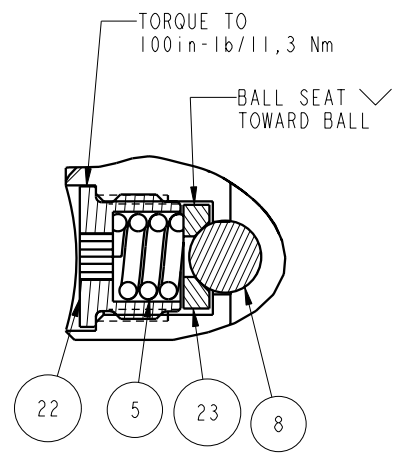
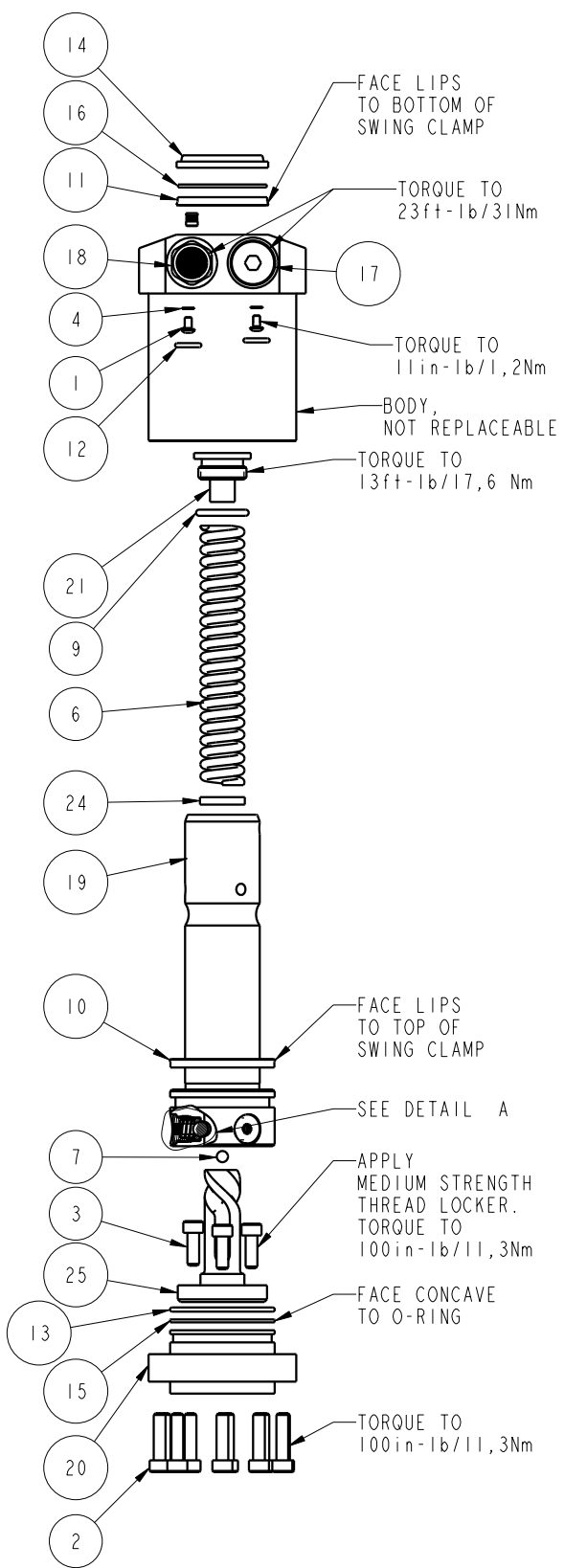


APPLY LUBRICANT TO ALL SEALS  
PRIOR TO INSTALLATION.  
DO NOT USE SILICONE TYPE LUBRICANTS.  
FOR PROPER ARM MOUNTING SEE IS1505.



