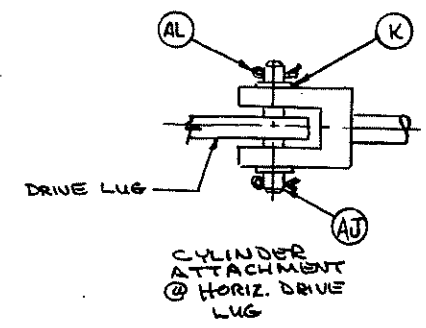
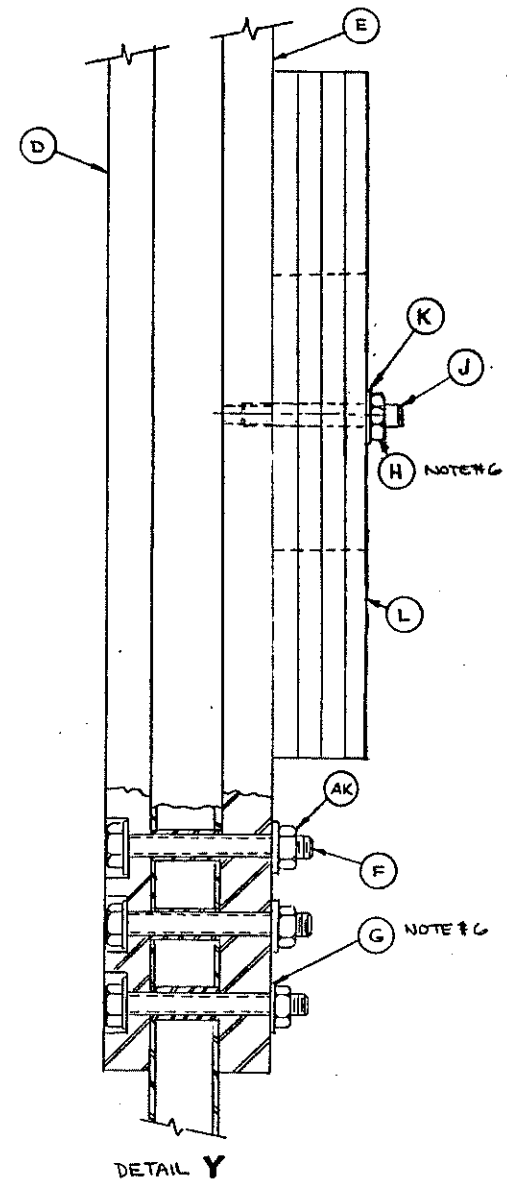
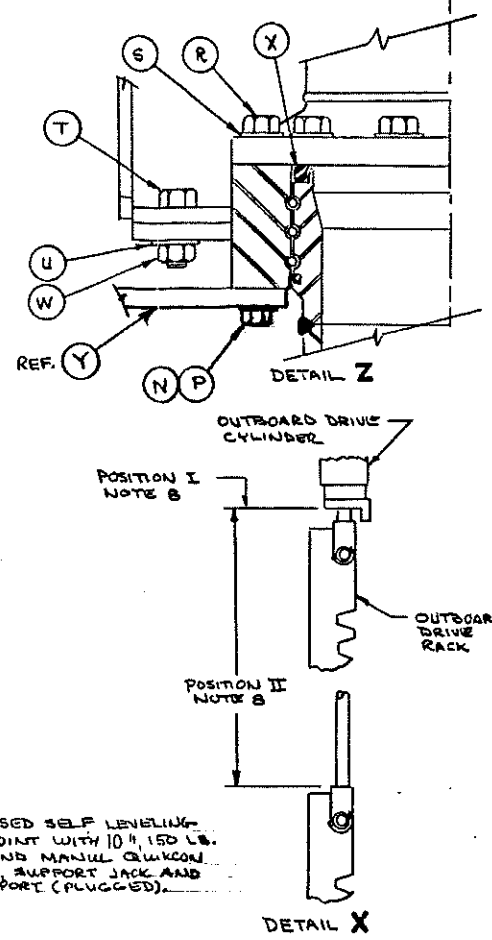


