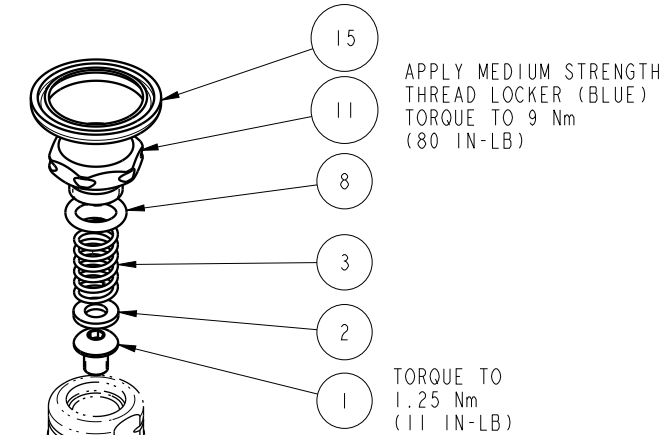
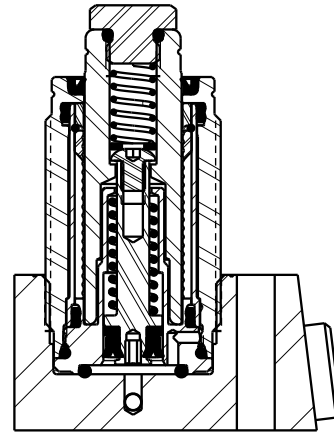




SEE IS1023 FOR SERVICE INSTRUCTIONS.  
LUBRICATE ALL SEALS WITH CLEAN  
HYDRAULIC OIL PRIOR TO ASSEMBLY.  
DO NOT USE SILICONE BASED LUBRICANTS.

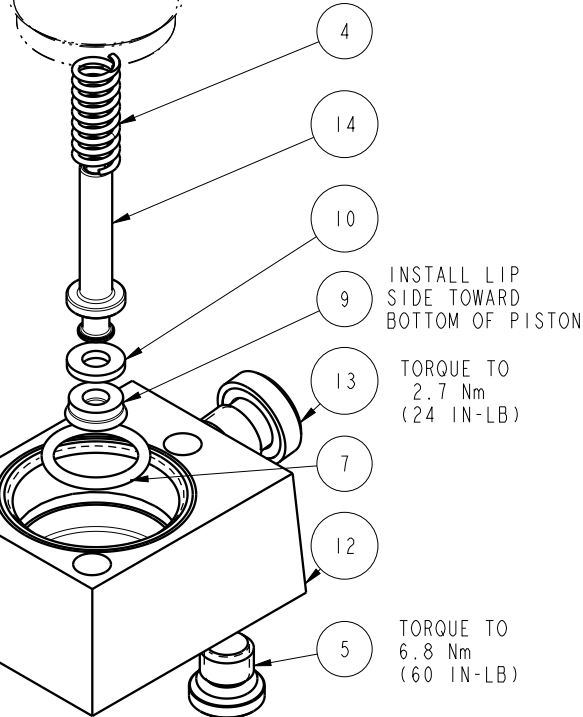


APPLY MEDIUM STRENGTH  
THREAD LOCKER (BLUE)  
TORQUE TO 9 Nm  
(80 IN-LB)

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 47.5 Nm  
(35 FT-LB)



INSTALL LIP  
SIDE TOWARD  
BOTTOM OF PISTON

TORQUE TO  
2.7 Nm  
(24 IN-LB)

TORQUE TO  
6.8 Nm  
(60 IN-LB)

FOR MANIFOLD MOUNTING,  
REMOVE SAE 2 PLUG FROM  
BASE AND INSERT O-RING  
INTO COUNTERBORE

NO	QTY	PART NO	DESCRIPTION	STD SEAL KIT	SPRING KIT
1	1	21410076	BHCS, 6-32 x 3/16 SELFLOCK, SST		
2	1	21430012	WASHER		
3	1	23350060	SPRING, COMPRESSION		X
4	1	23350122	SPRING, COMPRESSION		X
5	1	30601123	PLUG, SOCH, SAE 2		
6	1	39000068	O-RING, (-202)	X	
7	1	39050008	O-RING, (-014)	X	
8	1	39051059	O-RING, (6mm x 1.5)	X	
9	1	39052057	SEAL, BEVEL, 3/32 X 5/32 X 11/32	X	
10	1	39054035	BU RING, (.157 X .089)	X	
11	1	41040602	BOLT, CONTACT, WS, FA, 4.4 KN		
12	1	41040607	BASE, WS, FA, 4.4 & 6.2 KN		
13	1	43068004	PLUG, SOCH, G1/8		
14	1	81010615	PISTON, WS, FA, HC, 2000		
15	1	39V53003	WIPER, PRESS-IN, (9/16), VBGV	X	
N/A	N/A	60100136	KIT, SEAL, WS, FA, BM, HC, 8.9KN, 3 BOLT	NOTED	N/A
N/A	N/A	61100223	KIT, SPRING, WS, FA, HC, 2000	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  
41080610

