

**THIS IS A TWO PAGE PARTS LIST.  
THIS FIRST PAGE APPLIES TO  
ASSEMBLY REVISION D AND LATER.**

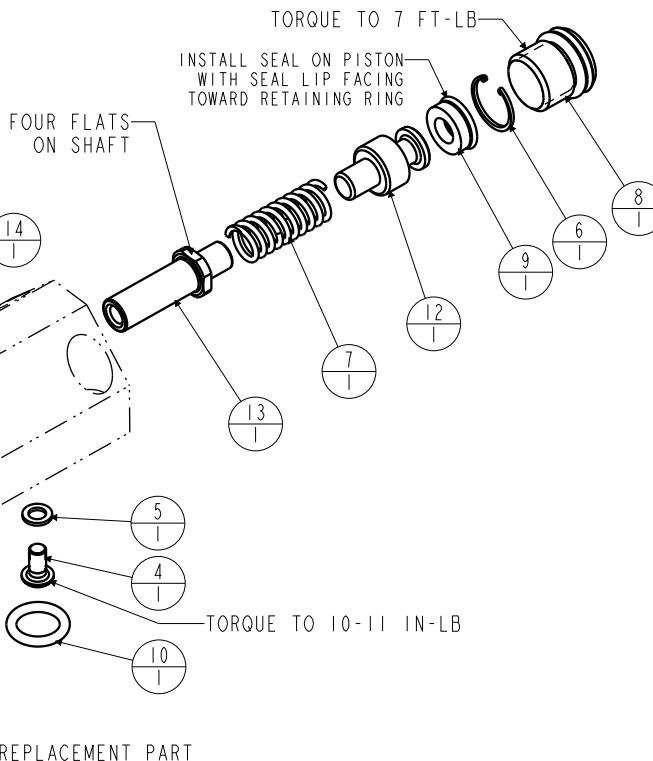
THIS 10-32 CAP SCREW PROVIDED TO PREVENT THE FRONT SHAFT FROM ROTATING WHILE CHANGING THE CONTACT PLATE. REMOVE THE 10-32 FLATHEAD SCREW FROM THE BODY AND TIGHTEN THIS CAP SCREW AGAINST ONE OF THE FOUR FLATS ON THE CROWDER SHAFT. TO AVOID SHAFT DAMAGE TIGHTEN CAP SCREW TO 25 IN-LBS MAXIMUM.

APPLY LOW STRENGTH THREAD LOCKER (PURPLE) TO THREAD. TORQUE TO 25 IN-LB

WHEN ORDERING REPLACEMENTS SEE CONTACT PLATE DIMENSIONS AND INFORMATION BELOW



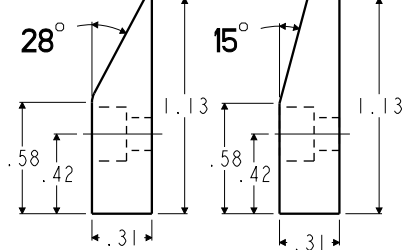
APPLY MEDIUM STRENGTH THREAD LOCKER (BLUE) TO THREAD. TORQUE TO 25 IN-LB



**CONTACT PLATE DIMENSIONS AND INFORMATION**

81-5000-65, CONTACT PLATE PROVIDED WITH ASSEMBLIES REVISION "B" AND EARLIER


81-5000-25, CONTACT PLATE PROVIDED WITH ASSEMBLIES REVISION "C" AND LATER



**NOTES:**

1. ALL SEALS AND THE RETAINING RING ARE INCLUDED IN STD OR FKM SEAL KIT.
2. APPLY LUBRICANT TO ALL SEALS PRIOR TO ASSEMBLY.

NO	QTY	PART NO	DESCRIPTION	STD SEAL KIT	FKM SEAL KIT
1	1	21410005	SCREW, CAP, SOCH, 8-32 X 1/4, ALY		
2	1	21410099	SCREW, CAP, FLTH, 10-32 X 3/16, ALY, UNDERCUT HEAD		
3	1	21411035	SCREW, CAP, SOCH, 10-32 X 5/8, ALY		
4	1	21500019	SCREW, CAP, BTNH, M3 X 6, ALY		
5	1	21500200	WASHER		
6	1	23002015	RETAINING RING, BASIC INTERNAL	X	X
7	1	23350054	SPRING, COMPRESSION		
8	1	30601144	PLUG, SOCH, SAE 4		
9	1	39010011	SEAL, BEVEL, 3/16 X 3/32 X 3/8	X	39V10011
10	1	39050042	O-RING, (-011)	X	X
11	1	81500025	PLATE, CONTACT, CROWDER, 550, 28°		
12	1	81500028	PISTON, PART CROWDER, 550		
13	1	81500031	SHAFT, PART CROWDER, 550		
14	1	39V51004	O-RING, 5.5mm X 1mm	X	X
N/A	N/A	60159100	KIT, SEAL, STANDARD	NOTED	N/A
N/A	N/A	6V159100	KIT, SEAL, FKM	N/A	NOTED

