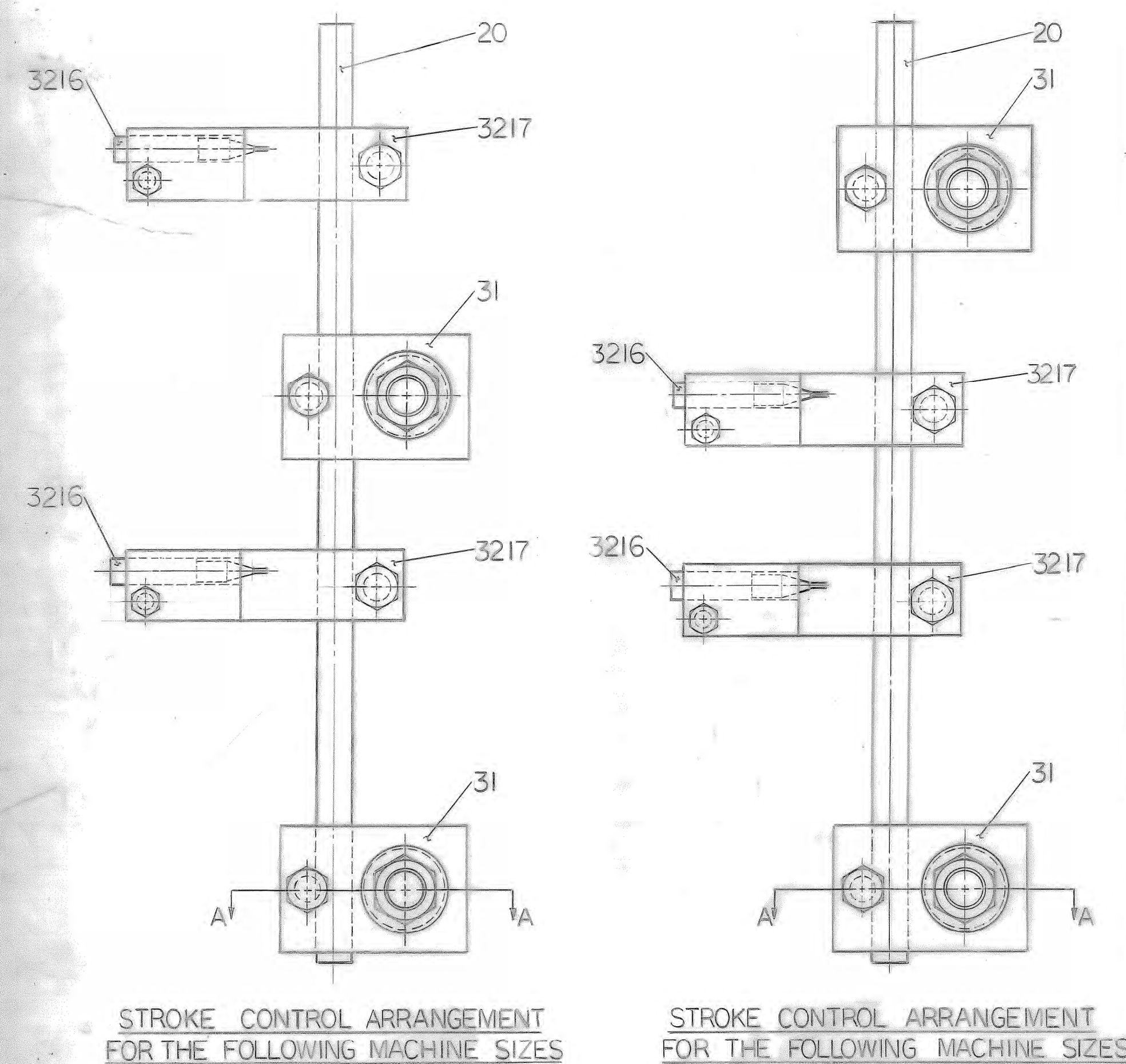
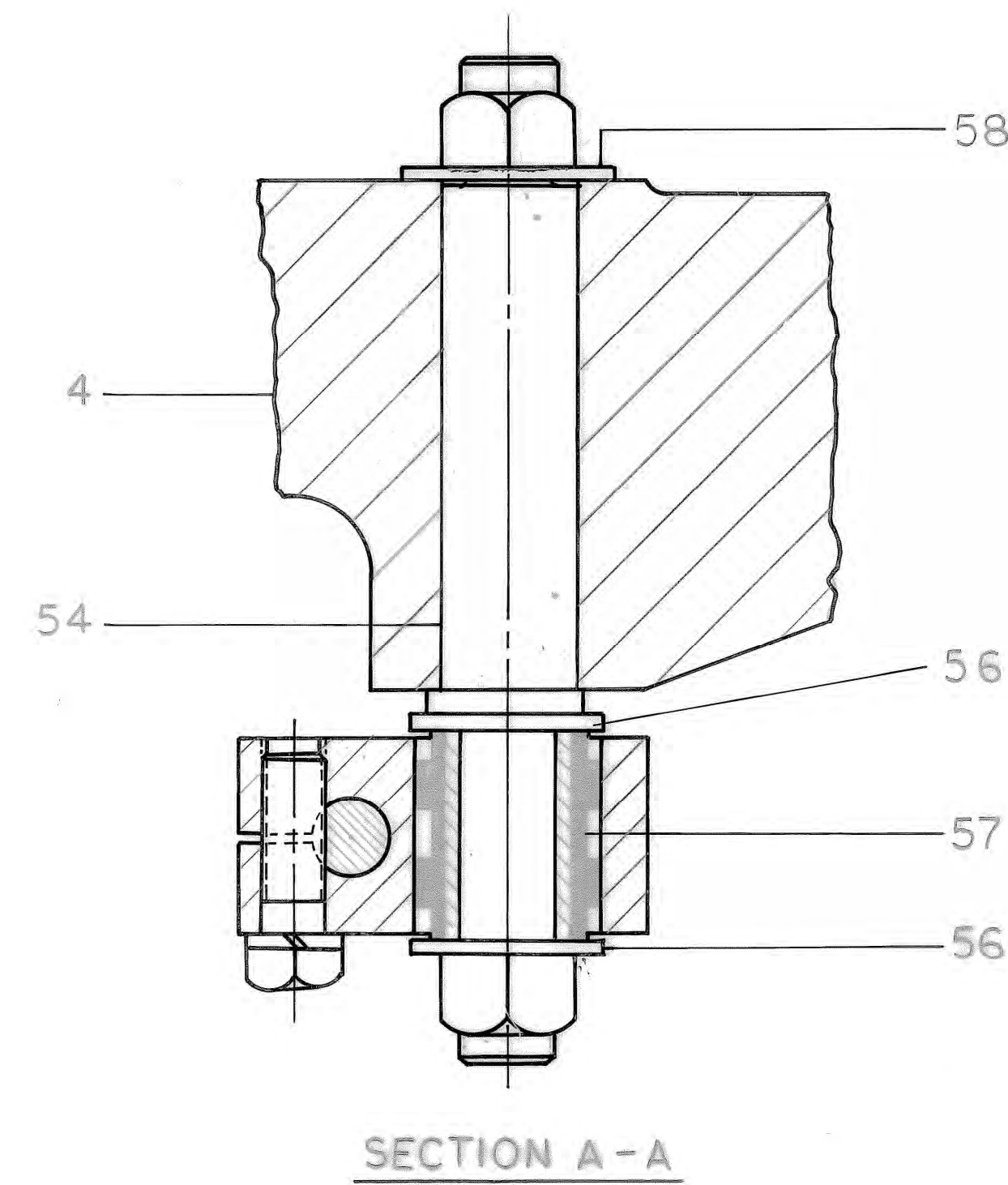
