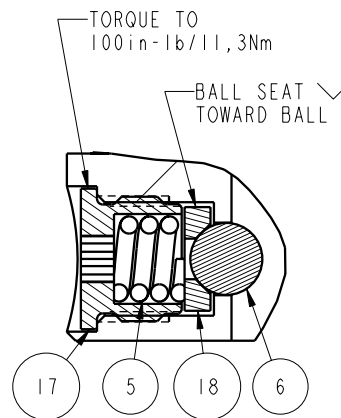
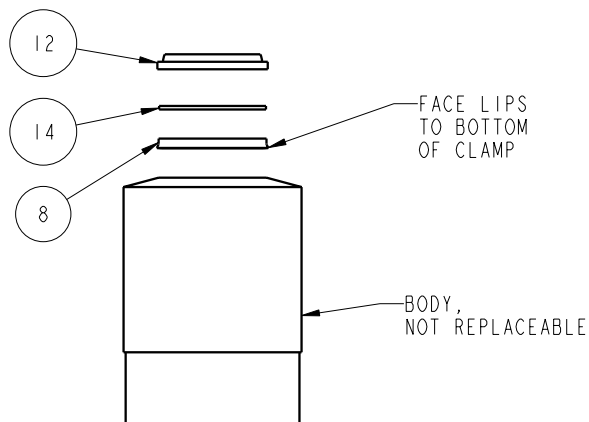
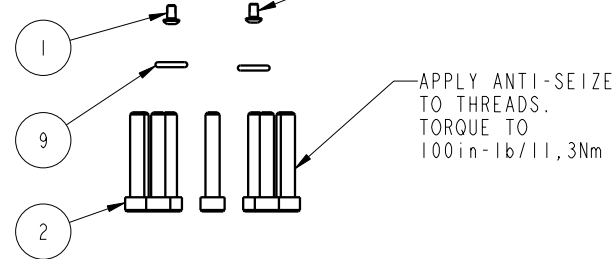
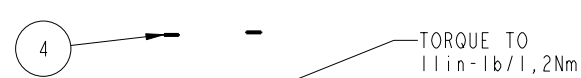
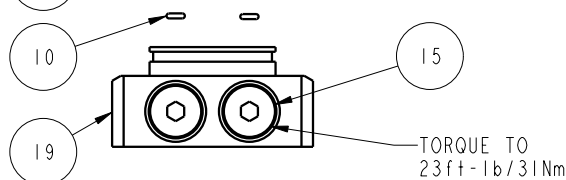
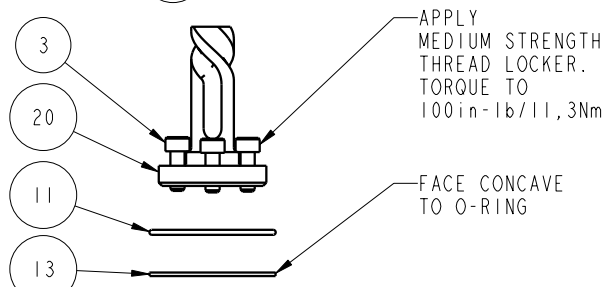
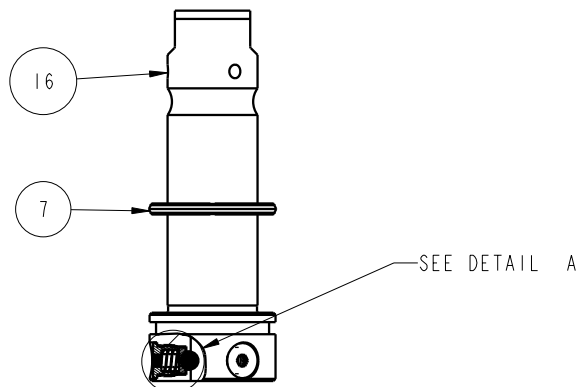



APPLY LUBRICANT TO ALL SEALS  
PRIOR TO INSTALLATION.  
DO NOT USE SILICONE TYPE LUBRICANTS.  
FOR PROPER ARM MOUNTING SEE IS1505.



DETAIL A  
SCALE 1.500



No.	QTY	PART No.	DESCRIPTION	Std. Seal Kit	FKM Seal Kit
N/A	N/A	IS1505	INSTRUCTION SHEET, ARM INSTALLATION		
N/A	N/A	6V711042	SEAL KIT, FKM		
N/A	N/A	60711042	SEAL KIT, STANDARD		
20	1	81591823	CAM, SC, LP, 5000/22KN, LH, TC		
19	1	81541807	BASE, SC, BF, LP, 22KN		
18	3	81532108	SEAT, BALL, SC, LP, TC		
17	3	81532107	RETAINER, SC, LP, TC		
16	1	81511811	PLUNGER, SC, LP, 5000&22KN, DA, TC		
15	2	43068006	PLUG, 1/4 BSPP MALE		
14	1	39054008	BU RING, (-218), HYTREL	X	X
13	1	39054007	BU RING, (-030), 90 NBR	X	39054021
12	1	39053005	WIPER, SNAP-IN, (-1/4), 90 FKM	X	X
11	1	39051042	O-RING, (-030), 1.814x.070, 90 HNBR	X	39V01021
10	2	39051041	O-RING, (-006), .114x.070, 90 HNBR	X	39V51041
9	2	39050042	O-RING, (-011), .301x.070, 90 AUD	X	39051025
8	1	39011060	SEAL, BEV, INSR, 1.25x.125x1.5, 85 HNBR	X	39052015
7	1	39011056	SEAL, CROWN, 1-9/16x1-3/4x5/32, 90AU	X	39V11056
6	3	23650004	BALL, TUNGSTEN-CARBIDE, .250		
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	21500023	SHCS, M5 X .8-66 X 30MM		
1	2	21500019	SCREW, CAP, BTNH, M3 X 6, ALY		

<b>PARTS LIST</b>	 VEKTEK, INC. 1334 E. SIXTH AVE. P.O. BOX 625 EMPORIA, KS. 66801 U.S.A.
	ASSEMBLIES AFFECTED 41422222
PARTS LIST, ASSY, SC, LP, TC, BF, 22KN, DA, LH	SIZE A <b>MPL7165</b>
REV B	SHEET 1 OF 1

B	2583	RELEASE	JDW	10/29/13
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY:	JDW	DRAWING STATUS: <b>Released</b> PRODUCTION APPROVED FOR RELEASED STATUS ONLY		
DATE:	6-17-11			

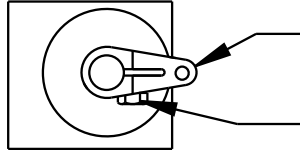
**1**      **2**

**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

**Instruction  
Sheet**



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

**Arm Installation Instruction Sheet**

**Low Profile Swing Clamps**

SIZE A	IS1505	REV C
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FORM FEG041-IS-ASIZE, REV. B

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			

SHEET 1 OF 1