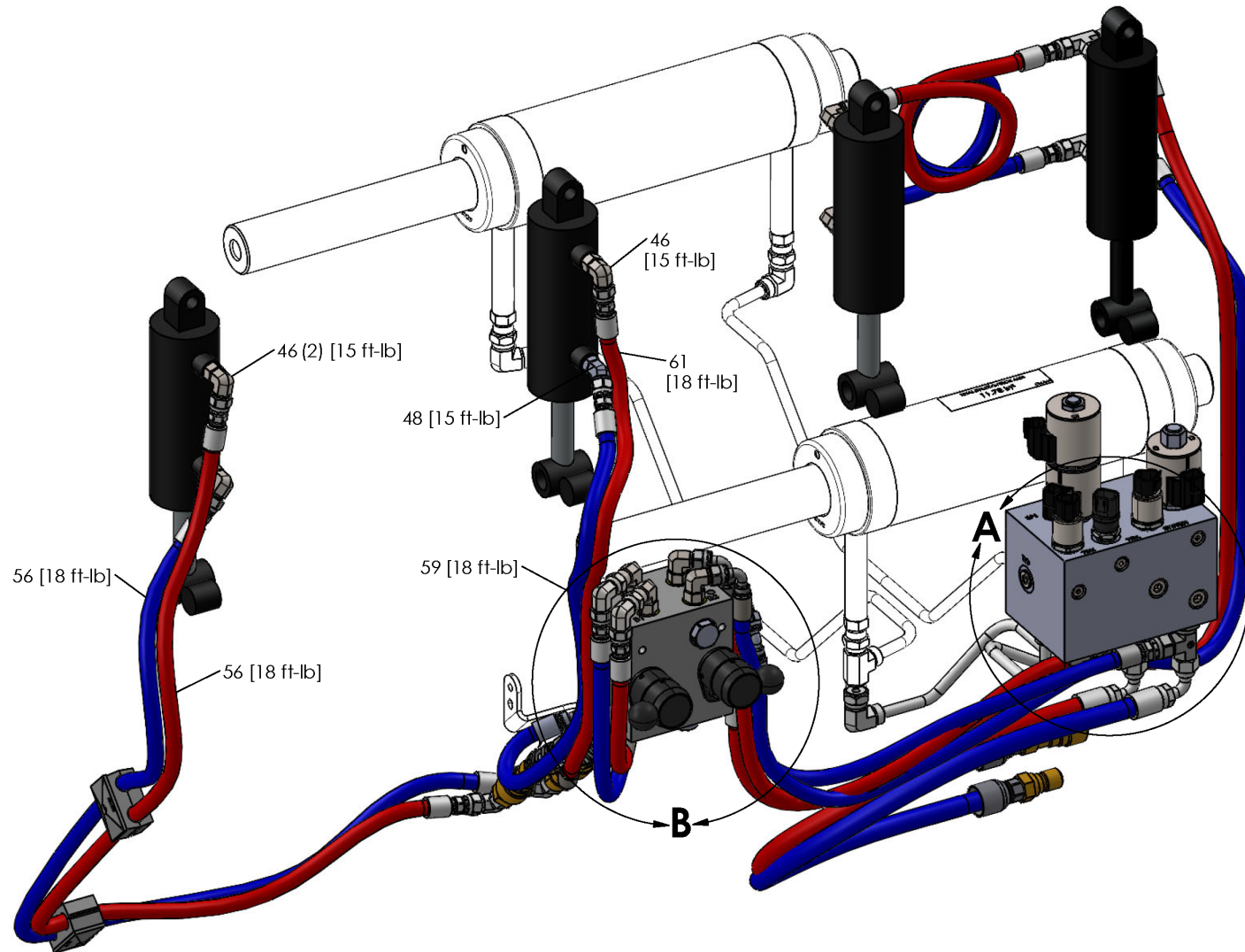


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