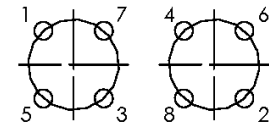
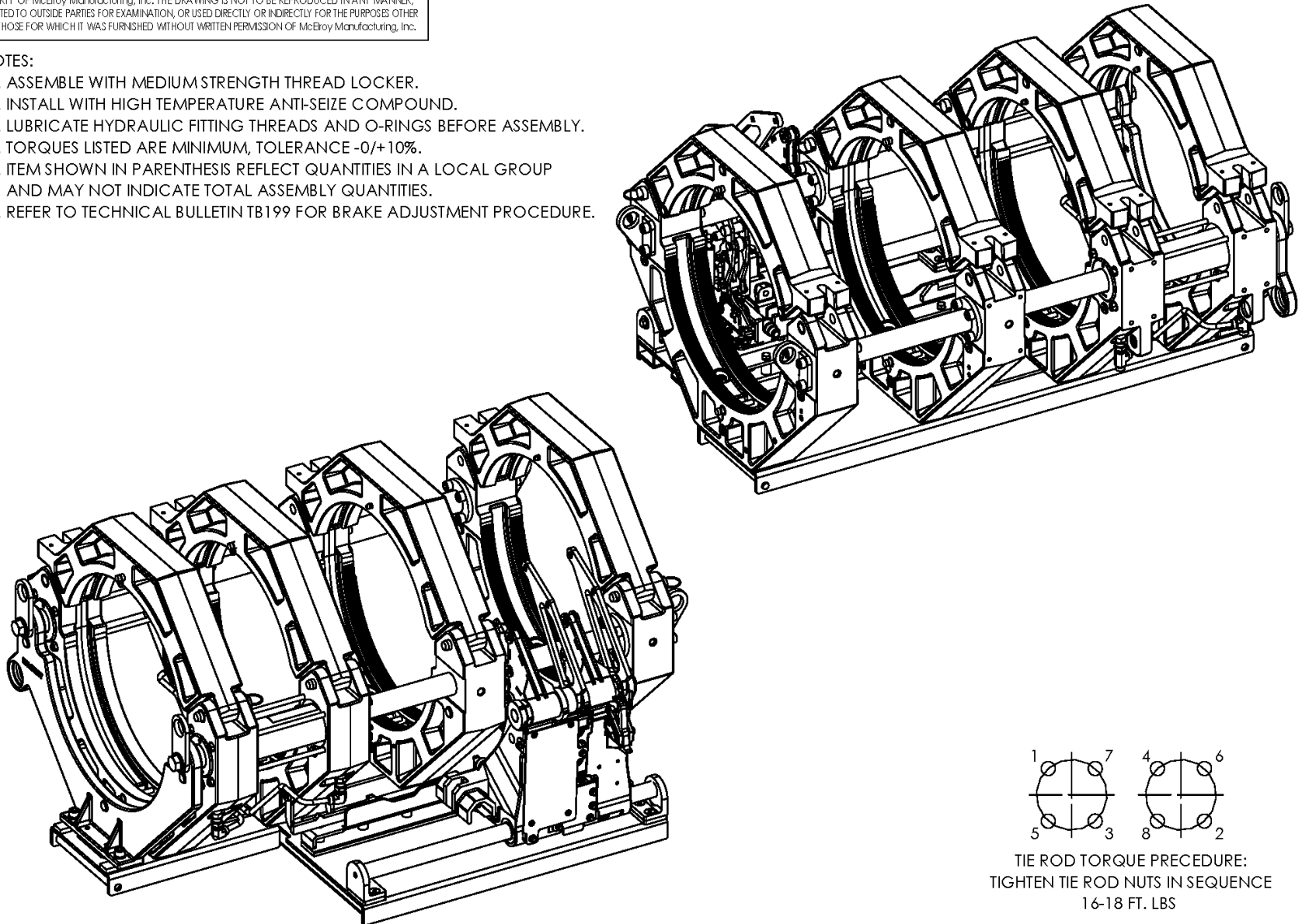


618 MEDIUM FORCE 4 JAW CARRIAGE ASSEMBLY

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:

