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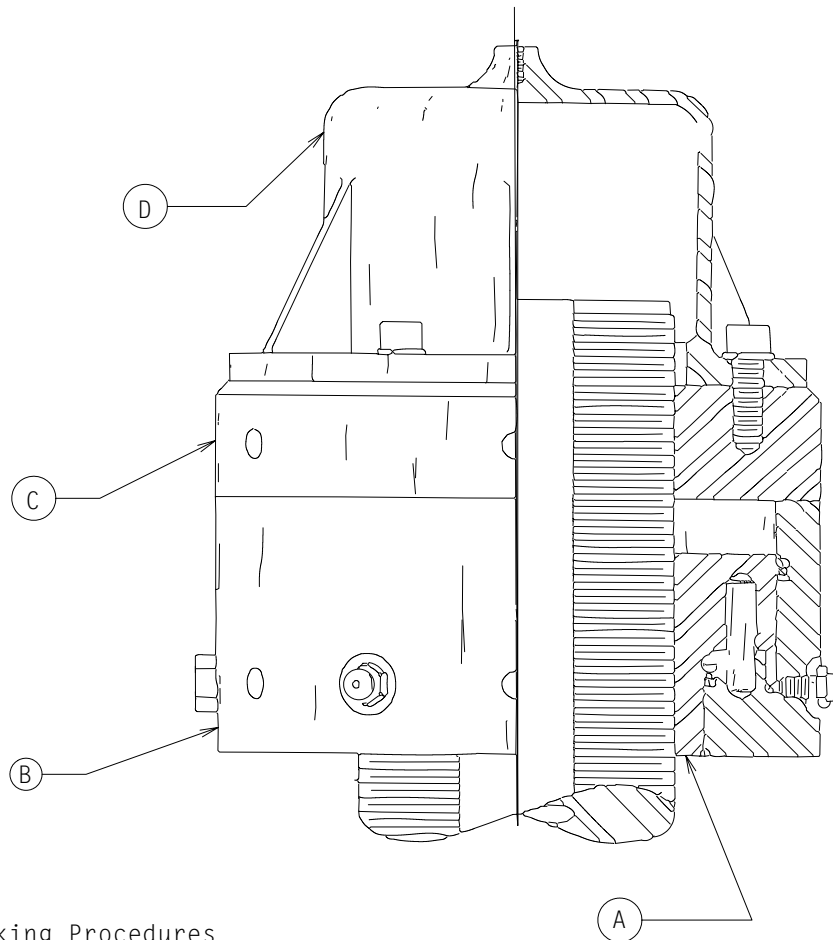
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Jacking Pressure Chart

| Hammer Size | Pressure PSIG | U.S. Tons |
|--|---------------|-----------|
| 020, 030, 320 330, 520, 530 3100, 5100 | 3925 | 40 |
| 040, 340, 540 | 3950 | 60 |
| 060, 360, 560 5150 | 3500 | 60 |



Installation and Jacking Procedures

- 1) Screw Piston (A) and Cylinder (B) together onto cable fitting.
- 2) Using manual jack, take up slack from cable.
- 3) Using grease gun, pump to required pressure (see table above).
- 4) Screw lock nut (C) tight against Auto-Jack cylinder (B).
- 5) Install thread protector cap (D).

