

BRK DISC
PDS A-7358

ITEM NO.	REQ'D	PART NO.	DESCRIPTION
1	1	C-7248	FLYWHEEL, 150 TON, 2-3-4" STROKE
		C-7247	FLYWHEEL, 150 TON, 5-6-7" STROKE
		C-7248	FLYWHEEL, 200 TON, 2-3-4" STROKE
		C-7259	FLYWHEEL, 200 TON, 5-6-7" STROKE
2	2		BALL BEARINGS. (SEE CHART)
3	1	B-7322	CLUTCH PLATE
4	1	B-7323	CLUTCH PRESSURE PLATE
5	1	B-1522	PISTON
6	8	A-7321-1	SPACER (SEE CHART FOR LENGTH)
7		B-7324	CLUTCH DISC (SEE CHART FOR QUANTITY)
8		68-09252-B2	FRICTION DISC (SEE CHART FOR QUANTITY)
9	8	A-7327-1	SPRING (SEE CHART FOR LENGTH)
10	1	B-7325-1	HUB GEAR (SEE CHART)
11	1	A-390-1	BRIDGE, AIR SWIVEL
12	1	A-129	SPINDLE
13	1	A-406	"U" CUP SEAL
14	1	A-373	BALL BEARING
15	1	A-236	BRASS FITTING 1/2 x 3/8
16	1	B-7326	FRICTION DISC, Ø HOLE
17	2	900098502	1/2-13 x 1/4" H.H.C.S.
18	8		ASSY BOLT 1/2-13 S.H.C.S. (SEE CHART FOR LENGTH)
19	10	980131402	1/2" MED. L'WASHERS
20	1	A-125	EXTERNAL RETAINER RING 5105-50
21	2	900139002	3/4-10 x 3/4" HOL. HD. SET SCREW
22	1		KEY, R.O.E. (SEE CHART)
23	2	A-173-A	O-RING SEAL
24	1	A-121	SNAP RING
25	1		CLUTCH HUB NUT (SEE CHART)
26	1	A-396	QUICK EXHAUST

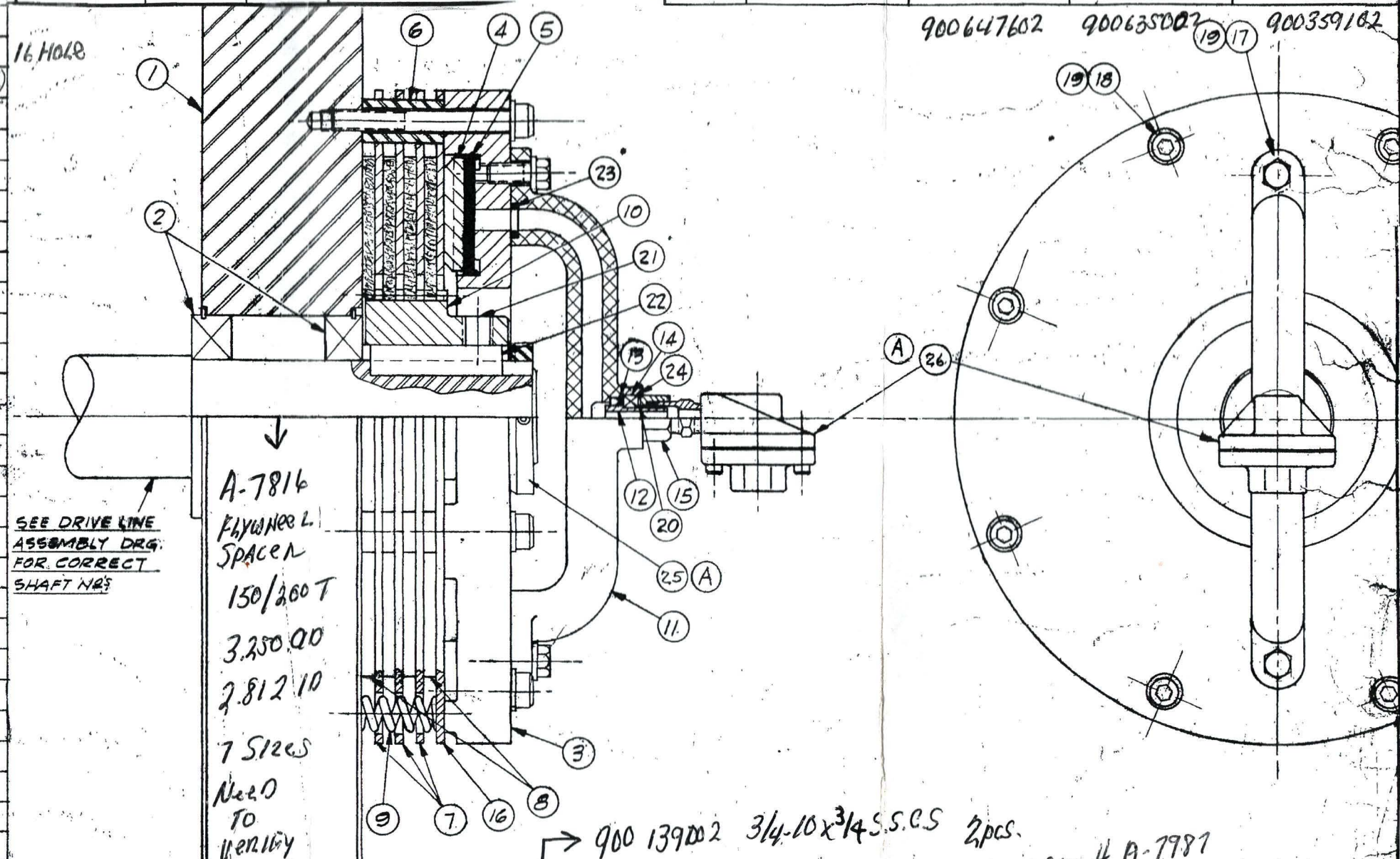
TORQUE BOLTS

80 PSI

55 T B.G. OLD STYLE 23x3 3.541 10.
70 T B.G. OLD STYLE 24x4 4.918 10
↑

PART NO.	A	FR. PL.	WHERE USED
A-7321-A-1	1.540	3	32,55,95,120,160 T. S/C FL. & B-G. 70 T. S/C B-G. & ALL PR. BR.
A-7321-A-2	2.050	4	150,200,250,300,400 T. S.S.
A-7321-A-3	2.560	5	70 T. S/C FL, 200 T. S/C B-G

A		USED ON		
ITEM NO.	DESCRIPTION	70-100T OBI-GAP-FLWL. 200T OBI-GAP-FLWL. BACK GEAR	ALL STRAIGHT SIDE PRESSES	ALL OTHER PRESSES (EXCEPT 30-45T PB)
6	SPACER	2 1/2" LONG A-7321-3	2" LONG A-7321-2	1 1/2" LONG A-7321-1
7	CLUTCH DISC	4 REQ'D	3 REQ'D	2 REQ'D
8	FRICTION DISC	5 REQ'D	4 REQ'D	3 REQ'D
9	SPRING	2 1/2" LONG A-7327-3	2" LONG A-7327-2	1 1/2" LONG 930921802
18	1/2" ASSY BOLT	5" LONG	4 1/2" LONG	4" LONG



ITEM	DESCRIPT.	USED ON	PART NO.
25	CLUTCH HUB NUT	70-100T-PB 30-70T-OBI-G BACK GEAR A-394 (U-15)	32T FAC A-7694 A-7624 A-7328 A-2544-A
2	BALL BRNG	30-100T-PB 30-70T-OBI-G BACK GEAR A-1456	5-4A

A		32T B.G. USED ON		
ITEM NO.	DESCRIPT.	50-70T OBI-GAP (BACK GEAR)	30T OBI-GAP (FLYWH.) 45-120T OBI-GAP (B.G.) 150-300T S.S.	50-70T OBI-GAP (FLYWH.) 150-300T OBI-GAP (B.G.) 400T S.S.
10	HUB GEAR	2 5/8" DIA. BORE B-7325-1	2 3/4" DIA. BORE B-7325-2	3 1/4" DIA. BORE B-7325-3
22	HUB KEY	1/2" SQ X 3 1/2" LG A-1581	3/4" SQ X 3" LG #3-81	1" X 3/4" X 3" LG 5-81
B		A-7624 NASA-394-B	BY L.K.	7-18-89
A		ADDED BY P.W.W.	7-1-89	

DRWG # A-7987
DRWG # A-7250 C-7320

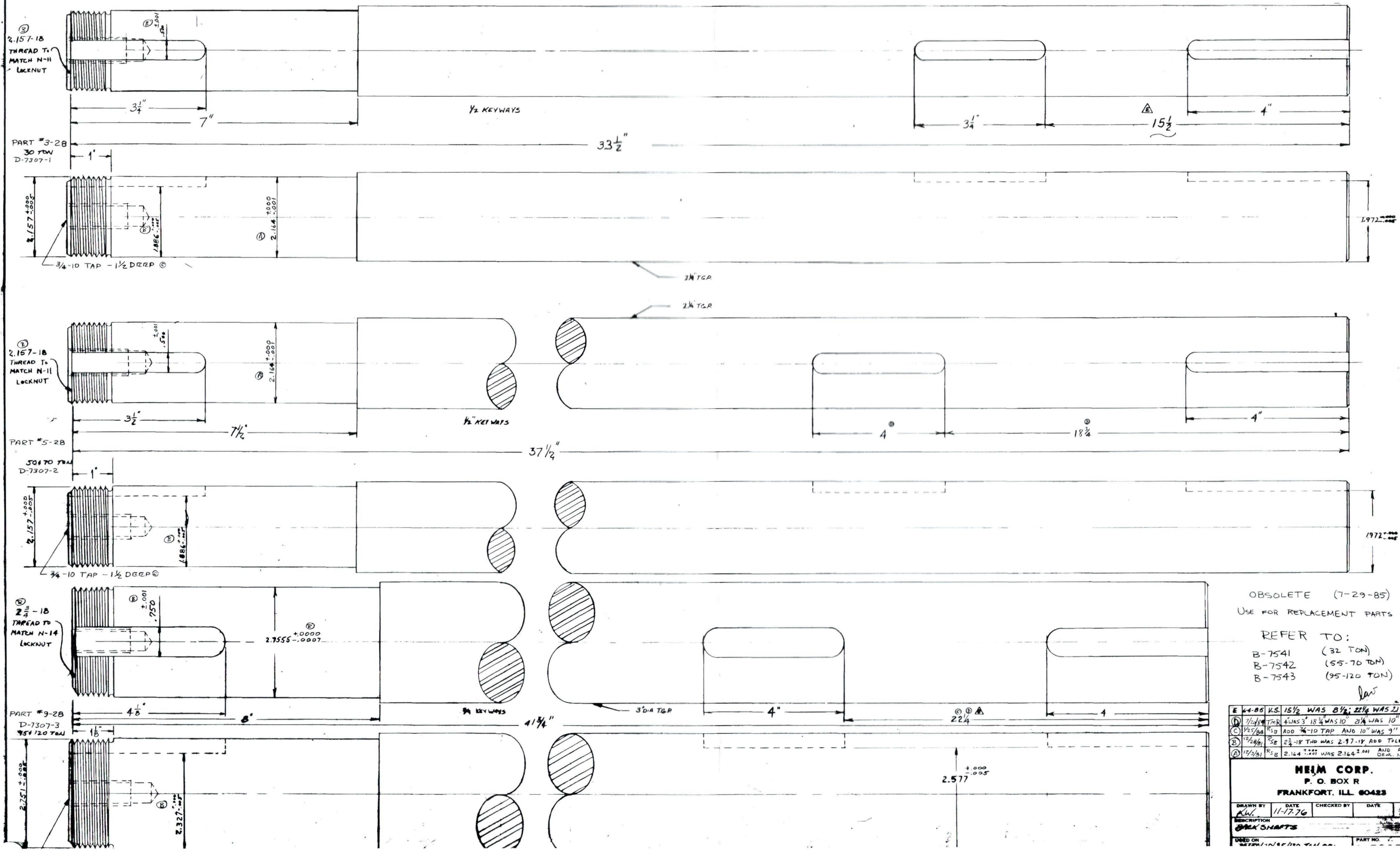
HEIM CORP.
P. O. BOX R
FRANKFORT, ILL. 60423

DRAWN BY: G.F.L. DATE: 3-12-74
CHECKED BY: BH DATE: 3-18-74

DESCRIPTION: CLUTCH ASSEMBLY

ALL O.B.T. GAP & S.S.

150/200 T P.B. D-2576



OBsolete (7-29-85)
USE FOR REPLACEMENT PARTS ONLY.

REFER TO:
B-7541 (32 TON)
B-7542 (55-70 TON)
B-7543 (95-120 TON)

E 4-85 K.S. 15 1/2 WAS 8 1/2; 22 1/4 WAS 2 1/4 00111	
① 7/24/84 TMR 4 WAS 3' 18 1/4 WAS 10' 2 1/4 WAS 10' E-6 00041	
② 1/25/84 RSB ADD 3/4-10 TAP AND 10" WAS 9" E-6 00046	
③ 12/28/81 RSB 2 3/4-18 THD WAS 2-17-18 ADD TOLER. E-6 00017	
④ 12/3/81 RSB 2.164 T. WAS 2.164 ±.001 AND ADD E-6 00008	

HEIM CORP.
P. O. BOX R
FRANKFORT, ILL. 60423

DRAWN BY K.W.	DATE 11-17-76	CHECKED BY	DATE	SCALE
DESCRIPTION SHAFTS				
USED ON FRANKFORT, ILL. 60423				

STEEL WELDMENT STARTED 1985

BY 1984
COULD BE A-1456
23x3 FLYWHEEL

32T-NH
55/70T-NH
95/120-NH

BEARINGS
A-7358
BOLT 3/4"
1" x 5.5"
900163202

BRASS PINS
860267202

860267902

900121102
1/2-13 x 13/4 LG
SOCKET SCREW

3-28
5-28 & 9-28
DRAWING # D-7307

1976
5-28-1 1985
NUT
850127702

9501430A2 32T
A-7868 55-120T

ALWAYS CHECK BS. 3 STYLES
2 1/4" 5-28 GETS B-1455
HELM
HELM
OMPI

BOLTS FOR BULL GEAR

32T 900227702
55/70T 900456102
95/120T 900651002
518-11 x 2 1/4
314-10 x 3 1/2
1-8 x 3 1/4

BILL OF MATERIAL, BACKGEAR TYPE PRESS

ITEM NO	DESCRIPTION	QTY.	30 TON	50 TON	70 TON	95 TON	120 TON
1	FRAME, Std. O.B.I.	1	3-1	5-1	7-1	9-1	10-1
	FRAME, Dp. Th't. O.B.I.	1	3T-1	5T-1	7T-1	9T-1	10T-1
	FRAME, Std. Gap	1	3G-1	5G-1	7G-1	9G-1	10G-1
	FRAME, Dp. Th't. Gap	1	3GT-1	5GT-1	7GT-1	9GT-1	10GT-1
2	RAM Assembly	1	3-2	5-2	5-2-1	9-2	9-2-1
3	CALIPER Assembly	1					
4	FLYWHEEL	1					
4A	BEARING, Flywheel	2	A-1456	A-1456	A-7328	A-7328-1	
5	BOLSTER PLATE	1	3-5	5-5	7-5	9-5	10-5
6	CONNECTING ROD	1	3-6	5-6	5-6-1	9-6	9-6-1
6A	CONN. ROD CAP	1	3-6A	5-6A	5-6A-1	9-6A	9-6A-1
6B	BUSHING, Split	1	3-6B	5-6B	5-6B-1	9-6B	9-6B-1
6C	PLUG	1	3-6C	3-6C-1	3-6C-2	3-6C-3	3-6C-4
6D	PLATE, Plug	1	3-6D	3-6D-1	3-6D-2	3-6D-3	3-6D-4
7	BUSHING, C'Shaft	2	3-7	5-7	5-7-1	9-7	9-7-1
7A	SEAL, Bushing	1	3-7-A	5-7A	5-7A-1		
11	AIR CLUTCH Assy.	1	5G-11	5G-11-1	5G-11-2	3-11-1	3-11-2
12	INCLINING SCREW	2	3-1277	5-1277	5-1277-1	5-1277-2	5-1277-3
13	ROTARY CAM, outer	1	3-13	5-13	5-13-1	5-13-2	5-13-3
14	ROTARY CAM, inner	2	3-14	5-14	5-14-1	5-14-2	5-14-3
15	SWITCH, Rot. Cam	3	30-400	30-400	30-400	30-400	30-400
16	CRANK SHAFT	1" Stroke	3-1621	7-1621	7-1621-1	10-1621	10-1621-1
		2" Stroke	3-1622	7-1622	7-1622-1	10-1622	10-1622-1
		3" Stroke	3-1623	7-1623	7-1623-1	10-1623	10-1623-1
		4" Stroke	3-1624	7-1624	7-1624-1	10-1624	10-1624-1
		5" Stroke	N.A.	7-1625	7-1625-1	10-1625	10-1625-1
		6" Stroke	N.A.	7-1626	7-1626-1	10-1626	10-1626-1
		7" Stroke	N.A.	N.A.	N.A.	10-1627	10-1627-1
		8" Stroke	N.A.	N.A.	N.A.	10-1628	10-1628-1
17	BRAKE, Disc.	1	C-7351-1A	C-7351-1A1	C-7351-1A2	C-7351-1B	C-7351-1B1
19	ADJUSTING SCREW	1	3-19	5-19	5-19-1	9-19	9-19-1
19A	SOCKET, Adj. Screw	1	3-19A	5-19A	5-19A-1	9-19A	9-19A-1
19B	NUT, Adj. Screw	1	3-19B	5-19B	5-19B-1	9-19B	9-19B-1
19C	CLAMP, Adj. Screw	1	3-19C	3-19C-1	3-19C-2	3-19C-3	3-19C-4
28	BACKSHAFT	1	3-28	5-28	5-28-1	9-28	9-28-1
36	GIB	2	3-36	5-36	5-36-1	9-36	9-36-1
36A	LINER, Gib	2	3-36A	5-36A	5-36A-1	9-36A	9-36A-1
42	MOTOR BRACKET	1	5G-42	5G-42-1	7G-42	7G-42-1	7G-42-2
43	GUARD, Flywheel	1	3G-43	5G-43	5G-43-1	9G-42	9G-42-1
43B	GUARD, Front	1	3-43-B	5-43B	5-43B-1	9-43B	9-43B-1
43C	GUARD, Cam	1	3-43-C	5-34C	5-43C-1	9-43C	9-43C-1
43D	GUARD, Bull Gear	1	3-43-D	5-43D	5-43D-1	9-43D	9-43D-1
45	MOTOR	1					
60	LEG, Floor R.L.	1	3-60 R-L	5-60 R-L	5-60 R-L-1	9-60 R-L	9-60 R-L-1
70	GEAR, Bull	1	3-70	5-70	5-70-1	9-70	9-70-1
78	BEARING, B.S.	2	B-1455	B-1455-1	B-1455-2	B-2542	B-2542-1
80	PINION, B.S.	1	B-1418	B-1418-1	B-1418-2	B-2518	B-2518-1
81	KEY, Clutch	1	A-1581	A-1581	A-1581	3-81	3-81
81A	KEY, Brake	1	A-1581	A-1581	A-1581	3-81	3-81
81B	KEY, Gb	2	3-81B	3-81B-1	3-81B-2	3-81B-3	3-81B-4
81C	KEY, Pinion	1	A-428	K0010830	A-2579	A-2579-1	

B/4
1998
New
TO
BRILL
HOLE
IN
BAR

32T
C-7345
55/70
C-1596
95/120
C-7347

95TAW
can be
B-2518
2 1/2 B

A-428
HELM CORP.
M-183-B

DRIVE DRAWING
32T B-7493
55/70T B-7494
95/120T C-7495

30T 50 70 95-120
A-1456 A-7981 A-2575

TECH. GR.	DATE	CHECKED BY	DATE	SCALE
5/20/76				
PUNCH PRESS, BACKGEAR				
USED ON				

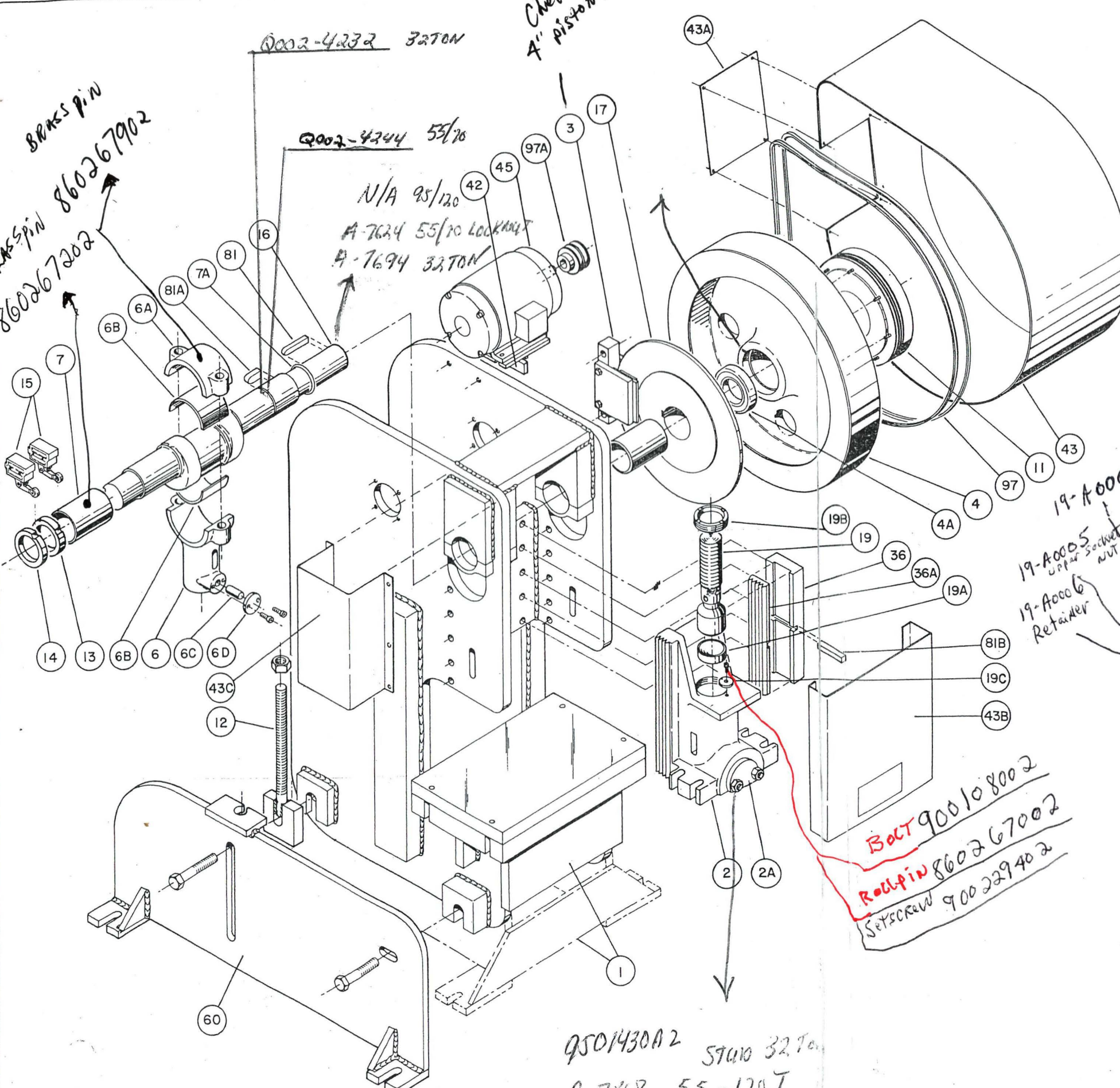
BRASS pin 860267202
BRASS pin 860267902

Q002-4232 32TON

Check if
4" piston?

Q002-4244 55/70

N/A 95/120
A-7624 55/10 LOCKWAT
A-7694 32TON



BILL OF MATERIAL, FLYWHEEL TYPE PRESS

ITEM NO.	DESCRIPTION	QTY.	30 TON	50 TON	70 TON	95 TON	120 TON
1	FRAME, Std. O.B.I.	1	3-1	5-1	7-1	9-1	10-1
	FRAME, Dp. Th't. O.B.I.	1	3T-1	5T-1	7T-1	9T-1	10T-1
	FRAME, Std. Gap	1	3G-1	5G-1	7G-1	9G-1	10G-1
	FRAME, Dp. Th't. Gap	1	3GT-1	5GT-1	7GT-1	9GT-1	10GT-1
2	RAM Assembly	1	3-2	5-2	5-2-1	9-2	9-2-1
2A	RAM CLAMP	1	3-2A	5-2A	5-2A-1	5-2A-2	5-2A-3
3	CALIPER Assembly	1					
4	FLYWHEEL	1	3-4	5-4	7-4	9-4	10-4
4A	BEARING, Flywheel	2	A-7380 5-4A			1740 635402	
5	BOLSTER PLATE	1	3-5	5-5	7-5	9-5	10-5
6	CONNECTING ROD	1	3-6	5-6	5-6-1	9-6	9-6-1
6A	CONN. ROD CAP	1	3-6A	5-6A	5-6A-1	9-6A	9-6A-1
6B	BUSHING, Split	1	3-6B	5-6-B	5-6-B-1	9-6B	9-6B-1
6C	PLUG	1	3-6C	3-6C-1	3-6C-2	3-6C-3	3-6C-4
6D	PLATE, Plug	1	3-6D	3-6D-1	3-6D-2	3-6D-3	3-6D-4
7	BUSHING, Shaft	2	3-7	5-7	5-7-1	9-7	9-7-1
7A	SEAL, Bushing	1	3-7-A	5-7A	5-7A-1	9-7A	9-7A-1
11	AIR CLUTCH Assy.	1	SEE DRG C-7320				
12	INCLINING SCREW	2	3-1277	5-1277	5-1277-1	5-1277-2	5-1277-3
13	ROTARY CAM, OUTER	1					
14	ROTARY CAM, INNER	2	B SOLE T E				
15	SWITCH, Rot. Cam	2					
16	CRANK-SHAFT	1" Stroke	3-1621	7-1621	7-1621-1	10-1621	10-1621-1
		2" Stroke	3-1622	7-1622	7-1622-1	10-1622	10-1622-1
		3" Stroke	3-1623	7-1623	7-1623-1	10-1623	10-1623-1
		4" Stroke	3-1624	7-1624	7-1624-1	10-1624	10-1624-1
		5" Stroke	N.A.	7-1625	7-1625-1	10-1625	10-1625-1
		6" Stroke	N.A.	7-1626	7-1626-1	10-1626	10-1626-1
		7" Stroke	N.A.	N.A.	N.A.	10-1627	10-1627-1
		8" Stroke	N.A.	N.A.	N.A.	10-1628	10-1628-1
17	BRAKE, Disc.	1	SEE DRG C-7350-A				
19	ADJUSTING SCREW	1	3-19	5-19	5-19	9-19	9-19-1
19A	SOCKET, Adj. Screw	1	3-19A	5-19A	5-19A-1	9-19A	9-19A-1
19B	NUT, Adj. Screw	1	3-19B	5-19B	5-19B-1	9-19B	9-19B-1
19C	BLOCK, Clamp	1	3-19C	3-19C-1	3-19C-2	3-19C-3	3-19C-4
36	GIB	2	3-36	5-36	5-36-1	9-36	9-36-1
36A	GIB LINER	2	3-36A	5-36A	5-36A-1	9-36A	9-36A-1
42	MOTOR BRACKET	1	5-42	5-42	9-42	9-42-1	9-42-2
43	GUARD, Flywheel	1	3-43	5-43	5-43-1	9-43	9-43-1
43A	ACCESS PLATE	1	3-43A	5-43A	5-43A-1	9-43A	9-43A-1
43B	GUARD, Front	1	3-43-B	5-43B	5-43B-1	9-43B	9-43B-1
43C	GUARD, Cam	1	3-43-C	5-43C	5-43C-1	9-43C	9-43C-1
45	MOTOR	1	3-45	5-45	7-45		
60	LEG, Floor R.L.	1	3-60 R-L	5-60 R-L	5-60R-L-1	9-60 R-L	9-60R-L-1
81	KEY, Clutch	1	3-81	5-81	5-81-1	9-81	9-81-1
81A	KEY, Brake	1	3-81A	5-81A	5-81A-1	9-81A	10-81A
81B	KEY, Gib	2	3-81B	3-81B-1	3-81B-2	3-81B-3	3-81B-4
97	V-BLET	1	3-97	5-97	7-97	9-97	10-97
97A	PULLEY	1	3-97-A	5-97A	7-97A	9-97A	10-97A

HEIM CORP.

