

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	SPRING
12	O-RING (12.5MM X 1.8)
13	RETAINER
14	O-RING (24.5MM X 2)
15	BOTTOM CAP
16	PISTON
17	O-RING (6.7MM X 1.8)
18	O-RING (4MM X 3)
19	PLUG
20	O-RING (6MM X 1)
21	BREATHER
22	PLUG
23	BODY
24	WASHER
25	SHCS

TOOL LIST	
<input type="checkbox"/>	11mm & 13mm Open End Wrench
<input type="checkbox"/>	2.5mm & 3mm Hex Key
<input type="checkbox"/>	Vektex #ATL10312 Spanner Wrench
<input type="checkbox"/>	10mm Dia. or Smaller Drift Or Equivalent Rod

INSTALLATION INSTRUCTIONS

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

C	2846	RELEASE	Two	05/04/15
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY:	N. KARRAS	DRAWING STATUS: Released		
DATE:	03/10/14	PRODUCTION APPROVED FOR RELEASED STATUS ONLY		

ASSEMBLIES AFFECTED
 L1-0215-00H
 L1-0215-00L

INSTRUCTION SHEET, WS, 7MPo, TF, FA, 5.5kN	
SIZE A	ISL1002
REV C	


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. Clamp work support body (23) in vise with bottom side facing up.
5. Using Vektek #ATL10312 spanner wrench unscrew bottom cap (15) from work support body (23). Remove O-ring (14) from bottom cap (15).
6. Remove work support body (23) from vise. Insert 3mm hex key into piston (16) from bottom of work support to prevent turning. Insert 2.5mm hex key into cap screw (25) inside plunger (3) and unscrew cap screw (25). Remove cap screw (25) and washer (24) from inside plunger (3). NOTE: PISTON (16) IS LOOSE AND NO LONGER FASTENED TO THE ASSEMBLY.
7. Remove piston (16) and return spring (11) from inside retainer (13). Remove O-ring (17) from piston (16). CAUTION: RETURN SPRING (11) AND CONTACT SPRING (4) ARE NOT INTERCHANGEABLE, NOTE LOCATION AND KEEP SEPARATE FOR REASSEMBLY.
8. Gently slide plunger (3) out from top of work support.
9. Remove wiper (5) from top cap (6). Be careful not to damage wiper bore or bore below wiper (5).
10. From top of work support place drift or equivalent rod on top of retainer (13) and push downward till retainer (13) comes free from body (23). Remove retainer (13) from body (23). Remove O-ring (12) from retainer (13).
11. If work support hydraulics or vent is manifold fed from fixture, remove O-ring (18) from manifold s'face on work support body (23) mounting flange (2 places).
12. If work support hydraulics or vent is not manifold fed, insert 3mm hex key into plug (19) located at work support body (23) mounting flange and unscrew plug (19) (2 places). Remove O-ring (20) from plug (19).
13. Thoroughly clean contact bolt (1), contact spring (4), plunger (3), cap screw (25), washer (24), retainer (13), bottom cap (15), piston (16), plugs (19), return spring (11) and set aside to dry.
14. Wipe clean bottom cap seal bore and retainer seal bore located in bottom of body (23). Wipe clean wiper bore located in top cap (6) at top of work support. Wipe clean manifold s'face located on body (23) 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.

		
<small>VEKTEK, INC. 1334 E. SIXTH AVE. P.O. BOX 625 EMPORIA, KS. 66801 U.S.A.</small>		
INSTRUCTION SHEET, WS, 7MPo, TF, FA, 5.5kW		
<small>SIZE A</small>	ISL1002	<small>REV C</small>
<small>FORM FEG041-IS-ASIZE, REV. B</small>		

