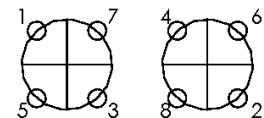
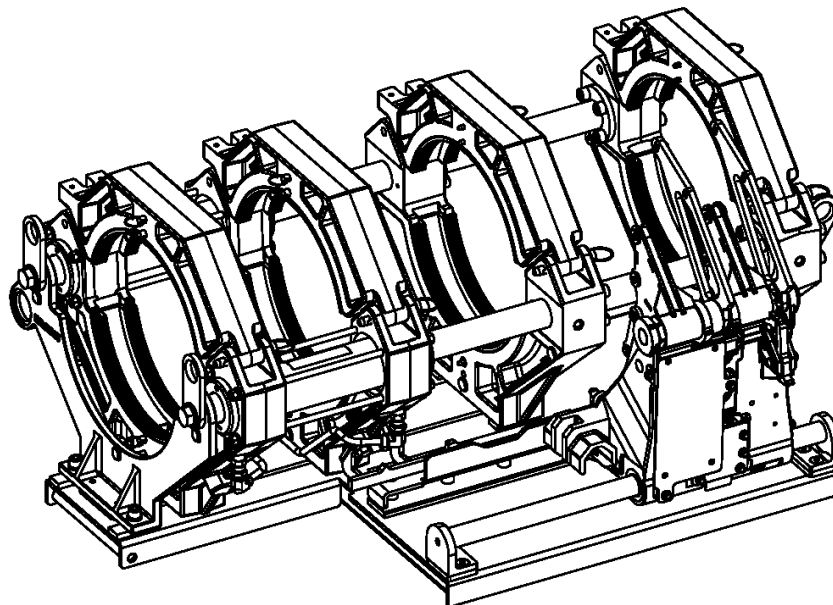
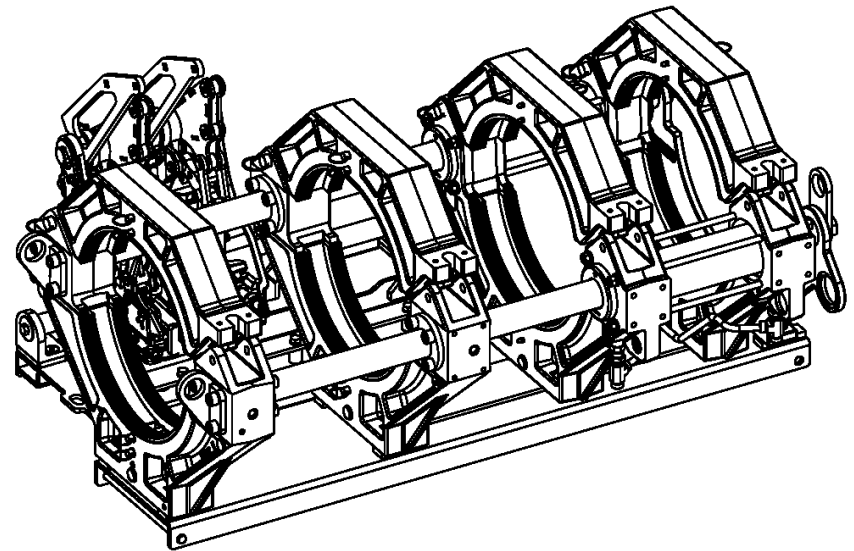


412 MEDIUM FORCE 4 JAW CARRIAGE ASSEMBLY

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:

