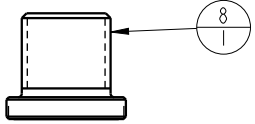
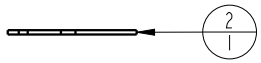
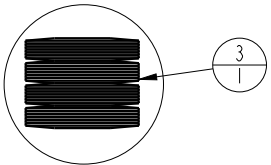


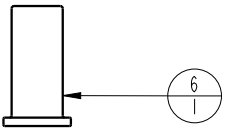
TIGHTEN TO
5 FT-LB / 7 Nm
TORQUE.



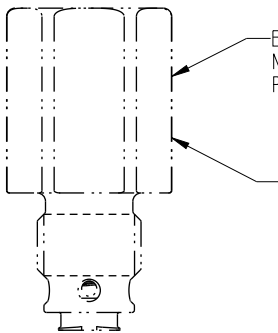
APPLY ANTI-SEIZE
TO THREADS



USE CAUTION WHEN INSTALLING
SPRING PACK, DO NOT LOSE
FACTORY ORIENTATION. DO
NOT RE-STACK SPRINGS
DIFFERENTLY FROM
FACTORY ORIENTATION.



ELLIPTICAL
LIPS

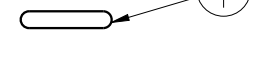


BODY
NON-REPLACEMENT
PART

TIGHTEN TO
15 FT-LB / 20 Nm
TORQUE.

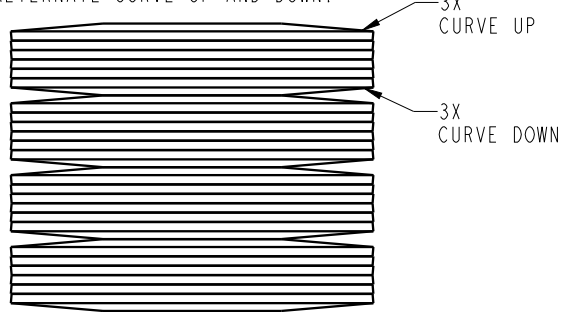


INSTALL
NOSE O-RING
BEFORE SPACER



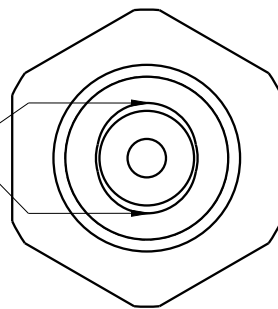
NOTES:
1. APPLY LUBRICANT TO ALL SEALS
PRIOR TO INSTALLATION.
2. DO NOT USE SILICONE TYPE LUBRICANTS.

SPRING PACK MUST BE STACKED AS
SHOWN BELOW. 24 SPRINGS TOTAL.
ALTERNATE CURVE UP AND DOWN.

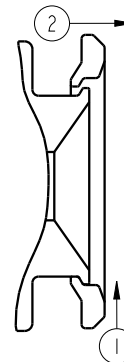


SPACER/NOSE O-RING REPLACEMENT

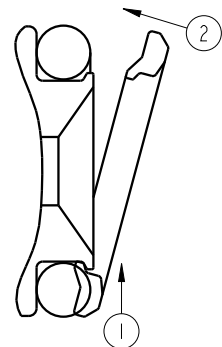
STEP 2



STEP 3: REMOVAL



STEP 5: INSTALLATION



1. REMOVE NOSE O-RING.
2. LOCATE ELLIPTICAL SHAPED LIPS ON NOSE. USE A LOUPE OR MAGNIFYING GLASS IF NECESSARY, SEE STEP 2 DIAGRAM ABOVE.
3. REMOVE SPACER BY FIRST SHIFTING THE SPACER IN THE DIRECTION OF ARROW 1 IN THE STEP 3 DIAGRAM, THEN ROTATE IT OFF THE OPPOSITE LIP IN THE DIRECTION OF ARROW 2 IN THE STEP 3 DIAGRAM.
4. REPLACE THE O-RING.
5. HOOK THE SPACER ID OVER ONE LIP PUSHING IN THE DIRECTION OF ARROW 1 IN THE STEP 5 DIAGRAM, THEN TIP THE SPACER OVER THE OPPOSITE LIP ONTO THE BODY IN THE DIRECTION OF ARROW 2 IN THE STEP 5 DIAGRAM, COMPRESSING THE O-RING.

