

REV	DESCRIPTION	DET	DATE
A	RELEASE	HKS	09/21/15
B	ITEM 4 QTY 1 WAS 2, UPDATED NOTE 1	HKS	04/19/16

NOTES:

- (B)

1

TO ASSEMBLE:

A)

APPLY LOCTITE 243 (P/N 508567) TO PULLER EXTENSION'S EXTERNAL THREADS

B)

THREAD PULLER EXTENSION INTO TOOL'S END CAP

C)

THREAD LOCKNUT ON PULLER AS SHOWN

D)

THREAD PULLER INTO PULLER EXTENSION, TIGHTEN LOCKNUT

E)

TIGHTEN ANVIL INTO ANVIL EXTENSION, TIGHTEN 501781 SETSCREWS

F)

INSTALL ANVIL OVER PULLER AND THREAD ANVIL/ANVIL HOLDER ASM INTO PISTON

G)

TIGHTEN SETSCREWS ON PISTON

2

APPLY ANTI-SEIZE LUBRICANT P/N: 508183 OR EQUIVALENT TO OUTSIDE OF PULLER AND INSIDE OF ANVIL.

3

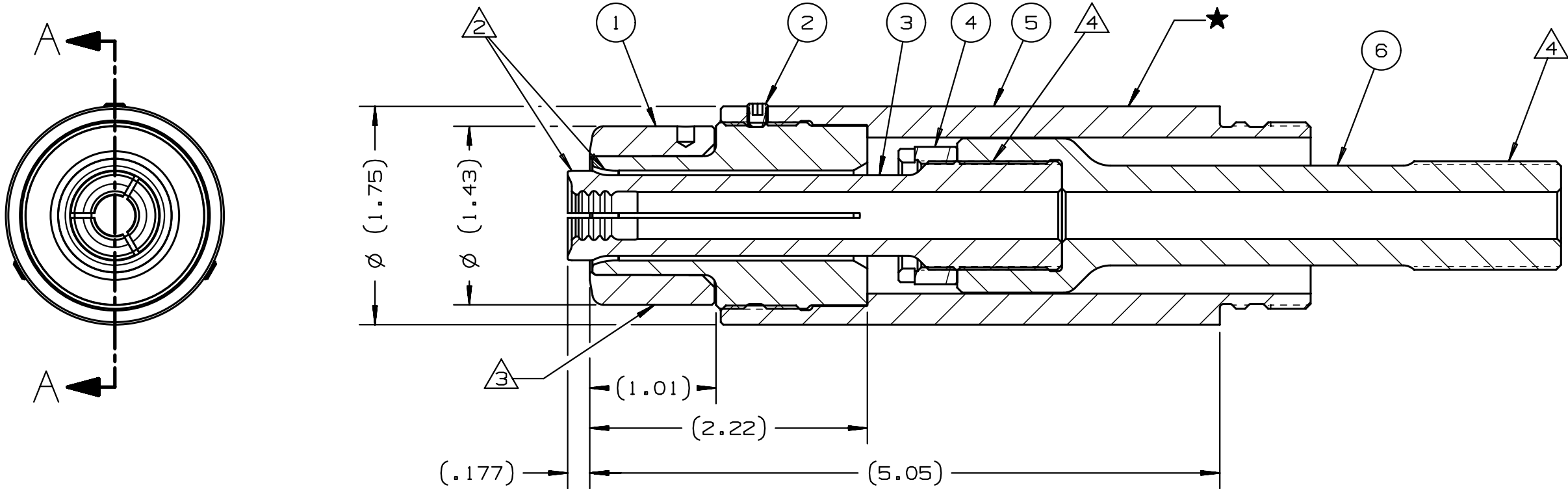
APPLY WARNING STICKER P/N: 590516 TO ANVIL.

4

LEFT HAND THREAD.

5

ACTUATOR ROD ASM 129157 OPTIONALLY AVAILABLE FOR USE WITH SFBTT-20-IT AND SFBTT20-ST. NOT REQUIRED WITH SF20 OR SFBTT20-DT



SECTION A - A

(B)

131003	1	EXTENSION, PULLER, SF20,4	6
129154	1	HOLDER, ANVIL, SF20, 4	5
128807	1	LOCKNUT, PULLER	4
129314	1	PULLER, SF20, -16 BT	3
501781	3	SET SCREW, #8-32 X .19	2
129315	1	ANVIL ASM, SF20, -16 BT	1
PART NO.	QTY	DESCRIPTION	ITEM

IDENTIFICATION PER SPEC 42-311: ★ PERMANENT		HUCK INTERNATIONAL, INC., I.S.D 1 CORPORATE DR KINGSTON, NEW YORK 12401	
ITAR/ECCN: EAR99		NOSE, -16 BT, 4" EXTENDED SF20 TOOL	
SCH B#: 8467.99.0190		FINAL ASSY: -	
HTS: 8467.99.0190		ENG: SMA	CK: DATE: 09/21/15 SCALE: 1:1
		B	99-7882-4