



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

PARTS LIST

PL-7095

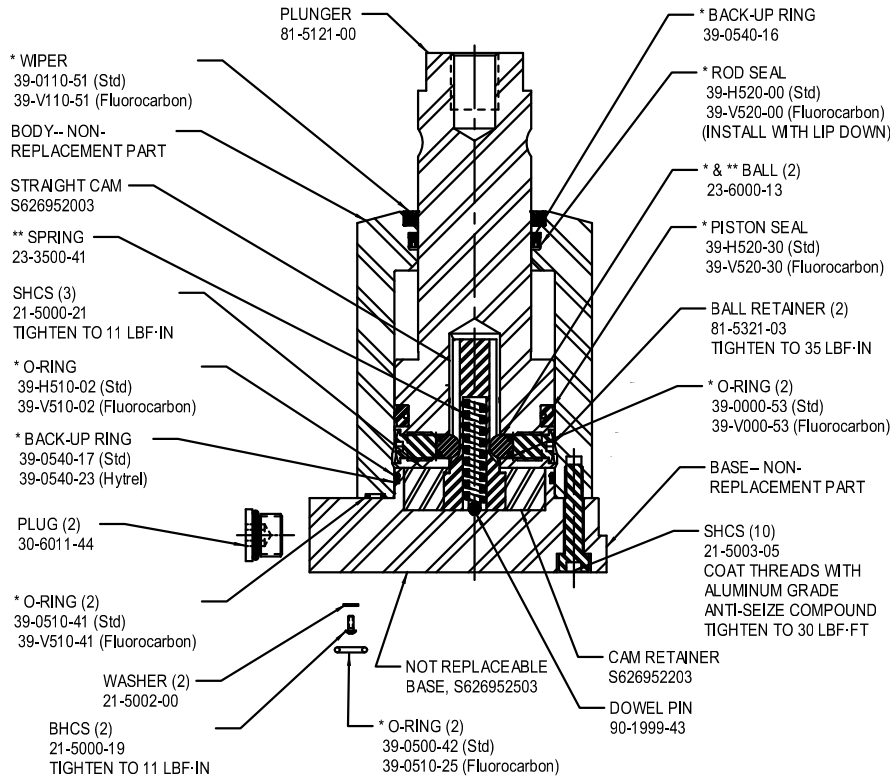
REVL
ECN 2503

ASSEMBLIES AFFECTED: 15222102
15222102F

DRAWN/DATE

ROMINE
06/18/01

ASSY, SC, LP, BF, 7500, DA, STR



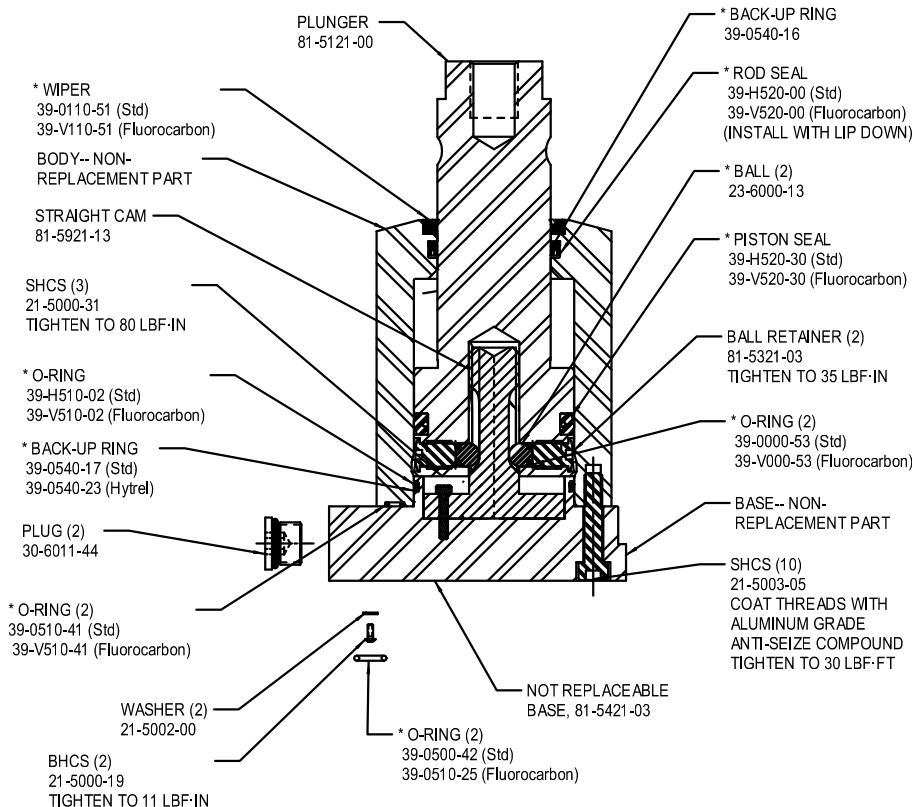
**UNIT WITH PLUNGER CLUTCH
MODELS THAT APPLY**
15222102 , Revision C & Earlier
15222102F , Revision C & Earlier

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

FOR PROPER ARM MOUNTING SEE IS-1505

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

ASSY, SC, LP, BF, 7500, DA, STR



**UNIT WITHOUT PLUNGER CLUTCH
AS OF 11/09/04
MODELS THAT APPLY**
15222102 , Revision D & Later
15222102F , Revision D & Later

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

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

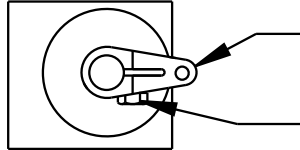
FOR PROPER ARM MOUNTING SEE IS-1505

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
50001b & 22Kn	115 ft-lb	156 N-m
75001b & 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	 <small>VEKTEK, INC. 1334 E. SIXTH AVE. P.O. BOX 625 EMPORIA, KS. 66801 U.S.A.</small>
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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		

Arm Installation Instruction Sheet		
Low Profile Swing Clamps		
SIZE A	IS1505	REV C