P. O. BOX R

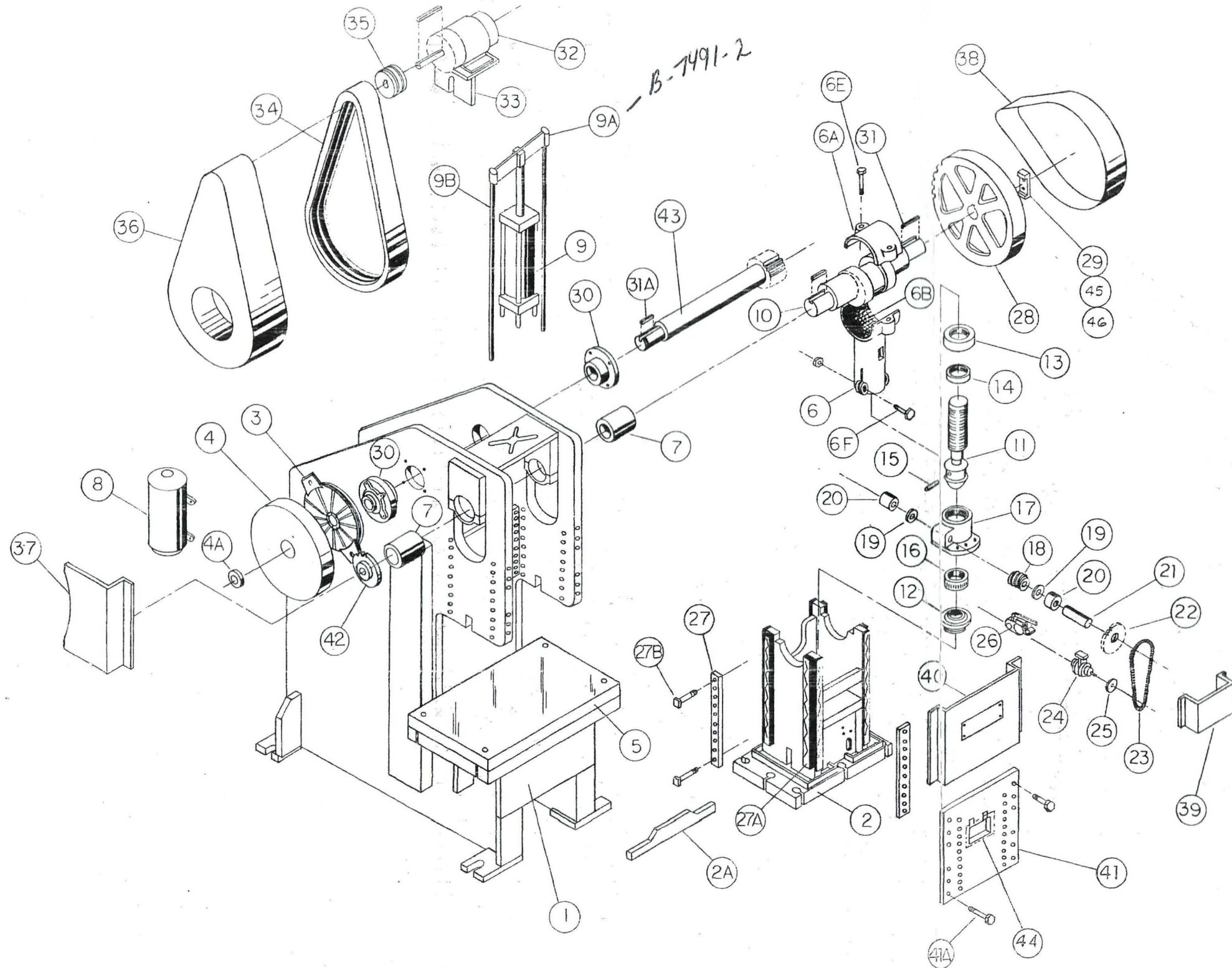
FRANKFORT, ILL. 60423

DRAWN BY TECH. GR. DATE 5/21/76 CHECKED BY DATE SCALE

DESCRIPTION PUNCH PRESS, FLYWHEEL

USED ON CATALOG PART NO. D-10,000-P

M-184-B



BILL OF MATERIAL BACKGEAR PRESSES

ITEM NO.	DESCRIPTION	QTY	250 TON	300 TON
1	FRAME - STD - O.B.S.	1	D-7568	D-7568
2	RAM ASSEMBLY	1	D-7951	D-7951
2A	KNOCKOUT BAR	1	A-7952	A-7952
3	HI PRO AIR CLUTCH & BRAKE	1	25-3	30-3
4	FLYWHEEL	1	C-7831-250G	C-7831-300G
4A	BEARING-FLYWHEEL	2	25-4A	30-4A
5	BOLTER PLATE	1	B-7456-1	B-7456-2
6	CONNECTING ROD	1	D-7950	D-7950
6A	CONN. ROD CAP	1	D-7950	D-7950
6B	CONN. ROD SPLIT BUSHING	1	B-8133	D-8133
6E	CAP BOLTS	2	25-6E	30-6E
6F	CONN ROD BOLTS	2	25-6F	30-6F
7	BUSHING - C SHAFT	2	B-7955	B-7955
8	SURGE TANK	1	A-201	A-201
9	COUNTERBALANCE CYL.	1	D-7841	D-7841
9A	CT' BAL. CROSSBAR	1	B-7491-2	B-7491-2
9B	CT' BAL. TIERODS	2	25-9B	30-9B
10	CRANKSHAFT	1	D-7950	D-7950
11	ADJUSTING SCREW	1	C-7661-2	C-7661-2
12	SOCKET - LOWER	1	C-7657	C-7657
13	NUT ADJ. SCREW	1	B-7659	B-7659
14	SOCKET - UPPER	1	B-7660	B-7660
15	ADJ. SCREW PLUG	1	A-7540	A-7540
16	WORM WHEEL	1	D-7667-1	D-7667-1
17	KNUCLE BOX	1	D-7667-2	D-7667-2
18	WORM	1	A-1448	A-1448
19	BALL BEARING	2	A-7243	A-7243
20	BEARING ADAPTER	2	A-7207B	A-7207B
21	WORM SHAFT	1	B-7959	B-7959
22	SPROCKET - WORM SHAFT	1	A-824-2	A-824-2
23	ADJUSTING CHAIN	1	A-166	A-166
24	AIR MOTOR	1	B-1493	B-1493
25	SPROCKET - AIR MOTOR	1	A-817	A-817
26	SAFETY VALVE	1	25-26	30-26
27	GIB BACKING PLATE	8	B-7461	B-7461
27A	GIB LINER	8	B-5027	B-5027
27B	GIB SCREWS	80	25-27B	30-27B
28	GEAR BULL	1	C-7552-2	C-7552-2
29	END PLATE	1	B-7956	B-7956
30	BEARING - B.S.	2	B-7825-A	B-7825-A
31	KEY - BULL GEAR	1	25-31	30-31
31A	KEY - CLUTCH & BRAKE	1	25-31A	30-31A
32	MOTOR	1	25-32	30-32
33	MOTOR BRACKET	1	42-24347-C2	
34	V-BELT	1	25-34	30-34
35	PULLEY	1	25-35	30-35
36	GUARD-FLYWHEEL	1	D-7889	D-7889
37	GUARD-PULSE WHEEL	1	C-7689-2	C-7689-2
38	GUARD-BULL GEAR	1	C-7983	C-7983
39	CHAIN GUARD FOR SLIDE IND.	1	B-7378	B-7378
40	GUARD-FRONT UPPER	1	B-7957	B-7957
41	GUARD-FRONT LOWER	1	C-7954	C-7954
41A	FRONT PLATE SCREWS	12	25-41A	30-41A
42	PULSE WHEEL	1	B-7958	B-7958
43	BACKSHAFT, PINION	1	C-7544-2	C-7544-2
44	DOOR, GUARD FRONT LOWER	1	A-7965	A-7965
45	3/4-10-27/16G HEX HD BOLT	2	90-01243-02	90-01243-02
46	3/4 SPLIT LOCK WASHER	2	98-01216-02	98-01216-02

16-93

→ K6012456 1 1/2" x 7 1/2"
SINGLE POINT

REV	DATE	37	DESCRIPTION	ECO NO.
HEIM P.O. BOX R, FRANKFORD, ILL. 60423 (815) 469-2335				
THIS DRAWING IS THE PROPERTY OF HEIM CO. AND MAY NOT BE COPIED REPRODUCED OR USED FOR DESIGN, MANUFACTURE OR SALE WITHOUT PRIOR PERMISSION FROM HEIM CO.		SCALE: — DATE: — DRAWN BY: LK 5-2369 CHECK BY: —		
FINISHED DIMENSION TOLERANCE: .015 OTHERWISE SPECIFIED		DESCRIPTION: SINGLE POINT BACKGEAR CBS		
FRACTION: 1/16 DECIMAL: .005 ANGLES: 1/4° 3/4°		USED ON: CATALOG		
ALL DIMENSIONS IN INCHES UNLESS OTHERWISE SPECIFIED		DRWG. NO.: ID-10006-P		

H1 PRO Roussele P-31323 STEEL WELDOMENTS
HEIM H-3592 " " "

3-2 RAM PARTS 0005.TIF PART NUMBER 32T-55-70 BATCH 04

ALL (C-7686 FRONT DOOR GUARD
MDS (A-7989 LATCHES FOR FRONT DOOR GUARD

32T B-7380-1
55/70 + B-7380-2 KNOCKOUT BAR
95/120 B-7380-3

9000-A BULL GEMS DRAW # C-8168
9800-A " " C-8167
D-9009 - CON RODS SEE DRAW C-7390-1 ASSY

ACB - FSA 00 820102502
CON ROD, MAIN + GIBS FSA 2 820102802

SEAL KITS FOR 32TON

PR2004MA01 PISTON KIT } RITTEN
R604MA0061 SEAL KIT }

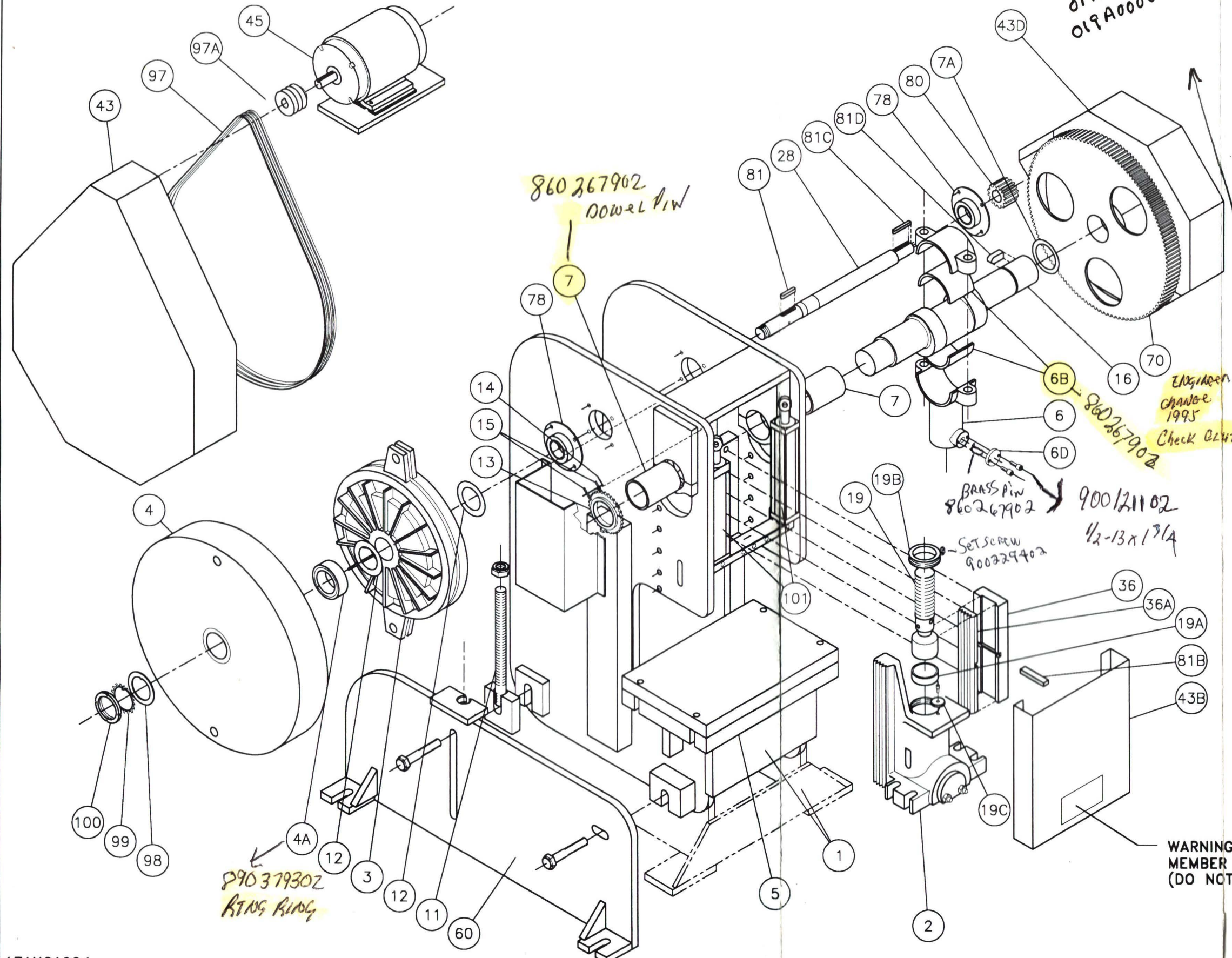
32 Ton OBI & OBS BACKGEAR TYPE PRESS

UPPER SKT New
019A00004648

BRASS
UPPER SKT Nut
019A00000706
019A000009376 Lower SKT

BILL OF MATERIALS

ITEM NO.	DESCRIPTION	QTY	32 TON
1	FRAME, Standard OBI	1	3-1
	FRAME, Deep Throat OBI	1	3T-1
	FRAME, Standard Gap	1	3G-1
	FRAME, Deep Throat Gap	1	3GT-1
2	SLIDE w/Clamp & Studs	1	3-2
3	HI PRO CLUTCH / BRAKE	1	KB-0100C
4	FLYWHEEL	1	C-7831-32
4A	BEARING, Flywheel	2	A-2537
5	BOLSTER PLATE	1	3-5 → B-7450
6	CONNECTING ROD w/Cap & Plug	1	3-6
6B	BUSHING, Split	1	3-6B → B-8035-1
6D	PLATE, Plug	1	3-6D → A-7489
7	BUSHING, Crankshaft	2	3-7 → B-7482
7A	SEAL, Bushing	1	3-7-A
11	INCLINING SCREW	2	3-1277
12	SPACER, O-RING	2	C-7645-100
13	PULSE WHEEL	1	B-7607
14	BRACKET	1	4224369C2
15	PROXIMITY SWITCHES	2	*
16	CRANK SHAFT (Stroke Length in Inches)	1	C-7545-1
		2	C-7545-2
		3	C-7545-3
		4	C-7545-4
19	ADJUSTING SCREW	1	3-19
19A	SOCKET, Adjusting Screw	1	3-19A
19B	NUT, Adjusting Screw	1	3-19B
19C	BLOCK, Clamp	1	3-19C
28	BACKSHAFT	1	B-7541-1
36	GIB, Backing Plate	2	3-36
36A	GIB LINER	2	3-36A
42	MOTOR BRACKET	1	3-42
43	GUARD, Flywheel	1	3-43
43A	ACCESS PLATE	1	3-43A
43B	GUARD, Front	1	3-43B
43C	GUARD, Cam	1	3-43-C
43D	GEAR GUARD	1	*
45	MOTOR	1	3 HP
60	LEG, Floor R-L	1	3-60 R-L
70	GEAR, Bull	1	3-70
78	BEARING, Backshaft	1	B-1455
80	PINION, Backshaft	1	B-1418-A-1
81	KEY, Clutch & Brake Combo	1	5-81
81B	KEY, Gib	2	3-81B
81C	KEY, Pinion	1	A-428
81D	KEY, Bull Gear	1	3-81D → A-8139
97	V-BELT	3	*
97A	PULLEY	1	*
98	LOCK NUT SPACER	1	*
99	LOCKING WASHER	1	F-0420 W10
100	LOCK NUT	1	F-0410 W10
101	COUNTERBALANCE CYL.	2	A-7444

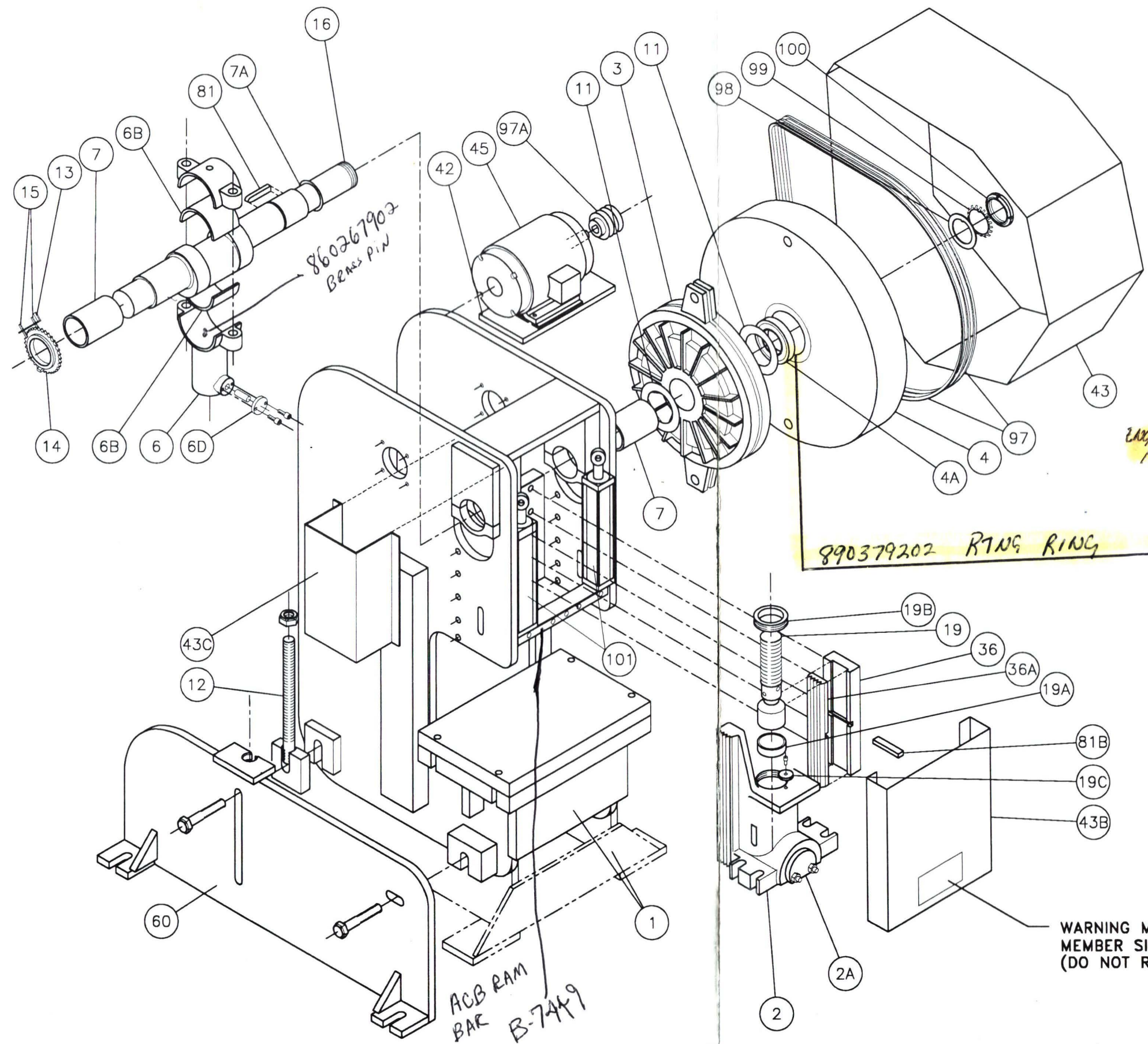


WARNING MOVING
MEMBER SIGN
(DO NOT REMOVE)

* CONSULT FACTORY

Doesn't come w/ clevis or pins → C-1444 DRAWING ASSY

32 Ton OBI & OBS FLYWHEEL TYPE PRESS



BILL OF MATERIALS

ITEM NO.	DESCRIPTION	QTY	32 TON
1	FRAME, Standard OBI	1	3-1
	FRAME, Deep Throat OBI	1	3T-1
	FRAME, Standard OBS	1	3G-1
	FRAME, Deep Throat OBS	1	3GT-1
2	SLIDE W/CLAMP & STUDS	1	3-2
2A	SLIDE CLAMP	1	5-2A
3	HI PRO CLUTCH / BRAKE	1	KB-0400C
4	FLYWHEEL	1	3-4
4A	BEARING, Flywheel	2	A-7690
5	BOLSTER PLATE	1	3-5
6	CONNECTING ROD W/CAP & PLUG	1	3-6
6B	BUSHING, Split	1	3-6B
6D	PLATE, Plug	1	3-6D
7	BUSHING, Crankshaft	2	3-7
7A	SEAL, Bushing	1	3-7-A
11	SPACER, O-RING	2	C-7645-400
12	INCLINING SCREW	2	3-1277
13	BRACKET	1	4224369C2
14	PULSE WHEEL	1	B-7607
15	PROXIMITY SWITCHES	2	*
16	CRANK SHAFT (Stroke Length in Inches)	1	C-7545-1
		2	C-7545-2
		3	C-7545-3
		4	C-7545-4
19	ADJUSTING SCREW	1	3-19
19A	SOCKET, Adjusting Screw	1	3-19A
19B	NUT, Adjusting Screw	1	3-19B
19C	BLOCK, Clamp	1	3-19C
36	GIB, Backing Plate	2	3-36
36A	GIB LINER	2	3-36A
42	MOTOR BRACKET	1	3-42
43	GUARD, Flywheel	1	3-43
43A	ACCESS PLATE	1	3-43A
43B	GUARD, Front	1	3-43B
43C	GUARD, Cam	1	3-43-C
45	MOTOR	1	3HP
60	LEG, Floor R-L	1	3-60R-L
81	KEY, Clutch / Brake	2	K-0051232
81B	KEY, Gib	2	3-81B
97	V-BELT	3	*
97A	PULLEY	1	*
98	LOCKING NUT SPACER	1	*
99	LOCKING WASHER	1	F0420W13
100	LOCKING NUT	1	F0410N13
101	COUNTERBALANCE CYL.	2	C-7444

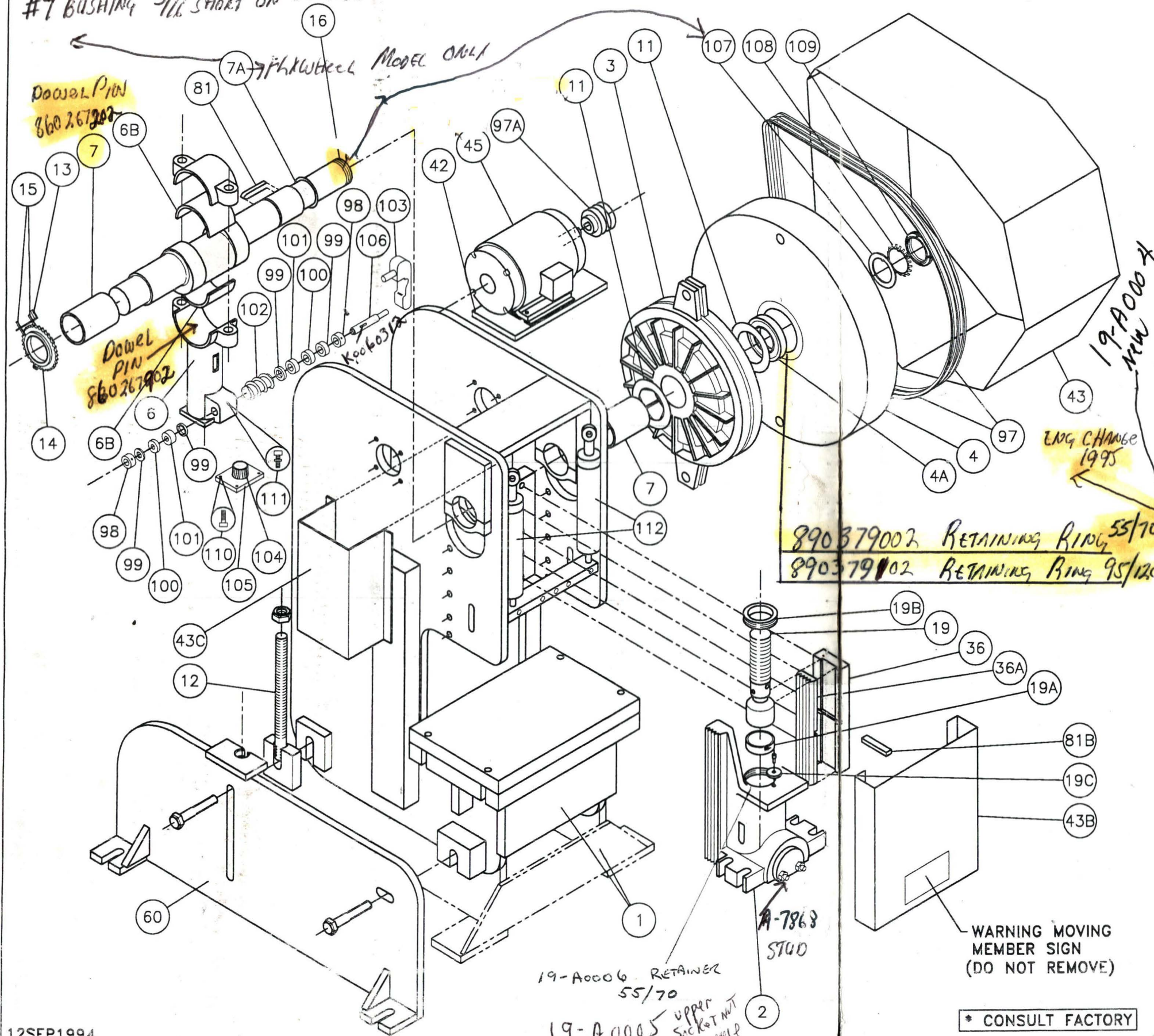
* CONSULT FACTORY P0056001

→ C-7444 DRAWING ASSY

* ALWAYS VERIFY OMPI CLUTCH
Flywheel
PIN DIA DRAW CALL FOR 1.811 DIA
STANDARD KB-0400 PINS ARE 1.732
" " KB-0500 PINS ARE 1.811

