

Vekttek, Inc. 1334 East Sixth Ave. P.O. Box 625 Emporia, Ks. 66801 U.S.A.	Instruction Sheet	IS-	1005		
		REV.	B, I.A.W. ECN1990		
		BY/DATE:	JDW	1-14-09	
		APPR/DATE:	JAM	1-30-09	
TITLE: Disassembly/Assembly: 1000 & 2500 Air Advance Work Supports					

Read all instructions before disassembly

Refer to the illustrations on page three for component 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.

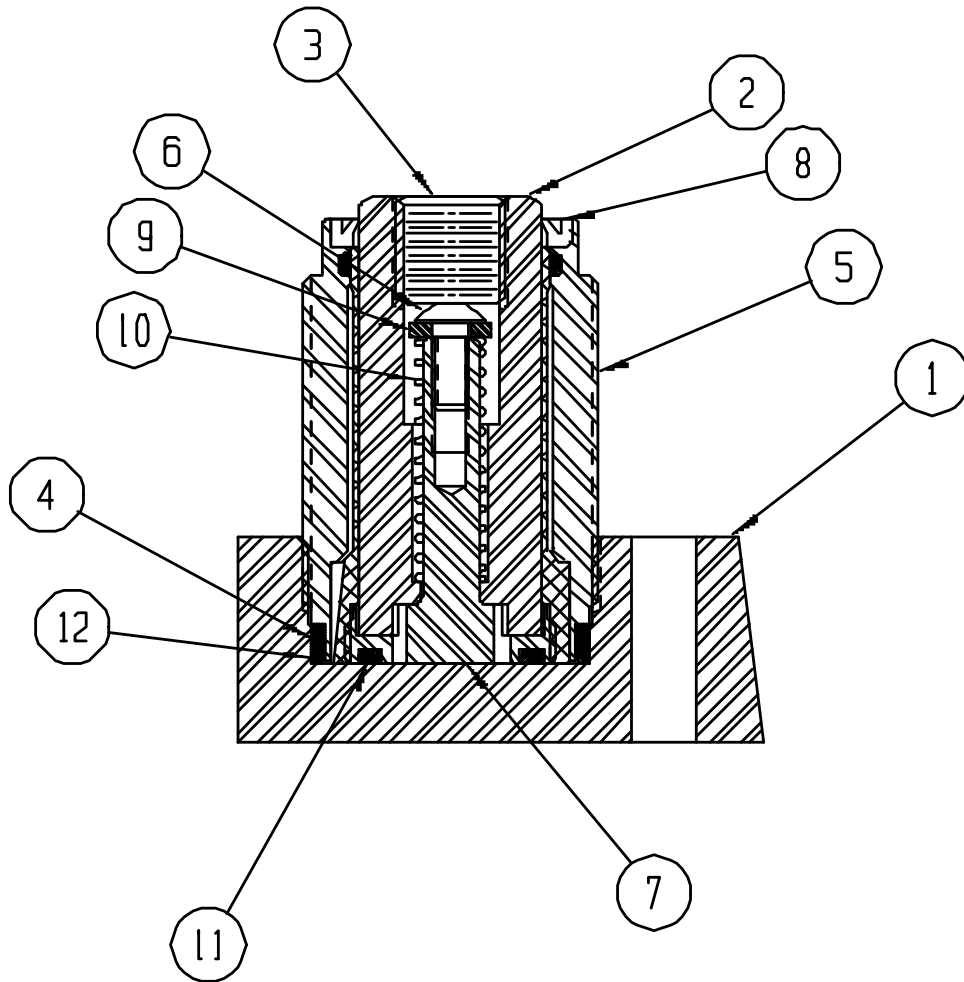
1. Clamp the work support base (1) in a vise. Cartridge mounted work supports must remain in their fixture for steps two and three.
2. Connect a hydraulic power supply to the work support. Apply hydraulic pressure (approximately 1000 psi) to lock the plunger (2) in place.
3. Remove the threaded insert (3) from the plunger (2).
4. Release the pressure and disconnect the hydraulic line.
5. Remove the body/sleeve assembly (2) from the base or fixture.
Caution- Use a six-point socket only. Other types of wrenches may deform the wiper counterbore.
6. Remove all accessible sealing components (4)(11)(12). **Note for 2500 work support only: If new seals were purchased after 3-20-2009 and are being installed the gasket has changed and the metal back-up ring should not be reinstalled.**
7. Remove the cap screw (6), spacer (9) and spring (10) from the plunger.
8. Unthread the retainer (7) from the body/sleeve assembly.
9. Slide the plunger (2) out of the body/sleeve assembly (5)
10. Remove the wiper (8) from the body. **Caution--Do not scratch the inner sleeve.**
11. Clean all parts thoroughly and set aside to dry.

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Assembly

1. Before assembly, lubricate all seals and wipers with clean hydraulic oil (Vekttek 65-0010-01 or equivalent). Apply Loctite primer N® or equivalent to the threaded insert (3) and the cap screw (6) and allow to dry.
2. Press the wiper (8) into the body/sleeve assembly (5), using only enough force to seat the wiper in the counterbore. **Caution: Excess force may cause the inner sleeve to collapse.**
3. Insert the retainer (7) into the plunger (2)
4. Install the spring (10) and spacer (9) onto the retainer. Apply one drop of Loctite 222® or equivalent, to the cap screw (6) and tighten it to the torque specification on the parts list.
5. Insert the plunger/retainer assembly in to the body/sleeve assembly (5) and tighten it to the torque specification on the parts list.
6. Install the O-ring (11) on the retainer (7), and the gasket (4) onto the body/sleeve assembly (5).
7. Place the backup ring (12) into the base (1) or fixture cavity. **Note for 2500 work support only: If new seals were purchased after 3-20-2009 and are being installed the gasket has changed and the metal back-up ring should not be reinstalled.** Insert the work support assembly and tighten it to the torque specification noted on the parts list. **Caution- Use a six-point socket only. Other types of wrenches may deform the wiper counterbore.**
8. Connect the hydraulic power supply to the work support. Apply pressure (approximately 1000 psi) to lock the plunger(2) in place.
9. Apply one drop of Loctite 243® or equivalent to the threaded insert (3) and tighten it to the torque specification on the parts list.
10. Release the pressure and disconnect the hydraulic line.

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Model Number	Tools Required
10060607	5/64 hex key, spanner wrench, screwdriver, 7/8 socket (6 pt)
10060608	5/64 hex key, spanner wrench, screwdriver, 7/8 socket (6 pt)
10060609	5/64 hex key, spanner wrench, screwdriver, 7/8 socket (6 pt)
10060903	3/32 hex key, spanner wrench, screwdriver, 1 1/8 socket (6 pt)
10060904	3/32 hex key, spanner wrench, screwdriver, 1 1/8 socket (6 pt)
10060905	3/32 hex key, spanner wrench, screwdriver, 1 1/8 socket (6 pt)