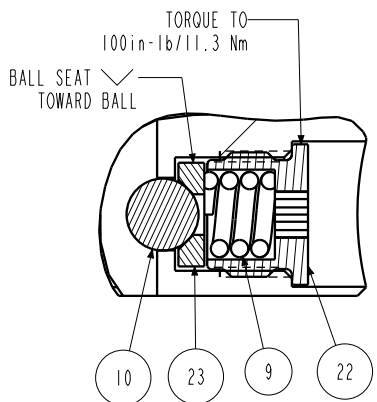
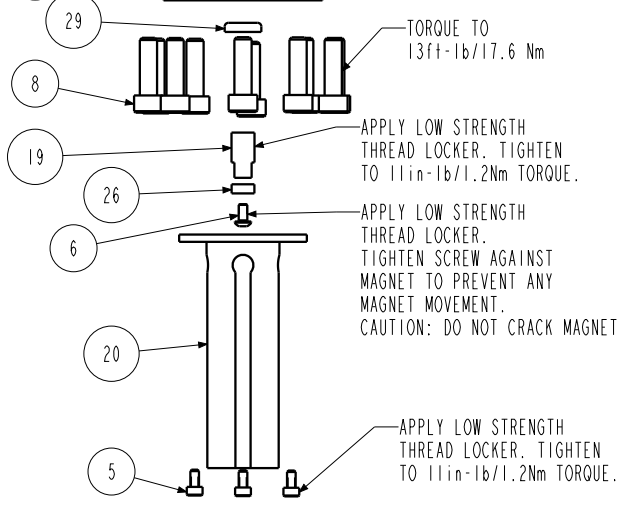
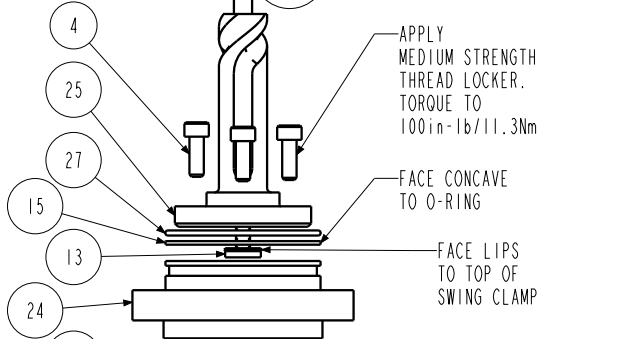
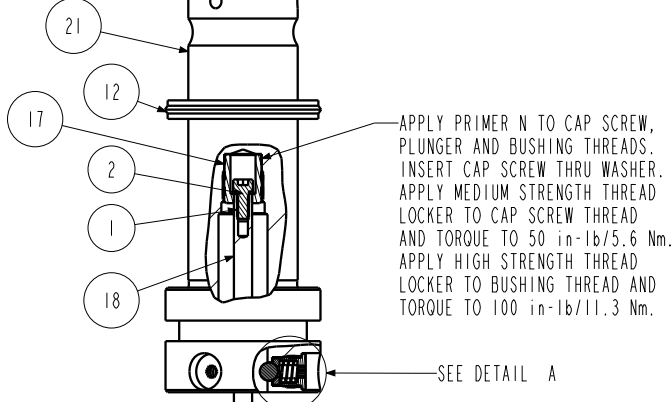


APPLY LUBRICANT TO ALL SEALS
PRIOR TO INSTALLATION.
DO NOT USE SILICONE TYPE LUBRICANTS.
FOR PROPER ARM MOUNTING SEE IS1505.



