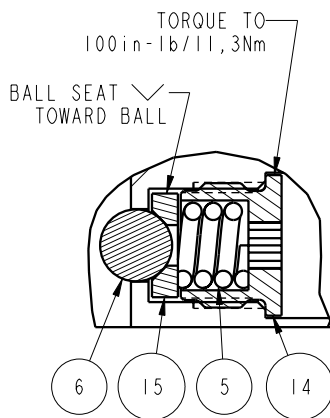
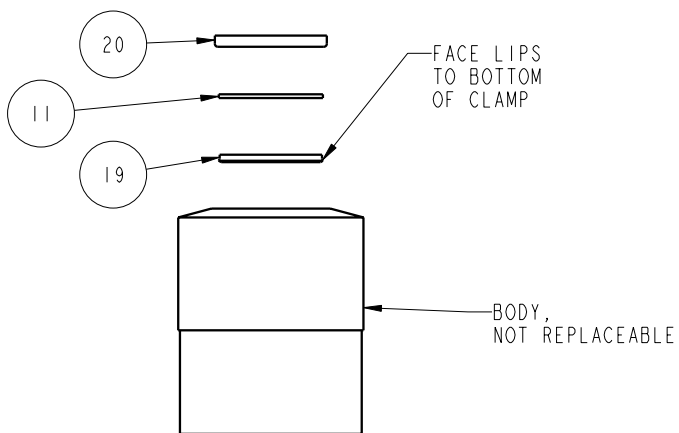
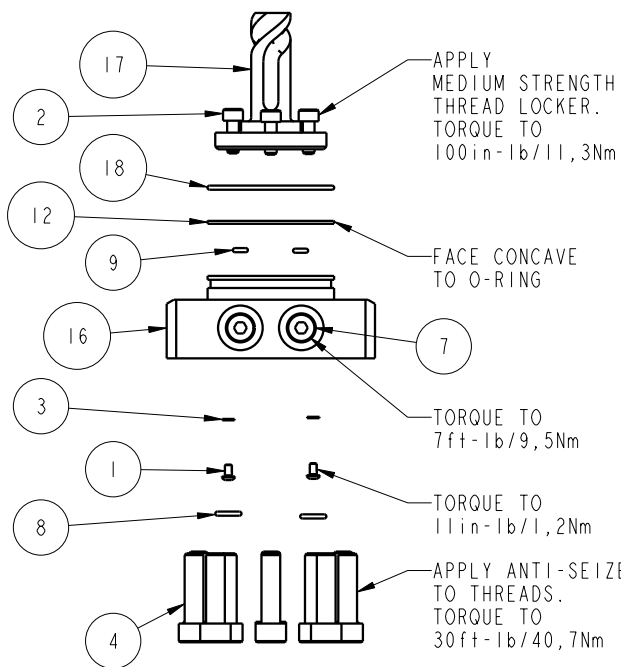
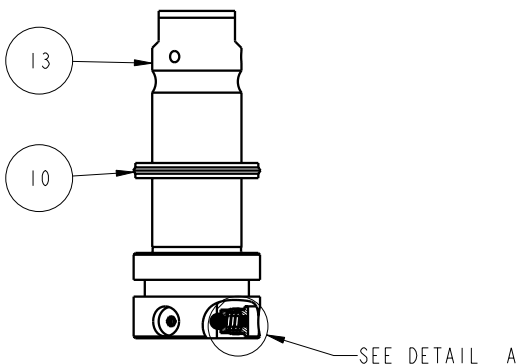


APPLY LUBRICANT TO ALL SEALS  
PRIOR TO INSTALLATION.  
DO NOT USE SILICONE TYPE LUBRICANTS.  
FOR PROPER ARM MOUNTING SEE ISI505.



DETAIL A  
SCALE 1.500



No.	QTY	PART No.	DESCRIPTION	Std. Seal Kit	FKM Seal Kit
N/A	N/A	ISI505	INSTRUCTION SHEET, ARM INSTALLATION		
N/A	N/A	6V711044	SEAL KIT, FKM		
N/A	N/A	60711044	SEAL KIT, STANDARD		
20	1	39V11051	WIPER, PRESS-IN, 1-1/2", 85 FKM	X	X
19	1	39H52000	SEAL, BEV, 1-1/2x1/8x1-3/4, 85 HNBR	X	39V52000
18	1	39H51002	O-RING, (-033), 1.989x.070, 90 HNBR	X	39V51002
17	1	81592121	CAM, SC, LP, 7500/33KN, RH, TC		
16	1	81542103	BASE, SC, BF, LP, 7500		
15	3	81532108	SEAT, BALL, SC, LP, TC		
14	3	81532107	RETAINER, SC, LP, TC		
13	1	81512111	PLUNGER, SC, LP, 7500/33KN, DA, TC		
12	1	39054017	BU RING, (-033), 90 NBR	X	39054023
11	1	39054016	BU RING, 1.5x.125x.063, HYTREL	X	X
10	1	39052030	SEAL, CROWN, 1-3/4x2-1/8x1/4, 90AU	X	39V52030
9	2	39051041	O-RING, (-006), 1.14x.070, 90 HNBR	X	39V51041
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	21500305	SHCS, M8 X 1, 25-6G X 30MM		
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		

<b>PARTS LIST</b>	
	VEKTEK, INC. 1334 E. SIXTH AVE. P.O. BOX 625 EMPORIA, KS. 66801 U.S.A.
ASSEMBLIES AFFECTED 14222100 14222100F	PARTS LIST, ASSY, SC, LP, TC, BF, 7500, DA, RH
SIZE A	PL7174
	REV B

B	2596	RELEASE	JDW	12/06/13
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY:	JDW	<b>DRAWING STATUS: Released</b>		
DATE:	6-17-11	PRODUCTION APPROVED FOR RELEASED STATUS ONLY		

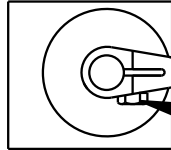
**1**      **2**

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

**Arm Installation Instruction Sheet**

**Low Profile Swing Clamps**

SIZE A      IS1505      REV C

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

FORM FEG041-IS-ASIZE, REV. B