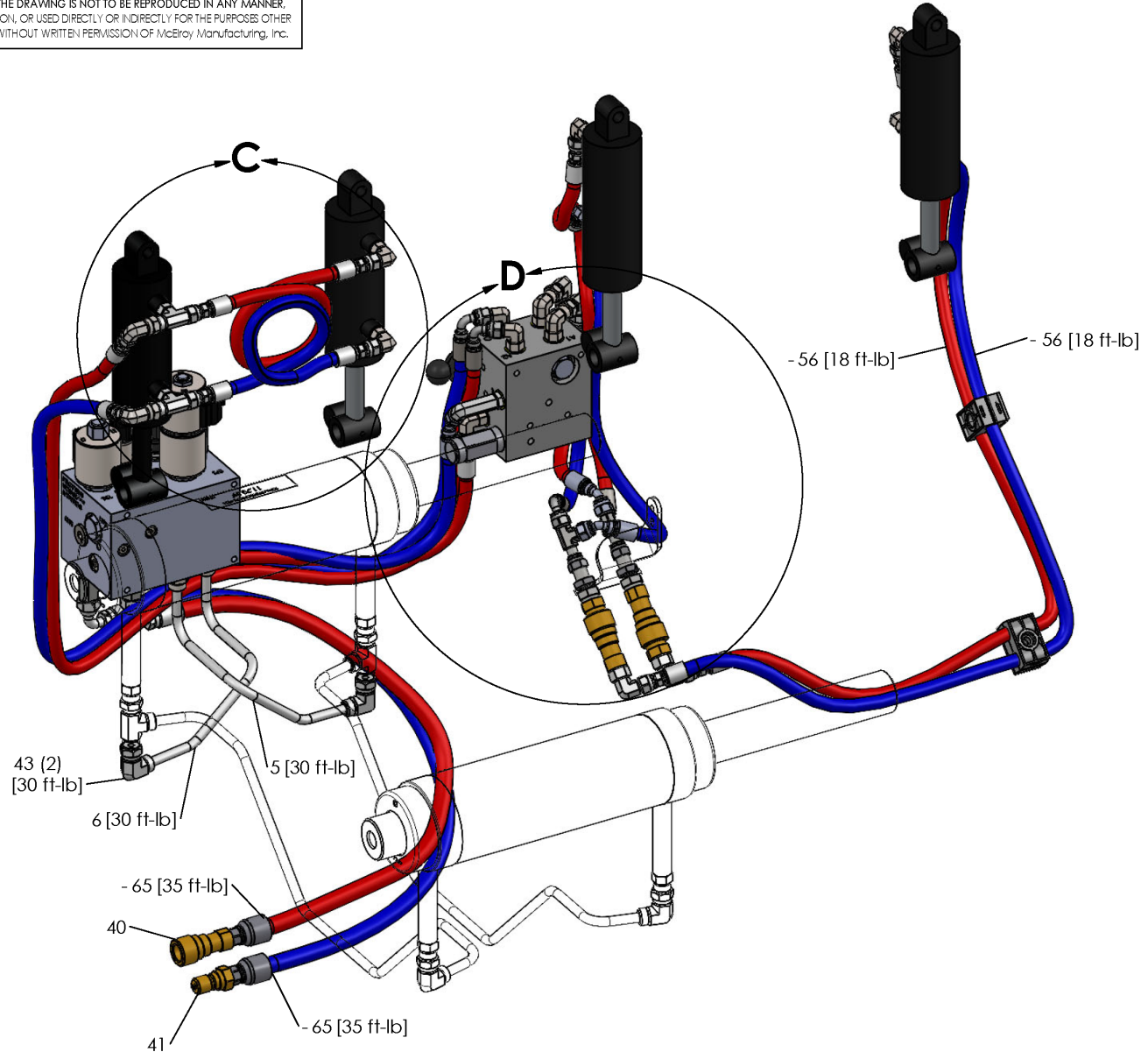
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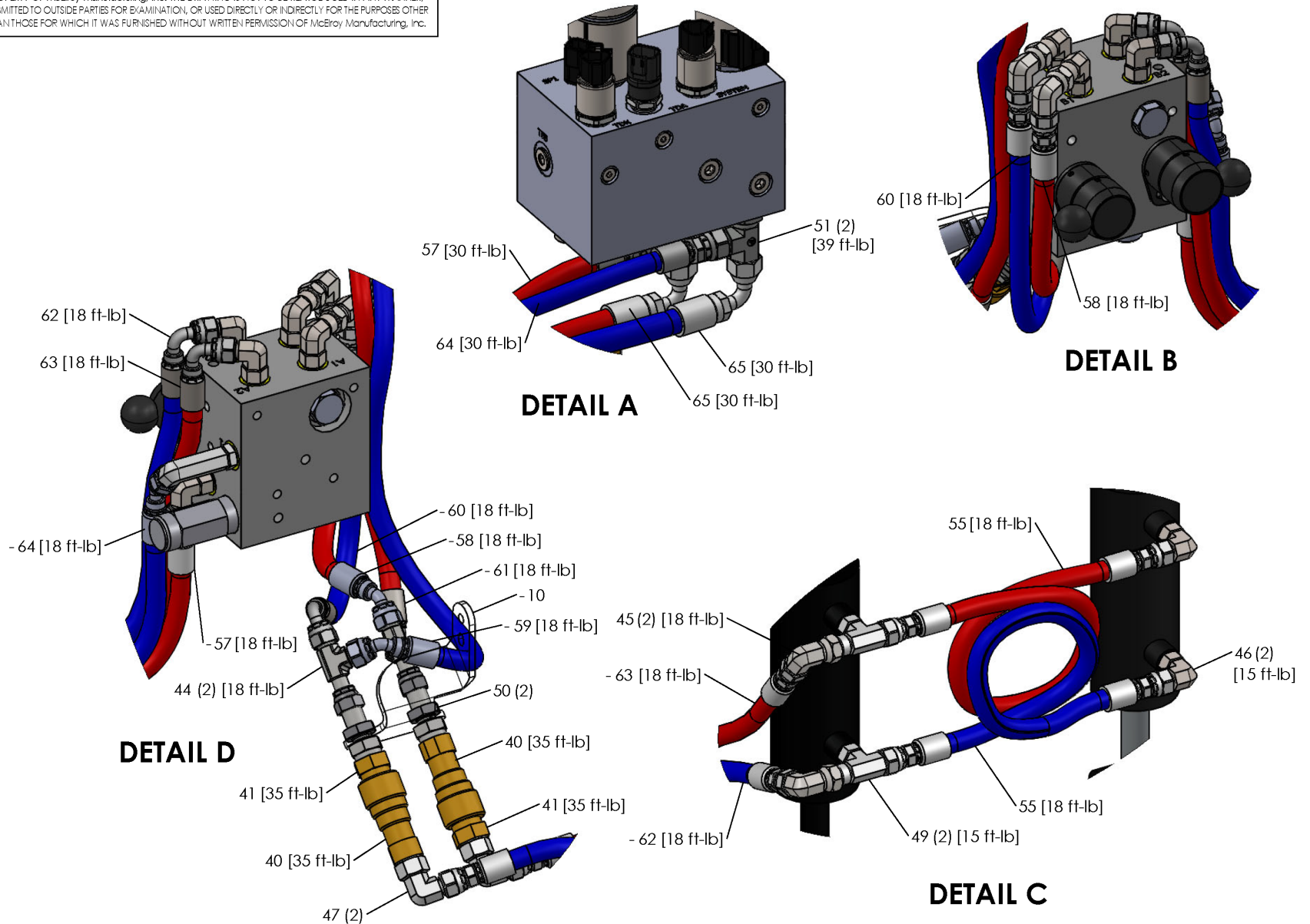


