


No.	DESCRIPTION
1	CONTACT BOLT
2	O-RING (7.5MM X 1.5)
3	PLUNGER
4	SPRING
5	WIPER
6	BODY
7	O-RING (23.6MM X 2.65)
8	COLLET ASSY
9	SPRING
10	SPRING
11	RETAINER
12	O-RING (28.5MM X 2)
13	O-RING (-026)
14	BREATHER
15	O-RING (6MM X 1)
16	O-RING (4MM X 3)
17	MANIFOLD PLUG
18	O-RING (-015)
19	PISTON
20	O-RING (6.7MM X 1.8)
21	PLUG
22	BASE
23	WASHER
24	SHCS

TOOL LIST			
<input type="checkbox"/>	11mm & 13mm Open End Wrench		
<input type="checkbox"/>	2.5mm & 3mm Hex Key		
<input type="checkbox"/>	32mm Socket		

INSTALLATION INSTRUCTIONS		 VEKTEK, INC. 1334 E. SIXTH AVE. P.O. BOX 625 EMPORIA, KS. 66801 U.S.A.	
ASSEMBLIES AFFECTED		INSTRUCTION SHEET, WS, 7MPo, CM/BM, FA, 5.5kN	
LI-0415-00H LI-0415-00L LI-0615-00H LI-0615-00L		SIZE A	REV C
		ISLI006	
		FORM FEG041-1S-ASIZE, REV. B	

C	2846	RELEASE	Twa	05/04/15
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY: N.KARRAS	DRAWING STATUS: Released			
DATE: 3/11/14	PRODUCTION APPROVED FOR RELEASED STATUS ONLY			


2

B

- 3

A

- A

 <p>VEKTEK, INC. 1334 E. SIXTH AVE. P.O. BOX 625 EMPORIA, KS. 66801 U.S.A.</p>	
INSTRUCTION SHEET, WS, 7MPo, CW/BW, FA, 5.5kN	
SIZE A	ISL1006
	REV C


Assembly

Model Number L1-0415-00H & L1-0415-00L

1. Lubricate new O-rings (2),(13),(18),(20) 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 (6) 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 O-ring (20) onto piston (19).
5. Slide return spring (10) onto piston (19) and insert piston (19) and return spring (10) into retainer (11) bore. Insert 3mm hex key into piston (19) and push inward to compress return spring (10). While holding piston (19) and return spring (10) in compressed position place washer (23) onto cap screw (24) and drop thread side down into hole through top of plunger (3). Insert 2.5mm hex key into cap screw (24) and torque to 2.5 N-m (20 in-lb). CAUTION: RETURN SPRING (10) AND CONTACT SPRING (4) ARE NOT INTERCHANGEABLE, NOTE LOCATION AND KEEP SEPARATE FOR REASSEMBLY.
6. Insert contact spring (4) into hole through top of plunger (3). Contact spring (4) will pilot onto cap screw (24).
7. Install O-ring (2) onto contact bolt (1).
8. 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).
9. Install O-ring (18) into retainer (11) s'face.
10. Install O-ring (13) into bottom of fixture cavity.
11. Using 32mm socket, screw work support into fixture cavity. Torque to 40 N-m (30 ft-lb).

Model Number L1-0615-00H & L1-0615-00L

12. Complete assembly steps 1 - 9.
13. Install O-ring (13) into bottom of base (22) cavity.
14. Using 32mm socket, screw work support into base (22) cavity. Torque to 40 n-m (30 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 (22) mounting face (2 places).
16. If work support hydraulics or vent is not manifold fed, install O-ring (15) onto plug (17), insert 3mm hex key into plug (17) and torque to 3 N-m (25 in-lb) (2 places).

 VEKTEK [®]	
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SIZE A	ISL1006
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FORM FEG041-1S-ASIZE, REV. B

SHEET 3 OF 3