

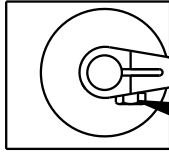
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**READ ALL INSTRUCTIONS BEFORE INSTALLING ARMS  
FAILURE TO FOLLOW INSTALLATION INSTRUCTIONS  
WILL VOID PRODUCT WARRANTY !**

**-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
5000 lb & 22Kn	115 ft-lb	156 N-m
7500 lb & 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

FORM FEG041-IS-ASIZE, REV. B

C	2799	RELEASE	JDW	01/29/15
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY:	MES	<b>DRAWING STATUS: Released</b>		
DATE:	08/01/05	PRODUCTION APPROVED FOR RELEASED STATUS ONLY		

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SHEET 1 OF 1