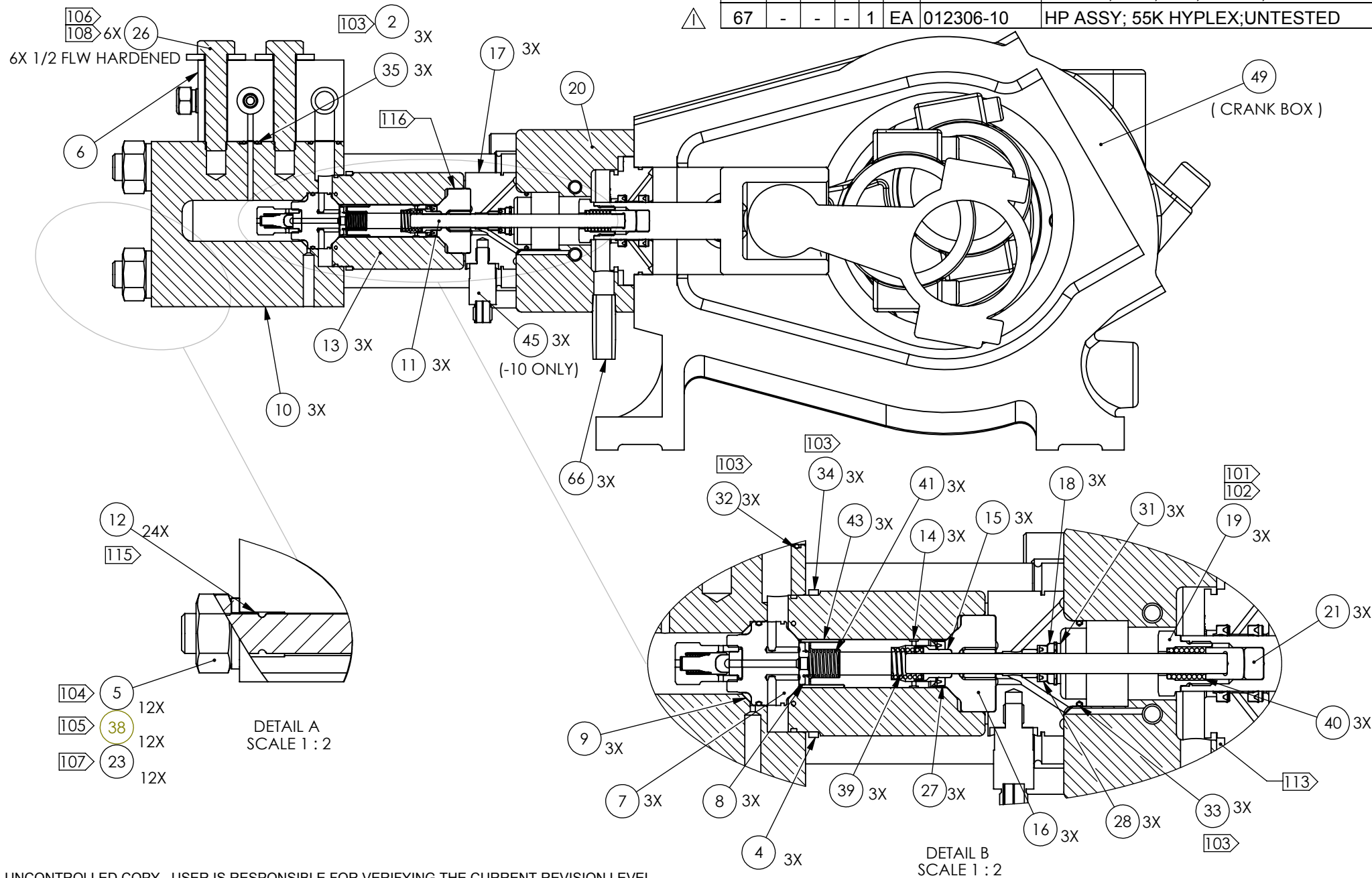


NOTE:

