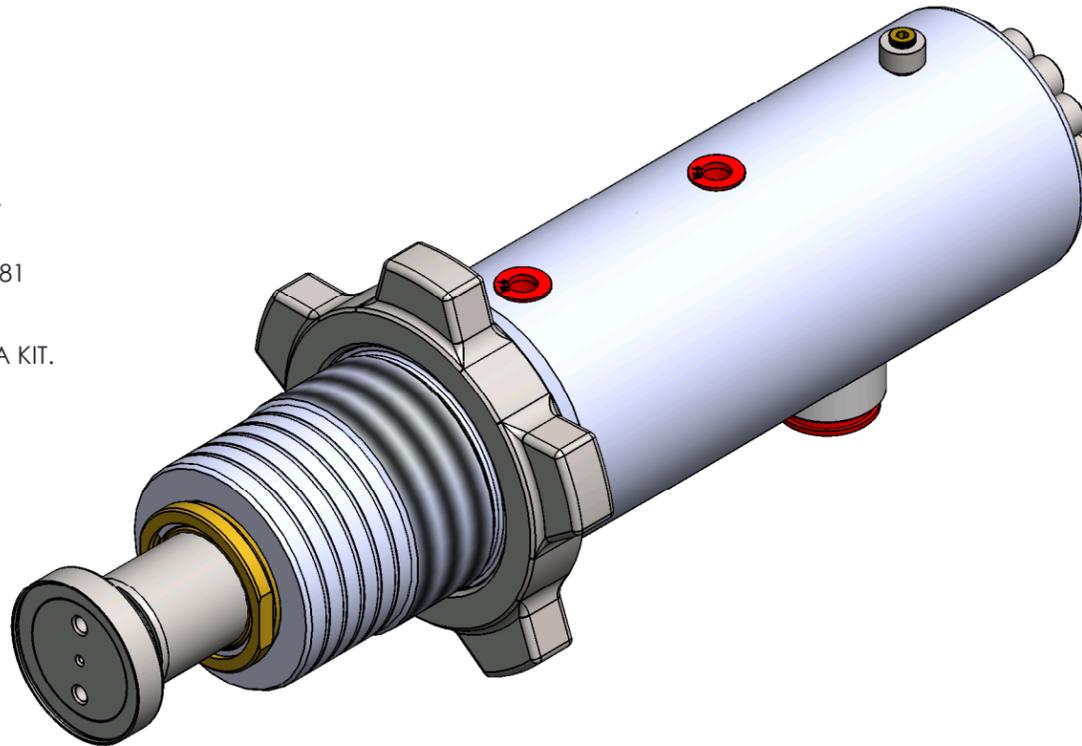
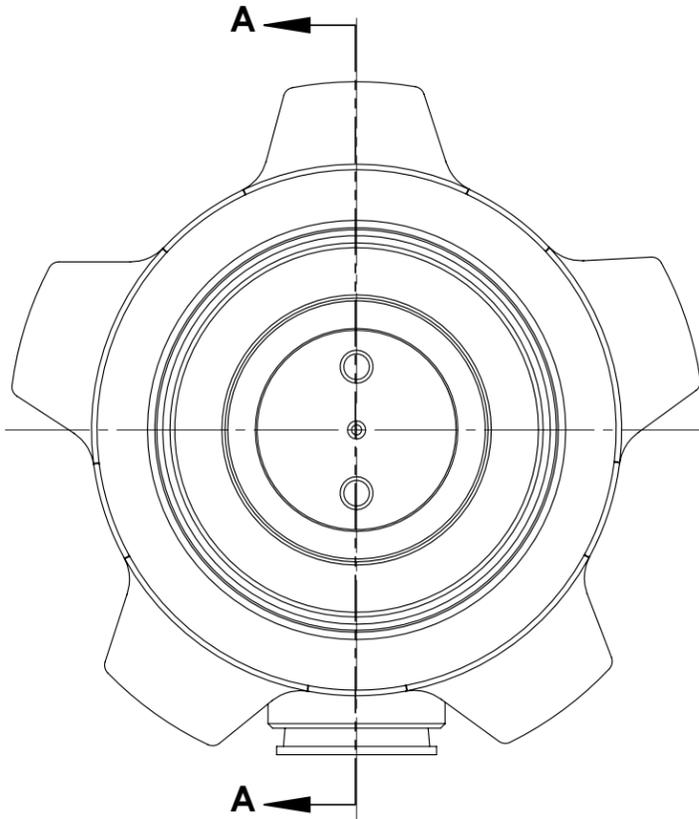


NOTES: UNLESS OTHERWISE SPECIFIED.