55 to 120 Ton OBI & OBS FLYWHEEL TYPE PRESSES

#7 BUSHING 3/16" SHORT ON OUTSIDE EDGE



BILL OF MATERIALS

ITEM NO.	DESCRIPTION	QTY	55 TON	70 TON	95 TON	120 TON
1	FRAME, Standard OBI	1	5-1	7-1	D-7570-1	12-1
	FRAME, Deep Throat OBI	1	5T-1	7T-1	9T-1	12T-1
	FRAME, Standard OBS	1	5G-1	7G-1	9G-1	12G-1
	FRAME, Deep Throat OBS	1	5GT-1	7GT-1	9GT-1	12GT-1
2	Slide w/clamp & studs	1	5-2	5-2	9-2	9-2
3	HI PRO CLUTCH / BRAKE	1	KB0500C	KB0500C	KB1200C	KB1200C
4	FLYWHEEL D-7411	1	5-4	7-4	C-7831-95F	C-7831-120F
4A	BEARING, Flywheel	2	5-4A	5-4A	740635402	740635402
5	BOLSTER PLATE	1	5-5	7-5	9-5	10-5
6	CONN. ROD w/CAP	1	5-6	5-6	9-6	9-6
6B	BUSHING, Split	1	5-6-B	5-6-B	9-6B	9-6B
6D	PLATE, Plug	1	3-6D	3-6D	3-6D	3-6D
7	BUSHING, C'Shaft	2	5-7	5-7	9-7	9-7
7A	SEAL, Bushing	1	5-7A	5-7A	5-7A	5-7A
11	SPACER, O-RING Clutch	1	C-7645-500	C-7645-500	45-80015	45-80015
11A	SPACER, O-RING BRAKE	1	C-7645-500	C-7645-500	45-80014	45-80014
12	INCLINING SCREW	2	5-1277	5-1277	9-1277	9-1277
13	BRACKET Prox Switch	1	4224369C2 ALL MODELS			
14	PULSE WHEEL	1	B-7607 ALL MODELS			
15	PROX SWITCHES	2	7720006			
16	CRANK SHAFT (Stroke Length in inches)	1	C-7546-1	C-7546-1	C-7830-1	C-7830-1
		2	C-7546-2	C-7546-2	C-7830-2	C-7830-2
		3	C-7546-3	C-7546-3	C-7830-3	C-7830-3
		4	C-7546-4	C-7546-4	C-7830-4	C-7830-4
		5	C-7546-5	C-7546-5	C-7830-5	C-7830-5
		6	C-7546-6	C-7546-6	C-7830-6	C-7830-6
		7	NA	NA	C-7830-7	C-7830-7
		8	NA	NA	C-7830-8	C-7830-8
19	ADJUSTING SCREW	1	5-19	5-19	9-19	9-19
19A	SOCKET, Adj. Screw	1	5-19A	5-19A	9-19A	9-19A
19B	NUT, Adj. Screw	1	5-19B	5-19B	9-19B	9-19B
19C	BLOCK, Clamp	1	3-19C	3-19C	3-19C	3-19C
36	GIB, BACKING PLATE	2	5-36	5-36	9-36	9-36
36A	GIB LINER	2	5-36A	5-36A	9-36A	9-36A
42	MOTOR BRACKET	1	5-42	5-42	9-42	9-42
43	GUARD, Flywheel	1	5-43	5-43	D-7836	D-7836
43A	ACCESS PLATE	1	5-43A	5-43A	9-43A	9-43A
43B	GUARD, Front	1	5-43B	5-43B	9-43B	9-43B
43C	GUARD, Cam	1	5-43C	5-43C	9-43C	9-43C
45	MOTOR	1	5 HP	7.5 HP	10 HP	10 HP
60	LEG, Floor R-L	1	5-60 R-L	5-60 R-L	9-60 R-L	9-60 R-L
81	KEY, Clutch / Brake	2	K-0031648			
81B	KEY, Gib	2	3-81B	3-81B	3-81B	3-81B
97	V-BELT	3	*	*	*	*
97A	PULLEY	1	*	*	*	*
98	SHAFT COLLAR	1	A-389 ALL MODELS			
99	WASHER	1	3088A513 ALL MODELS			
100	BEARING NUT	1	A-625 ALL MODELS			
101	BEARING	1	A-626 BEARING			
102	WORM	1	A-339-A ALL MODELS			
103	AIR RATCHET	1	*	*	*	*
104	BLOCK	1	D-5990-7	D-5990-7	D-7105-11	D-7105-11
105	WORM GEAR	1	D-5990-3	D-5990-3	D-7105-9	D-7105-9
106	SHAFT	1	D-5990-9	D-5990-9	D-5990-9	D-5990-9
107	LOCKING NUT SPACER	1	K91518	*	* K91522	* K91522
108	LOCKING NUT WASHER	1	F-042018	*	F-042022	F-042022
109	LOCKING NUT	1	F-042018	*	F-041022	F-041022
110	BOLT	4	90009802	1/2-13 X 1 1/2	5/8-11 X 2 1/2	5/8-11 X 2 1/2
111	BRASS BOLT & TRIM NUT	1 ea.	900436402	1/2-13 X 1 1/2	5/8-11 X 2 1/2	5/8-11 X 2 1/2
112	AIR COUNTERBALANCE CYLINDERS	2	SEE AIR COU			

* CONSULT FACTORY

19-A0006 RETAINER 55/70

19-A0005 UPPER SOCKET NUT NEW STYLE

A-7868 STUD

WARNING MOVING MEMBER SIGN (DO NOT REMOVE)

Draw # B-7450 BEFORE 1995 Need to DRILL HOLE IN RAM

-A 6MPL CLUTCH ON OUTSIDE C-7830 CLUTCH ON INSIDE

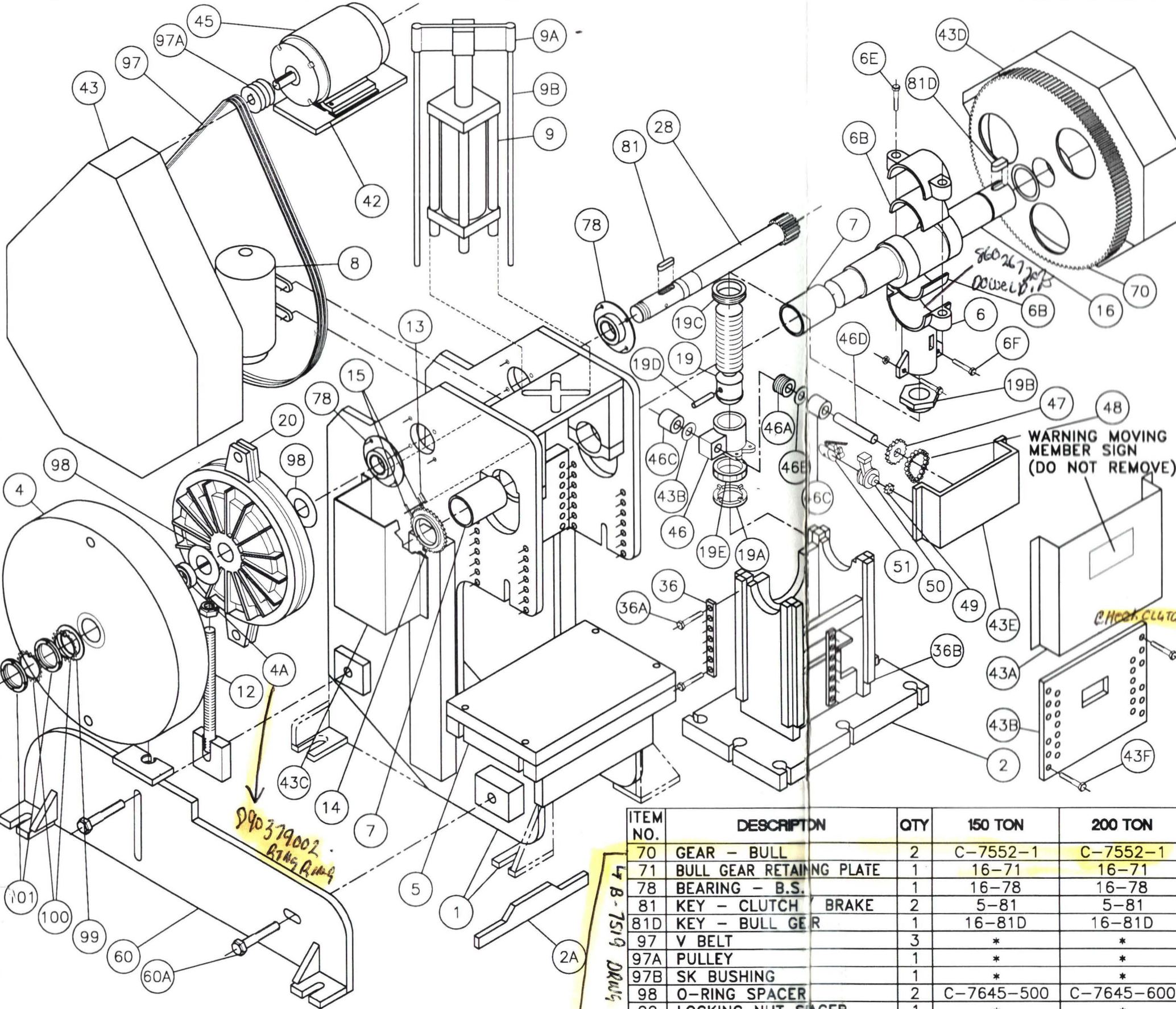
90012102

C-7830

D-7830-B

150 & 200 Ton OBI & OBS BACKGEAR TYPE PRESSES

BILL OF MATERIALS



ITEM NO.	DESCRIPTION	QTY	150 TON	200 TON
1	FRAME - STD - OBI	1	160-1	200-1
	FRAME - STD - OBS	1	16G-1	200G-1
2	SLIDE ASSEMBLY	1	16-2	16-2
2A	KNOCKOUT BAR	1	16-2A	16-2A
3	HI-PRO CLUTCH & BRAKE	1	KB-0500C	KB-0600C
4	FLYWHEEL	1	D-7812-5*	D-7812-7*
4A	BEARING - FLYWHEEL	2	5-4A	5-4A
5	BOLSTER PLATE	1	16-5	20-5
6	CONNECTING ROD W/CAP	1	15-6	15-6
6B	BEARING - SPLIT	1	16-6B	16-6B
6E	CAP BOLTS	2	900120502	900120502
6F	CONNECTING ROD - BOLTS	2	900139202	900139202
7	BUSHING - CRANK SHAFT	2	16-7	16-7
8	SURGE TANK	1	A-201	A-201
9	COUNTERBALANCE CYLINDER	1	D-7841*	D-7841*
9A	COUNTERBALANCE CROSSBAR	1	B-7491-1	
9B	COUNTERBALANCE TIERODS	2	16-9B	16-9B
12	INCLINING SCREW	2	16-1277	16-1277
13	BRACKET - PROXIMITY SWITCHES	1	4224369C2	4224369C2
14	PULSE WHEEL		B-7607	B-7607
15	PROXIMITY SWITCHES	2	*	*
16	CRANKSHAFT (Stroke Length in Inches)	2	15-1622	15-1622
		4	15-1624	15-1624
		6	15-1626	15-1626
		8	15-1628	15-1628
		10	15-1630	15-1630
		12	15-1632	15-1632
19	ADJUSTING SCREW (Stroke Length in Inches)	2,4,6	B-7379-1A	
		8,10,12	B-7379-2A	
19A	SOCKET - LOWER	1	10032A	10032A
19B	NUT - ADJUSTING SCREW	1	10034A	10034A
19C	SOCKET - UPPER	1	10033A	10033A
19D	DRIVE PIN	1	16-19D	16-19D
19E	WORM WHEEL	1	10033	10033
28	BACKSHAFT - PINION	1	C-7544-1	C-7544-1
36	GIB PLATE	8	16-36	16-36
36A	GIB SCREWS	80	*	*
36B	GIB BRONZE	8	16-36B	16-36B
42	BRACKET - MOTOR	1	16G-42	16G-42
43	GUARD - FLYWHEEL	1	16-43	16-43
43A	GUARD - FRONT - UPPER	1	16-43A	16-43A
43B	GUARD - FRONT - LOWER	1	16-43B	16-43B
43C	GUARD - CAM	1	16-43C	16-43C
43D	GUARD - BULL GEAR	1	16-43D	16-43D
43E	GUARD - AIR MOTOR	1	16-43E	16-43E
43F	FRONT PLATE SCREWS	12	900139302	900139302
45	MOTOR	1	15HP	20HP
46	NUCKLE BOX ASSEMBLY	1	10036	10036
46A	WORM GEAR	1	A-1448	A-1448
46B	BALL BEARING	2	A-7243	A-7243
46C	BEARING ADAPTER	2	A-7207	A-7207
46D	WORM SHAFT	1	A-1449	A-1449
47	SPROCKET - WORM SHAFT	1	A-824	A-824
48	ADJUSTING CHAIN	1	A-166	A-166
49	SPROCKET - AIR MOTOR	1	A-1496	A-1496
50	AIR MOTOR	1	840667802	840667802
51	SAFETY VALVE	1	A-229	A-229
60	LEG	2	16-60	16-60
60A	LEG SCREWS	4	*	*

17AUG1994

* CONSULT FACTORY

ITEM NO.	DESCRIPTION	QTY	150 TON	200 TON
70	GEAR - BULL	2	C-7552-1	C-7552-1
71	BULL GEAR RETAINING PLATE	1	16-71	16-71
78	BEARING - B.S.	1	16-78	16-78
81	KEY - CLUTCH BRAKE	2	5-81	5-81
81D	KEY - BULL GEAR	1	16-81D	16-81D
97	V BELT	3	*	*
97A	PULLEY	1	*	*
97B	SK BUSHING	1	*	*
98	O-RING SPACER	2	C-7645-500	C-7645-600
99	LOCKING NUT SPACER	1	*	*
100	LOCKING WASHER	2	F0430-18	*
101	LOCKING NUT	2	F0410A-18	*

VERIFY KEYWAY SIZE

F-5

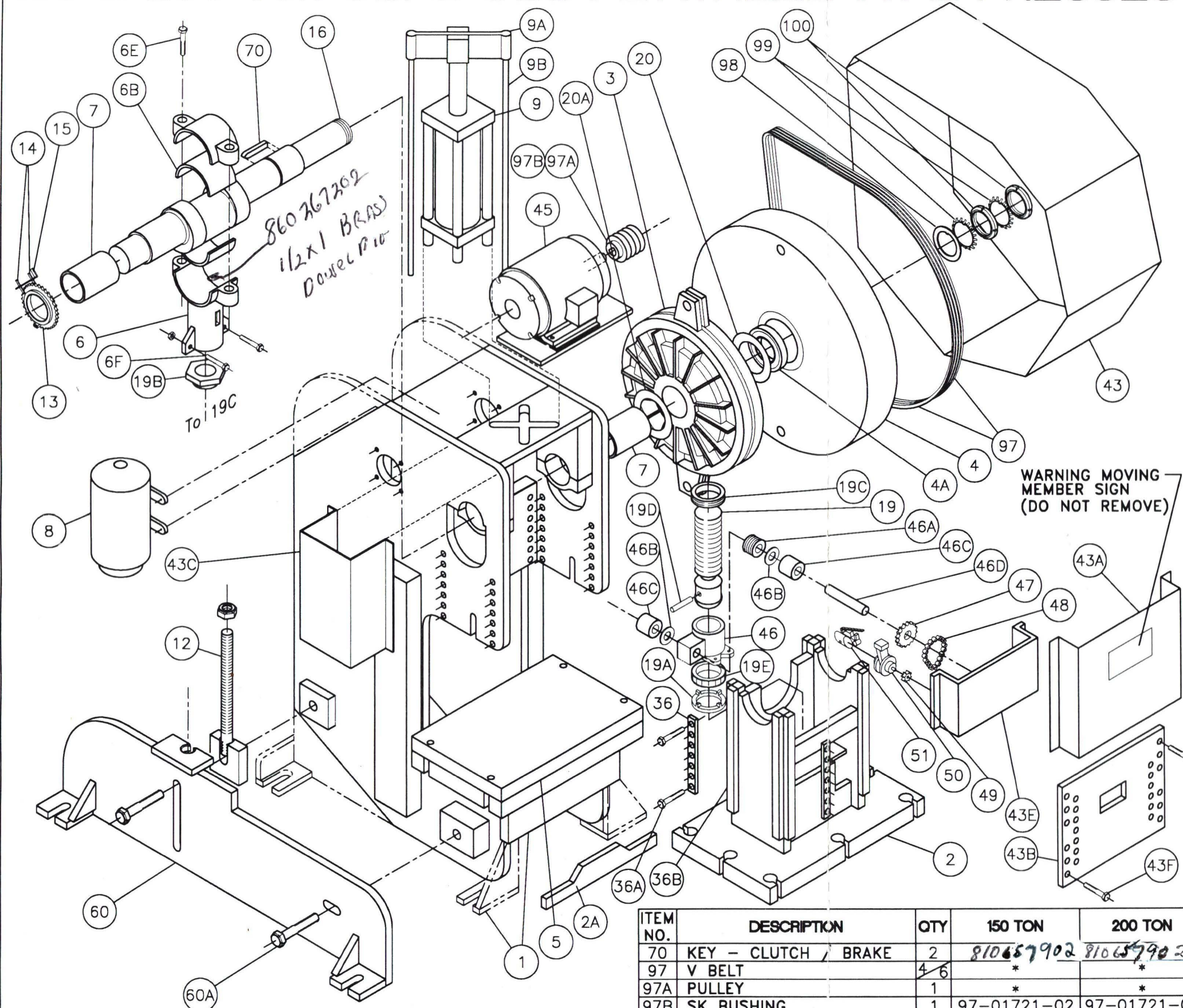
C-7496-1

C-7548

DRAWING B-5027

D-7889 + D-7890

150 & 200 Ton OBI & OBS FLYWHEEL TYPE PRESSES



BILL OF MATERIALS

ITEM NO.	DESCRIPTION	QTY	150 TON	200 TON
1	FRAME - STD - OBI	1	160-1	200-1
	FRAME - STD - OBS		16G-1	200G-1
2	RAM ASSEMBLY	1	16-2	16-2
2A	KNOCKOUT BAR	1	16-2A	16-2A
3	HI-PRO CLUTCH & BRAKE	1	HT 2150-6	HT 2150-6
4	FLYWHEEL	1	*	*
4A	BEARING - FLYWHEEL	2	740635402	
5	BOLSTER PLATE	1	16-5	20-5
6	CONNECTING ROD W/CAP	1	15-6	15-6
6B	BEARING - SPLIT	1	16-6B	16-6B
6E	CAP BOLTS	2	900120502	900120502
6F	CONNECTING ROD - BOLTS	2	900139202	900139202
7	BUSHING - C SHAFT	2	16-7	16-7
8	SURGE TANK	1	A-201	A-201
9	COUNTERBALANCE CYLINDER	1	D-7841*	D-7841*
9A	COUNTERBALANCE CROSSBAR	1	B-7491-1	
9B	COUNTERBALANCE TIERODS	2	16-9B	16-9B
12	INCLINING SCREW	2	16-1277	16-1277
13	PULSE WHEEL	1	B-7607	B-7607
14	PROX SWITCHES	2	*	*
15	BRACKET - PROX SWITCHES	1	4224369C2	4224369C2
16	CRANKSHAFT (Stroke Length in Inches)	1	2 C-7548-2 C-7548-2 4 C-7548-4 C-7548-4 6 C-7548-6 C-7548-6 8 C-7548-8 C-7548-8 10 C-7548-10 C-7548-10 12 C-7548-12 C-7548-12	2 C-7548-2 C-7548-2 4 C-7548-4 C-7548-4 6 C-7548-6 C-7548-6 8 C-7548-8 C-7548-8 10 C-7548-10 C-7548-10 12 C-7548-12 C-7548-12
19	ADJUSTING SCREW (Stroke Length in Inches)	1	2,4,6 B-7379-1A B-7379-1A 8,10,12 B-7379-2A B-7379-2A	2,4,6 B-7379-1A B-7379-1A 8,10,12 B-7379-2A B-7379-2A
19A	SOCKET - LOWER	1	10032A	10032A
19B	NUT - ADJ SCREW	1	10034A	10034A
19C	SOCKET - UPPER	1	10033A	10033A
19D	DRIVE PIN A-7540	1	16-19D	16-19D
19E	WORM WHEEL	1	10033	10033
20	O-RING SPACER, CLUTCH	1	45-B0013	45-B0013
20A	O-RING SPACER, BRAKE	1	45-B005	45-B005
36	GIB PLATE	8	16-36	16-36
36A	GIB SCREWS	80	900139302	900139302
36B	GIB BRONZE 900649602	8	16-36B	16-36B
42	BRACKET - MOTOR	1	16G-42	16G-42
43	GUARD - FLYWHEEL	1	16-43	16-43
43A	GUARD - FRONT - UPPER	1	16-43A	16-43A
43B	GUARD - FRONT - LOWER	1	16-43B	16-43B
43C	GUARD - CAM	1	16-43C	16-43C
43E	GUARD - AIR MOTOR	1	16-43E	16-43E
43F	FRONT PLATE SCREWS	12	900139302	900139302
45	MOTOR	1	15HP	20HP
46	KNUCKLE BOX	1	10036	10036
46A	WORM	1	A-1448	A-1448
46B	BALL BEARING	2	A-7243	A-7243
46C	BEARING ADAPTER	2	A-7207	A-7207
46D	WORM SHAFT	1	A-1449	A-1449
47	SPROCKET - WORM SHAFT	1	A-824	A-824
48	ADJUSTING CHAIN NO. 41	1	A-166	A-166
49	SPROCKET - AIR MOTOR	1	A-1496	A-1496
50	AIR MOTOR 6AM	1	840667802	840667802
51	SAFETY VALVE	1	A-229	A-229
60	LEG	2	16-60	16-60
60A	LEG SCREWS	4	*	*

17AUG1994

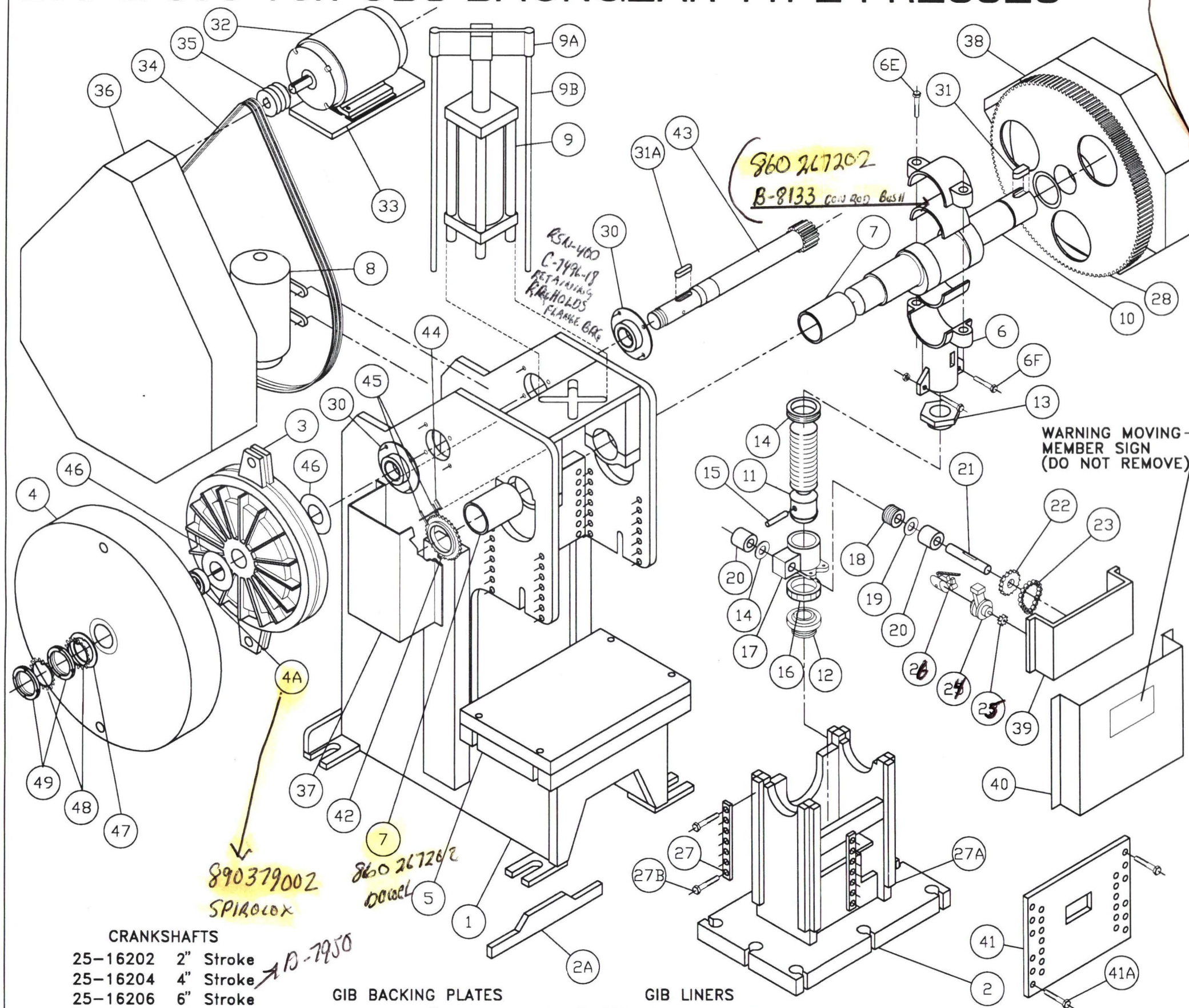
* CONSULT FACTORY

ITEM NO.	DESCRIPTION	QTY	150 TON	200 TON
70	KEY - CLUTCH / BRAKE	2	810657902	810657902
97	V BELT	4/6	*	*
97A	PULLEY	1	*	*
97B	SK BUSHING	1	97-01721-02	97-01721-02
98	LOCKING NUT SPACER	1	*	*
99	LOCKING WASHER	2	F-0420W22	F-0420W22
100	LOCKING NUT	2	F-0418W22	F-0418W22