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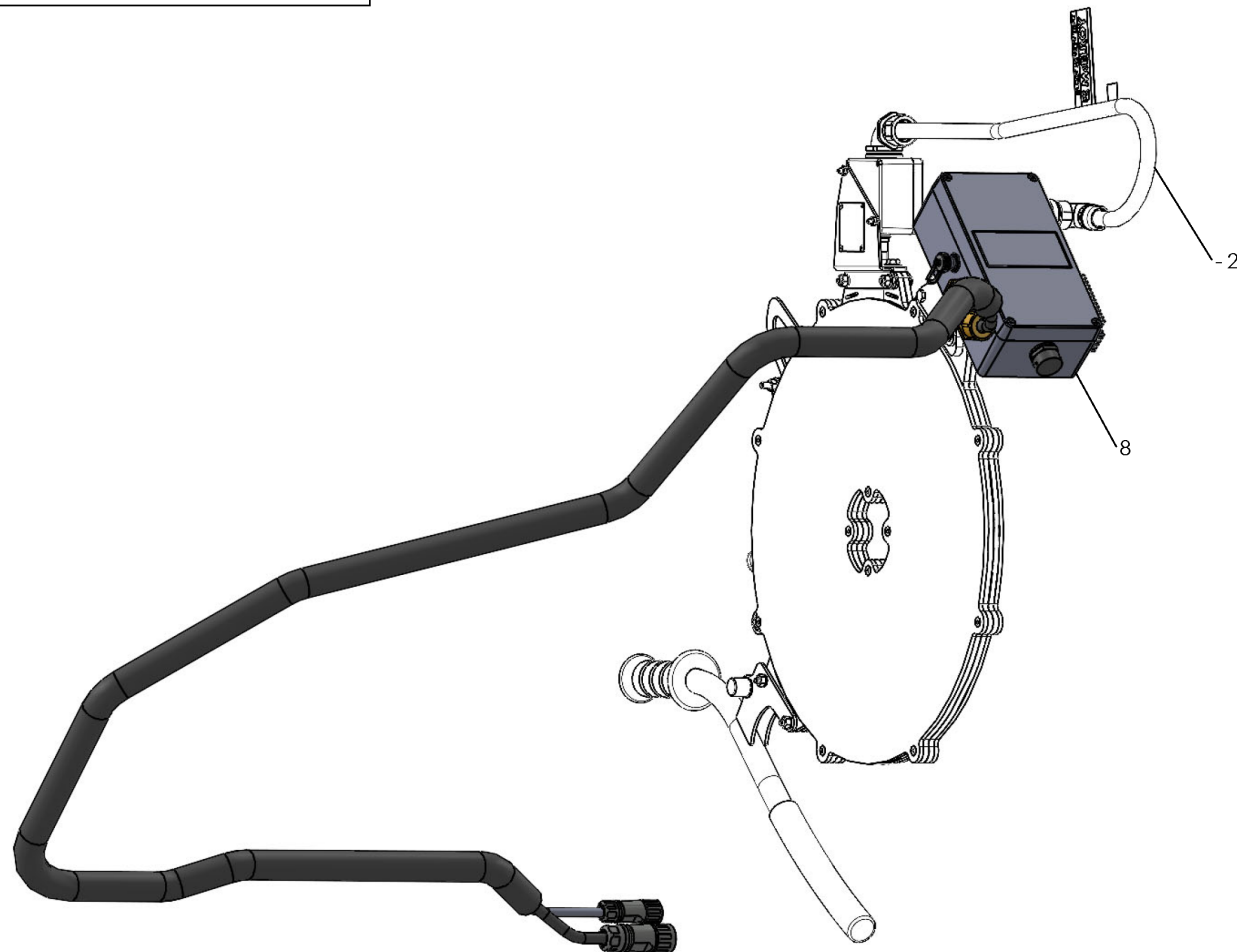