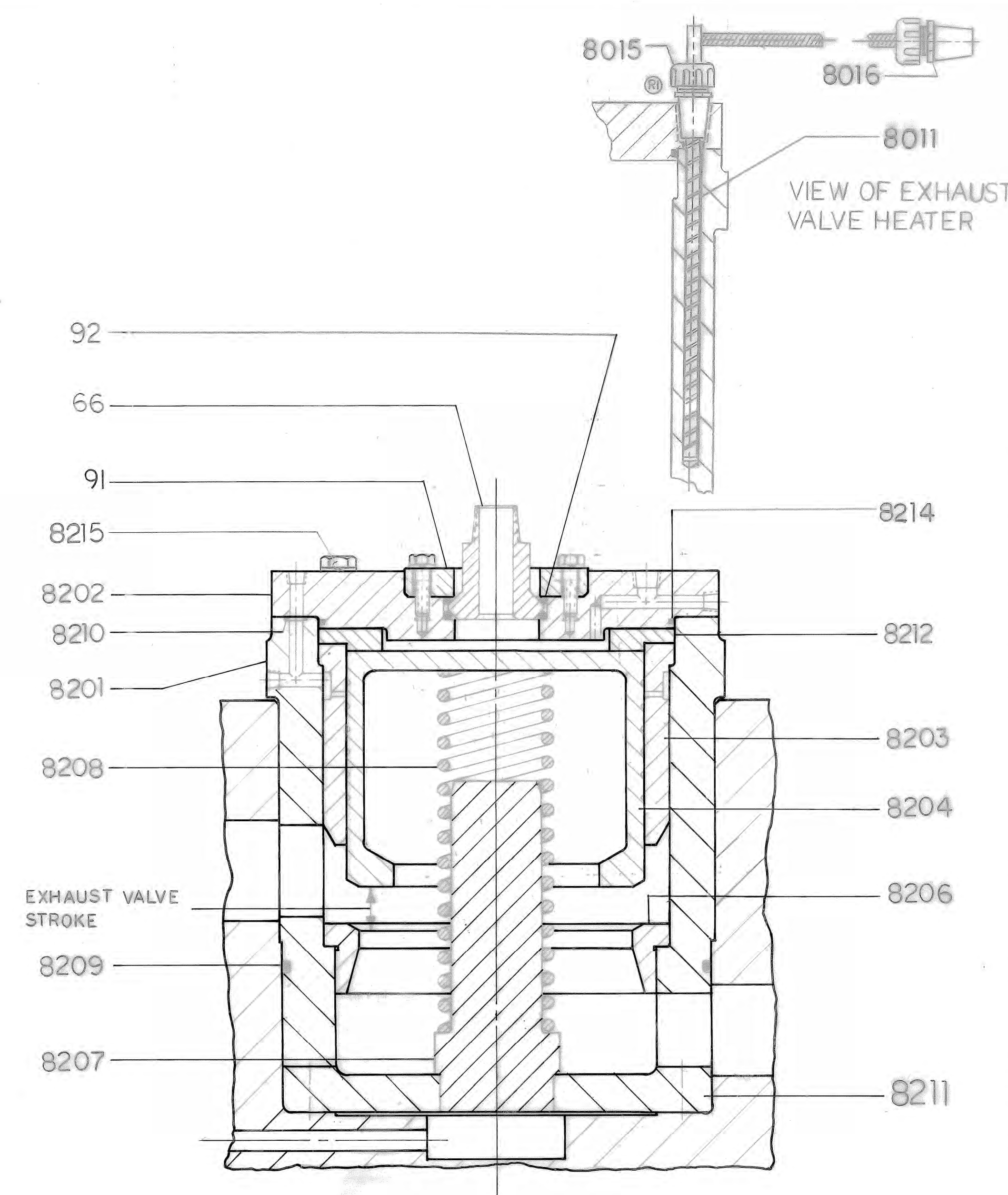




