

**THIS IS A TWO PAGE PARTS LIST.
THIS FIRST PAGE APPLIES TO
ASSEMBLY REVISION E 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

1/4 LONG SCREW, USED ON REVISION E AND LATER

APPLY MEDIUM STRENGTH THREAD LOCKER (BLUE) TO THREADS. TORQUE TO 7 FT-LB

TORQUE TO 16 FT-LB
INSTALL SEAL ON PISTON WITH SEAL LIP FACING TOWARD RETAINING RING

FOUR FLATS ON SHAFT

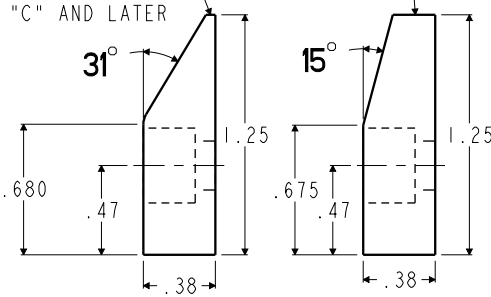
TORQUE TO 10-11 IN-LB

BODY NON-REPLACEMENT PART

CONTACT PLATE DIMENSIONS AND INFORMATION

81-5000-66, CONTACT PLATE PROVIDED WITH ASSEMBLIES REVISION "B" AND EARLIER

81-5000-26, 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	21410096	SCREW, CAP, SOCH, 1/4-20 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	23050026	RING, RTNG, INTL	X	X
7	1	23350053	SPRING, COMPRESSION		
8	1	30601166	PLUG, SOCH, SAE 6		
9	1	39010012	SEAL, BEVEL, 5/16 X 3/32 X 1/2	X	39V10012
10	1	39050042	O-RING, (-011)	X	
11	1	81500026	PLATE, CONTACT, CROWDER, 980, 31°		
12	1	81500029	PISTON, PART CROWDER, 980		
13	1	81500032	SHAFT, PART CROWDER, 980		
14	1	39V51004	O-RING, 5.5mm X 1mm	X	X
N/A	N/A	60159101	KIT, SEAL, STANDARD	NOTED	N/A
N/A	N/A	6V159101	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 15910500 15910500F REVISION E AND LATER	PARTS LIST, PART CROWDER, 980
DRAWN BY: JAW DATE: 8/4/06	SIZE A PL1593
DRAWING STATUS: Released PRODUCTION APPROVED FOR RELEASED STATUS ONLY	REV E

E	3828	RELEASE	JDW	05/21/19
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE

**THIS IS A TWO PAGE PARTS LIST.
THIS SECOND PAGE APPLIES TO
ASSEMBLY REVISION D 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

1/2 LONG SCREW, USED ON REVISION D AND EARLIER

APPLY MEDIUM STRENGTH THREAD LOCKER (BLUE) TO THREADS. TORQUE TO 7 FT-LB

WIPER NOT INCLUDED IN SEAL KITS

BODY NON-REPLACEMENT PART

TORQUE TO 16 FT-LB
INSTALL SEAL ON PISTON WITH SEAL LIP FACING TOWARD RETAINING RING

FOUR FLATS ON SHAFT

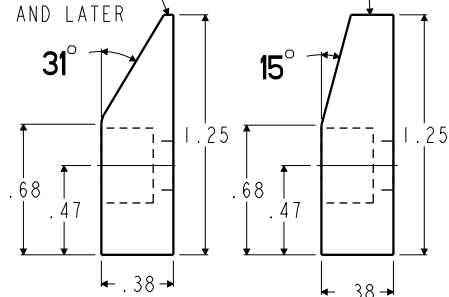
DUE TO SHAFT DESIGN CHANGES WHEN ORDERING THIS SHAFT AS A REPLACEMENT PART FOR ASSEMBLIES REVISION D AND EARLIER REVISIONS BE CERTAIN TO ALSO ORDER CAP SCREW 21410096, SCREW, CAP, SOCH, 1/4-20 X 1/4, ALY

TORQUE TO 10-11 IN-LB

CONTACT PLATE DIMENSIONS AND INFORMATION

81-5000-66, CONTACT PLATE PROVIDED WITH ASSEMBLIES REVISION "B" AND EARLIER

81-5000-26, CONTACT PLATE PROVIDED WITH ASSEMBLIES REVISION "C" AND LATER



NO	QTY	PART NO	DESCRIPTION	STD SEAL KIT	FKM SEAL KIT
1	1	21410063	S.H.C.S. 1/4-20 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	23050026	RING, RTNG, INTL	X	X
7	1	23350053	SPRING, COMPRESSION		
8	1	30601166	PLUG, SOCH, SAE 6		
9	1	39010012	SEAL, BEVEL, 5/16 X 3/32 X 1/2	X	39V10012
10	1	39050042	O-RING, (-011)	X	X
11	1	39053023	WIPER, PRESS-IN, (3/8)		
12	1	81500026	PLATE, CONTACT, CROWDER, 980, 31°		
13	1	81500029	PISTON, PART CROWDER, 980		
14	1	81500032	SHAFT, PART CROWDER, 980		
15	1	39V51004	O-RING, 5.5mm X 1mm	X	X
N/A	N/A	60159101	KIT, SEAL, STANDARD	NOTED	N/A
N/A	N/A	6V159101	KIT, SEAL, FKM	N/A	NOTED

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.

PARTS LIST	
	VEKTEK, INC. 1334 E. SIXTH AVE. P.O. BOX 625 EMPORIA, KS. 66801 U.S.A.
ASSEMBLIES AFFECTED	PARTS LIST, PART CROWDER, 980
15910500	
15910500F	
REVISION D AND EARLIER	
SIZE A	PL1593
	REV E

E	3828	RELEASE	JDW	05/21/19
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY:	JAW	DRAWING STATUS: Released		
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