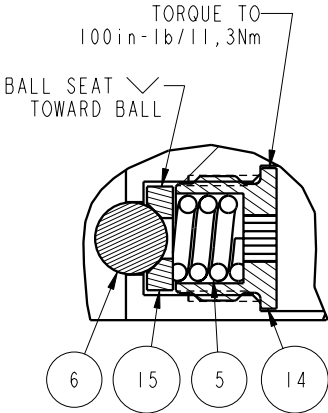


APPLY LUBRICANT TO ALL SEALS  
PRIOR TO INSTALLATION.  
DO NOT USE SILICONE TYPE LUBRICANTS.  
FOR PROPER ARM MOUNTING SEE IS1505.



DETAIL A  
SCALE 1.500

N/A	N/A	IS1505	INSTRUCTION SHEET, ARM INSTALLATION		
N/A	N/A	6V711044	SEAL KIT, FKM		
N/A	N/A	60711044	SEAL KIT, STANDARD		
20	1	39V11051	WIPER, PRESS-IN, 1-1/2", 85 FKM	X	X
19	1	39H52000	SEAL, BEV, 1-1/2x1/8x1-3/4, 85 HNBR	X	39V52000
18	1	39H51002	O-RING, (-033), 1.989x.070, 90 HNBR	X	39V51002
17	1	81592121	CAM, SC, LP, 7500/33KN, RH, TC		
16	1	81542102	BASE, SC, BF, LP, 33KN		
15	3	81532108	SEAT, BALL, SC, LP, TC		
14	3	81532107	RETAINER, SC, LP, TC		
13	1	81512111	PLUNGER, SC, LP, 7500&33KN, DA, TC		
12	2	43068006	PLUG, 1/4 BSPP MALE		
11	1	39054017	BU RING, (-033), 90 NBR	X	39054023
10	1	39054016	BU RING, 1.5x.125x.063, HYTREL	X	X
9	1	39052030	SEAL, CROWN, 1-3/4x2-1/8x1/4, 90AU	X	39V52030
8	2	39051041	O-RING, (-006), 1.14x.070, 90 HNBR	X	39V51041
7	2	39050042	O-RING, (-011), .301x.070, 90 AUD	X	39051025
6	3	23650004	BALL, TUNGSTEN-CARBIDE. 250		
5	3	23350066	SPRING, COMP., .296x.06x.31x.21, 903		
4	10	21500305	SHCS, M8 X 1, 25-66 X 30MM		
3	2	21500200	WASHER, .124x.207x.024, COPPER		
2	3	21500031	SHCS, M5 X 0,8 X 14, ALY		
1	2	21500019	SCREW, CAP, BTNH, M3 X 6, ALY		
No.	QTY	PART No.	DESCRIPTION	Std. Seal Kit	FKM Seal Kit

<h2>PARTS LIST</h2>	<p>VEKTEK, INC. 1334 E. SIXTH AVE. P.O. BOX 625 EMPORIA, KS. 66801 U.S.A.</p>
	ASSEMBLIES AFFECTED 41423321
SIZE A	MPL7174
REV B	

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:	6-17-11	PRODUCTION APPROVED FOR RELEASED STATUS ONLY		

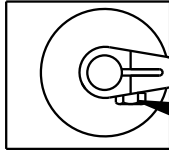
**1**      **2**

**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
50001b & 22Kn	115 ft-lb	156 N-m
75001b & 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