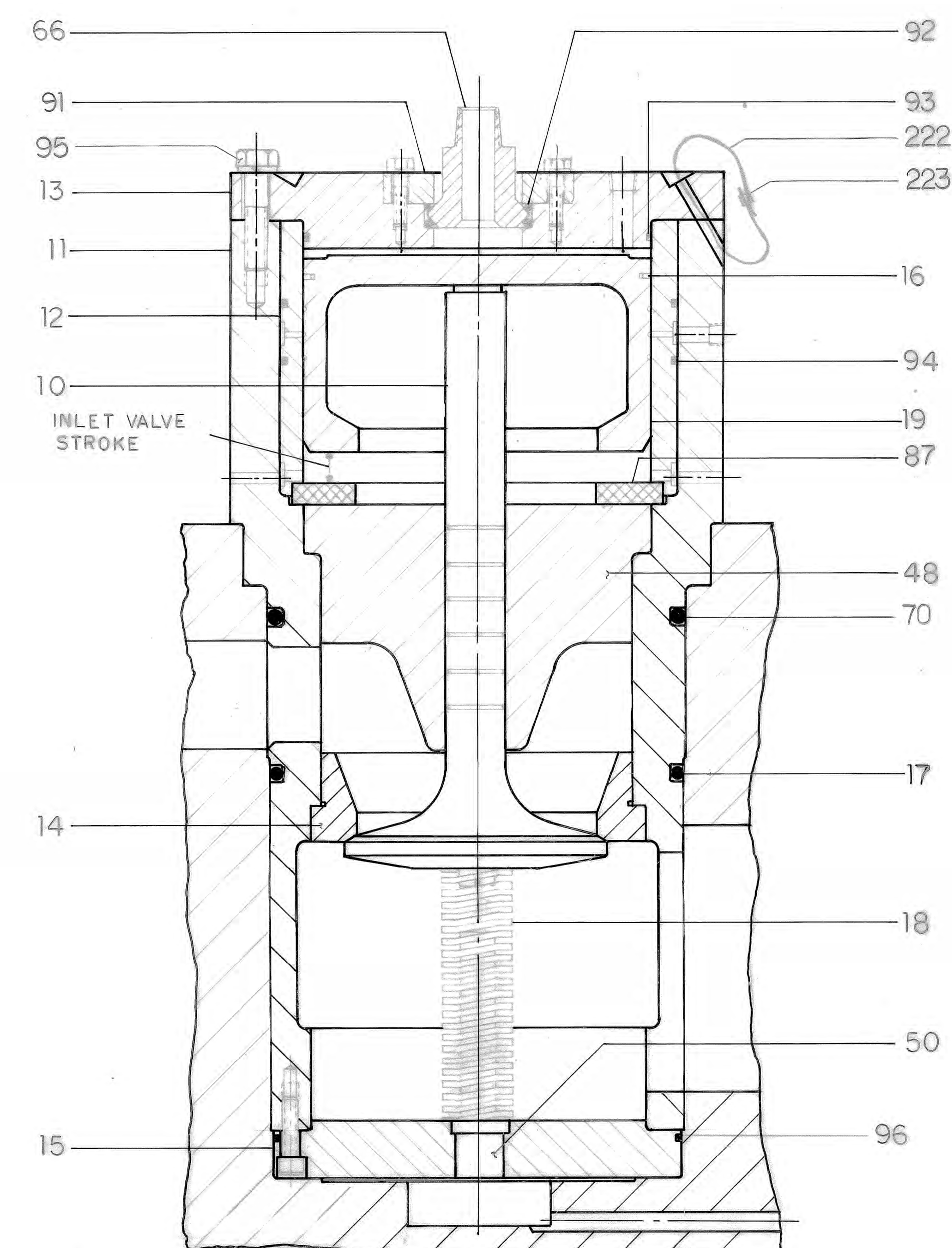
12 CDF

21 CDF



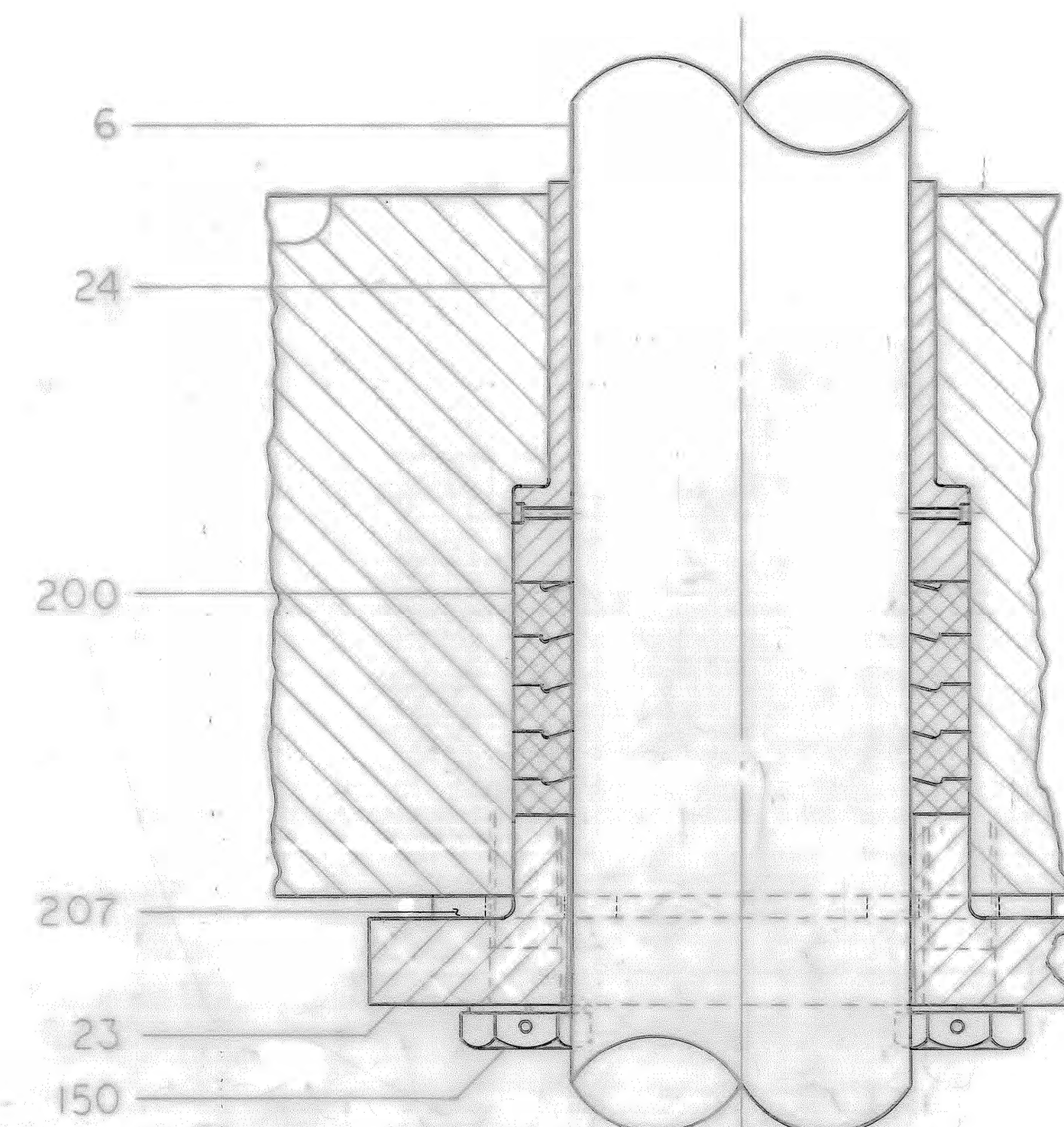
SIZE	EXHAUST VALVE STROKE (INCHES)
NO. 12	.315 / .317
NO. 21	.278 / .280

