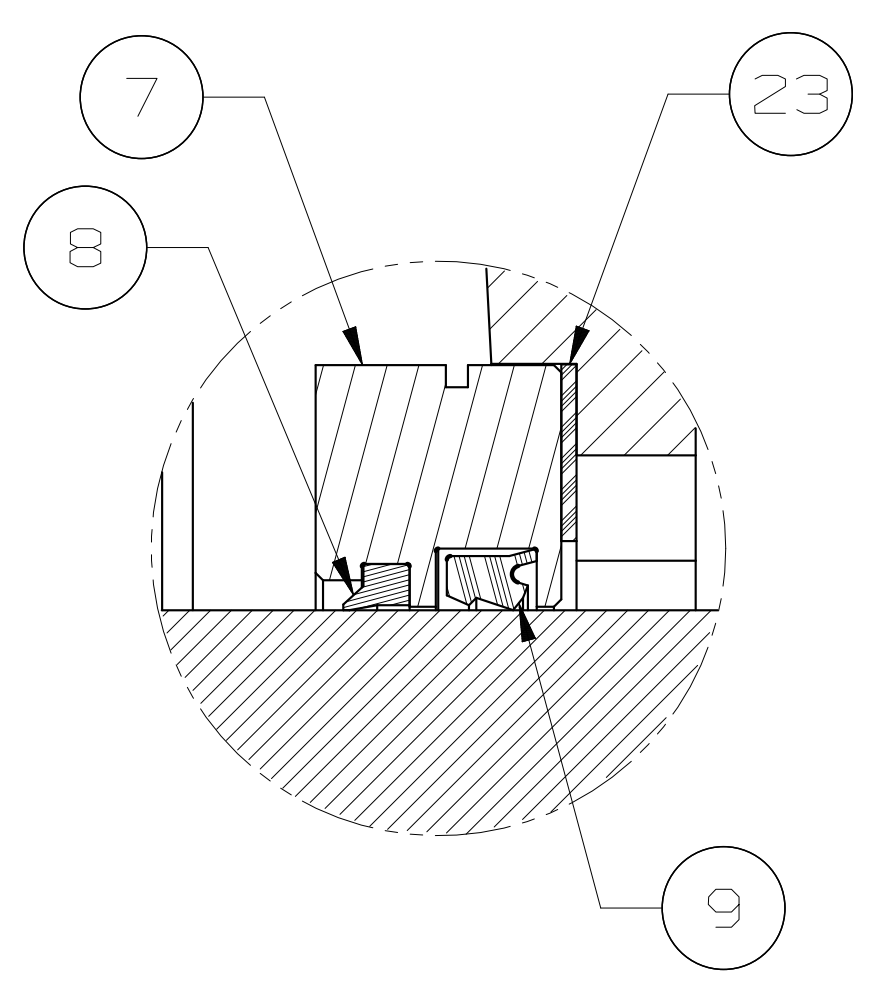
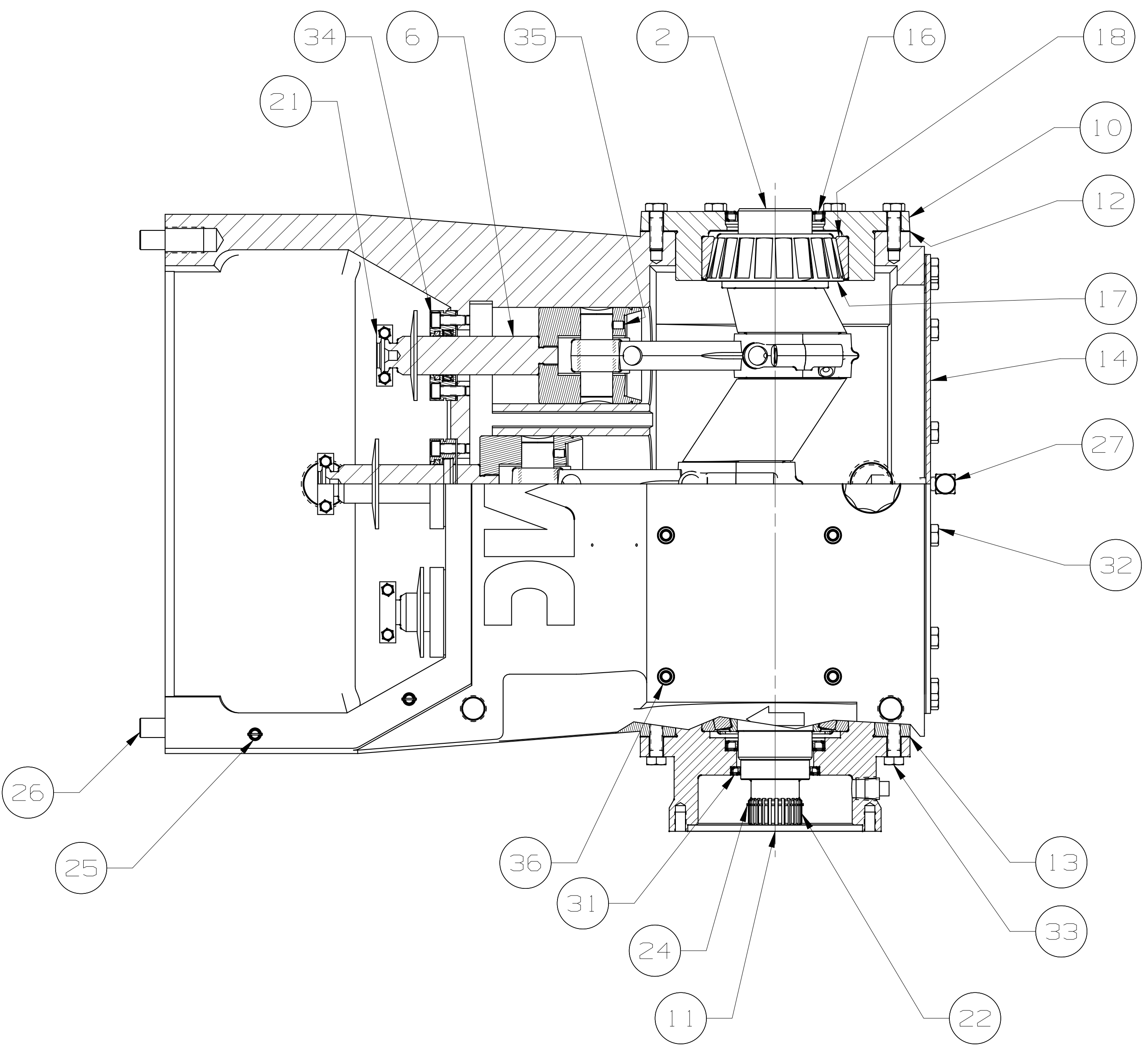
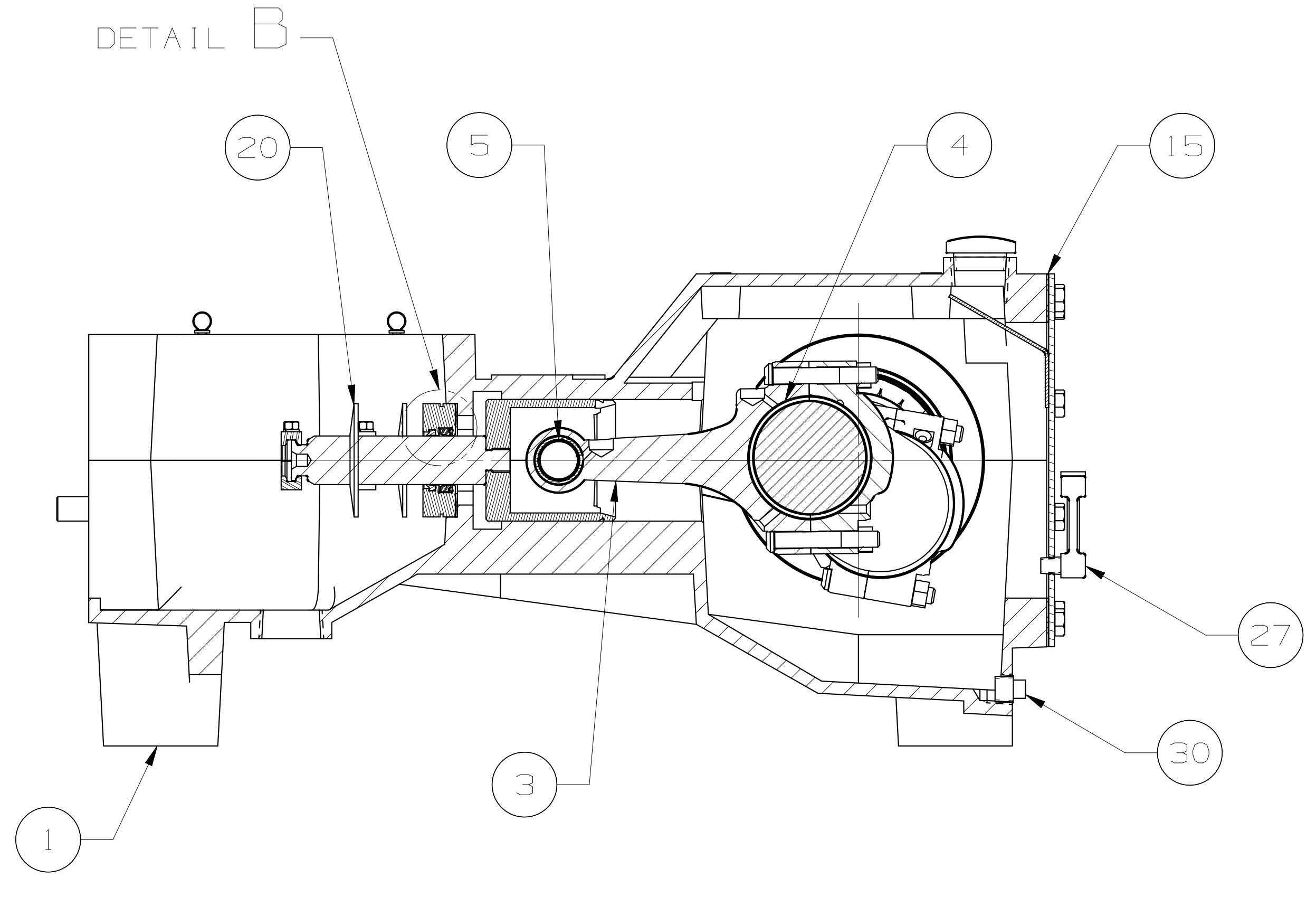


ASSEMBLY NOTES

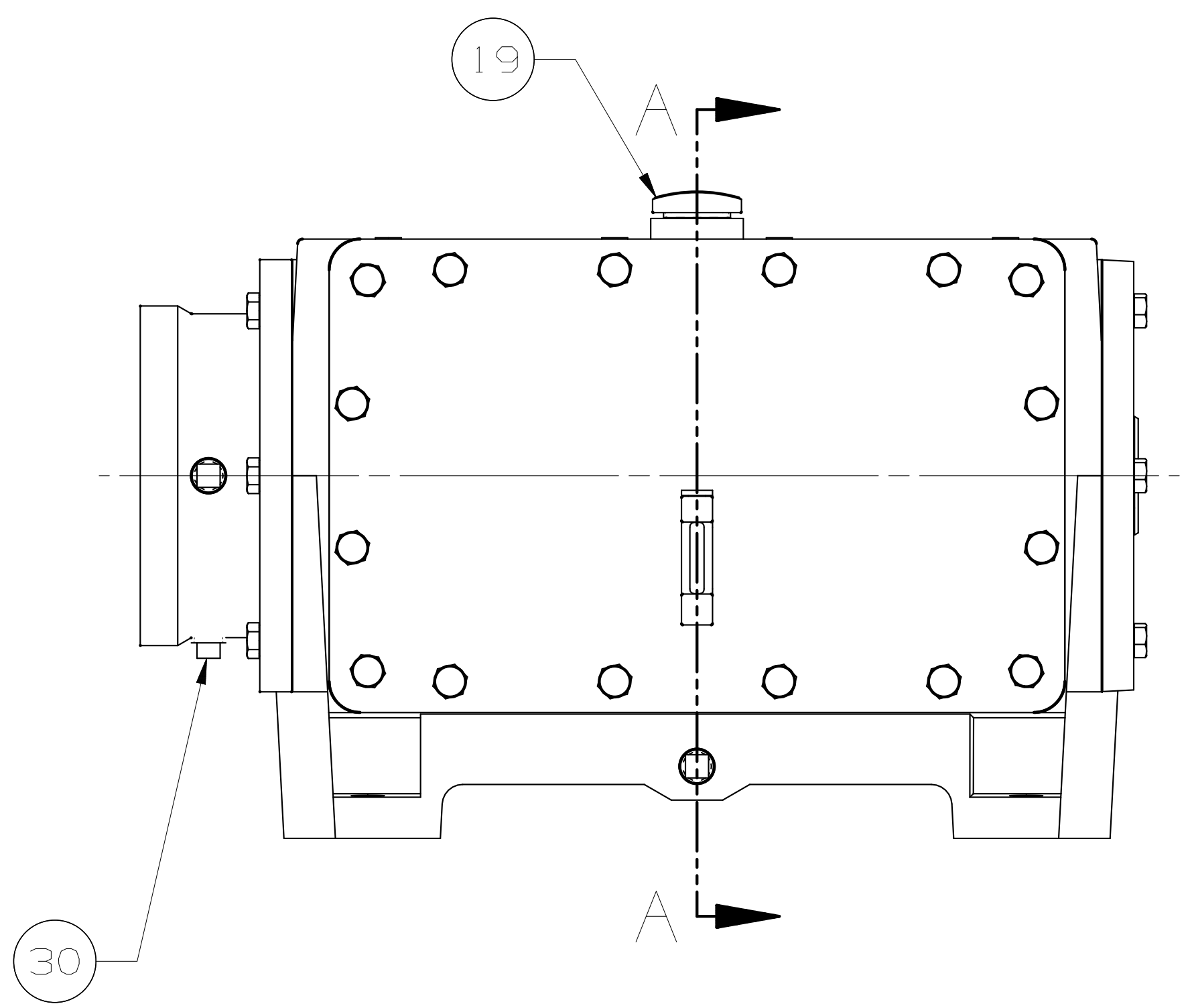
- 1 CROSSHEAD SLOT MUST BE FACING UPWARD.
- 2 WRIST PIN LOCK HOLE MUST ALIGN WITH SET SCREW. APPLY LOCTITE 271 TO SET SCREWS BEFORE ASSEMBLY.
- 3 LUBRICATE CRANKSHAFT OIL SEALS WITH LIGHT OIL ONLY.
- 4 BEARING END PLAY TO BE .002 TIGHT TO .002 MAX LOOSE. GASKETS GO AGAINST POWER FRAME.
- 5 ALL MOVING 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



SECTION A - A



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

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				<p>DRAFTING CHECK:</p> <p>KUNISHIGE, SCOTT</p>	<p>DATE:</p> <p>05-AUG-2008</p>	
				<p>DESIGN REVIEW:</p> <p>SINGLETERRY, RONALD</p>	<p>DATE:</p> <p>26-FEB-2009</p>	
				<p>MANUFACTURING APPROVAL:</p> <p>CRUZ, GEORGE</p>	<p>DATE:</p> <p>26-FEB-2009</p>	
<p>APPROVED BY:</p> <p>KOKEL, ZACHERY</p>	<p>DATE:</p> <p>26-FEB-2009</p>	<p>LATEST REV. NO. 5020464</p> <p>REV. A</p> <p>DRAWING NUMBER DU500012283</p> <p>COPYRIGHT FMC TECHNOLOGIES</p>				