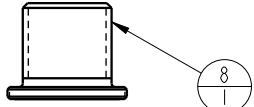
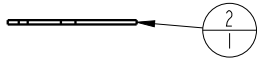
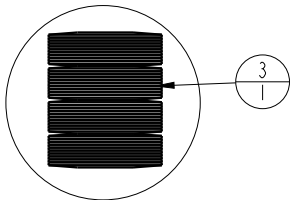


TIGHTEN TO  
5 FT-LB / 7 Nm  
TORQUE.

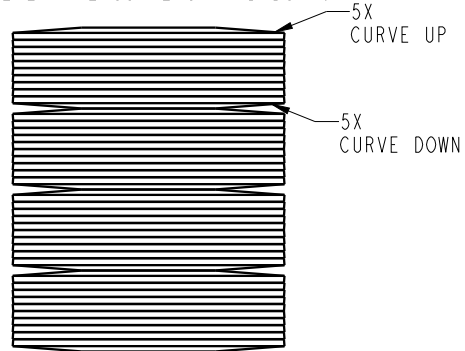


APPLY ANTI-SEIZE  
TO THREADS



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.

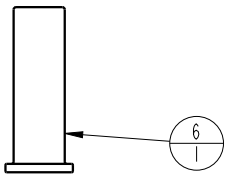


**SPACER/NOSE O-RING REPLACEMENT**

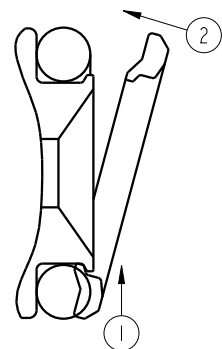
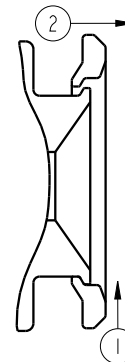
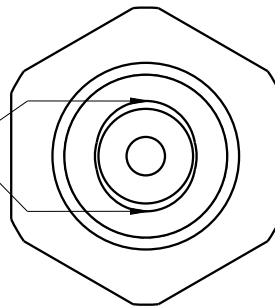
STEP 2

STEP 3: REMOVAL

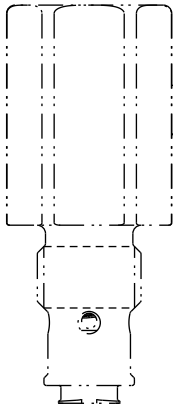
STEP 5: INSTALLATION



ELLIPTICAL  
LIPS

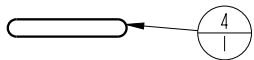


BODY  
NON-REPLACEMENT  
PART



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  
70-4437-22

PARTS LIST, ASSY, IP-SEQ, SAE 4, .750, 3000PSI

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

SIZE  
A PL7035

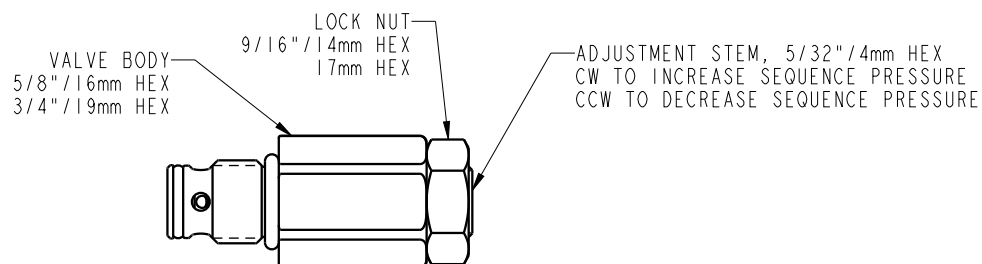
REV  
A

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	<b>DRAWING STATUS: Released</b>		
DATE:	10/17/18	PRODUCTION APPROVED FOR RELEASED STATUS ONLY		

1

2

FORM FEG041-IS.ASIZ, REV. B

SHEET 1 OF 1