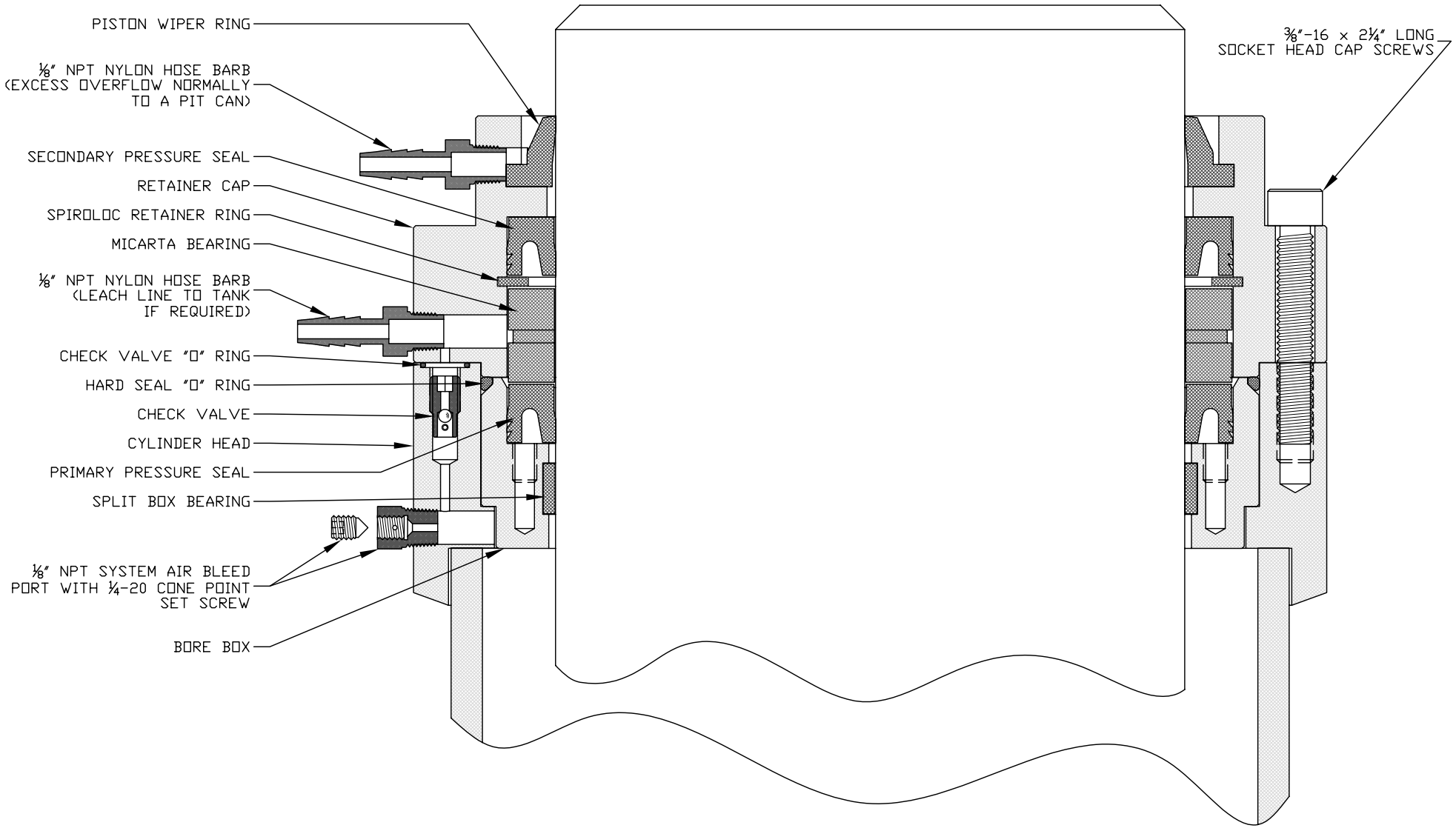


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| LVL | ECN         | DATE     | DESCRIPTION  | BY        |
|-----|-------------|----------|--|-----------|
| A   | N/A         | 05.09.01 | INITIAL RELEASE  | SAM       |
| B   | JEFF GRISAN | 11/14/05 | ALL PARTS DRAWN TO SCALE AND LABELED, INSERTED NEW TITLE BLOCK | MLJ<br>JG |
|     |             |          |  |           |



|                                 |                  |
|---------------------------------|------------------|
| TOLER. 3PL. ± .005"             | FRACTION ± 1/32" |
| TOLER. 2PL. ± .015"             | ANGLE ± 2'       |
| MATERIAL:                       |                  |
| N/A                             |                  |
| FILE: ..\PRODENG\SK\SK10017.DWG |                  |

**CEMCO**  
**LIFT**  
ELEVATOR SYSTEMS

2801 TOWNSHIP LINE RD. HATFIELD, PA 19440-0500

|  |                |            |                  |              |
|--|----------------|------------|------------------|--------------|
| TITLE: CROSS SECTION<br>CEMCO 2 SEAL WELDED HEAD |                |            |                  |              |
| DRAWN: SAM                                       | DATE: 05.09.01 | SIZE: A    | DWG NO. SK-10017 | REV. B       |
| CHECKED:   | DATE:          | SCALE: NTS |                  | SHEET 1 OF 1 |

## Packing Procedures

### 2 Seal weld-on head

- Remove socket head cap screws
- Remove retainer cap
- Remove both O rings
- Remove primary seal from bore box-using seal puller or similar device
- Remove bore box using 2 tapped holes on face of bore box
- Remove split box bearing from bore box
- From retainer cap – remove piston wiper ring
- Turn retainer cap upside down and remove micarta bearing
- Remove spiroloc retainer ring
- Remove secondary pressure seal

### Installing new packing

- Replace piston wiper ring in retainer cap
- Turn retainer cap upside down
- Insert secondary pressure seal –**lettering down** into retainer cap
- Install spiroloc retainer ring
- Install micarta bearing
- With tapped holes on bore box facing up-install split box bearing into bottom groove of the bore box
- Install primary pressure seal-**lettering up**
- Coat the packing with oil or grease to facilitate replacement of bore box and retainer
- Using 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 above ball check valve
- Turn retainer ring wiper side up and slide onto top of piston
- Align pin – install socket head cap screws and tighten