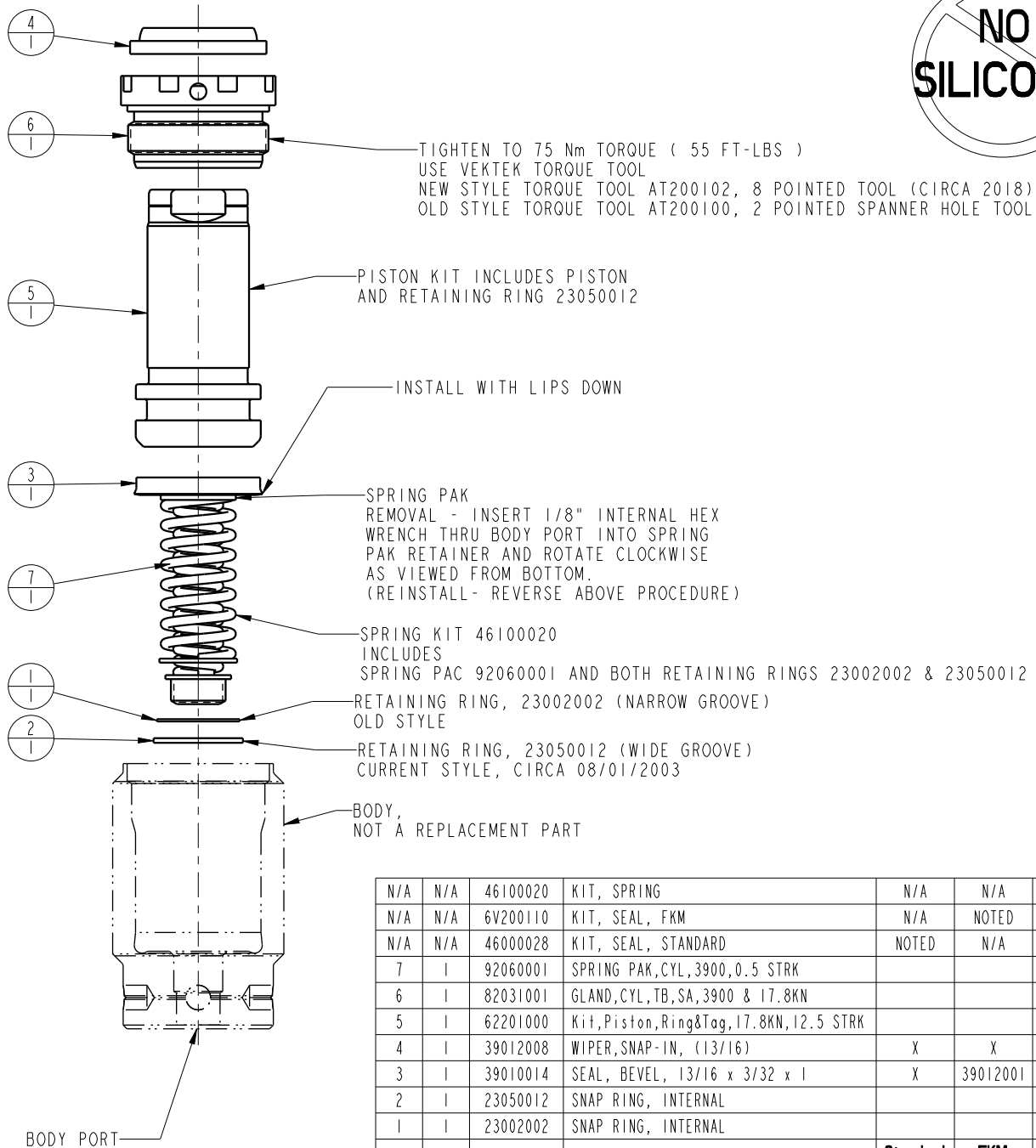


LUBRICATE ALL SEALS WITH CLEAN HYDRAULIC OIL PRIOR TO ASSEMBLY. DO NOT USE SILICONE BASED LUBRICANTS.



TIGHTEN TO 75 Nm TORQUE ( 55 FT-LBS )  
 USE VEKTEK TORQUE TOOL  
 NEW STYLE TORQUE TOOL AT200102, 8 POINTED TOOL (CIRCA 2018)  
 OLD STYLE TORQUE TOOL AT200100, 2 POINTED SPANNER HOLE TOOL

PISTON KIT INCLUDES PISTON AND RETAINING RING 23050012

INSTALL WITH LIPS DOWN

SPRING PAK  
 REMOVAL - INSERT 1/8" INTERNAL HEX WRENCH THRU BODY PORT INTO SPRING PAK RETAINER AND ROTATE CLOCKWISE AS VIEWED FROM BOTTOM. (REINSTALL- REVERSE ABOVE PROCEDURE)

SPRING KIT 46100020 INCLUDES SPRING PAC 92060001 AND BOTH RETAINING RINGS 23002002 & 23050012

RETAINING RING, 23002002 (NARROW GROOVE) OLD STYLE

RETAINING RING, 23050012 (WIDE GROOVE) CURRENT STYLE, CIRCA 08/01/2003

BODY, NOT A REPLACEMENT PART

BODY PORT

No.	QTY	PART No.	DESCRIPTION	Standard Seal Kit	FKM Seal Kit	Spring Kit
N/A	N/A	46100020	KIT, SPRING	N/A	N/A	NOTED
N/A	N/A	6V200110	KIT, SEAL, FKM	N/A	NOTED	N/A
N/A	N/A	46000028	KIT, SEAL, STANDARD	NOTED	N/A	N/A
7	1	92060001	SPRING PAK,CYL,3900,0.5 STRK			X
6	1	82031001	GLAND,CYL,TB,SA,3900 & 17.8KN			
5	1	62201000	Kit,Piston, Ring&Tag,17.8KN,12.5 STRK			
4	1	39012008	WIPER,SNAP-IN, (13/16)	X	X	
3	1	39010014	SEAL, BEVEL, 13/16 x 3/32 x 1	X	39012001	
2	1	23050012	SNAP RING, INTERNAL			X
1	1	23002002	SNAP RING, INTERNAL			X

**PARTS LIST**



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

ASSEMBLIES AFFECTED  
 42001003

PARTS LIST, ASSY,CYL,TB,17.8KN,12.5 STRK,SA

SIZE A MPL2046

REV J

SHEET 1 OF 1

J	4249	RELEASE	JDW	08/10/20
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY:	BUSH	<b>DRAWING STATUS: Released</b>		
DATE:	12/13/94	PRODUCTION APPROVED FOR RELEASED STATUS ONLY		

FORM FEG035\_PL\_ASIZE, REV. B