- NOTES:
1. RCMA DENOTES "ROTARY COUNTERWEIGHT MARINE ARM".
  2. FASTENER FINISHES PER SPECIFICATION, PE-1.
  3. BASE RISER (ITEM C) TO BE INSTALLED BY INSERTING SHIMS AT BASE TO LEVEL FACE OF COUPLING. (SEE INSTALLATION INSTRUCTIONS).
  4. ARM IS BALANCED EMPTY AND MUST BE DRAINED OF PRODUCT BEFORE MOVING TO OR FROM VESSEL. MEANS OF DRAINAGE BY OTHERS.
  5. ADD TRIM WEIGHTS (ITEM "AG") AS REQUIRED FOR INBOARD ARM TO HAVE A SLIGHT TENDENCY TO RETURN TO THE STORED POSITION.
  6. TORQUE ITEM "H" TO 250 FOOT POUNDS & THE NUT OF ITEM "F" TO 650 FOOT POUNDS.
  7. ASSEMBLY HAS BEEN PAINTED PER 16629-31.
  8. RACK & PINION GEAR LOCATIONS:  
 POSITION I:  
 WITH INBOARD ARM IN THE STORED POSITION (AS SHOWN) THE HYDRAULIC CYLINDER ROD END AND RACK ARE TO BE FULLY RETRACTED WITH ONLY 15 1/16" OF ROD EXPOSED.  
 POSITION II:  
 WITH OUTBOARD ARM (AND ROTARY COUNTERWEIGHTS) 90° TO INBOARD ARM, THE AMOUNT OF EXPOSED CYLINDER ROD ON THE RACK END IS TO BE 15 1/32" ± 3/16".
  9. LUBRICATE CYLINDER TRUNNION PINS AT TIME OF ASSEMBLY WITH FMC # 315574 (#7) GREASE.



ITEM	REQUIRED	PART NUMBER	DESCRIPTION, MATERIAL AND SPECIFICATION (ALL PURCHASED PARTS AS SPECIFIED ON EQUAL)	EST WEIGHT
AP	1	16629-26A	STRIPPING LINE DETAIL	9
AN	1	16629-27A	HYD. TUBING DETAIL - VACUUM BREAKER	3
AM	1	16629-328A	TRAVEL LIMIT ALARM	-
AL	2	3226777	PIN - COTTER, 1/4 DIA. X 2", STL.	-
AK	6	3243831	NUT, HEX, 1" - BNC, A325, STL.	-
AJ	1	3125245	PIN, CYLINDER, 1" DIA. X 3 3/4" LG., STL.	1
AH	1	16629-29A	TUBING DETAIL ON ARM	-
AG	7	N100984	TRIM WEIGHT, FIXED, STL.	82
AF	2	N100983	FIXED LOCK, STAINLESS STEEL	-
AE	3	N100974	RAIL SPLICE CONNECTOR, SST.	-
AD	2	N100982	LADDER SECTION W/ CUT-OUTS, 2 BM	70
AC	1	N100973	LADDER SECTION, 2 BM, STL, GALV.	35
AB	6	N100972	LADDER CLAMP W/ SET SCREW, STL. GALV.	12
AA	2	3238919	NUT - JAM, HEX, 2" - 4 1/2 UNC, STL.	1
Z	2	3103480	SCREW - ADJUSTMENT, STEEL	6
Y	1	16617-8A	MTG. BRKT. HORIZ CYLINDER, STL.	86
X	1	3115389	PACKING - 12" LPS (HM/ SST)	-
W	8	3155678	NUT - REG. HEX, 1 1/4" - 7, STEEL	5
U	8	3239763	WASHER, ASA NARROW, 1 1/4", STL.	1
T	8	3152047	BOLT - REG. HEX. HD, 1 1/4" - 7 X 4", STL.	17
S	12	3239761	WASHER - ASA NARROW, 7/8", STL.	1
R	12	3238152	SCREW - CAP, HEX. HD, 7/8" - 9 X 2 1/2", STL.	8
P	4	3238957	WASHER - ASA NARROW, 3/4", STL.	-
N	4	3238916	SCREW - CAP HEX. HD, 3/4" - 10 X 2", STL.	2
M	1	3155552	CYLINDER - HYDRAULIC, 3 1/2" X 17", STL.	86
L	5	16600-636	TRIM WEIGHT - ROTARY, STEEL	835
K	8	3238984	WASHER - ASA WIDE, 1", STEEL	2
J	2	3140117	STUD BOLT, 1" - 8 X 5" STEEL	2
H	6	3239497	NUT - HVY. HEX, 1" - 8, STEEL	3
G	12	3154030	WASHER - ASA, 1", A325 - STL.	2
F	6	N101449	BOLT - HEX. HD, 1" - 8 X 10 1/2", A325 - STL.	16
E	1	16629-61A	COUNTERWEIGHT, SECONDARY, STEEL	485
D	1	16629-62A	COUNTERWEIGHT, MAIN, STEEL	2158
C	1	16629-304A	RISER ASSEMBLY	457
B	1	16629-303A	ARM ASSEMBLY	770
A	1		MECHANICAL ASSEMBLY	2143

REVISIONS 1. 10/1/93 BY GILL 2. 10/1/93 BY GILL 3. 10/1/93 BY GILL		DATE: 10/1/93 DRAWN: GILL CHECKED: GILL	
DIMENSION TOLERANCES FRACTIONAL - ± .005 DECIMAL - ± .005 ANGULAR - ± .005		REF. NEXT ASSY: 16629-1 SCALE: NONE DATE: 12-3-92 APP'D: [Signature] SHEET: 302	
MECHANICAL ASSEMBLY 10" 60-0" FULLY POWERED RCMA LEFT HAND, REVERSED STYLE 80			