

<b>HYPERJET - 94KSI</b>	
020070-1	INTENSIFIER;94K PH2 ----- TESTED
020070-10	INTENSIFIER;94K PH2 ----- UNTESTED
020070-1-R	INTENSIFIER;94K PH2 ----- RETURNED
020070-1-FX	INTENSIFIER;94K PH2 ----- REMANUFACTURED (TESTED)
020070-1-EX	INTENSIFIER;94K PH 2 ---- EXCHANGE (TESTED)

SEE SHEET 2

<b>HYPERLIFE - 75KSI</b>	
020070-2	INTENSIFIER;75K PH2 ----- TESTED
020070-20	INTENSIFIER;75K PH2 ----- UNTESTED
020070-2-R	INTENSIFIER;75K PH2 ----- RETURNED
020070-2-FX	INTENSIFIER;75K PH2 ----- REMANUFACTURED (TESTED)

SEE SHEET 3

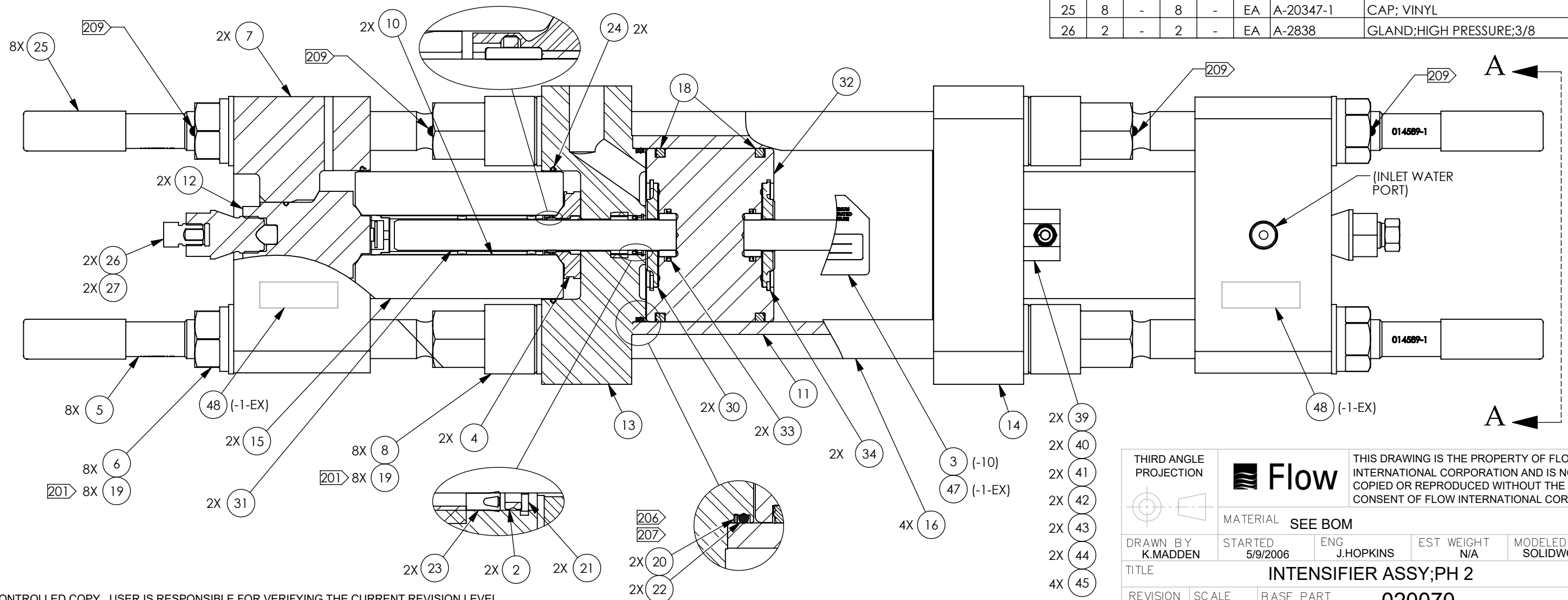
THIRD ANGLE PROJECTION 	 <b>Flow</b>	THIS DRAWING IS THE PROPERTY OF FLOW INTERNATIONAL CORPORATION AND IS NOT TO BE COPIED OR REPRODUCED WITHOUT THE WRITTEN CONSENT OF FLOW INTERNATIONAL CORPORATION.		
	MATERIAL	SEE BOM		
DRAWN BY K.MADDEN	STARTED 5/9/2006	ENG J.HOPKINS	EST WEIGHT N/A	MODELED IN SOLIDWORKS
TITLE <b>INTENSIFIER ASSY;PH 2</b>				
REVISION N	SCALE 3:9	BASE PART NUMBER	<b>020070</b>	1 OF 4

