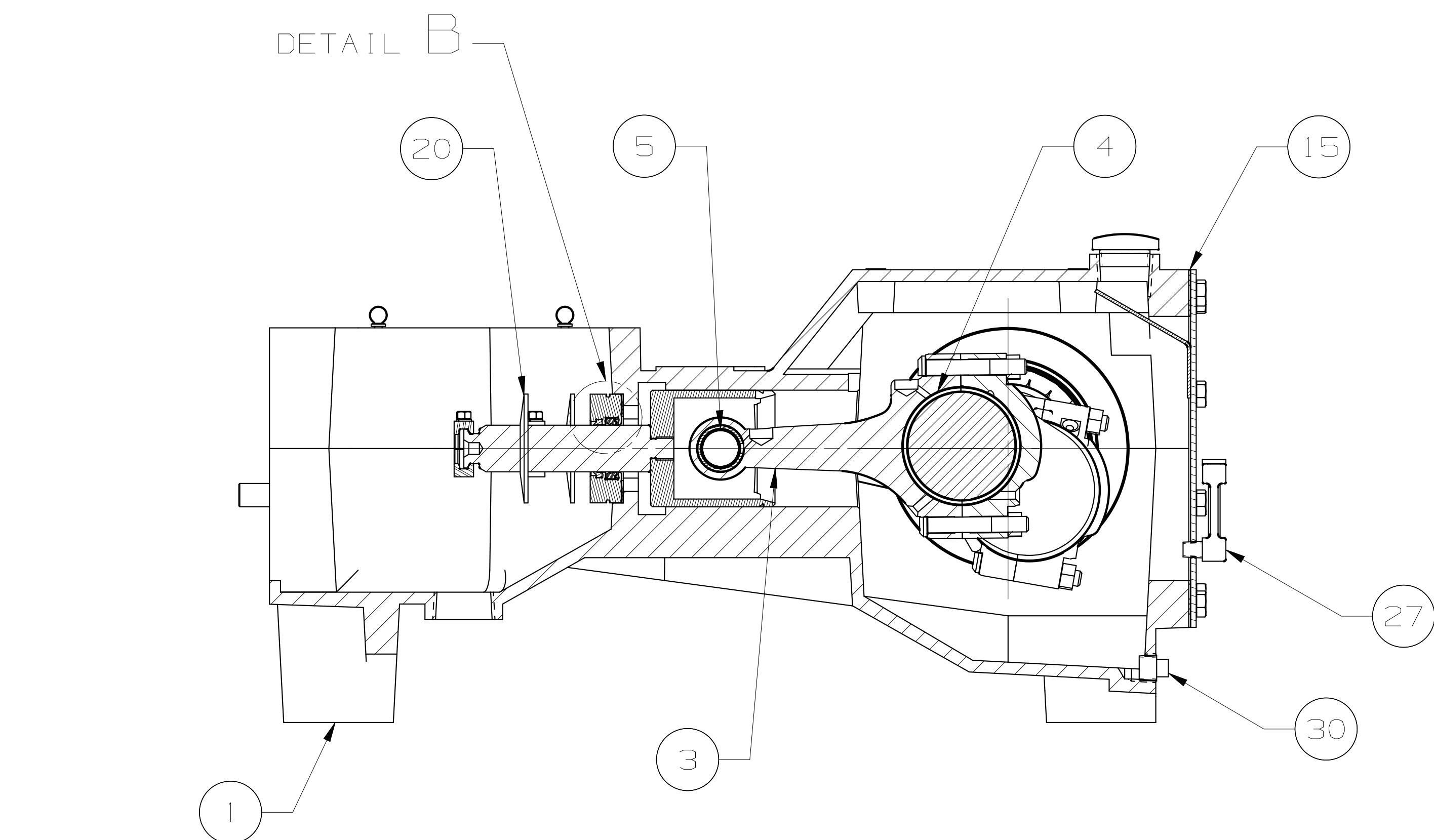
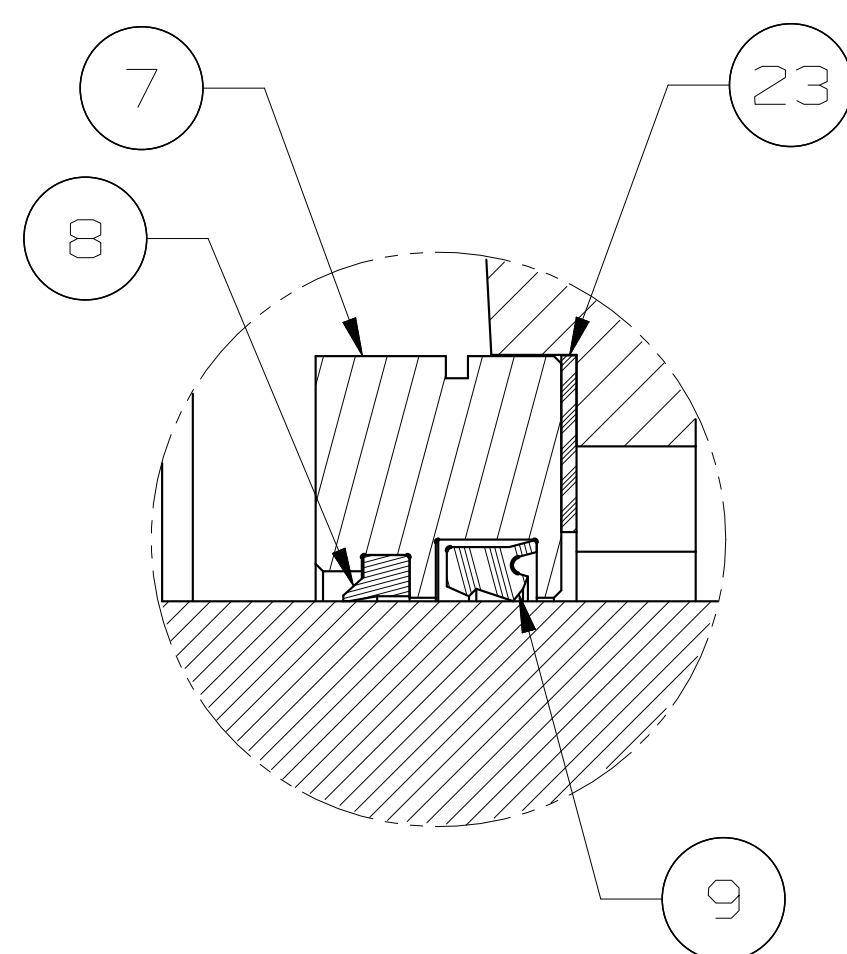


