



LENGTH OF MACHINE	*A	*B	*C	*D
8'-0"	8'-11 1/2"	7'-11 1/2"	3'-11 1/2"	6'-10 1/2"
10'-0"	10'-11 1/2"	9'-11 1/2"	4'-11 1/2"	8'-10 1/2"
12'-0"	12'-11 1/2"	11'-11 1/2"	5'-11 1/2"	10'-10 1/2"
14'-0"	14'-11 1/2"	13'-11 1/2"	6'-11 1/2"	12'-10 1/2"
16'-0"	16'-11 1/2"	15'-11 1/2"	7'-11 1/2"	14'-10 1/2"

LENGTH OF MACHINE	PART No.	CYL. WELDMENT
8'-0"	COI-4559-1	DOI-4806-10
10'-0"	-2	DOI-4729-10
12'-0"	-3	DOI-4791-10
14'-0"	-4	
16'-0"	-5	DOI-4677-10

LENGTH OF MACHINE	PART No.	CYL. BODY
8'-0"	COI-4559-10	COI-4559-1
10'-0"	-11	2
12'-0"	-12	3
14'-0"	-13	4
16'-0"	-14	5

**NOTES:**  
 1-WELDING PROCEDURES PER E-1265 & E-1385  
 2-DIAS. & SURFACES MARKED TO BE SQUARE, PARALLEL & CONCENTRIC WITH EACH OTHER WITHIN .003 FULL INDICATOR READING.

REQ.	PART No.	DESCRIPTION	ITEM
			22
1	1" IPS STD. PIPE (CUT LENGTH TO SUIT) S1005-1		21
1	R01-4529-1	DIPPER PIPE SCOOP	20
1	1" IPS SHORT NIPPLE	ST. 19	
1	1" IPS x 90° STD. ELBOW	ST. 18	
1	1" IPS x 2 x 90° REDUCING ELBOW	ST. 17	
1	R01-5592	CLAMP	16
2	3/8" 16UNC x 1/2 LG. HEX. HD. CAP SCR.	ST. 15	
2	3/8" 16 UNC STD. HEX NUT	ST. 14	
8	5/4" 10UNC x 2 LG. HEX. HD. CAP SCR.	ST. 13	
24	1/4" 7UNC AM. STD. HVY. FIN. HEX NUT	ST. 12	
			11
			10
			9
28	14575-429	HEX HD. CAP SCR.	8
24	30220-003	STUD	7
2	M01-4522-1	GASKET	6
2	T146-3	MANHOLE COVER	5
2	18437-59	END RING	4
1	H01-4518-12	REAR SHAFT	3
1	DOI-6683	TRUNNION MAT' PER SPEC'S	2
1	SEE TABLE	CYLINDER THRU OPERATION #4	1

**STOCK LIST**

IMPROVED MACHINERY INC.  
 NASHUA, NEW HAMPSHIRE

**8'-0" DIA. VACUUM WASHER  
 STEEL CYLINDER COMPLETE  
 WITH 1/4 WRAPPER PLATE, REAR SHAFT,  
 & "D" WIRE - FOR USE WITH D24-663 VALVE**

**COI-4559**

RECORD OF CHANGES	LOC.
2. ITEM #4 REMOVED.	SPR. LIST A-3
ORIGINAL STEPS #1 & 2	
REMOVED. NUMBERING	
SEQUENCE REVISED.	
BY 6485 ST. D.E.B. JA	
DATE 6-2-64	
ITEM #4 REINSTATED.	SPR. LIST A-2
ORIGINAL STEPS #1 & 2 REINSTATED.	
NUMBERING SEQUENCE REVISED.	A-4
DATE 5/13/67 11-2-65	
BY C.M.G.	

DATE	BY	REVISION
10-12-60		1
10-12-60		2

DATE	BY	REVISION
10-12-60		1
10-12-60		2