

<b>Vektec Inc.</b> 1334 East Sixth Ave. P.O. Box 625 Emporia, Ks. 66801 U.S.A.	<b>Instruction Sheet</b>	IS	1001		
		REV.	A I.A.W. ECN 1352		
		BY/DATE:	M Say	08/01/05	
		APPR/DATE:	R. Hausler	10-4-05	
<b>Title: Disassembly/Assembly Instructions: 4000 Fluid Advance Work Support</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.**

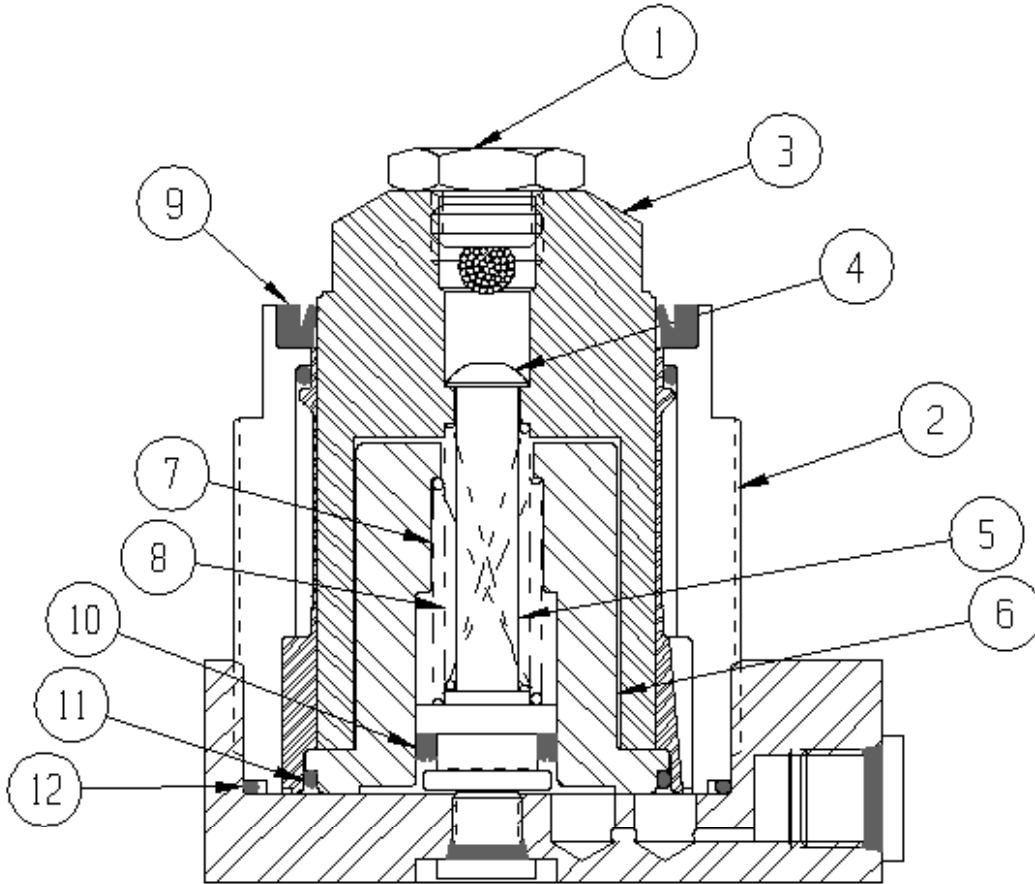
1. Clamp the work support base/feeder cap in a vise. Cartridge mounted work supports must remain in their fixture for steps two and three.
2. Remove the contact bolt (1) from the plunger
3. Remove the body/sleeve assembly (2) from the base/feeder cap, or fixture.  
**Caution- Use a six-point socket only. Other types of wrenches may damage the work support.**
4. Remove the cap screw (4) from the piston (5). A 3/16 hex key inserted in to the bottom of the piston (5) will be needed to keep it from turning with the cap screw.
6. Pull the plunger (3) out of the body/sleeve assembly (2).
7. Remove the retainer (6) and piston (5) from the body/sleeve assembly (2)
8. Remove the springs (7)(8) and the seal (10) from the piston (5).
9. Remove the wiper (9) from the body/sleeve assembly (1). Do not scratch the inner sleeve.
10. Remove the O-rings (11)(12).
11. Clean all parts thoroughly and set aside to dry.

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## Assembly

1. Lubricate all seals and wipers with clean hydraulic oil (Vektek 65-0010-01 or equivalent). Apply Loctite primer N® or equivalent to the contact bolt (1) and the cap screw (4) and allow to dry.
2. Press the new wiper (9) into the body/sleeve assembly (1), using only enough force to seat the wiper in the counterbore. **Caution: Excess force may cause the inner sleeve to collapse.**
3. Insert the plunger (3) in to the body/sleeve assembly (2) from the top and the retainer (6) into the body/sleeve assembly from the bottom.
4. Install the piston seal (10) onto the piston (5) with the open side of the seal toward the bottom end of the piston.
5. Install the springs (7)(8) on the piston (5).
6. Insert the piston (5) and springs in to the retainer (6).
7. Apply Loctite 243® or equivalent to the threads of the cap screw (4) and tighten it to the torque specification on the parts list. A 3/16 hex wrench inserted into the bottom of the piston (3) will be needed to keep it from turning with the cap screw.
8. Insert the O-ring (11) into the groove in the bottom of the retainer (6).
9. Place the O-ring (12) into the bottom of the cavity of the base/feeder cap or cartridge cavity.
10. Carefully screw the work support assembly into the base/feeder cap or cartridge cavity. The assembly will come to a positive stop when it contacts the mating surface. Do not tighten it until it has been determined that the O-ring (12) is in place and that the assembly is in contact with the mating surface. Tighten the assembly to the torque specification on the parts list. **Caution- Use a six-point socket only. Other types of wrenches may damage the work support.**
11. Insert the contact bolt (1) and tighten it to the torque specification on the parts list.

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Model	Tool List
10-0715-05	1/8 & 3/16 hex keys, 3/4 & 1-3/8 open end wrenches, 2 socket (6 pt)