


33	WIPER,PRESS-IN, (1-1/4)
32	WASHER
31	WASHER
30	STUD, WS, DA, CGS, 5500
29	SPRING, COMPRESSION
28	SPRING, COMPRESSION
27	SPRING, COMPRESSION
26	SLEEVE, WS, DA, CGS, 5500
25	SEAL,T, (1-7/8X1/8X2-1/8)
24	SEAL, BEVEL, 1 7/8 X 1/8 X 2 1/8
23	SCREW, CAP, SOCH, 1/4-28 X 5/8, ALY
22	SCREW, CAP, SOCH, 5/16-24 X 1/2, ALY, SLFLKG
21	BU RING, (-225)
20	BU RING, (-033)
19	RETAINER, SLEEVE, WS, DA, CGS, 5500
18	WASHER
17	RETAINER, PISTON, WS, DA, CGS, 5500
16	PLUNGER, WS, DA, CGS, RPS, 5500
15	PISTON, SHUTTLE, WS, DA, CGS, 5500
14	PIN, SPRING, COIL TYPE, 3/32 X 3/8, SST
13	O-RING, (61mm x 1.5)
12	O-RING, (51mm x 1.5)
11	O-RING, (5-142)
10	O-RING, (-906)
9	O-RING, (-033)
8	O-RING, (-029)
7	O-RING, (-016)
6	HOUSING, RPS, WS, DA, CGS, 5500
5	CAP, HOUSING, WS, DA, CGS, RPS
4	CAP, BODY, WS, DA, CGS, 5500
3	BOLT, CONTACT, WS, DA, CGS, 5500
2	BODY, WS, DA, CGS, TF, RPS, 5500
1	BALL, STEEL, ALLOY, .250
No.	DESCRIPTION

MODEL NUMBER	TOOL LIST
10-0212-01 10-0212-01F	7/16, 1 & 1 1/8 wrenches 5/32, 3/16 & 1/4 hex key 1/4 socket, 11/16 deep well socket

INSTALLATION INSTRUCTIONS	 VEKTEK <small>VEKTEK, INC. 1334 E. SIXTH AVE. P.O. BOX 625 EMPORIA, KS. 66801 U.S.A.</small>
	INSTRUCTION SHEET, WS, DA, CGS, TF, RPS, 5500 ***** SIZE A 1S1018 REV B

B	2785	RELEASE	MAJ	1-26-15
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY:	ALUTHI	DRAWING STATUS: Released PRODUCTION APPROVED FOR RELEASED STATUS ONLY		
DATE:	8-12-10			

ASSEMBLIES AFFECTED
10-0212-01
10-0212-01F

SIZE A	1S1018	REV B
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READ ALL INSTRUCTIONS BEFORE DISASSEMBLY


REFER TO THE ILLUSTRATION ON PAGE ONE FOR COMPONENT NUMBERS AND TOOL LIST

DISASSEMBLY

1. Remove return position sensor housing (6) using 5/32" hex key to remove the 3 SHCS. Remove the housing cap (5) using 1/4" socket and remove spring (29), washer (31) and ball (1). Remove o-rings (12) and (13) and press out wiper (33).
2. Clamp work support body (2) in vise and using 3/16" hex key remove SHCS (24) from bottom cap (4). Remove bottom cap (4) from body (2) and remove o-ring (9) and back-up ring (20).
3. Slide shuttle piston (15) sub-assembly out of body (2). Remove back-up ring (21), and bevel seal (22) from body (2). Remove T-seal (23) from shuttle piston (15).
4. Using 1" and 1 1/8" wrenches remove contact bolt (3) from plunger (16), remove spring (28) and o-ring (7).
5. Clamp shuttle piston (15) in vise clamping on the flats near the bottom. Remove SHCS (25) and washer (32), plunger can now be removed.
6. Using 11/16" deep well socket remove stud (30) from piston retainer (17) and remove o-ring (10) from stud. Remove spring (27), washer (18), and ball (1).
7. Using small flat blade screw driver, remove wiper (33) from shuttle piston (15). CAUTION: DO NOT DAMAGE INSIDE OF SLEEVE (26) OR SLEEVE RETAINER (19).
8. DO NOT REMOVE SLEEVE RETAINER (19) OR PISTON RETAINER (17) FROM SHUTTLE PISTON (15). DOING SO WILL VOID PRODUCT WARRANTY!
9. Clean all parts thoroughly and set aside to dry.

ASSEMBLY

1. Lubricate o-rings (7), (9), (10), (12) & (13), T-seal (23), bevel seal (22) and back-up rings (20) & (21) with clean hydraulic oil (Vektek 65-0010-01 or equivalent). Apply Loctite® primer N or equivalent to the threads of contact bolt (3), then allow to dry.
2. Install ball (1), washer (18), spring (27) into piston retainer (17) through top of shuttle piston (15). Install o-ring (10) on SAE 6 boss of stud (30). Torque stud into piston retainer, 30 ft-lb.
3. Press wiper (33) into top of shuttle piston (15) using only enough force to seat wiper into counterbore. CAUTION: EXCESS FORCE MAY CAUSE DAMAGE TO WIPER.
4. Slide plunger (16) into sleeve (26). Install washer (32) and SHCS (25), torque to 25 ft-lb. Install spring (28) into plunger (16). Install o-ring (7) onto contact bolt (3) and apply medium strength Loctite® (blue) to threads. Thread contact bolt (3) into plunger (16) and torque to 30 ft-lb. Plunger should freely move up and down in sleeve without binding or dragging. Spring force should return plunger to full stroke without sticking.
5. Install T-seal (23) onto shuttle piston (15) with round bulb facing out. Install back-up rings on each side of T-seal bulb. Make sure back-up rings are seated.
6. Install bevel seal (22) into body (2) with lips facing piston bore, push to bottom of groove, then install back-up ring (21). Make sure seals are not rolled.
7. Slide shuttle piston (15) subassembly into body (2) bore. Shuttle piston should slide smoothly up and down in bore.
8. Install back-up ring (20) and o-ring (9) onto cap (4). Install cap (4) into body (2) with holes in proper orientation. Apply anti-seize to threads of SHCS (24), insert through cap and thread into body. Torque to 16 ft-lb using a criss-cross pattern.
9. Press wiper (33) into top of return position sensor housing (6). Install ball (1), washer (31) and spring (29) into housing (6). Install housing cap (5) and tighten. Install o-rings (12) and (13) onto bottom side of housing (6). Install housing sub-asm onto body (2), insert SHCS and torque to 50 in-lb.

		
VEKTEK, INC. 1334 E. SIXTH AVE. P.O. BOX 625 EMPORIA, KS. 66801 U.S.A.		
INSTRUCTION SHEET, WS, DA, CGS, TF, RPS, 5500 *****		
SIZE A	IS1018	REV B
FORM FEG035_PL_ASIZE, REV. B		