



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

PARTS LIST

PL-7093

REV L
ECN 2503

ASSEMBLIES AFFECTED:

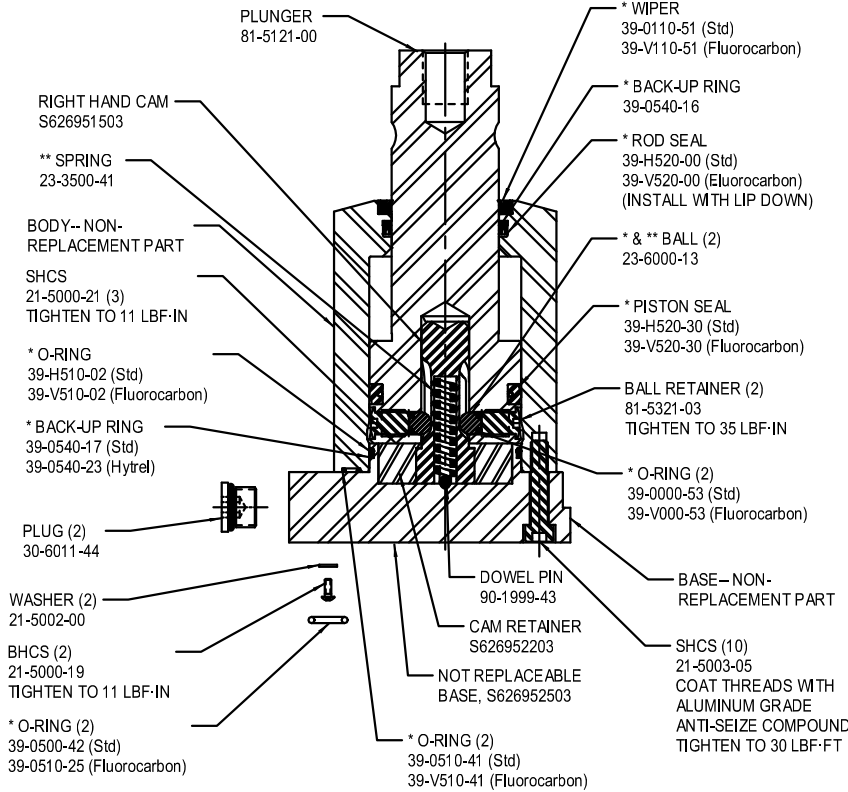
15222100
15222100F

DRAWN/DATE

ROMINE
06/18/01

ASSY, SC, LP, BF, 7500, DA, RH

UNIT WITH PLUNGER CLUTCH
MODELS THAT APPLY
15222100 , Revision C & Earlier
15222100F , Revision C & Earlier



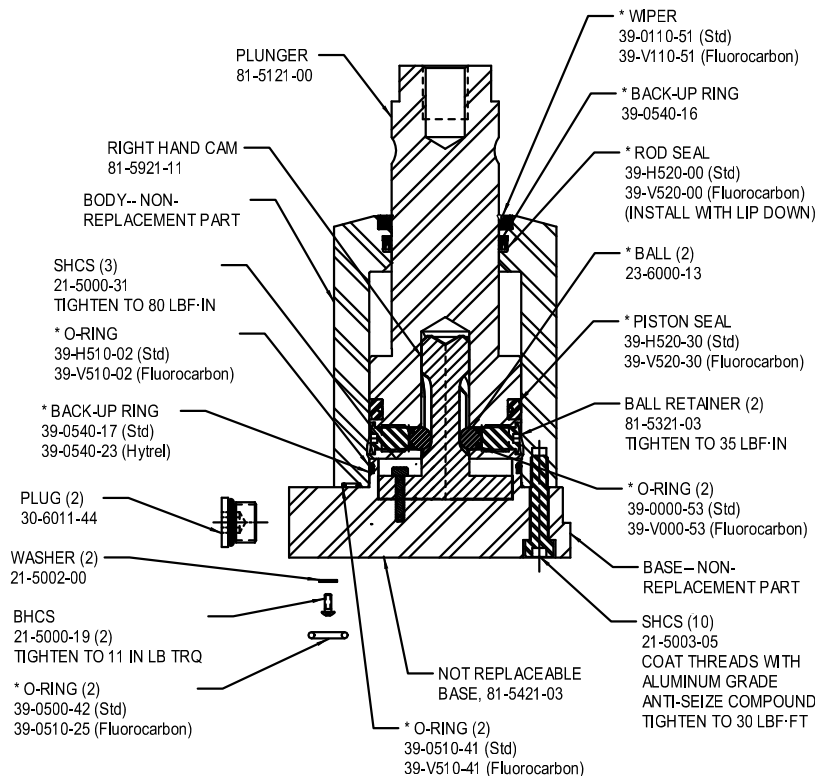
* INCLUDED IN SEAL KIT (Std) No. 60-7110-22
(Fluorocarbon) 6V-7110-13
** INCLUDED IN SPRING KIT No. 61-7040-07

APPLY LUBRICANT TO ALL SEALS PRIOR TO INSTALLATION
DO NOT USE SILICONE TYPE LUBRICANTS.

FOR PROPER ARM MOUNTING SEE IS-1505

ASSY, SC, LP, BF, 7500, DA, RH

UNIT WITHOUT PLUNGER CLUTCH
AS OF 11/09/04
MODELS THAT APPLY
15222100 , Revision D & Later
15222100F , Revision D & Later



* INCLUDED IN SEAL KIT (Std) No. 60-7110-22
(Fluorocarbon) 6V-7110-13

APPLY LUBRICANT TO ALL SEALS PRIOR TO INSTALLATION
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FOR PROPER ARM MOUNTING SEE IS-1505

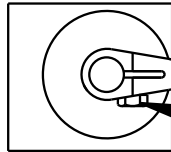
1 **2**

**READ ALL INSTRUCTIONS BEFORE INSTALLING ARMS
FAILURE TO FOLLOW INSTALLATION INSTRUCTIONS
WILL VOID PRODUCT WARRANTY !**

–Installing or Positioning of Low Profile Swing Clamp Arms–

**NOTE: If the arm is already installed on the plunger,
loosen the cap screw.**

**CAUTION: Never attempt to rotate the arm before loosening
the cap screw. This can damage the plunger rotating mechanism.**



- 1. Rotate the arm to the desired radial position.**
- 2. Tighten to the torque specification listed below.**

MODEL	TORQUE ft-lb	TORQUE N-m
5000lb & 22Kn	115 ft-lb	156 N-m
7500lb & 33Kn	225 ft-lb	305 N-m

**IT IS RECOMMEND THE CROSS BOLT
BE REPLACED IF THE ARM NEEDS
REMOVED AFTER IT HAS BEEN IN SERVICE.**

CROSS BOLT	CROSS BOLT	CROSS BOLT	CROSS BOLT
5000 & 22KN	5000 & 22KN	7500 & 33KN	7500 & 33KN
SHORT LONG DOUBLE	UPREACH	SHORT LONG DOUBLE	UPREACH
21-5000-24	21-5000-25	21-5000-28	21-5000-25

**Instruction
Sheet**



VEKTEK, INC.
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EMPORIA, KS. 66801 U.S.A.

Arm Installation Instruction Sheet

Low Profile Swing Clamps

SIZE A	IS1505	REV C
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FORM FEG041-IS-ASIZE, REV. B

C	2799	RELEASE	JDW	01/29/15
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY: MES	DRAWING STATUS: Released			
DATE: 08/01/05	PRODUCTION APPROVED FOR RELEASED STATUS ONLY			

SHEET 1 OF 1