



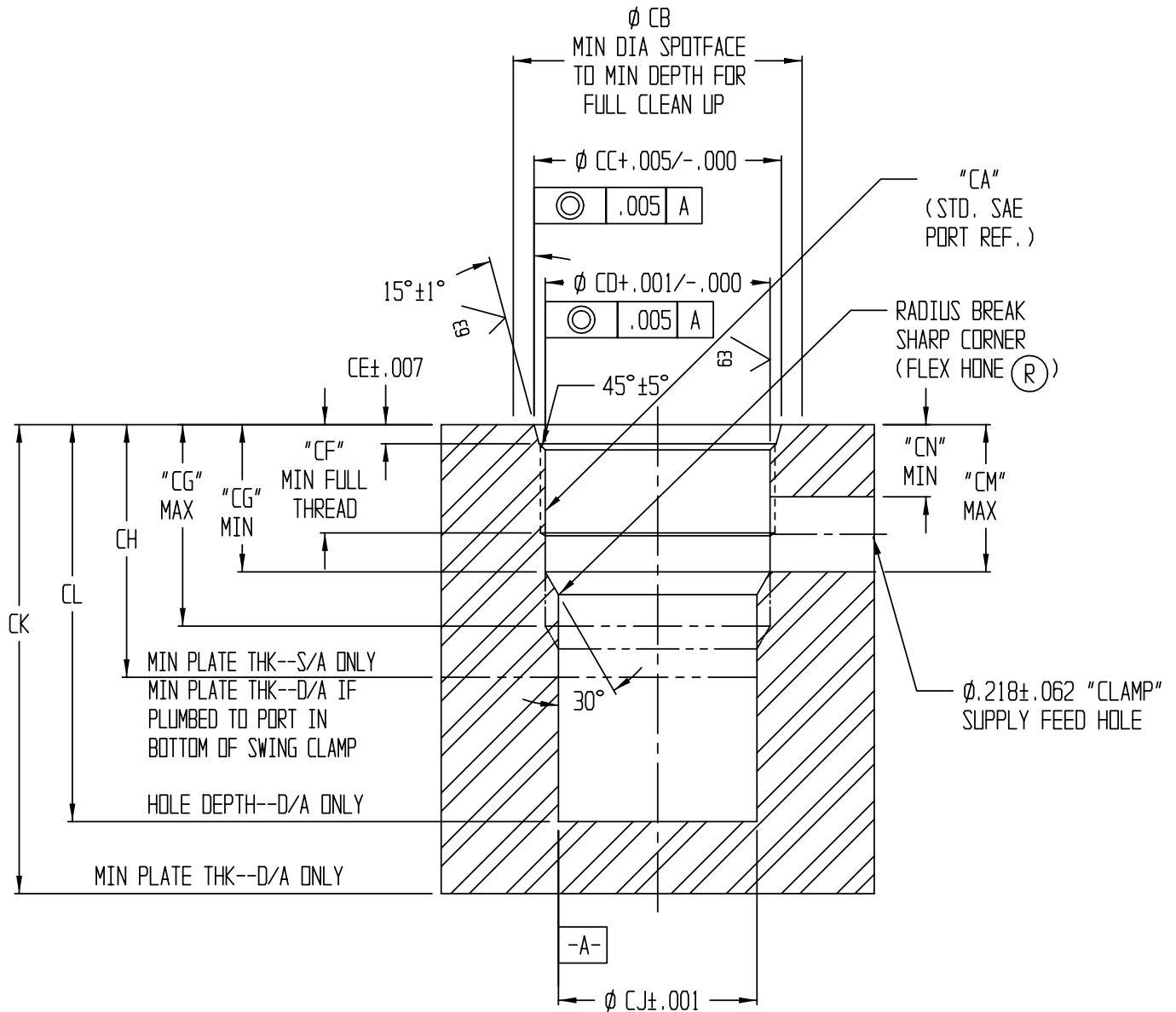
VEKTEK, INC.
1334 E. SIXTH AVE.
P.O. BOX 625
EMPORIA, KS. 66801
U.S.A.