EXHAUST VALVE ARRANGEMENT

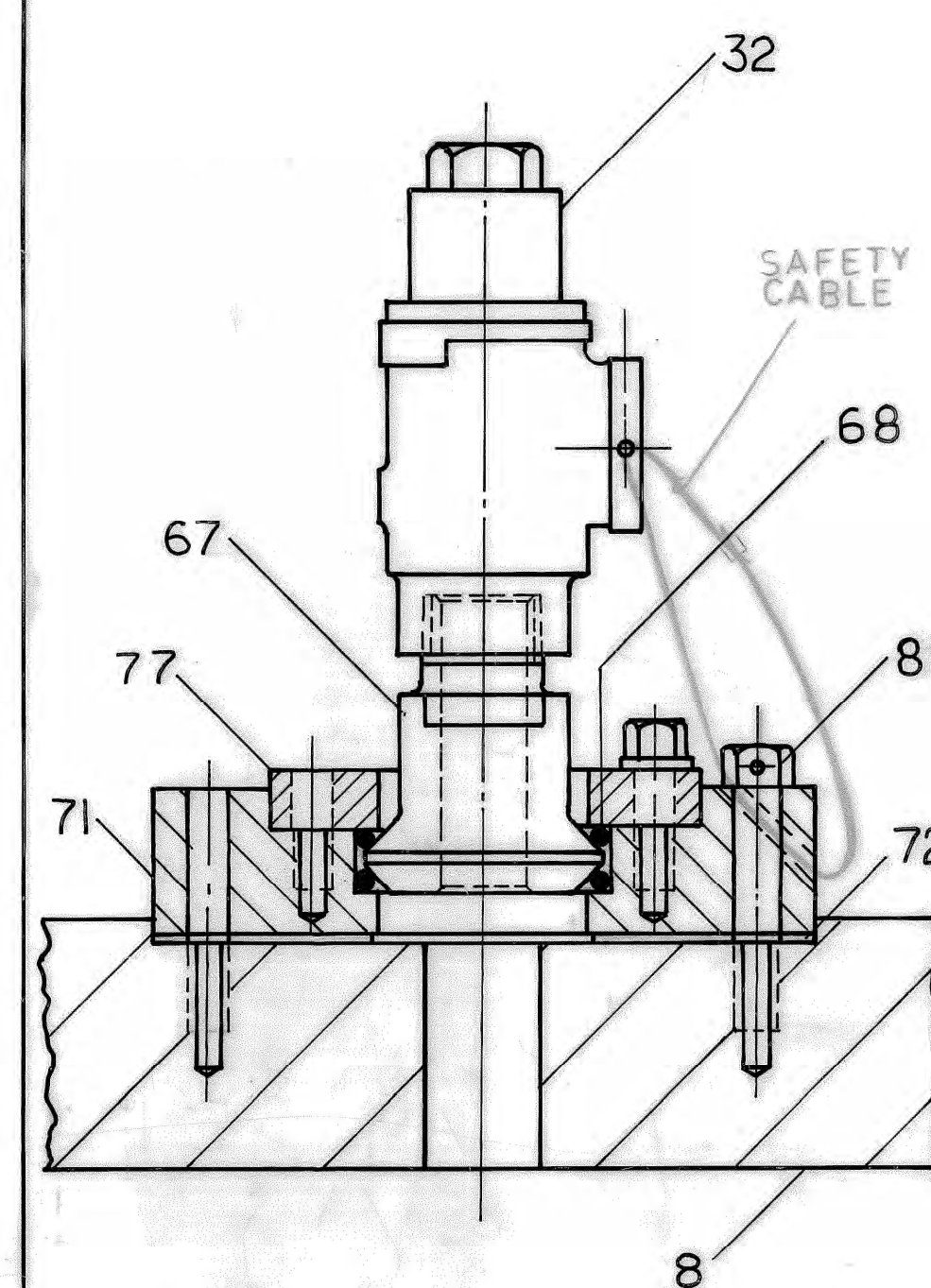


SIZE	INLET VALVE STROKE (INCHES)
NO. 12	.365 / .367
NO. 21	.392 / .394

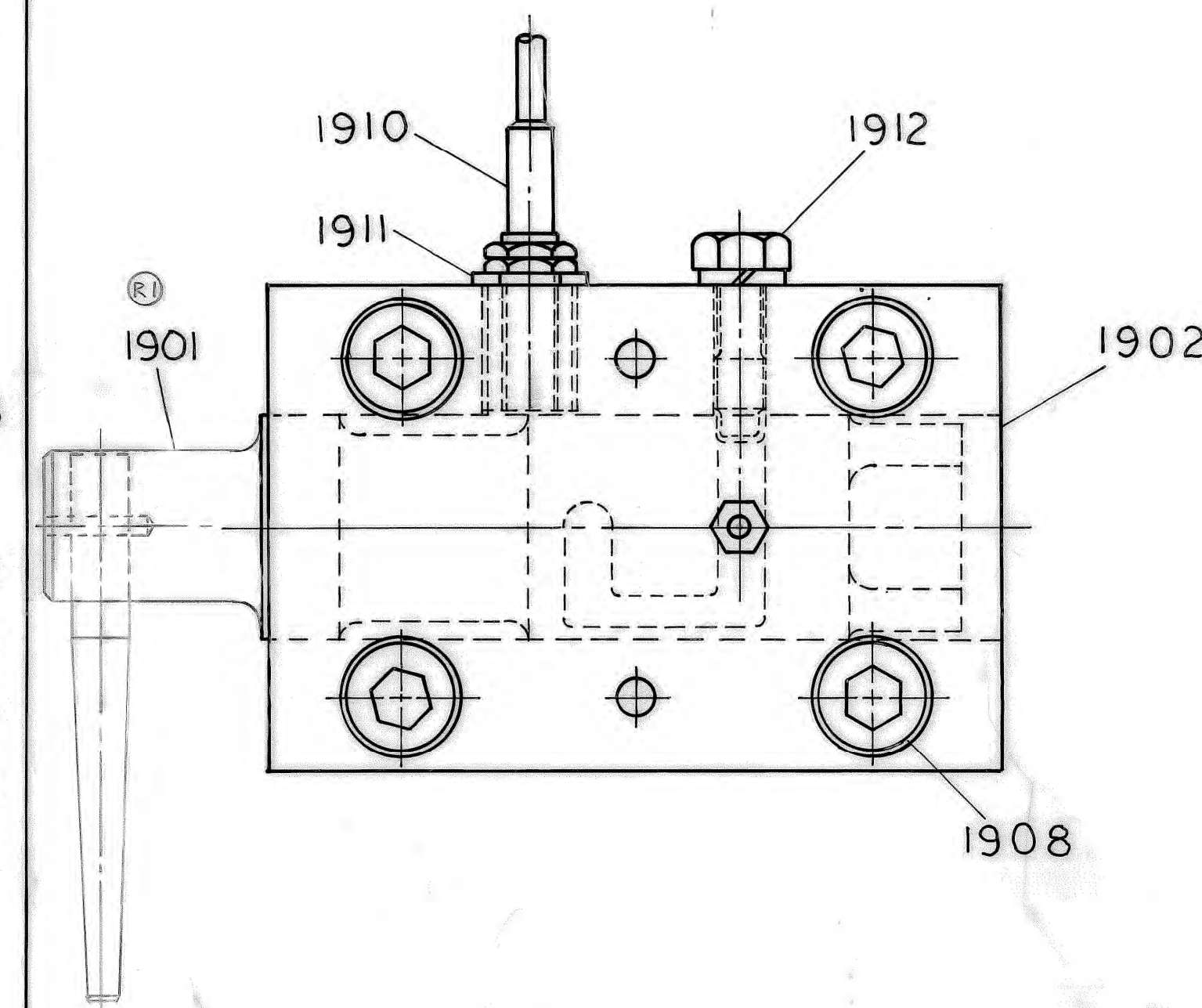
INLET VALVE ARRANGEMENT



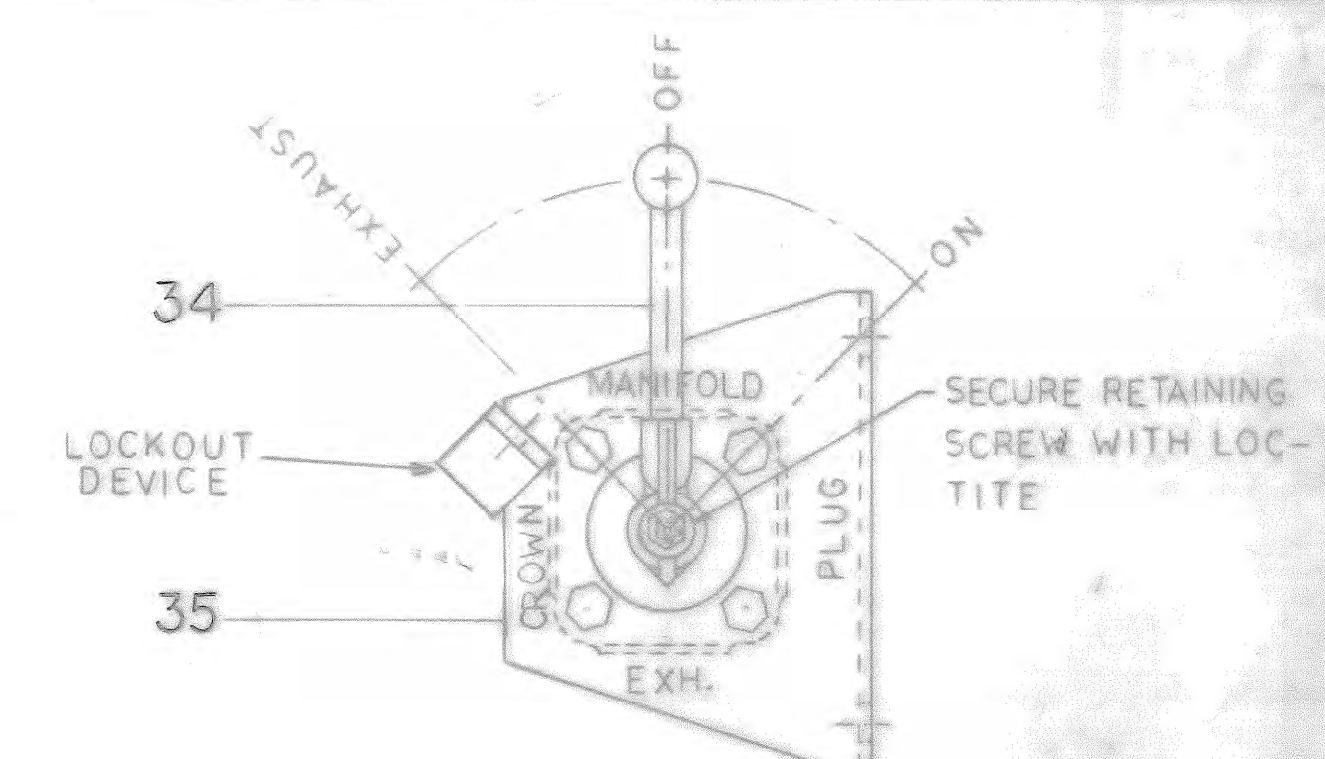
PISTON ROD PACKING ARRANGEMENT



SAFETY VALVE ARRANGEMENT



SAFETY REST ARRANGEMENT



LIFTING AIR VALVE ARRANGEMENT

CDF ASSEMBLY COMPLETE
CONSISTS OF THE FOLLOWING
