



SEE IS1023 FOR SERVICE INSTRUCTIONS.
LUBRICATE ALL SEALS WITH CLEAN
HYDRAULIC OIL PRIOR TO ASSEMBLY.
DO NOT USE SILICONE BASED LUBRICANTS.



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

TORQUE TO
1.25 Nm
(11 IN-LB)

PLUNGER
These work supports are
fully rebuildable to full
factory original capacity by
any authorized Vekttek repair
facility. All seals can be
replaced by any authorized
repair facility.

BODY ASSEMBLY
NOT REPLACEABLE
TORQUE TO 67.8 Nm
(50 FT-LB)

INSTALL LIP
SIDE TOWARD
BOTTOM OF PISTON

TORQUE TO
5.7 Nm
(50 IN-LB)

TORQUE TO
13.5 Nm
(120 IN-LB)

TORQUE TO
1.25 Nm
(11 IN-LB)

FOR MANIFOLD
MOUNTING, REMOVE
BHCS & BONDED
SEAL FROM BASE
AND INSERT O-RING
INTO COUNTERBORE

NO	QTY	PART NO	DESCRIPTION	STD SEAL KIT	SPRING KIT
1	1	21410075	BHCS, 8-32 x 3/16 SELFLOCK, SST		
2	1	21430001	WASHER		
3	2	21500019	SCREW, CAP, BTNH, M3 X 6, ALY		
4	1	21500046	SCREW, CAP, BTNH, M5-0.8 X 6, ALY		
5	1	23350002	SPRING, COMPRESSION		X
6	1	23350059	SPRING, COMPRESSION		X
7	1	39000061	O-RING, (-016)	X	
8	1	39002009	O-RING, (-012)	X	
9	1	39050028	SEAL, BEVEL, 3/16 X 7/16 X 1/8	X	
10	2	39051116	O-RING, (6.8mm X 1.9)	X	
11	1	39054039	BU RING, (-201)	X	
12	2	39055011	SEAL, BONDED, M3	X	
13	1	39055013	SEAL, BONDED, M5	X	
14	1	41060802	BOLT, CONTACT, WS, 17.8kN		
15	2	43068004	PLUG, SOCH, G1/8		
16	1	81010817	PISTON, WS, FA, HC, 4000		
17	1	91040617	KIT, BASE, WS, FA, MM, HC, 17.8kN		
18	1	39V10023	WIPER, PRESS-IN, (3/4), VBGV	X	
N/A	N/A	60100133	KIT, SEAL, WS, FA, BM, HC, 17.8kN	NOTED	N/A
N/A	N/A	61100222	KIT, SPRING, WS, FA, HC, 4000	N/A	NOTED
N/A	N/A	IS1023	INSTRUCTION SHEET	N/A	N/A

PARTS LIST



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

ASSEMBLIES AFFECTED
41080820

PARTS LIST, ASSY, WS, FA, BM, HC, 17.8kN

SIZE
A MPL1090

REV
D

D	4993	RELEASE	RLK	12/7/22
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY:	ALS	DRAWING STATUS: Released		
DATE:	06/10/19	PRODUCTION APPROVED FOR RELEASED STATUS ONLY		

SHEET 1 OF 1