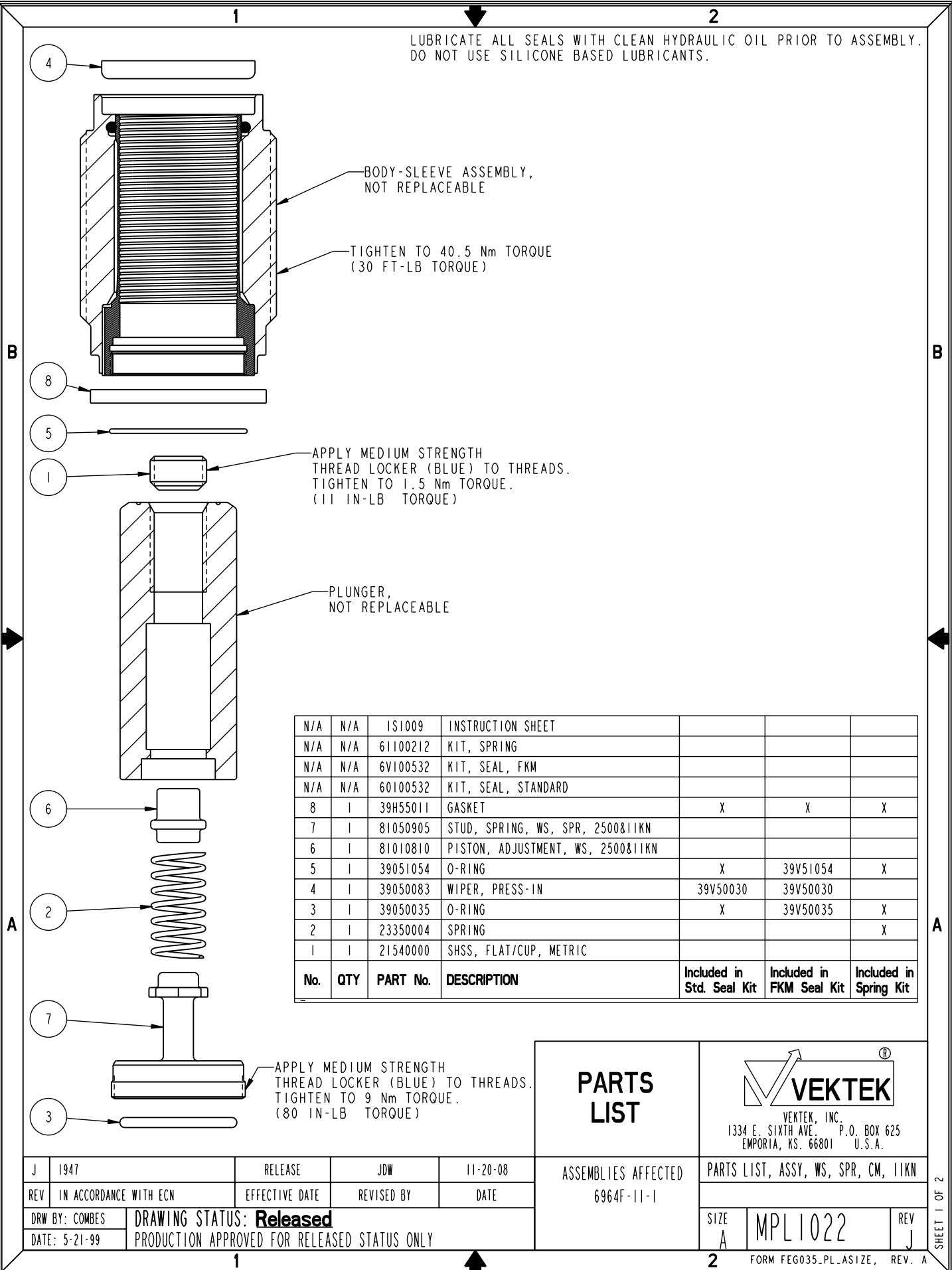


LUBRICATE ALL SEALS WITH CLEAN HYDRAULIC OIL PRIOR TO ASSEMBLY.
DO NOT USE SILICONE BASED LUBRICANTS.