00 24277C2

250 & 300 Ton OBS BACKGEAR TYPE PRESSES

16902 Cap Drive, Can Red 16905 Cap Drive, Cap



BILL OF MATERIALS

ITEM NO.	DESCRIPTION	QTY	250 TON	300 TON
1	FRAME - STD - OBS	1	0124336D2	0124336D2
2	SLIDE ASSEMBLY	1	D-7951	D-7951
2A	KNOCKOUT BAR	1	A-7952	A-7952
3	HI-PRO CLUTCH & BRAKE	1	KB-0800C	KB-0800C
4	FLYWHEEL	1	C-7831	C-7831
4A	BEARING - FLYWHEEL	2	5-4A	5-4A
5	BOLSTER PLATE	1	*	*
6	CONNECTING ROD W/CAP	1	25-6	25-6
6E	CAP BOLTS	2	900120502	900120502
6F	CONNECTING ROD - BOLTS	2	900139202	900139202
7	BUSHING - CRANK SHAFT	2	B-7955	B-7955
8	SURGE TANK	1	A-201	A-201
9	COUNTERBALANCE CYLINDER	1	D-7841	D-7841
9A	COUNTERBALANCE CROSSBAR	1	B-7491-2	B-7491-2
9B	COUNTERBALANCE TIERODS	2	*	*
10	CRANKSHAFT	1	SEE NOTE	SEE NOTE
11	ADJUSTING SCREW	1	C-7661-2	C-7661-2
12	SOCKET - LOWER	1	C-7657	C-7657
13	NUT - ADJUSTING SCREW	1	B-7659	B-7659
14	SOCKET - UPPER	1	B-7660	B-7660
15	ADJUSTING SCREW PLUG	1	A-7540	A-7540
16	WORM WHEEL	1	D-7677-1	D-7677-1
17	KNUCKLE BOX	1	D-7677-2	D-7677-2
18	WORM GEAR	1	A-1448	A-1448
19	BALL BEARING	2	A-7243	A-7243
20	BEARING ADAPTER	2	A-7207B	A-7207B
21	WORM SHAFT	1	B-7959	B-7959
22	SPROCKET - WORM SHAFT	1	A-824-2	A-824-2
23	ADJUSTING CHAIN	1	A-166	A-166
24	AIR MOTOR	1	840667802	840667802
25	SPROCKET - AIR MOTOR	1	A-817	A-817
26	SAFETY VALVE	1	A-229	A-229
27	GIB BACKING PLATE	8	SEE NOTE	SEE NOTE
27A	GIB LINER	8	SEE NOTE	SEE NOTE
27B	GIB SCREWS	80	900121302	900121302
28	GEAR - BULL	1	C-7552-2	C-7552-2
29	END PLATE	1	B-7956	B-7956
30	BEARING - B.S.	2	*	*
31	KEY - BULL GEAR	1	K0012456	K0012456
31A	KEY - CLUTCH / BRAKE	1	K0031640	K0031640
32	MOTOR	1	840308402	840308302
33	BRACKET - MOTOR	1	4224347C2	4224347C2
34	V BELT	3	970171602	970170302
35	PULLEY	1	970171102	970171102
36	GUARD - FLYWHEEL	1	D-7889*	D-7889*
37	GUARD - PULSE WHEEL	1	C-7689-2*	C-7689-2*
38	GUARD - BULL GEAR	1	C-7983	C-7983
39	CHAIN GUARD FOR CHAIN IND.	1	B-7378	B-7378
40	GUARD - FRONT - UPPER	1	B-7957	B-7957
41	GUARD - FRONT - LOWER	1	C-7954	C-7954
41A	FRONT PLATE SCREWS	12	900139302	900139302
42	PULSE WHEEL	1	B-7958	B-7958
43	BACKSHAFT - PINION	1	C-7544-2	C-7544-2
44	BRACKET - PROXIMITY SWITCHES	1	4224369C2	4224369C2
45	PROXIMITY SWITCHES	2	*	*
46	ADAPTER - O RING	2	C-7645-800	C-7645-800
47	LOCKING NUT SPACER	1	*	*
48	LOCKING WASHER	2	*	*
49	LOCK NUT	2	F0440118	*

* CONSULT FACTORY

CRANKSHAFTS

25-16202	2" Stroke	D-7950
25-16204	4" Stroke	
25-16206	6" Stroke	
25-16208	8" Stroke	
25-16210	10" Stroke	

GIB BACKING PLATES

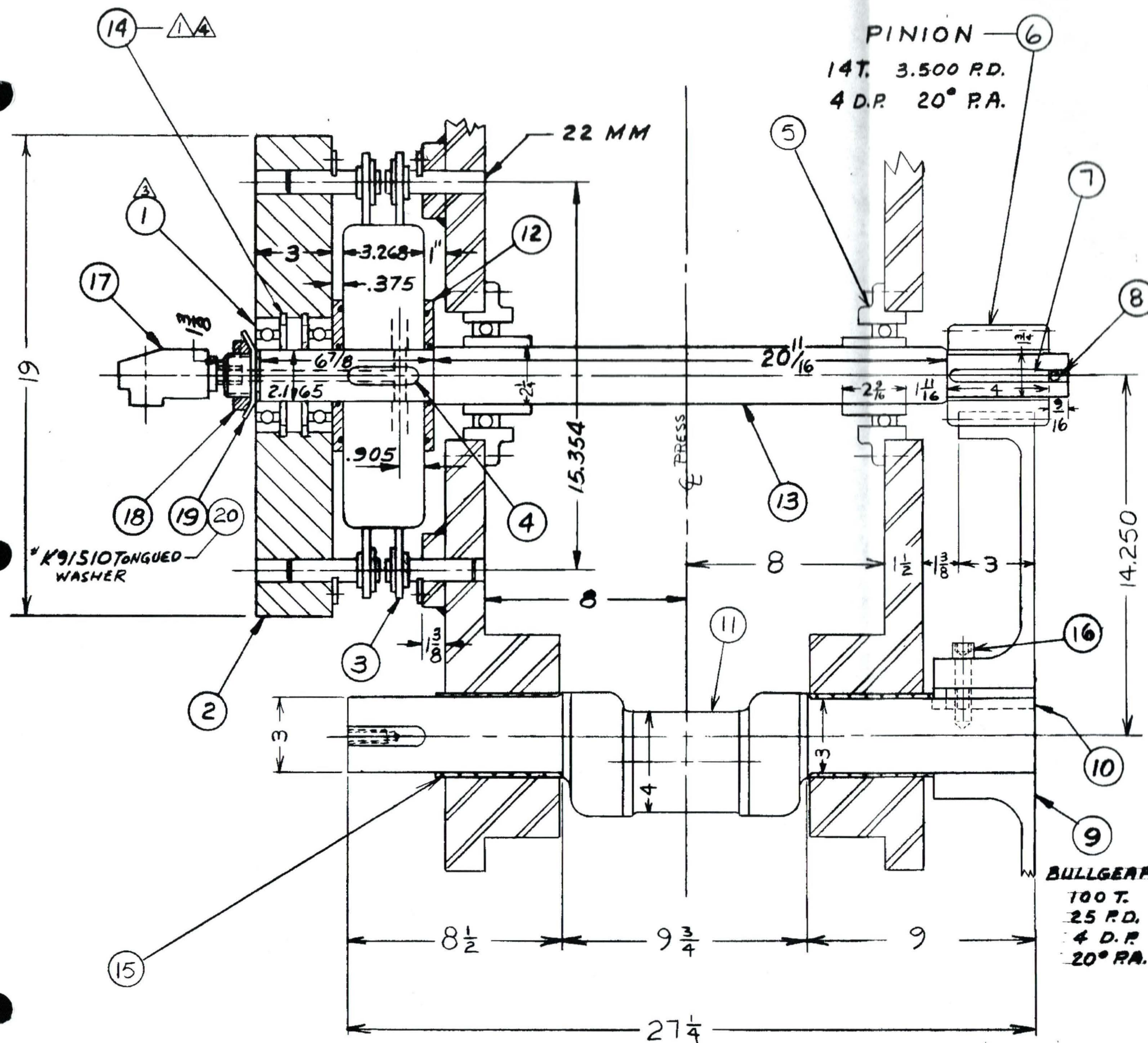
B-7236-C-1	29" - 4 Pieces
B-7236-C-3	33" - 4 Pieces

GIB LINERS

B-7236-B-29	- 4 Pieces
B-7236-B-33	- 4 Pieces

17AUG1994

C-7953



BILL OF MATERIALS

ITEM	PART NO.	DRG. NO.	DESCRIPTION	QUAN.
1		A-2556	MRC-211 MFF FLYWHEEL BRG.	2
2	3G-4-1	C-7831-32	19x3 FLYWHEEL	1
3		80-06550-02	OMPI KB-0100 CLUTCH & BRAKE	1
4		K0010622	3/8x3/8x2 3/4" DBL. FTH. KEY	2
5		B-1455	MFC-36 FL. BRG.	2
6		B-1418-A-1	PINION 1 3/4 BORE	1
7		K0010830	1/2x1/2x3 3/4" STRAIGHT KEY	1
8		86-02712-02	3/8 DIA x 2 1/2 LG ROLL PIN	1
9	3-70	C-7549	BULLGEAR	1
10		A-8129	3/4x3/4x3 3/4" STRAIGHT KEY	1
11		C-7545	CRANK SHAFT	1
12		C-7645-100	"0" RING SPACER	2
13	3-28-1	B-7541-1	BACK SHAFT	1
14		89-03797-02	SMALLEY WHT-393	2
15	3-7	B-7982	CRANK SHAFT BUSHING	2
16		F-0021018	5/8-11x2 1/4 LG. SOC. HD. CAP SCREW	1
17		80-06563-02	3/8 SWIVEL *4037	1
18		F-0410N10	LOCKNUT TIMKEN TAN-10	1
19		F-0420W10	LOCKWASHER TIMKEN TW-110	1

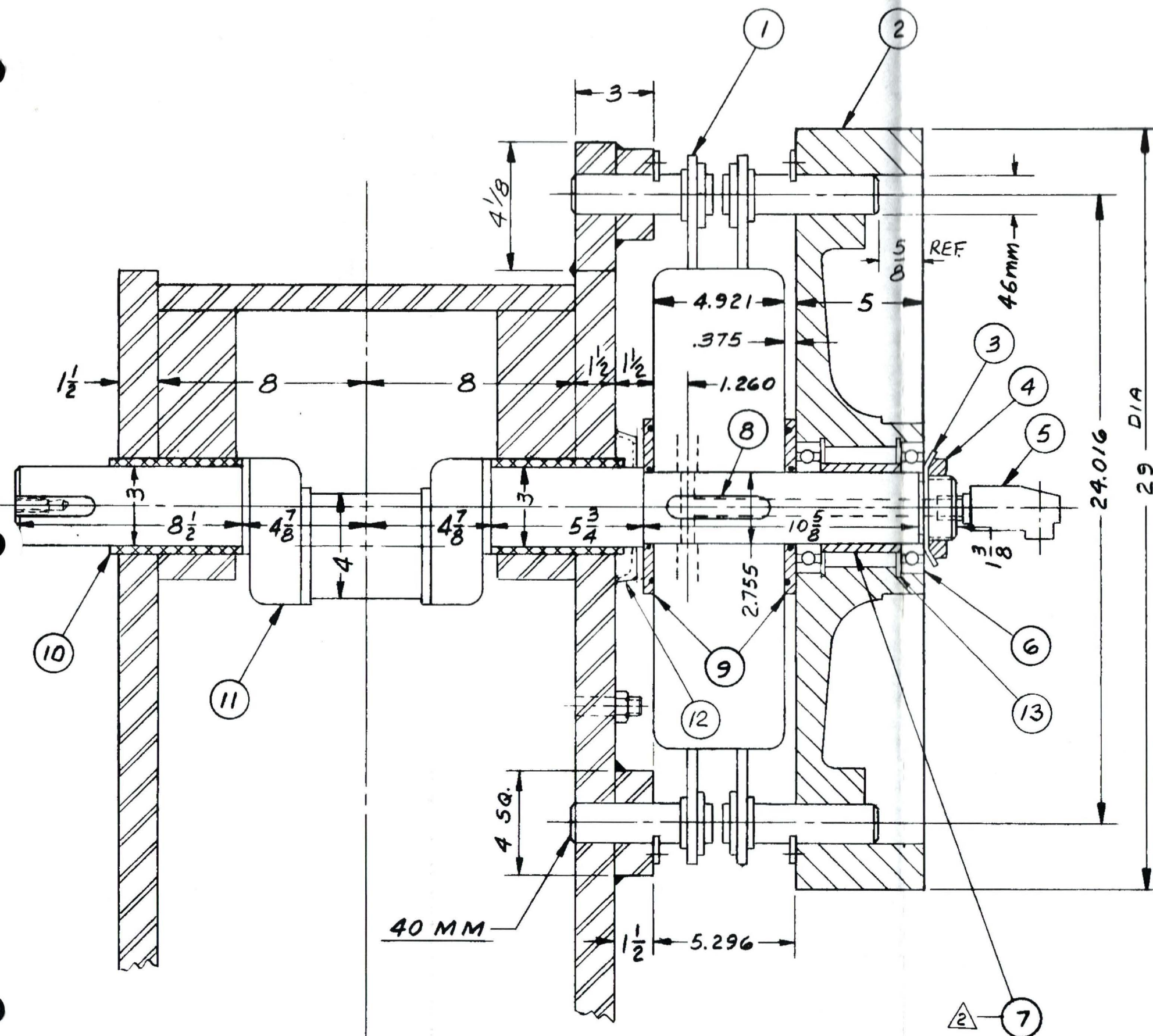
2	07/29/81	BY	KEY A-8129 WAS K001129	
1	12-6-90	V.B.	REMOVED NOTE FOR SPACER #14	00392
REV	DATE	BY	DESCRIPTION	ECO NO.

HEIM

P.O. BOX R,
FRANKFORT, ILL. 60423
(815) 469-2335

SUPERSEDES	THIS DRAWING IS THE PROPERTY OF HEIM CORP. AND MAY NOT BE COPIED, REPRODUCED OR USED FOR DESIGN, MANUFACTURE OR SALE WITHOUT PRIOR PERMISSION FROM HEIM CORP.	SCALE: 1/4	DATE
FINISHED DIMENSION TOLERANCE UNLESS OTHERWISE SPECIFIED	FRACTION ± .015 DECIMAL ± .005 ANGLES ± 0° 30'	DRWN. BY LAV	10-16-87
ALL FINISHES 125 RMS UNLESS OTHERWISE SPECIFIED	DESCRIPTION DRIVE LAYOUT - BACK GEAR	CHK. BY RSB	10-23-87
	USED ON GAC	DRWG. NO.	
	32 TON OBI & GAP	B-7493-1	

3	11/11/98	BY	A-2556 MRC-211 MFF WAS 80-06550-02	
---	----------	----	------------------------------------	--



DET.	PART NO.	DESCRIPTION	QTY.
1	80-06552-02	BRAKE & CLUTCH OMPI KB-0400	1
2	D-7812-3	FLYWHEEL 29 DIA x 5 W.	1
3	F-0420W13	LOCKWASHER TIMKEN TW-113	1
4	F-0410N13	LOCKNUT TIMKEN TAN-13	1
5	80-06560-02	3/4" SWIVEL OMPI U075	1
6	A-7690	BEARING MCR-214-S22	2
7	A-7816-2	SPACER 3 5/32 W.	1
8	K-0031232	3/4 x 3/4 x 4" LG. DBL. FTH. KEY	2
9	C-7645-400	"O" RING SPACER	2
10	B-7982	CRANKSHAFT BUSHING	2
11	C-7545-A	CRANKSHAFT	1
12	3-7-A	SEAL BUSHING RUBBER	1
13	89-03792-02	SMALLEY WHH-500	2

3	07/27/01	EK	DET'L. 12 & 3-7-A ADDED	
2	12/6/90	V.S.	REMOVED NOTE FOR SPACER #7	00332
1	9-27-89	LK	PARTNO. A-7690 WAS 74-06352-02	
REV	DATE	BY	DESCRIPTION	ECO NO.

HEIM

P.O. BOX R,
FRANKFORT, ILL. 60423
(815) 469-2335

SUPERSEDES

FINISHED DIMENSION
TOLERANCE UNLESS
OTHERWISE SPECIFIED

FRACTION $\pm .015$
DECIMAL $\pm .005$
ANGLES $\pm 0^{\circ} 30'$

ALL FINISHES 125
RMS UNLESS
OTHERWISE SPECIFIED

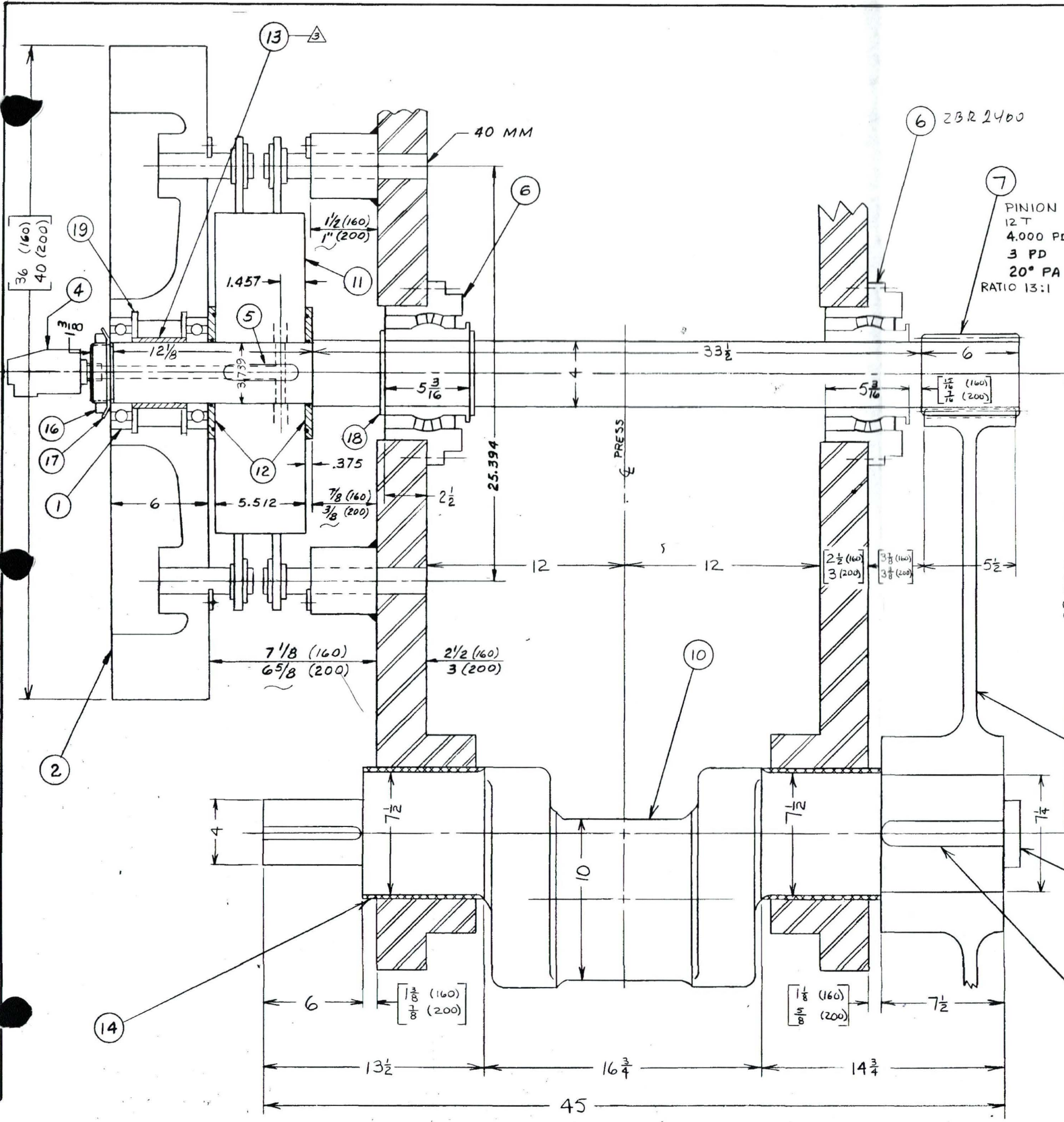
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SCALE: 1/4
DATE
DRWN. BY V.S. 10-21-87
CHK. BY RSB 10-27-87

DESCRIPTION 32 TON FAC
DRIVE ASSY

USED ON 32 TON FAC
(OMPI CL. & BR.)

DRWG. NO
B-7821



BILL OF MATERIALS				
ITEM	PART NO.	DRG. NO.	DESCRIPTION	QUAN.
1	5-4A	74-06353-02	FLYWHEEL BRG #219MFF	2
2	5-4	D-7812-5	36x6 CAST FLYWHEEL (160 T)	1
	7-4	D-7812-7	40x6 CAST FLYWHEEL (200T)	
3		B-7825	SEALMASTER MFC-64	1
4		80-06560-02	3/4" SWIVEL OMPI #UD75	1
5		81-06577-02	1"x1"x5" LG. KEY- DBL. FEATH.	2
6	16-78 -1	B-7825-A	ZBR-2400 FLANGE BRG.	1
7		C-7544-1	BACKSHAFT, PINION	1
8	15-70	C-7552	BULLGEAR	1
9		81-06580-02	1 1/2 x 1 1/2 x 7" STRAIGHT KEY	1
10		C-7548	CRANKSHAFT	1
11		80-06553-02	BRAKE & CLUTCH K80500 OMPI	1
12		C-7645-500	6" RING SPACER	2
13		A-7814-4	SPACER 3.500 W.	1
14		B-7828	CRANKSHAFT BUSHING	2
15	16-71	B-7519	END PLATE	1
16		F-0410N18	LOCKNUT TAN18 TIMKEN	1
17		F-0420W18	LOCKWASHER TW-118 TIMKEN	1
18		C-7496-18	SNAP RING 3.765 I.D. x .111 W. RSN-400 SPIROLOX	2
19		89-03790-02	PIROLOX RR 669	2

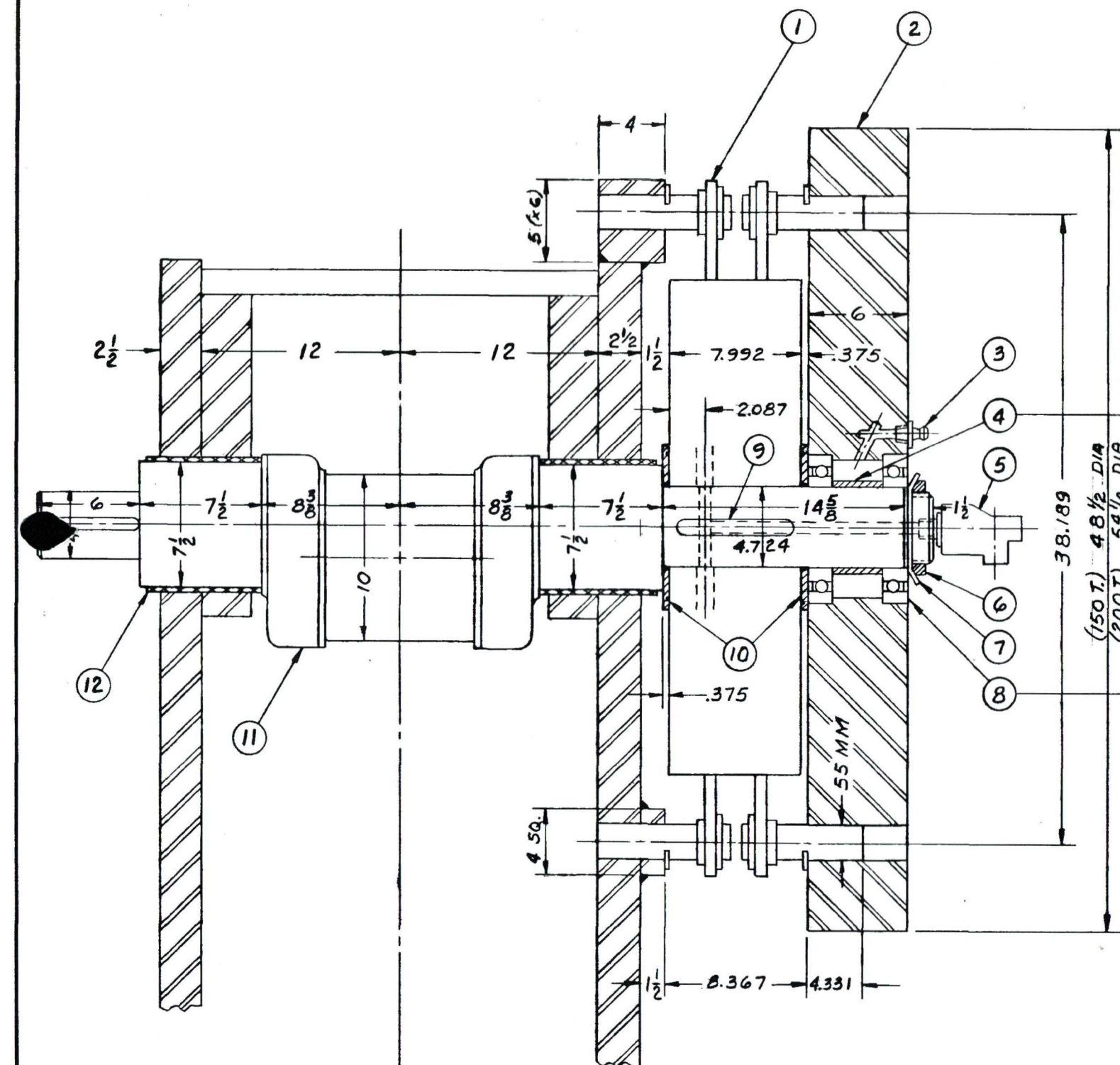
BULLGEAR
156 T 52.000 PD
3DP 20° PA

3 12590 V.S. REMOVED NOTE FOR SPACER (3) 00932

2 101319 RE ITEM 5 B-06577 WAS K-0031690, ITEM 981-06580 WAS K0012456

1 10-26-88 V.S. DET. 3 WAS B-7825; QTY DET. 6 WAS 1

REV	DATE	BY	DESCRIPTION	ECO NO.
HEIM P.O. BOX R, FRANKFORT, ILL. 60423 (815) 469-2335				
SUPERSEDES		THIS DRAWING IS THE PROPERTY OF HEIM CORP. AND MAY NOT BE COPIED, REPRODUCED OR USED FOR DESIGN, MANUFACTURE OR SALE WITHOUT PRIOR PERMISSION FROM HEIM CORP.		SCALE: 1/4
FINISHED DIMENSION TOLERANCE UNLESS OTHERWISE SPECIFIED		DRWN BY LAV		DATE 5-18-81
FRACTION ± .015		CHK BY RSB		521-52
DECIMAL ± .005		DESCRIPTION		
ANGLES ± 0° 30'		DRIVE LAYOUT		
ALL FINISHES 125 RMS UNLESS OTHERWISE SPECIFIED		USED ON OMPI CL. 4 BR		
		160-200 T OBI & GAP		
		DRWG. NO. C-7496-1		



