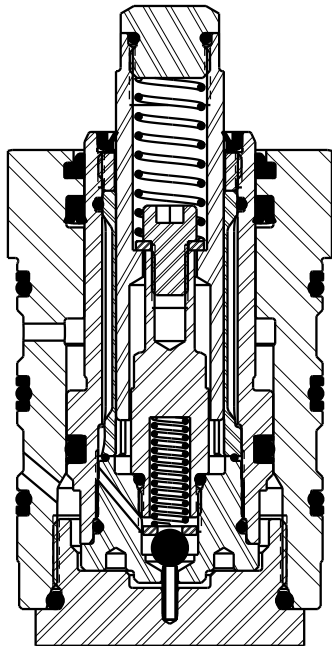


No.	QTY	PART No.	DESCRIPTION	STANDARD SEAL KIT	FKM SEAL KIT	SPRING KIT	INCLUDED IN SUB-ASM 91-0000-28
N/A	N/A	IS1019	INSTRUCTION SHEET				
N/A	N/A	61100523	KIT, SPRING				
N/A	N/A	6V100203	KIT, SEAL, FKM				
N/A	N/A	60100203	KIT, SEAL, STANDARD				
22	1	39V10022	WIPER,PRESS-IN, (3/4)	X	X		X
21	1	39H52032	SEAL,T, (1 3/16 X 1/8 X 1 7/16)	X	39V52040		X
20	1	39H52031	SEAL, BEVEL, 1 3/16 X 1/8 X 1 7/16	X	39V52039		
19	4	39F54010	BU RING,(-135)	X	X		
18	1	39F54009	BU RING,(-217)	X	X		
17	1	91000028	ASSY, SHUTTLE, WS, DA, CGS, 2750				
16	1	81071001	CAP, BODY, WS, DA, CGS, 2750				
15	1	81042003	STUD, WS, DA, CGS, 2750				X
14	1	81040608	BOLT, CONTACT, WS, DA, CGS, 2750				X
13	1	81000810	BODY, WS, DA, CGS, CM, 2750				
12	1	39053031	WIPER,SNAP-IN, 1 3/16	X	X		
11	3	39051061	O-RING, (-135)	X	39V01035		
10	1	39051058	O-RING, (-920)	X	39V51058		
9	1	39000072	O-RING, (-013)	X	39V50047		X
8	1	39000024	O-RING, (-904)	X	39V00024	X	X
7	2	23600002	BALL, STEEL, ALLOY, .250				X
6	1	23530000	PIN, SPRING, COIL TYPE, 3/32 X 3/8, SST				
5	1	23355006	SPRING, COMPRESSION			X	X
4	1	23311016	SPRING, COMPRESSION			X	X
3	1	21430034	WASHER				X
2	1	21430020	WASHER				X
1	1	21411030	SCREW,CAP,SOCH,1/4-28 X 3/8,ALY,SLFLKG				X



SEE IS1019 FOR SERVICE INSTRUCTIONS
 LUBRICATE ALL SEALS WITH CLEAN HYDRAULIC OIL PRIOR TO ASSEMBLY
 DO NOT USE SILICONE BASED LUBRICANTS