PARTS LIST, ASSY, WS, FA, BM, HC, 8.9KN, 3 BOLT  
DROP-IN REPLACEMENT FOR 41007004

SIZE  
A MPL1093

REV  
B

SHEET 1 OF 1

B	4096	RELEASE	MJUST	4/1/20
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY:	ALS	<b>DRAWING STATUS: Released</b>		
DATE:	06/10/19	PRODUCTION APPROVED FOR RELEASED STATUS ONLY		

<b>Vektek LLC</b> 1334 East Sixth Ave. P.O. Box 625 Emporia, Ks. 66801 U.S.A.	<b>Instruction Sheet</b>	<b>IS</b>	<b>1023</b>	
		<b>REV:</b>	<b>C, I.A.W ECN3930</b>	
		<b>REV. BY/DATE:</b>	<b>ALS</b>	<b>10/03/19</b>
		<b>APPR/DATE:</b>	<b>TDK</b>	<b>10/04/19</b>
<b>TITLE: Disassembly/Assembly Instructions: Inch and Metric High Capacity Fluid Advance Work Supports</b>				

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

**Read all instructions prior to disassembling!**

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

## **Disassembly**

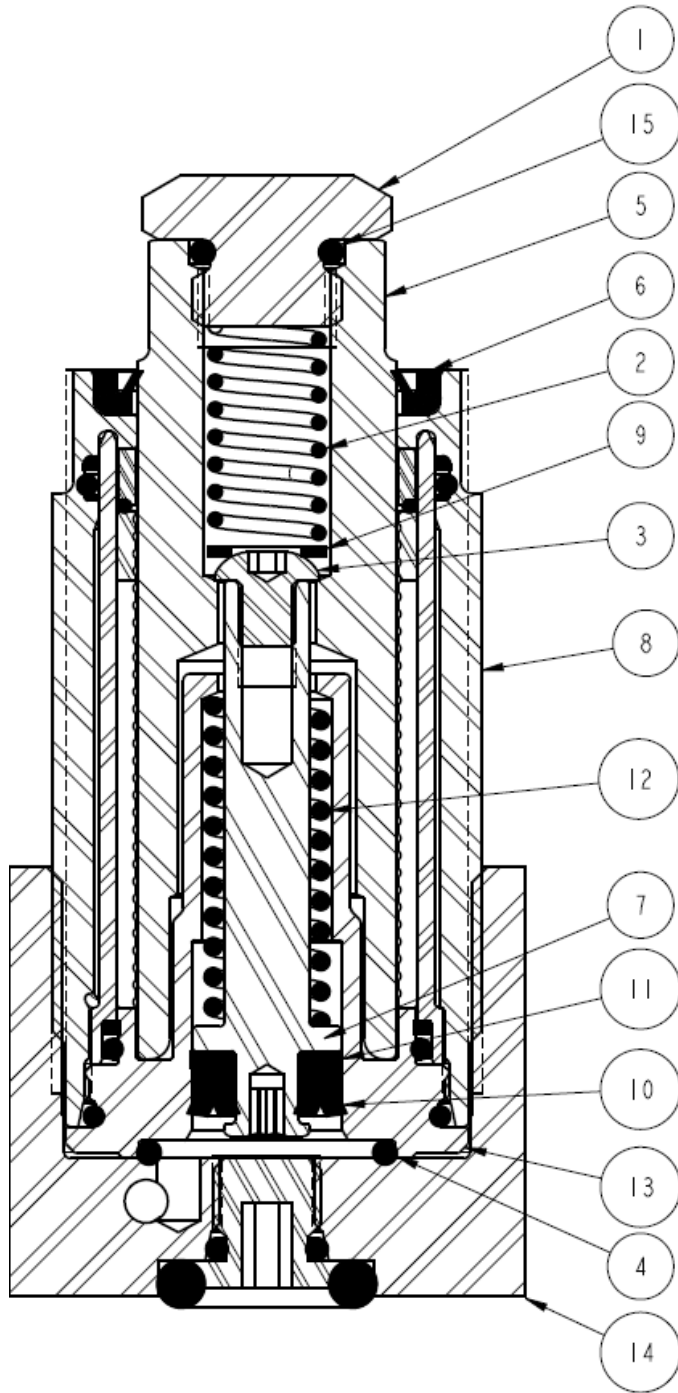
1. Unscrew the cartridge assembly (8) from the base (14) or fixture. **Caution- Use a six-point socket only. Other types of wrenches may damage the work support.**
2. Hold the plunger (5) stationary and unscrew the contact bolt (1). Remove contact o-ring (15) from contact bolt (1).
3. Remove the spring (2) and spacer (9) from inside the plunger (5).
4. Hold the piston (7) stationary and unscrew the cap screw (3).
5. Slide the plunger (5) out of the top of the cartridge assembly (8) and then push the piston (7) and spring (12) out of the retainer (13).
6. Remove the wiper (6) from the cartridge assembly (8).
7. Remove the piston seal (10) and piston seal back-up ring (11) from the piston (7), and the seal (4) from the base (14) or fixture.
8. Clean all parts thoroughly and set aside to dry.