- 101 APPLY ANTI-SIEZE TO THREADS, TORQUE TO 20 FT. LBS.
- 102 INSTALL PLUNGER NUT (ITEM 13) WITH INSTALLATION TOOL 011153-1.
- 103 APPLY FOOD GRADE LUBRICANT TO ALL O-RINGS (A-4889).
- 104 APPLY ANTI-SIEZE COMPOUND 767 (A-10039) TO BOTH ENDS OF THE TIE RODS AND ON BOTH ENDS OF WASHERS.
- 105 INSTALL TIE RODS INTO INTO SUBPLATE USING DRIVER (011154-1) AND 1/2-20 BOLT. TORQUE TO 80 FT LBS.
- 106 APPLY ANTI-SIEZE COMPOUND 767 (A-10039) TO MANIFOLD BOLTS AND BOTH SIDES OF WASHERS.
- 107 TORQUE TO 165 FT LBS (SEE TORQUE PROCEDURE, PAGE 2)
- 108 TORQUE TO 70 LBS (SEE TORQUE PROCEDURE, PAGE 2)
- 112 REFER TO TD-1035.
- 113 REPLACEMENT RETAINER SPRING PART NUMBER A-12495.
- 114 ITEM NOT SHOWN.
- 115 INSTALL ONE BEARING ON HEX NUT SIDE AND ONE ON HP CYLINDER SIDE FOR EACH TIE ROD.
- 116 APPLY BLUE LUBRICANT TO H.P. CYLINDER AND SEAL CARRIER.

ITEM	-20	-10	-2	-1	U/M	PART	DESCRIPTION
114	42	.01	.01	-	-	DR 202504-01-5	OIL;SAE 30;55 GALLONS
	43	3	3	-	-	EA 011350-1	SLEEVE;FILLER;TUBE;EAGLE
	45	-	3	-	-	EA A-13262	THERMISTOR;10K OHM;BRASS
	46	1	1	-	-	EA A-4691	ADAPTER;HP;9/16" MALE;3/8" FEM
	47	1	1	-	-	EA 042155-10	VALVE ASSY;PRESS CNTL;60KSI
	48	1	1	-	-	EA 006113-1	NUT;ADAPTER MANIFOLD;S-200
	49	1	1	-	-	EA A-12222	CRANK;POWER END;C35
	54	1	1	-	-	EA A-2867	COLLAR;HIGH PRESSURE;1/4
	55	1	1	-	-	EA A-0610-6	PLUG;STRAIGHT THD;SST;1/2 OD
	56	1	1	-	-	EA A-14403	ORIFICE;0.8 MM;-6 SAE X -4 JIC
	57	1	1	-	-	EA A-0689-1	COLLET;GLAND;ANTI-VIB;1/4"
	61	1	1	-	-	EA A-00017-11	ELBOW;STR THD;1/2";3/4-16
	62	1	1	-	-	EA A-00017-12	ELBOW;STR THD;1/2 OD;9/16-18
	63	1	1	-	-	EA A-0531-6	ELBOW;SWIVEL;NUT;SST;3/4-16
	64	1	1	-	-	EA A-0689-2	COLLET;GLAND;ANTI-VIB;3/8"
	65	1	1	-	-	EA A-2839	COLLAR;HIGH PRESSURE;3/8
	66	3	3	-	-	EA A-0592-15	NIPPLE;PIPE;BRS;1/4NPT;1.5LG
	67	-	-	-	-	EA 012306-10	HP ASSY; 55K HYPLEX;UNTESTED

