

Lubricate all seals with clean hydraulic oil prior to assembly.
DO NOT USE SILICONE BASED LUBRICANTS

BODY - NOT REPLACEABLE

Assemble with lip side facing bottom of body

Assemble with lip side facing top of piston

Thread into piston until the flat point of set screw is even with the inside of the piston


Align slot with hole in body, insert pin and tighten screw to 20 in lb torque

Insert in bottom counterbore of base and tighten set screw to 11 in lb torque

Tighten to 16 ft lb torque, using a crisscross tightening sequence

13	1	81591901	LOCATOR, VISE, COLLET
12	1	81591900	PIN, GUIDE, VISE, COLLET
11	1	81541901	BASE, VISE, COLLET, SINGLE
10	1	81511900	PISTON, VISE, COLLET
9	1	39011077	SEAL, WIPER, SNAP-IN, (1-1/2), 90, AU
8	1	39011076	SEAL, LOADED LIP
7	1	39011075	SEAL, LOADED LIP
6	1	39000053	O-RING
5	1	30601144	PLUG, SOCH, SAE 4
4	1	23315002	SPRING
3	2	21440006	SHSS, FLAT POINT, SELF-LOCKING
2	4	21411010	SCREW, CAP, SOCH, 5/16-18 XI 14, ALY
1	1	21410006	BUTTON HEAD CAP SCREW
No.	Qty	Part No.	Description

Standard Seal Kit 60-1221-19	Fluorocarbon Seal Kit 6V-1221-19	Spring Kit 61-1551-19
39-0110-76	39-V110-76	39-0000-53
39-0110-77	39-V110-77	23-3150-02
39-0000-53	39-V000-53	
39-0110-75	39-V110-75	

PARTS LIST	 VEKTEK VEKTEK, INC. 1334 E. SIXTH AVE. P.O. BOX 625 EMPORIA, KS. 66801 U.S.A.
	Model Number 15-5119-01 PARTS LIST, ASSY, VISE, COLLET, SINGLE
SIZE A	PL-1518
REV K	SHEET 1 OF 1

K	1636	RELEASE	MES	02-19-07
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY: JACOB	DRAWING STATUS: Released PRODUCTION APPROVED FOR RELEASED STATUS ONLY			
DATE: 05-15-90				