NOTES:

- 201 LUBE TIE ROD THREADS AND BOTH SIDES OF WASHER WITH ANTI-SEIZE.
- 202. ASSEMBLE PER MD-0120 AND MD-0104.
- 203. APPROXIMATE WEIGHT: 325 LBS.
- 204. ASSEMBLE PISTON (ITEMS 30 THRU 34) PER AP-1025.
- 205 ITEM NOT SHOWN.
- 206 SEALS MUST BE ORIENTED AS SHOWN. LUBRICATE LIGHTLY WITH MOLYKOTE ORING GREASE.
- 207 ORIENT BACK UP RING SO FLASHING IS AWAY FROM O-RING.
- 208 TEST PER MD-0118 AND TD-1102.
- 209 APPLY ONE BEAD OF TAMPER PROOF ADHESIVE (A-4109), GREEN, TO THE LOCATIONS INDICATED (2X - OPP. ENDS).  
**APPLY TO 020070-1-EX ONLY**

PART NO.	DESCRIPTION
208 020070-1	INTENSIFIER;94K PH2 ----- TESTED
020070-10	INTENSIFIER;94K PH2 ----- UNTESTED
020070-1-R	INTENSIFIER;94K PH2 ----- RETURNED
020070-1-FX	INTENSIFIER;94K PH2 ----- REMANUFACTURED (TESTED)
020070-1-EX	INTENSIFIER;94K PH 2 ----- EXCHANGE (TESTED)

