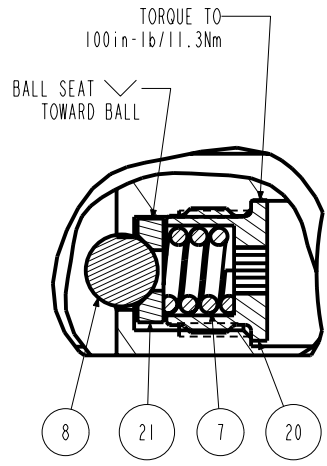


APPLY LUBRICANT TO ALL SEALS
PRIOR TO INSTALLATION.
DO NOT USE SILICONE TYPE LUBRICANTS.
FOR PROPER ARM MOUNTING SEE ISI505.



DETAIL A
SCALE 1.500

APPLY PRIMER N TO CAP SCREW,
PLUNGER AND BUSHING THREADS.
INSERT CAP SCREW THRU WASHER.
APPLY MEDIUM STRENGTH THREAD
LOCKER TO CAP SCREW THREAD
AND TORQUE TO 50 in-lb/5.6 Nm.
APPLY HIGH STRENGTH THREAD
LOCKER TO BUSHING THREAD AND
TORQUE TO 100 in-lb/11.3 Nm.

N/A	N/A	ISI505	INSTRUCTION SHEET, ARM INSTALLATION		
N/A	N/A	6V711050	SEAL KIT, FKM		
N/A	N/A	60711050	SEAL KIT, STANDARD		
27	1	39V11051	WIPER,PRESS-IN, (1-1/2)	X	X
26	1	39V10029	WIPER,PRESS-IN, (1/4)	X	X
25	1	39H52000	SEAL, U-CUP, 1-1/2 x 1/8 x 1-3/4	X	39V52000
24	1	39H51002	O-RING, (-033)	X	39V51002
23	1	81592133	CAM,SC,LP,7500/33KN,STR,TC,PR		
22	1	81542113	BASE,SC,BF,LP,7500.PR		
21	3	81532108	SEAT, BALL, SC, LP, TC		
20	3	81532107	RETAINER, SC, LP, TC		
19	1	81512121	PLUNGER,SC,LP,7500&33KN,DA,TC,PR		
18	1	81500053	ROD,ACTUATOR,SC,LP,BF,7500/33KN		
17	1	81500040	RING, LOCATOR, SC, LP, PR		
16	1	81500039	BUSHING,PLUNGER,PR,SC,LP		
15	1	39054017	BU RING, (-033)	X	39054023
14	1	39054016	BU RING, (1.5x.125x.063)	X	X
13	1	39052043	SEAL, LL, (1/4 X 1/8 X 1/8 X 1/2)	X	39V52043
12	1	39052030	SEAL,CROWN,1-3/4x2-1/8x1/4	X	39V52030
11	2	39051041	O-RING, (-006)	X	39V51041
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	21500305	SHCS, M8 X 1,25-66 X 30MM		
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		
No.	QTY	PART No.	DESCRIPTION	Std. Seal Kit	FKM Seal Kit

<h2>PARTS LIST</h2>	<p>VEKTEK, INC. 1334 E. SIXTH AVE. P.O. BOX 625 EMPORIA, KS. 66801 U.S.A.</p>
	<p>ASSEMBLIES AFFECTED</p> <p>14222102PR 14122102FPR</p>
<p>SIZE A</p>	<p>PL7209</p>
<p>FORM FEG035_PL_ASIZE, REV. B</p>	<p>SHEET 1 OF 1</p>

A	2679	RELEASE	JDW	06/23/14
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY:	JDW	DRAWING STATUS: Released PRODUCTION APPROVED FOR RELEASED STATUS ONLY		
DATE:	10/16/13			

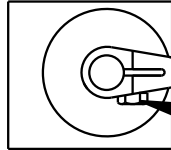
1 **2**

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 FEG041-1S.AS1Z, 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			