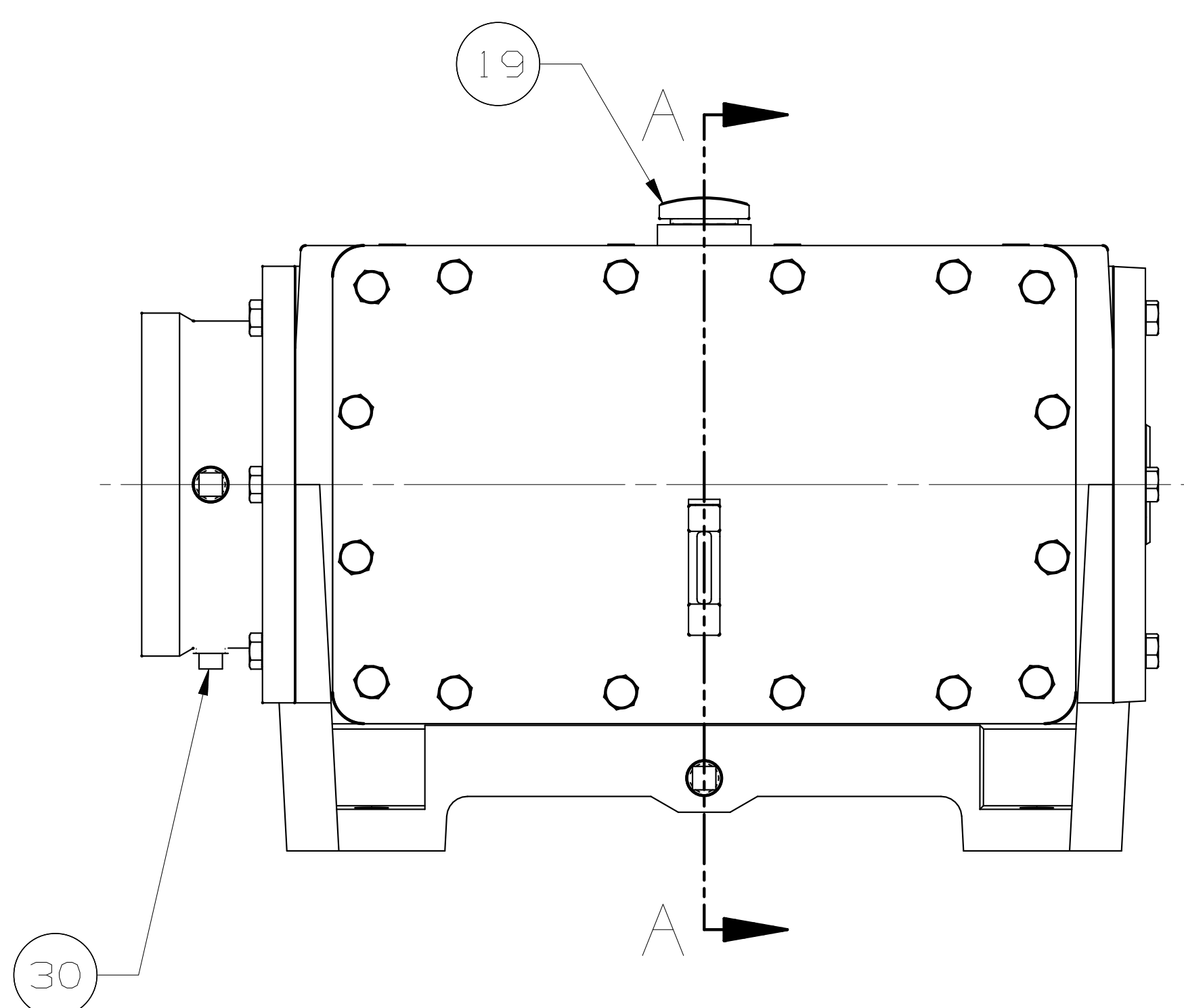


ASSEMBLY NOTES

- 1 CROSSHEAD SLOT MUST BE FACING UPWARD.
- 2 WRIST PIN LOCK HOLE MUST ALIGN WITH SET SCREW. APPLY
LOCTITE 271 TO SET SCREWS BEFORE ASSEMBLY.
- 3 LUBRICATE CRANKSHAFT OIL SEALS WITH LIGHT OIL ONLY.
- 4 BEARING END PLAY TO BE .002 TIGHT TO .002 MAX LOOSE.
GASKETS GO AGAINST POWER FRAME.
- 5 ALL MOVING PARTS IN THE POWER END SHOULD BE LUBRICATED
WITH SAE 30 WT OIL AT ASSEMBLY
- 6 INSTALL ROD SEALS WITH BOTH LIPS TURNED TOWARD THE
CRANKCASE



DETAIL B



ITEM	DESCRIPTION	QTY
1	POWER FRAME:	1
2	CRANKSHAFT:	1
3	CONNECTING ROD:	3
4	ROD BEARING:	6
5	WRIST PIN:	3
6	CROSSHEAD ASSEMBLY:	3
7	SEAL HOLDER:	3
8	OIL SEAL: W/ SCRAPER	3
9	PONY ROD SEAL: BUSAK SYSTEM	3
10	BEARING HOUSING:	1
11	BEARING HOUSING ADAPTER:	1
12	GASKET:	2
13	SHIM:	10
14	BACKCOVER WELDMENT:	1
15	COVER GASKET: F/M12	1
16	OIL SEAL:	2
17	BEARING CONE:	2
18	BEARING CUP:	2
19	OIL CAP:	1
20	SHIELD DEFLECTOR:	3
21	PLUNGER CLAMP ASSEMBLY:	3
22	CRANKSHAFT EXTENSION:	1
23	GASKET: OIL SEAL HOLDER	3
24	RETAINER RING:	1
25	THUMB SCREW: 1/4 X .50 LG	4
26	DOWEL PIN:	2
27	LIQUID LEVEL GAGE:	1
28	PIPE PLUG: 1 1/4 NPT (N.S.)	1
29	PIPE PLUG: 1/4 NPT (N.S.)	1
30	PIPE PLUG: SQ HEAD, 1/2 NPT	3
31	OIL SEAL:	1
32	CAP SCREW: HEX HEAD, 1/2 X .75 LG	16
