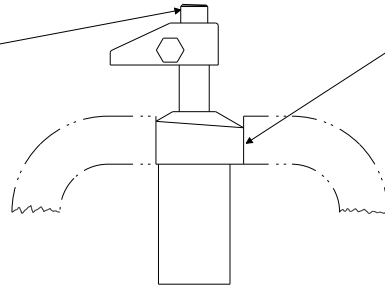


CAUTION: SPRING RETURN UNITS CONTAIN SPRINGS WHICH EXERT A CONSIDERABLE AMOUNT OF FORCE AGAINST THIS RETAINER. LOOSENING THE RETAINER MUCH BEYOND THE FIRST FULL THREAD MAY CAUSE THE RETAINER TO BE EJECTED UPWARD CAUSING HAZARD IF NOT CONSTRAINED.

4. PUSH DOWNWARD ON ARM AND PLUNGER WHILE APPLYING A CLOCKWISE OR COUNTERWISE MOTION, ALLOWING PLUNGER TO FOLLOW THE CAM MOTION UNTIL PLUNGER REACHES BOTTOM OF STROKE.



3. RECLAMP UNIT ACROSS FLAT OF PORT AS SHOWN WITH ARM INSTALLED FOR EASE OF MOVING THE PLUNGER.

NOTE: SPRING RETURN UNITS WILL EXERT A CONSIDERABLE AMOUNT OF FORCE NEAR BOTTOM OF STROKE. (e.g. MODEL NO. 15-0113-11 WILL EXERT 60-80 LBS. IN THIS POSITION.) IT MAY BE HELPFULL TO USE A SMALL HAND ARBOR PRESS TO EXERT THE FORCE NEEDED. IF THIS METHOD IS USED, MAKE SURE THE PLUNGER CAN FREELY ROTATE AND A SOLID GRIP IS MAINTAINED ON THE BODY. 5. WHILE HOLDING THE PLUNGER IN ITS BOTTOM POSITION, CONTINUE TO ROTATE THE ARM. IF YOU ARE CHANGING A DOUBLE-ACTION MODEL, PULL UP ON THE ARM AS YOU ARE ROTATING IT UNTIL IT "FINDS" THE OTHER CAM TRACK. SPRING-RETURN MODELS WILL EXERT THIS UPWARD FORCE NATURALLY; CONSEQUENTLY, A RESTRICTIVE DOWNWARD FORCE SHOULD BE EXERTED TO SLOW THE RAPID UPWARD TRAVEL WHEN THE REQUIRED CAM TRACK IS "FOUND". AS THE PLUNGER EXTENDS UPWARD IT WILL ROTATE WHILE FINISHING ITS EXTENSION. (IF THE ARM ROTATION IS NOT AS REQUIRED, THEN REPEAT STEPS 4 AND 5 UNTIL THE REQUIRED CAM GROOVE IS LOCATED.) 6. RECLAMP THE UNIT AS SHOWN IN STEP 1. TIGHTEN THE RETAINER AND TORQUE TO ONE OF THE FOLLOWING SPECIFICATIONS:


SERIES 15-XX05-XX or 41-5X02-XX = 13 FT-LBS / 18 Nm
 SERIES 15-XX09-XX or 41-5X05-XX = 13 FT-LBS / 18 Nm
 SERIES 15-XX13-XX or 41-5X11-XX = 13 FT-LBS / 18 Nm
 SERIES 15-XX18-XX or 41-5X22-XX = 13 FT-LBS / 18 Nm

READ COMPLETE INSTRUCTIONS BEFORE OPERATING SWING CLAMP.

NOTICE!

NEVER ALLOW SWING ARM TO CONTACT WORKPIECE OR FIXTURE DURING ARM ROTATION. (AT OPR. PRES. CONTACT OF ARM DURING SWING MAY CAUSE CAM DAMAGE.) TO CHECK POSITION, RUN SWING CLAMPS AT LOW PRESSURE FOR FIRST FEW CYCLES. MINIMUM CLAMP TIME: SHORT ARM--5 SEC. or LONG ARM-1 SEC.

FAILURE TO HEED NOTICE WILL VOID WARRANTY.

INSTALLATION INSTRUCTIONS		 VEKTEK, INC. 1334 E. SIXTH AVE. P.O. BOX 625 EMPORIA, KS. 66801 U.S.A.	
ASSEMBLIES AFFECTED		INSTALLATION INSTRUCTIONS, RESTRICTOR INSTALLATION	
ALL SWING CLAMP MODELS EXCEPT LOW PROFILE		SIZE A	REV D
		FORM FEG041-IS-ASIZE, REV. B	

D	3958	RELEASE	JDW	10/31/19
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY:	JACOB	DRAWING STATUS: Released		
DATE:	09/13/01	PRODUCTION APPROVED FOR RELEASED STATUS ONLY		

SHEET 3 OF 3