


No.	DESCRIPTION
1	CONTACT BOLT
2	O-RING (7.5MM X 1.5)
3	PLUNGER
4	SPRING
5	WIPER
6	BODY
7	O-RING (28MM X 3.55)
8	COLLET ASSY
9	SPRING
10	RETAINER
11	O-RING (30MM X 2.65)
12	O-RING (35.5MM X 2)
13	O-RING (-030)
14	PLUG
15	O-RING (-015)
16	O-RING (4MM X 3)
17	MANIFOLD PLUG
18	O-RING (6MM X 1)
19	BREATHER
20	BASE
21	WASHER
22	SHCS

TOOL LIST	
<input type="checkbox"/>	11mm & 13mm Open End Wrench
<input type="checkbox"/>	2.5mm & 3mm Hex Key
<input type="checkbox"/>	41mm Socket

INSTALLATION INSTRUCTIONS	 VEKTEK, INC. 1334 E. SIXTH AVE. P.O. BOX 625 EMPORIA, KS. 66801 U.S.A.	
	INSTRUCTION SHEET, WS, 7MPa, CM/BM, SPR, 10kN	
ASSEMBLIES AFFECTED LI-0316-00H LI-0316-00L LI-0516-00H LI-0516-00L	SIZE A	REV B

B	2846	RELEASE	Two	05/04/15
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY: N.KARRAS		DRAWING STATUS: Released		
DATE: 03/11/14		PRODUCTION APPROVED FOR RELEASED STATUS ONLY		


Assembly

Model Number L1-0316-00H & L1-0316-00L

1. Lubricate new O-rings (2),(13),(15) and outside diameter of new wiper (5) with clean hydraulic oil (Vektek 65-0010-01 or equivalent). Also, apply light film of hydraulic oil to outside surface of plunger (3)
2. Press wiper (5) into top of body taking extra care to install squarely without excess force. CAUTION: IMPROPER INSTALLATION COULD DAMAGE WIPER (5) CAUSING EXCESS WIPER DRAG.
3. 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.
4. Install washer (21) onto cap screw (22) and drop thread side down into hole through top of plunger (3). Insert 2.5mm hex key into cap screw (22) and torque to 2.5 N-m (20 in-lb).
5. Insert contact spring (4) into hole through top of plunger (3). Contact spring (4) will pilot onto cap screw (22).
6. Install O-ring (2) onto contact bolt (1).
7. 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).
8. Install O-ring (15) into retainer (10) s'face.
9. Install O-ring (13) into bottom of fixture cavity.
10. Using 41mm socket, screw work support into fixture cavity. Torque to 55 N-m (40 ft-lb).

Model Number L1-0516-00H & L1-0516-00L

12. Complete assembly steps 1-8.
13. Install O-ring (13) into bottom of base (20) cavity.
14. Using 41mm socket, screw work support into base (20) cavity. Torque to 55 N-m (40 ft-lb).
15. If work support hydraulics or vent is manifold fed from fixture, install new O-ring (16) into manifold s'face on base (20) mounting face (2 places).
16. If work support hydraulics or vent is not manifold fed, install O-ring (18) onto plug (17), insert 3mm hex key into plug (17) and torque to 3 N-m (25 in-lb) (2 places).

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SIZE A	ISL1005
REV B	

FORM FEG041-1S-ASIZE, REV. B

SHEET 3 OF 3