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McElroy Manufacturing Parts List

Part Number: AT18P1011829 Pit Bull 618i Hydraulic Clamping High Force Fusion Machine Package

Part Number AT18P1011829 Component List

Item	Component	Description	Quantity	Unit	Price
1	T1800501	TracStar 618 Facer Assembly	1.0	EA	17,778.00
2	T18P0974613	#618 220-240V Heater Assembly (Effective to 1/22/26)	1.0	EA	0.00
2	T18P1097040	#618 220-240V, 50/60Hz, 1Ph Heater Assembly	1.0	EA	4,276.00
3	T18P0985093	Carriage Transducer Assembly	1.0	EA	1,240.00
4	T18P0998676	TracStar 412i & 618i Carriage Control Assembly	1.0	EA	0.00
5	T18P1006433	618 A1 Port to Cyl Tube Assy	1.0	EA	111.00
6	T18P1006435	618 B1 Port to Cyl Tube Assy	1.0	EA	111.00
7	T18P1011302	618 Heater Bag Frame	1.0	EA	870.00
8	T18P1017420	412i / 618i Heater Control Assembly (Effective to 2/4/25)	1.0	EA	2,021.00
8	T18P1051490	412i/618i Heater Control Assembly	1.0	EA	1,918.00
9	T18P1018378	618 High Force 4 Jaw Carriage Assembly	1.0	EA	0.00
10	T18P1020888	Inr Fixed Jaw Bulkhead Bracket	1.0	EA	0.00
11	T18P1021143	618 Facer Arm (Effective to 9/18/24)	1.0	EA	0.00
11	T18P1039143	618 Facer Arm	1.0	EA	630.00
12	T18P1021213	Outer Fxd Jaw Hose Clamp Brkt	1.0	EA	0.00
13	T18P1023080	412/618 Facer Shoulder Nut	2.0	EA	23.10
14	T18P1023505	Hydraulic Clamping Manifold Assembly with Fittings	1.0	EA	2,737.00
15	T48P0810875	Indexer Transducer Bushing	1.0	EA	19.90
16	T48P0843680	Indexer Trnsdcr Bushing Washer	2.0	EA	7.10
17	1806302	Jaw Clamp Pad Mod	4.0	EA	53.75
18	1819101	Pivot Pin	4.0	EA	28.19
19	1870703	Manifold Bracket Wld	1.0	EA	311.00
20	1870801	Fixed Jaw Clamp Handle	1.0	EA	87.47
21	1870901	Movable Jaw Clamp Handle	1.0	EA	79.51
22	MAB00007	1/4-20NCX1-3/4LG Hhcs	1.0	EA	0.46
23	MAB00081	1/2-13NCX1-1/4LG Hhcs	2.0	EA	1.43
24	MAB00257	1/4-20NCX3/4LG Hxhd SR Flg Blt	6.0	EA	0.52
25	MAB00258	5/16-18NCX3/4LG Hxhd SR Flgblt	4.0	EA	0.76
26	MAB00260	3/8-16NCX3/4LG Hxhd SR Flg Blt	2.0	EA	1.50
27	MAGP1030623	Replaced by MAGP1048538 (Effective to 1/8/25)	4.0	EA	0.00
27	MAGP1048538	#10-24NCX3/8LG Skt Set Scr SS	4.0	EA	0.66
28	MAH00006	#6X1/4LG Drv Scr	4.0	EA	0.31
29	MAIP0978605	1/4-20NCX2" LG Carriage Bolt	1.0	EA	0.00
30	MAN00001	#10-24NCX3/8 LG Fhscs SS	8.0	EA	0.41
31	MAN00097	1/4-20NCX1/2LG Hhcs SS	2.0	EA	0.30
32	MBC00005	1/4-20NC Fnsh Hex Nyl Lck Nut	1.0	EA	0.39
33	MCBP0886175	1-1/4 Ext Retaining Ring St PL	2.0	EA	1.57
34	MCE00036	1/2DIAX1.50 Grip Detent Pin	1.0	EA	64.61
35	MCF00002	1/2DIAX1-11/32 Grip Clv Pin PL	3.0	EA	3.29
36	MCH00001	1/8DIAX1LG Cotter Pin	3.0	EA	0.12
37	MDMP0983087	1-1/2" X 1/2" X 1/8" Wear Ring	1.0	EA	0.00
38	MEB00150	2B X 3S X 3/4R Clamp Cylinder	4.0	EA	914.00
39	MFD00091	1/2" ID Twin Hose Clamp	2.0	EA	0.00
40	MFH00043	3/8 Fsae Quick Disc Coupler	3.0	EA	58.19
41	MFH00044	3/8 Fsae Quick Disc Nipple	3.0	EA	29.01
42	MFL00042	1.85 ID Hose Sleeve	4.416	FT	8.12
43	MFQ00009	6MSL/6FSL Swivel Elbow	2.0	EA	19.65
44	MFQ00025	4MSL/4FSL/4MSL Swivel Tee	2.0	EA	27.84
45	MFQ00026	4MSL/4FSL Swivel Elbow	2.0	EA	17.97
46	MFQ00040	4MSL/4MSAE Elbow	5.0	EA	10.33
47	MFQ00041	4MSL/6MSAE Elbow	2.0	EA	23.20

