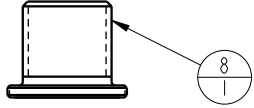
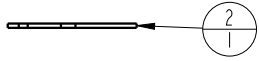
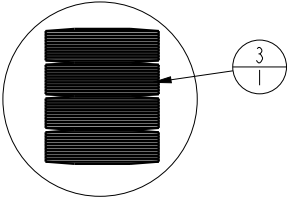


TIGHTEN TO
5 FT-LB / 7 Nm
TORQUE.

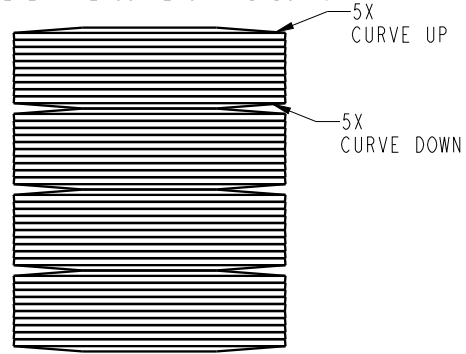


APPLY ANTI-SEIZE
TO THREADS



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

SPRING PACK MUST BE STACKED AS
SHOWN BELOW. 40 SPRINGS TOTAL.
ALTERNATE CURVE UP AND DOWN.

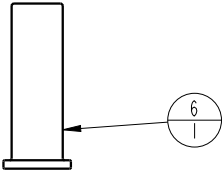


SPACER/NOSE O-RING REPLACEMENT

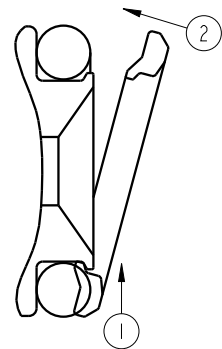
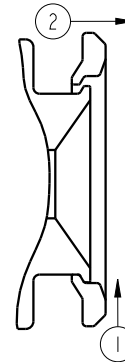
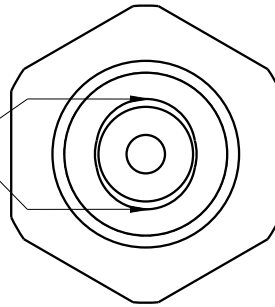
STEP 2

STEP 3: REMOVAL

STEP 5: INSTALLATION

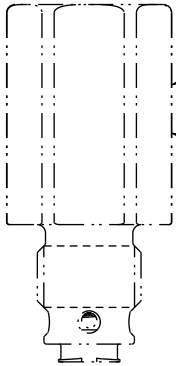


ELLIPTICAL
LIPS

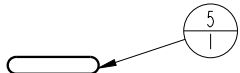


BODY
NON-REPLACEMENT
PART

TIGHTEN TO
15 FT-LB / 20 Nm
TORQUE.



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.



INSTALL
NOSE O-RING
BEFORE SPACER



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

| 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 | 23360102 | SPRING PACK, DISK, .012 X .470, 8SX5P | | X |
| 4 | 1 | 39000070 | O-RING, (-904) | X | |
| 5 | 1 | 39051004 | O-RING, (-010) | X | |
| 6 | 1 | 87044314 | GUIDE, SPRING, IP-SEQ, SAE4/G1/8, HP | | |
| 7 | 1 | 87044316 | SPACER, IP-SEQ, SAE4 | X | |
| 8 | 1 | 87044321 | ADJUSTER, SPRING, IP-SEQ, 3000 PSI | | |
| N/A | N/A | 60701611 | KIT, SEAL, ASSY, IP-SEQ, SAE 4 | NOTED | N/A |
| N/A | N/A | 61704304 | KIT, SPRING, IP-SEQ, SAE 3000PSI/G1/8 200BAR | N/A | NOTED |

PARTS LIST



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

ASSEMBLIES AFFECTED
70-4437-12

PARTS LIST, ASSY, IP-SEQ, SAE 4, .580, 3000PSI

| | | | | |
|---------|------------------------|--|------------|----------|
| A | 3613 | RELEASE | JDW | 10/16/18 |
| REV | IN ACCORDANCE WITH ECN | EFFECTIVE DATE | REVISED BY | DATE |
| DRW BY: | JDW | DRAWING STATUS: Released | | |
| DATE: | 10/16/18 | PRODUCTION APPROVED FOR RELEASED STATUS ONLY | | |

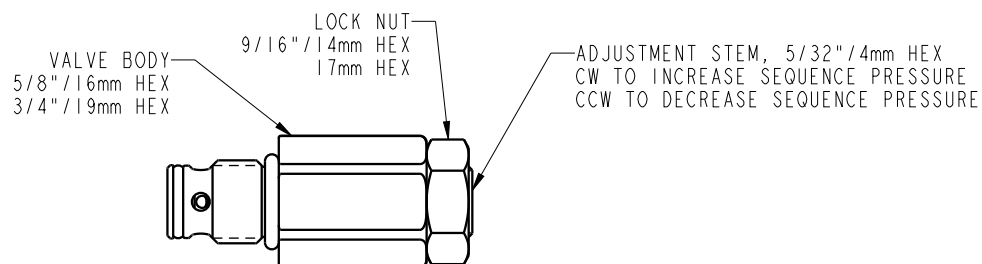
| | | |
|-----------|--------|----------|
| SIZE A | PL7032 | REV A |
|-----------|--------|----------|

FORM FEG035_PL_ASIZE, REV. B

SHEET 1 OF 1

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