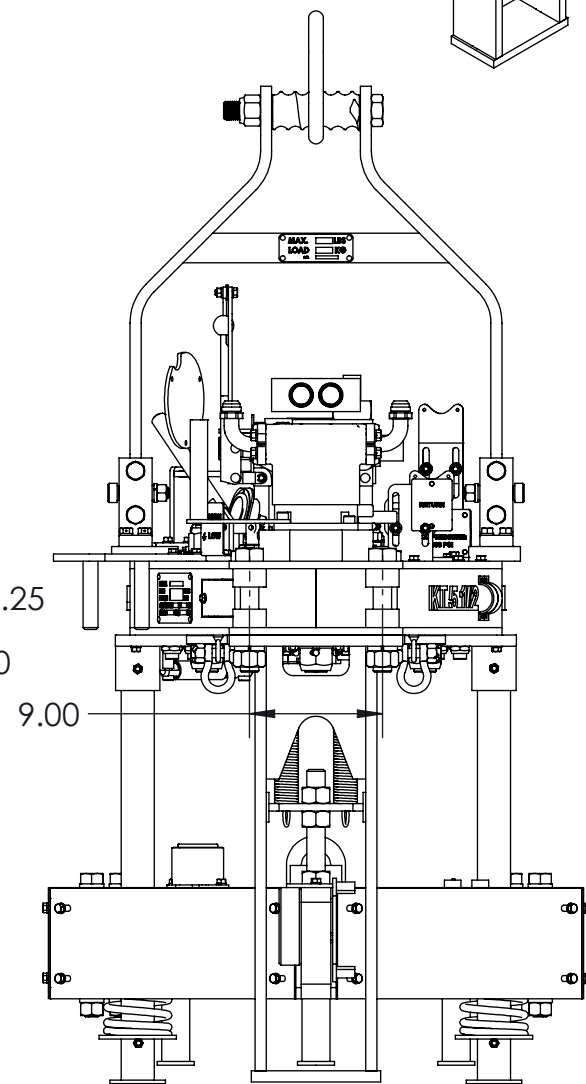
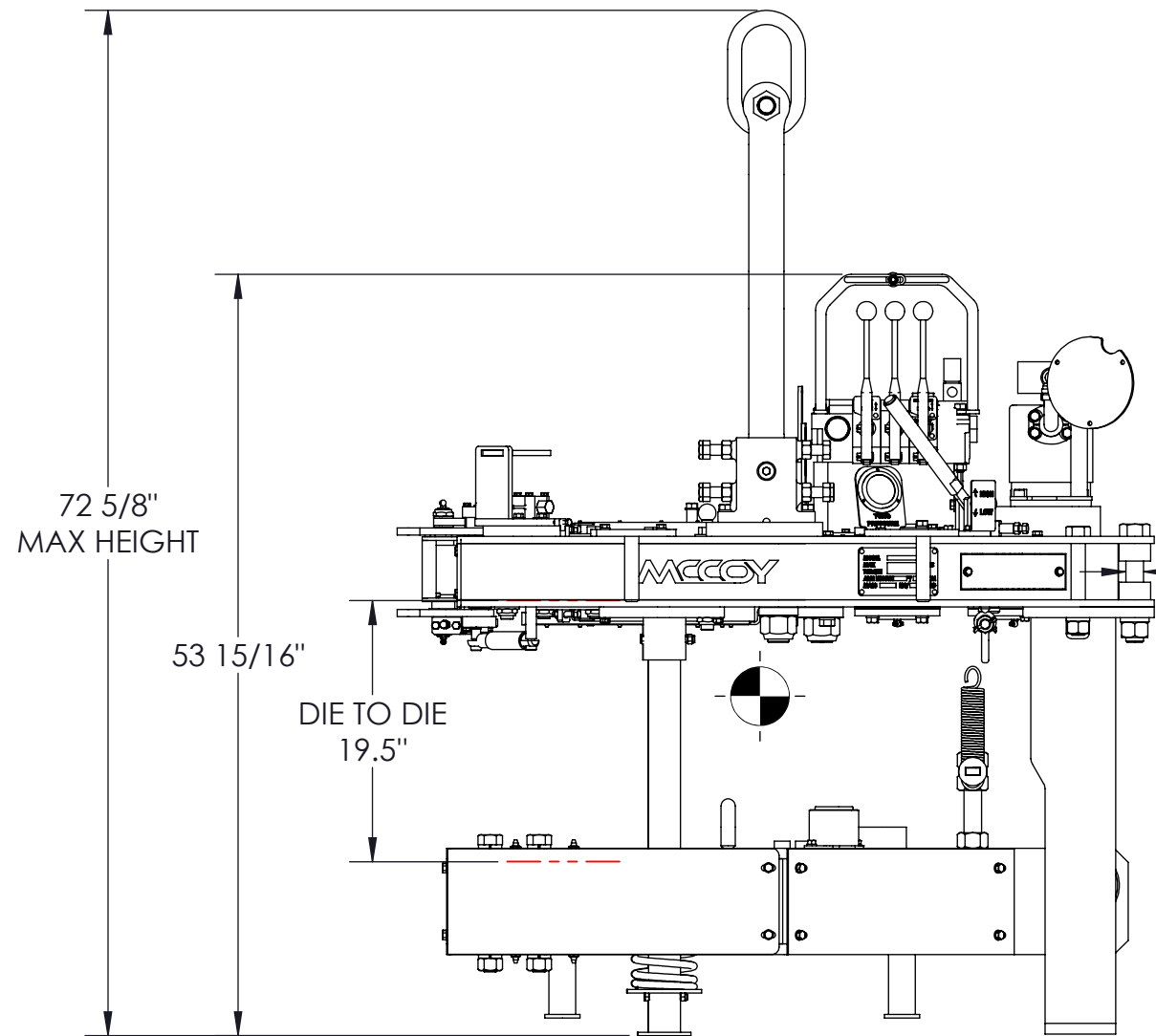