ITEM	-20	-10	-2	-1	U/M	PART	DESCRIPTION
1	-	-	1	-	-	EA 012306-20	HP ASSY;55K HYPLEX;UNTESTED
2	3	3	-	-	-	EA 006760-1	BACKUP RING;MANIFOLD
3	1	1	-	-	-	EA 006738-1	STATIC CAP SEAL;END CAP
4	3	3	-	-	-	EA 014172-1	SPACER RING;TIE RODS;HYPLEX
5	12	12	-	-	-	EA 011034-1	TIE ROD;EAGLE
6	1	1	-	-	-	EA 011899-1	MANIFOLD;HP;DIESEL EAGLE
7	3	3	-	-	-	EA 013385-1	CHECK VALVE ASSY;55K EAGLE
8	3	3	-	-	-	EA 011042-1	POPPET;INLET;EAGLE
9	3	3	-	-	-	EA 011043-1	SEAL;STATIC END CAP;EAGLE
10	3	3	-	-	-	EA 011044-1	END CAP;EAGLE
11	3	3	-	-	-	EA 011045-1	PLUNGER ASSY;EAGLE
12	24	24	-	-	-	EA A-18018-8	BEARING;SPLIT SLEEVE;5/8 X .67
13	3	3	-	-	-	EA 013932-1	CYLINDER;HIGH PRESS;55K EAGLE
14	3	3	-	-	-	EA 011050-1	FILLER TUBE;EAGLE
15	3	3	-	-	-	EA 011051-1	SEAL;DYNAMIC;EAGLE
16	3	3	-	-	-	EA 013933-1	SEAL CARRIER ASSY;55K EAGLE
17	3	3	-	-	-	EA 012402-1	ADAPTER ASSY;SUBPLATE;HYPLEX
18	3	3	-	-	-	EA 011054-1	SPACER;LOW PRESS;SEAL;EAGLE
19	3	3	-	-	-	EA 011055-1	NUT;PLUNGER;EAGLE
20	1	1	-	-	-	EA 014108-1	SUBPLATE;EAGLE
21	3	3	-	-	-	EA 011057-1	PAD;PLUNGER;EAGLE
22	1	1	-	-	-	EA 012400-1	INSERT;MANIFOLD;EAGLE
23	12	12	-	-	-	EA 011070-1	NUT;HEX;SST;EAGLE
24	1	1	-	-	-	EA A-0633-12	CONN;STR THD;9/16 X 1/2OD;SST
26	6	6	-	-	-	EA A-00756-40	SCREW;HEX;STL;GR8;1/2-20;2-1/2
27	3	3	-	-	-	EA A-00621-33	SEAL;ROD;7/16 X 11/16
28	3	3	-	-	-	EA A-00720-31	SEAL;ROD;.312 ID
29	4	4	-	-	-	EA A-0107-56	SCREW;CAP;SKT;STL;1/2-13;3-1/2
30	4	4	-	-	-	EA A-0108-72	SCREW;CAP;SKT;STL;5/8-11;4-1/2
31	3	3	-	-	-	EA A-0265-062	SNAP RING;INTERNAL;.625 OD
32	3	3	-	-	-	EA A-0275-015	O-RING;BUNA-N;70 DUR;NO.2-015
33	3	3	-	-	-	EA A-0275-025	O-RING;BUNA-N;70 DUR;NO.2-025
34	3	3	-	-	-	EA A-0275-033	O-RING;BUNA-N;70 DUR;NO.2-033
35	3	3	-	-	-	EA A-0290-010	O-RING;HIGH PRESSURE;NO.2-010
36	2	2	-	-	-	EA A-0610-5	PLUG;STR THD;SST;3/8 OD
38	12	12	-	-	-	EA A-10161	WASHER;SST;5/8
39	3	3	-	-	-	EA A-12217	SPRING;COMP;.48 DIA;.059 WIRE
40	3	3	-	-	-	EA A-12218	SPRING;COMP;.48 OD;.072 WIRE
41	3	3	-	-	-	EA A-12219	SPRING;COMP;.42 OD;RATE 3.7



