

No.	DESCRIPTION
1	CONTACT BOLT
2	O-RING (7.5MM X 1.5)
3	PLUNGER
4	SPRING
5	WIPER
6	TOP CAP
7	O-RING (31.5MM X 2)
8	O-RING (25MM X 2.65)
9	COLLET ASSY
10	SPRING
11	BOTTOM CAP
12	BODY
13	O-RING (19.5MM X 2)
14	O-RING (24.5MM X 2)
15	O-RING (4MM X 3)
16	MANIFOLD PLUG
17	O-RING (6MM X 1)
18	G1/8 PLUG
19	BREATHER
20	WASHER
21	SHCS

TOOL LIST

- 11mm & 13mm Open End Wrench
- 2.5mm & 3mm Hex Key
- Vekttek #ATL10312 Spanner Wrench

INSTALLATION INSTRUCTIONS



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

A	2629	RELEASE	Two	4/9/14
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY:	N. KARRAS	DRAWING STATUS: Released		
DATE:	3/10/14	PRODUCTION APPROVED FOR RELEASED STATUS ONLY		

ASSEMBLIES AFFECTED	INSTRUCTION SHEET, WS, 7MPo, TF, SPR, 5.5kn
L1-0115-00H	
L1-0115-00L	
SIZE A	ISL1000
REV A	


Read all instructions before disassembly

Refer to the illustration on page 1 for component part numbers and tool list

Disassembly

1. Remove work support from fixture. Wipe clean to remove external contaminants.
2. With 13mm wrench at plunger (3) and 11mm wrench at contact bolt (1), unscrew contact bolt (1) from plunger (3). Remove O-ring (2) from contact bolt (1).
3. Remove contact spring (4) from inside plunger (3).
4. Insert 2.5mm hex key into cap screw (21) inside plunger (3) and unscrew cap screw (21). Remove cap screw (21) and washer (20) from inside plunger (3).
5. Gently slide plunger (3) out from top of work support.
6. Clamp work support body (12) in vise with bottom side facing up.
7. Using Vektek #ATL10312 spanner wrench unscrew bottom cap (11) from work support body (12). Remove O-ring (13) and O-ring (14) from bottom cap (11).
8. Remove work support body (12) from vise.
9. Remove wiper (5) from top cap (6). Be careful not to damage wiper bore or bore below wiper (6).
10. If work support hydraulics or vent is manifold fed from fixture, remove O-ring (15) from manifold s'face on work support body (12) mounting flange (2 places).
11. If work support hydraulics or vent is not manifold fed, insert 3mm hex key into plug (16) located at work support body (12) mounting flange and unscrew plug (16) (2 places). Remove O-ring (17) from plug (16).
12. Thoroughly clean contact bolt (1), contact spring (4), plunger (3), cap screw (21), washer (20), bottom cap (11), plugs (16) and set aside to dry.
13. Wipe clean bottom cap seal bore and seal face located in bottom of body (12). Wipe clean wiper bore located in top cap (6) at top of work support. Wipe clean manifold s'face located on body (12) mounting flange.

Caution: Do not expose work support clamping mechanism (9) located underneath the top cap (6) to any type of cleaning solutions. Removal of top cap (6) or clamping mechanism (9) terminates product warranty.

 VEKTEK, INC. 1334 E. SIXTH AVE. P.O. BOX 625 EMPORIA, KS. 66801 U.S.A.		
INSTRUCTION SHEET, WS, 7MP, TF, SPR, 5.5kH		
SIZE A	ISL1000	REV A
FORM FEG041-1S-ASIZE, REV. B		

Assembly

1. Lubricate new O-rings (2), (13), (14), (15), (17) and outside diameter of new wiper (5) with clean hydraulic oil (Vekttek 65-0010-01 or equivalent). Also, apply light film of hydraulic oil to outside surface of plunger (3)
2. Press wiper (5) into top cap (6) taking extra care to install squarely without excess force. CAUTION: IMPROPER INSTALLATION COULD DAMAGE WIPER (5) CAUSING EXCESS WIPER DRAG.
3. Install O-ring (13) and O-ring (14) onto bottom cap (11)
4. Clamp work support body (12) into vise with bottom side facing up.
5. Screw bottom cap (11) into bottom of work support body (12). Using Vekttek #ATL10312 spanner wrench torque bottom cap (11) to 30 N-m (20 ft-lb).
6. Remove work support body from vise and position with top cap upward.
7. Gently install plunger (3) into work support through wiper (5) taking care not to damage wiper (5). Plunger (3) should move freely without binding. Lightly push plunger (3) downward until bottoms.
8. Install washer (20) onto cap screw (21) and drop thread side down into hole through top of plunger (3). Insert 2.5mm hex key into cap screw (21) and torque to 2.5 N-m (20 in-lb).
9. Insert contact spring (4) into hole through top of plunger (3). Contact spring (4) will pilot onto cap screw (21).
10. Install O-ring (2) onto contact bolt (1).
11. Screw contact bolt (1) into top of plunger (3). With 13mm wrench at plunger (3) and 11mm wrench at contact bolt (1) torque to 9 N-m (80 in-lb).
12. If work support hydraulics or vent is manifold fed from fixture, install new O-ring (15) into manifold surface on work support body (12) mounting flange (2 places).
13. If work support hydraulics or vent is not manifold fed install O-ring (17) onto plug (16), insert 3mm hex key into plug (16) and torque to 3 n-m (25 in-lb) (2 places).



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INSTRUCTION SHEET, WS, 7MP, TF, SPR, 5.5kN

SIZE
A

ISL1000

REV
A

FORM FEG041-IS-ASIZE, REV. B

SHEET 3 OF 3