<b>PARTS LIST</b>	 <b>VEKTEK</b> VEKTEK, INC. 1334 E. SIXTH AVE. P.O. BOX 625 EMPORIA, KS. 66801 U.S.A.	
	ASSEMBLIES AFFECTED	PARTS LIST, PART CROWDER, 550
15910400		
15910400F		
REVISION D AND LATER	SIZE A	REV G
	PL1592	

G	5200	RELEASE	RLK	4/4/24
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY: JAW	<b>DRAWING STATUS: Released</b> PRODUCTION APPROVED FOR RELEASED STATUS ONLY			
DATE: 8/4/06				

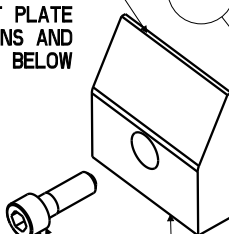
**THIS IS A TWO PAGE PARTS LIST.  
THIS SECOND PAGE APPLIES TO  
ASSEMBLY REVISION C AND EARLIER.**

THIS 10-32 CAP SCREW PROVIDED TO PREVENT THE FRONT SHAFT FROM ROTATING WHILE CHANGING THE CONTACT PLATE. REMOVE THE 10-32 FLATHEAD SCREW FROM THE BODY AND TIGHTEN THIS CAP SCREW AGAINST ONE OF THE FOUR FLATS ON THE CROWDER SHAFT. TO AVOID SHAFT DAMAGE TIGHTEN CAP SCREW TO 25 IN-LBS MAXIMUM.

APPLY LOW STRENGTH THREAD LOCKER (PURPLE) TO THREAD. TORQUE TO 25 IN-LB

WHEN ORDERING REPLACEMENTS SEE CONTACT PLATE DIMENSIONS AND INFORMATION BELOW

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APPLY MEDIUM STRENGTH THREAD LOCKER (BLUE) TO THREAD. TORQUE TO 25 IN-LB

WIPER NOT INCLUDED IN SEAL KITS

BODY NON-REPLACEMENT PART

TORQUE TO 7 FT-LB

INSTALL SEAL ON PISTON WITH SEAL LIP FACING TOWARD RETAINING RING

FOUR FLATS ON SHAFT

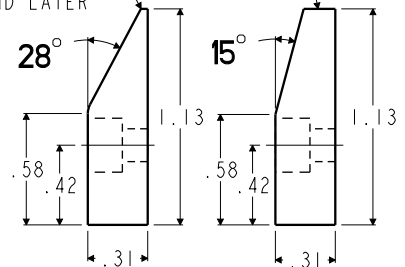
DUE TO SHAFT DESIGN CHANGES WHEN ORDERING THIS SHAFT AS A REPLACEMENT PART FOR ASSEMBLIES REVISION C AND EARLIER REVISIONS BE CERTAIN TO ALSO ORDER CAP SCREW 21410005, SCREW, CAP, SOCH, 8-32 X 1/4, ALY

TORQUE TO 10-11 IN-LB

**CONTACT PLATE DIMENSIONS AND INFORMATION**

81-5000-65, CONTACT PLATE PROVIDED WITH ASSEMBLIES REVISION "B" AND EARLIER

81-5000-25, CONTACT PLATE PROVIDED WITH ASSEMBLIES REVISION "C" AND LATER



**NOTES:**

- ALL SEALS AND THE RETAINING RING ARE INCLUDED IN STD OR FKM SEAL KIT WITH THE EXCEPTION OF THE WIPER NOT BEING INCLUDED IN THE SEAL KITS.
- APPLY LUBRICANT TO ALL SEALS PRIOR TO ASSEMBLY.

NO	QTY	PART NO	DESCRIPTION	STD SEAL KIT	FKM SEAL KIT
1	1	21410055	S.H.C.S. 8-32 UNC X .50 LG.		
2	1	21410099	SCREW,CAP,FLTH,10-32 X 3/16,ALY,UNDERCUT HEAD		
3	1	21411035	SCREW, CAP, SOCH, 10-32 X 5/8, ALY		
4	1	21500019	SCREW, CAP, BTNH, M3 X 6, ALY		
5	1	21500200	WASHER		
6	1	23002015	RETAINING RING, BASIC INTERNAL	X	X
7	1	23350054	SPRING, COMPRESSION		
8	1	30601144	PLUG, SOCH, SAE 4		
9	1	39010011	SEAL, BEVEL, 3/16 X 3/32 X 3/8	X	39V10011
10	1	39050042	O-RING, (-011)	X	X
11	1	81500025	PLATE,CONTACT,CROWDER,550,28°		
12	1	81500028	PISTON, PART CROWDER, 550		
13	1	81500031	SHAFT, PART CROWDER, 550		
14	1	39V10029	WIPER,PRESS-IN, (1/4)		
15	1	39V51004	O-RING, 5.5mm X 1mm	X	X
N/A	N/A	60159100	KIT, SEAL, STANDARD	NOTED	N/A
N/A	N/A	6V159100	KIT, SEAL, FKM	N/A	NOTED

**PARTS LIST**



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

ASSEMBLIES AFFECTED  
15910400  
15910400F  
REVISION C AND EARLIER

PARTS LIST, ASSY, PART CROWDER, 550

SIZE  
A  
**PL1592**

REV  
G

G	5200	RELEASE	RLK	4/4/24
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE

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DATE: 8/4/06  
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