


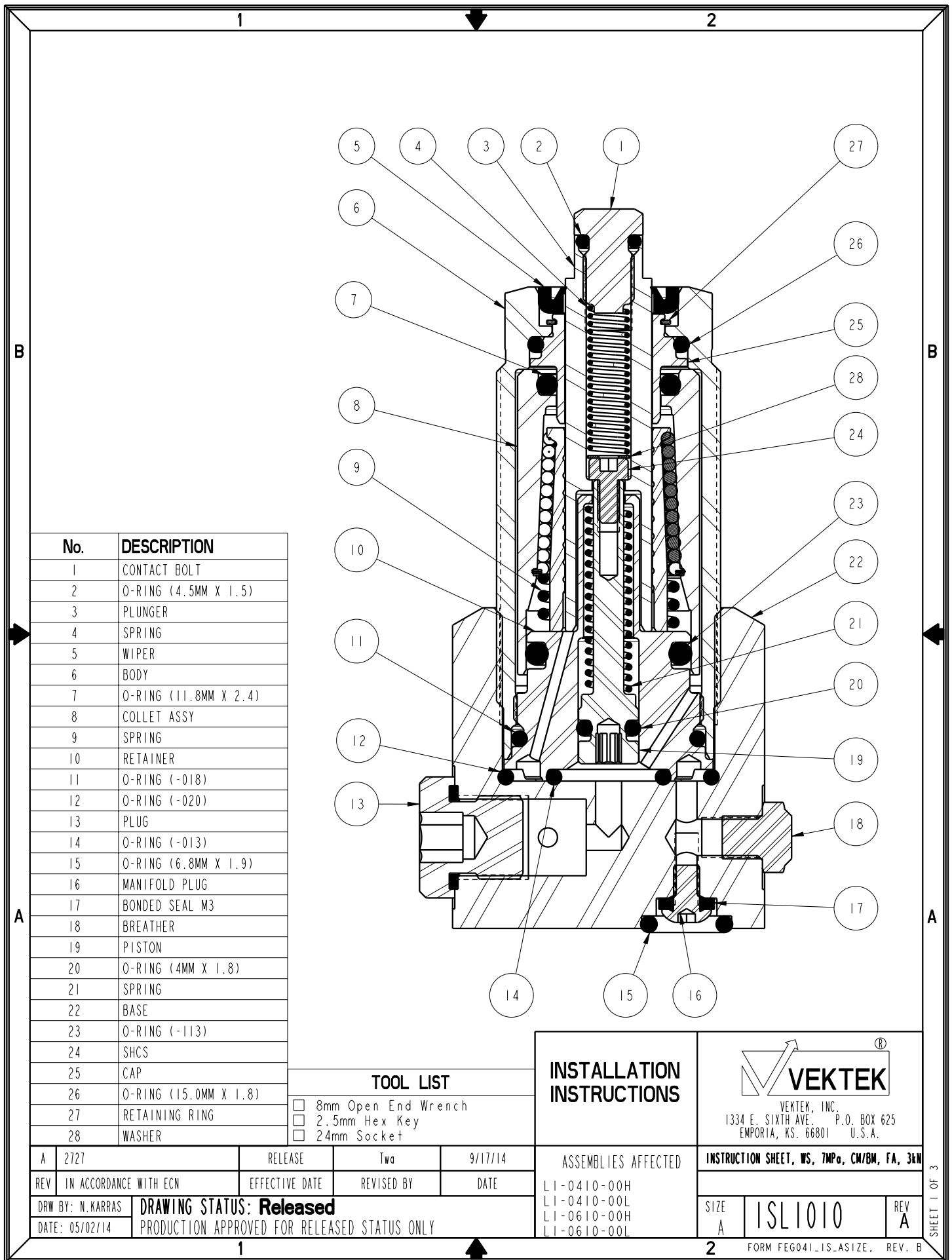
NO	QTY	PART NO	DESCRIPTION	STD SEAL KIT	LIGHT SPRING KIT	HEAVY SPRING KIT
1	1	23350102	SPRING, COMPRESSION		X	X
2	1	23350104	SPRING, COMPRESSION			X
3	1	39051117	O-RING, (3.75 X 1.8)	X	X	X
4	1	39051118	O-RING, (4.5mm X 1.5)	X	X	X
5	1	39051120	O-RING, (-020)	X	X	X
6	1	39051124	O-RING, (-013)	X	X	X
7	1	39053051	WIPER, PRESS-IN, 10mm	X		
8	1	81000032	CONTACT BOLT, WS, 7MPa, 3kN			
9	1	23350103	SPRING, COMPRESSION		X	
N/A	N/A	L6010007	KIT, SEAL, WS, 7MPa, CM/BM, 3kN	NOTED	N/A	N/A
N/A	N/A	L6110014	SPRING, KIT, WS, 7MPa, CM/BM, FA, 3kN	N/A	NOTED	N/A
N/A	N/A	L6110015	SPRING, KIT, WS, 7MPa, CM/BM, FA, 3kN	N/A	N/A	NOTED
N/A	N/A	ISL1010	INSTRUCTION SHEET, WS, 7MPa, CM/BM, FA, 3kN	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. EMPORIA, KS. 66801 P.O. BOX 625 U.S.A.	
ASSEMBLIES AFFECTED				PARTS LIST, ASSY, WS, 7MPa, CM, FA, 3kN	
L1-0410-00H				SIZE A	REV B
L1-0410-00L				LPL1014	

