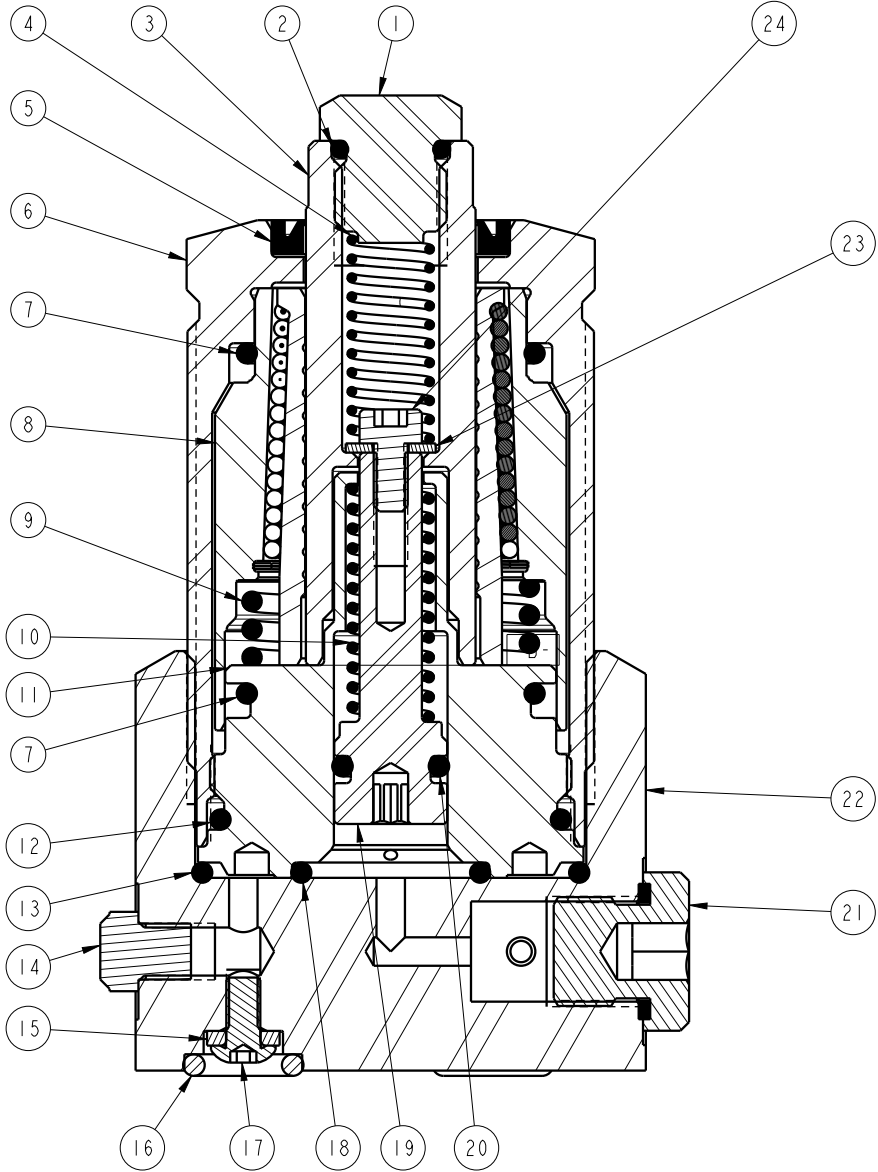





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 <p>VEKTEK, INC. 1334 E. SIXTH AVE. P.O. BOX 625 EMPORIA, KS. 66801 U.S.A.</p>		
INSTRUCTION SHEET, WS, 7MPa, CM/BM, FA, 5.5kN		
SIZE A	ISL1006	REV D

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 bonded seal (15) onto plug (17), insert 3mm hex key into plug (17) 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, 7MPo, CM/BM, FA, 5.5kN

SIZE
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ISL1006

REV
B

FORM FEG041-1S-ASIZE, REV. B

SHEET 3 OF 3