N/A	N/A	IS1009	INSTRUCTION SHEET			
N/A	N/A	61100212	KIT, SPRING			
N/A	N/A	6V100532	KIT, SEAL, FKM			
N/A	N/A	60100532	KIT, SEAL, STANDARD			
8	1	39H55011	GASKET	X	X	X
7	1	81050905	STUD, SPRING, WS, SPR, 2500&11KN			
6	1	81010810	PISTON, ADJUSTMENT, WS, 2500&11KN			
5	1	39051054	O-RING	X	39V51054	X
4	1	39050083	WIPER, PRESS-IN	39V50030	39V50030	
3	1	39050035	O-RING	X	39V50035	X
2	1	23350004	SPRING			X
1	1	21540000	SHSS, FLAT/CUP, METRIC			
No.	QTY	PART No.	DESCRIPTION	Included in Std. Seal Kit	Included in FKM Seal Kit	Included in Spring Kit

PARTS LIST



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

ASSEMBLIES AFFECTED
6964F-11-1

PARTS LIST, ASSY, WS, SPR, CM, 11KN

SIZE
A MPL1022

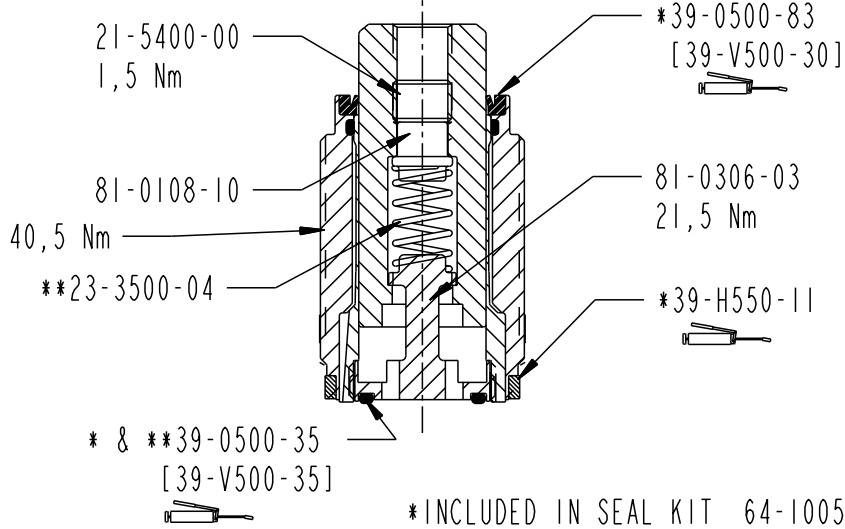
REV
J

J	1947	RELEASE	JDW	11-20-08
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY:	COMBES	DRAWING STATUS: Released		
DATE:	5-21-99	PRODUCTION APPROVED FOR RELEASED STATUS ONLY		

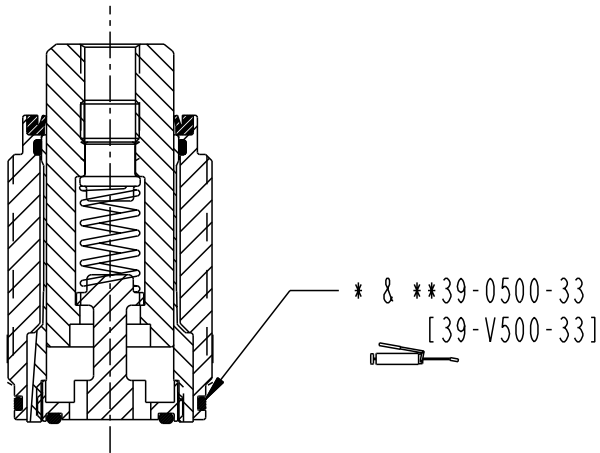
FORM FEG035_PL_ASIZE, REV. A

SHEET 1 OF 2

THIS PAGE APPLIES TO ASSEMBLIES BEFORE 4-1-2009



* INCLUDED IN SEAL KIT 64-1005-06
[6V-1005-06]
** INCLUDED IN SPRING KIT 61-1002-09



* INCLUDED IN SEAL KIT 64-1005-06
[6V-1005-06]
** INCLUDED IN SPRING KIT 61-1002-09

PARTS LIST



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

J	1947	RELEASE	JDW	11-20-08
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY: COMBES	DRAWING STATUS: Released			
DATE: 5-21-99	PRODUCTION APPROVED FOR RELEASED STATUS ONLY			

ASSEMBLIES AFFECTED
6964F-11-1
41-0051-01

PARTS LIST, ASSY, WS, SPR, CM, I1KN		
SIZE A	MPL1022	REV J

FORM FEG035_PL_ASIZE, REV. A

SHEET 2 OF 2

Vekttek, Inc. 1334 East Sixth Ave. P.O. Box 625 Emporia, Ks. 66801 U.S.A.	Instruction Sheet	IS1009		
		REVISION:	A , I.A.W. ECN1945	
		BY/DATE:	JDW	11-19-08
		APPR/DATE:	JAM	12-15-08
Title: Disassembly/Assembly: 2500 lb & 11 kN Spring Advance Work Supports				

Read all instructions before disassembly

Refer to the illustration on page three for component numbers and a tool list.

