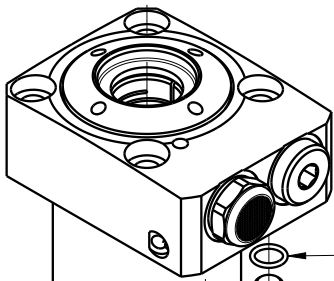
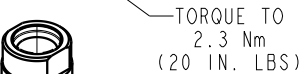
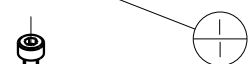
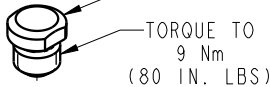
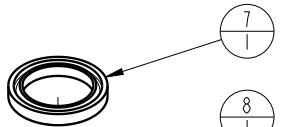


NO	QTY	PART NO	DESCRIPTION	STD SEAL KIT	LIGHT SPRING KIT	HEAVY SPRING KIT
1	1	23350096	SPRING, COMPRESSION			X
2	2	39051079	O-RING, (6mm X 1)	X		
3	2	39051087	O-RING, (4mm X 3)	X		
4	1	39051091	O-RING, (7.5mm x 1.5)	X	X	X
5	1	39051100	O-RING, (24.5mm X 2)	X		
6	1	39051106	O-RING, (19.5mm X 2)	X		
7	1	39053049	WIPER, PRESS-IN, 15mm	X		
8	1	81000000	CONTACT BOLT, WS, 7MPa, 5.5 & 10kN			
9	2	81400200	PLUG, MANIFOLD, 7MPa, M6			
10	1	23350095	SPRING, COMPRESSION		X	
N/A	N/A	L6010002	KIT, SEAL, WS, 7MPa, TF, SPR, 5.5kN	NOTED	N/A	N/A
N/A	N/A	L6110000	KIT, SPRING, WS, 7MPa, SPR, 5.5kN	N/A	NOTED	N/A
N/A	N/A	L6110001	KIT, SPRING, WS, 7MPa, SPR, 5.5kN	N/A	N/A	NOTED
N/A	N/A	ISL1000	INSTRUCTION SHEET, WS, 7MPa, TF, SPR, 5.5kN	N/A	N/A	N/A




TORQUE TO 1.3 Nm (11 IN. LBS)



TORQUE TO 30 Nm (20 FT. LBS)

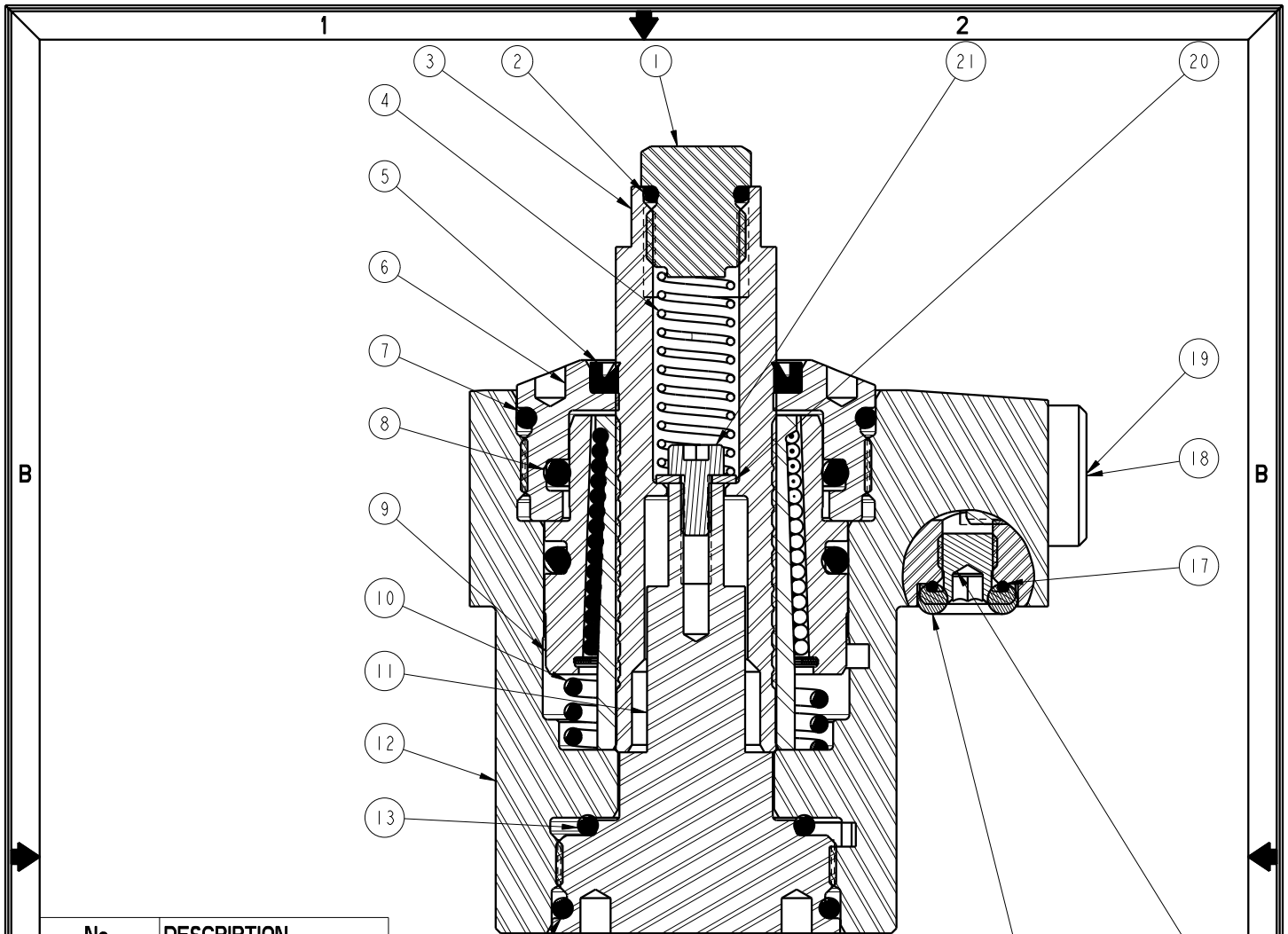
See Instruction Sheet ISL1000 For Service Instructions.
Lubricate All Seals With Clean Hydraulic Oil Prior To Assembly.
Do Not Use Silicone Base Lubricants.