DET.	PART NO.	DESCRIPTION	MATERIAL	QTY.
1	80-06557-02	CLUTCH & BRAKE	OMPI KB-1700	1
2	C-7831-600 C-7831-200F	FLYWHEEL 48 1/2 DIA x 6 W. 54 1/2	H.R. MILD STL.	1
3	82-00929-02	1/8 NPT LUBR. FITTING	1610-B ALEMITE	1
4	A-7814-4	SPACER 3.500 W.	STL.	1
5	80-06562-02	1/4 SWIVEL	OMPI #U125	1
6	F-0410N22	LOCKNUT	TIMKEN TAN-22	1
7	F-0420W22	LOCKWASHER	" TW-122	1
8	74-0635A-02	BEARING-ONE SHIELD	MRC-224-MF	2
9	B1-06579-02	1" x 1" x 7" LG. KEY-DBL. FEATH.	STL.	1
10	C-7645-1700	"O" RING SPACER	H.R.S.	2
11	2024278-C2	CRANKSHAFT 4" STR.	1045 H.R.S.	1
12	B-7828	CRANKSHAFT BUSHING	SAE 660 BRONZE	2
13	43-24333-C2	FLYWHEEL COVER	STL.	1

ASSEMBLE BEARING
WITH SHIELD OUTSIDE

3	V.S. 12-590	REMOVED NOTE FOR SPACER (4)
2	V.S. 1-3090	ADDED - USED ON 200 TON
1	LK 8-25-89	PART NO. WAS K-0031656

ORIGINAL DWG. NO.	REV.	BY	DATE	CHANGES OR ADDITIONS
EQUIPMENT USED ON	150 TON FAC ROUSSELLE & 200 T. S/N P-30816 160 TON FAC HEIM & 200 T.			
THIS DRAWING IS THE PROPERTY OF ROUSSELLE CORPORATION AND MAY NOT BE COPIED, REPRODUCED OR USED FOR DESIGN, MANUFACTURE OR SALE WITHOUT PRIOR PERMISSION FROM ROUSSELLE CORPORATION.				
ASSEM.	FINISHED DIMENSION TOL: DECIMAL ±.005, FRACT. ±.015 ANGLES ±0° 30' UNLESS OTHERWISE SPECIFIED			SCALE 3/16 DATE
DWG. NO.	REMOVE ALL BURRS BREAK SHARP CORNERS			DR: V.S. 8-4-87
UNIT OR ASSEM. TITLE	MATERIAL: SEE B/M			CKD: APPR. RSB 8-6-87
HEAT TREAT		SUPERSEDES NO.		
TITLE 150, 200 T. FAC DRIVE ASSY		ITER NO.		
ROUSSELLE CORPORATION AN ALCO STANDARD COMPANY CHICAGO, ILLINOIS		DRG. NO. 00-24277-C2		

REV	DATE	BY	DESCRIPTION	ECO NO.
			P.O. BOX R, FRANKFORT, ILL. 60423 (815) 469-2335	
SUPERSEDES			THIS DRAWING IS THE PROPERTY OF HEIM CORP. AND MAY NOT BE COPIED, REPRODUCED OR USED FOR DESIGN, MANUFACTURE OR SALE WITHOUT PRIOR PERMISSION FROM HEIM CORP.	SCALE: 3/8 DATE
FINISHED DIMENSION TOLERANCE UNLESS OTHERWISE SPECIFIED			DRAWN: LAV CHK. BY	7-26-85
FRACTION $\pm .015$ DECIMAL $\pm .005$ ANGLES $\pm 0^{\circ} 30'$			DESCRIPTION BACK SHAFT	
ALL FINISHES 125 RMS UNLESS OTHERWISE SPECIFIED			USED ON C-7495 95-120 T OBI & GAP	DRWG. NO. B-7543

9-28-1

1	FINISHES	SK	2/16 WAS 9/16	ASSY
REV	DATE	BY	DESCRIPTION	ECO NO.
			P.O. BOX R, FRANKFORT, ILL. 60423 (815) 469-2335	
SUPERSEDES		THIS DRAWING IS THE PROPERTY OF HEIM CORP. AND MAY NOT BE COPIED, REPRODUCED OR USED FOR DESIGN, MANUFACTURE OR SALE WITHOUT PRIOR PERMISSION FROM HEIM CORP.		SCALE: $\frac{3}{8}$ DATE
FINISHED DIMENSION TOLERANCE UNLESS OTHERWISE SPECIFIED		DRWN: BY LAV CHK: BY		7-26-85
FRACTION $\pm .015$ DECIMAL $\pm .005$ ANGLES $\pm 0^{\circ} 30'$ ALL FINISHES 125 RMS UNLESS OTHERWISE SPECIFIED		DESCRIPTION (USE WITH STD. BACKSHAFT HEIM CLUTCH)		
		USED ON B-7434 55-70 T OBI & GAP		DRWG. NO. B-7542

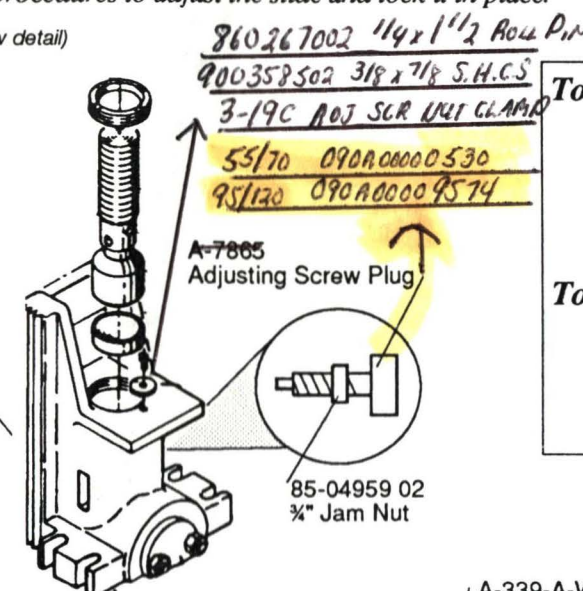
5-28-1

Memo #1: Power Slide Adjustment

Press Classification Applicable: 55 to 120 ton Single Point OBI and OBS presses
Serial Numbers Affected: 3637 and above; all retrofits

To avoid damage to a press from improper slide adjustment, the following instructions and parts assembly drawings are being provided. This design change in the power slide adjustment assembly requires the following procedures to adjust the slide and lock it in place:

(Bolts enlarged to show detail)



To adjust slide:

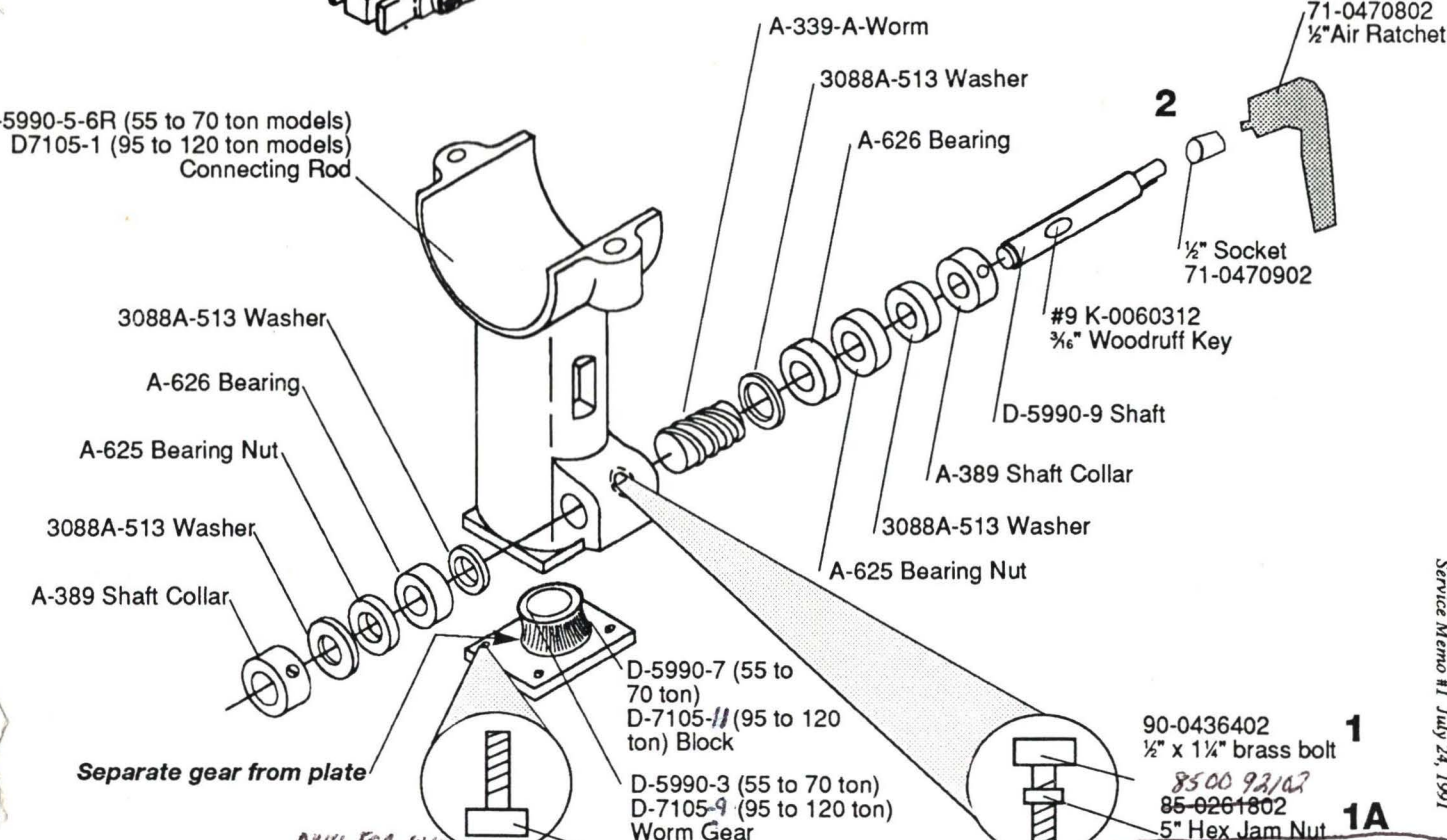
- loosen slide nut 1A
- loosen locking bolt 1
- take air ratchet and connect to end of slide adjusting shaft 2

To lock slide in place:

- once slide is adjusted, remove air ratchet
- tighten locking bolt 1 until snug
- tighten slide nut 1A

5-2 (55 to 70 ton models)
9-2 (95 to 120 ton models)
Slide

D-5990-5-6R (55 to 70 ton models)
D7105-1 (95 to 120 ton models)
Connecting Rod



Separate gear from plate

DRILL FOR WIRE

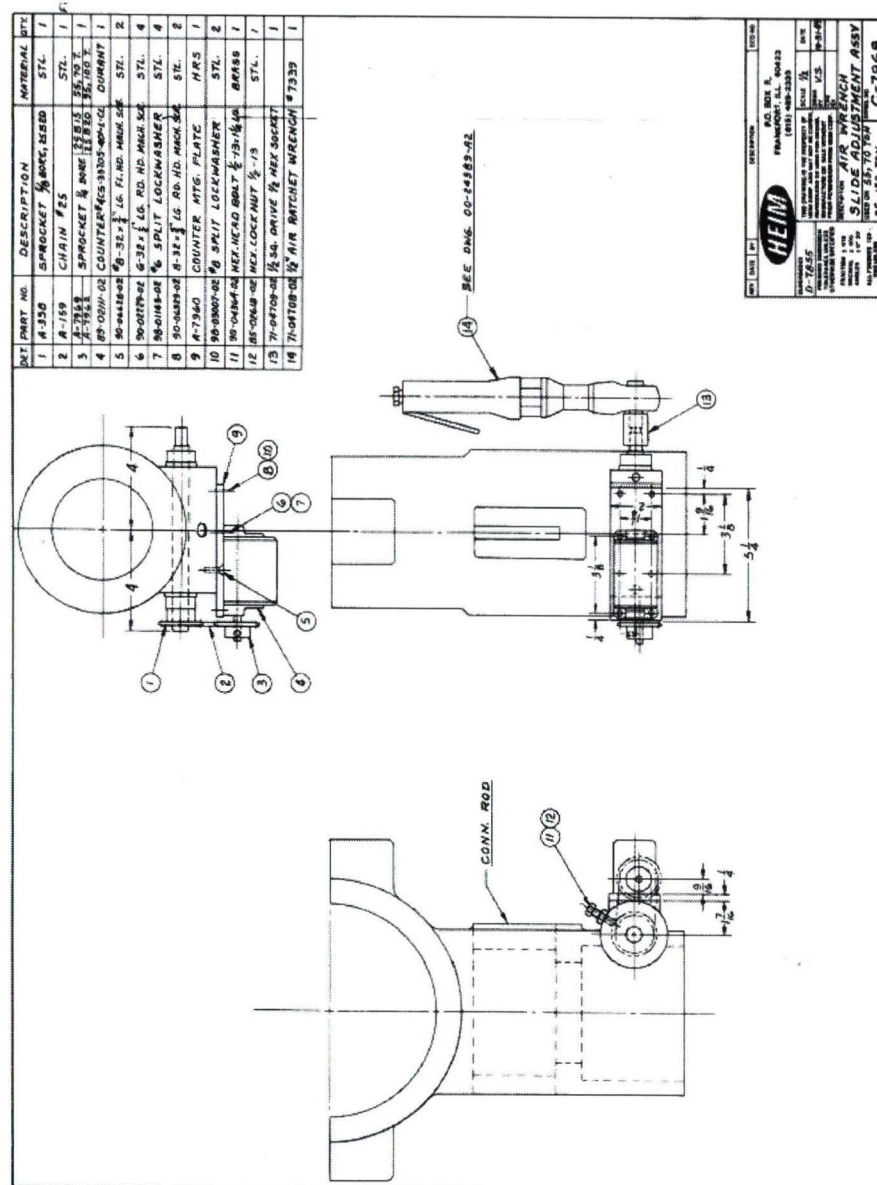
55/70 900098502 Bolt
980121402 Lockwasher

Four (4) 1/2" x 13" x 1 1/2" lg.
Drill heads for safety wire.

DRILL FOR SAFETY WIRE
95/120 900122102 5/8" 21"

980121502 Lockwasher

C-7968.GP4:



Service Update

Memo #1: Power Slide Adjustment

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To avoid damage to a press from improper slide adjustment, the following instructions and parts assembly drawings are being provided. This design change in the power slide adjustment assembly requires the following procedures to adjust the slide and lock it in place:

(Bolts enlarged to show detail)

860267002 1/4 x 1 1/2 Rod Pin

900358502 3/8 x 7/8 S.H.C.S.

3-19C A0J SCR WRT CLAMP

55/70 090A00000530

95/120 090A000009574

A-7805 Adjusting Screw Plug

85-04959 02 3/4" Jam Nut

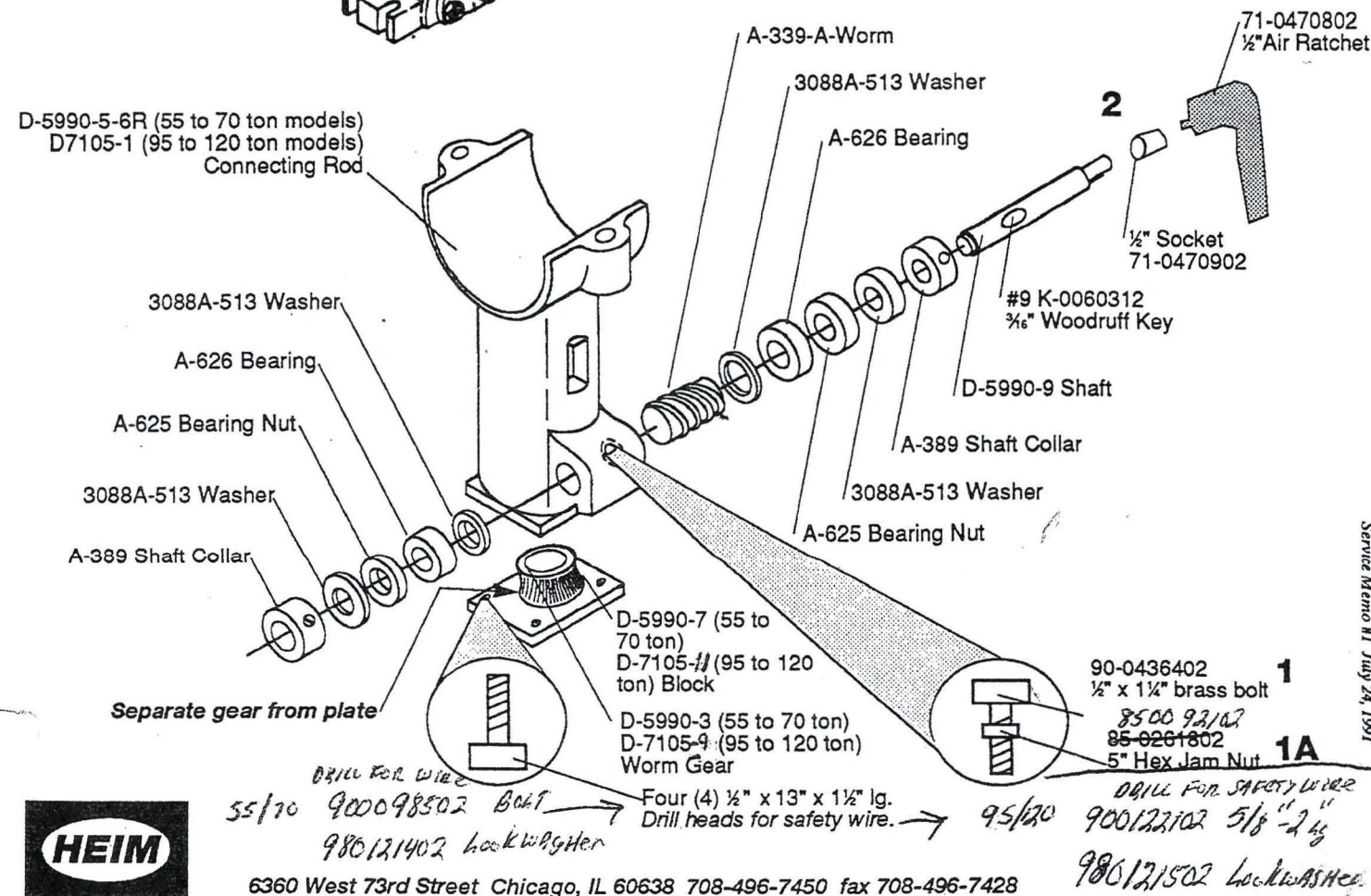
5-2 (55 to 70 ton models)
9-2 (95 to 120 ton models)
Slide

To adjust slide:

- loosen slide nut 1A
- loosen locking bolt 1
- take air ratchet and connect to end of slide adjusting shaft 2

To lock slide in place:

- once slide is adjusted, remove air ratchet
- tighten locking bolt 1 until snug
- tighten slide nut 1A



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3-19C A0J SCR WRT CLAMP

55/70 090A00000530

95/120 090A000009574

A-7805 Adjusting Screw Plug

85-04959 02 3/4" Jam Nut

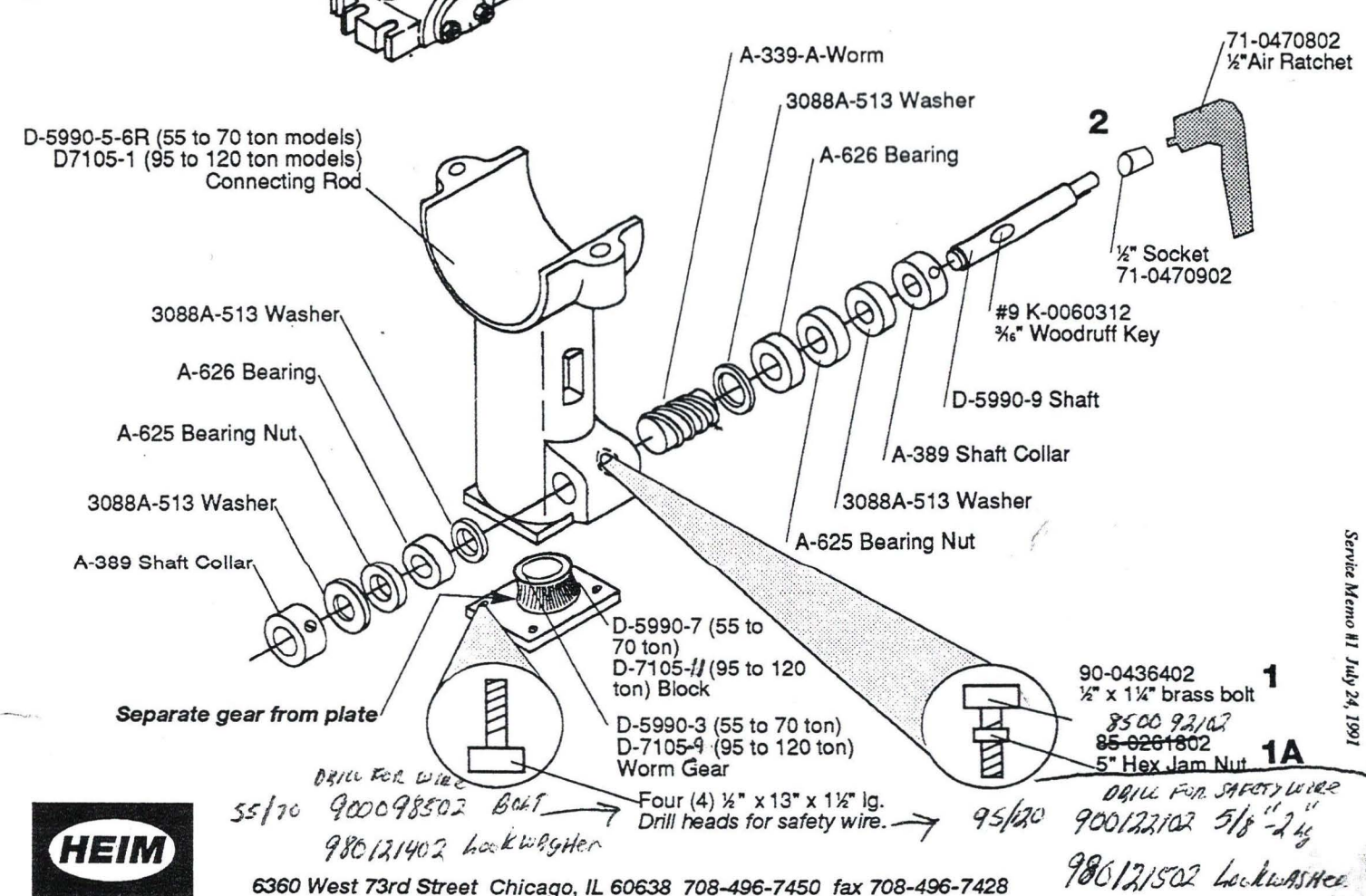
5-2 (55 to 70 ton models)
9-2 (95 to 120 ton models)
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- tighten slide nut 1A