INSTALLATION INSTRUCTIONS

IS-1501
REV. F, ECN1719
PAGE 1 OF 3

ASSEMBLIES AFFECTED
MANIFOLD MOUNTED DEVICES

DRAWN/DATE VANDALSEM
8/17/90



BASIC CAVITY CAN BE FORMED WITH A STANDARD SAE O-RING PORT CONTOUR CUTTER.

MODEL NO.	CA	CB	CC	CD	CE	CF	CG MIN	CG MAX	CH	CJ	CK	CL	CM	CN
15-1105-00	1 1/16-12	1.38	1.148	.979	.137	.50	.750	.906	1.25	.938	N/A	N/A	.750	.417
15-1109-00	1 5/8-12	2.00	1.713	1.541	.139	.68	.815	.906	1.50	1.376	N/A	N/A	.815	.525
15-1113-00	1 7/8-12	2.25	1.962	1.792	.139	.62	.875	.906	1.50	1.751	N/A	N/A	.875	.403
15-1205-00	1 1/16-12	1.38	1.148	.979	.137	.50	.750	.906	N/A	.938	2.75	2.25	.750	.417
15-1209-00	1 5/8-12	2.00	1.713	1.541	.139	.68	.815	.906	N/A	1.376	3.25	2.75	.815	.525
15-1213-00	1 7/8-12	2.25	1.962	1.792	.139	.62	.875	.906	N/A	1.751	3.75	3.25	.875	.403