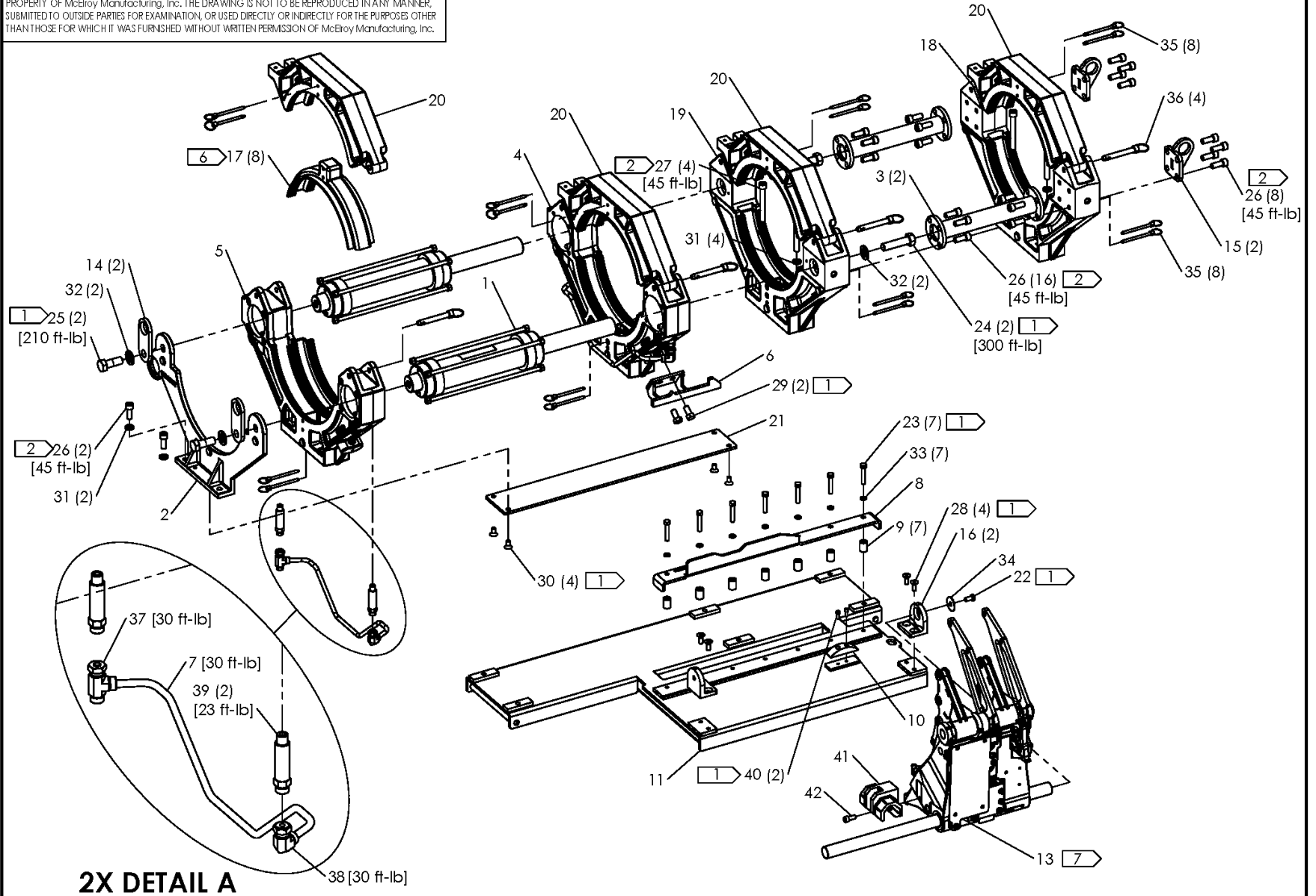
1. ASSEMBLE WITH MEDIUM STRENGTH THREAD LOCKER.
2. INSTALL WITH HIGH TEMPERATURE ANTI-SEIZE COMPOUND.
3. LUBRICATE HYDRAULIC FITTING THREADS AND O-RINGS BEFORE ASSEMBLY.
4. TORQUES LISTED ARE MINIMUM, TOLERANCE -0/+10%.
5. ITEM SHOWN IN PARENTHESIS REFLECT QUANTITIES IN A LOCAL GROUP AND MAY NOT INDICATE TOTAL ASSEMBLY QUANTITIES.
6. FOR 12" MASTER INSERT SET ORDER SET NUMBER 1203102.
7. REFER TO TECHNICAL BULLETIN TB199 FOR BRAKE ADJUSTMENT PROCEDURE.



