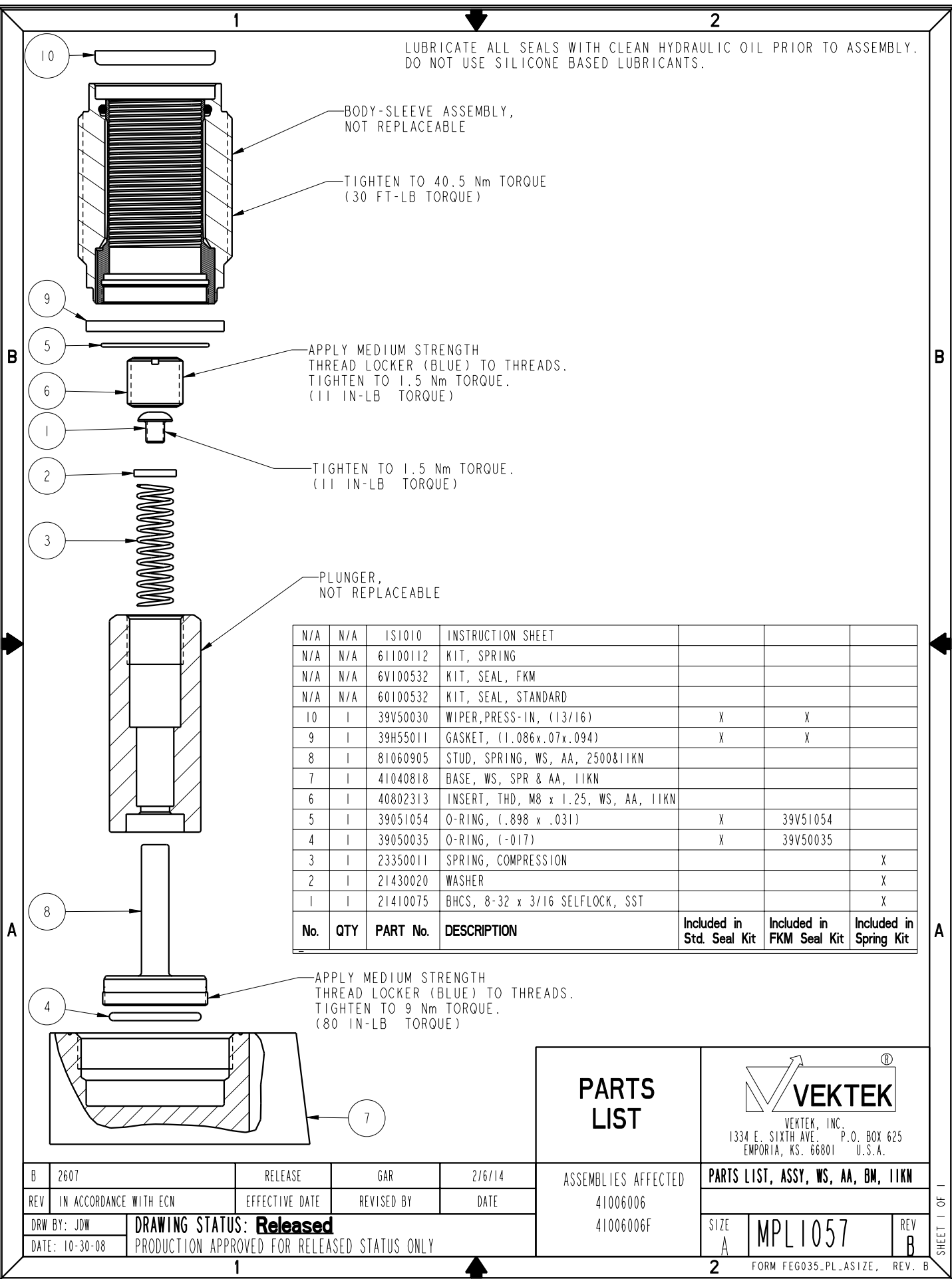


LUBRICATE ALL SEALS WITH CLEAN HYDRAULIC OIL PRIOR TO ASSEMBLY.
DO NOT USE SILICONE BASED LUBRICANTS.



