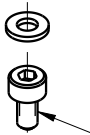
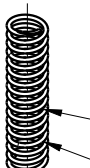
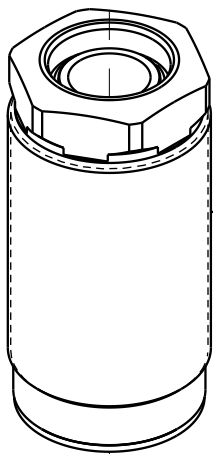
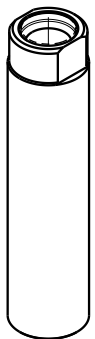


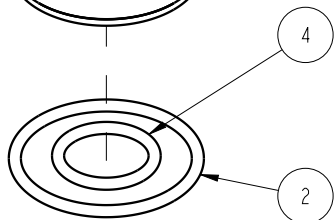
TORQUE TO  
9 Nm  
(80 IN. LBS.)



TORQUE TO  
2.3 Nm  
(20 IN. LBS.)



TORQUE TO  
40 Nm  
(30 FT. LBS.)



NO	QTY	PART NO	DESCRIPTION	STD SEAL KIT	LIGHT SPRING KIT	HEAVY SPRING KIT
1	1	23350101	SPRING, COMPRESSION			X
2	1	39050085	O-RING, (-022)	X		
3	1	39051108	O-RING, (5.5mm X 1.5)	X	X	X
4	1	39051114	O-RING, (-014)	X		
5	1	39053050	WIPER, PRESS-IN, 12mm	X		
6	1	81000031	CONTACT BOLT, WS, 7MPa, 4kN			
7	1	23350100	SPRING, COMPRESSION		X	
N/A	N/A	L6010006	KIT, SEAL, WS, 7MPa, CM/BM, 4kN	NOTED	N/A	N/A
N/A	N/A	L6110016	KIT, SPRING, WS, 7MPa, SPR, 4kN	N/A	NOTED	N/A
N/A	N/A	L6110017	KIT, SPRING, WS, 7MPa, SPR, 4kN	N/A	N/A	NOTED
N/A	N/A	ISL1009	INSTRUCTION SHEET, WS, 7MPa, CM/BM, SPR, 4kN	N/A	N/A	N/A

See Instruction Sheet ISL1009 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.