33	CAP SCREW: HEX HEAD, 1/2 X 1.50 LG	12
34	CAPSCREW: SOC HD, 3/8 X 1.00 LG	6
35	SET SCREW: SOC HD, 5/16 X .50 LG	3
36	CAPLUG: 4	8
37	THREAD PROTECTOR: CAPPLUGS #T-9 (N.S.)	1

PRIVATE AND CONFIDENTIAL THIS DOCUMENT AND ALL THE INFORMATION CONTAINED HEREIN ARE THE CONFIDENTIAL AND EXCLUSIVE PROPERTY OF FMC TECHNOLOGIES AND MAY NOT BE DISCLOSED, REPRODUCED, OR COPIED IN ANY MANNER FOR OR BY ANY PERSON OR ENTITY WITHOUT PRIOR EXPRESS WRITTEN AUTHORIZATION BY FMC TECHNOLOGIES.		UNLESS OTHERWISE SPECIFIED DO NOT SCALE THIS DRAWING ALL DIMENSIONS ARE IN INCHES (MM) BRAUN SHAFT PADDLES - 0.381 (15.0) MAXIMUM INSIDE CORNER RADIUS - 0.127 (5.0) MAXIMUM THREADS CONFORM TO FEDERAL STANDARD H-28 TAPERED THREADS CONFORM TO API 6A BOLT HOLES MUST STRADDLE COMMON CENTERLINE FINISH 250 RMS ALL DIA'S CONCENTRIC WITHIN .010 (254) T.I.R.		DESCRIPTION POWER END ASSEMBLY; M12 RH, 24 TOOTH DRIVE		DRAWN BY WOLVERTON, JARROD DRAWING CHECKED KUMSHIGE, SCOTT DESIGN REVIEW SINGLETERRY, RONALD MANUFACTURING REVIEW CRUZ, GEORGE APPROVED BY KOKEL, ZACHARY		DATE 16-JUN-2008 05-AUG-2008 26-FEB-2009 26-FEB-2009 26-FEB-2009		LATEST P/N 5020464 REV. A		FMC Technologies Drawing Number 050500112283	
--	--	---	--	---	--	--	--	---	--	---	--	---	--