DRAWINGS:
GENERAL ASSEMBLY
ARRANGEMENTS ASSEMBLY
LUBRICATION DIAGRAM

CHAMBERSBURG ENGINEERING COMPANY
Chambersburg, Pennsylvania, U. S. A.

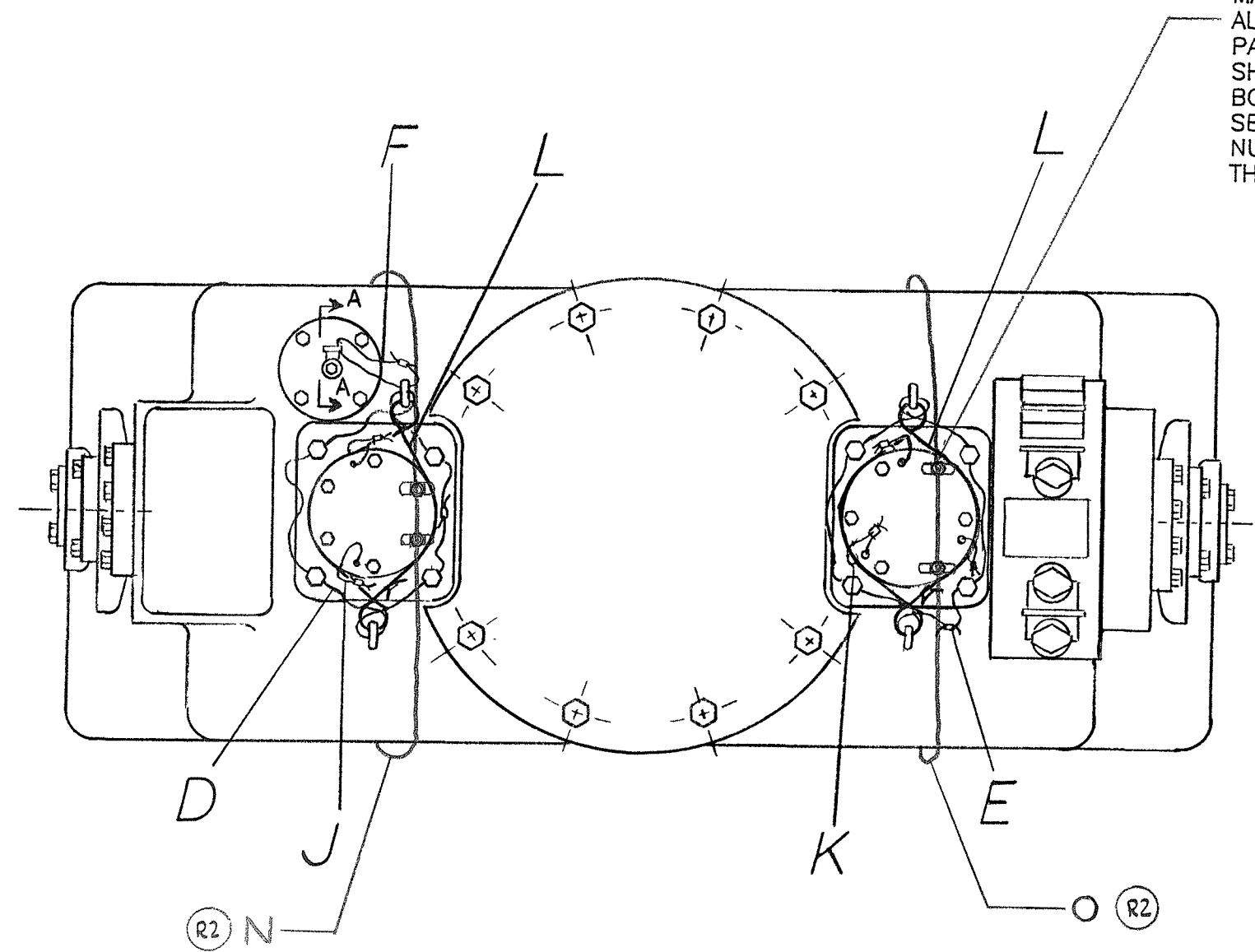
PROPERTY OF CHAMBERSBURG ENGINEERING COMPANY - TO BE RETURNED TO CHAMBERSBURG ENGINEERING COMPANY ON THE COMPLETION OF THE WORK OR ON THE FIRST DAY OF JANUARY OF THE YEAR FOLLOWING THE YEAR OF COMPLETION OF THE WORK.