ASSEMBLIES AFFECTED

L1-0312-00H  
L1-0312-00L

PARTS LIST, ASSY, WS, 7MPa, CM, SPR, 4kN

SIZE  
A

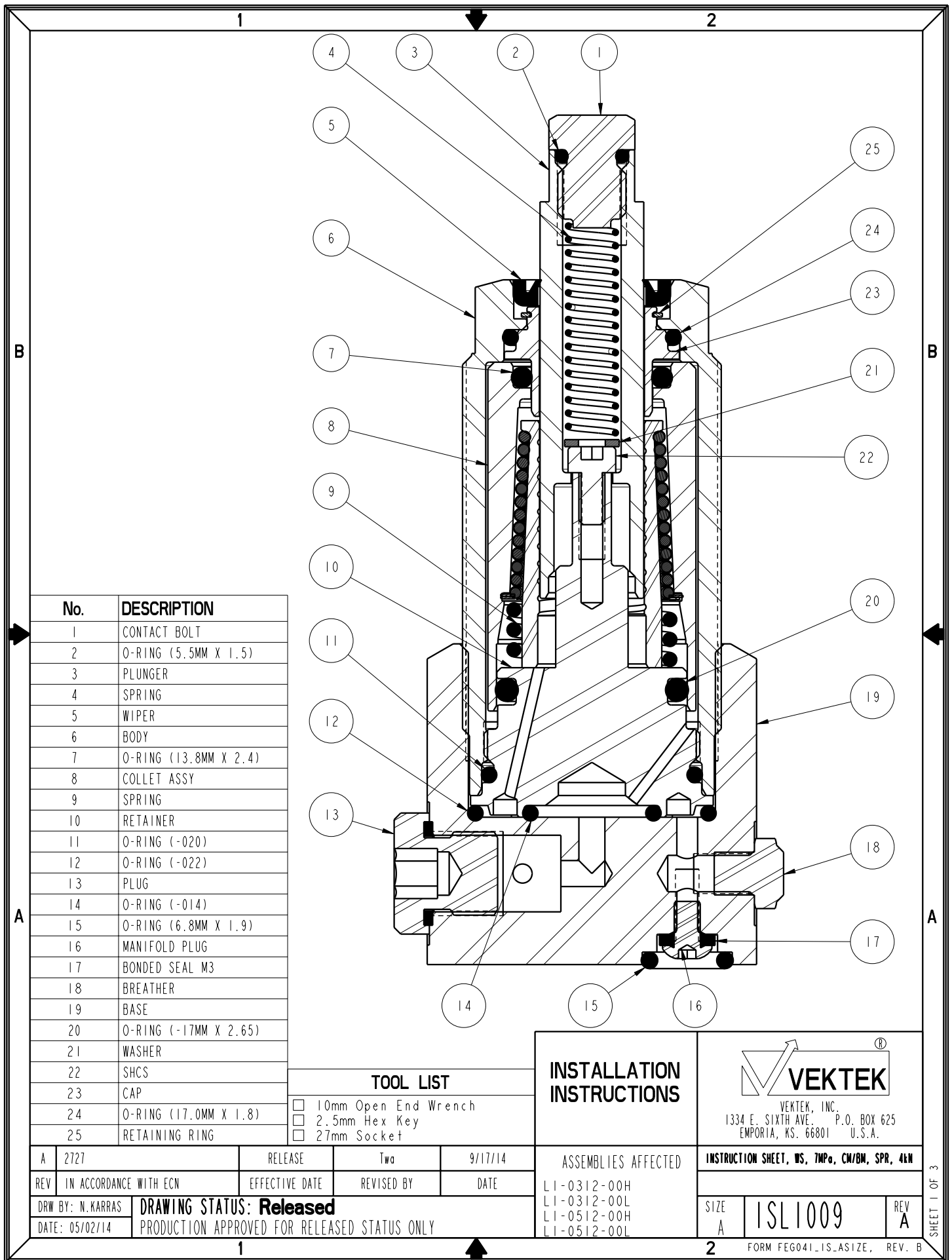
LPL1013

REV  
B

B	2846	RELEASE	Twa	05/01/15
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY:	Twa	<b>DRAWING STATUS: Released</b>		
DATE:	4/24/14	PRODUCTION APPROVED FOR RELEASED STATUS ONLY		

SHEET 1 OF 1

FORM FEG035\_PL\_ASIZE, REV. B



No.	DESCRIPTION
1	CONTACT BOLT
2	O-RING (5.5MM X 1.5)
3	PLUNGER
4	SPRING
5	WIPER
6	BODY
7	O-RING (13.8MM X 2.4)
8	COLLET ASSY
9	SPRING
10	RETAINER
11	O-RING (-020)
12	O-RING (-022)
13	PLUG
14	O-RING (-014)
15	O-RING (6.8MM X 1.9)
16	MANIFOLD PLUG
17	BONDED SEAL M3
18	BREATHER
19	BASE
20	O-RING (-17MM X 2.65)
21	WASHER
22	SHCS
23	CAP
24	O-RING (17.0MM X 1.8)
25	RETAINING RING

TOOL LIST	
<input type="checkbox"/>	10mm Open End Wrench
<input type="checkbox"/>	2.5mm Hex Key
<input type="checkbox"/>	27mm Socket

**INSTALLATION INSTRUCTIONS**

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

A	2727	RELEASE	Two	9/17/14
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY:	N. KARRAS	<b>DRAWING STATUS: Released</b>		
DATE:	05/02/14	PRODUCTION APPROVED FOR RELEASED STATUS ONLY		

ASSEMBLIES AFFECTED  
 LI-0312-00H  
 LI-0312-00L  
 LI-0512-00H  
 LI-0512-00L

INSTRUCTION SHEET, WS, 7MP, CW/BM, SPR, 4IN	
SIZE A	ISL1009
REV A	

Read all instructions before disassembly

Refer to the illustration on page 1 for component descriptions and tool list

### Disassembly


#### Model Number L1-0312-00H & L1-0312-00L

1. Using a 27mm socket, unscrew work support from fixture or base (19). Wipe clean to remove external contaminants.
2. Remove O-ring (14) from retainer (10) s'face or cavity (19). Be careful not to damage retainer (10) face.
3. Remove O-ring (12) from fixture or base cavity.
4. With 10mm wrench at plunger (3) and 10mm wrench at contact bolt (1), unscrew contact bolt (1) from plunger (3). Remove O-ring (2) from contact bolt (1).
5. Remove contact spring (4) and washer (21) from inside plunger (3).
6. Insert 2.5mm hex key into cap screw (22) inside plunger (3) and unscrew cap screw (22). Remove cap screw (22) from inside plunger (3).
7. Gently slide plunger (3) out from top of work support.
8. Remove wiper (5) from top of body (6). Be careful not to damage wiper bore or bore below wiper (5). To assist holding body (6) during wiper (5) removal, body (6) may be threaded into base (19) or fixture, be careful not to damage the body (6) or retainer face (10).
9. Thoroughly clean contact bolt (1), contact spring (4), plunger (3), cap screw (22), washer (21) and set aside to dry.
10. Wipe clean retainer (10) face located on bottom of work support. Wipe clean wiper bore located in body at top of work support.
11. Wipe clean work support cavity in fixture.

#### Model Number L1-0512-00H & L1-0512-00L

13. Remove work support base (19) from fixture and complete disassembly steps 1-10.
14. If work support hydraulics or vent is manifold fed from fixture, remove O-ring (15) from manifold s'face on base mounting face (2 places).
15. If work support hydraulics or vent is not manifold fed, insert 3mm hex key into plug (16) located at base (19) mounting face and unscrew plug (16) (2 places). Remove bonded seal (17) from plug (16).
16. Thoroughly clean base (19), plugs (16) and set aside to dry.

**Caution: Do not expose work support clamping mechanism (8) located above retainer (10) to any type of cleaning solutions. Removal of retainer (10) or clamping mechanism (8) terminates product warranty.**

		
VEKTEK, INC. 1334 E. SIXTH AVE. P.O. BOX 625 EMPORIA, KS. 66801 U.S.A.		
INSTRUCTION SHEET, WS, 7MP, CW/BM, SPR, 4LN		
SIZE A	ISL1009	REV A
FORM FEG041-1S-ASIZE, REV. B		

