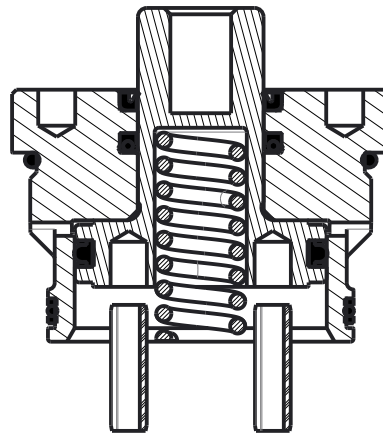
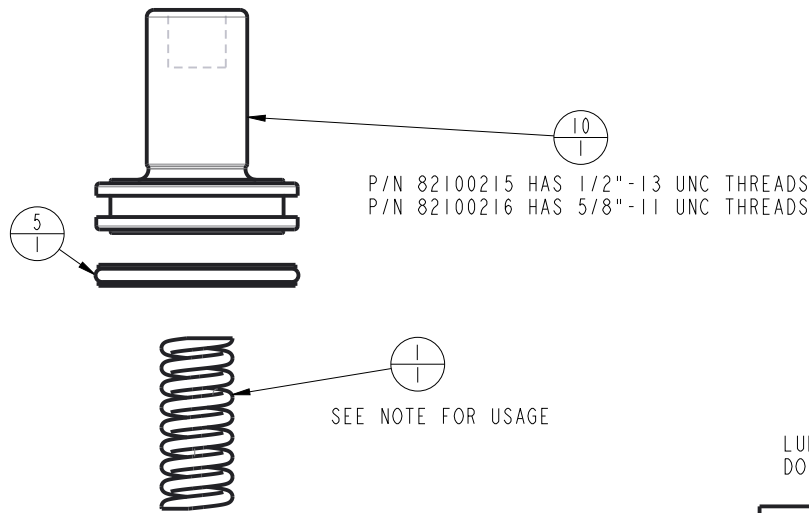
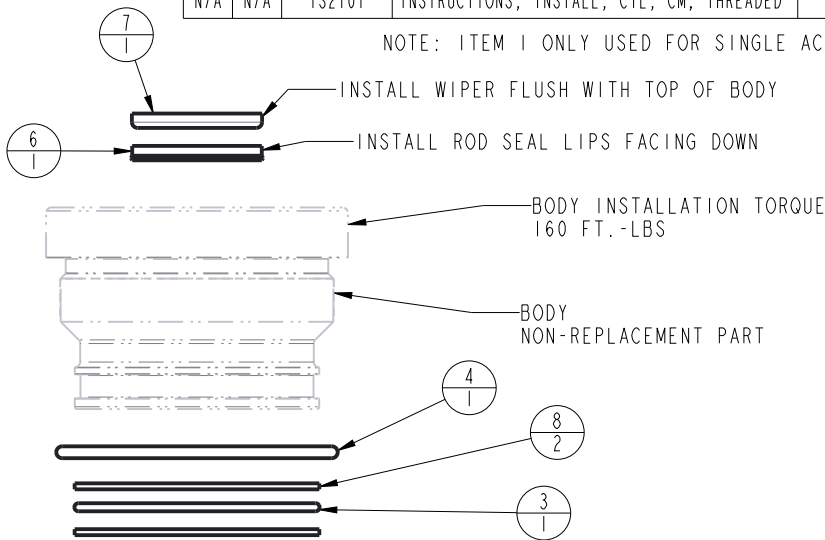



NO	QTY	PART NO	DESCRIPTION	21-0216-00	21-0216-01	STD SEAL KIT
1	1	23355015	SPRING, COMPRESSION	X	X	
2	2	23520005	PIN, SPRING, 1/4 X 7/8, SST	X	X	
3	1	39051128	O-RING, (-033)	X	X	X
4	1	39051130	O-RING, (-140)	X	X	X
5	1	39052052	SEAL, T, (1 1/2 X 1/8 X 1 3/4)	X	X	X
6	1	39052054	SEAL, LL, (7/8 X 1/8 X 1/8 X 1 1/8)	X	X	X
7	1	39053054	WIPER,PRESS-IN, (7/8)	X	X	X
8	2	39054023	BU RING,(-033)	X	X	X
9	1	67010154	TAG, INSTALL, CYL, CM, THREAD-IN	X	X	X
10	1	82100215	PLUNGER,CYL,CM,PP,12000LB	X		
-	1	82100216	PLUNGER,CYL,CM,PP,12000LB		X	
N/A	N/A	60210207	KIT, SEAL, CYL, CM, PP, 12000LB	N/A	N/A	NOTED
N/A	N/A	IS2101	INSTRUCTIONS, INSTALL, CYL, CM, THREADED	N/A	N/A	N/A