Doc 10-26-92 Date 12-26-92

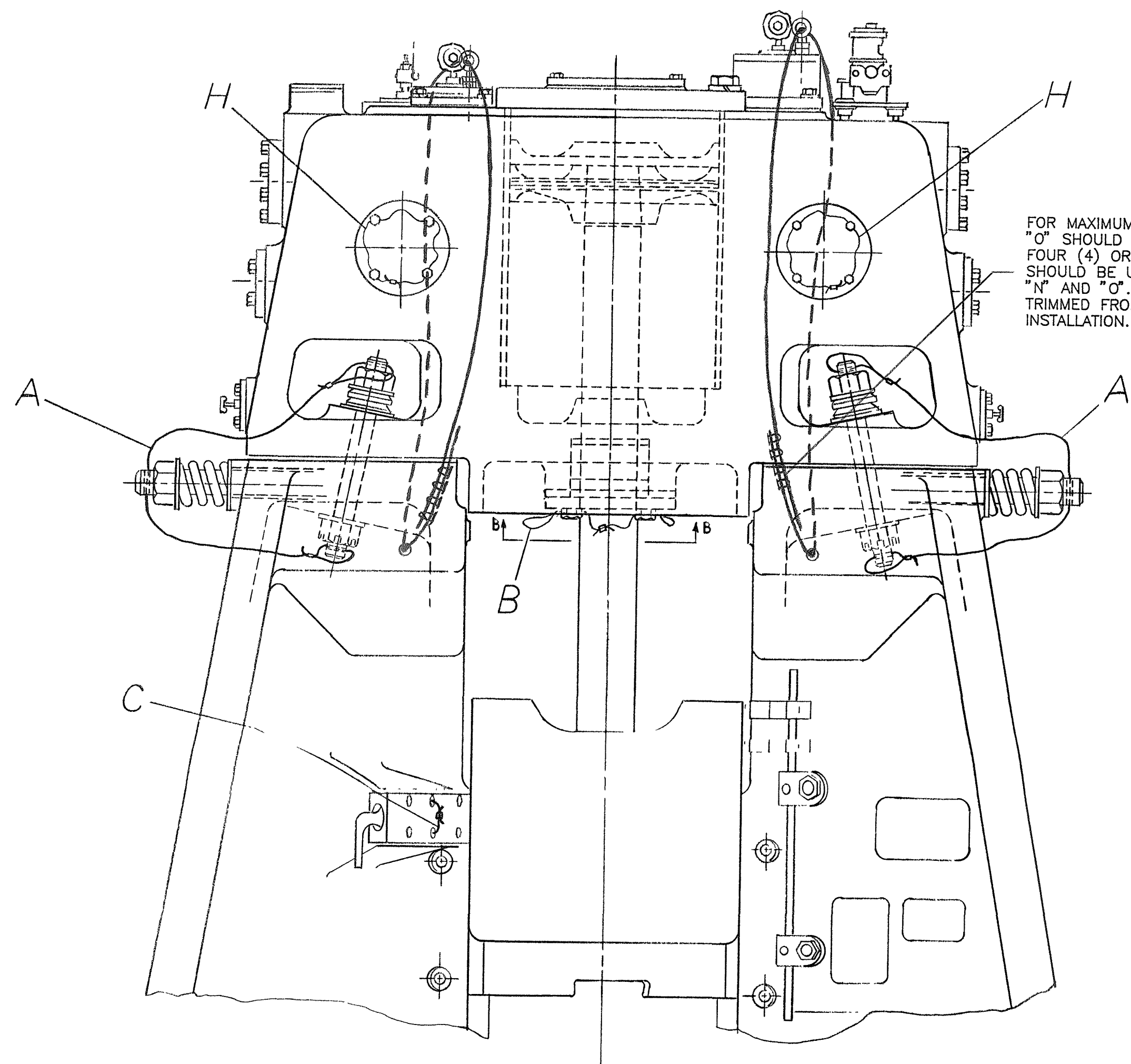
2905-L

ARRANGEMENTS ASSEMBLY
(DIE FORGER CONVERSION MODEL CDF)