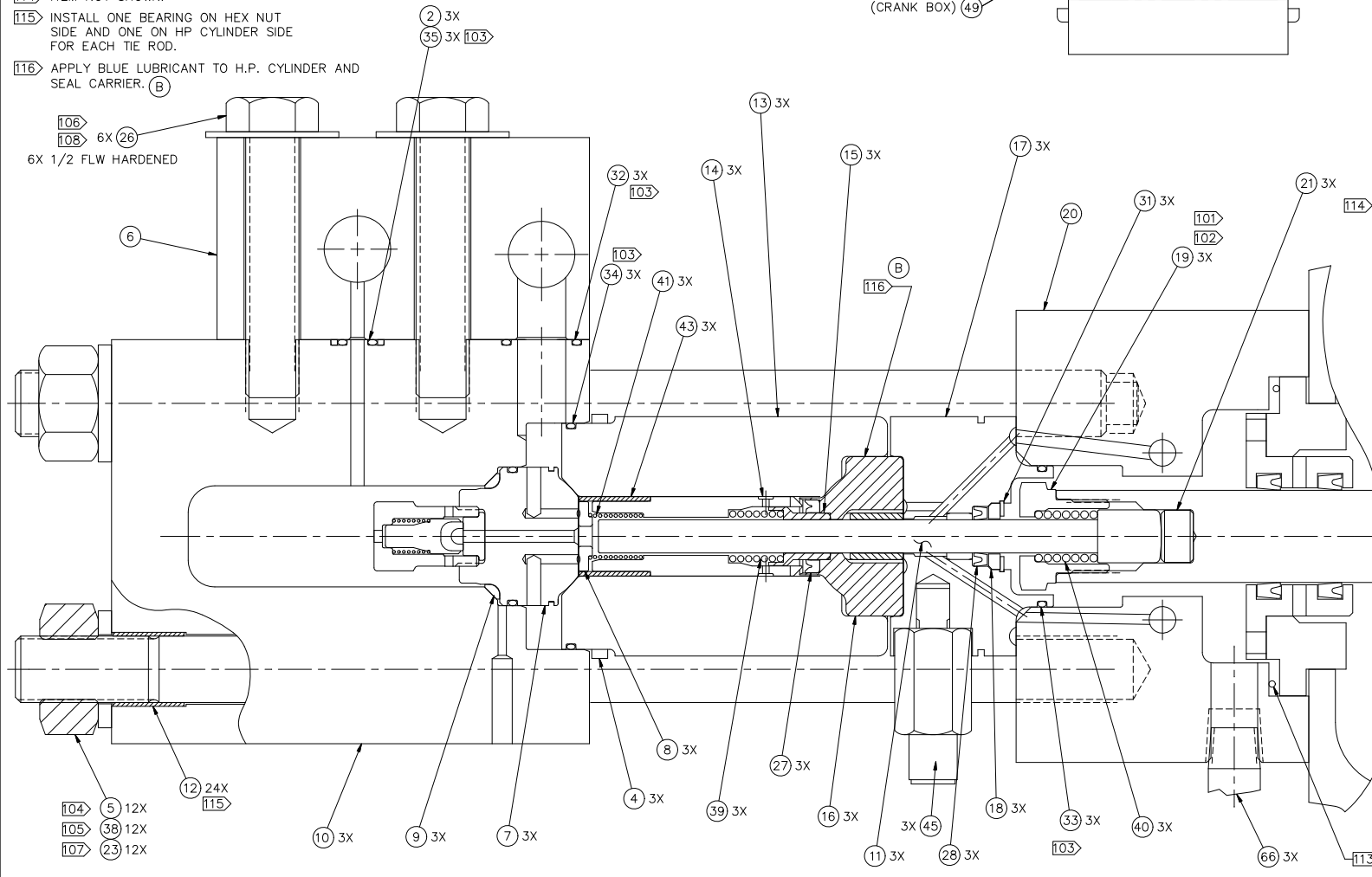
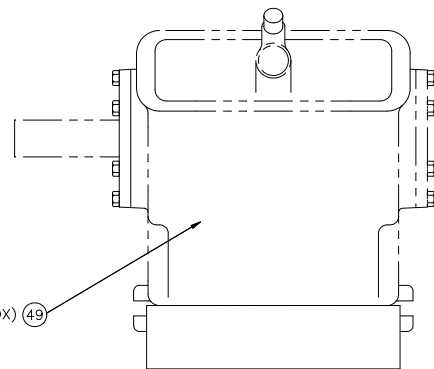
ASSEMBLY NO.	ENGINEERING REFERENCE
012306-1&2	TESTED
012306-10 & 20	UNTESTED

THIRD ANGLE PROJECTION		THIS DRAWING IS THE PROPERTY OF FLOW INTERNATIONAL CORPORATION AND IS NOT TO BE COPIED OR REPRODUCED WITHOUT THE WRITTEN CONSENT OF FLOW INTERNATIONAL CORPORATION.	
		MATERIAL SEE BOM	
REVISION 1	MODELED IN SOLIDWORKS	TITLE H.P. ASSY 55K HYPLEX	
DRAWN BY R.MANN	STARTED 5/14/99		
ENG K.KOSTOHRIS	SCALE 1:10	BASE PART NUMBER	012306

NOTES:

- [101] APPLY ANTI-SIEZE TO THREADS, TORQUE TO 20 FT LBS.
- [102] INSTALL PLUNGER NUT (ITEM 19) WITH INSTALLATION TOOL 011153-1.
- [103] APPLY FOOD GRADE LUBRICANT TO ALL O-RINGS (A-4689).
- [104] APPLY ANTI-SIEZE COMPOUND 767 (A-10039) TO BOTH ENDS OF TIE RODS AND ON BOTH SIDES OF WASHERS.
- [105] INSTALL TIE RODS INTO SUBPLATE USING DRIVER (011154-1) AND 1/2-20 BOLT. TORQUE TO 80 FT LBS.
- [106] APPLY ANTI-SIEZE COMPOUND 767 (A-10039) TO MANIFOLD BOLTS AND BOTH SIDES OF WASHERS.
- [107] TORQUE TO 165 FT LBS (SEE TORQUE PROCEDURE, PAGE 2).
- [108] TORQUE TO 70 FT LBS (SEE TORQUE PROCEDURE, PAGE 2).
- [112] REFER TO TD-1035.
- [113] RETAINER SPRING SUPPLIED WITH CRANK BOX (A-13043).
- [114] ITEM NOT SHOWN.
- [115] INSTALL ONE BEARING ON HEX NUT SIDE AND ONE ON HP CYLINDER SIDE FOR EACH TIE ROD.
- [116] APPLY BLUE LUBRICANT TO H.P. CYLINDER AND SEAL CARRIER. (B)