6360 West 73rd Street Chicago, IL 60638 708-496-7450 fax 708-496-7428



6360 West 73rd Street Chicago, IL 60638 708-496-7450 fax 708-496-7428

Service Memo #1 July 24, 1991

Service Update

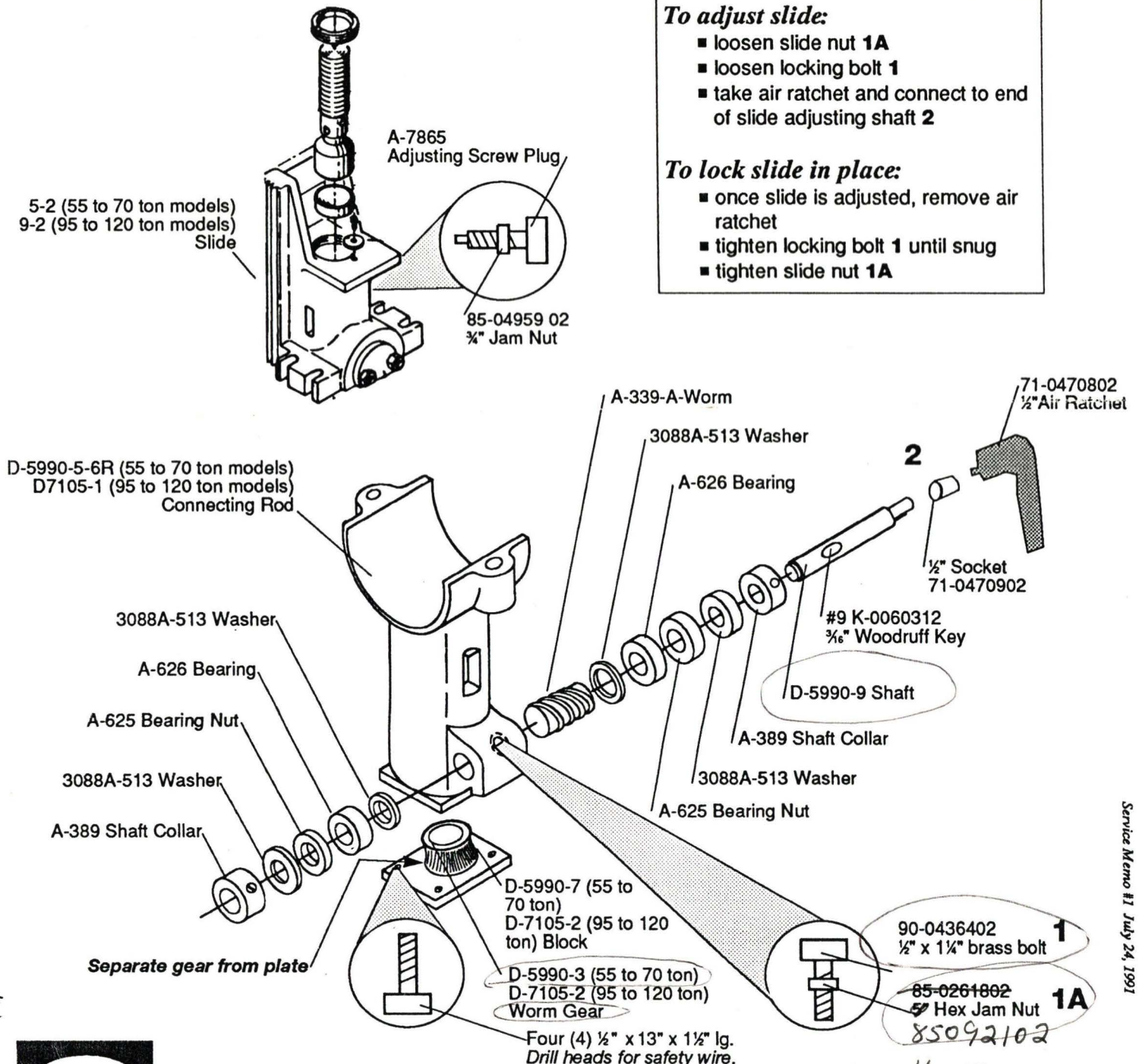
Memo #1: Power Slide Adjustment

Press Classification Applicable: 55 to 120 ton Single Point OBI and OBS presses

Serial Numbers Affected: 3637 and above; all retrofits

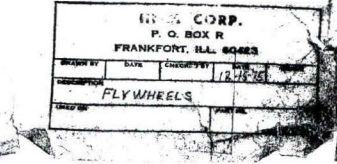
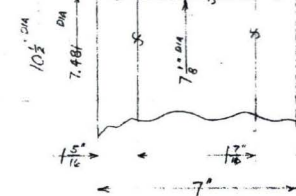
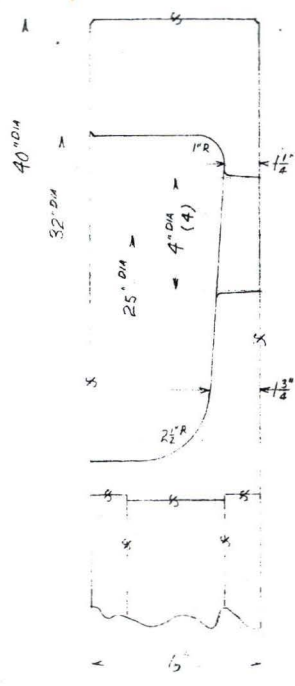
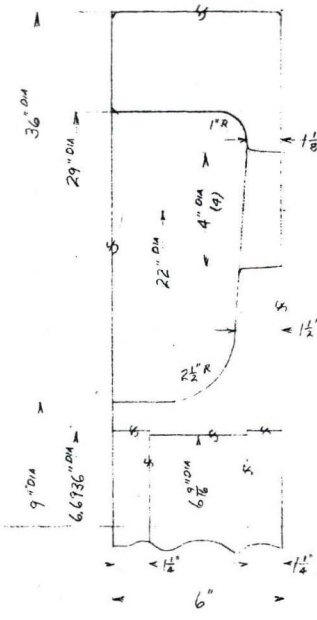
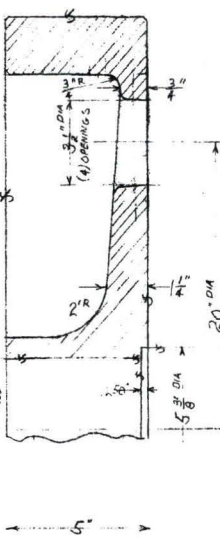
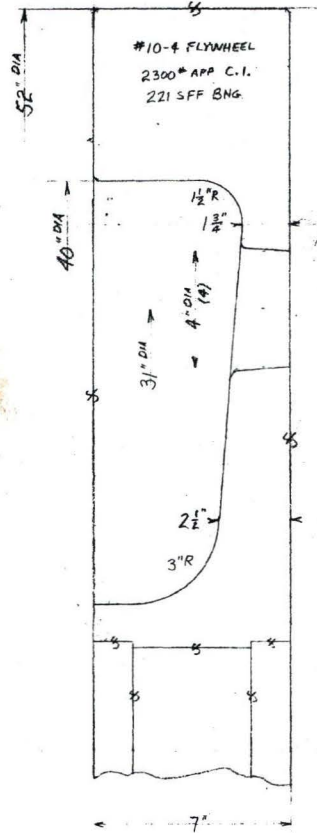
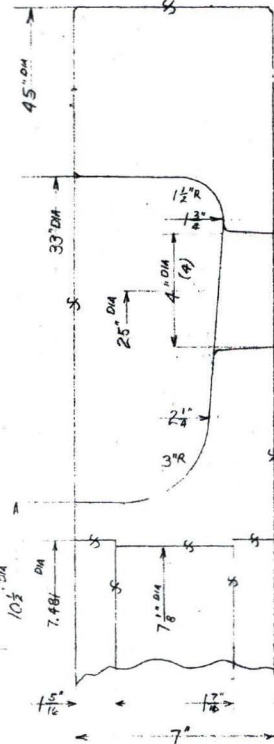
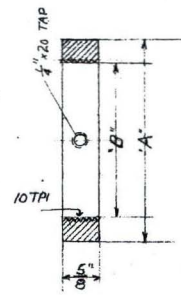
To avoid damage to a press from improper slide adjustment, the following instructions and parts assembly drawings are being provided. This design change in the power slide adjustment assembly requires the following procedures to adjust the slide and lock it in place:

(Bolts enlarged to show detail)

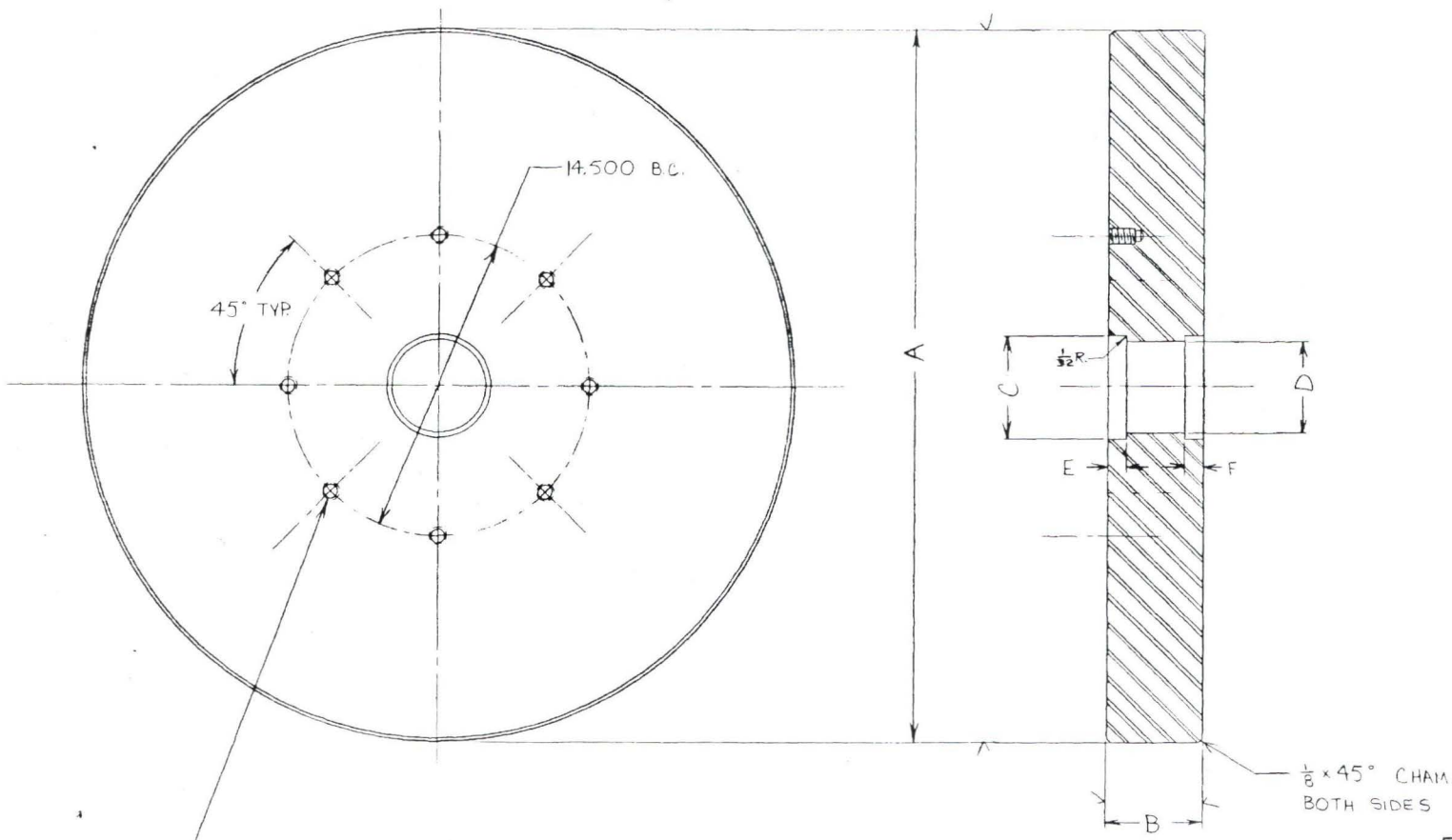


	A	B	PITCH
	QD.	I.D.	O/A
	3"	2.034	2.079 + .002
	3 $\frac{3}{4}$ "	2.625	2.690 + .002
	4 $\frac{1}{2}$ "	3.625	3.674 + .002
	5"	4"	4.068 + .002

	A	B	WT	RPM	PULLEY *
95 TON	28	4	680	430	7" DD
120 TON	34	4	1000	387	7.8 PD



PART NO.	DWG. NO.	PRESS	A	B	C	D	E	F
3G-4-1	C-7247-32	32 T OBI/BG	19	3	3.54 ^{±.003}	3 $\frac{1}{4}$	0.709	0.709
5G-4-1	C-7247-55	55 T OBI/BG	24	5	4.9194 ^{±.002}	4 $\frac{1}{2}$	0.945	0.945
7G-4-1	C-7247-70	70 T OBI/BG	25 $\frac{1}{2}$	5	4.9194 ^{±.002}	4 $\frac{1}{2}$	0.945	0.945
9G-4-1	C-7247-95	95 T OBI/BG	30 $\frac{1}{2}$	4	4.9194 ^{±.002}	4 $\frac{1}{2}$	0.945	0.945
10G-4-1	C-7247-120	120 T OBI/BG	34	4	4.9194 ^{±.002}	4 $\frac{1}{2}$	0.945	0.945
	C-7247-150	150 T SS	32	4	4.9194 ^{±.002}	4 $\frac{1}{2}$	0.945	0.945
	C-7247-200	200 T SS	37	4	4.9194 ^{±.002}	4 $\frac{1}{2}$	0.945	0.945
	C-7247-250	250 T SS	37	5	6.6910 ^{±.0010}	6 $\frac{1}{4}$	2.520	1.260
	C-7247-300	300 T SS	40 $\frac{1}{2}$	5	6.6910 ^{±.0010}	6 $\frac{1}{4}$	2.520	1.260
	C-7247-400	400 T SS	43	6	6.6910 ^{±.0010}	6 $\frac{1}{4}$	2.520	1.260



DRILL $\frac{27}{64}$ (1.422 DIA.)
1 $\frac{1}{2}$ DEEP ~ TAP $\frac{1}{2}$ -13 NC.
8 PLACES, EQUALLY
SPACED

MATERIAL:
H.R. MILD STEEL

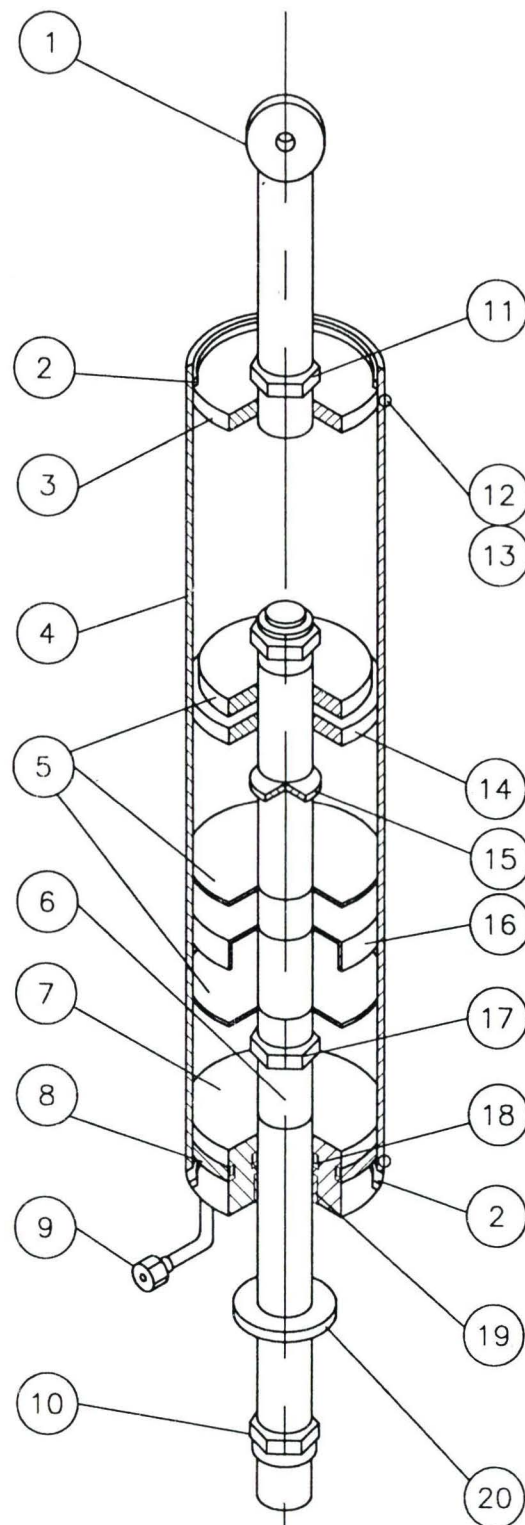
NOTE:

FLYWHEEL FOR STANDARD
CLUTCH ONLY

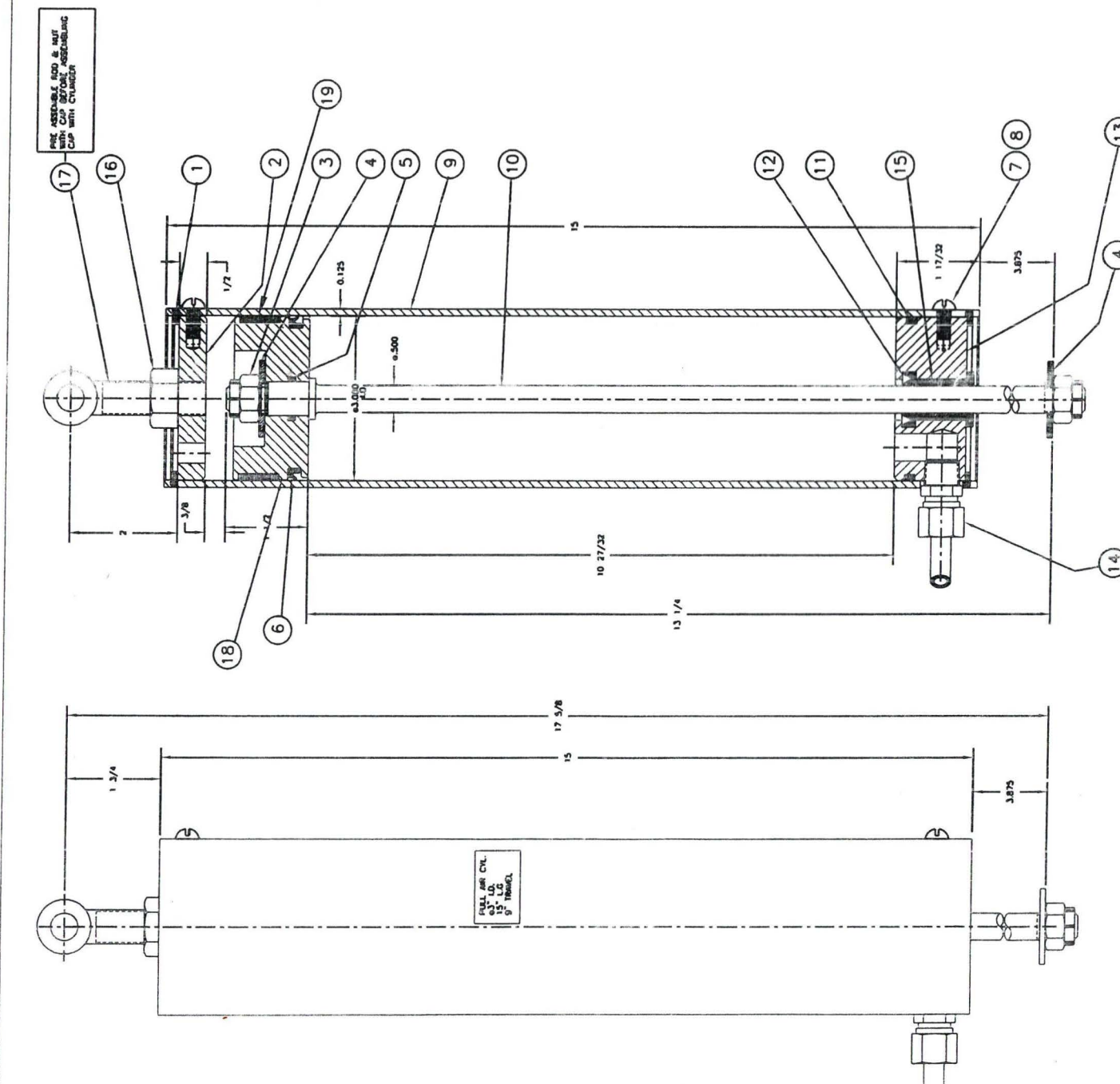
FOR HEAVY DUTY CLUTCH
SEE DRG. C-7594

REV	DATE	BY	DESCRIPTION	ECO NO.
			P.O. BOX R, FRANKFORT, ILL. 60423 (815) 469-2335	
SUPERSEDES			THIS DRAWING IS THE PROPERTY OF HEIM CO. AND MAY NOT BE COPIED REPRODUCED OR USED WITHOUT MANUFACTURE OR SALE WITHOUT PRIOR PERMISSION FROM HEIM CO.	SCALE 1/4
FINISH DIMENSION TOLERANCE UNLESS OTHERWISE SPECIFIED			DRAWN BY LAV CHECKED BY R S S	7-31-58 8-1-58
FRACTION: 1/16 DECIMAL: 2.005 ANGLES: 1° 0' 30"			DESCRIPTION	
ALL FINISHES 125 RMS UNLESS OTHERWISE SPECIFIED			FLYWHEEL USED ON 55 PRESSURE W/ 570.0 CLUTCH 12-12-58 10-1-58	
			DRWG. NO. 1C-7247	

AIR COUNTERBALANCE ASSEMBLY (55 to 70 Ton Presses) 1998



REF NO.	DESCRIPTION	ORDER NUMBER
1	ROD END 5/8" x 2 1/2" LG	7009688A2
2	RETAINING RING	890435102 N5000-300
3	CAP	6609089A2
4	CYLINDER 15" LG	6609088B2
5	BACK UP WASHER 2.500 O.D.	6609091A2
6	PISTON ROD	6609090A2
7	BASE	6609093B2
8	"O" RING 3.00 O.D. x 2.750 I.D.	910276002
9	ELBOW - COMPRESSION 1/2" TUBE x 3/8 N.P.T	870195302
10	JAM LOCK NUT 1/2" - 13	850261802
11	HEX NUT 5/8 - 16	850264402
12	MACHINE SCREW ROUND HEAD 1/2" x 0.500 LG	900101702
13	LOCKWASHER 1/4"	980099902
14	FELT WASHER 3.000 O.D. x 0.875 I.D.	6609092A2
15	LOCKWASHER 1/2"	980121402
16	PACKING CUP 3.00 O.D. x 0.500 I.D.	910276702
17	JAM NUT 1/2" x 13	850092102
18	HOMOGENOUS "U" CUP 1.000 O.D. x 0.500 I.D.	910276102
19	FLANGE BUSHING 1/2" I.D. x 3/4" O.D. x 1" LG	750967102
20	PLAIN WASHER 1/2"	980092502
-	COMPRESSION ELBOW	820100702
-	METER UNIT	820102502
-	CYLINDER ASSEMBLY	000907400



ITEM	PART NO.	DESCRIPTION	MATERIAL
1	89-04331-02	RETAINING RING 15000-300	TRIPLEX
2	035600014263	CYLINDER CAP	H.A.S.E
3	83-00818-02	1/2"-13 JIN LOCK NUT	STEEL
4	90-00925-02	1/2" PLUMB W/SH	STEEL
5	91-00100-02	"O" RING 5/8	FLUOROPOLYMER
6	91-00107-02	1/4" CAP. SCA. 2.569 CH.218in / IN-218-09349	COMPRESSOR
7	91-00141-02	1/4"-20x1 7/8 LG LOCKWASHLOCATOR / 15317-08.000	STEEL
8	91-00959-02	4 SEAL 1/4 IN. ROUND	STEEL
9	045800014263-2	CYLINDER TUBE 3 1/2" x 5/8 = 15 LG	STEEL, TUB
10	045800014263-1	PISTON ROD 31/2x1 1/2	STEEL
11	91-02789-02	0.0005 0.0-2.75 1.0x1.125 CS. 10" RING	STEEL
12	91-02781-02	NONCOMPRESSION "O" CAP- 12.510 1.0x1.00 0.0-2.50	COMPOSITE
13	045800014267	CYLINDER HEAD FOR 3" 102V	STEEL
14	87-01192-02	COMPRESSOR CONNECTORS 1/2x3/8 68A-8C	STEEL
15	73-00871-02	FLANGE BUSHING 1/2 10x3/4 0.0x1" LG	99-812-4
16	83-02644-02	5/8x1 1/2 HEX NUT	STEEL
17	73-00868-02	5/8x2 1/2 ROD END	STEEL
18	045800014263	PISTON 3" O.D.	STEEL

PULL AIR CYL.
ø3" I.D.
15" L.G
9" TRAVEL

02/07/20
130 v. 144

2000000 | 4271

[illegible]

DRAWING 000000014271 55-70 R&K 06/06

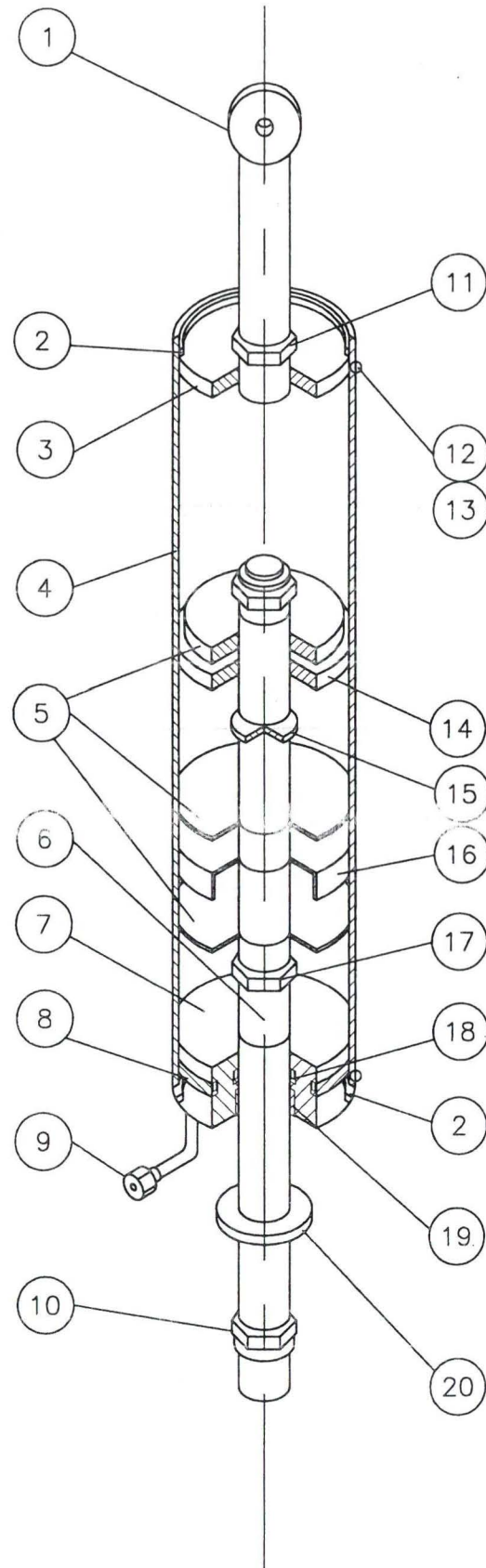
ITEM	PART NO.	DESCRIPTION	MATERIAL	QTY.
1	89-04351-02	RETAINING RING N5000-300	TRUARC	2
2	066A00014262	CYLINDER CAP	H.R.S.	1
3	85-02618-02	1/2"-13 JAM LOCK NUT	STEEL	2
4	98-00925-02	1/2" PLAIN WASHER	STEEL	2
5	91-05100-02	"O" RING 5/8 I.D.c 7/8 O.D.x1/8 # AS-568A-208	RUBBER/LUTZ Co.	1
6	91-05149-02	"U-CAP" SEAL # N4-218-02.562, 2.562 IDx.218w	OMNIPAC/MPI	1
7	90-01017-02	1/4-20x1/2 LG RD.HD.MACH.SCREW # KP312-08.000	STEEL	2
8	98-00999-02	K SEAL 1/4 LOCKWASHER	STEEL	2
9	066B00014263-2	CYLINDER TUBE #3" I.D.x1/8 x 15 LG	STEEL TUBE	1
10	066C00014266-2	PISTON ROD #1/2x18 1/2	STEEL	1
11	91-02760-02	#3.000 O.D.x2.75 I.D.x.125 C.S. "O" RING	J.CRANE	1
12	91-02761-02	HOMOGENEOUS "U"CAP-12,500 I.D.x1.00 O.D.x.250	STEEL	1
13	066B00014267	CYLINDER BASE FOR #3" I.D.CYL.	STEEL	1
14	87-01192-02	COMPRESSION.CONECTORS.1/2x3/8 68A-8C	FB-812-8 BOSTON	1
15	75-09671-02	FLANGE BUSHING 1/2 I.D.x3/4 O.Dx1" LG	STEEL	1
16	85-02644-02	5/8-11 HEX NUT	STEEL	1
17	70-09688-A2	5/8x2 1/2 ROD END	STEEL	1
18	066B00014265	PISTON #3" O.D.	STEEL	1
19	91-015148-02	BEARING TAPE PTFE-T-0125-0.750x8 15/16"LG,T-LOG-22 "T-LOG" Inc		1

