

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

TORQUE TO  
100 in-lb/11,3 Nm

BALL SEAT  
TOWARD BALL

TORQUE TO  
23 ft-lb/31 Nm

DETAIL A  
SCALE 1.500

No.	QTY	PART No.	DESCRIPTION	Std. Seal Kit	FKM Seal Kit	Spring Kit
N/A	N/A	IS1505	INSTRUCTION SHEET, ARM INSTALLATION			
N/A	N/A	61704033	SPRING KIT			
N/A	N/A	6V711035	SEAL KIT, FKM			
N/A	N/A	60711035	SEAL KIT, STANDARD			
26	1	39V11051	WIPER, PRESS-IN, 1-1/2", 85 FKM	X	X	
25	1	39H52001	SEAL, BEV, 1-3/4x3/16x2-1/8, 85 HNBR	X	39V52001	
24	1	39H52000	SEAL, BEV, 1-1/2x1/8x1-3/4, 85 HNBR	X	39V52000	
23	1	39H51002	O-RING, (-033), 1.989x.070, 90 HNBR	X	39V51002	
22	1	81592123	CAM, SC, LP, 7500/33KN, STR, TC			
21	1	81592100	DISK, Ø1.00 X .19			X
20	1	81532111	PLUG, SC, LP, 7500/33KN, SA, TC			
19	3	81532108	SEAT, BALL, SC, LP, TC			
18	3	81532107	RETAINER, SC, LP, TC			
17	1	81532105	CAP, END, SC, LP, 33KN/7500			
16	1	81512110	PLUNGER, SC, LP, 7500/33KN, SA, TC			
15	1	49001905	BREATHER, 1/4 BSPP			
14	1	43068006	PLUG, 1/4 BSPP MALE			
13	1	39054018	BU RING, (-327), HYTREL, CUT	X	X	
12	1	39054017	BU RING, (-033), 90 NBR	X	39054023	
11	1	39054016	BU RING, 1.5x.125x.063, HYTREL	X	X	
10	2	39050042	O-RING, (-011), .301x.070, 90 AUD	X	39051025	
9	1	39001056	O-RING, (-119), .924x.103, 70 NBR	X	X	X
8	3	23650004	BALL, TUNGSTEN-CARBIDE .250			
7	1	23600011	BALL, STEEL, ALLOY, .187			X
6	1	23350068	SPRING, COMP, 1.01x.192x6.22x3.68, 199			X
5	3	23350066	SPRING, COMP, .296x.06x.31x.21, 903			
4	10	21500304	SHCS, M6 X 1.0-6G X 20MM			
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			

### PARTS LIST



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

ASSEMBLIES AFFECTED  
41463315

PARTS LIST, ASSY, SC, LP, TC, TF, 33KN, SA, STR

SIZE A  
MPLV7153  
REV C

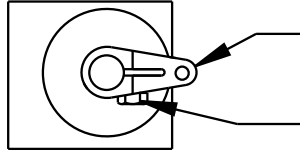
C	2601	RELEASE	GAR	12/17/13
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY:	JDW	<b>DRAWING STATUS: Released</b>		
DATE:	6-7-11	PRODUCTION APPROVED FOR RELEASED STATUS ONLY		

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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 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

<h2>Instruction Sheet</h2>	 VEKTEK, INC. 1334 E. SIXTH AVE. P.O. BOX 625 EMPORIA, KS. 66801 U.S.A.	
	<b>Arm Installation Instruction Sheet</b>	
	<b>Low Profile Swing Clamps</b>	
SIZE A	1S1505	REV 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		