

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

No.	QTY	PART No.	DESCRIPTION	Std. Seal Kit	FKM Seal Kit
N/A	N/A	IS1505	INSTRUCTION SHEET, ARM INSTALLATION		
N/A	N/A	6V711054	SEAL KIT, FKM		
N/A	N/A	60711054	SEAL KIT, STANDARD		
26	1	39V11051	WIPER, PRESS-IN, (1-1/2)	X	X
25	1	39V10029	WIPER, PRESS-IN, (1/4)	X	X
24	1	39H52000	SEAL, U-CUP, 1-1/2 x 1/8 x 1-3/4	X	39V52000
23	1	39H51002	O-RING, (-033)	X	39V51002
22	1	81592132	CAM, SC, LP, 7500/33KN, LH, TC, PR		
21	1	81532115	CAP, END, SC, LP, 33kN/7500, PR		
20	3	81532108	SEAT, BALL, SC, LP, TC		
19	3	81532107	RETAINER, SC, LP, TC		
18	1	81512121	PLUNGER, SC, LP, 7500/33KN, DA, TC, PR		
17	1	81500051	ROD, ACTUATOR, SC, LP, TF, 7500/33KN		
16	1	81500040	RING, LOCATOR, SC, LP, PR		
15	1	81500039	BUSHING, PLUNGER, PR, SC, LP		
14	1	39054017	BU RING, (-033)	X	39054023
13	1	39054016	BU RING, (1.5x.125x.063)	X	X
12	1	39052043	SEAL, LL, (1/4 x 1/8 x 1/8 x 1/2)	X	39V52043
11	1	39052030	SEAL, CROWN, 1-3/4x2-1/8x1/4	X	39V52030
10	2	39050042	O-RING, (-011)	X	39051025
9	2	30601144	PLUG, SOCH, SAE 4		
8	3	23650004	BALL, TUNGSTEN-CARBIDE. 250		
7	3	23350066	SPRING, COMPRESSION		
6	10	21500304	SHCS, M6 x 1.0-6G x 20MM		
5	2	21500200	WASHER		
4	3	21500031	SHCS, M5 x 0.8 x 14, ALY		
3	2	21500019	SCREW, CAP, BTNH, M3 x 6, ALY		
2	1	21430022	WASHER		
1	1	21410049	SCREW, CAP, SOCH, 8-32 x 3/8, ALY		

<h3>PARTS LIST</h3>	<p>VEKTEK, INC. 1334 E. SIXTH AVE. P.O. BOX 625 EMPORIA, KS. 66801 U.S.A.</p>
<p>SIZE A</p> <p>PL7202</p>	<p>REV A</p>

FORM FEG035_PL_ASIZE, REV. B

A	2679	RELEASE	JDW	12/06/13
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY:	JDW	DRAWING STATUS: Released		
DATE:	10/16/13	PRODUCTION APPROVED FOR RELEASED STATUS ONLY		

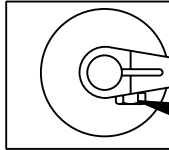
1 **2**

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
15-XX18-XX (5000lb) 14-XX18-XX (5000lb)	115 ft-lb	156 N-m
41-XX22-XX (22Kn)	115 ft-lb	156 N-m
6951KN-22-XX (22Kn) 6951KN-22-XXX (22Kn) 6951KZN-22-XX (22Kn) 6951FN-22-XX (22Kn) 6951FZN-22-XX (22Kn)	115 ft-lb	156 N-m
6951KP-22-XX (22Kn) 6951KP-22-XXX (22Kn) 6951KZP-22-XX (22Kn) 6951FP-22-XX (22Kn) 6951FZP-22-XX (22Kn)	115 ft-lb	156 N-m
15-XX21-XX (7500lb) 14-XX21-XX (7500lb)	225 ft-lb	305 N-m
41-XX33-XX (33Kn)	225 ft-lb	305 N-m
6951KN-33-XX (33Kn) 6951KN-33-XXX (33Kn) 6951KZN-33-XX (33Kn) 6951FN-33-XX (33Kn) 6951FZN-33-XX (33Kn)	225 ft-lb	305 N-m
6951KP-33-XX (33Kn) 6951KP-33-XXX (33Kn) 6951KZP-33-XX (33Kn) 6951FP-33-XX (33Kn) 6951FZP-33-XX (33Kn)	225 ft-lb	305 N-m

Instruction Sheet



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

B	2288	RELEASE	JDW	6-9-11
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY: MES	DRAWING STATUS: Released PRODUCTION APPROVED FOR RELEASED STATUS ONLY			
DATE: 08/01/05				

ASSEMBLIES AFFECTED

Arm Installation Instruction Sheet

Low Profile Swing Clamps

SIZE A	151505	REV B
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FORM FEG041-1S-ASIZE, REV. A