HEIM 55-70 s/c

ITEM	PART NO.	DESCRIPTION	MATERIAL	QTY.
1	89-04351-02	RETAINING RING N5000-300	TRUARC	2
2	066A00014262	CYLINDER CAP	H.R.S.	1
3	85-02618-02	1/2"-13 JAM LOCK NUT	STEEL	2
4	98-00925-02	1/2" PLAIN WASHER	STEEL	2
5	91-05100-02	"O" RING 5/8 I.D.c 7/8 O.D.x1/8 # AS-568A-208	RUBBER/LUTZ Co.	1
6	91-05149-02	"U-CAP" SEAL 2.562 IDx.218w # N4-218-02.562	OMNIPAC/MPI	1
7	90-01017-02	1/4-20x1/2 LG RD.HD.MACH.SCREW # KP312-08.000	STEEL	2
8	98-00999-02	K SEAL 1/4 LOCKWASHER	STEEL	2
9	066B00014263-2	CYLINDER TUBE #3" I.D.x1/8 x 15 LG	STEEL TUBE	1
10	066C00014266-2	PISTON ROD #1/2x18 1/2	STEEL	1
11	91-02760-02	#3.000 O.D.x2.75 I.D.x.125 C.S. "O" RING		1
12	91-02761-02	HOMOGENEOUS "U"CAP-12,500 I.D.x1.00 O.D.x.250	J.CRANE	1
13	066B00014267	CYLINDER BASE FOR #3" I.D.CYL.	STEEL	1
14	87-01192-02	COMPRESSION.CONECTORS.1/2x3/8 68A-8C		1
15	75-09671-02	FLANGE BUSHING 1/2 I.D.x3/4 O.Dx1" LG	FB-812-8 BOSTON	1
16	85-02644-02	5/8-11 HEX NUT	STEEL	1
17	70-09688-A2	5/8x2 1/2 ROD END	STEEL	1
18	066B00014265	PISTON #3" O.D.	STEEL	1
19	91-015148-02	BEARING TAPE PTFE-T-0125-0.750x8 15/16"LG,T-LOG-22 "T-LOG" Inc		1

RBK000105 O.S. 7 8" STROKE 7009693A2

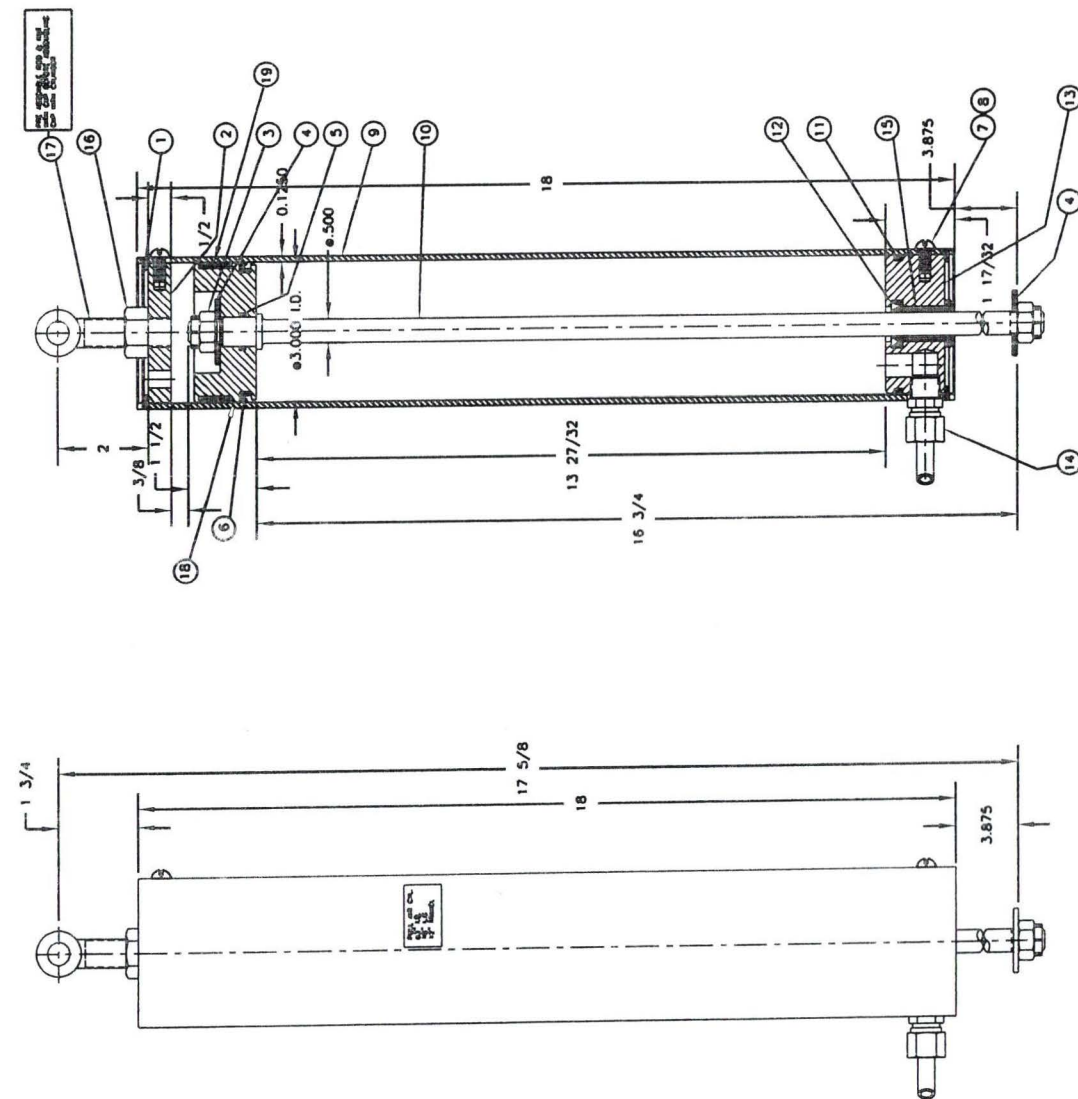
3" DIAMETER
AIR COUNTERBALANCE ASSEMBLY
(95) to 120 Ton Presses) 1998



BILL OF MATERIALS

REF NO.	DESCRIPTION	ORDER NUMBER
1	ROD END 5/8" x 2 1/2" LG	7009688A2
2	RETAINING RING	890435102 N5000-300
3	CAP	6609089A2
4	CYLINDER 18" LG	6609095B2
5	BACK UP WASHER 2.500 O.D.	6609091A2
6	PISTON ROD	6609094B2
7	BASE	6609093B2
8	"O" RING 3.00 O.D. x 2.750 I.D.	910276002
9	ELBOW - COMPRESSION 1/2" TUBE x 3/8 N.P.T	870195302
10	JAM LOCK NUT 1/2" - 13	850261802
11	HEX NUT 1/2" - 13	850173302
12	MACHINE SCREW ROUND HEAD 1/2" x 0.500 LG	900101702
13	LOCKWASHER 1/4"	980099902
14	FELT WASHER 3.000 O.D. x 0.875 I.D.	6609092A2
15	LOCKWASHER 1/2"	980121402
16	PACKING CUP 3.00 O.D. x 0.500 I.D.	910276702
17	JAM NUT 1/2" x 13	850092102
18	HOMOGENOUS "U" CUP 1.000 O.D. x 0.500 I.D.	910276102
19	FLANGE BUSHING 1/2" Ø.D. x 3/4" I.D. x 1" LG	750967102
20	PLAIN WASHER 1/2"	980092502
-	COMPRESSION ELBOW	820100702
-	METER UNIT	820102502
-	CYLINDER ASSEMBLY	000000014272

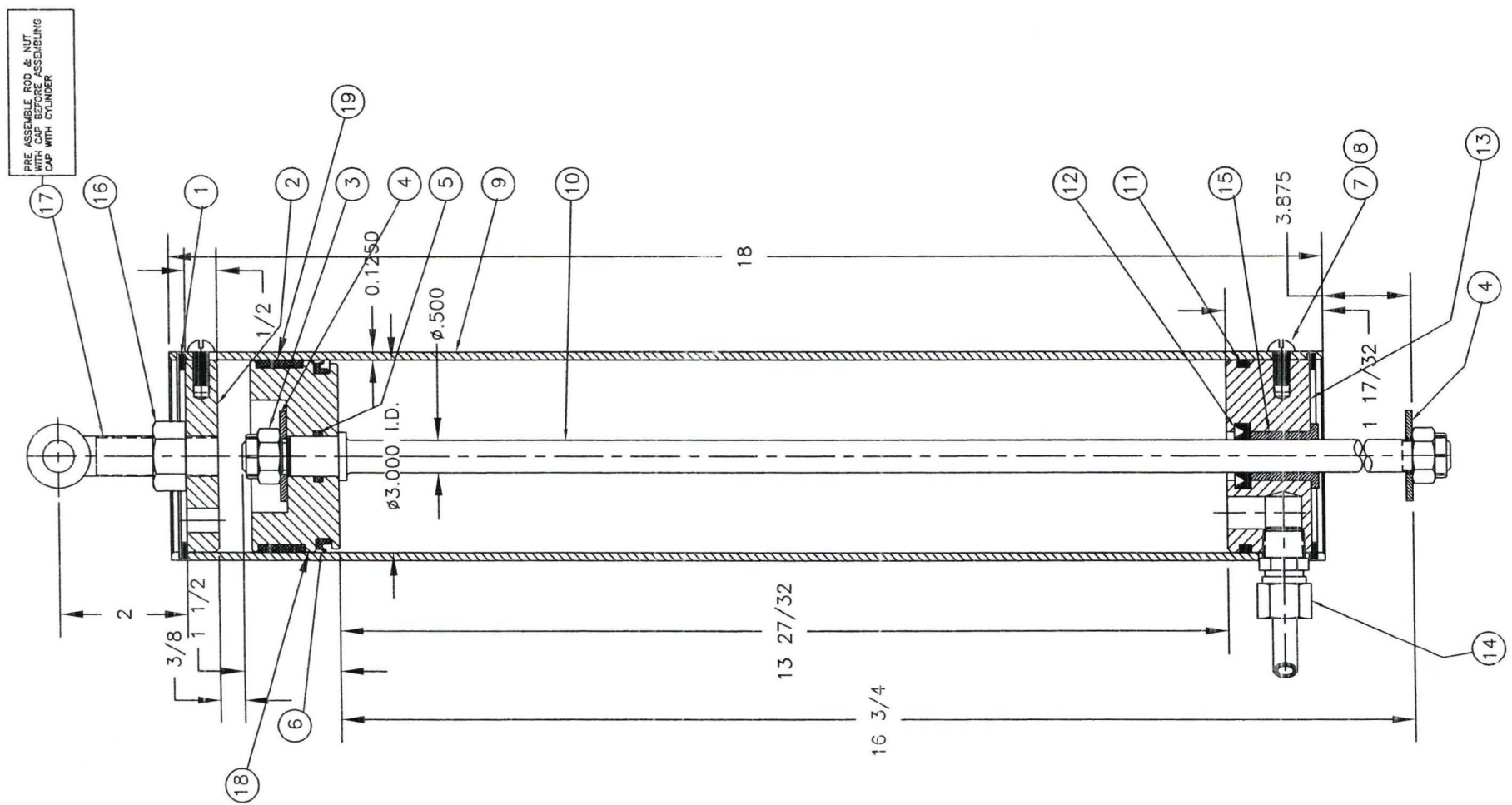
AGE	NAME	ADDRESS	CITY	STATE
1	BO-1311-41	1000-1000-1000	1000-1000	1000
2	BO-1311-42	1000-1000-1000	1000-1000	1000
3	BO-1311-43	1000-1000-1000	1000-1000	1000
4	BO-1311-44	1000-1000-1000	1000-1000	1000
5	BO-1311-45	1000-1000-1000	1000-1000	1000
6	BO-1311-46	1000-1000-1000	1000-1000	1000
7	BO-1311-47	1000-1000-1000	1000-1000	1000
8	BO-1311-48	1000-1000-1000	1000-1000	1000
9	BO-1311-49	1000-1000-1000	1000-1000	1000
10	BO-1311-50	1000-1000-1000	1000-1000	1000
11	BO-1311-51	1000-1000-1000	1000-1000	1000
12	BO-1311-52	1000-1000-1000	1000-1000	1000
13	BO-1311-53	1000-1000-1000	1000-1000	1000
14	BO-1311-54	1000-1000-1000	1000-1000	1000
15	BO-1311-55	1000-1000-1000	1000-1000	1000
16	BO-1311-56	1000-1000-1000	1000-1000	1000
17	BO-1311-57	1000-1000-1000	1000-1000	1000
18	BO-1311-58	1000-1000-1000	1000-1000	1000
19	BO-1311-59	1000-1000-1000	1000-1000	1000
20	BO-1311-60	1000-1000-1000	1000-1000	1000



46120
95/120
081

REVISION DESC.	65-120 TOMS RUSSELLE-HEMI PRESSES			
MODEL	C'RAL CYL ASSUMP-PULL TYPE PIVOT MTG 3" ID-18" L			
DESCRIPTION	THIS DRAWING IS THE PROPERTY OF THE U.S. AIR FORCE AND IS LOANED TO YOU BY THE AIR FORCE. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM THE AIR FORCE. THIS DRAWING IS THE PROPERTY OF THE U.S. AIR FORCE AND IS LOANED TO YOU BY THE AIR FORCE. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM THE AIR FORCE.		DATE	
	FOR THE AIR FORCE, THE DRAWING IS THE PROPERTY OF THE U.S. AIR FORCE AND IS LOANED TO YOU BY THE AIR FORCE. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM THE AIR FORCE.		8-24-1968	
	FOR THE AIR FORCE, THE DRAWING IS THE PROPERTY OF THE U.S. AIR FORCE AND IS LOANED TO YOU BY THE AIR FORCE. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM THE AIR FORCE.		DATE	
	FOR THE AIR FORCE, THE DRAWING IS THE PROPERTY OF THE U.S. AIR FORCE AND IS LOANED TO YOU BY THE AIR FORCE. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM THE AIR FORCE.		APPROV. YES	
Q.D. NO.	AIRMAIL		08/24/1968	
DATE	TITLE: PULL AND CYLINDER PRESS MOUNT-65-120-18-18			
The HEMI Group 6130 N. 7th Street Chicago, Illinois 60630 Tel: 312-656-7200 Telex: 312-656-7200 Fax: 312-656-7200			SCALE: 1/2" = 1"	
			000000014277	

ITEM	PART NO.	DESCRIPTION	MATERIAL	QTY.
1	89--04351-02	RETAINING RING N5000-300	TRUARC	2
2	066A00014262	CYLINDER CAP	H.R.S.	1
3	85--02618-02	1/2"-13 JAM LOCK NUT	STEEL	2
4	98-00925-02	1/2" PLAIN WASHER	STEEL	2
5	91-05151-02	"O" RING 5/8 I.D.c 7/8 O.D.x1/8 # AS-568A-208	RUBBER/LUTZ Co.	1
6	91-05149-02	"U-CUP" SEAL # N4-218-02.562, 2.562 IDx.218w	OMNIPAK/MPI	1
7	90-01017-02	1/4-20x1/2 LG RD.HD.MACH.SCREW # RP312-08.000	STEEL	2
8	98-00999-02	K SEAL 1/4 LOCKWASHER	STEEL	2
9	066B00014263-3	CYLINDER TUBE ø3" I.D.x1/8 x 18 LG	STEEL TUBE	1
10	066C00014266-3	PISTON ROD ø1/2x21 1/2	STEEL	1
11	91-02760-02	ø3.000 O.D.x2.75 I.D.x.125 C.S. "O" RING		1
12	91-02761-02	HOMOGENEOUS "U"CAP-12,.500 I.D.x1.00 O.D.x.250	J.CRANE	1
13	066B00014267	CYLINDER BASE FOR ø3" I.D.CYL.	STEEL	1
14	87-01192-02	COMPRESSION.CONECTORS.1/2x3/8 68A-8C		1
15	75-09671-02	FLANGE BUSHING 1/2 I.D.x3/4 O.Dx1" LG	FB-812-8 BOSTON	1
16	85-02644-02	5/8-11 HEX NUT	STEEL	1
17	70-09688-A2	5/8x2 1/2 ROD END	STEEL	1
18	066B00014265	PISTON ø3" O.D.	STEEL	1
19	91-015148-02	BEARING TAPE PTFE-T-0125-0.750x8 15/16"LG,T-LOG-22 "T-LOG"Inc		1



D66 000C00014272

95-120 RBK000106

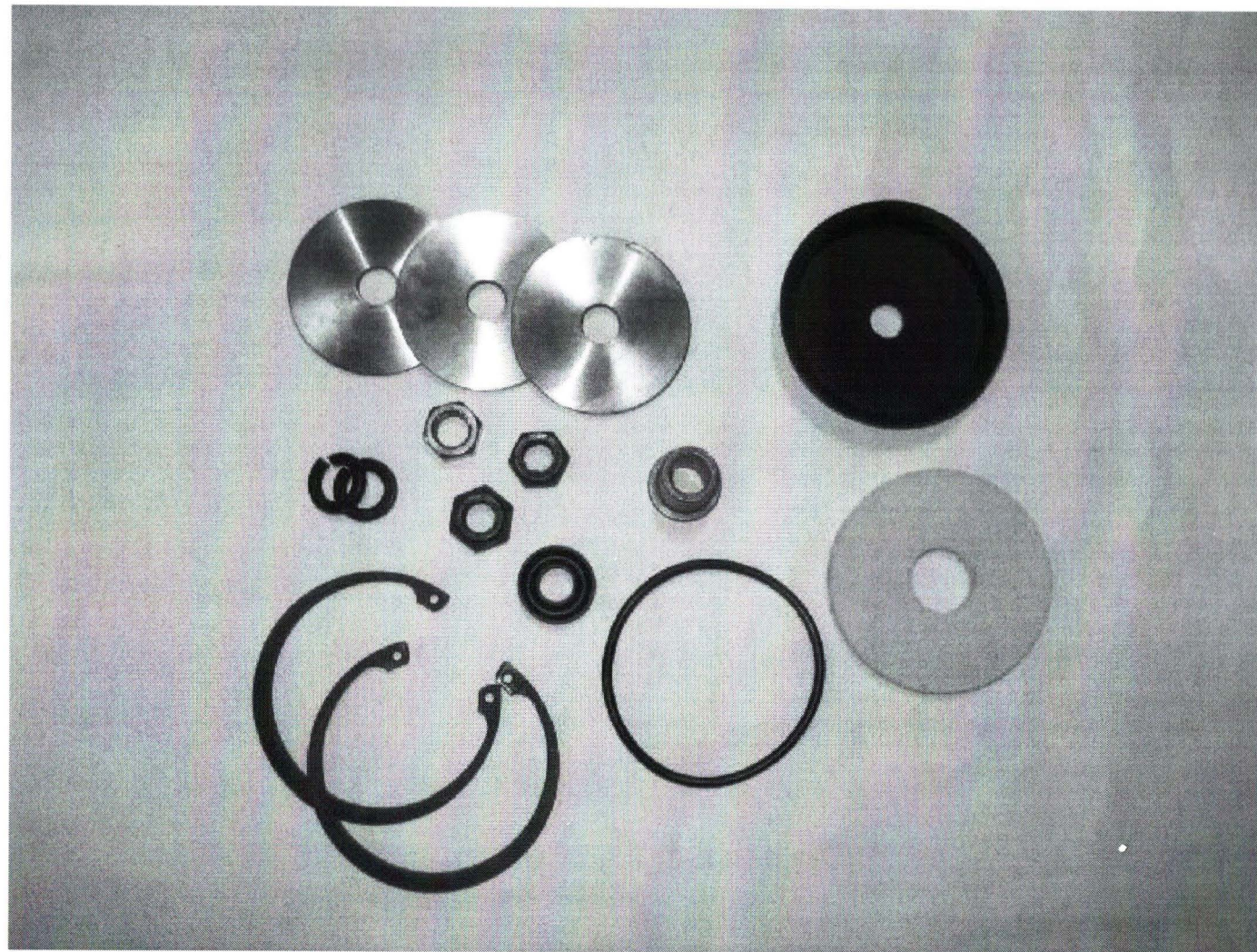
ITEM	PART NO.	DESCRIPTION	MATERIAL	QTY.
1	89-04351-02	RETAINING RING N5000-300	TRUARC	2
2	066A00014262	CYLINDER CAP	H.R.S.	1
3	85-02618-02	1/2"-13 JAM LOCK NUT	STEEL	2
4	98-00925-02	1/2" PLAIN WASHER	STEEL	2
5	910515702	"O" RING 5/8 I.D.c 7/8 O.D.x1/8 # AS-568A-208	RUBBER/LUTZ Co.	1
6	91-05149-02	"U-CUP" SEAL # N4-218-02.562, 2.562 IDx.218w	OMNIPAK/MPI	1
7	90-01017-02	1/4-20x1/2 LG RD.HD.MACH.SCREW # 312-08.000	STEEL	2
8	98-00999-02	K SEAL 1/4 LOCKWASHER	STEEL	2
9	066B00014263-3	CYLINDER TUBE ø3" I.D.x1/8 x 18 LG	STEEL TUBE	1
10	066C00014266-3	PISTON ROD ø1/2x21 1/2	STEEL	1
11	91-02760-02	ø3.000 O.D.x2.75 I.D.x.125 C.S. "O" RING		1
12	91-02761-02	HOMOGENEOUS "U"CAP-12,500 I.D.x1.00 O.D.x.250	J.CRANE	1
13	066B00014267	CYLINDER BASE FOR ø3" I.D.CYL.	STEEL	1
14	87-01192-02	COMPRESSION.CONECTORS.1/2x3/8 68A-8C		1
15	75-09671-02	FLANGE BUSHING 1/2 I.D.x3/4 O.D.x1" LG	FB-812-8 BOSTON	1
16	85-02644-02	5/8-11 HEX NUT	STEEL	1
17	70-09688-A2	5/8x2 1/2 ROD END	STEEL	1
18	066B00014265	PISTON ø3" O.D.	STEEL	1
19	91-015148-02	BEARING TAPE PTFE-T-0125-0.750x8 15/16"LG,T-LOG-22 "T-LOG"Inc		1

3" DIA ACB REBUILD KIT

(RBK000105)

\$101.45

- 3 BACK UP WASHERS
- 1 FELT WASHER
- 1 FLANGE BUSHING
- 1 JAM NUT
- 2 LOCKNUT JAM
- 2 RET RING TRUARC
- 1 O-RING
- 1 PACKING CUP
- 2 LOCKWASHER
- 1 U-CUP



3" DIA ACB REBUILD KIT

(RBK000106)

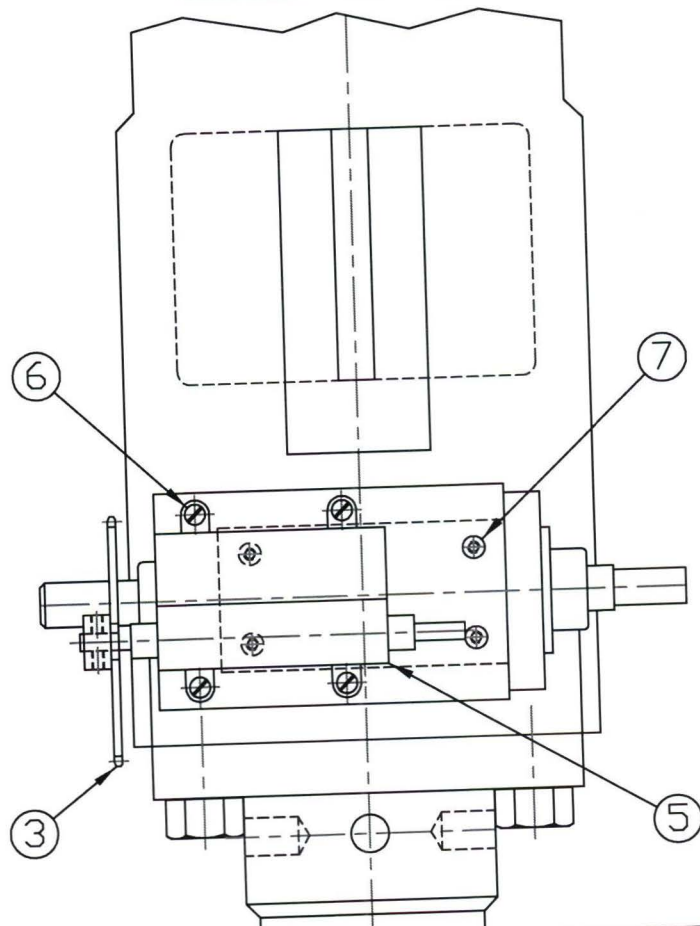
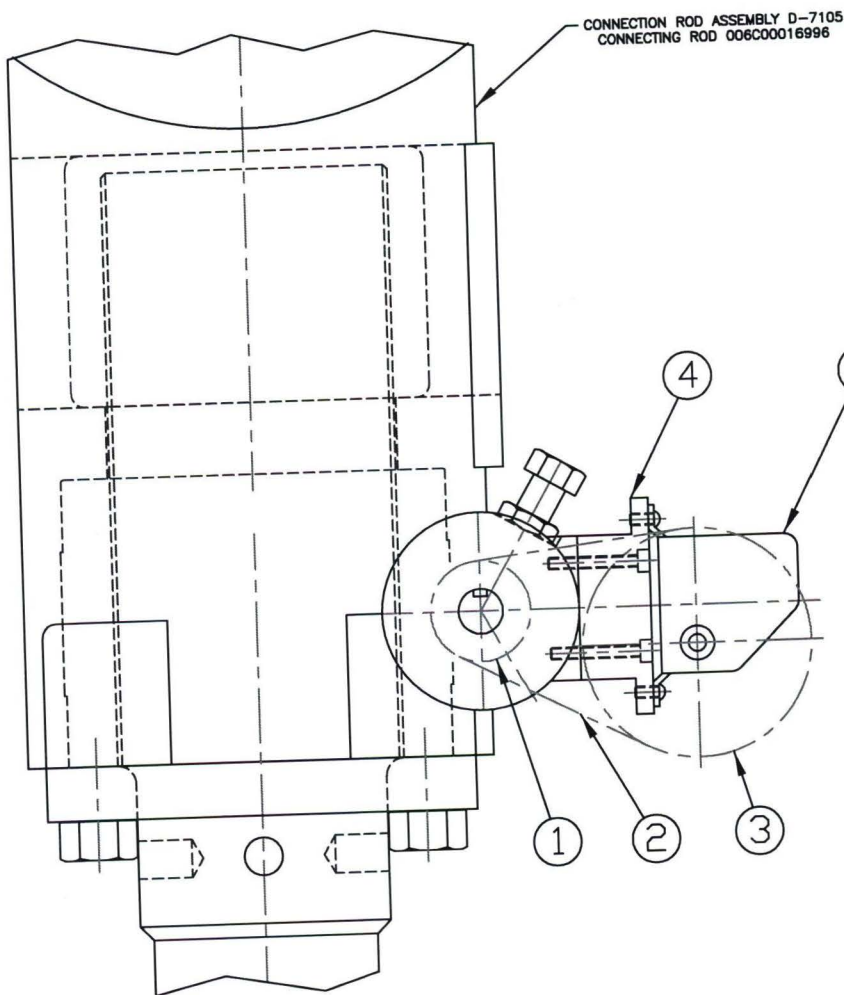
\$119.39