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

INSTALLATION INSTRUCTIONS

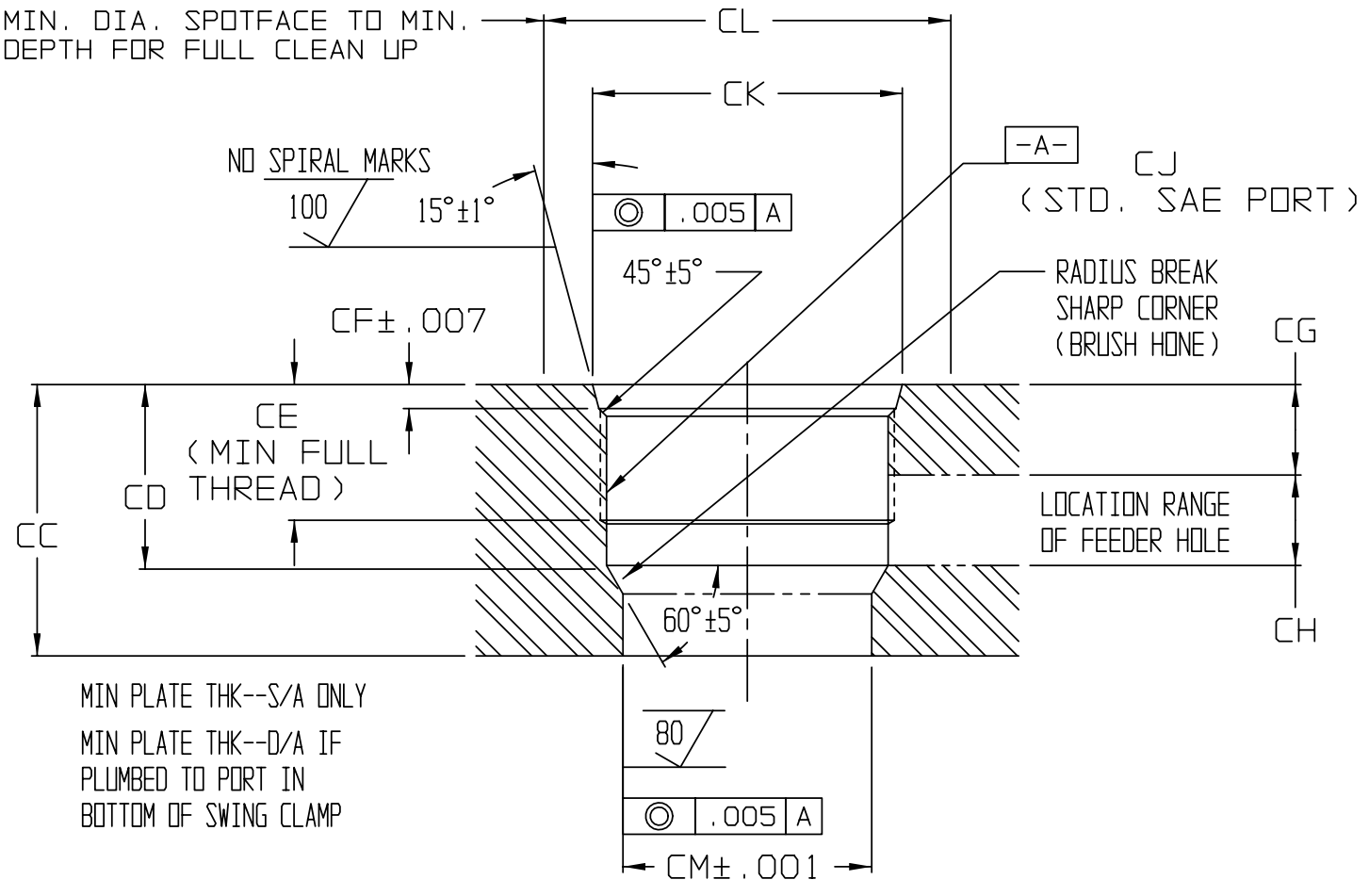
IS1501
REV. F, ECN1719
PAGE 2 OF 3

ASSEMBLIES AFFECTED
MANIFOLD MOUNTED SWING CLAMPS

DRAWN/DATE VANDALSEM
8/17/90

CAVITY FOR S/A SWING CLAMP or D/A UNIT
WITH HYDRAULICS PLUMBED TO BOTTOM PORT.

MIN. DIA. SPOTFACE TO MIN.
DEPTH FOR FULL CLEAN UP



D/A CAVITY WITH BLIND HOLE SHOWN ON BACK.

BASIC CAVITY CAN BE FORMED WITH A STANDARD SAE O-RING BOSS PORT CONTOUR CUTTER.

MODEL NO.	TYPE*	CA	CB	CC	CD	CE	CF	CG	CH	CJ	INSTALLATION TORQUE	CK	CL	CM
15-1105-00 15-1205-00	S/A D/A	2.75	2.25	1.25	.91	.75	.137	.44	.38	1 1/16-12 SAE NO. 12	60 FT-LB	1.150	1.38	.938
15-1109-00 15-1209-00	S/A D/A	3.25	2.75	1.50	.91	.75	.137	.50	.56	1 5/8-12 SAE NO. 20	95 FT-LB	1.715	2.00	1.376
15-1113-00 15-1213-00	S/A D/A	3.75	3.25	1.50	.91	.75	.137	.50	.50	1 7/8-12 SAE NO. 24	110 FT-LB	1.964	2.25	1.751