BODY-SLEEVE ASSEMBLY,
NOT REPLACEABLE

TIGHTEN TO 40.5 Nm TORQUE
(30 FT-LB TORQUE)


APPLY MEDIUM STRENGTH
THREAD LOCKER (BLUE) TO THREADS.
TIGHTEN TO 1.5 Nm TORQUE.
(11 IN-LB TORQUE)

TIGHTEN TO 1.5 Nm TORQUE.
(11 IN-LB TORQUE)

PLUNGER,
NOT REPLACEABLE

APPLY MEDIUM STRENGTH
THREAD LOCKER (BLUE) TO THREADS.
TIGHTEN TO 9 Nm TORQUE.
(80 IN-LB TORQUE)

N/A	N/A	IS1010	INSTRUCTION SHEET			
N/A	N/A	61100112	KIT, SPRING			
N/A	N/A	6V100532	KIT, SEAL, FKM			
N/A	N/A	60100532	KIT, SEAL, STANDARD			
10	1	39V50030	WIPER, PRESS-IN, (13/16)	X	X	
9	1	39H55011	GASKET, (1.086x.07x.094)	X	X	
8	1	81060905	STUD, SPRING, WS, AA, 2500811KN			
7	1	41040818	BASE, WS, SPR & AA, 11KN			
6	1	40802313	INSERT, THD, M8 x 1.25, WS, AA, 11KN			
5	1	39051054	O-RING, (-.898 x .031)	X	39V51054	
4	1	39050035	O-RING, (-.017)	X	39V50035	
3	1	23350011	SPRING, COMPRESSION			X
2	1	21430020	WASHER			X
1	1	21410075	BHCS, 8-32 x 3/16 SELFLOCK, SST			X
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.	
	PARTS LIST, ASSY, WS, AA, BM, 11KN	
ASSEMBLIES AFFECTED	41006006	41006006F
SIZE	A	MPL1057
REV	B	

B	2607	RELEASE	GAR	2/6/14
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY:	JDW	DRAWING STATUS: Released PRODUCTION APPROVED FOR RELEASED STATUS ONLY		
DATE:	10-30-08			

Vekttek, Inc. 1334 East Sixth Ave. P.O. Box 625 Emporia, Ks. 66801 U.S.A.	Instruction Sheet	IS1010	
		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 Air 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.