ASSEMBLY NO.	ENGINEERING REFERENCE
[112] 012306-1	TESTED
012306-10	UNTESTED

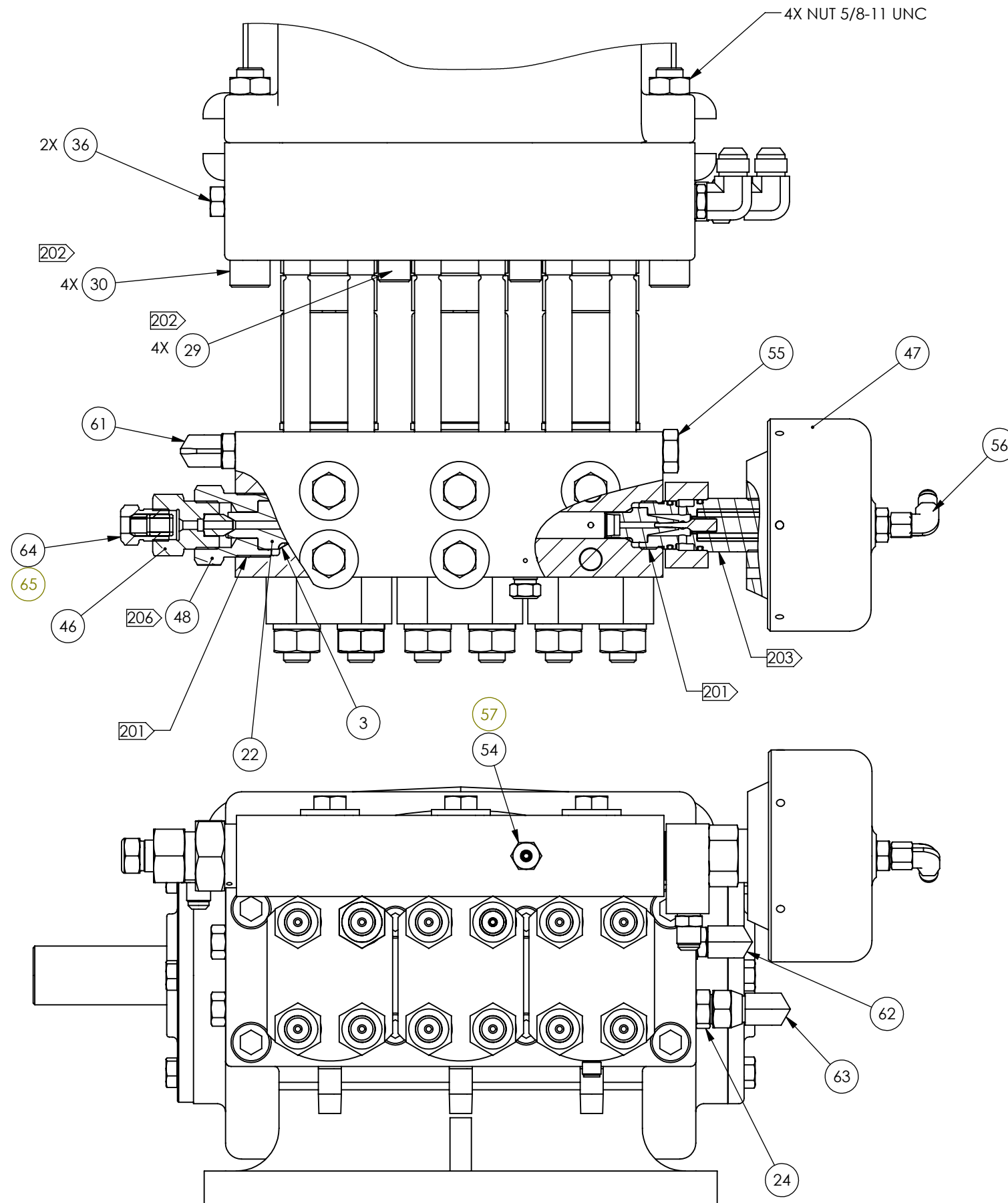


		BILL OF MATERIAL		
ITEM	QUANTITY	U/M	PART NUMBER	DESCRIPTION
1	1	EA	012306-10	HP ASSY;UNTESTED;55K EAGLE
2	3	EA	006760-1	BACKUP RING MANF;OM PUMP 10
3	1	EA	006738-1	STATIC CAP SEAL;END CAP
4	3	EA	014172-1	SPACER RING;TIE ROD
5	12	EA	011034-1	TIE ROD;EAGLE
6	1	EA	011899-1	MANIFOLD;H.P.;DIESEL EAGLE
7	3	EA	013385-1	CHECK VALVE ASSY;55K EAGLE
8	3	EA	011042-1	POPPET;INLET;EAGLE
9	3	EA	011043-1	STATIC SEAL;END CAP;EAGLE
10	3	EA	011044-1	END CAP;EAGLE
11	3	EA	011045-1	PLUNGER ASSY;EAGLE
12	24	EA	A-18018-8	BEARING;SPLIT SLEEVE;5/8 X .67
13	3	EA	013932-1	CYLINDER;HIGH PRESS;55K EAGLE
14	3	EA	011050-1	FILLER TUBE;EAGLE
15	3	EA	011051-1	SEAL;DYNAMIC;EAGLE
16	3	EA	013933-1	SEAL CARRIER;EAGLE
17	3	EA	012402-1	ADAPTER;SUBPLATE;EAGLE;GG
18	3	EA	011054-1	SPACER;SEAL;LOW PRESSURE;EAGLE
19	3	EA	011055-1	NUT;PLUNGER;EAGLE
20	1	EA	014108-1	SUBPLATE;EAGLE
21	3	EA	011057-1	PLUG;PLUNGER;EAGLE
22	1	EA	012400-1	INSERT;MANIFOLD;EAGLE
23	12	EA	011070-1	NUT;HEX;SST;EAGLE
24	1	EA	A-0633-12	CONN;STRT THD;9/16 X 1/20D;SST
26	6	EA	A-00756-40	SCREW;HEX;1/2-20 UNF;2-1/2
27	3	EA	A-00621-33	SEAL;ROD;7/16 X 11/16
28	3	EA	A-00720-31	SEAL;ROD;312 ID
29	4	EA	A-0107-56	SCREW;SKT HD;1/2-13 UNC;3-1/2
30	4	EA	A-0108-72	SCREW;SKT HD;5/8-11 UNC 4-1/2
31	3	EA	A-0265-062	SNAP RING;INTERNAL;.625 OD
32	3	EA	A-0275-015	O-RING;BUNA-N;70 DUR;NO.2-015
33	3	EA	A-0275-025	O-RING;BUNA-N;70 DUR;NO.2-025
34	3	EA	A-0275-033	O-RING;BUNA-N;70 DUR;NO.2-033
35	3	EA	A-0290-010	O-RING;HIGH PRESSURE;NO.2-010
36	2	EA	A-0610-5	PLUG;STR THD;SST;3/8 OD
38	12	EA	A-10161	WASHER;SST;5/8
39	3	EA	A-12217	SPRING;COMP;48 DIA;.059 WIRE
40	3	EA	A-12218	SPRING;COMP;48 OD;.072 WIRE
41	3	EA	A-12219	SPRING;COMP;42 OD;RATE 3.7
42	0.01	DR	202504-01-5	OIL;SAE 30;55 GALLONS
43	3	EA	011350-1	SLEEVE;FILLER;TUBE;EAGLE
45	3	EA	A-13262	THERMISTOR;10K OHM;BRASS
46	1	EA	A-4691	ADAPTER;HP;9/16" MALE;3/8" FEM
47	1	EA	013002-10	VALVE ASSY;PCV;EAGLE;UNTESTED
48	1	EA	A-12222	CRANK;POWER END;C35
49	1	EA	A-2867	COLLAR;HIGH PRESSURE;1/4
54	1	EA	A-0610-6	PLUG;STRAIGHT THD;SST;1/2 OD
55	1	EA	A-14403	DRIFICE;0.8MM;-6SAE X -4JIC
56	1	EA	A-0689-1	COLLET;GLAND;ANTI-VIB;1/4"
57	1	EA	A-0689-1	COLLET;GLAND;ANTI-VIB;1/4"
61	1	EA	A-00017-11	ELBOW;STR THD;1/2";3/4-16
62	1	EA	A-00017-12	ELBOW;STR THD;1/2" OD;9/16-18
63	1	EA	A-0531-6	ELBOW;SWIVEL;NUT;SST;3/4-16
64	1	EA	A-0689-2	COLLET;GLAND;ANTI-VIB;3/8"
65	1	EA	A-2839	COLLAR;HIGH PRESSURE;3/8
66	3	EA	A-0592-15	NIPPLE;PIPE;BRS;1/4 NPT;1.5LG

