


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	PISTON
20	O-RING (4.87MM X 1.8)
21	SPRING
22	BASE
23	O-RING (17MM X 2.65)
24	WASHER
25	SHCS
26	CAP
27	O-RING (17.0MM X 1.8)
28	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.	
		INSTRUCTION SHEET, WS, 7MPa, CM/BN, FA, 4kN	
ASSEMBLIES AFFECTED LI-0412-00H LI-0412-00L LI-0612-00H LI-0612-00L		SIZE A	REV A

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

2

B

- B**

A

- A**

Assembly

Model Number L1-0412-00H & L1-0412-00L

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 (25) thread side down into hole through top of plunger (3). Insert 2.5mm hex key into cap screw (25) and torque to 2.5 N-m (20 in-lb). CAUTION: RETURN SPRING (21) AND CONTACT SPRING (4) ARE NOT INTERCHANGEABLE, NOTE LOCATION AND KEEP SEPARATE FOR REASSEMBLY.
6. Insert washer (24) 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 10mm wrench at plunger (3) and 10mm 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 27mm socket, screw work support into fixture cavity. Torque to 40 N-m (30 ft-lb).

Model Number L1-0612-00H & L1-0612-00L

12. Complete assembly steps 1 - 9.
13. Install O-ring (12) into bottom of base (22) cavity.
14. Using 27mm 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 (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, 4kN

SIZE
A

ISLI011

REV
A

FORM FEG041-1S-ASIZE, REV. B

SHEET 3 OF 3