McElroy Manufacturing Parts List

Part Number: AT18P1011829 Pit Bull 618i Hydraulic Clamping High Force Fusion Machine Package

48	MFQ00067	4MSL/4MSAE 45DEG Elbow	1.0 EA	16.86
49	MFQ00098	4MSL/4MSAE/4MSL Branch Tee	2.0 EA	18.93
50	MFQ00197	4MSL/6MSAE Bulkhead Adapter	2.0 EA	40.90
51	MFQP1013691	6MSL/8MSAE/6MSL Run Tee	2.0 EA	0.00
52	MJL00018	3/8 Hex Key Wrench-long Ser PL	1.0 EA	12.26
53	MJM00032	Keensert 1/2-13NC W/thrd Lckng	2.0 EA	0.00
54	N1AT18P1011829	Nameplate	1.0 EA	0.00
55	SLABBBBA023	Hose Assy Oal 23"	2.0 EA	0.00
56	SLABBBBA046	Hose Assy Oal 46"	2.0 EA	0.00
57	SLABBBBD019	Hose Assy Oal 19"	1.0 EA	0.00
58	SLABBCB011	Hose Assy Oal 11"	1.0 EA	0.00
59	SLABBCBA025	Hose Assy Oal 25"	1.0 EA	0.00
60	SLABBDB012	Hose Assy Oal 12"	1.0 EA	0.00
61	SLABBDBA024	Hose Assy Oal 24"	1.0 EA	0.00
62	SLABBDBA048	Hose Assy Oal 48"	1.0 EA	0.00
63	SLABBDBA051	Hose Assy Oal 51"	1.0 EA	0.00
64	SLABDCB021	Hose Assy Oal 21"	1.0 EA	0.00
65	SLBDDJD035	Hose Assy Oal 35"	2.0 EA	79.70
66	T18P1039133	618 Facer Arm Standoff (Effective 9/19/24 to 10/24/24)	1.0 EA	46.13
66	T18P1044376	618 Facer Arm Stop	1.0 EA	93.87
67	MAD00277	1/4-20NCX1/2LG Fhscs PL	1.0 EA	0.77
68	MLNP1042967	11" X .5" Velcro Strap	2.0 EA	0.00

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