DETAIL A
SCALE 1.500



| N/A | N/A | IS1505 | INSTRUCTION SHEET, ARM INSTALLATION | | |
|-----|-----|----------|--|---------------|--------------|
| N/A | N/A | 6V711054 | SEAL KIT, FKM | | |
| N/A | N/A | 60711054 | SEAL KIT, STANDARD | | |
| 30 | 1 | 39V11051 | WIPER, PRESS-IN, (1-1/2) | X | X |
| 29 | 1 | 39V10029 | WIPER, PRESS-IN, (1/4) | X | X |
| 28 | 1 | 39H52000 | SEAL, U-CUP, 1-1/2 x 1/8 x 1-3/4 | X | 39V52000 |
| 27 | 1 | 39H51002 | O-RING, (-033) | X | 39V51002 |
| 26 | 1 | 91100001 | MAGNET, .130 x .312, PS | | |
| 25 | 1 | 81592136 | CAM, SC, LP, 7500/33KN, RH, LS, TC, PR | | |
| 24 | 1 | 81532115 | CAP, END, SC, LP, 33KN/7500, PR | | |
| 23 | 3 | 81532108 | SEAT, BALL, SC, LP, TC | | |
| 22 | 3 | 81532107 | RETAINER, SC, LP, TC | | |
| 21 | 1 | 81512122 | PLUNGER, SC, LP, 7500/33KN, DA, LS, TC, PR | | |
| 20 | 1 | 81500062 | HOUSING, PS, MAG, SC, LP, LS | | |
| 19 | 1 | 81500060 | ADAPTOR, PS, MAG, SC, LP | | |
| 18 | 1 | 81500052 | ROD, ACTUATOR, SC, LP, TF, 7500/33KN, LS | | |
| 17 | 1 | 81500039 | BUSHING, PLUNGER, PR, SC, LP | | |
| 16 | 2 | 43068006 | PLUG, 1/4 BSPP MALE | | |
| 15 | 1 | 39054017 | BU RING, (-033) | X | 39054023 |
| 14 | 1 | 39054016 | BU RING, (.15 x .125 x .063) | X | X |
| 13 | 1 | 39052043 | SEAL, LL, (1/4 X 1/8 X 1/8 X 1/2) | X | 39V52043 |
| 12 | 1 | 39052030 | SEAL, CROWN, 1-3/4x2-1/8x1/4 | X | 39V52030 |
| 11 | 2 | 39050042 | O-RING, (-011) | X | 39051025 |
| 10 | 3 | 23650004 | BALL, TUNGSTEN-CARBIDE .250 | | |
| 9 | 3 | 23350066 | SPRING, COMPRESSION | | |
| 8 | 10 | 21500304 | SHCS, M6 X 1.0-6G X 20MM | | |
| 7 | 2 | 21500200 | WASHER | | |
| 6 | 1 | 21500044 | SCREW, CAP, BTNH, M3-0.5 X 6, SSSL | | |
| 5 | 3 | 21500043 | SHCS, M3-0.5 X 6 ALY | | |
| 4 | 3 | 21500031 | SHCS, M5 X 0.8 X 14, 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 | | |
| No. | QTY | PART No. | DESCRIPTION | Std. Seal Kit | FKM Seal Kit |

| | |
|-----------------------------------|--|
| PARTS LIST | |
| | VEKTEK, INC. 1334 E. SIXTH AVE. P.O. BOX 625 EMPORIA, KS. 66801 U.S.A. |
| ASSEMBLIES AFFECTED 41463323PS | PARTS LIST, ASSY, SC, LP, TC, TF, 33KN, DA, RH, LS, PS |
| SIZE A | MPL7225 |
| | REV B |

| | | | | |
|---------|------------------------|---|------------|----------|
| B | 3886 | RELEASE | JDW | 07/19/19 |
| REV | IN ACCORDANCE WITH ECN | EFFECTIVE DATE | REVISED BY | DATE |
| DRW BY: | JDW | DRAWING STATUS: Released PRODUCTION APPROVED FOR RELEASED STATUS ONLY | | |
| DATE: | 10/16/13 | | | |

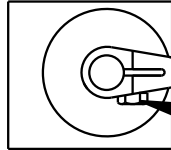
1 **2**

**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 |

**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 |
|-----------|--------|----------|

FORM FEG041-1S-ASIZE, REV. B

| | | | | |
|----------------|--|----------------|------------|----------|
| 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 | | | |