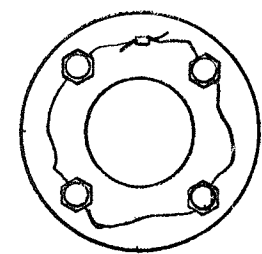
CDF DRAWING NUMBER 32742 F



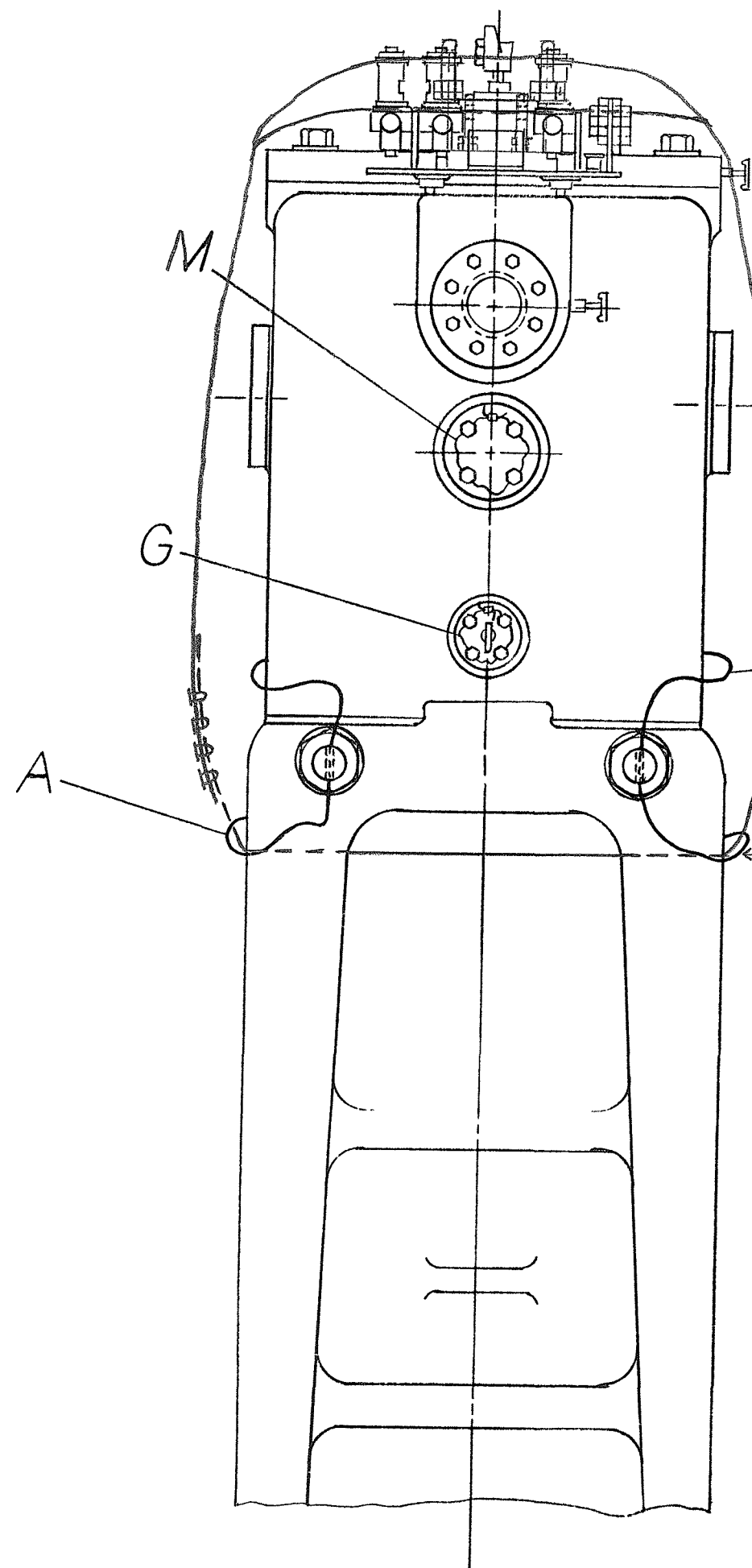
TWO (2) SAFETY CABLE EYEBOLTS, PT. 8101, SHOULD BE INSTALLED IN EACH VALVE COVER. THE EYEBOLTS SHOULD BE INSTALLED TO THEIR MAXIMUM POSSIBLE DEPTH WHILE STILL MAINTAINING THE CORRECT ORIENTATION TO ALLOW THE SAFETY CABLES "N" AND "O" TO PASS AROUND THE CROWN. TWO (2) NUTS SHOULD BE PRESENT ON EACH EYEBOLT. THE BOTTOM NUT SHOULD BE TIGHTENED TO HELP SECURE THE VALVE COVER IN PLACE. THE TOP NUT SHOULD BE USED AS A JAM NUT TO LOCK THE EYEBOLT IN PLACE.



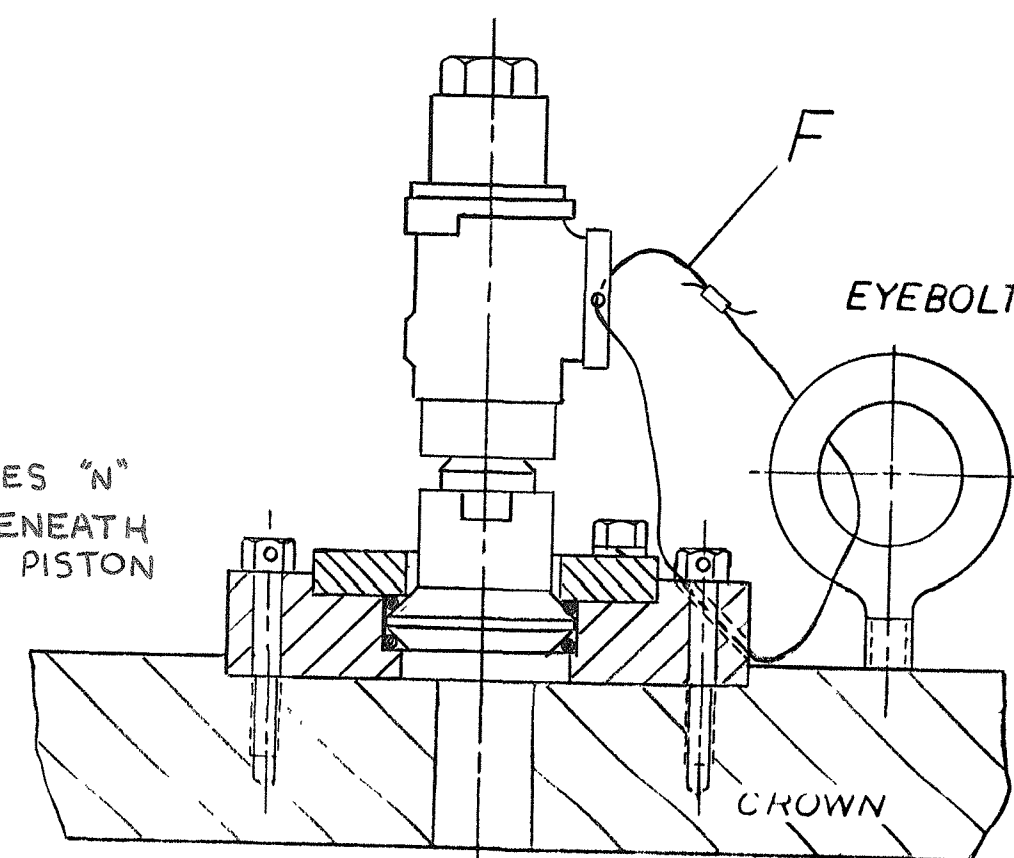
FOR MAXIMUM SAFETY, CABLES "N" AND "O" SHOULD BE TIGHT AROUND THE CROWN. FOUR (4) OR MORE STEEL CABLE CLAMPS SHOULD BE USED ON EACH OF THE CABLES "N" AND "O". EXCESS CABLE MAY BE TRIMMED FROM CABLES "N" AND "O" AFTER INSTALLATION.