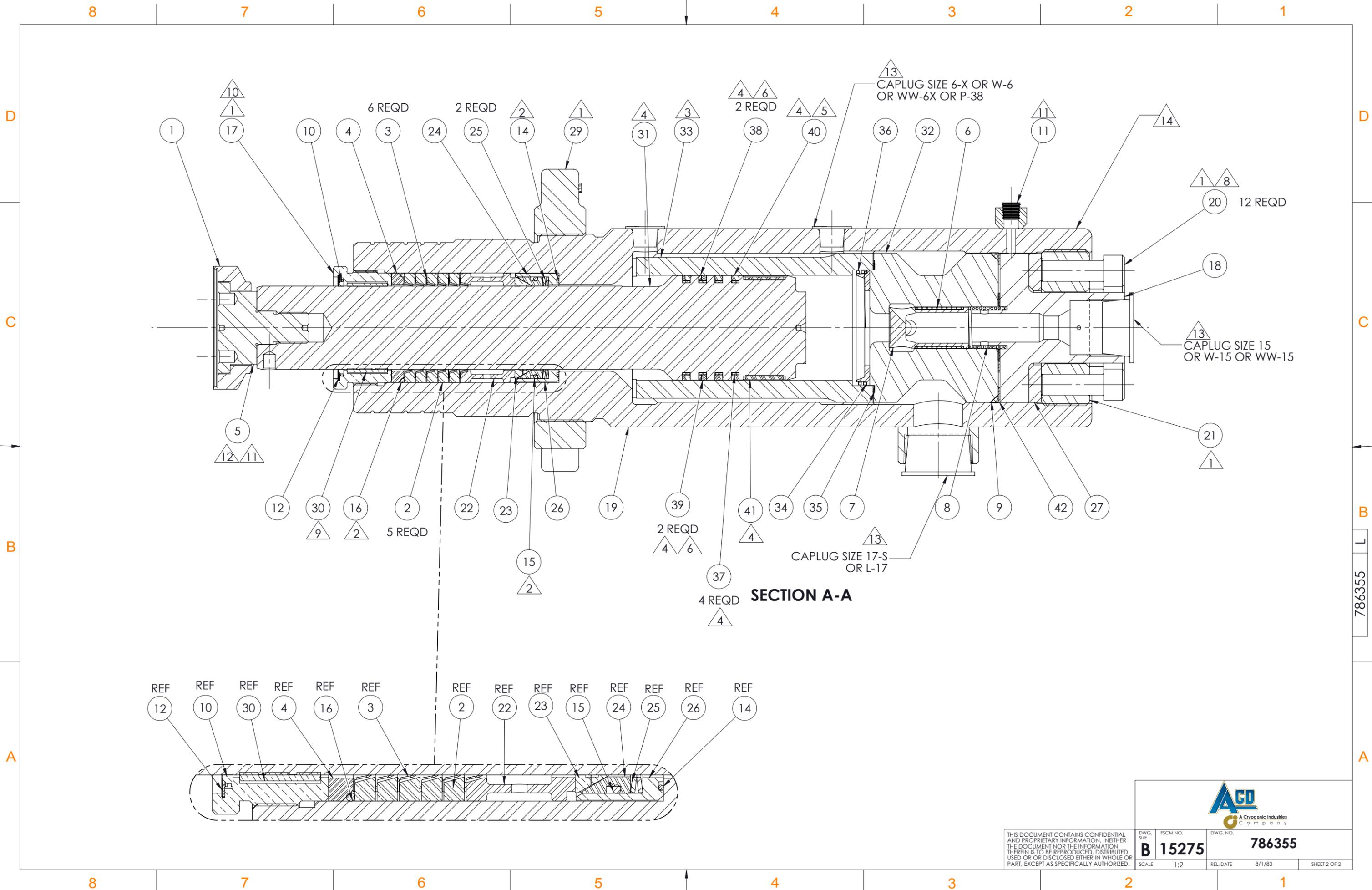
- 1 COAT THREADS WITH LUBRICANT P/N 14290-1.
- 2 COAT O-RINGS WITH LUBRICANT P/N 87903-2.
- 3 CHILL ITEM 33 IN LN2 FOR EASE OF ASSY.
- 4 USE TOOL P/N 760198-1 TO INSTALL ITEMS 31, 37, 38, 40 & 41.
- 5 GAP OF PISTON RING TO BE IN LINE WITH GAP IN EXPANDER RING.
- 6 GAP OF AFT PISTON RING TO BE LOCATED 180° FROM GAP IN FORWARD RING AND EXPANDER RING.
- 7 REMOVED.
- 8 TORQUE TO 100-105 LB-FT USING 3/8" HEX KEY.
- 9 MAY REQUIRE USE OF TOOL P/N 760189-1 TO SIZE ITEM 30, AFTER INSTALLING INTO PACKING SCREW, ITEM 17.
- 10 TORQUE TO 30 LB-FT.
- 11 COAT THREADS WITH LOCTITE P/N 87911-004.
- 12 TORQUE ITEM 5 TO 100 LB-FT USING TOOL P/N 760199-1.
- 13 THESE PARTS USED FOR SHIPPING, STORAGE AND HANDLING OF ASS'Y ONLY.
- 14 ELECTRO- ETCH WITH "786355 (APPL DASH NO./LATEST REV. LTR)" SERIAL NO., ON SURFACE INDICATED AND LOGO WITH STENCILS 99900-680 AND 99900-681 PER DRAWING 785937.
- 15. SEE -10 FOR SEAL KIT TO THIS ASSEMBLY. STANDARD CLEAN PER ECP-007. TO BE PACKAGED INDIVIDUALLY AND AS A KIT.
- 16. REMOVED.
- 17 DUE TO ROD LOAD LIMITATIONS, THIS COLD END IS LIMITED TO 11,600 PSI WHEN INSTALLED ON STANDARD ACD SLS DRIVE UNITS.



