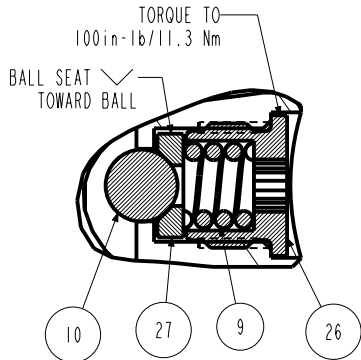
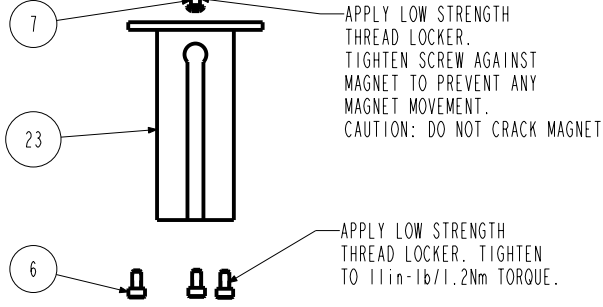
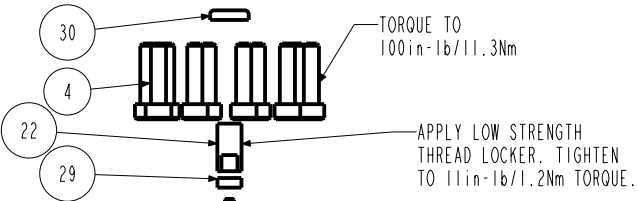
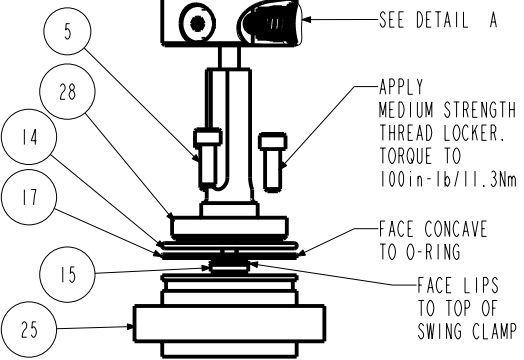
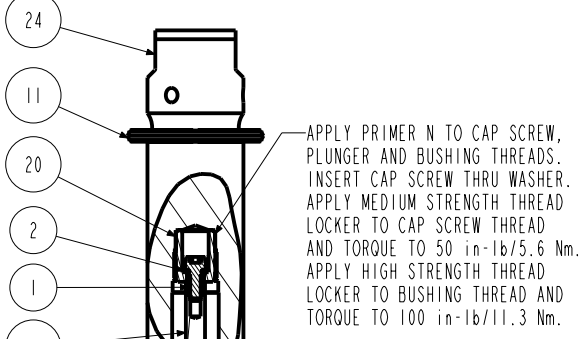


APPLY LUBRICANT TO ALL SEALS PRIOR TO INSTALLATION. DO NOT USE SILICONE TYPE LUBRICANTS. FOR PROPER ARM MOUNTING SEE IS1505.



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		
30	1	39V10029	WIPER,PRESS-IN, (1/4)	x	x
29	1	91100001	MAGNET, .130 x .312, PS		
28	1	81591834	CAM,SC,LP,5000/22KN,STR,TC,PR		
27	3	81532108	SEAT, BALL, SC, LP, TC		
26	3	81532107	RETAINER, SC, LP, TC		
25	1	81531819	CAP_END,SC,LP,22KN/5000,PR		
24	1	81511821	PLUNGER,SC,LP,5000/22KN,DA,TC,PR		
23	1	81500061	HOUSING,PS,MAG,SC,LP		
22	1	81500060	ADAPTOR,PS,MAG,SC,LP		
21	1	81500041	ROD,ACTUATOR,SC,LP,TF,22KN		
20	1	81500039	BUSHING,PLUNGER,PR,SC,LP		
19	2	43068006	PLUG, 1/4 BSPP MALE		
18	1	39054008	BU RING, (-218)	x	x
17	1	39054007	BU RING, (-030)	x	39054021
16	1	39053005	WIPER,SNAP-IN, (1-1/4)	x	x
15	1	39052043	SEAL, LL, (1/4 X 1/8 X 1/8 X 1/2)	x	x
14	1	39051042	O-RING, (-030)	x	39V01021
13	2	39050042	O-RING, (-011)	x	39051025
12	1	39011060	SEAL,BEVEL W/HEEL INSERT,1-1/4 x1/8 x1-1/2	x	39052015
11	1	39011056	SEAL,CROWN,1-9/16x1-3/4x5/32	x	39V11056
10	3	23650004	BALL,TUNGSTEN-CARBIDE.250		
9	3	23350066	SPRING, COMPRESSION		
8	2	21500200	WASHER		
7	1	21500044	SCREW, CAP, BTNH, M3-0.5 X 6,SSTL		
6	3	21500043	SHCS, M3-0.5 X 6 ALY		
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 41462225PS	<b>PARTS LIST, ASSY, SC, LP, TC, TF, 22KN, DA, STR, PS</b>
SIZE A	<b>MPL7219</b>
FORM FEG035_PL_ASIZE, REV. B	REV A

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

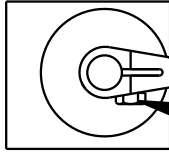
**1**      **2**

# 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



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

### Instruction Sheet

<b>Arm Installation Instruction Sheet</b>		
<b>Low Profile Swing Clamps</b>		
SIZE A	<b>1S1505</b>	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> PRODUCTION APPROVED FOR RELEASED STATUS ONLY		
DATE: 08/01/05				