PARTS LIST



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

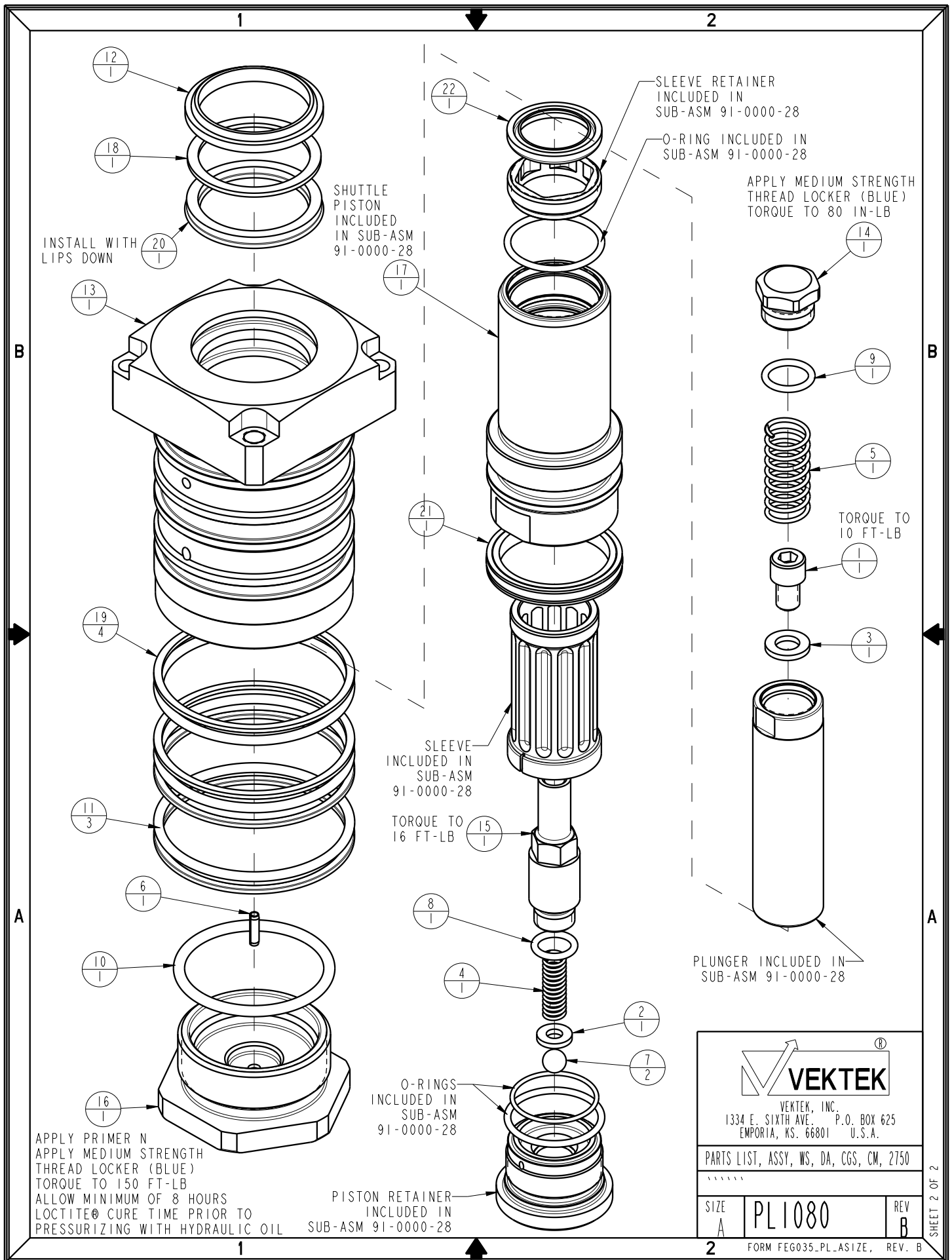
ASSEMBLIES AFFECTED
 10-0208-02
 10-0208-02F

PARTS LIST, ASSY, WS, DA, CGS, CM, 2750

SIZE A **PL1080**

REV B

B	3060	RELEASE	DLG	7-18-16
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY: ALUTHI	DRAWING STATUS: Released			
DATE: 8-12-10	PRODUCTION APPROVED FOR RELEASED STATUS ONLY			