ITEM	-1-EX	-1-FX	-10	-1	U/M	PART NUMBER	DESCRIPTION	ITEM	-1-EX	-1-FX	-10	-1	U/M	PART NUMBER	DESCRIPTION
27	2	-	2	-	EA	A-2839	COLLAR;HIGH PRESSURE;3/8	1	-	-	-	1	EA	020070-10	INTENSIFIER ASSY;87K PH2;UNTES
30	2	-	2	-	EA	007029-1	SPACER;BISCUIT;60K	2	2	-	2	-	EA	010276-1	SPACER;OIL SEAL;60K
31	2	-	2	-	EA	010253-1	PLUNGER ASSY;60K;CERAMIC	3	-	-	1	-	EA	049645-4	LABEL;SERIAL NO;87K
32	1	-	1	-	EA	020080-1	BISCUIT;PISTON;87K INT PH2	4	2	2	2	-	EA	040015-1	SEAL CARTRIDGE;87K-2.0 INTENS
33	2	-	2	-	EA	A-00251-18	T-SEAL;ROD;1-1/4 ID X 1-1/2 OD	5	8	-	8	-	EA	014589-1	TIE ROD;END CAP;87K-2.0 INT.
34	2	-	2	-	EA	A-0270-300	SNAP RING;INTERNAL	6	8	-	8	-	EA	014597-1	NUT;TIE ROD;87K-2.0 INT.
205 35	-	-	-	1	EA	A-20283-30	CRATE;SHIPPING;87K INT;SHT BLK	7	2	-	2	-	EA	014817-1	END CAP;INTENSIFIER;87K-2.0
205 36	-	1	-	-	EA	020070-1-R	INTENSIFIER ASSY;87K PH2;RETRN	8	8	-	8	-	EA	014840-1	NUT;TIE ROD;INT;87K-2.0
205 37	-	1	-	-	EA	013157-901	SEAL KIT;LOW-PRESS;6000 BAR	10	2	-	2	-	EA	020595-1	FILLER TUBE ASSY;87K INT;CARTR
205 38	-	2	-	-	EA	012035-1	REPAIR KIT;CHK VLV;6000 BAR INT	11	1	-	1	-	EA	019975-1	CYLINDER;LOW PRESS;87K INT;PH2
39	2	-	2	-	EA	011275-1	SENSOR ASSY;ELECTRIC SHIFT;24V	12	2	-	2	-	EA	020071-1	CHECK VALVE ASSY;87K INT PH2
40	2	-	2	-	EA	B-8346-1	ACTUATOR ASSY;ELECTRONIC SHIFT	13	1	-	1	-	EA	020072-1	ENDBELL ASSY;LEFT;87K INT PH2
41	2	-	2	-	EA	A-0276-012	RING;BACK UP;NITRILE;.390 DIA	14	1	-	1	-	EA	020074-1	ENDBELL ASSY;RIGHT;87K INT PH2
42	2	-	2	-	EA	A-0275-012	O-RING;BUNA-N;70 DUR;NO.2-012	15	2	-	2	-	EA	020592-1	HP CYLINDER;87K INT;CARTRIDGE
43	2	-	2	-	EA	A-2409	SPRING COMPRESSION;P/N CO480-0	16	4	-	4	-	EA	020078-1	TIE ROD;LOW PRESS;87K INT PH2
44	2	-	2	-	EA	B-1702-1	PIN;FIRING	18	2	-	2	-	EA	201446-219-1	SEAL;POLYPAK;5 IN BORE;STD
45	4	-	4	-	EA	A-0114-16	SCREW;CAP;SKT;STL;10-32;1	19	16	-	16	-	EA	A-22757-1	WASHER;HRDNED;1.135 ID X 2 OD
47	1	-	-	-	EA	049645-6	LABEL;SERIAL NO;87 KSI;ALUM	20	2	-	2	-	EA	A-00437-248	BACK UP RING;4-3/4 X 5 X 1/8
48	2	-	-	-	EA	059865-1	LABEL;DO NOT SERVICE;ALUM	21	2	-	2	-	EA	A-0264-112	SNAP RING;INVERTED
49	1	-	-	-	EA	A-20283-52	SHIPPING CRATE;60 INTN-EX	22	2	-	2	-	EA	A-0275-248	O-RING;BUNA-N;70 DUR;NO.2-248
205 50	1	-	-	-	EA	FIC-0315	HYPERJET INTENSIFIER RETURN FORM	23	2	-	2	-	EA	A-11275	SEAL;ROD;7/8 ID
205 51	1	-	-	-	EA	CAP-1503	HYPERJET INTENSIFIER EXCHANGE PROGRAM	24	2	-	2	-	EA	A-15034-2	O-RING;METRIC;94MM ID;3MM CS
25	8	-	8	-	EA	A-20347-1	CAP; VINYL	25	8	-	8	-	EA	A-20347-1	CAP; VINYL
26	2	-	2	-	EA	A-2838	GLAND;HIGH PRESSURE;3/8	26	2	-	2	-	EA	A-2838	GLAND;HIGH PRESSURE;3/8



