

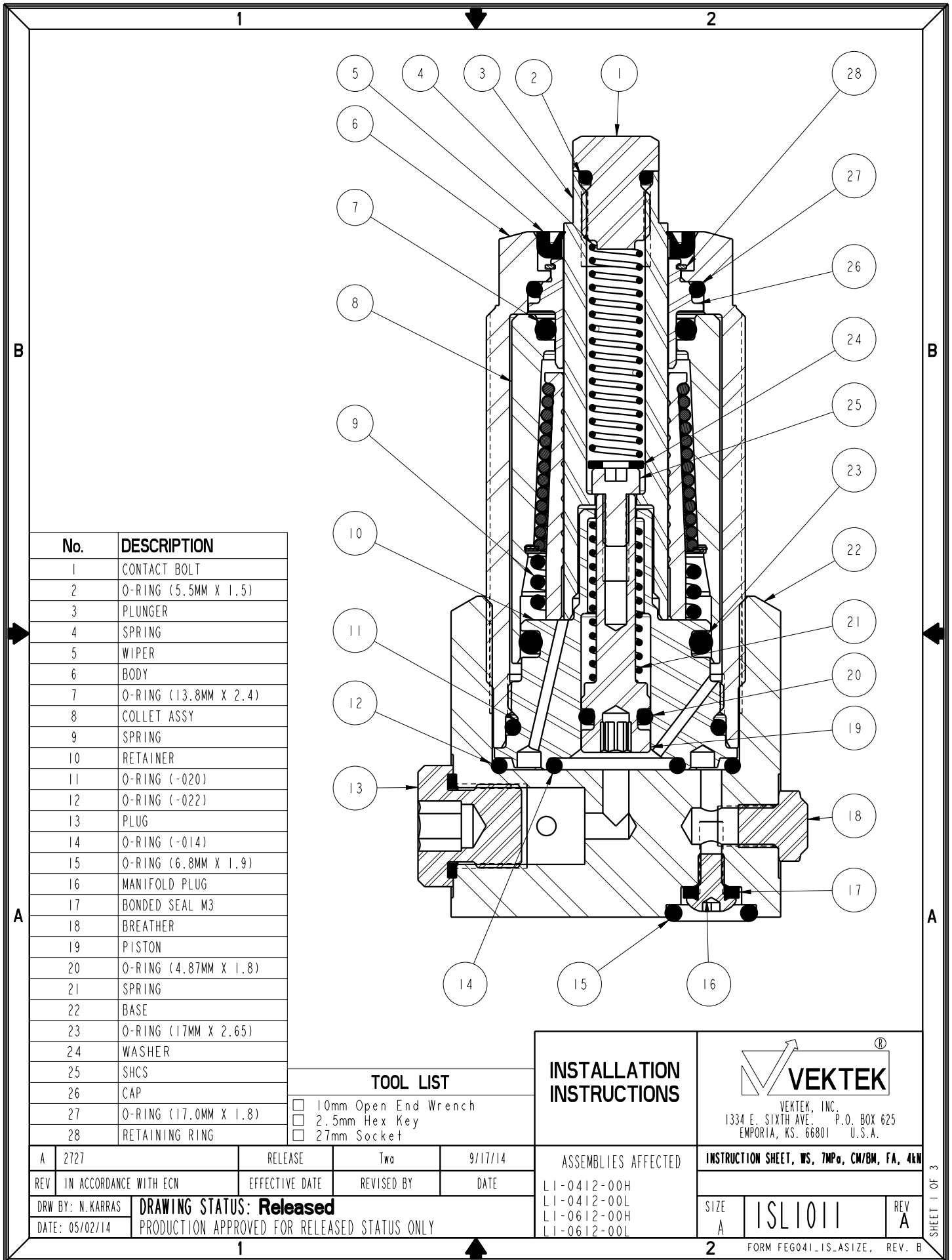
NO	QTY	PART NO	DESCRIPTION	STD SEAL KIT	LIGHT SPRING KIT	HEAVY SPRING KIT
1	2	21500019	SCREW, CAP, BTNH, M3 X 6, ALY			
2	1	23350099	SPRING, COMPRESSION		X	X
3	1	23350101	SPRING, COMPRESSION			X
4	1	39050085	O-RING, (-022)	X	X	X
5	1	39051107	O-RING, (4.87mm X 1.8)	X	X	X
6	1	39051108	O-RING, (5.5mm X 1.5)	X	X	X
7	1	39051114	O-RING, (-014)	X	X	X
8	2	39051116	O-RING, (6.8mm X 1.9)	X		
9	1	39053050	WIPER, PRESS-IN, 12mm	X		
10	2	39055011	SEAL, BONDED, M3	X		
11	2	43068004	PLUG, SOCH, G1/8			
12	1	81000031	CONTACT BOLT, WS, 7MPa, 4kN			
13	1	91000045	BASE, WS, 7MPa, 4kN			
14	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	L6110012	KIT, SPRING, WS, 7MPa, CM/BM, FA, 4kN	N/A	NOTED	N/A
N/A	N/A	L6110013	KIT, SPRING, WS, 7MPa, CM/BM, FA, 4kN	N/A	N/A	NOTED
N/A	N/A	ISL1011	INSTRUCTION SHEET, WS, 7MPa, CM/BM, FA, 4kN	N/A	N/A	N/A

See Instruction Sheet ISL1011 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	PARTS LIST, ASSY, WS, 7MPa, BM, FA, 4kN
L1-0612-00H L1-0612-00L	SIZE A LPL1019 REV C

C	3849	RELEASE	MJUST	7/8/19
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY:	Twa	DRAWING STATUS: Released PRODUCTION APPROVED FOR RELEASED STATUS ONLY		
DATE:	05/02/14			



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.

A	2727	RELEASE	Two	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		

ASSEMBLIES AFFECTED
 LI-0412-00H
 LI-0412-00L
 LI-0612-00H
 LI-0612-00L

INSTRUCTION SHEET, WS, 7MPo, CW/BM, FA, 4kN	
SIZE A	ISL1011
REV A	

SHEET 1 OF 3

1 ↓ 2


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, CW/BM, FA, 4kN		
SIZE A	ISL1011	REV A
FORM FEG041-IS-ASIZE, REV. B		

SHEET 3 OF 3