

No.	DESCRIPTION
1	CONTACT BOLT
2	O-RING (5.5MM X 1.5)
3	PLUNGER
4	SPRING
5	WIPER
6	BODY
7	O-RING (13.8MM X 2.4)
8	COLLET ASSY
9	SPRING
10	RETAINER
11	O-RING (-020)
12	O-RING (-022)
13	PLUG
14	O-RING (-014)
15	O-RING (6.8MM X 1.9)
16	MANIFOLD PLUG
17	BONDED SEAL M3
18	BREATHER
19	PISTON
20	O-RING (4.87MM X 1.8)
21	SPRING
22	BASE
23	O-RING (17MM X 2.65)
24	WASHER
25	SHCS
26	CAP
27	O-RING (17.0MM X 1.8)
28	RETAINING RING

TOOL LIST	
<input type="checkbox"/>	10mm Open End Wrench
<input type="checkbox"/>	2.5mm Hex Key
<input type="checkbox"/>	27mm Socket

INSTALLATION INSTRUCTIONS

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

A	2727	RELEASE	Two	9/17/14
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY:	N. KARRAS	DRAWING STATUS: Released		
DATE:	05/02/14	PRODUCTION APPROVED FOR RELEASED STATUS ONLY		

ASSEMBLIES AFFECTED
 LI-0412-00H
 LI-0412-00L
 LI-0612-00H
 LI-0612-00L

INSTRUCTION SHEET, WS, 7MPo, CW/BM, FA, 4kN	
SIZE A	ISL1011
REV A	

Read all instructions before disassembly
Refer to the illustration on page 1 for component descriptions and tool list


Disassembly
Model Number L1-0412-00H & L1-0412-00L

1. Using a 27mm socket, unscrew work support from fixture or base (22). Wipe clean to remove external contaminants.
2. Remove O-ring (14) from retainer (10) surface or cavity. Be careful not to damage retainer (11) face.
3. Remove O-ring (12) from fixture or base (22) cavity.
4. With 10mm wrench at plunger (3) and 10mm wrench at contact bolt (1), unscrew contact bolt (1) from plunger (3). Remove O-ring (2) from contact bolt (1).
5. Remove contact spring (4) and washer (24) from inside plunger (3).
6. Insert 2.5mm hex key into piston (19) 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) from inside plunger (3). NOTE: PISTON (19) IS LOOSE AND NO LONGER FASTENED TO THE ASSEMBLY.
7. Remove piston (19) and return spring (21) from inside retainer (10). Remove O-ring (20) from piston (19). CAUTION: RETURN SPRING (21) AND CONTACT SPRING (4) ARE NOT INTERCHANGEABLE
8. Gently slide plunger (3) out from top of work support.
9. Remove wiper (5) from top of body (6). Be careful not to damage wiper bore or bore below wiper (5). To assist holding body (6) during wiper (5) removal, body (6) may be threaded into base (22) or fixture, be careful not to damage the body (6) or retainer (10) face
10. Thoroughly clean contact bolt (1), contact spring (4), plunger (3), cap screw (25), washer (24), piston (19), return spring (21) and set aside to dry.
11. Wipe clean retainer (10) face located on bottom of work support. Wipe clean wiper bore located in body at top of work support.
12. Wipe clean work support cavity in fixture.

Model Number L1-0612-00H & L1-0612-00L

13. Remove work support base (22) from fixture and complete disassembly steps 1-11.
14. If work support hydraulics or vent is manifold fed from fixture, remove O-ring (15) from manifold surface on base (22) mounting face (2 places).
15. If work support hydraulics or vent is not manifold fed, insert 3mm hex key into plug (16) located at base (22) mounting face and unscrew plug (16) (2 places). Remove bonded seal (17) from plug (16)
16. Thoroughly clean base (22), plugs (16) and set aside to dry.

Caution: Do not expose work support clamping mechanism (8) located above retainer (10) to any type of cleaning solutions. Removal of retainer (10) or clamping mechanism (8) terminates product warranty.

		
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INSTRUCTION SHEET, WS, 7MPa, CW/BM, FA, 4kN		
SIZE A	ISL1011	REV A
FORM FEG041-1S-ASIZE, REV. B		