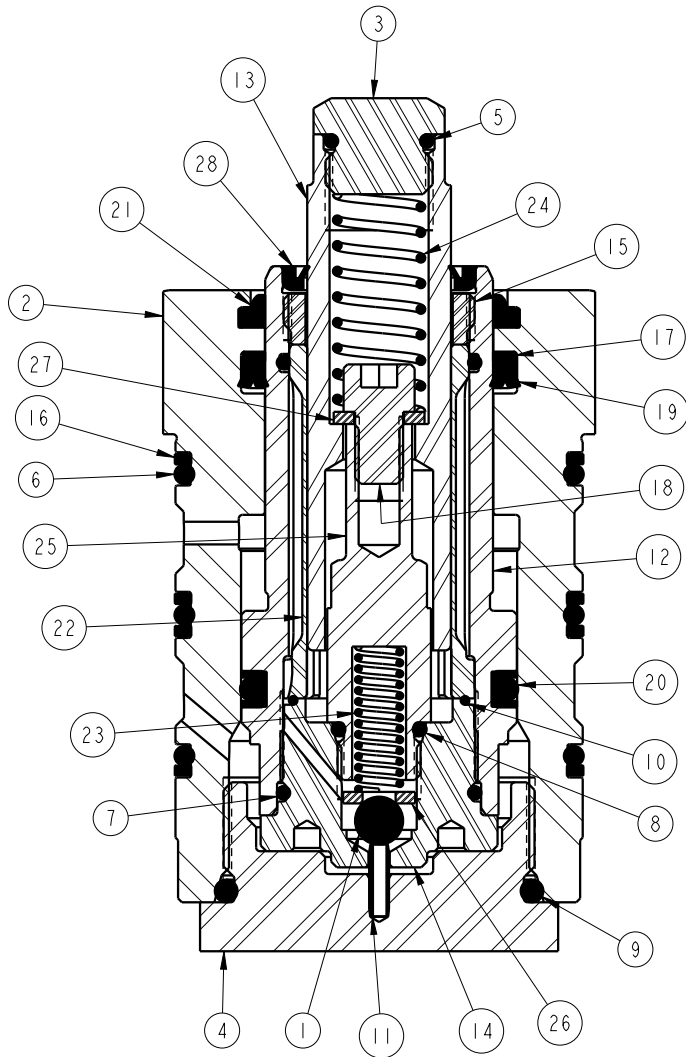
VEKTEK
 VEKTEK, INC.
 1334 E. SIXTH AVE. P.O. BOX 625
 EMPORIA, KS. 66801 U.S.A.

PARTS LIST, ASSY, WS, DA, CGS, CM, 2750

SIZE A	PL1080	REV B
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FORM FEG035_PL_ASIZE, REV. B

SHEET 2 OF 2



28	WIPER,PRESS-IN, (3/4)
27	WASHER
26	WASHER
25	STUD, WS, DA, CGS, 2750
24	SPRING, COMPRESSION
23	SPRING, COMPRESSION
22	SLEEVE, WS, DA, CGS, 2750
21	WIPER,SNAP-IN, 1 3/16
20	SEAL,T, (1 3/16 X 1/8 X 1 7/16)
19	SEAL, BEVEL, 1 3/16 X 1/8 X 1 7/16
18	SCREW,CAP,SOCH,1/4-28 X 3/8,ALY,SLFLKG
17	BU RING,(-217)
16	BU RING,(-135)
15	RETAINER, SLEEVE, WS, DA, CGS, 2750
14	RETAINER, PISTON, WS, DA, CGS, 2750
13	PLUNGER, WS, DA, CGS, 2750
12	PISTON, SHUTTLE, WS, DA, CGS, 2750
11	PIN, SPRING, COIL TYPE, 3/32 X 3/8, SST
10	O-RING, (-5-708)
9	O-RING, (-920)
8	O-RING, (-904)
7	O-RING, (-021)
6	O-RING, (-135)
5	O-RING, (-013)
4	CAP, BODY, WS, DA, CGS, 2750
3	BOLT, CONTACT, WS, DA, CGS, 2750
2	BODY, WS, DA, CGS, CM, 2750
1	BALL, STEEL, ALLOY, .250
No.	DESCRIPTION

MODEL NUMBER	TOOL LIST
10-0208-02 10-0208-02F	1-7/8 SOCKET (6 pt.) 5/8 & 11/16 wrenches 3/16 hex key 7/16 deep well socket

INSTALLATION INSTRUCTIONS	 VEKTEK <small>VEKTEK, INC. 1334 E. SIXTH AVE. P.O. BOX 625 EMPORIA, KS. 66801 U.S.A.</small>
	INSTRUCTION SHEET, WS, DA, CGS, CM, 2750 ***** SIZE A 1S1019 REV B

B	3060	RELEASE	DLG	7/18/16
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY:	ALUTHI	DRAWING STATUS: Released PRODUCTION APPROVED FOR RELEASED STATUS ONLY		
DATE:	8-12-10			

