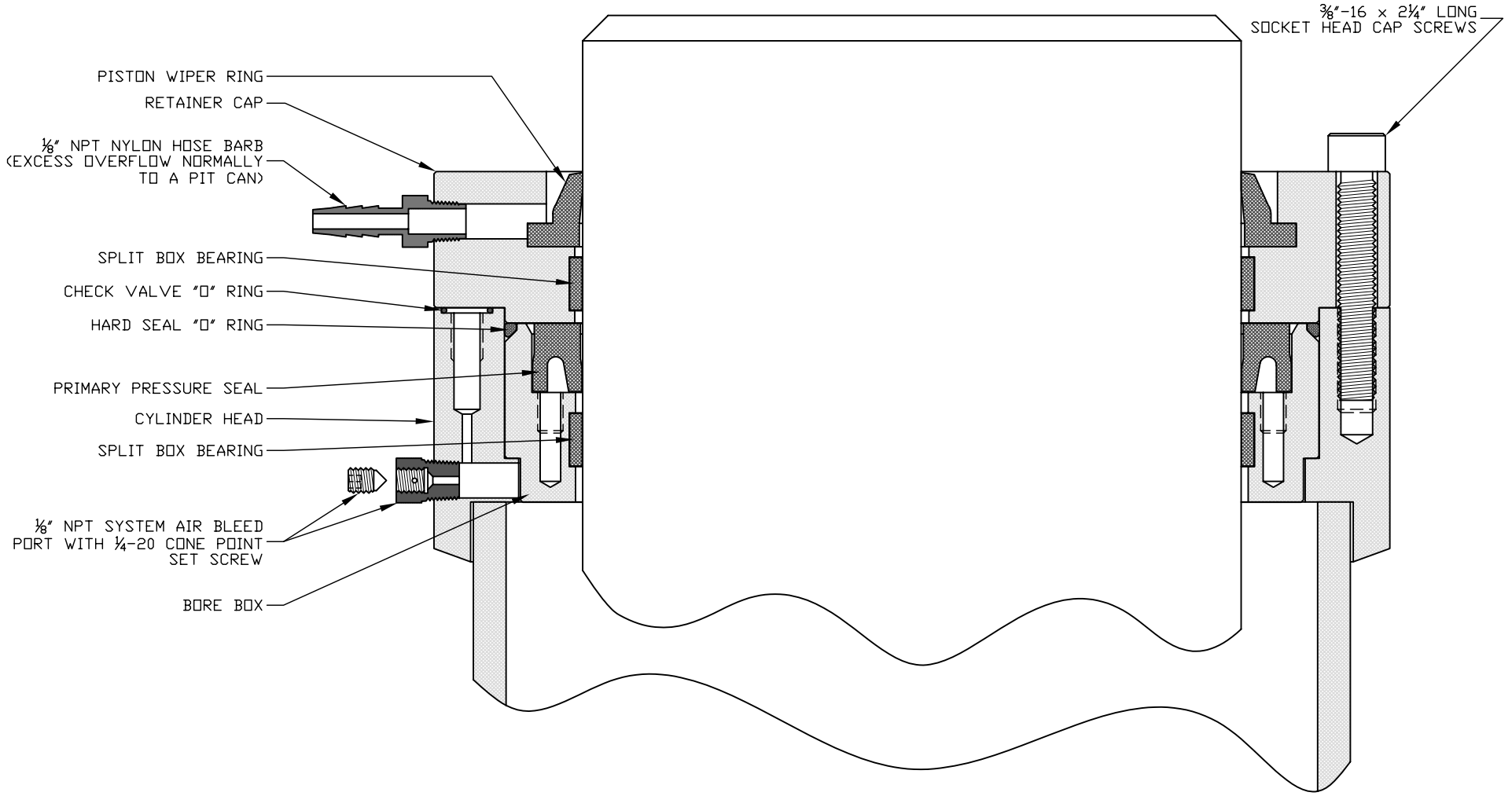


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LVL	ECN	DATE	DESCRIPTION	BY
A	N/A	3/13/02	REVISED TEXT	MLJ
B	JEFF GRISAN	11/07/06	MODIFIED BORE BOX, ADDED MISSING COMPONENTS, DRAWN TO SCALE WITH NEW TITLE BLOCK	JG



TOLER. 3PL. ± .005"	FRACTION ± 1/32"
TOLER. 2PL. ± .015"	ANGLE ± 2'
MATERIAL:	
N/A	
FILE: ..\PRODENG\SK\SK10023.DWG	

CEMCO
ELEVATOR SYSTEMS

2801 TOWNSHIP LINE RD. HATFIELD, PA 19440-0500

TITLE: CROSS SECTION CEMCO SINGLE SEAL WELDED HEAD				
DRAWN: MLJ	DATE: 11/15/05	SIZE: A	DWG NO. SK-10023	REV. B
CHECKED:	DATE:	SCALE: NTS		SHEET 1 OF 1

Packing Procedures

Single Seal Weld-on head

- Remove socket head cap screws
- Remove retainer cap
- Remove O-ring from bore box
- Remove seal using seal puller or similar device
- Remove bore box by inserting screws into 2 tapped holes on face of bore box
- Remove split box bearing
- On retainer cap- remove split box bearing
- Remove wiper ring

Install new packing

- Install wiper ring into retainer cap
- Install split box bearing into retainer cap
- With tapped holes on bore box facing up-install split box bearing into bottom groove of bore box
- Install seal- **lettering up**
- Coat the packing with oil or grease to facilitate replacement of bore box and retainer
- Use bridge plate, or similar device, to push the bore box on top of piston without the seal coming out of bore box
- Push bore box until seated in weld-on head-slightly below head height
- Insert large O-ring in beveled groove between bore box and cylinder head
- Insert small O-ring on face of weld-on head if required
- Slide retaining cap over top of piston-wiper up
- Install socket head cap screws and tighten