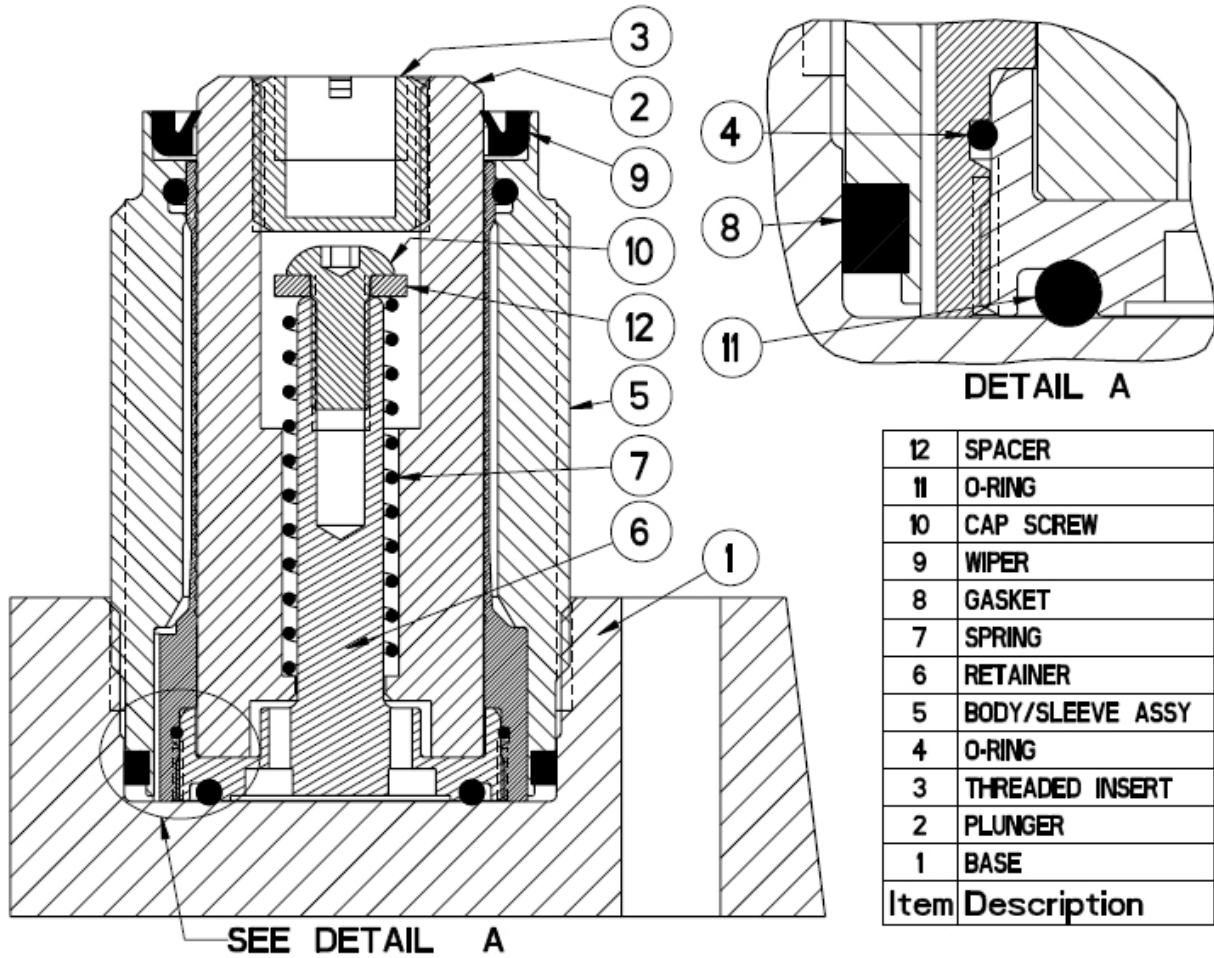
1. Clamp the work support base (1) in a vise. Cartridge mounted work supports must remain in their fixture for steps two and three.
2. Connect a hydraulic power supply to the work support. Apply hydraulic pressure (approximately 1000 psi) to lock the plunger (2) in place.
3. Remove the threaded insert (3) from the plunger (2).
4. Release the hydraulic pressure and disconnect the hydraulic line.
5. Remove the body/sleeve assembly (5) from the base (1) or fixture.
Caution--Use a six-point socket only. Other types of wrenches may damage the work support.
6. Remove O-ring (11) and gasket (8).
7. Unscrew cap screw (10) and remove spacer (12) and spring (7) from the plunger (2).
8. Unscrew the retainer (6) from the body/sleeve assembly (5).
9. Slide the plunger (2) out of the body/sleeve assembly (5).
10. Remove O-ring (4) from the internal groove in the body/sleeve assembly (5).
11. Remove the wiper (9) from the body/sleeve assembly (5). **Caution--Do not damage the inner sleeve of the body/sleeve assembly (5).**
12. 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	IS1010	
		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 Air Advance Work Supports			

Assembly

1. Before assembly, 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 threaded insert (3), retainer (6) and 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 retainer (6) into the plunger (2).
4. Install the spring (7) and then spacer (12) onto the retainer (6). Apply one drop of low strength Loctite 222® or equivalent, to the cap screw (10) threads and tighten to the torque specification on the parts list.
5. Place the O-ring (4) into the internal groove in the body/sleeve assembly (5). Apply one drop of medium strength Loctite 243® or equivalent, to the retainer (6) threads and insert the plunger (2) and retainer (6) assembly into the body/sleeve assembly (5). Tighten to the torque specification on the parts list.
6. Install the O-ring (11) on the retainer (6), and the gasket (8) onto the body/sleeve assembly (5).
7. Insert the body/sleeve assembly (5) into the base (1) or fixture cavity and tighten to the torque specification on the parts list. **Caution--Use a six-point socket only. Other types of wrenches may damage the work support.**
8. Connect the hydraulic power supply to the work support. Apply hydraulic pressure (approximately 1000 psi) to lock the plunger (2) in place.
9. Apply one drop of medium strength Loctite 243® or equivalent to the threaded insert (3) and tighten to the torque specification on the parts list.
10. 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		IS1010		
			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 Air Advance Work Supports					



Model Number	Tool List
10060906 10060907 10060908	3/32 hex key, spanner wrench, screwdriver, 1-1/8 socket (6 pt)
41006106 41006006 6964L-11-1 6964L-11-2	3/32 hex key, spanner wrench, screwdriver, 30mm socket (6 pt)