DETAIL A  
SCALE 1.500

No.	QTY	PART No.	DESCRIPTION	Std. Seal Kit	FKM Seal Kit	Spring Kit
N/A	N/A	IS1505	INSTRUCTION SHEET, ARM INSTALLATION			
N/A	N/A	61704022	SPRING KIT			
N/A	N/A	6V711031	SEAL KIT, FKM			
N/A	N/A	60711031	SEAL KIT, STANDARD			
25	1	81591823	CAM, SC, LP, 5000/22KN, LH, TC			
24	1	81591302	DISK, 0.75 X .12			X
23	3	81532108	SEAT, BALL, SC, LP, TC			
22	3	81532107	RETAINER, SC, LP, TC			
21	1	81531811	PLUG, SC, LP, 5000&22KN, SA, TC			
20	1	81531809	CAP, END, SC, LP, 22KN/5000			
19	1	81511810	PLUNGER, SC, LP, 5000&22KN, SA, TC			
18	1	49001905	BREATHER, 1/4 BSPP			
17	1	43068006	PLUG, 1/4 BSPP MALE			
16	1	39054008	BU RING, (-218), HYTREL	X	X	
15	1	39054007	BU RING, (-030), 90 NBR	X	39054021	
14	1	39053005	WIPER, SNAP-IN, (1-1/4), 90 FKM	X	X	
13	1	39051042	O-RING, (-030), 1.814x.070, 90 HNBR	X	39V01021	
12	2	39050042	O-RING, (-011), .301x.070, 90 AUD	X	39051025	
11	1	39011060	SEAL, BEV, INSR, 1.25x.125x1.5, 85 HNBR	X	39052015	
10	1	39011055	SEAL, BEV, I-9/16x3/32x1-3/4, 85 AU	X	39052013	
9	1	39000029	O-RING, (-115), .674x.103, 90 NBR	X	X	X
8	3	23650004	BALL, TUNGSTEN-CARBIDE.250			
7	1	23600011	BALL, STEEL, ALLOY, .187			X
6	1	23350067	SPRING, COMP., 738X.142X5.3X3.24, 133			X
5	3	23350066	SPRING, COMP., 296X.06X.31X.21, 903			
4	2	21500200	WASHER, .124x.207x.024, COPPER			
3	3	21500031	SHCS, M5 x 0.8 x 14, ALY			
2	10	21500022	SHCS, M5 x .8-66 x 20, ALY			
1	2	21500019	SCREW, CAP, BTNH, M3 X 6, ALY			

**PARTS LIST**



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

ASSEMBLIES AFFECTED  
41462212

PARTS LIST, ASSY, SC, LP, TC, TF, 22KN, SA, LH

SIZE A  
**MPL7142**

B	2583	RELEASE	JDW	10/29/13
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY:	JDW	<b>DRAWING STATUS: Released</b>		
DATE:	6-7-11	PRODUCTION APPROVED FOR RELEASED STATUS ONLY		

**1      2**

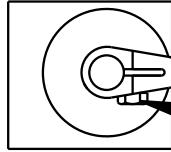
↓

# READ ALL INSTRUCTIONS BEFORE INSTALLING ARMS FAILURE TO FOLLOW INSTALLATION INSTRUCTIONS WILL VOID PRODUCT WARRANTY !

## –Installing or Positioning of Low Profile Swing Clamp Arms–

**NOTE: If the arm is already installed on the plunger,  
loosen the cap screw.**

**CAUTION: Never attempt to rotate the arm before loosening  
the cap screw. This can damage the plunger rotating mechanism.**




- 1. Rotate the arm to the desired radial position.**
- 2. Tighten to the torque specification listed below.**

MODEL	TORQUE ft-lb	TORQUE N-m
5000lb & 22Kn	115 ft-lb	156 N-m
7500lb & 33Kn	225 ft-lb	305 N-m

**IT IS RECOMMEND THE CROSS BOLT  
BE REPLACED IF THE ARM NEEDS  
REMOVED AFTER IT HAS BEEN IN SERVICE.**

CROSS BOLT	CROSS BOLT	CROSS BOLT	CROSS BOLT
5000 & 22KN	5000 & 22KN	7500 & 33KN	7500 & 33KN
SHORT LONG DOUBLE	UPREACH	SHORT LONG DOUBLE	UPREACH
21-5000-24	21-5000-25	21-5000-28	21-5000-25

<b>Instruction Sheet</b>	 <p>VEKTEK, INC. 1334 E. SIXTH AVE.      P.O. BOX 625 EMPORIA, KS. 66801      U.S.A.</p>		
	<b>Arm Installation Instruction Sheet</b>		
	<b>Low Profile Swing Clamps</b>		
SIZE A	1S1505		REV C

C	2799	RELEASE	JDW	01/29/15
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY: MES	<b>DRAWING STATUS: Released</b>			
DATE: 08/01/05	PRODUCTION APPROVED FOR RELEASED STATUS ONLY			