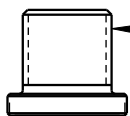
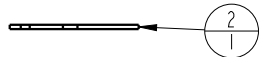
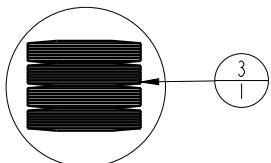


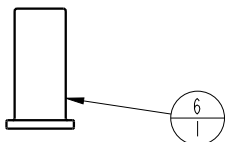
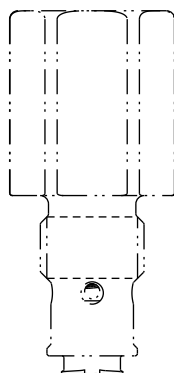
-TIGHTEN TO  
5 FT-LB / 7 Nm  
TORQUE.



APPLY ANTI-SEIZE  
TO THREADS

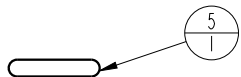
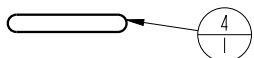


USE CAUTION WHEN INSTALLING  
SPRING PACK, DO NOT LOSE  
FACTORY ORIENTATION. DO  
NOT RE-STACK SPRINGS  
DIFFERENTLY FROM  
FACTORY ORIENTATION.

ELLIPTICAL  
LIPS

-BODY  
NON-REPLACEMENT  
PART

-TIGHTEN TO  
15 FT-LB / 20 Nm  
TORQUE.



INSTALL  
NOSE O-RING  
BEFORE SPACER

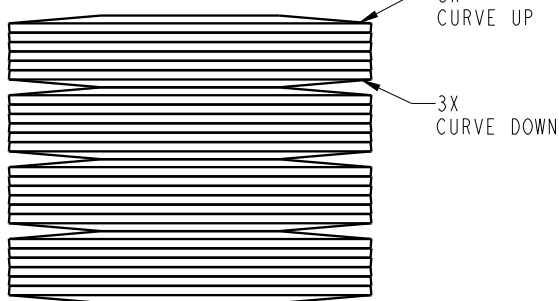


NOTES:

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

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

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

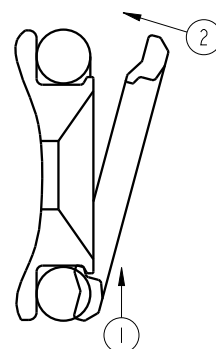
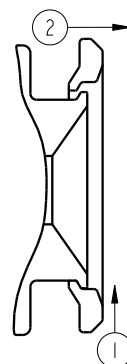
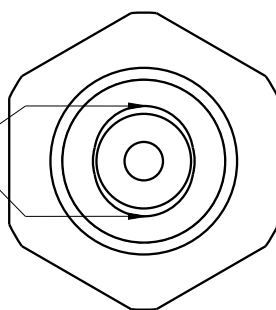


## SPACER/NOSE O-RING REPLACEMENT

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  
70-4437-21

PARTS LIST, ASSY, IP-SEQ, SAE 4, .750, 1500PSI

SIZE A	PL7034
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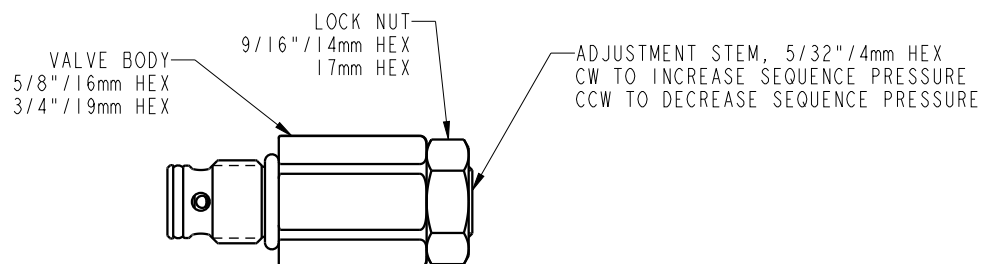
REV  
A

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.

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

#### 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

#### 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 IS7006

REV  
A

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

1

2

FORM FEG041-IS-ASIZE, REV. B

SHEET 1 OF 1