TIE ROD TORQUE PRECEDURE:
TIGHTEN TIE ROD NUTS IN SEQUENCE
16-18 FT. LBS

412 MEDIUM FORCE 4 JAW CARRIAGE 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.



McElroy Manufacturing Parts List

Part Number: T12P1031343 412 Medium Force 4 Jaw Carriage Assembly

Part Number T12P1031343 Component List

Item	Component	Description	Quantity	Unit	Price
1	T12P0985135	412 Medium Force SAE Cylinder Assembly Set	1.0	ST	2,466.00
2	T12P0988656	Guide Rod Support	1.0	EA	448.00
3	T12P0988775	412 Fixed Jaw Brace (Effective to 3/18/25)	2.0	EA	0.00
3	T12P1051436	Fixed Jaw Brace	2.0	EA	208.00
4	T12P0989832	Dips Lower Inner Movable Jaw	1.0	EA	1,381.00
5	T12P0989837	Dips Lower Outer Movable Jaw	1.0	EA	1,381.00
6	T12P1004908	Hook Wld	1.0	EA	124.00
7	T12P1006427	412 Jaw Tube Assy	2.0	EA	150.00
8	T12P1018344	412 Cam Follower Upper Rail	1.0	EA	0.00
9	T18P0990181	Cam Follower Rail Spacer	7.0	EA	20.40
10	T18P0991628	Latch Release Storage Ramp	1.0	EA	117.00
11	T18P0992288	Carriage Skid	1.0	EA	1,386.00
12	T18P0992997	Indexer Linear Guide Rod (Effective to 9/17/24)	1.0	EA	220.00
13	T18P0993034	Indexer Assembly (Effective to 7/1/26)	1.0	EA	9,639.00
13	T18P1039764	Indexer Assembly	1.0	EA	0.00
14	T18P1008160	Guide Rod Lifting Plate	2.0	EA	0.00
15	T18P1008204	Fixed Jaw Lifting Wld	2.0	EA	88.14
16	T18P1023502	Indexer Guide Rod Support	2.0	EA	169.00
17	1203101	12IPS/DIPS Master Insert	8.0	EA	363.00
18	1203204	Dips Lower Outer Fixed Jaw	1.0	EA	1,222.00
19	1203208	Hyd Clmpng Dips Lwr Inr FX Jaw	1.0	EA	1,240.00
20	1203302	Dips Upper Jaw	4.0	EA	888.00
21	1814601	Carriage Support Plate	1.0	EA	187.00
22	MAB00063	3/8-16NCX3/4LG Hhcs	1.0	EA	0.40
23	MAB00068	3/8-16NCX2LG Hhcs	7.0	EA	0.56
24	MAB00084	3/4-10NCX3LG Hhcs GR8	2.0	EA	5.27
25	MAB00123	3/4-10NCX2LG Hhcs	2.0	EA	3.78
26	MAC00140	1/2-13NCX1-1/4LG Shcs PL	26.0	EA	3.10
27	MAC00451	1/2-13NCX4LG Shcs PL	4.0	EA	6.20
28	MAD00073	3/8-16NCX1LG Fhscs PL	4.0	EA	1.70
29	MAN00020	1/2-13NCX1LG Shcs SS (Effective to 10/27/24)	2.0	EA	2.05
29	MAB00103	1/2-13NCX1LG Hhcs	2.0	EA	0.72
30	MAN00057	3/8-16NCX3/4LG Fhscs SS (Effective to 6/1/25)	4.0	EA	1.44
30	MAD00072	3/8-16NCX3/4LG Fhscs PL	4.0	EA	1.07
31	MBE00009	1/2 Reg Splt Lck Washer Stl PL	6.0	EA	0.18
32	MBFP1023933	3/4" Sae Washer Stl PL	4.0	EA	0.00
33	MBG00001	3/8 Type 'an' FL Wshr Stl PL	7.0	EA	0.26
34	MBG00022	3/8" Fender Washer Stl PL	1.0	EA	0.32
35	MCE00003	1/4 DIA X3.00 Grip Detent Pin	16.0	EA	7.94
36	MCE00007	1/2 DIA X3.00 Grip Detent Pin	4.0	EA	12.24
37	MFQ00003	6MSL/6FSL/6MSL Swivel Tee	2.0	EA	38.33
38	MFQ00009	6MSL/6FSL Swivel Elbow	2.0	EA	19.65
39	MFQP0986681	6MSL/6MSAE 2.875LG Adapter	4.0	EA	39.32
40	MAC00052	1/4-20NCX5/8LG Shcs PL	2.0	EA	0.49
41	T12P1033249	Facer Guide Rod Bracket	1.0	EA	169.00
42	MAC00093	3/8-16N X7/8LG Shcs PL	1.0	EA	1.65

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