VIEW ON B-B



ALTERNATIVELY, SAFETY CABLES "N" AND "O" MAY BE ROUTED BENEATH THE CROWN BETWEEN THE PISTON GLAND AND THE FRAMES.



VIEW ON A-A
SAFETY VALVE WIRING

UNIT NO	1000	8000	1000	1000	1000	8000	8000	8000	8200	8100	8000	8000	1000	1000
PART NO	220	222	220	222	222	222	222	222	222	222	220	222	224	224
QTY	4	1	1	1	1	1	2	4	2	3- 9,12 CDF 4- 21 CDF	2	2	1	1
SIZE	CABLE IDENTIFICATION													
	A	B	C	D	E	F	G	H	J	K	L	M	(R2) N	(R2) O
4														
6														
9	76"	55"	40"	48"	48"	20"	17"	33"	8"	8"	90"	31"	180"	190"
12	80"	64"	33"	48"	48"	20"	17"	33"	8"	8"	96"	32"	190"	200"
15														
21	107"	40"	38"	48"	48"	20"	23"	33"	8"	8"	110"	33"	220"	230"
27														
33														

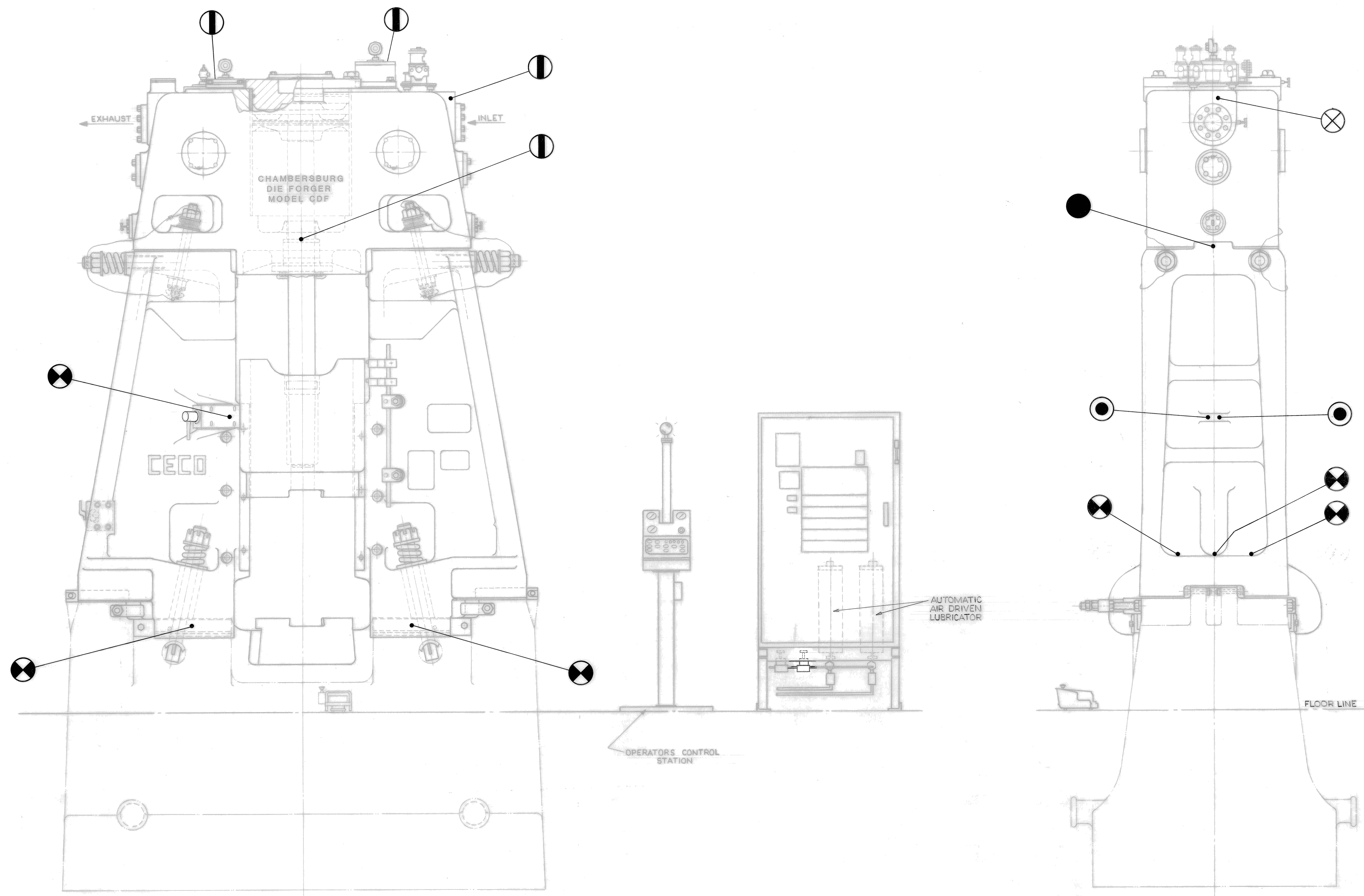
NOTE:

PT. 220 - $\frac{1}{4}$ DIA. , 7 X 19 STRAND AIRCRAFT GALVANIZED CABLE

PT. 222 - $\frac{1}{8}$ DIA. , 7 X 19 STRAND AIRCRAFT GALVANIZED CABLE

(R2) PT. 224 - $\frac{1}{2}$ DIA. , 7 X 19 STRAND AIRCRAFT GALVANIZED CABLE

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2	SAFETY CABLES "N" AND "O" ADDED.	C. V. R.	1	25	11-17-92	Scale	1-29-93
1	NOTE ADDED.	JMH	2	12	8-12-93	Print Date	
Rev	Revision	By	Date	Eng	Ref		
No				Part	No		
Wt							



AUTOMATIC LUBRICATION

2 OUTLET LUBRICATOR

1-OUTLET FOR CYLINDER AND CONTROL AIR
LINE LUBRICATION

1-OUTLET FOR GUIDE LUBRICATION

FOR PIPING INSTRUCTIONS REFER TO
INSTALLATION DRAWING

- ⊗ CYLINDER LUBRICATION-SEE INSTRUCTIONS
- GUIDE LUBRICATION-SEE INSTRUCTIONS
- ⊖ CONTROL AIR, VALVE AND PACKING
LUBRICATION-SEE INSTRUCTIONS

MANUAL LUBRICATION

- ⊗ GREASE-PRESSURE GUN EACH EIGHT HOUR
SHIFT (11 POINTS)
- GREASE-PRESSURE GUN ONCE A WEEK
(2 POINTS)

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Drawn	Checked	Approved	By	Date	Print Date
DGS	JL-15-92				
Rev.	Revision	By	Date	Part No.	Size

**LUBRICATION
DIAGRAM**

CDF DRAWING NUMBER
32780E