- 1 FLANGE BUSHING
- 2 LOCKNUT JAM
- 2 RET RING TRUARC
- 1 ACB-11 O-RING
- 1 ACB-12 U-CUP
- 1 BEARING TAPE
- 1 ACB-6 U-CUP
- 1 ACB-5 O-RING
- 2 FLAT WASHER



A-161-1 A-161

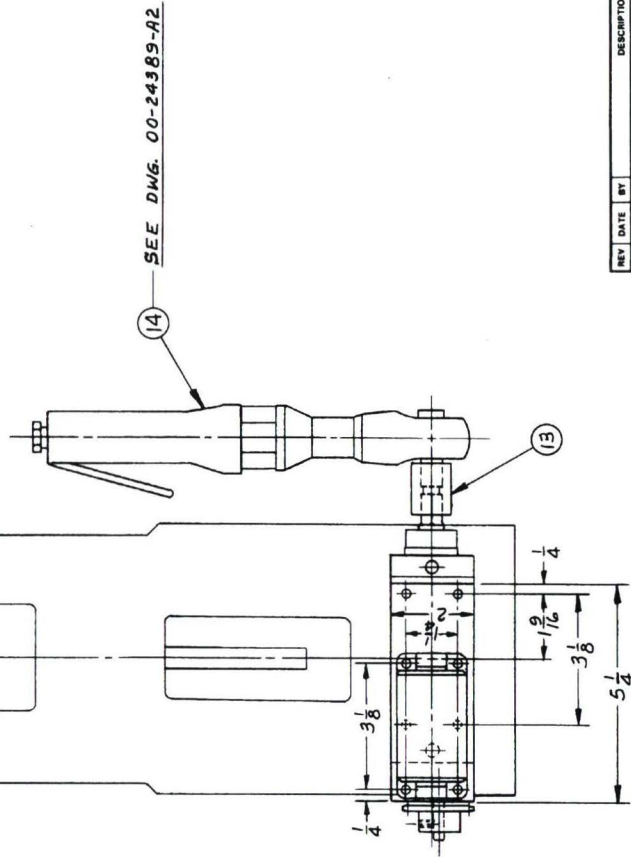
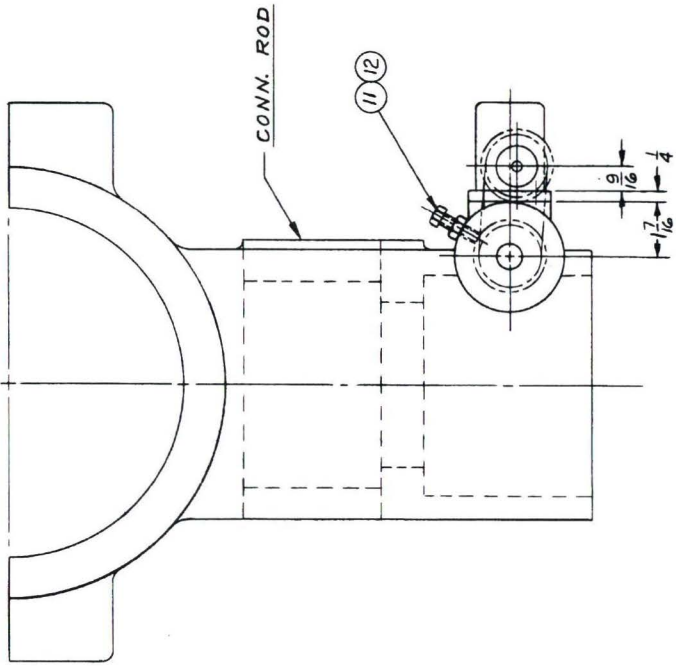
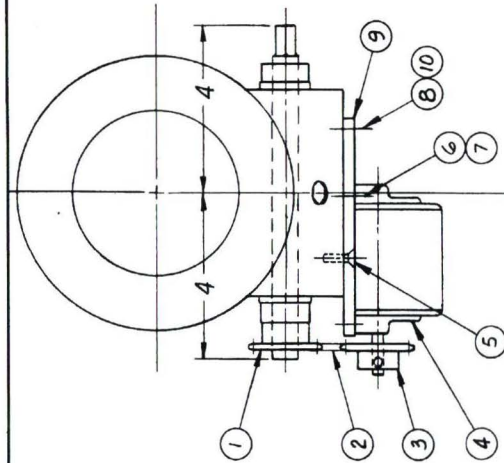
DET	PART NO.	DESCRIPTION	QTY
1	A-338	SPROCKET 25B20, 5/8 BORE	1
2	A-159	NO. 25 CHAIN-16" LG. (64 PITCHES) WITH 1 HALF LINK AND 1 CONNECTING LINK	1
3	000B00023471	SPROCKET ASSEMBLY-25A40, .2362 BORE	1
4	070A00023468	MOUNTING PLATE	1
5	70297002	COUNTER, FARGO NO. RL-136G-5, 10:1 RATIO, TOP GOING	1
6	900225502	8-32 X 3/8 LG. ROUND HEAD SCREW	4
7	90296802	8-32 X 1 1/4 LG. SOCKET HEAD CAP SCREW	4



REVISION DESC.	B1,G1-95,120	P-33568
MODEL	COUNTER ASSEMBLY-FARGO COUNTER	
DESCRIPTION	THIS DRAWING IS THE PROPERTY OF HEIM LP. AND MAY NOT BE COPIED, REPRODUCED, OR USED FOR DESIGN, MANUFACTURE OR SALE WITHOUT PRIOR PERMISSION FROM THE HEIM GROUP	
ALL FINISHES 125 RMS UNLESS OTHERWISE SPECIFIED	FINISHED DIMENSION TOLERANCE DECIMAL +/- .005, FRACTION +/- .015, HOLES +/- 0 DES 30 UNLESS SPECIFIED	DR: EB
OLD:	MATERIAL:	APPR:
NEW:		
The HEIM Group		
6360 W. 73rd Street, Chicago, Illinois 60638 708-498-7400 Fax: 708-498-7428 http://www.heimgroup.com		
TITLE:	COUNTER ASSEMBLY-FARGO COUNTER	
SCALE:	REV. NO.	DWG. NO.
NONE	0	000C00023473

RESS MODEL	PART NO.	FLYWHEEL DIA X WIDTH	V-BELTS	PULLEY	PULLEY BUSHING
L,G1-32 FAC.	D-7812 3-4	29X5	3-A-105	P#970063902 3.6 P.D.	P#970467702 SH-1 3/8 BORE
L,G1-32 GAC.	C-7247 3-G-4-1R	19X3	3-B-75	P#970064102 5.6 P.D.	P#970065002 SD-1 1/8 BORE
L,G1-55 FAC.	D-7812 5-4	36X6	3-B-124	P#970063902 3.6 P.D.	P#970467702 SH-1 3/8 BORE
L,G1-55 GAC.	O.S. C-7247 C-7831-55 (7-4)	24X5	3-B-85	P#970631902 7.0 P.D.	P#970631002 SK-1 1/8 BORE
L,G1-70 FAC	D-7812-7	40X6	3-B-136	P#970063902 3.6 P.D.	P#970630302 SH-1 5/8 BORE
L,G1-70 GAC.	O.S. C-7247 C-7831-70	25 1/2 X 5	3-B-93	P#970455802 6.8 P.D.	P#970064902 SD-1 3/8 BORE
L,G1-95 FAC.	C-7831-95F	42X6	4-B-144	P#970424602 3.4 P.D.	P#970065402 SD-1 5/8 BORE
L,G1-95 GAC.	O.S. C-7247 C-7831-95G	30 1/2 X 4	3-B-108	P#970064302 7.4 P.D.	P#970065302 SK-1 3/8 BORE
L,G1-120 FAC.	C-7831-120F	45X6	4-B-150	P#970424602 3.4 P.D.	P#970065402 SD-1 5/8 BORE
L,G1-120 GAC.	O.S. C-7247 C-7831-120G	34X4	3-B-116	P#970064302 7.4 P.D.	P#970065302 SK-1 3/8 BORE

DET. PART NO.	DESCRIPTION	MATERIAL QTY.
1 A-338	SPROCKET $\frac{5}{8}$ BORE, 25B20	STL. 1
2 A-159	CHAIN #25	STL. 1 F.
3 A-7962	SPROCKET $\frac{1}{4}$ BORE 25B15 55,70 T.	STL. 1
4 83-0211-02	COUNTER#4CS-33705-40-L-CL	DURANT 1
5 90-06628-02	#8-32 x $\frac{3}{4}$ LG. FL.HD. MACH. SCR.	STL. 2
6 90-02229-02	G-32 x $\frac{1}{2}$ LG. RD. HD. MACH. SCR.	STL. 4
7 98-01149-02	#6 SPLIT LOCKWASHER	STL. 4
8 90-06629-02	B-32 x $\frac{3}{4}$ LG. RD. HD. MACH. SCR.	STL. 2
9 A-7960	COUNTER MTG. PLATE	HRS. 1
10 98-03007-02	#8 SPLIT LOCKWASHER	STL. 2
11 90-04364-02	HEX. HEAD BOLT $\frac{1}{2}$ -13x1 $\frac{1}{4}$ LG	BRASS 1
12 85-02618-02	HEX. LOCK NUT $\frac{1}{2}$ -13	STL. 1
13 71-04709-02	$\frac{1}{2}$ SQ. DRIVE $\frac{1}{2}$ HEX SOCKET	1
14 71-04708-02	$\frac{1}{2}$ " AIR RATCHET WRENCH #7339	1

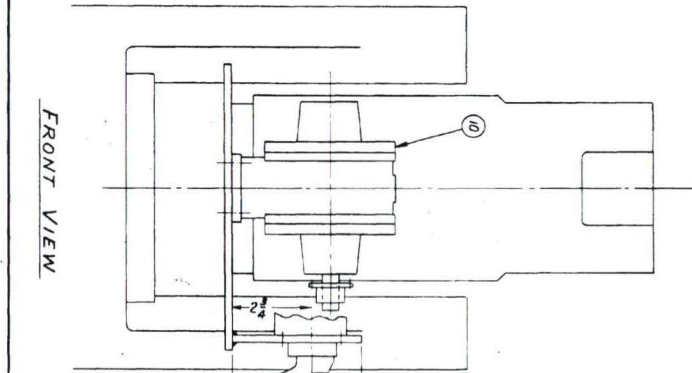
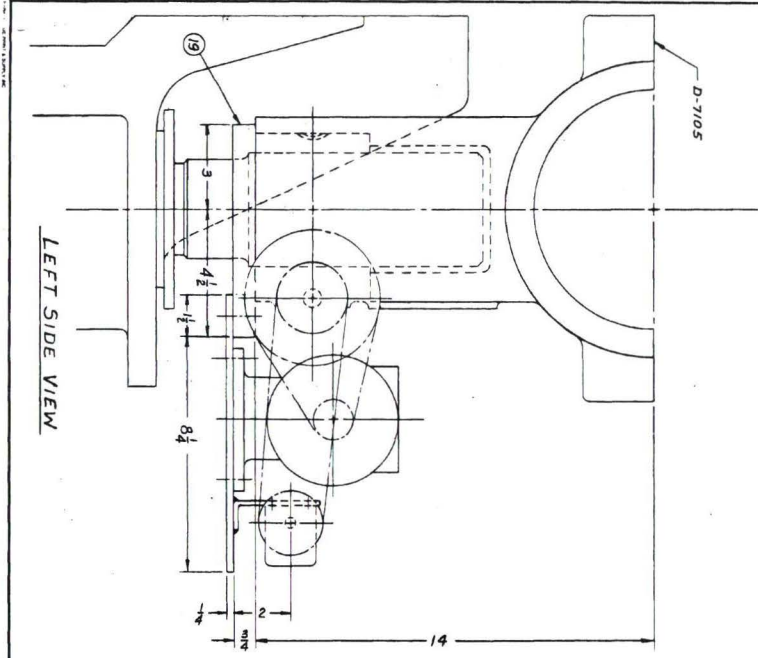


REV.	DATE	BY	DESCRIPTION	ECO NO.

HEIM
 P.O. BOX R.
 FRANKFORD ILL. 60423
 (815) 489-2335

SUPERSEDES: D-7855
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SCALE: 1/2" = 1"
 DATE: 10-31-85
 V.S. 10-31-85
 DESCRIPTION: AIR WRENCH SLIDE ADJUSTMENT ASSY
 USED ON: 55,70 TON
 DRAWING NO.: C-7968
 95, 120 TON
 ALL FINISHES 125, UNLESS OTHERWISE SPECIFIED.



SECTION A-A
(DRG. D-7105 SEC. A-A) REF
ORIGINAL

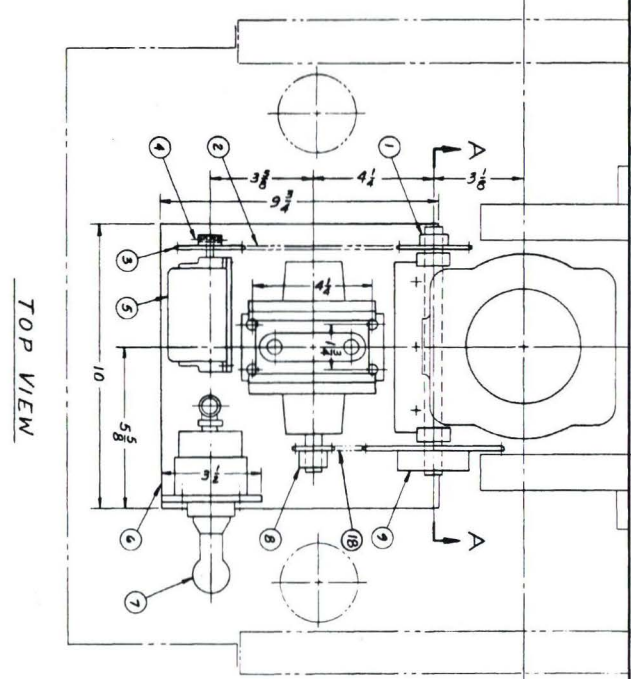
REV.	DATE	BY	DESCRIPTION	ECO NO.

HEIM
 P.O. BOX R.
 FRANKFORD ILL. 60423
 (815) 489-2335

SUPERSEDES: D-7855
 THIS DRAWING IS THE PROPERTY OF HEIM. IT IS TO BE USED ONLY FOR THE MANUFACTURE OR SALE WITHOUT PERMISSION FROM HEIM. IT IS TO BE DESTROYED WHEN NO LONGER REQUIRED.

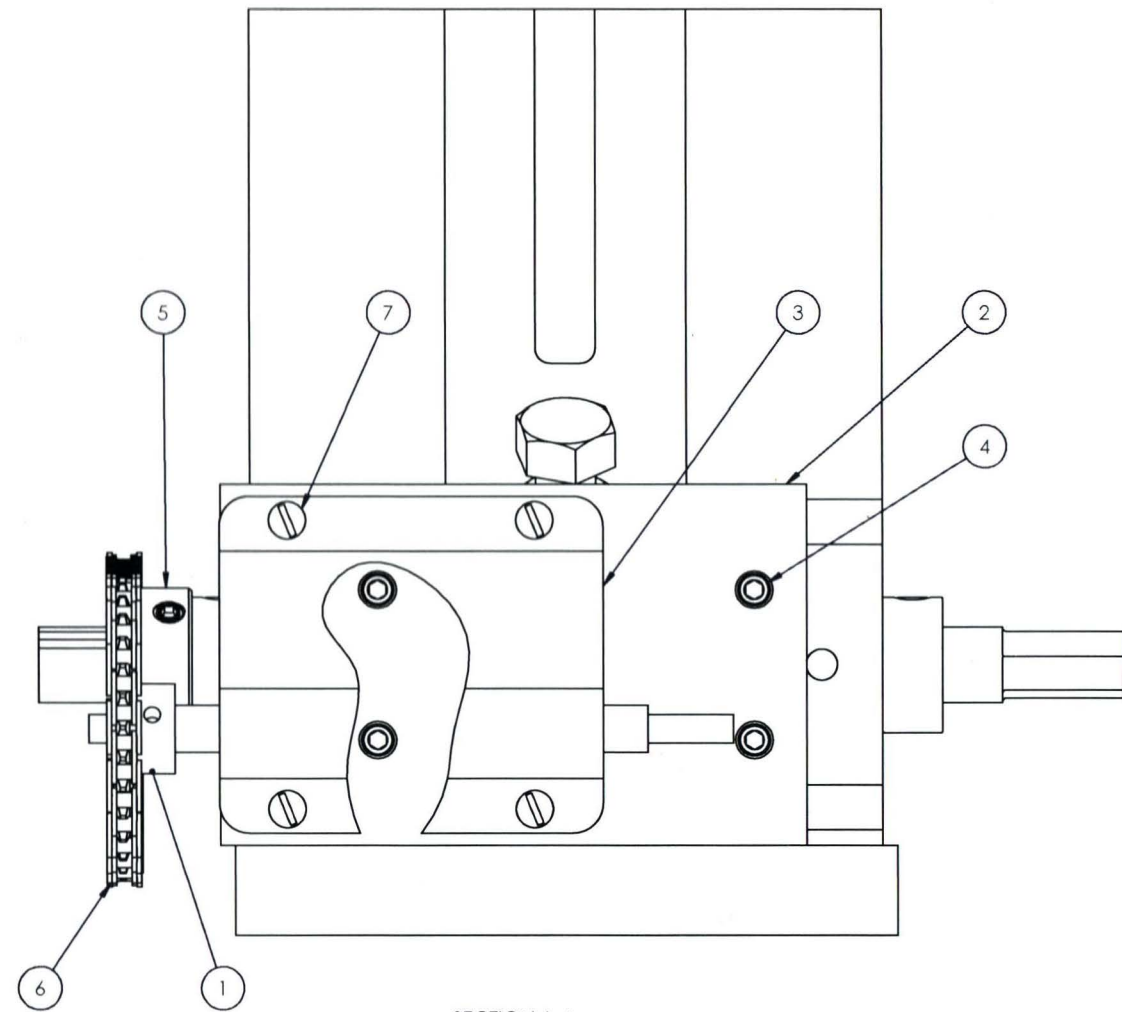
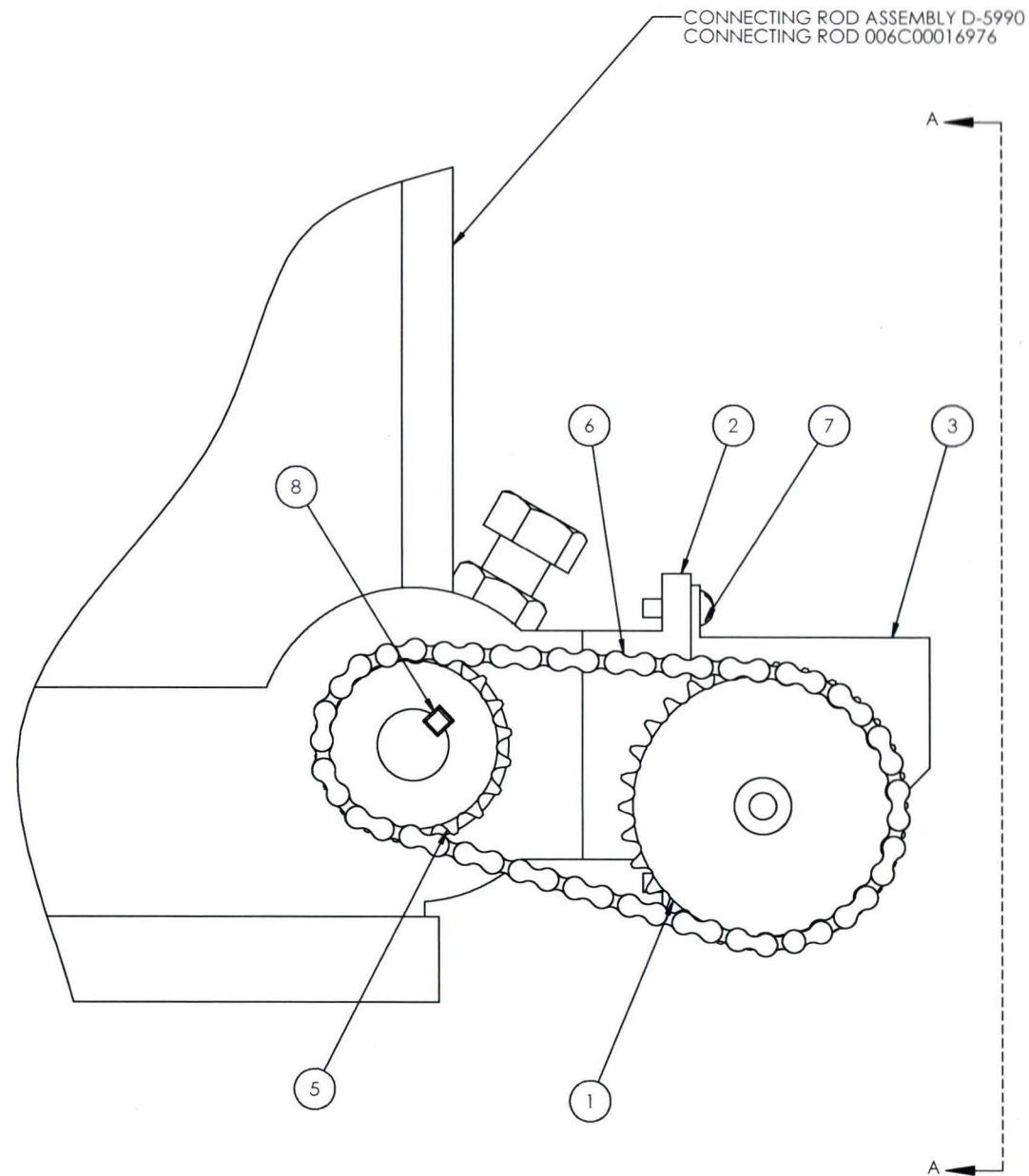
SCALE: 1/2" = 1"
 DATE: 10-31-85
 V.S. 10-31-85
 DESCRIPTION: POWER SLIDE ADJUSTMENT ASSY
 USED ON: 55, 120 TON
 DRAWING NO.: D-7865

USE NEW
R/R WRENCH SLIDE ADJ.
C-7968
10-31-85



DET. PART NO.	DESCRIPTION	MATERIAL QTY.
1 A-338	SPROCKET $\frac{5}{8}$ BORE	STL. 25B20 1
2 A-159	CHAIN #25	STL. 1
3 A-7962	SPROCKET $\frac{1}{4}$ BORE	STL. 25B20 1
4 83-0211-02	COUNTER #4CS-33705-40-L-CL	DURANT 1
5 A-372	COUNTER 4CS-33705-40-L-CL	HRS. 1
6 B-7894	ADJ. MOTOR MTG. PLATE	HRS. 1
7 B-0-0370-02	4-WAY MANUAL VALVE $\frac{1}{2}$ " NPT	3022HC BRASS 1
8 A-817	SPROCKET $\frac{5}{8}$ BORE	STL. 41B10 1
9 A-824-1	SPROCKET $\frac{5}{8}$ BORE	STL. 41B36 1
10 B-1493	AIR MOTOR 6MM. FRY 5A	GAST 1
11 D-559	WORK SHAFT $\frac{5}{8}$ DIA	STL. 1
12 A-339-A	WORM	STL. 1
13 BDC0304	WOODRUFF KEY $\frac{1}{2}$ " x $\frac{1}{2}$ " x 9	STL. 2
14 8088A53	SPACER $\frac{1}{2}$ " ID x 1.00 x 8 TMS	MECHSTEEL 6
15 A-626	WORM SHAFT BEARING	STL. 2
16 A-625	BEARING NUT	STL. 2
17 A-389	SHAFT COLLAR	STL. 2
18 A-166	CHAIN NO. 41	STL. 47
19 D-7105-13	BLOCK WITH POWER SLIDE ADJ.	STL. 1

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	000B000313679	SPROCKET ASSEMBLY-25A30, 0.2362 BORE	1
2	070A00023468	MOUNTING PLATE	1
3	70297002	COUNTER-FARGO NO. RL-136G-5 10:1 RATIO, TOP GOING DIRECTION	1
4	90296802	#8-32 X 1 1/4" SOCKET HEAD CAP SCREW	4
5	A-338	SPROCKET 25B20 5/8 BORE	1
6	#25 CHAIN 12.5	#25 CHAIN 12.5 LG (50 PITCHES)WITH CONNECTING LINK	1
7	900225502	SCREW- RD HD #8-32 X .5	4
8	810659202	KEY 3/16 X 3/16 X 1/2	1



SECTION A-A
SCALE 1 : 1

SERIAL	THIS DRAWING IS THE PROPERTY OF HEIM L.P. AND MAY NOT BE COPIED, REPRODUCED, OR USED FOR DESIGN, MANUFACTURE, OR SALE WITHOUT PRIOR PERMISSION FROM THE HEIM GROUP		DATE
ALL FINISHES 125 RMS UNLESS OTHERWISE SPECIFIED	REF: 000C00023475	FINISHED DIMENSION TOLERANCE DECIMAL +/- 0.005 FRACT. +/- 0.015, ANGLES +/- 0 DEG 30' UNLESS SPECIFIED. REMOVE BURRS, BREAK SHARP CORNERS	DR: MC 9/10/21
OLD: NEW:	MODEL B1,G1 55,70	MATERIAL	CKD: C DAE
The HEIM Group		TITLE DESCRIPTION	SHEET OF
6360 W. 73rd Street Chicago, Illinois 60638 708-496-7450 Fax: 708-496-7428 parts fax 708-496-0708		SCALE WEIGHT(lbs) SIZE DWG. NO 000C000313680	REV. NO. 0

000C000313680