

LUBRICATE SEALS WITH CLEAN HYDRAULIC OIL PRIOR TO ASSEMBLY.  
DO NOT USE SILICONE BASED LUBRICANTS

APPLY MEDIUM STRENGTH THREAD LOCKER (BLUE).  
TIGHTEN TO 100 ft lbs TORQUE

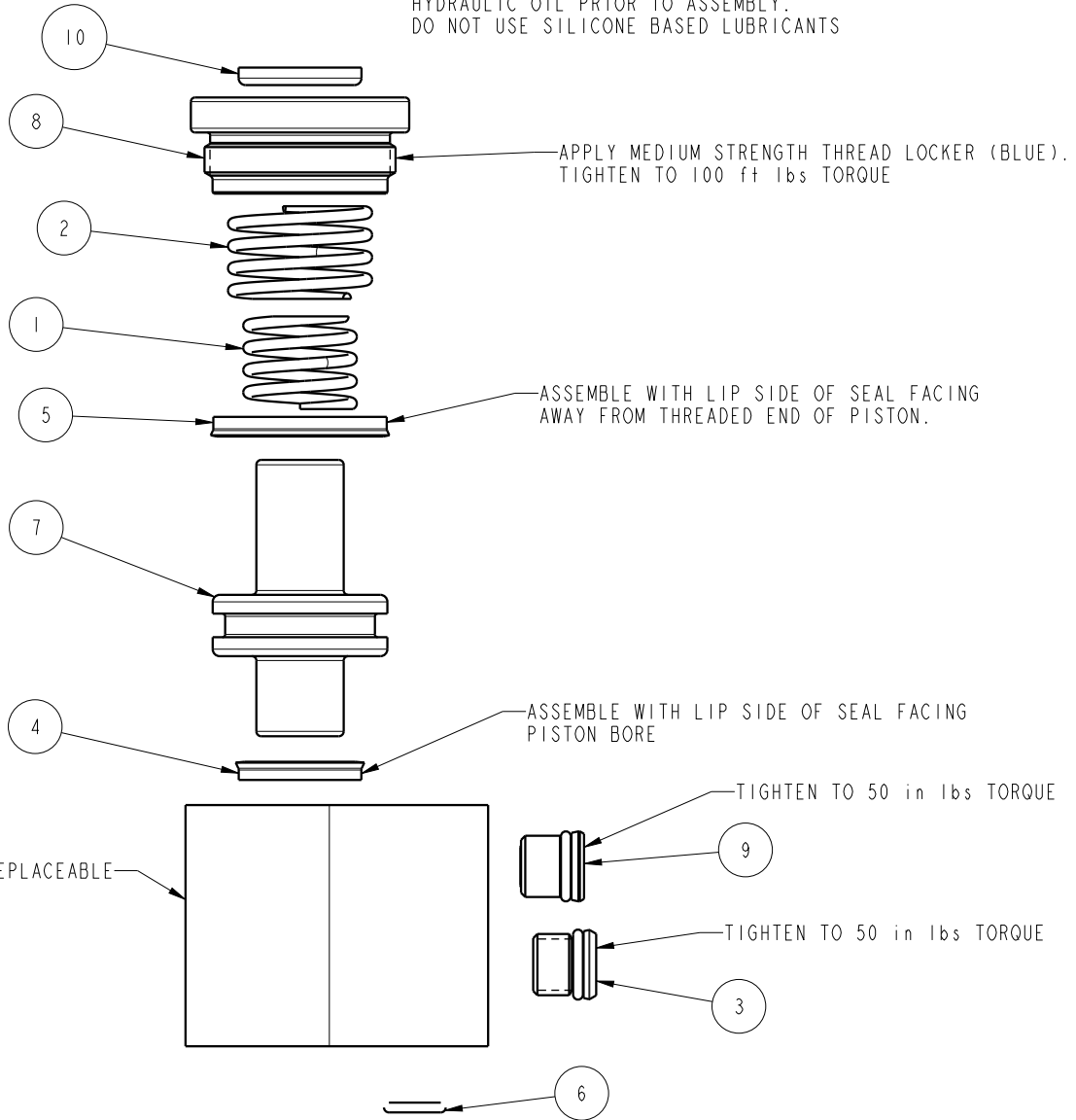
ASSEMBLE WITH LIP SIDE OF SEAL FACING AWAY FROM THREADED END OF PISTON.

ASSEMBLE WITH LIP SIDE OF SEAL FACING PISTON BORE

TIGHTEN TO 50 in lbs TORQUE

TIGHTEN TO 50 in lbs TORQUE

BODY - NOT REPLACEABLE



NO	QTY	PART NO	DESCRIPTION
1	1	23350074	SPRING, COMPRESSION
2	1	23350075	SPRING, COMPRESSION
3	1	30601144	PLUG, SOCH, SAE 4
4	1	39010020	SEAL, BEVEL W/HEEL INSERT, 5/8 x 1/8 x 7/8
5	1	39011027	SEAL, BEVEL, 1-1/16 x 3/32 x 1-1/4
6	1	39050042	O-RING, (-011)
7	1	82011301	PISTON, CYL, HR, 4600
8	1	82031309	GLAND, CYL, HR, 4600&20.6KN, SA
9	1	92090001	ASSY, BREATHER, SAE #4
10	1	39V11020	WIPER, PRESS-IN, (5/8)

Standard Seal Kit	Fluorocarbon Seal Kit	Spring Kit
60-2121-13	6V-2121-13	61-2021-14
39-0100-20	39-0520-02	23-3500-74
39-0110-27	39-0520-12	23-3500-75
39-V110-20	39-V110-20	

### PARTS LIST



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

ASSEMBLIES AFFECTED  
21211303

PARTS LIST, ASSY, CYL, HR, 4600, SA, WM

A	3148	RELEASE	GAR	2/17/17
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE

DRW BY: GAR  
DATE: 2-17-17  
**DRAWING STATUS: Released**  
PRODUCTION APPROVED FOR RELEASED STATUS ONLY

SIZE  
A  
PL2191  
REV  
A

SHEET 1 OF 1