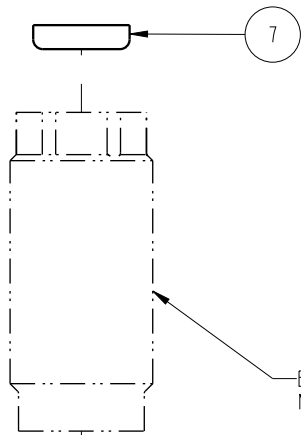


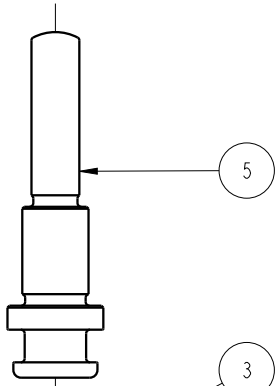
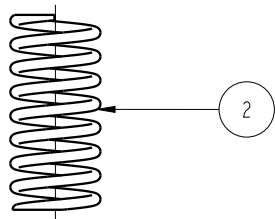
NO	QTY	PART NO	DESCRIPTION	STD SEAL KIT	FKM SEAL KIT	SPRING KIT
1	1	23050010	WASHER	X	X	X
2	1	23350127	SPRING, COMPRESSION			X
3	1	39010012	SEAL, BEVEL, 5/16 X 3/32 X 1/2	X	39V10012	
4	1	39010030	GASKET, COPPER	X	X	X
5	1	82110503	PISTON, CYL, CM, 980, .50 STRK, RAD			
6	1	39T55009	GASKET, (.451 x .100 x .080)	X	X	X
7	1	39V10029	WIPER, PRESS-IN, (1/4)	X	X	
N/A	N/A	60210105	KIT, SEAL,	NOTED	N/A	N/A
N/A	N/A	6V210105	KIT, SEAL, FKM,	N/A	NOTED	N/A
N/A	N/A	61210105	KIT, SPRING,	N/A	N/A	NOTED



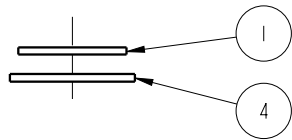
Body -
Not Replaceable

See IS-2100 for machining
and installation instructions.

Lubricate all seals with clean
hydraulic oil prior to assembly.
**DO NOT USE SILICONE
BASED LUBRICANTS.**



Assemble with the lip side of the seal
facing the bottom of the piston.



USE ONLY ONE GASKET

INSTALLATION TORQUE:

- Metal Gasket = 40 ft-lb
- Composite Gasket = 20 ft-lb

*Cylinders may need to be
re-torqued after a break-in
period of 3 weeks or 2,500
cycles for both gasket
styles.

Both metal and composite gaskets are
supplied. Use only one gasket. The metal
gasket is recommended when the cavity
seal surface has every smooth finish and
is flat and perpendicular to the minor
diameter. The metal gasket must be
torqued to a higher value, which is more
resilient to machining vibrations
providing long term sealing. The
composite gasket is recommended when the
cavity seal surface has a rough surface
finish or is not flat.

