

N/A	N/A	IS1505	INSTRUCTION SHEET, ARM INSTALLATION		
N/A	N/A	6V711048	SEAL KIT, FKM		
N/A	N/A	60711048	SEAL KIT, STANDARD		
27	1	39V10029	WIPER, PRESS-IN, (1/4)	X	X
26	1	81591838	CAM, SC, LP, 22KN, LH, LS, TC, PR		
25	1	81541818	BASE, SC, BF, LP, 5000, PR		
24	3	81532108	SEAT, BALL, SC, LP, TC		
23	3	81532107	RETAINER, SC, LP, TC		
22	1	81511822	PLUNGER, SC, LP, 22KN, DA, LS, TC, PR		
21	1	81500044	ROD, ACTUATOR, SC, LP, BF, 5000/22KN, LS		
20	1	81500040	RING, LOCATOR, SC, LP, PR		
19	1	81500039	BUSHING, PLUNGER, PR, SC, LP		
18	1	39054008	BU RING, (-218)	X	X
17	1	39054007	BU RING, (-030)	X	39054021
16	1	39053005	WIPER, SNAP-IN, (1-1/4)	X	X
15	1	39052043	SEAL, LL, (1/4 X 1/8 X 1/8 X 1/2)	X	39V52043
14	1	39051042	O-RING, (-030)	X	39V01021
13	2	39051041	O-RING, (-006)	X	39V51041
12	2	39050042	O-RING, (-011)	X	39051025
11	1	39011060	SEAL, BEVEL WHEEL INSERT, 1-1/4 x 1/8 x 1-1/2	X	39052015
10	1	39011056	SEAL, CROWN, 1-9/16 x 1-3/4 x 5/32	X	39V11056
9	2	30601144	PLUG, SOCH, SAE 4		
8	3	23650004	BALL, TUNGSTEN-CARBIDE, .250		
7	3	23350066	SPRING, COMPRESSION		
6	2	21500200	WASHER		
5	3	21500031	SHCS, M5 x 0.8 x 14, ALY		
4	10	21500023	SHCS, M5 X .8-6G X 30MM		
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

<h3>PARTS LIST</h3>		
	VEKTEK, INC. 1334 E. SIXTH AVE. P.O. BOX 625 EMPORIA, KS. 66801 U.S.A.	
ASSEMBLIES AFFECTED 14281804PR 14281804PRF	PARTS LIST, ASSY, SC, LP, TC, BF, 5000, DA, LH, LS, PR	SIZE A PL7251
REV IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REV B

B	4171	RELEASE	JDW	05/01/20
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			

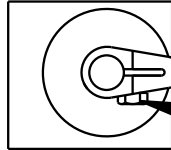
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**READ ALL INSTRUCTIONS BEFORE INSTALLING ARMS
FAILURE TO FOLLOW INSTALLATION INSTRUCTIONS
WILL VOID PRODUCT WARRANTY !**

–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
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	IS1505	REV C
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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	DRAWING STATUS: Released			
DATE: 08/01/05	PRODUCTION APPROVED FOR RELEASED STATUS ONLY			

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