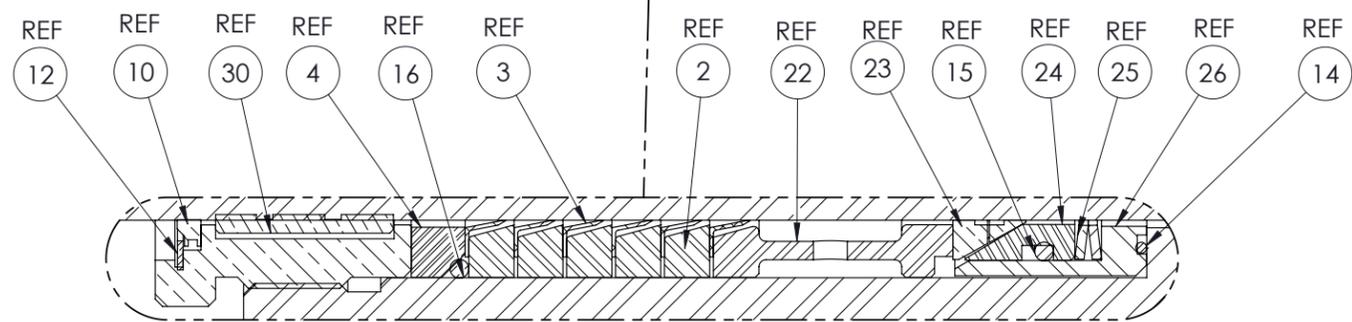
REVISIONS			
LTR	REV DESCRIPTION	DATE	APPROVED
L	SEE ECN	7/19/16	VU/JFP/MW

QTY	QTY	PART NUMBER	DESCRIPTION	ITM
1	1	784667-1	GASKET, DISCHARGE 64mm DIA SLS BP	42
1	1	784381-1	RING, RIDER PISTON 64mm DIA SLS BP	41
2	2	784379-3	RING, PISTON 64mm DIA SLS BP	40
2	2	784379-2	RING, PISTON 64mm DIA SLS BP	39
2	2	784379-1	RING, PISTON 64mm DIA SLS BP	38
4	4	784378-1	RING, EXPANDER 64mm DIA SLS BP	37
-	1	68422-001	SPRING, SUCTION, 2.50 DIA LMPD	36
1	1	784376-1	GASKET, HEAD 64mm DIA SLS BP	35
-	1	784375-1	PLATE, VALVE 64mm DIA SLS BP	34
-	1	784374-1	SLEEVE, 64mm DIA BYPASS	33
-	1	784853-1	HEAD, 64mm DIA SLS STD	32
-	1	784372-1	PISTON, 64mm DIA SLS BP - CHROME CERTS	31
1	1	784064-1	RING, RIDER PACKING SCREW	30
-	1	784044-1	JAMNUT HAMMER UP	29
-	1	783605-1	RING, SEAL PLATE 2.875 DIA BP	27
-	1	783484-1	RING SEAL CARRIER	26
-	2	783483-1	SPRING, BELLEVILLE 3.25 DIA SL	25
-	1	783482-1	RING SEAL, COMPRESSOR	24
1	1	783481-1	RING, WEDGE ROD SEAL	23
-	1	783480-1	RING, LANTERN 2.00 DIA PISTON	22
-	1	783106-1	SCREW, HEAD JAM 2.00 DIA SLS	21
-	12	60805-1	CAPSCREW 1/2-20UNF 17-4 PH COND H925 M	20
-	1	786348-1	CYLINDER ASSY 64mm DIA BP HP	19
-	1	784852-1	FITTING, DISCHARGE 2.500 DIA STD	18
-	1	781382-1	SCREW, PACKING 2.00 DIA SL	17
1	1	84143	O RING 2.43750 INCH ID X 2.62500 INCH	16
1	1	84140	O RING 2.25000 INCH ID X 2.43750 INCH	15
1	1	84035	O RING 2.25000 INCH ID X 2.37500 INCH	14
-	1	85022-01	RING, RETAINING 2.541 FREE OD X 0.158	12
-	1	00308-016	PLUG 0.1250 NPTM BRASS ALLEN HEAD (THR	11
1	1	86008	RING, SCRAPER 2.282 OD X 1.993 ID BRON	10
1	1	15253-1	SEAL-WEDGE (2 7/8 LMPD) TEFLON- 15% G	9
-	1	14858-1	SPRING DISCHARGE (2-7/8 DIA LMPD)	8
-	1	14856-2	POPPET - DISCHARGE 2.875 LMPD	7