*S/A DENOTES SINGLE ACTING, D/A DENOTES DOUBLE ACTING

IS1501-1



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

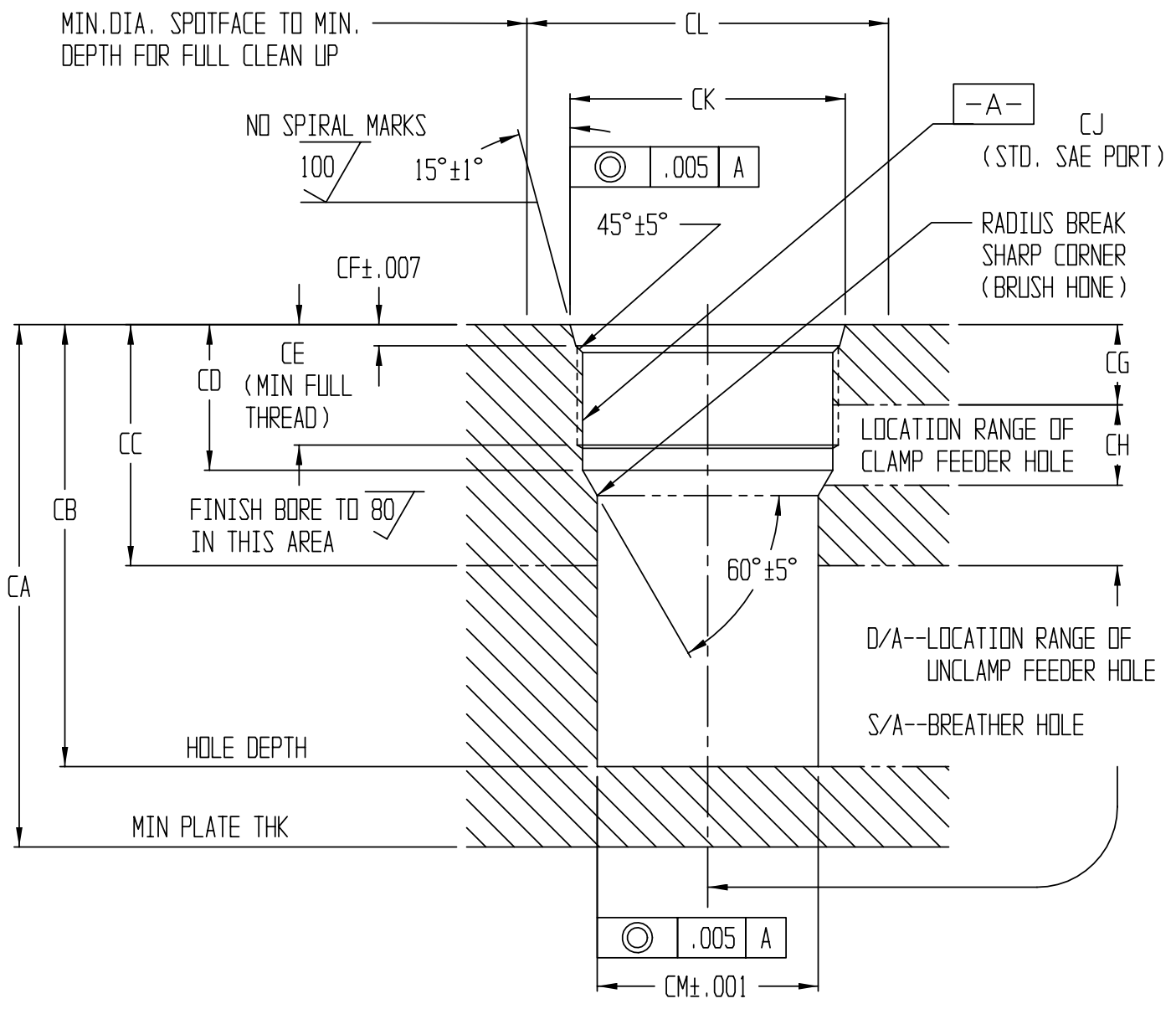
INSTALLATION INSTRUCTIONS

IS1501
REV. F, ECN1719
PAGE 3 OF 3

ASSEMBLIES AFFECTED
MANIFOLD MOUNTED SWING CLAMPS

DRAWN/DATE VANDALSEM
8/17/90

CAVITY WITH BLIND HOLE



IF A SINGLE ACTING UNIT IS TO BE INSTALLED IN A BLIND HOLE; A BREATHER HOLE MUST BE INSTALLED IN THE BOTTOM OF THE BLIND HOLE.
BASIC CAVITY CAN BE FORMED WITH A STANDARD SAE O-RING PORT CONTOUR CUTTER.

MODEL NO.	TYPE*	CA	CB	CC	CD	CE	CF	CG	CH	CJ	INSTALLATION TORQUE	CK	CL	CM
15-1105-00 15-1205-00	S/A D/A	2.75	2.25	1.25	.91	.75	.137	.44	.38	1 1/16-12 SAE NO. 12	88 FT-LB	1.150	1.38	.938
15-1109-00 15-1209-00	S/A D/A	3.25	2.75	1.50	.91	.75	.137	.50	.56	1 5/8-12 SAE NO. 20	155 FT-LB	1.715	2.00	1.376
15-1113-00 15-1213-00	S/A D/A	3.75	3.25	1.50	.91	.75	.137	.50	.50	1 7/8-12 SAE NO. 24	185 FT-LB	1.964	2.25	1.751

*S/A DENOTES SINGLE ACTING, D/A DENOTES DOUBLE ACTING

IS1501-2