Disassembly

Notice: When disassembling multiple work supports, the plunger and body/sleeve assembly from each work support should be kept together.

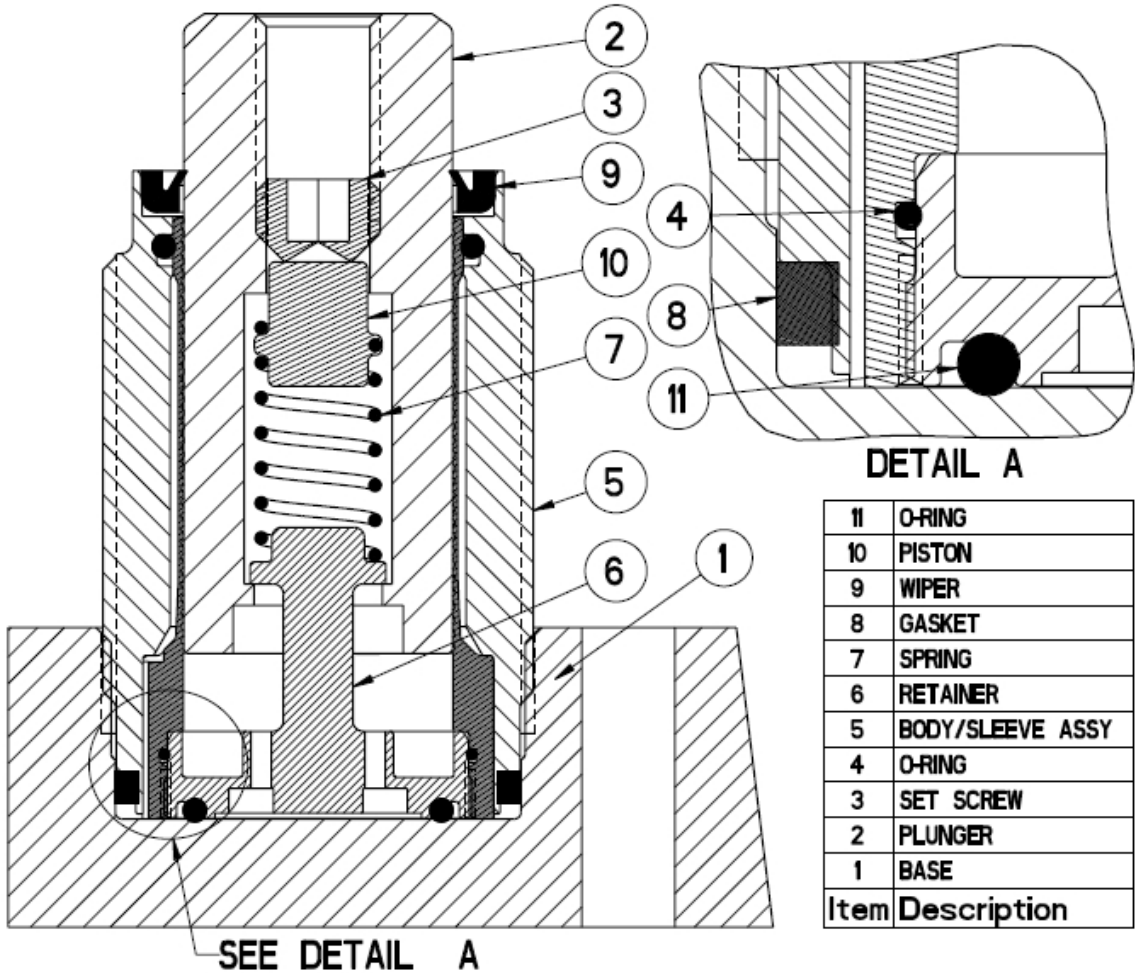
1. Clamp work support base (1) in a vise. Cartridge mounted work supports must remain in their fixture for steps two and three.
2. Connect a hydraulic power supply to the work support. Apply hydraulic pressure (approximately 1000 psi) to lock the plunger (2) in place.
3. Remove the set screw (3) from inside the tapped hole of the plunger (2).
4. Release the hydraulic pressure and disconnect the hydraulic line.
5. Remove the work support cartridge from the base (1) or fixture.
Caution- Use a six-point socket only. Other types of wrenches may damage the work support.
6. Unscrew the threaded retainer (6) from the body/sleeve assembly (5) and slide the retainer (6) and the plunger (2) out of the body/sleeve assembly (5).
7. Remove the o-rings (4) (11) and gasket (8).
8. Remove the retainer (6) from the plunger (2) by pushing the retainer (2) away from its seat and tipping it to one side, allowing it to slip out of the plunger (2) cavity.
9. Remove the wiper (9) from the body/sleeve assembly (5). **Caution--Do not damage the inner sleeve of the body/sleeve assembly (5).**
10. Clean all parts thoroughly and set aside to dry.