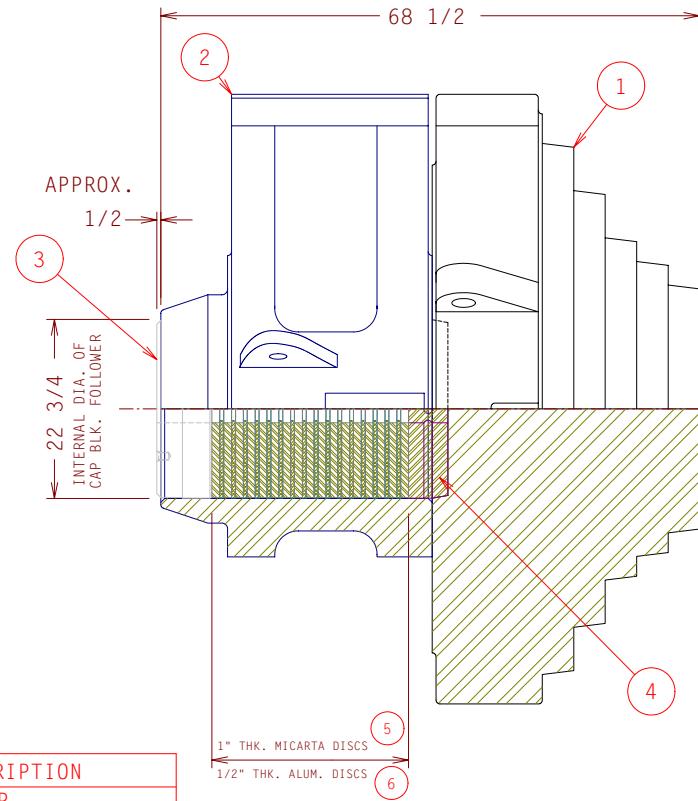
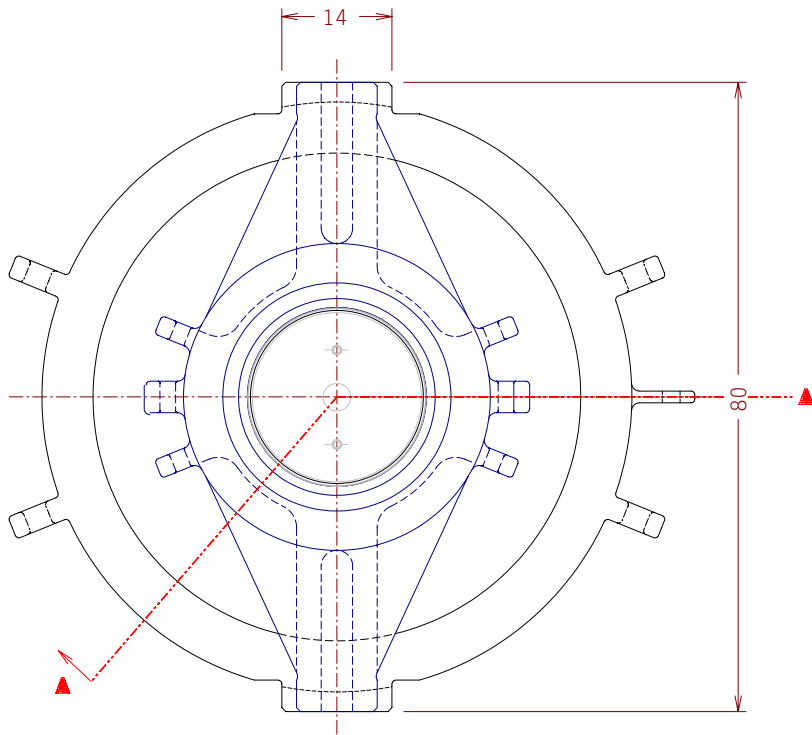
Unless Otherwise Specified:
 Surfaces: Square, parallel, concentric, and straight within 0.04%
 Machine Decimal Dimensions within $\pm .005"/0.1mm$
 All Other Dimensions within $1/64" / 0.4mm$ (Sand Case $1/8" / 3mm$)
 Angles within ± 0 Deg. 30 min. Break all sharp corners.

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| Rev. | Description | Date | By |
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| <h1>Vulcan Iron Works Inc</h1> | | | |
| Part No. | | Pattern No. | |
| Rgh/Fin Wt. | | Mat'l | |
| By | Date | Name Auto-Jack | |
| Drawn <i>D C Warrington</i> | 3 18 91 | General Arrangement and Instruction | |
| Chk'd | | <h2>A-11997</h2> | |
| Appv'd | | | |