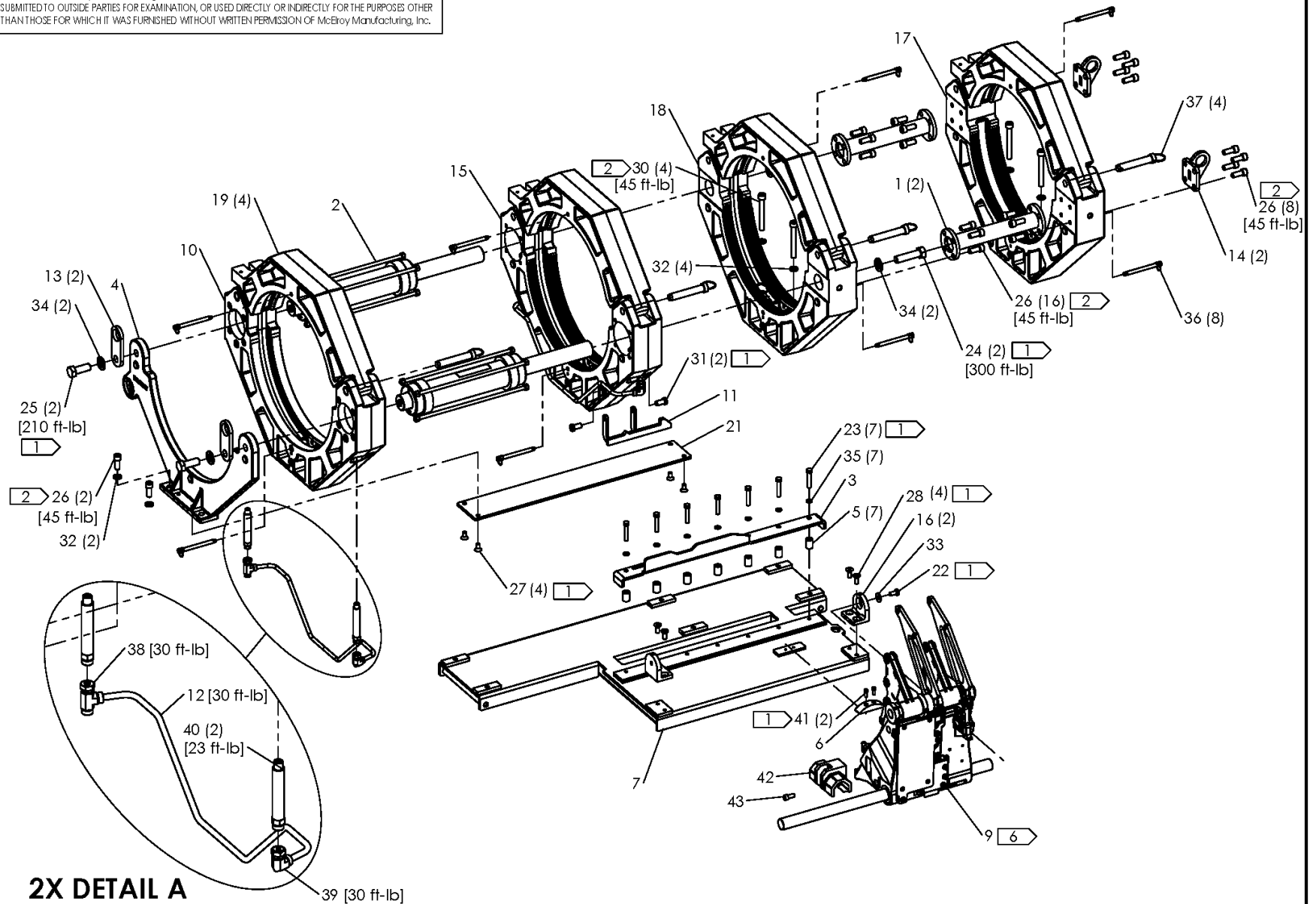
1. ASSEMBLE WITH MEDIUM STRENGTH THREAD LOCKER.
2. INSTALL WITH HIGH TEMPERATURE ANTI-SEIZE COMPOUND.
3. LUBRICATE HYDRAULIC FITTING THREADS AND O-RINGS BEFORE ASSEMBLY.
4. TORQUES LISTED ARE MINIMUM, TOLERANCE -0/+10%.
5. ITEM SHOWN IN PARENTHESIS REFLECT QUANTITIES IN A LOCAL GROUP AND MAY NOT INDICATE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