Vekttek, Inc. 1334 East Sixth Ave. P.O. Box 625 Emporia, Ks. 66801 U.S.A.	Instruction Sheet	IS1009		
		REVISION:	A , I.A.W. ECN1945	
		BY/DATE:	JDW	11-19-08
		APPR/DATE:	JAM	12-15-08
Title: Disassembly/Assembly: 2500 lb & 11 kN Spring Advance Work Supports				

Assembly

1. Lubricate the gasket (8) and o-rings (4) & (11) with clean hydraulic oil (Vekttek 65-0010-01 or equivalent). Apply Loctite primer N® or equivalent to the threads of the retainer (6) and set screw (3) then allow to dry.
2. Press the wiper (9) into the body/sleeve assembly (5), using only enough force to seat the wiper in the counterbore. **Caution: Excess force may cause the inner sleeve to collapse.**
3. Insert the piston (10) into the plunger (2) making certain that it seats against the bottom of the bore in the plunger (2).
4. Insert the spring (7) into the plunger (2) bore.
5. Insert the retainer (6) into the plunger (2) by tipping the retainer (6) to one side and slipping it through the smaller plunger (2) hole, allowing it to seat squarely on the opposite side of the plunger (2) hole. **Note: The retainer (2) should move smoothly up and down within the plunger (2) hole, when enough force is used to overcome the spring pressure.**
6. Place the o-ring (4) into the internal groove in the body/sleeve assembly (5). Apply medium strength Loctite 243® or equivalent to the retainer (6) threads and screw the retainer (6) into the body/sleeve assembly (5). Tighten to the torque specification on the parts list.
7. Place the o-ring (11) on the bottom of the retainer (6) and place the gasket (8) on the body/sleeve assembly (5).
8. Screw the body/sleeve assembly (5) into the base (1) or fixture cavity. The body/sleeve assembly (5) will come to a positive stop when it contacts the mating surface in the base (1) or fixture cavity.
9. Tighten the body/sleeve assembly (5) to the base (1) or fixture cavity using the torque specification on the parts list. **Caution- Use a six-point socket only. Other types of wrenches may damage the work support.**
10. Connect the hydraulic power supply to the work support. Apply hydraulic pressure (approximately 1000 psi) to lock the plunger (2) in place.
11. Apply medium strength Loctite 243® or equivalent to the threads of the set screw (3). Thread the set screw (3) into the plunger (2) and tighten to the torque specification on the parts list.
12. Release the pressure and disconnect the hydraulic line.

Vekttek, Inc. 1334 East Sixth Ave. P.O. Box 625 Emporia, Ks. 66801 U.S.A.	Instruction Sheet	IS1009		
		REVISION:	A , I.A.W. ECN1945	
		BY/DATE:	JDW	11-19-08
		APPR/DATE:	JAM	12-15-08
Title: Disassembly/Assembly: 2500 lb & 11 kN Spring Advance Work Supports				



11	O-RING
10	PISTON
9	WIPER
8	GASKET
7	SPRING
6	RETAINER
5	BODY/SLEEVE ASSY
4	O-RING
3	SET SCREW
2	PLUNGER
1	BASE
Item	Description

Model Number	Tool List
10050906 10050907 10050908	3/16 hex key, spanner wrench, 1-1/8 socket (6 pt)
41005106 41005006 6964F-11-1 6964F-11-2	5mm hex key, spanner wrench, 30mm socket (6 pt)