NO	QTY	PART NO	DESCRIPTION	STD SEAL KIT	SPRING KIT
1	1	21420030	NUT, HEX JAM, 3/8-24		
2	1	23050059	SNAP RING, INTERNAL		X
3	1	23360101	SPRING PACK, DISK, .012 X .470, 8SX3P		X
4	1	39000070	O-RING, (-904)	X	
5	1	39051004	O-RING, (-010)	X	
6	1	87044313	GUIDE, SPRING, IP-SEQ, SAE4/G1/8		
7	1	87044316	SPACER, IP-SEQ, SAE4	X	
8	1	87044320	ADJUSTER, SPRING, IP-SEQ, 1500 PSI		
N/A	N/A	60701611	KIT, SEAL, ASSY, IP-SEQ, SAE 4	NOTED	N/A
N/A	N/A	61704303	KIT, SPRING, IP-SEQ, SAE 1500PSI/G1/8 100BAR	N/A	NOTED

PARTS LIST



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

ASSEMBLIES AFFECTED
70-4437-11

PARTS LIST, ASSY, IP-SEQ, SAE 4, .580, 1500PSI

SIZE
A PL7031

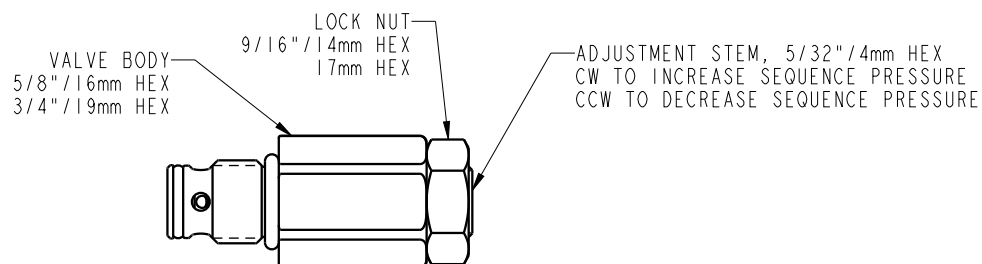
REV
A

SHEET 1 OF 1

FORM FEG035_PL_ASIZE, REV. B

1

2



NOTE:
THIS SEQUENCE VALVE CAN
 BE USED ONLY ON CLAMPS
 OF A COMPATIBLE DEVICE
 THAT ARE MANIFOLD MOUNTED.

PORT
DEVICE READY

FOR USE IN YOUR OWN CAVITY
 SEE CAVITY DETAILS FROM CATALOG OR WEB PAGE.

TO INSTALL THE SEQUENCE VALVE INTO A PORT.
 SCREW VALVE BODY INTO PORT AND TIGHTEN
 ACCORDING TO TORQUE SPECIFIED ON THE CHART BELOW.

TO ADJUST THE SEQUENCE VALVE:
 LOOSEN LOCK NUT.
 ROTATE ADJUSTMENT STEM CLOCKWISE TO INCREASE SEQUENCE PRESSURE.
 ROTATE ADJUSTMENT STEM COUNTER CLOCKWISE TO DECREASE SEQUENCE PRESSURE.
 INTERNAL RETAINING RING WILL PREVENT EXCESSIVE TRAVEL COUNTER CLOCKWISE.
 TIGHTEN LOCK NUT ACCORDING TO TORQUE SPECIFIED ON THE CHART BELOW.

IN-PORT SEQUENCE VALVE MODEL LIST.

70-4437-10, ASSY, IP-SEQ, SAE 4, .580, 750 PSI
 70-4437-11, ASSY, IP-SEQ, SAE 4, .580, 1500 PSI
 70-4437-12, ASSY, IP-SEQ, SAE 4, .580, 3000 PSI
 70-4437-20, ASSY, IP-SEQ, SAE 4, .750, 750 PSI
 70-4437-21, ASSY, IP-SEQ, SAE 4, .750, 1500 PSI
 70-4437-22, ASSY, IP-SEQ, SAE 4, .750, 3000 PSI
 47-0443-30, ASSY, IP-SEQ, G1/8, 15.16, 50 BAR
 47-0443-31, ASSY, IP-SEQ, G1/8, 15.16, 100 BAR
 47-0443-32, ASSY, IP-SEQ, G1/8, 15.16, 200 BAR
 47-0443-50, ASSY, IP-SEQ, G1/4, 18.72, 50 BAR
 47-0443-51, ASSY, IP-SEQ, G1/4, 18.72, 100 BAR
 47-0443-52, ASSY, IP-SEQ, G1/4, 18.72, 200 BAR
 L4-7044-30, ASSY, IP-SEQ, G1/8, 15.16, 50 BAR
 L4-7044-31, ASSY, IP-SEQ, G1/8, 15.16, 100 BAR
 L4-7044-50, ASSY, IP-SEQ, G1/4, 18.72, 50 BAR
 L4-7044-51, ASSY, IP-SEQ, G1/4, 18.72, 100 BAR

PORT SIZE	BODY INSTALLATION TORQUE	LOCK NUT TORQUE
SAE 4	15 ft-lb	5 ft-lb
G1/8	16 Nm	7 Nm
G1/4	27 Nm	7 Nm

INSTALLATION INSTRUCTIONS



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

ASSEMBLIES AFFECTED
 SEE MODEL LIST

INSTALLATION, IN-PORT SEQ VALVE

SIZE
 A 1S7006

REV
 A

A	3613	RELEASE	JDW	10/17/18
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY:	JDW	DRAWING STATUS: Released		
DATE:	10/17/18	PRODUCTION APPROVED FOR RELEASED STATUS ONLY		

1

2

FORM FEG041-IS.ASIZ, REV. B

SHEET 1 OF 1