

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

TORQUE TO 11 in-lb/1.2 Nm

BODY, NOT REPLACEABLE

SEE DETAIL A

APPLY MEDIUM STRENGTH THREAD LOCKER. TORQUE TO 100 in-lb/11.3 Nm

FACE CONCAVE TO O-RING


TORQUE TO 100 in-lb/11.3 Nm

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	6V711032	SEAL KIT, FKM		NOTED
N/A	N/A	60711032	SEAL KIT, STANDARD	NOTED	
19	1	81591829	CAM, SC, LP, 5000/22KN, STR, LS, TC		
18	3	81532108	SEAT, BALL, SC, LP, TC		
17	3	81532107	RETAINER, SC, LP, TC		
16	1	81531809	CAP, END, SC, LP, 22KN/5000		
15	1	81511812	PLUNGER, SC, LP, 22KN, DA, LS, TC		
14	2	43068006	PLUG, 1/4 BSPP MALE		
13	1	39054008	BU RING, (-218)	X	X
12	1	39054007	BU RING, (-030)	X	39054021
11	1	39053005	WIPER, SNAP-IN, (1-1/4)	X	X
10	1	39051042	O-RING, (-030)	X	39V01021
9	2	39050042	O-RING, (-011)	X	39051025
8	1	39011060	SEAL, BEVEL WHEEL INSERT, 1-1/4 x 1/8 x 1-1/2	X	39052015
7	1	39011056	SEAL, CROWN, 1-9/16 x 1-3/4 x 5/32	X	39V11056
6	3	23650004	BALL, TUNGSTEN-CARBIDE .250		
5	3	23350066	SPRING, COMPRESSION		
4	2	21500200	WASHER		
3	3	21500031	SHCS, M5 x 0.8 x 14, ALY		
2	10	21500022	SHCS, M5 x .8-66 x 20, ALY		
1	2	21500019	SCREW, CAP, BTNH, M3 X 6, ALY		

PARTS LIST

ASSEMBLIES AFFECTED
41462226
41462226F



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

REV	3884	RELEASE	JDW	07/16/19
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY:	JDW	DRAWING STATUS: Released		
DATE:	07/16/19	PRODUCTION APPROVED FOR RELEASED STATUS ONLY		

SIZE A

FORM FEG035_PL_ASIZE, REV. B

REV A

MPLV7189

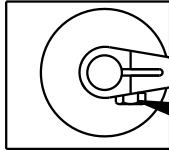
SHEET 1 OF 1

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



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Arm Installation Instruction Sheet

Low Profile Swing Clamps

SIZE A IS1505 REV C

FORM FEG041-IS.AS1ZE, 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			