

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),.1989x.070,90 HNBR	X	39V51002
17	1	81592123	CAM,SC,LP,7500/33KN,STR,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),.114x.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 1,25-66 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		

PARTS LIST		
	VEKTEK, INC. 1334 E. SIXTH AVE. P.O. BOX 625 EMPORIA, KS. 66801 U.S.A.	
	ASSEMBLIES AFFECTED 14222102 14122102F	PARTS LIST, ASSY,SC,LP,TC,BF,7500,DA,STR
SIZE A	PL7176	REV B

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			
DATE: 6-17-11	PRODUCTION APPROVED FOR RELEASED STATUS ONLY			

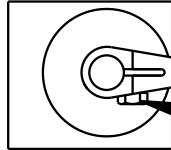
1 **2**

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
-----------	--------	----------

FORM FEG041-IS.AS1ZE, REV. B

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