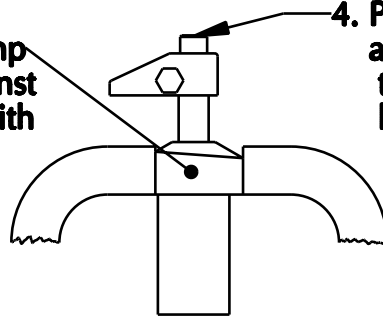


CAUTION: Single Acting swing clamps (15-1105-00, 15-1109-00, 15-1113-00, 15-0105-00, 15-0109-08, 15-1113-11 and 15-0118-00 contain springs that apply force against the retainer. Loosening the retainer beyond the first full thread may result in the retainer being forced out of the body.

3. Reposition the swing clamp in the vise, clamping against the flat face of the port, with the arm above the body.



4. Push downward on the plunger, allowing it to follow the ball track until it reaches the bottom of its stroke.

NOTE: Single Acting swing clamp springs exert considerable force on the retainer when compressed to the bottom of their stroke. For example, model 15-0113-11 will exert 60-80 pounds of force in this position. It may be helpful to use a manual arbor press to overcome the spring force. If this method is used, make sure that the plunger can rotate freely and that the swing clamp body is kept from slipping or turning.

5. Double Acting units- With the plunger in its bottomed position, rotate it and pull upward on the plunger until it slips into the selected ball track.

Single Acting units(spring loaded)- With the plunger held near its bottom position, rotate the plunger until it slips into the selected ball track, at which point the spring will cause the plunger to move upward, rapidly. Continue applying force to the plunger and allow it to move slowly upward until it reaches its uppermost position.

NOTE- When changing rotation from right to left or left to right, the plunger may have to be rotated past the center ball track that provides for straight line clamping.

6. Reposition the swing clamp in the vise as shown in step one. Tighten the retainer to the torque settings listed below.

15-XX05-XX	15-XX09-XX	15-XX13-XX	15-XX18-XX
13 ft lb	13 ft lb	13 ft lb	13 ft lb

WARNING!

Never allow Swing Clamp arms to contact the workpiece or fixture during arm rotation. At operating pressure, this contact may cause damage to the rotating mechanism. To check arm clearance and position, operate the swing clamps through several cycles at low pressure. For short arms, the clamping time should not be less than one half(.50) second. For long arms, the clamping time should not be less than one(1) second.

INSTALLATION INSTRUCTIONS



VEKTEK, INC.
1334 E. SIXTH AVE. P.O. BOX 625
EMPORIA, KS. 66801 U.S.A.

A	1328	RELEASE	MES	06/03/05
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY:	MES	DRAWING STATUS: Released		
DATE:	06/03/05	PRODUCTION APPROVED FOR RELEASED STATUS ONLY		

ASSEMBLIES AFFECTED

SC OPERATING INSTRUCTIONS

SIZE	IS1511	REV
A		A

FORM FEG041-1S-ASIZE, REV. A

SHEET 2 OF 2