


APPLY LUBRICANT TO ALL SEALS PRIOR TO INSTALLATION. DO NOT USE SILICONE TYPE LUBRICANTS. FOR PROPER ARM MOUNTING SEE IS1505.

TORQUE TO 100in-lb/11,3 Nm
BALL SEAT TOWARD BALL

DETAIL A
SCALE 1.500

No.	QTY	PART No.	DESCRIPTION	Std Seal Kit	FKM Seal Kit
N/A	N/A	IS1505	INSTRUCTION SHEET, ARM INSTALLATION		
N/A	N/A	6V711036	SEAL KIT, FKM		
N/A	N/A	60711036	SEAL KIT, STANDARD		
19	1	39V11051	WIPER, PRESS-IN, 1-1/2", 85 FKM	X	X
18	1	39H52000	SEAL, BEV, 1-1/2x1/8x1-3/4, 85 HNBR	X	39V52000
17	1	39H51002	O-RING, (-033), 1.989x.070, 90 HNBR	X	39V51002
16	1	81592128	CAM, SC, LP, 7500, STR, LS, TC		
15	3	81532108	SEAT, BALL, SC, LP, TC		
14	3	81532107	RETAINER, SC, LP, TC		
13	1	81532105	CAP, END, SC, LP, 33kN/7500		
12	1	81512112	PLUNGER, SC, LP, 7500/33KN, DA, LS, TC		
11	1	39054017	BU RING, (-033), 90 NBR	X	39054023
10	1	39054016	BU RING, 1.5x.125x.063, HYTREL	X	X
9	1	39052030	SEAL, CROWN, 1-3/4x2-1/8x1/4, 90AU	X	39V52030
8	2	39050042	O-RING, (-011), .301x.070, 90 AUD	X	39051025
7	2	30601144	PLUG, SOCH, SAE 4		
6	3	23650004	BALL, TUNGSTEN-CARBIDE .250		
5	3	23350066	SPRING, COMP, .296X.06X.31X.21, 903		
4	10	21500304	SHCS, M6 X 1, 0-66 X 20MM		
3	2	21500200	WASHER, .124x.207x.024, COPPER		
2	3	21500031	SHCS, M5 X 0.8 X 14, ALY		
1	2	21500019	SCREW, CAP, BTNH, M3 X 6, ALY		

<h2>PARTS LIST</h2>	 VEKTEK VEKTEK, INC. 1334 E. SIXTH AVE. P.O. BOX 625 EMPORIA, KS. 66801 U.S.A.
	ASSEMBLIES AFFECTED 14062105 14062105F

FORM FEG035_PL_ASIZE, REV. B

B	2596	RELEASE	JDW	12/06/13
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY:	JDW	DRAWING STATUS: Released PRODUCTION APPROVED FOR RELEASED STATUS ONLY		
DATE:	6-7-11			

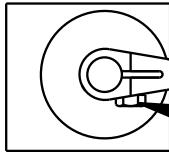
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**READ ALL INSTRUCTIONS BEFORE INSTALLING ARMS
FAILURE TO FOLLOW INSTALLATION INSTRUCTIONS
WILL VOID PRODUCT WARRANTY !**

-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**



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

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

FORM FEG041-1S.AS1ZE, REV. B