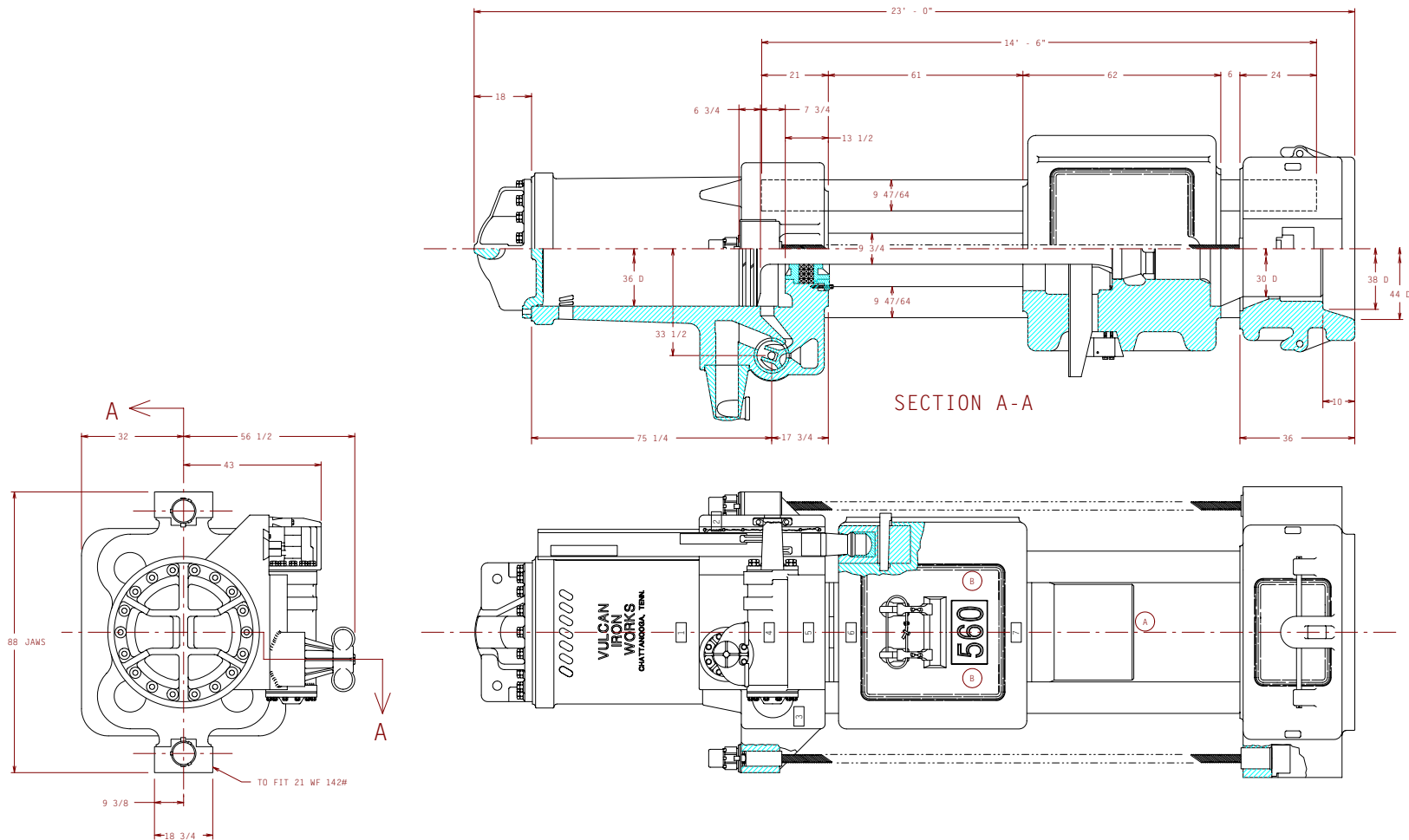
| Rev. | Description | Date | By | App'vd. | Rev. | Description | Date | By | App'vd. | Rev. | Description | Date | By | App'vd. | Rev. | Description | Date | By | App'vd. | Rev. | Description | Date | By | App'vd. |
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| KEY | QTY. | DWG# | P/N | DESCRIPTION |
|-----|------|---------|---------|--------------------|
| 1 | 1 | D-13358 | 13358 | PIPE CAP |
| 2 | 1 | D-13360 | 13360 | CAP BLOCK FOLLOWER |
| 3 | 1 | A-12247 | 09A1001 | TOP PLATE |
| 4 | 1 | A-12246 | 09A1004 | BOTTOM/KEY PLATE |
| 5 | 16 | A-12240 | 09A1002 | MICARTA DISCS |
| 6 | 17 | A-12241 | 09A1003 | ALUM. DISCS |

| | | | | | | | | | | | | | |
|-----|-------|-----------|------|----------|---|---|---|-----------|--|-----------|---------|---------|------|
| P/N | Drawn | D. COOPER | Date | 07/22/93 | <small>NOTICE: This drawing discloses confidential ideas and information that are the property of VULCAN IRON WORKS, INC., and a special confidential disclosure is made herein under an implied and continuing promise of good faith and secrecy that disclosure and use of the trade secrets shall not be made without the prior written authorization of VULCAN IRON WORKS, INC., P.O. Box 8400, Chattanooga, TN, 37408.</small> | Vulcan Iron Works Inc. Chattanooga, TN |  | Pattern # | | Rough Wt. | | D-13469 | Rev. |
| | Chk'd | | | | | | | Material | | Fin. Wt. | 39,300# | Name | |

| Rev. | Description | Date | By | App'vd. | Rev. | Description | Date | By | App'vd. | Rev. | Description | Date | By | App'vd. | Rev. | Description | Date | By | App'vd. | Rev. | |
|------|------------------------|----------|-----|---------|------|-------------|------|----|---------|------|-------------|------|----|---------|------|-------------|------|----|---------|------|--|
| A | MODIFIED RAM POINT | 11-7-73 | | | | | | | | | | | | | | | | | | | |
| B | REMOVED RAM LUGS | 11-14-73 | | | | | | | | | | | | | | | | | | | |
| C | REMOVED RAM POINT PINS | 11-20-78 | | | | | | | | | | | | | | | | | | | |
| D | REDRAWN IN CAD | 9-12-94 | RLS | | | | | | | | | | | | | | | | | | |



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|-----|--------|-----|------|---------|--|---|-----------|--|-----------|--|---|------|--|
| P/N | Drawn | RLS | Date | 9-12-94 | NOTICE: This drawing discloses confidential ideas and information that are the property of VULCAN IRON WORKS, INC., and a special confidential disclosure is made herein under an implied and continuing promise of good faith and secrecy that disclosure and use of the trade secrets shall not be made without the prior written authorization of VULCAN IRON WORKS, INC., P.O. Box 8400, Chattanooga, TN, 37408. | Vulcan Iron Works Inc. Chattanooga, TN | Pattern # | | Rough Wt. | | D-11006 Name GENERAL ARRANGEMENT 560 OFFSHORE HAMMER | Rev. | |
| | Chk'd | | | | | | Material | | Fin. Wt. | | | D | |
| | App'vd | | | | | | | | | | | | |

