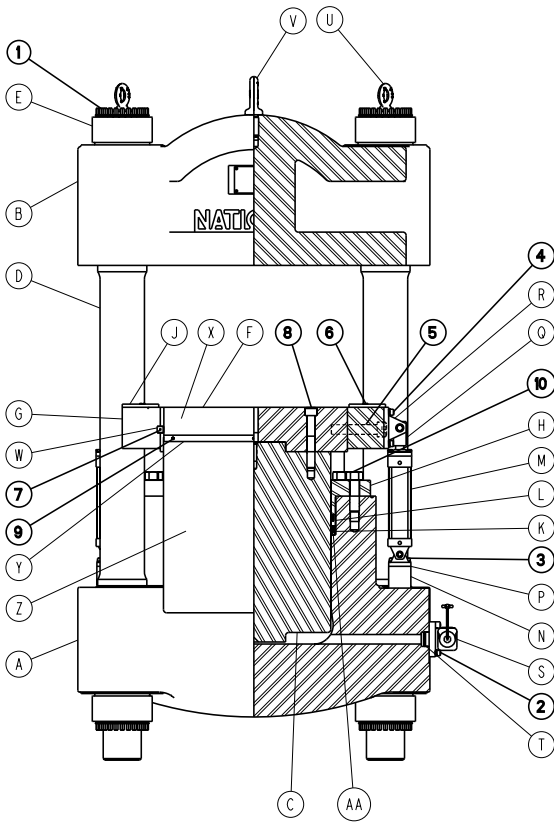
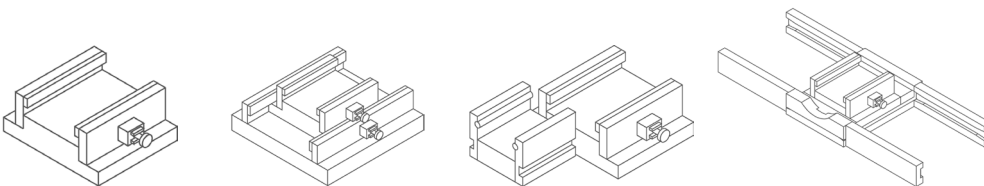


“NEW STYLE” NATIONAL HYDRAULIC SWAGING MACHINE TORQUE MAINTENANCE INFORMATION



Item	No. Req'd.	Description
A	1	Cylinder
B	1	Housing Cap
C	1	Piston
D	4	Tie Rod
E	8	Tie Rod Nut
F	1	Platen
G	2	Guide
H	1	Gland
J	4	Bushing
K	1	Mono Seal
L	1	Seal Spacer
M	2	Side Cylinder
N	2	Side Cylinder Mount
P	2	Lower Bracket
Q	2	Knuckle
R	2	Upper Bracket
S	1	Check Valve
T	1	Check Valve Seal
U	4	Tie Rod Eyebolt
V	1	Cap Eyebolt
W	4	Key
X	2	Bumper
Y	2	Bumper Strip
Z	2	Rubber Skirt
AA	1	Bottom of Seal Cavity

Table B						
Item No.	No. Req'd.	Description	Torque in Ft-Lbs			
			500 Ton Swaging Machine	1000 Ton Swaging Machine	1500 Ton Swaging Machine	Maintenance Schedule
1	Varies	Tie Rod Nut Jack-Bolts	105	N/A	260	Weekly
2	4	Check Valve Bolts	100	100	100	Weekly
3	8	Lower Bracket Bolts	100	100	100	Weekly
4	8	Upper Bracket Bolts	100	100	100	Weekly
5	4	Guide Bolts	250	250	250	Weekly
6	8	Bushing Screws	15	15	15	Weekly
7	4	Key Screws	4	4	4	Weekly
8	4	Platen Bolts	525	600	700	Monthly
9	6	Bumper Apron Screws	4	4	4	Monthly
10	12	Gland Bolts	700	800	800	Monthly



	Bolt Size Thread Form	Torque in ft./ lbs.
Die Holder Bolt Torque	1/4 20 UNC	13
	5/16 18 UNC	15
	5/8 11 UNC	211
	7/8 9 UNC	583