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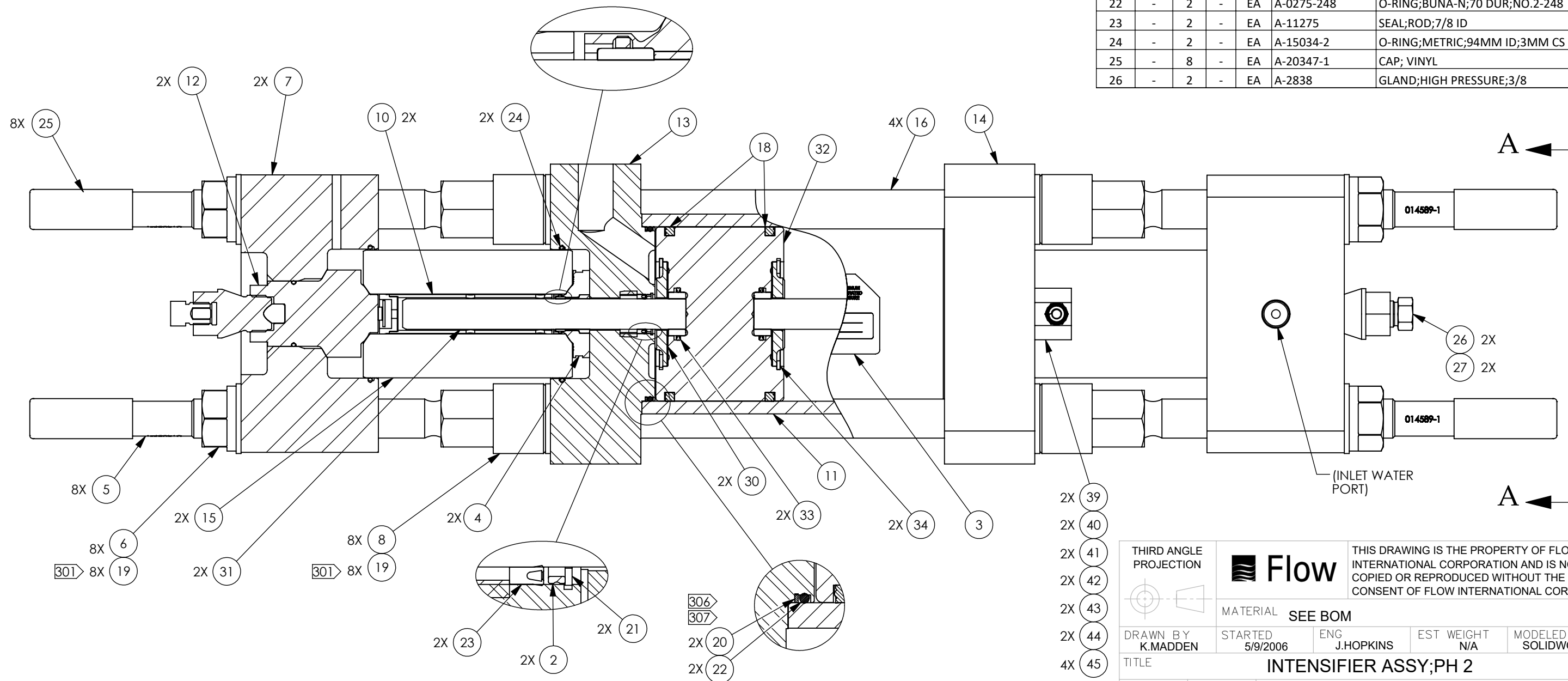
THIRD ANGLE PROJECTION			THIS DRAWING IS THE PROPERTY OF FLOW INTERNATIONAL CORPORATION AND IS NOT TO BE COPIED OR REPRODUCED WITHOUT THE WRITTEN CONSENT OF FLOW INTERNATIONAL CORPORATION.	
	MATERIAL SEE BOM			
DRAWN BY K.MADDEN	STARTED 5/9/2006	ENG J.HOPKINS	EST WEIGHT N/A	MODELED IN SOLIDWORKS
TITLE <b>INTENSIFIER ASSY;PH 2</b>				
REVISION N	SCALE 3:9	BASE PART NUMBER	<b>020070</b>	2 OF 4

NOTES:

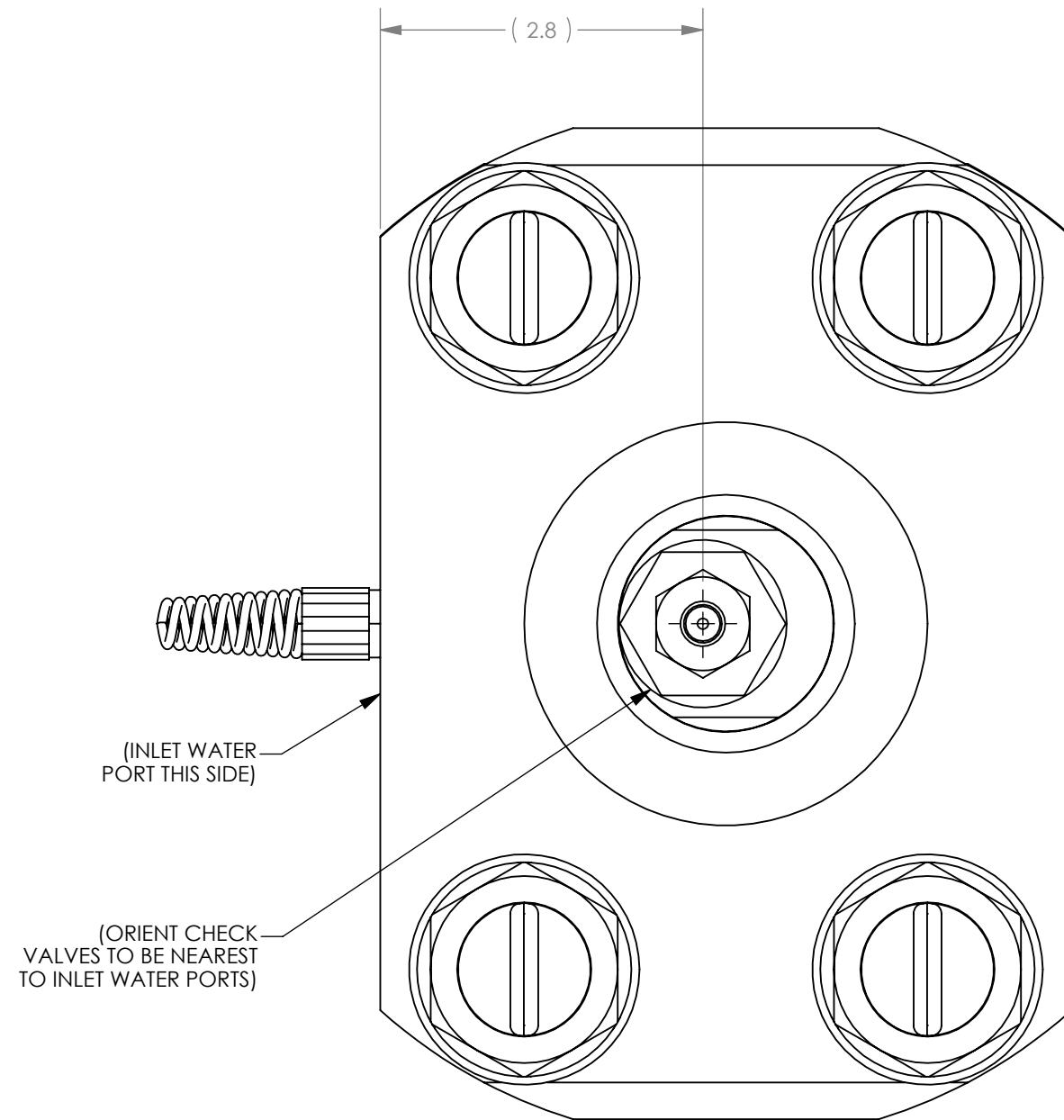
- 301 LUBE TIE ROD THREADS AND BOTH SIDES OF WASHER WITH ANTI-SEIZE.
- 302. ASSEMBLE PER MD-0120 AND MD-0104.
- 303. APPROXIMATE WEIGHT: 325 LBS.
- 304. ASSEMBLE PISTON (ITEMS 30 THRU 34) PER AP-1025.
- 305 ITEM NOT SHOWN.
- 306 SEALS MUST BE ORIENTED AS SHOWN. LUBRICATE LIGHTLY WITH MOLYKOTE ORING GREASE.
- 307 ORIENT BACK UP RING SO FLASHING IS AWAY FROM O-RING.
- 308 TEST PER MD-0118 AND TD-1102.

PART NO.	DESCRIPTION
308 020070-2	INTENSIFIER;75K PH2 ----- TESTED
020070-20	INTENSIFIER;75K PH2 ----- UNTESTED
020070-2-R	INTENSIFIER;75K PH2 ----- RETURNED
020070-2-FX	INTENSIFIER;75K PH2 ----- REMANUFACTURED (TESTED)

