

Vekttek, Inc. 1334 East Sixth Ave. P.O. Box 625 Emporia, Ks. 66801 U.S.A.	<b>Instruction Sheet</b>	ISMV-	1000		
		REV:	A, I.A.W. ECN 1423		
		BY/DATE:	M Say	01/09/06	
		APPR/DATE:	K. Ratzlaff	2-16-06	
<b>Title Assembly/Disassembly: 33.4 &amp; 55.6 kN Spring Advance Work Supports</b>					

**Read all instructions before disassembly.**

**Refer to the illustrations on page three for component part numbers and a tool list.**

## Disassembly

**Notice: When disassembling multiple work supports, the plunger and body/sleeve assembly from each work support should be kept together.**

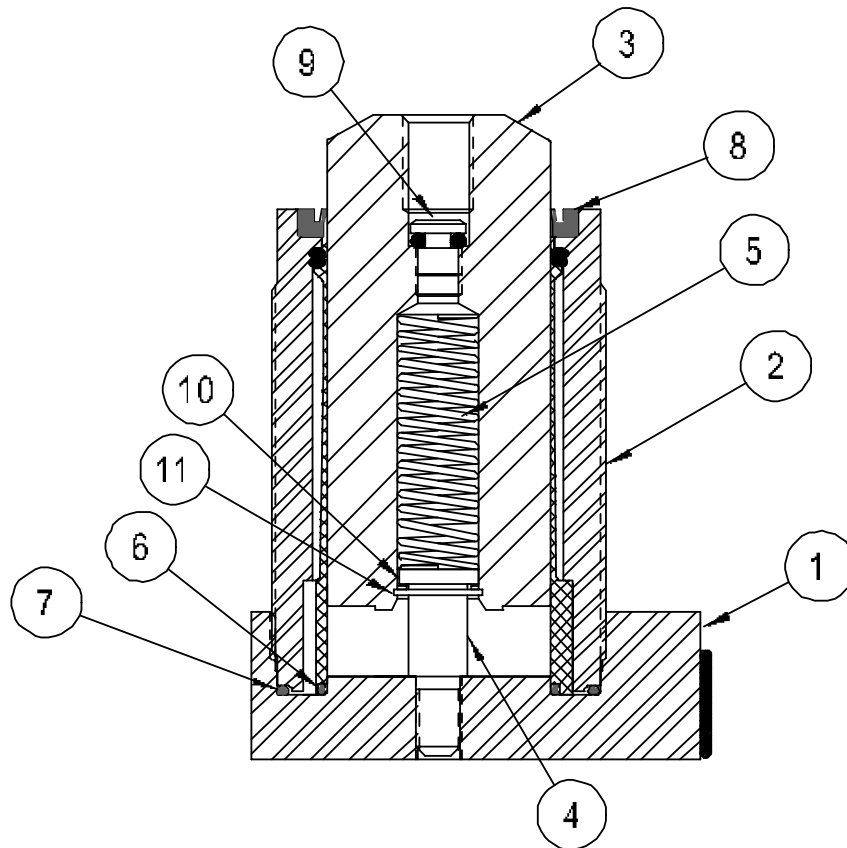
1. Clamp the work support base (1) in a vise.
2. Connect a hydraulic power supply to the work support. Apply hydraulic pressure (approximately 70 bar) to lock the plunger (3) in place.
3. Remove the threaded plug (9) inside the plunger.
4. Release hydraulic fluid pressure and disconnect the hydraulic line.
5. Unthread the body/sleeve assembly (2) and slide it off the plunger.  
**Caution Use a six-point socket only. Other types of wrenches may damage the work support.**
6. Unthread the spring stud (4) and remove the plunger subassembly
7. Remove the retaining ring (11) from the plunger. Slide the spring stud (4) and the spring (5) out of the plunger.
8. Remove the wiper (8) from the body/sleeve assembly. **Caution: Do not scratch the inner sleeve.**
9. Remove the o-rings (6)(7).
10. Clean all parts thoroughly and set aside to dry.

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## Assembly

1. Lubricate all O-rings with clean hydraulic oil. See the Vekttek catalog for hydraulic oil specifications and recommendations.
2. Insert the spring (5) in to the plunger (3). Insert the spring stud (4) in to the plunger. Depress the spring stud to gain access to the retaining ring groove and install the retaining ring (11).
4. Place the O-rings (6)(7) in their respective places in the base (1).
5. Position the plunger subassembly in the base (1) and tighten the spring stud (4) to the torque specification on the parts list.
6. Position the body/sleeve assembly (2) over the plunger (3), press it down to the base and tighten it to the torque specification on the parts list.  
**Note: Make certain the o-rings (6)(7) have not moved out of position.**  
**Caution- Use a six-point socket only. Other types of wrenches may damage the work support.**
7. Connect a hydraulic power supply to the work support. Apply hydraulic pressure (approximately 70 bar) to lock the plunger (3) in place.
8. Install the plug (9) into the threaded hole in the plunger and tighten to the torque specification on the parts list.
9. Release the hydraulic fluid pressure and disconnect the hydraulic line.

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Model Number	Tools needed
41-0050-02	50mm socket (six pt), 1/8 & 3/16 hex keys
41-0050-03	70mm socket (six pt), 1/8 & 3/16 hex keys