ITEM	QTY	P/N	DESCRIPTION
1	1	85-0398	ASSEMBLY, BACK UP
2	1	80-0420-29	ASSEMBLY, TONG, 5500-18K7
3	1	MK5500-1	MOUNTING KIT, 6-1/4 CLINCHER BU, KT5500

TONG SPECIFICATION		
MAX TORQUE (FT · LBS/N · M)	18,700	25,357
ARM LENGTH (INCH/CM)	32.0	81.3
MASS (LBS/KG)	2,200	999
TORQUE (FT LBS/N M, ESTIMATED)		
AT PRESSURE (PSI/BAR):	2,250	155
Hi/Full	3,740	5,071
Lo/Full	18,700	25,357
SPEED (RPM, ESTIMATED)		
AT FLOW RATE (GPM/LPM):	60	227
Hi/Full	77.0	
Lo/Full	15.4	



SYSTEM MAX TORQUE CAPACITY (FT LB)		
PIPE DIAMETER (IN)	STEEL DIES	GRITFACE DIES
*6.250 DOWN TO 5.500	18.7K	
**5.500		
DOWN TO 4.500	13K	13K
DOWN TO 4.000	11K	11K
DOWN TO 3.375	8K	
DOWN TO 3.000	6.5K	
DOWN TO 2.875	5.5K	
DOWN TO 2.375	4K	
* BACKUP MAXIMUM PIPE DIAMETER IS 6.250"		
** TONG MAXIMUM PIPE DIAMETER IS 5.500"		

UNDER REVISION

UNLESS OTHERWISE SPECIFIED:  
 1. DIMENSIONS ARE IN INCHES  
 2. TOLERANCES:  
 ANGULAR ± 1°  
 FRACTIONAL ± 1/16  
 TWO PLACE DECIMAL ± 0.02  
 THREE PLACE DECIMAL ± 0.005  
 3. IDENTIFY P/N & MAIL P.O. USING 1/8 TO 1/4 ETCHED LETTERS, DENOTED BY "X"  
 4. REMOVE BURRS & SHARP EDGES WITH 1/64x45° MAX  
 5. MACHINED FILET RADII SHALL BE 1/32  
 6. FINAL SURFACE ROUGHNESS AVG. (Ra) SHALL BE ≤ 250 MICROINCHES  
 7. ○ DENOTES CRITICAL DIMENSION; 100% INSPECTION REQUIRED  
 8. A TRIANGLE DENOTES A REVISION  
 9. INTERPRET DRAWING PER ASME Y14.5-2009

PROPRIETARY STATEMENT		
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DRAWN	S.PANCHAL	01/11/2016
CHECKED	R.RAHMAN	01/16/2016
APPROVED	R.RAHMAN	01/16/2016
THIRD ANGLE PROJECTION	WEIGHT	2079.0 LBS.

DESCRIPTION		
ASSEMBLY, TONG, 5500-18K7 X 6250 CLINCHER BU, COMPRESSION, CC		
SIZE	PART NO.	REV
B	80-0421-14	A
MATERIAL	SHEET 1 OF 1	
N/A		