

Vekttek Inc. 1334 East Sixth Ave. P.O. Box 625 Emporia, Ks. 66801 U.S.A.	Instruction Sheet	IS1012		
		REV.	C I.A.W. ECN2168	
		BY/DATE:	JDW	5-3-10
		APPR/DATE:	JAM	5-20-10
Title: Disassembly/Assembly: 4000 lb & 17 kN Fluid Advance Work Support				

Read all instructions before disassembly

Refer to the illustration on page three for the 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.

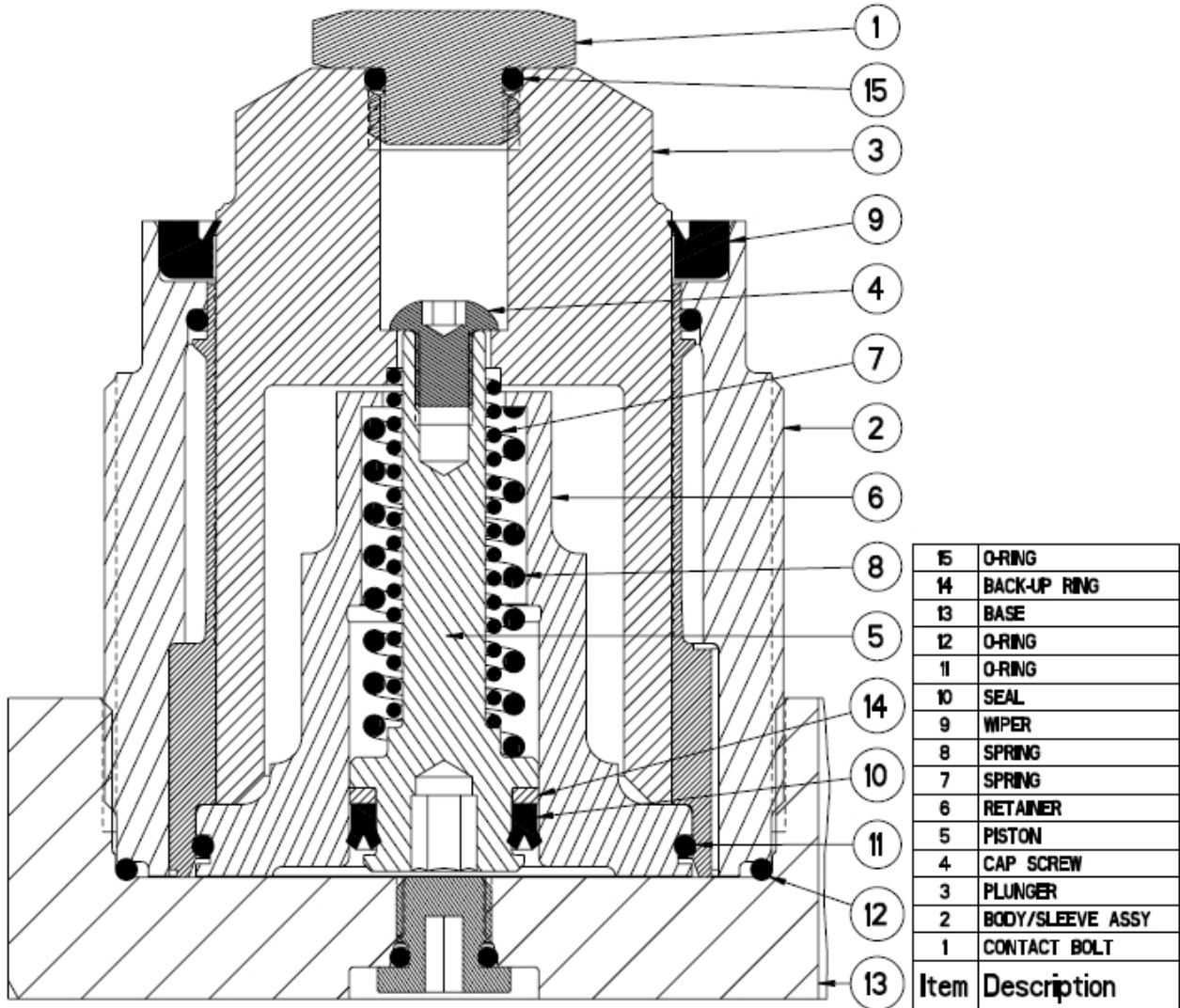
1. Clamp the work support base (13) or feeder cap in a vise. Cartridge mounted work supports should remain in their fixture for step two.
2. Remove the contact bolt (1) from the plunger (3). Remove o-ring (15) from contact bolt (1).
3. Remove the body/sleeve assembly (2) from the base (13), feeder cap 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 into the bottom of the piston (5) will be needed to keep it from turning with the cap screw (4).
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). Remove the seal (10) from the piston (5).
9. Remove the wiper (9) from the body/sleeve assembly (2). **Caution--Do not scratch the inner sleeve of the body/sleeve assembly (2).**
10. Remove the O-ring (12) from base (13), feeder cap or fixture. Remove the O-ring (11) from the retainer (6).
11. Clean all parts thoroughly and set aside to dry.

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Assembly

1. Lubricate the seal (10) and O-rings (11) & (12) with clean hydraulic oil (Vekttek 65-0010-01 or equivalent). Apply Loctite primer N® or equivalent to the threads of the contact bolt (1) and allow to dry.
2. Press the new wiper (9) into the body/sleeve assembly (2). Use only enough force to seat the wiper into the counterbore. **Caution--Excess force may cause the inner sleeve to collapse.**
3. Install the O-ring (11) into the groove of the retainer (6).
4. Insert the retainer (6) into the body/sleeve assembly (2) from the bottom. Insert the plunger (3) into the body/sleeve assembly (2) from the top.
5. Install the seal (10) onto the piston (5) with the open side of the seal toward the bottom end of the piston (5).
6. Install the springs (7) & (8) onto the piston (5).
7. Insert the piston (5) and springs (7) & (8) into the retainer (6).
8. Screw the cap screw (4) into the piston (5). Tighten to the torque specification on the parts list. A 3/16 hex wrench inserted into the bottom of the piston (5) will be needed to keep the piston (5) from turning with the cap screw (4).
9. Place the O-ring (12) into the bottom of the cavity in the base (13), feeder cap or fixture.
10. Screw the work support assembly into the base (13), feeder cap or fixture. The assembly will come to a positive stop when it contacts the mating surface. Tighten 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. Install o-ring (15) onto contact bolt (1). Apply medium strength Loctite 243® or equivalent to the threads of the contact bolt (1) and screw the contact bolt (1) into the plunger (3). Tighten to the torque specification on the parts list.

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Model Number	Tool List
10071506 10081505 10081506	1/8 & 3/16 hex keys, 3/4 & 1-3/8 open end wrenches, 2 socket (6 pt)
41007105 41007005 6964H-17-1 6964H-17-2	1/8 & 3/16 hex keys, 18mm & 19mm open end wrenches, 30mm socket (6 pt)