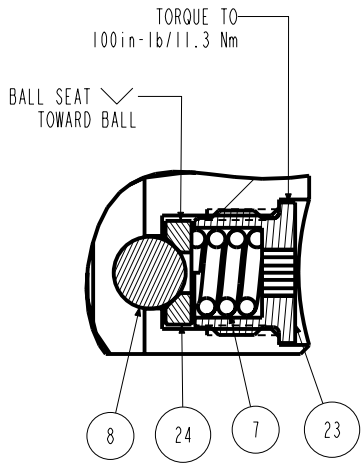


APPLY LUBRICANT TO ALL SEALS
PRIOR TO INSTALLATION.
DO NOT USE SILICONE TYPE LUBRICANTS.
FOR PROPER ARM MOUNTING SEE IS1505.



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	6V711052	SEAL KIT, FKM		
N/A	N/A	60711052	SEAL KIT, STANDARD		
26	1	39V10029	WIPER, PRESS-IN, (1/4)	X	X
25	1	81591837	CAM, SC, LP, 22KN, RH, LS, TC, PR		
24	3	81532108	SEAT, BALL, SC, LP, TC		
23	3	81532107	RETAINER, SC, LP, TC		
22	1	81531819	CAP, END, SC, LP, 22KN/5000, PR		
21	1	81511822	PLUNGER, SC, LP, 22KN, DA, LS, TC, PR		
20	1	81500042	ROD, ACTUATOR, SC, LP, TF, 22KN, LS		
19	1	81500040	RING, LOCATOR, SC, LP, PR		
18	1	81500039	BUSHING, PLUNGER, PR, SC, LP		
17	2	43068006	PLUG, 1/4 BSPP MALE		
16	1	39054008	BU RING, (-218)	X	X
15	1	39054007	BU RING, (-030)	X	39054021
14	1	39053005	WIPER, SNAP-IN, (1-1/4)	X	X
13	1	39052043	SEAL, LL, (1/4 X 1/8 X 1/8 X 1/2)	X	39V52043
12	1	39051042	O-RING, (-030)	X	39V01021
11	2	39050042	O-RING, (-011)	X	39051025
10	1	39011060	SEAL, BEVEL WHEEL INSERT, 1-1/4 x 1/8 x 1-1/2	X	39052015
9	1	39011056	SEAL, CROWN, 1-9/16 x 1-3/4 x 5/32	X	39V11056
8	3	23650004	BALL, TUNGSTEN-CARBIDE, 250		
7	3	23350066	SPRING, COMPRESSION		
6	2	21500200	WASHER		
5	3	21500031	SHCS, M5 x 0.8 x 14, ALY		
4	10	21500022	SHCS, M5 x .8-6G x 20, ALY		
3	2	21500019	SCREW, CAP, BTNH, M3 X 6, ALY		
2	1	21430022	WASHER		
1	1	21410049	SCREW, CAP, SOCH, 8-32 X 3/8, ALY		

PARTS LIST



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

ASSEMBLIES AFFECTED
41462223PR

PARTS LIST, ASSY, SC, LP, TC, TF, 22KN, DA, RH, LS, PR

SIZE
A **MPL7204**

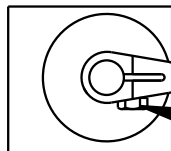
REV
A

A	2679	RELEASE	JDW	10/29/13
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY:	JDW	DRAWING STATUS: Released		
DATE:	10/16/13	PRODUCTION APPROVED FOR RELEASED STATUS ONLY		

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

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

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	IS1505	REV
A		C