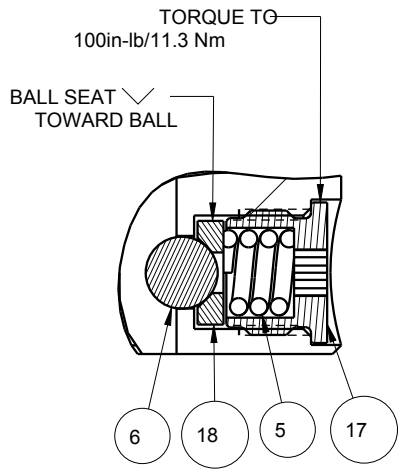
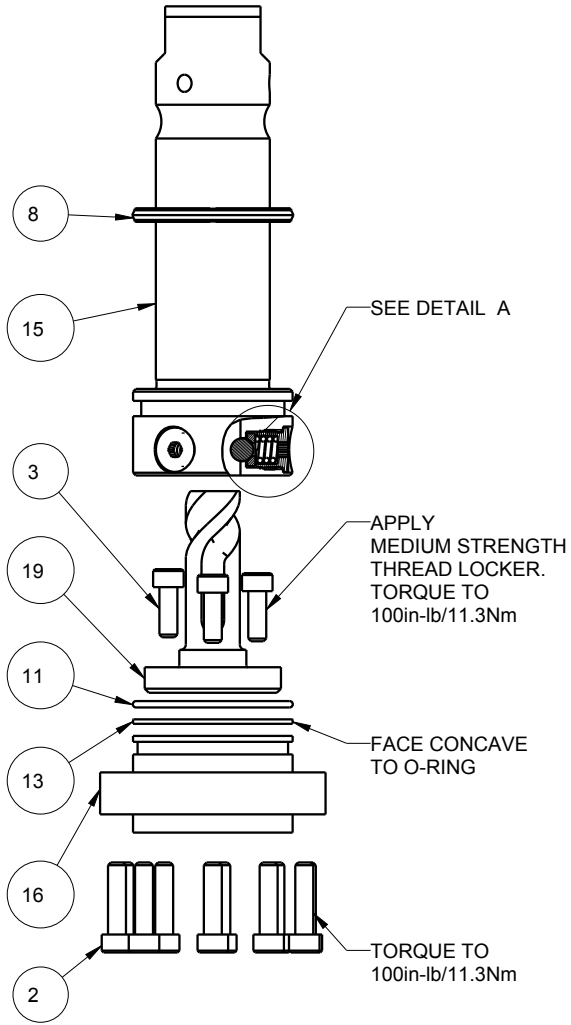


APPLY LUBRICANT TO ALL SEALS PRIOR TO INSTALLATION. DO NOT USE SILICONE TYPE LUBRICANTS. FOR PROPER ARM MOUNTING SEE IS1505.




DETAIL A
SCALE 1.500



N/A	N/A	IS1505	INSTRUCTION SHEET, ARM INSTALLATION		
N/A	N/A	6V711032	SEAL KIT, FKM		
N/A	N/A	60711032	SEAL KIT, STANDARD		
19	1	81591822	CAM,SC,LP,5000/22KN,RH,TC		
18	3	81532108	SEAT, BALL, SC, LP, TC		
17	3	81532107	RETAINER, SC, LP, TC		
16	1	81531809	CAP, END, SC, LP, 22KN/5000		
15	1	81511811	PLUNGER,SC,LP,5000&22KN,DA,TC		
14	1	39054008	BU RING,(-218)	X	X
13	1	39054007	BU RING,(-030)	X	39054021
12	1	39053005	WIPER,SNAP-IN, (1-1/4)	X	X
11	1	39051042	O-RING, (-030)	X	39V01021
10	2	39050042	O-RING, (-011)	X	39051025
9	1	39011060	SEAL,BEVEL W/WHEEL INSERT,1-1/4 x1/8 x1-1/2	X	39052015
8	1	39011056	SEAL,CROWN,1-9/16x1-3/4x5/32	X	39V11056
7	2	30601144	PLUG, SOCH, SAE 4		
6	3	23650004	BALL,TUNGSTEN-CARBIDE,250		
5	3	23350066	SPRING, COMPRESSION		
4	2	21500200	WASHER		
3	3	21500031	SHCS, M5 x 0,8 x 14, ALY		
2	10	21500022	SHCS, M5 x .8-6G x 20, ALY		
1	2	21500019	SCREW, CAP, BTNH, M3 X 6, ALY		
No.	QTY	PART No.	DESCRIPTION	Std. Seal Kit	FKM Seal Kit

PARTS LIST



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

A	3434	RELEASE	JDW	05/01/18
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY:	JDW	DRAWING STATUS: Released		
DATE:	05/01/18	PRODUCTION APPROVED FOR RELEASED STATUS ONLY		

ASSEMBLIES AFFECTED
14061800
14061800F

PARTS LIST, ASSY,SC,LP,TC,TF,5000,DA,RH	
SIZE A	PL7186
REV A	

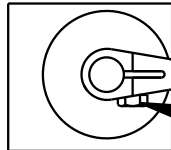
1 **2**

**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
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.

Arm Installation Instruction Sheet

Low Profile Swing Clamps

SIZE A	1S1505	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