ASSEMBLIES AFFECTED
10-0208-02
10-0208-02F

SIZE A	1S1019	REV B
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READ ALL INSTRUCTIONS BEFORE DISASSEMBLY


REFER TO THE ILLUSTRATION ON PAGE ONE FOR COMPONENT NUMBERS AND TOOL LIST

DISASSEMBLY

1. Clamp work support body (2) in vise and using 1 7/8" six point socket remove bottom cap (4). Cap is installed with Loctite® and tightened to 150 ft-lbs so will require high torque to remove cap. Remove o-ring (9) from cap (4) and clean Loctite® off threads using a wire brush. CAUTION: USE 6 POINT SOCKET ONLY, OTHER TYPES OF WRENCHES MAY DAMAGE THE WORK SUPPORT.
2. Slide shuttle piston (12) sub-assembly out of body (2). Remove wiper (21), back-up ring (17), bevel seal (19), o-rings (6) and back-up rings (16) from body (2). Remove T-seal (20) from shuttle piston (12).
3. Using 5/8" and 11/16" wrenches remove contact bolt (3) from plunger (13), remove spring (24) and o-ring (5).
4. Clamp shuttle piston (12) in vise clamping on the flats near the bottom. Remove SHCS (18) and washer (27), plunger can now be removed.
5. Using 7/16" deep well socket remove stud (25) from piston retainer (14) and remove o-ring (8) from stud. Remove spring (23), washer (26), and ball (1).
6. Using small flat blade screw driver, remove wiper (28) from shuttle piston (12). CAUTION: DO NOT DAMAGE INSIDE OF SLEEVE (22) OR SLEEVE RETAINER (15).
7. DO NOT REMOVE SLEEVE RETAINER (15) OR PISTON RETAINER (14) FROM SHUTTLE PISTON (12). DOING SO WILL VOID PRODUCT WARRANTY!
8. Clean all parts thoroughly and set aside to dry.

ASSEMBLY

1. Lubricate o-rings (5), (8) & (9), T-seal (20), bevel seal (19) and back-up ring (17) with clean hydraulic oil (Vektek 65-0010-01 or equivalent). Apply Loctite® primer N or equivalent to the threads of the cap (4), threads of body (2) and contact bolt (3), then allow to dry.
2. Install ball (1), washer (26), spring (23) into piston retainer (14) through top of shuttle piston (12). Install o-ring (8) on SAE 4 boss of stud (25). Torque stud into piston retainer, 16 ft-lb.
3. Press wiper (28) into top of shuttle piston (12) using only enough force to seat wiper into counterbore. CAUTION: EXCESS FORCE MAY CAUSE DAMAGE TO WIPER.
4. Slide plunger (13) into sleeve (22). Install washer (27) and SHCS (18), torque to 10 ft-lb. Install spring (24) into plunger (13). Install o-ring (5) onto contact bolt (3) and apply medium strength Loctite® (blue) to threads. Thread contact bolt (3) into plunger (13) and torque to 80 in-lb. Plunger should freely move up and down in sleeve without binding or dragging. Spring force should return plunger to full stroke without sticking.
5. Install T-seal (22) onto shuttle piston (12) with round bulb facing out. Install back-up rings on each side of T-seal bulb. Make sure back-up rings are seated.
6. Install bevel seal (19) into body (2) with lips facing piston bore, push to bottom of groove, then install back-up ring (17). Make sure seals are not rolled. Install snap-in wiper (21) into body (2).
7. Slide shuttle piston (12) subassembly into body (2) bore and ensure that piston seal back-up rings do not catch in threads. Shuttle piston should slide smoothly up and down in bore.
8. Install o-ring (9) onto cap (4) and apply medium strength Loctite® (blue) to threads. Immediately thread cap (4) into body (2) and torque to 150 ft-lb. Allow 8 hours of Loctite® cure time before pressurizing device with hydraulic oil.
9. Install o-rings (6) and back-up rings (16) onto body. Make sure back-up rings are not rolled.

		
<small>VEKTEK, INC. 1334 E. SIXTH AVE. P.O. BOX 625 EMPORIA, KS. 66801 U.S.A.</small>		
<small>INSTRUCTION SHEET, WS, DA, CGS, CM, 2750</small>		
<small>*****</small>		
<small>SIZE A</small>	<small>1S1019</small>	<small>REV B</small>
<small>FORM FEG035_PL_ASIZE, REV. B</small>		

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