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



No.	DESCRIPTION
1	CONTACT BOLT
2	O-RING (4.5MM X 1.5)
3	PLUNGER
4	SPRING
5	WIPER
6	BODY
7	O-RING (11.8MM X 2.4)
8	COLLET ASSY
9	SPRING
10	RETAINER
11	O-RING (-018)
12	O-RING (-020)
13	PLUG
14	O-RING (-013)
15	O-RING (6.8MM X 1.9)
16	MANIFOLD PLUG
17	BONDED SEAL M3
18	BREATHER
19	PISTON
20	O-RING (4MM X 1.8)
21	SPRING
22	BASE
23	O-RING (-113)
24	SHCS
25	CAP
26	O-RING (15.0MM X 1.8)
27	RETAINING RING
28	WASHER

TOOL LIST			
<input type="checkbox"/>	8mm Open End Wrench		
<input type="checkbox"/>	2.5mm Hex Key		
<input type="checkbox"/>	24mm Socket		

### INSTALLATION INSTRUCTIONS

ASSEMBLIES AFFECTED

LI-0410-00H  
LI-0410-00L  
LI-0610-00H  
LI-0610-00L

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

INSTRUCTION SHEET, WS, 7MPo, CM/BM, FA, 3kN

SIZE A	ISLI010	REV A
-----------	---------	----------

FORM FEG041-IS-ASIZE, REV. B

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



## Assembly

### Model Number L1-0410-00H & L1-0410-00L

1. Lubricate new O-rings (2),(12),(14),(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 (21) onto piston (19) and insert piston (19) and return spring (21) into retainer (11) bore. Insert 2.5mm hex key into piston (19) and push inward to compress return spring (21). While holding piston (19) and return spring (21) in compressed position drop the cap screw (24) 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 (21) AND CONTACT SPRING (4) ARE NOT INTERCHANGEABLE.
6. Insert washer (28) into hole through top of plunger (3), followed by the contact spring (4).
7. Install O-ring (2) onto contact bolt (1).
8. Screw contact bolt (1) into top of plunger (3). With 8mm wrench at plunger (3) and 8mm wrench at contact bolt (1) torque to 9 N-m (80 in-lbs).
9. Install O-ring (14) into retainer (10) s'face.
10. Install O-ring (12) into bottom of fixture cavity.
11. Using 24mm socket, screw work support into fixture cavity. Torque to 34 N-m (25 ft-lb).

### Model Number L1-0610-00H & L1-0610-00L

12. Complete assembly steps 1 - 9.
13. Install O-ring (12) into bottom of base (22) cavity.
14. Using 24mm socket, screw work support into base (22) cavity. Torque to 34 n-m (25 ft-lb).
15. If work support hydraulics or vent is manifold fed from fixture, install new O-ring (15) 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 (17) onto plug (16), insert 3mm hex key nto 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, 7MPa, CM/BM, FA, 3kN

SIZE  
A

ISLI010

REV  
A

FORM FEG041-1S-ASIZE, REV. B

SHEET 3 OF 3