1	1	14852-1	RIDER RING, POPPET 2.875 DIA LMPD	6
-	1	14701-1	KNOB, PISTON, LMPD	5
-	1	14698-1	RING, SEAL, 2.0 DIA LMPD HAT SEAL O-RI	4
6	6	14697-1	SEAL, HAT	3
-	5	14696-1	SPACER SEAL	2
-	1	213511-1	PISTON ADAPTER SL SLS	1
-10	-1	PART NUMBER	DESCRIPTION	ITM

UNLESS OTHERWISE SPECIFIED: A.) INTERPRET DRAWING PER ANSI Y14.5 B.) REMOVE ALL BURRS AND SHARP EDGES C.) SURFACE ROUGHNESS 125 PER ANSI B46.1 D.) THREADS PER ANSI B1.1 FOR UNIFIED SCREW THREADS ANSI B2.1 FOR PIPE THREADS E.) MACHINED FILLET RADI: R.005/.015 F.) WELD SYMBOLS PER AWS A2.4		UNLESS OTHERWISE SPECIFIED DIMENSION ARE IN INCHES TOLERANCES ON: FRACTIONS: .X .XX .XXX ±1/8" ±.10 ±.03 ±.010 DECIMALS: .XX .XXX ±.03 ±.010 ANGLES: ±1°		THIRD ANGLE PROJECTION	DRAWN S. FULTON CHECKED	DATE 8/1/83	<p><b>COLD END ASS'Y</b> DIA 64MM X 15000 PSI SLS, STD - H.P.</p>
EST. WT. ACT. WT.		DO NOT SCALE DRAWING		DESIGN C. E. TELLEZ STRESS	DATE 8/1/83	TITLE	
THIS DOCUMENT CONTAINS CONFIDENTIAL AND PROPRIETARY INFORMATION. NEITHER THE DOCUMENT NOR THE INFORMATION THEREIN IS TO BE REPRODUCED, DISTRIBUTED, USED OR OR DISCLOSED EITHER IN WHOLE OR PART, EXCEPT AS SPECIFICALLY AUTHORIZED.		FINISH		AERODYN./HYDR	PROJECT	DWG. NO. 786355	
SIMILAR TO		PARENT DWG. NO		DESIGN ACTIVITY C. E. TELLEZ MGF. ENGRG.	DATE 8/1/83	FSCM NO. 15275	
SCALE 1:8		REL. DATE 8/1/83		SHEET 1 OF 2			



**SECTION A-A**



<p>THIS DOCUMENT CONTAINS CONFIDENTIAL AND PROPRIETARY INFORMATION. NEITHER THE DOCUMENT NOR THE INFORMATION THEREIN IS TO BE REPRODUCED, DISTRIBUTED, USED OR OR DISCLOSED EITHER IN WHOLE OR PART, EXCEPT AS SPECIFICALLY AUTHORIZED.</p>			
DWG. NO.	FSCM NO.	DWG. NO.	
<b>B</b>	<b>15275</b>	<b>786355</b>	
SCALE	REL. DATE	SHEET 2 OF 2	
1:2	8/1/83		



786355

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