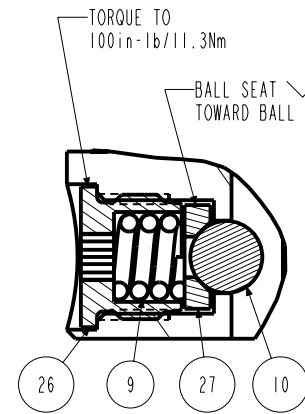


APPLY LUBRICANT TO ALL SEALS  
PRIOR TO INSTALLATION.  
DO NOT USE SILICONE TYPE LUBRICANTS.  
FOR PROPER ARM MOUNTING SEE 1S1505.



DETAIL A  
SCALE 1:500

| N/A | N/A | 1S1505   | INSTRUCTION SHEET, ARM INSTALLATION           |               |              |
|-----|-----|----------|---|---------------|--------------|
| N/A | N/A | 6V711048 | SEAL KIT, FKM                                 |               |              |
| N/A | N/A | 60711048 | SEAL KIT, STANDARD                            |               |              |
| 31  | 1   | 39V10029 | WIPER, PRESS-IN, (1/4)                        | X             | X            |
| 30  | 1   | 91100001 | MAGNET, .130 x .312, PS                       |               |              |
| 29  | 1   | 81591833 | CAM, SC, LP, 5000/22KN, LH, TC, PR            |               |              |
| 28  | 1   | 81541817 | BASE, SC, BF, LP, 22KN, PR                    |               |              |
| 27  | 3   | 81532108 | SEAT, BALL, SC, LP, TC                        |               |              |
| 26  | 3   | 81532107 | RETAINER, SC, LP, TC                          |               |              |
| 25  | 1   | 81511821 | PLUNGER, SC, LP, 5000/22KN, DA, TC, PR        |               |              |
| 24  | 1   | 81500061 | HOUSING, PS, MAG, SC, LP                      |               |              |
| 23  | 1   | 81500060 | ADAPTOR, PS, MAG, SC, LP                      |               |              |
| 22  | 1   | 81500043 | ROD, ACTUATOR, SC, LP, BF, 5000/22KN          |               |              |
| 21  | 1   | 81500039 | BUSHING, PLUNGER, PR, SC, LP                  |               |              |
| 20  | 2   | 43068006 | PLUG, 1/4 BSPP MALE                           |               |              |
| 19  | 1   | 39054008 | BU RING, (-218)                               | X             | X            |
| 18  | 1   | 39054007 | BU RING, (-030)                               | X             | 39054021     |
| 17  | 1   | 39053005 | WIPER, SNAP-IN, (1-1/4)                       | X             | X            |
| 16  | 1   | 39052043 | SEAL, LL, (1/4 X 1/8 X 1/8 X 1/2)             | X             | 39V52043     |
| 15  | 1   | 39051042 | O-RING, (-030)                                | X             | 39V01021     |
| 14  | 2   | 39051041 | O-RING, (-006)                                | X             | 39V51041     |
| 13  | 2   | 39050042 | O-RING, (-011)                                | X             | 39051025     |
| 12  | 1   | 39011060 | SEAL, BEVEL WHEEL INSERT, 1-1/4 x 1/8 x 1-1/2 | X             | 39052015     |
| 11  | 1   | 39011056 | SEAL, CROWN, 1-9/16 x 1-3/4 x 5/32            | 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  | 21500023 | SHCS, M5 X .8-6G X 30MM                       |               |              |
| 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  
41422222PS

**PARTS LIST, ASSY, SC, LP, IC, BF, 22KN, DA, LH, PS**

SIZE  
A **MPL7228**

REV  
A

|         |                        |  |            |          |
|---------|------------------------|--|------------|----------|
| A       | 2679                   | RELEASE                                      | JDW        | 06/23/14 |
| REV     | IN ACCORDANCE WITH ECN | EFFECTIVE DATE                               | REVISED BY | DATE     |
| DRW BY: | JDW                    | <b>DRAWING STATUS: Released</b>              |            |          |
| DATE:   | 10/16/13               | PRODUCTION APPROVED FOR RELEASED STATUS ONLY |            |          |

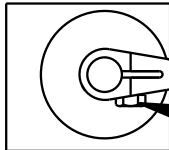
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**READ ALL INSTRUCTIONS BEFORE INSTALLING ARMS  
FAILURE TO FOLLOW INSTALLATION INSTRUCTIONS  
WILL VOID PRODUCT WARRANTY !**

**-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<br>ft-lb | TORQUE<br>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<br>LONG<br>DOUBLE | UPREACH     | SHORT<br>LONG<br>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<br>A | IS1505 | REV<br>C |
|-----------|--------|----------|

FORM FEG041-1S.AS1ZE, 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 |            |          |