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REVISION 8	MODELED IN SOLIDWORKS	MATERIAL: SEE BOM
DRAWN BY R.MANN	TITLE H.P. ASSY	55K EAGLE
ENG K.KOSTOHRIS	SCALE D 2:1	BASE PART NUMBER 012306
		1 OF 2

NOTES:

- 201 APPLY BLUE LUBE (A-2185) TO THREADS.
- 202 APPLY SILVER ANTI-SIEZE COMPOUND 767 (A-10039) TO THREADS.
- 203 TORQUE TO 190 FT-LBS.
- 206 TORQUE TO 250 FT-LBS.

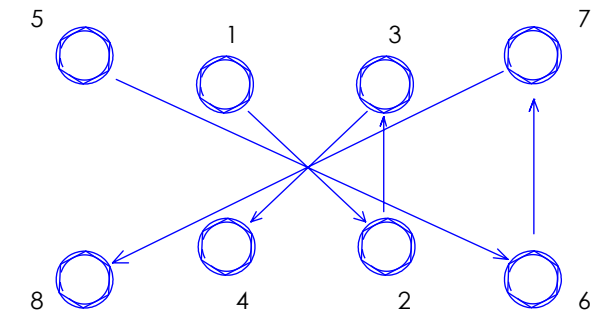


TORQUE PROCEDURES

TIGHTEN BOLT OR NUTS IN ORDER INDICATED BY NUMBERS AND ARROWS

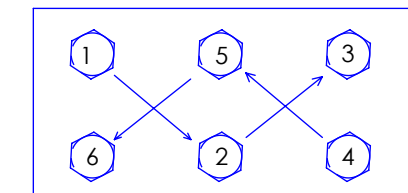
SUBPLATE

- 1) TORQUE ALL BOLTS TO 20 FT LBS.
- 2) TORQUE ALL BOLTS TO 40 FT LBS.
- 3) TORQUE OUTSIDE 5/8" BOLTS TO 70 FT LBS.

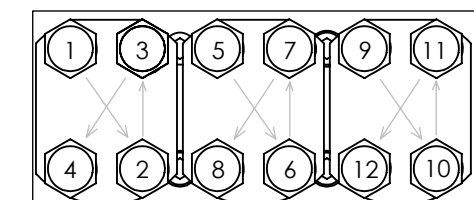


MANIFOLD & TIE RODS

- 1) PRELOAD MANIFOLD BOLTS TO 10 FT LBS.
- 2) HAND TIGHTEN TIE ROD NUTS.
- 3) TIGHTEN TIE ROD NUTS APPROXIMATELY 15°-60° ONE AT A TIME UNTIL 165 FT LBS TORQUE IS REACHED.
- 4) TORQUE MANIFOLD BOLTS TO 70 FT LBS.



MANIFOLD



TIE RODS

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		MATERIAL SEE BOM	
REVISION 1	MODELED IN SOLIDWORKS	TITLE H.P. ASSY 55K HYPLEX	
DRAWN BY R.MANN	STARTED 5/14/99	BASE PART NUMBER 012306	
ENG K.KOSTOHRIS	SCALE 1:3	2 OF 2	