Vekttek LLC 1334 East Sixth Ave. P.O. Box 625 Emporia, Ks. 66801 U.S.A.	Instruction Sheet	IS	1023	
		REV:	C, I.A.W ECN3930	
		REV. BY/DATE:	ALS	10/03/19
		APPR/DATE:	TDK	10/04/19
<b>TITLE: Disassembly/Assembly Instructions: Inch and Metric High Capacity Fluid Advance Work Supports</b>				

## Assembly

1. Lubricate all O-rings, gaskets, back-up rings and seals with clean hydraulic fluid (Vekttek 65-0010-01 or equivalent). Apply Loctite primer N® or equivalent to the threads of the contact bolt (1) and the retainer (13) and set aside to dry.
2. First install the back-up ring (11) then the piston seal (10) onto the piston (7) with the sealing lips of the piston seal (10) toward the piston (7) base.
3. Slide the spring (12) onto the piston (7) and insert both parts into the retainer (13).
4. Insert the plunger (5) into the top of the cartridge assembly (8).
5. While holding the piston (7) stationary insert the cap screw (3) into the top of the plunger (5) and thread the cap screw (3) into the piston (7). Tighten to the specification on the parts list.
6. Insert the flat washer (9) and the spring (2) into the top of the plunger (5).
7. Install contact o-ring (15) onto contact bolt (1). Apply one drop of Loctite 243® or equivalent to the threads of the contact bolt (1). While holding the plunger (5) stationary tighten the contact bolt (1) to the plunger (5). Tighten to the torque specification on the parts list.
8. If using o-ring, place the o-ring (4) flat in the bottom of the retainer (13). Insert the work support assembly into the base (14) or mounting cavity and tighten it to the torque specification on the parts list.  
**Caution- Use a six-point socket only. Other types of wrenches may damage the work support. Note- Use o-ring if cavity abides by ILS100716, ILS100717, or ILMV100723. Use o-ring OR gasket, not both.**
9. If using gasket, place the gasket (4) flat in the bottom of the base (14) or mounting cavity. Insert the work support assembly into the base (14) or mounting cavity and tighten it to the torque specification on the parts list.  
**Caution- Use a six-point socket only. Other types of wrenches may damage the work support.**

<b>Vekttek LLC</b> 1334 East Sixth Ave. P.O. Box 625 Emporia, Ks. 66801 U.S.A.	<b>Instruction Sheet</b>	<b>IS 1023</b>	
		<b>REV: C, I.A.W ECN3930</b>	
		<b>REV. BY/DATE: ALS</b>	<b>10/03/19</b>
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<b>TITLE: Disassembly/Assembly Instructions: Inch and Metric High Capacity Fluid Advance Work Supports</b>			



15	CONTACT O-RING
14	BASE
13	RETAINER
12	CONTACT SPRING
11	BACK-UP RING
10	PISTON SEAL
9	FLAT WASHER
8	CARTRIDGE ASSY
7	PISTON
6	WIPER
5	PLUNGER
4	SEAL
3	CAP SCREW
2	CONTACT SPRING
1	CONTACT BOLT
<b>Item</b>	<b>Description</b>