NOTE: ITEM 1 ONLY USED FOR SINGLE ACTING OPERATION



LUBRICATE ALL SEAL WITH CLEAN HYDRAULIC OIL.  
DO NOT USE SILICONE BASED LUBRICANTS

<b>PARTS LIST</b>	 VEKTEK, INC. 1334 E. SIXTH AVE. P.O. BOX 625 EMPORIA, KS. 66801 U.S.A.	
	ASSEMBLIES AFFECTED 21021600 21021601	<b>PARTS LIST, CYL, CM, PP, 12000LB</b> THREAD IN SIZE A <b>PL2186</b>

A	2802	RELEASE	DKC	2/24/15
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY:	DKC	<b>DRAWING STATUS: Released</b>		
DATE:	9/25/14	PRODUCTION APPROVED FOR RELEASED STATUS ONLY		

SHEET 1 OF 1



# INSTALLATION INSTRUCTIONS CONTINUED

## Anti-Rotation Pins- Optional

-Anti-Rotation Pins are included with all cylinders

-Anti-Rotation Pins are only to resist normal rotational force from cylinder actuation. The pins are not intended to resist torque from other applications.

-The use of anti-rotation pins are not required.

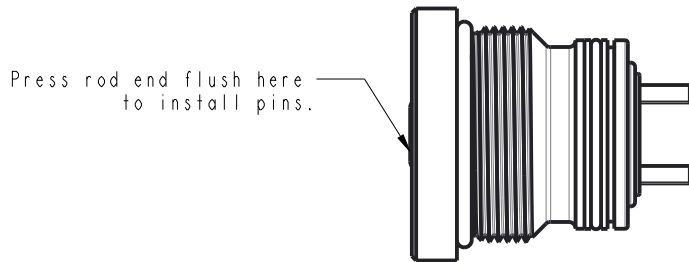
-Anti-Rotation Pins (included with each device) have sufficient length to fully engage in plunger as well as engage in the fixture greater than the total plunger stroke.

- Replacement anti-rotation pin part numbers are below for each size of cylinder.

MODEL NO.	PIN NO.
21-0206-XX	81-5905-09
21-0209-XX	23-5200-03
21-0210-XX	23-5200-04
21-0213-XX	23-5200-04
21-0216-XX	23-5200-05
21-0221-00	23-5200-05

## Installation of Anti-Rotation Pins- Optional

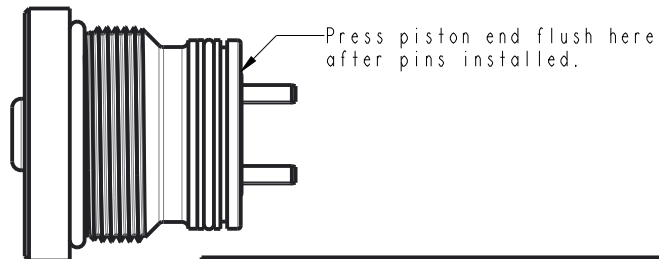
1. Press rod end of plunger flush with the end of the cylinder body. See view below. Care must be taken not to push the rod out of the rod seal. Piston seal may be exposed in certain cylinder models.



2. Press in the pins provided. Ensure pins start straight and are fully seated in the plunger. (An increase in resistance will be felt when pin is fully seated.)

NOTE: If piston seal was exposed during anti-rotation pin installation. Lubricate seal with non-silicone grease or clean hydraulic oil prior to reinstallation.

3. With both pins installed, carefully press piston end of the plunger flush with end of body. See view below.



4. Cylinder is ready for installation into fixture.

**INSTALLATION INSTRUCTIONS**



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

A	2753	RELEASE	DKC	10/1/14
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY:	DKC	<b>DRAWING STATUS: Released</b>		
DATE:	3/10/14	PRODUCTION APPROVED FOR RELEASED STATUS ONLY		

ASSEMBLIES AFFECTED  
21-0206-XX 21-0209-XX  
21-0210-XX 21-0213-XX  
21-0216-XX 21-0221-00

<b>INSTRUCTIONS, INSTALL, CYL, CM, THREADED</b>	
THREAD IN	
SIZE A	<b>IS2101</b>
REV A	

FORM FEG041-IS.AS1ZE, REV. B

SHEET 2 OF 3

