


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	81592138	CAM, SC, LP, 7500/STR, LS, 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	81512122	PLUNGER, SC, LP, 7500/33KN, DA, LS, TC, PR		
18	1	81500054	ROD, ACTUATOR, SC, LP, BF, 7500/33KN, LS		
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

PARTS LIST

ASSEMBLIES AFFECTED
14222105PR
14122105PRF



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

DATE: 03/04/19

DRAWING STATUS: **Released**

PRODUCTION APPROVED FOR RELEASED STATUS ONLY

SIZE A

PL7263

REV A

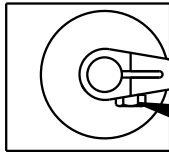
A	3677	RELEASE	JDW	03/04/19
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY:	JDW	DRAWING STATUS: Released		
DATE:	03/04/19	PRODUCTION APPROVED FOR RELEASED STATUS ONLY		

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

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			

FORM FEG041-1S.AS1ZE, REV. B