PARTS LIST	 VEKTEK, INC. 1334 E. SIXTH AVE. P.O. BOX 625 EMPORIA, KS. 66801 U.S.A.	
	PARTS LIST, ASSY, WS, 7MPa, TF, SPR, 5.5kN	
ASSEMBLIES AFFECTED	L1-0115-00H	L1-0115-00L
SIZE A	LPL1000	REV C

C 3849	RELEASE	MJUST	7/8/19
REV IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY: N.KARRAS	DRAWING STATUS: Released		
DATE: 03/20/14	PRODUCTION APPROVED FOR RELEASED STATUS ONLY		

SHEET 1 OF 1



No.	DESCRIPTION
1	CONTACT BOLT
2	O-RING (7.5MM X 1.5)
3	PLUNGER
4	SPRING
5	WIPER
6	TOP CAP
7	O-RING (31.5MM X 2)
8	O-RING (25MM X 2.65)
9	COLLET ASSY
10	SPRING
11	BOTTOM CAP
12	BODY
13	O-RING (19.5MM X 2)
14	O-RING (24.5MM X 2)
15	O-RING (4MM X 3)
16	MANIFOLD PLUG
17	O-RING (6MM X 1)
18	G1/8 PLUG
19	BREATHER
20	WASHER
21	SHCS

TOOL LIST			
<input type="checkbox"/>	11mm & 13mm Open End Wrench		
<input type="checkbox"/>	2.5mm & 3mm Hex Key		
<input type="checkbox"/>	Vekttek #ATL10312 Spanner Wrench		

INSTALLATION INSTRUCTIONS

VEKTEK, INC.
1334 E. SIXTH AVE. P.O. BOX 625
EMPORIA, KS. 66801 U.S.A.

A	2629	RELEASE	Two	4/9/14
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY:	N. KARRAS	DRAWING STATUS: Released		
DATE:	3/10/14	PRODUCTION APPROVED FOR RELEASED STATUS ONLY		

ASSEMBLIES AFFECTED
L1-0115-00H
L1-0115-00L


INSTRUCTION SHEET, WS, 7MPo, TF, SPR, 5.5kn			
SIZE	ISL1000	REV	A

FORM FEG041-IS-ASIZE, REV. B

SHEET 1 OF 3

Assembly

1. Lubricate new O-rings (2), (13), (14), (15), (17) and outside diameter of new wiper (5) with clean hydraulic oil (Vekttek 65-0010-01 or equivalent). Also, apply light film of hydraulic oil to outside surface of plunger (3)
2. Press wiper (5) into top cap (6) taking extra care to install squarely without excess force. CAUTION: IMPROPER INSTALLATION COULD DAMAGE WIPER (5) CAUSING EXCESS WIPER DRAG.
3. Install O-ring (13) and O-ring (14) onto bottom cap (11)
4. Clamp work support body (12) into vise with bottom side facing up.
5. Screw bottom cap (11) into bottom of work support body (12). Using Vekttek #ATL10312 spanner wrench torque bottom cap (11) to 30 N-m (20 ft-lb).
6. Remove work support body from vise and position with top cap upward.
7. Gently install plunger (3) into work support through wiper (5) taking care not to damage wiper (5). Plunger (3) should move freely without binding. Lightly push plunger (3) downward until bottoms.
8. Install washer (20) onto cap screw (21) and drop thread side down into hole through top of plunger (3). Insert 2.5mm hex key into cap screw (21) and torque to 2.5 N-m (20 in-lb).
9. Insert contact spring (4) into hole through top of plunger (3). Contact spring (4) will pilot onto cap screw (21).
10. Install O-ring (2) onto contact bolt (1).
11. Screw contact bolt (1) into top of plunger (3). With 13mm wrench at plunger (3) and 11mm wrench at contact bolt (1) torque to 9 N-m (80 in-lb).
12. If work support hydraulics or vent is manifold fed from fixture, install new O-ring (15) into manifold surface on work support body (12) mounting flange (2 places).
13. If work support hydraulics or vent is not manifold fed install O-ring (17) onto plug (16), insert 3mm hex key into plug (16) and torque to 3 n-m (25 in-lb) (2 places).

		
VEKTEK, INC. 1334 E. SIXTH AVE. P.O. BOX 625 EMPORIA, KS. 66801 U.S.A.		
INSTRUCTION SHEET, WS, 7MP, TF, SPR, 5.5M		
SIZE A	ISL1000	REV A
FORM FEG041-1S-ASIZE, REV. B		

SHEET 3 OF 3