**PARTS
LIST**



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

ASSEMBLIES AFFECTED

21-0105-05
21-0105-05F

PARTS LIST, ASSY, CYL, CM, 980, .50 STRK, SA, RAD

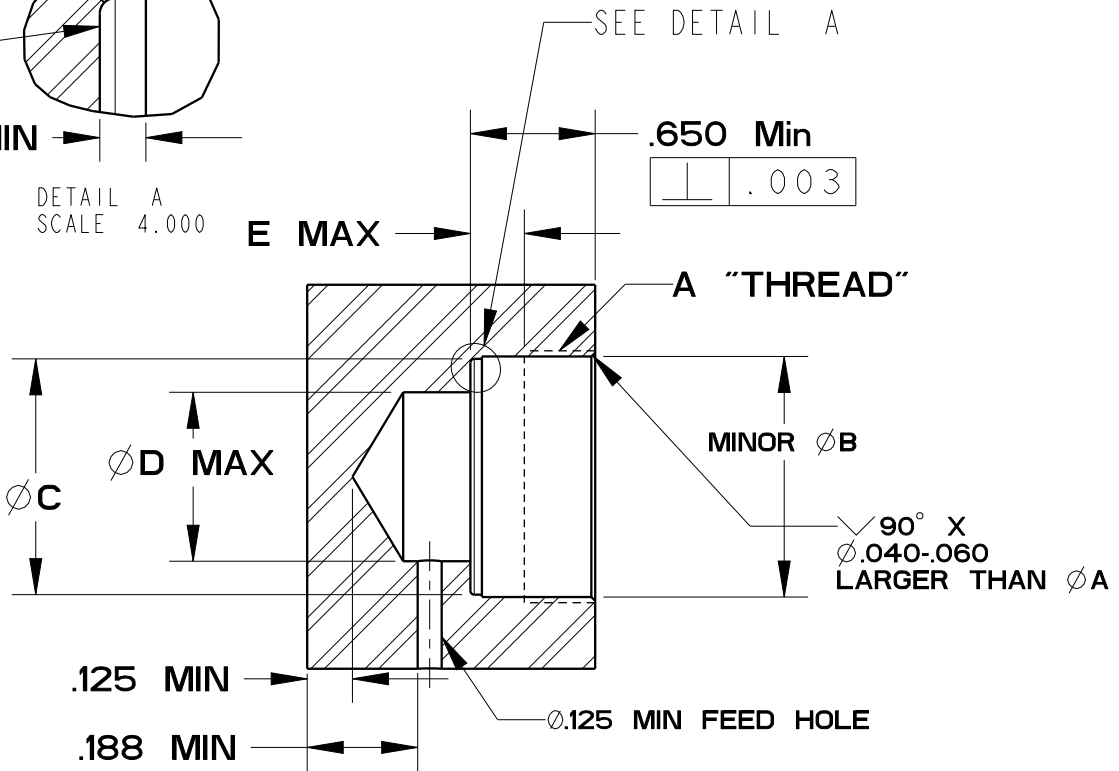
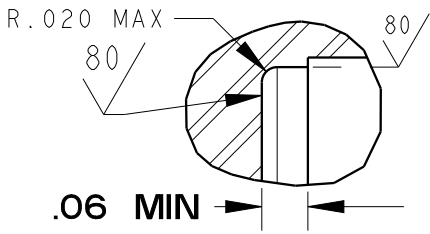
SIZE
A PL2189

REV
B

B	3140	RELEASE	BCD	11/9/16
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY:	MAJ	DRAWING STATUS: Released		
DATE:	4-1-16	PRODUCTION APPROVED FOR RELEASED STATUS ONLY		

FORM FEG035_PL_ASIZE, REV. B

SHEET 1 OF 1




Tighten cylinders with a six point socket only !

Model No.	A	Metal Gasket Torque	Composite Gasket Torque	ØB	ØC	D	E
21-0102-00	3/8-24 UNF-2B	10 ft lb	NA	.335±.003	.325±.005	.13	.100
21-0104-02	5/8-18 UNF-2B	30 ft lb	15 ft lb	.572±.003	.545±.005	.31	.156
21-0105-03	3/4-16 UNF-2B	40 ft lb	20 ft lb	.690±.003	.662±.005	.38	.156
21-0105-04	3/4-16 UNF-2B	40 ft lb	20 ft lb	.690±.003	.662±.005	.38	.156
21-0105-05	3/4-16 UNF-2B	40 ft lb	20 ft lb	.690±.003	.662±.005	.38	.156
21-0105-06	3/4-16 UNF-2B	40 ft lb	20 ft lb	.690±.003	.662±.005	.38	.156
21-0108-04	1 1/16-16 UN-2B	50 ft lb	25 ft lb	1.002±.003	.923±.005	.63	.281
21-0108-05	1 1/16-16 UN-2B	50 ft lb	25 ft lb	1.002±.003	.923±.005	.63	.281
21-0108-08	1 1/16-16 UN-2B	50 ft lb	25 ft lb	1.002±.003	.923±.005	.63	.281
21-0110-04	1 5/16-16 UN-2B	NA	35 ft lb	1.253±.003	1.228±.005	.88	.281

*Cylinders may need to be re-torqued after a break-in period of 3 weeks or 2,500 cycles for both gasket styles.

Instruction Sheet



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

Model number
-See Chart-

Cavity Dimensions
Cartridge Mounted Cylinders

SIZE
A

IS-2100

REV
G

FORM FEG041-IS-ASIZE, REV. B

G	3041	RELEASE	BCD	11/9/16
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY:	VANDALSEM			
DATE:	04-13-93			
DRAWING STATUS: Released PRODUCTION APPROVED FOR RELEASED STATUS ONLY				