ITEM	-2-FX	-20	-2	U/M	PART NUMBER	DESCRIPTION	ITEM	-2-FX	-20	-2	U/M	PART NUMBER	DESCRIPTION
27	-	2	-	EA	A-2839	COLLAR;HIGH PRESSURE;3/8	1	-	-	1	EA	020070-20	INTENSIFIER ASSY;87K PH2;UNTES
30	-	2	-	EA	007029-1	SPACER;BISCUIT;60K	2	-	2	-	EA	010276-1	SPACER;OIL SEAL;60K
31	-	2	-	EA	010253-1	PLUNGER ASSY;60K;CERAMIC	3	-	1	-	EA	049645-2	LABEL;SERIAL NO;75KSI
32	-	1	-	EA	020080-1	BISCUIT;PISTON;87K INT PH2	4	2	2	-	EA	053334-1	SEAL CARTRIDGE;75K-2.0 INTENS
33	-	2	-	EA	A-00251-18	T-SEAL;ROD;1-1/4 ID X 1-1/2 OD	5	-	8	-	EA	014589-1	TIE ROD;END CAP;87K-2.0 INT.
34	-	2	-	EA	A-0270-300	SNAP RING;INTERNAL	6	-	8	-	EA	014597-1	NUT;TIE ROD;87K-2.0 INT.
35	-	-	1	EA	A-20283-30	CRATE;SHIPPING;87K INT;SHT BLK	7	-	2	-	EA	014817-1	END CAP;INTENSIFIER;87K-2.0
36	1	-	-	EA	020070-2-R	INTENSIFIER ASSY;87K PH2;RETRN	8	-	8	-	EA	014840-1	NUT;TIE ROD;INT;87K-2.0
37	1	-	-	EA	013157-901	SEAL KIT;LOW-PRESS;6000 BAR	10	-	2	-	EA	020595-1	FILLER TUBE ASSY;87K INT;CARTR
38	2	-	-	EA	012035-1	REPAIR KIT;CHK VLV;6000 BAR INT	11	-	1	-	EA	019975-2	CYLINDER;LOW PRESS;75K INT;PH2
39	-	2	-	EA	011275-1	SENSOR ASSY;ELECTRIC SHIFT;24V	12	-	2	-	EA	020071-1	CHECK VALVE ASSY;87K INT PH2
40	-	2	-	EA	B-8346-1	ACTUATOR ASSY;ELECTRONIC SHIFT	13	-	1	-	EA	020072-1	ENDBELL ASSY;LEFT;87K INT PH2
41	-	2	-	EA	A-0276-012	RING;BACK UP;NITRILE;.390 DIA	14	-	1	-	EA	020074-1	ENDBELL ASSY;RIGHT;87K INT PH2
42	-	2	-	EA	A-0275-012	O-RING;BUNA-N;70 DUR;NO.2-012	15	-	2	-	EA	020592-1	HP CYLINDER;87K INT;CARTRIDGE
43	-	2	-	EA	A-2409	SPRING COMPRESSION;P/N C0480-0	16	-	4	-	EA	020078-1	TIE ROD;LOW PRESS;87K INT PH2
44	-	2	-	EA	B-1702-1	PIN;FIRING	18	-	2	-	EA	201446-219-1	SEAL;POLYPAK;5 IN BORE;STD
45	-	4	-	EA	A-0114-16	SCREW;CAP;SKT;STL;10-32;1	19	-	16	-	EA	A-22757-1	WASHER;HRDNED;1.135 ID X 2 OD
							20	-	2	-	EA	A-00437-248	BACK UP RING;4-3/4 X 5 X 1/8
							21	-	2	-	EA	A-0264-112	SNAP RING;INVERTED
							22	-	2	-	EA	A-0275-248	O-RING;BUNA-N;70 DUR;NO.2-248
							23	-	2	-	EA	A-11275	SEAL;ROD;7/8 ID
							24	-	2	-	EA	A-15034-2	O-RING;METRIC;94MM ID;3MM CS
							25	-	8	-	EA	A-20347-1	CAP; VINYL
							26	-	2	-	EA	A-2838	GLAND;HIGH PRESSURE;3/8



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MATERIAL	SEE BOM			
DRAWN BY	STARTED	ENG	EST WEIGHT	MODELED IN
K.MADDEN	5/9/2006	J.HOPKINS	N/A	SOLIDWORKS
TITLE				
INTENSIFIER ASSY;PH 2				
REVISION	SCALE	BASE PART NUMBER	020070	
N	3:9			



**VIEW A-A**

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		MATERIAL SEE BOM			
DRAWN BY K.MADDEN	STARTED 5/9/2006	ENG J.HOPKINS	EST WEIGHT N/A	MODELED IN SOLIDWORKS	
TITLE <b>INTENSIFIER ASSY;PH 2</b>					
REVISION N	SCALE 1:1.5	BASE PART NUMBER	<b>020070</b>		4 OF 4