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

618 MEDIUM FORCE 4 JAW CARRIAGE ASSEMBLY

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McElroy Manufacturing Parts List

Part Number: T18P1024510 618 Medium Force 4 Jaw Carriage Assembly

Part Number T18P1024510 Component List

Item	Component	Description	Quantity	Unit	Price
1	T18P0984304	Replaced by T18P1051443 (Effective to 3/18/25)	2.0	EA	0.00
1	T18P1051443	Fixed Jaw Brace	2.0	EA	179.00
2	T18P0985127	618 Medium Force SAE Cylinder Assembly Set	1.0	ST	7,118.00
3	T18P0987805	Cam Follower Upper Rail	1.0	EA	153.00
4	T18P0988605	Guide Rod Support	1.0	EA	448.00
5	T18P0990181	Cam Follower Rail Spacer	7.0	EA	20.40
6	T18P0991628	Latch Release Storage Ramp	1.0	EA	117.00
7	T18P0992288	Carriage Skid	1.0	EA	1,386.00
8	T18P0992997	Indexer Linear Guide Rod (Effective to 9/24/24)	1.0	EA	220.00
9	T18P0993034	Indexer Assembly (Effective to 7/5/26)	1.0	EA	9,639.00
9	T18P1039764	Indexer Assembly	1.0	EA	0.00
10	T18P0997790	Lower Outer Moveable Jaw	1.0	EA	1,752.00
11	T18P1003159	618 Hook Wld	1.0	EA	121.00
12	T18P1003170	618 Jaw Tube Assy	2.0	EA	147.00
13	T18P1008160	Guide Rod Lifting Plate	2.0	EA	0.00
14	T18P1008204	Fixed Jaw Lifting Wld	2.0	EA	88.14
15	T18P1009936	Lower Inner Mov Jaw	1.0	EA	1,752.00
16	T18P1023502	Indexer Guide Rod Support	2.0	EA	169.00
17	1801108	Lower Outer Fixed Jaw	1.0	EA	2,904.00
18	1801116	Hyd Clmp Lwr Inner Fixed Jaw	1.0	EA	2,805.00
19	1801202	Upper Jaw	4.0	EA	1,420.00
20	1801203	Hyd Clamping Upper Jaw Mod (Effective to 7/28/24)	2.0	EA	1,425.00
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	MAD00072	3/8-16NCX3/4LG Fhscs PL	4.0	EA	1.07
28	MAD00073	3/8-16NCX1LG Fhscs PL	4.0	EA	1.70
29	MAN00017	1/2-13NCX1-1/4LG Shcs SS (Effective to 7/28/24)	2.0	EA	2.05
30	MAN00018	1/2-13NCX4LG Shcs SS (Effective to 7/28/24)	4.0	EA	5.27
30	MAC00451	1/2-13NCX4LG Shcs PL	4.0	EA	6.20
31	MAN00020	1/2-13NCX1LG Shcs SS (Effective to 10/16/24)	2.0	EA	2.05
31	MACP1042757	1/2-13NCX1LG LP Shcs PL	2.0	EA	0.99
32	MBE00009	1/2 Reg Splt Lck Washer Stl PL	6.0	EA	0.18
33	MBF00007	3/8 TY 'a' Wide FL Wshr Stl PL	1.0	EA	0.11
34	MBFP1023933	3/4" Sae Washer Stl PL	4.0	EA	0.00
35	MBG00001	3/8 Type 'an' FL Wshr Stl PL	7.0	EA	0.26
36	MCE00004	3/8DIA X3.75 Grip Detent Pin	8.0	EA	6.34
37	MCE00010	3/4DIA X3.75 Grip Detent Pin	4.0	EA	20.39
38	MFQ00003	6MSL/6FSL/6MSL Swivel Tee	2.0	EA	38.33
39	MFQ00009	6MSL/6FSL Swivel Elbow	2.0	EA	19.65
40	MFQP1008264	6MSL/6MSAE 4.375LG Adapter	4.0	EA	31.61
41	MAC00052	1/4-20NCX5/8LG Shcs PL	2.0	EA	0.49
42	T18P1033760	618 Facer Guide Rod Bracket	1.0	EA	169.00
43	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.