


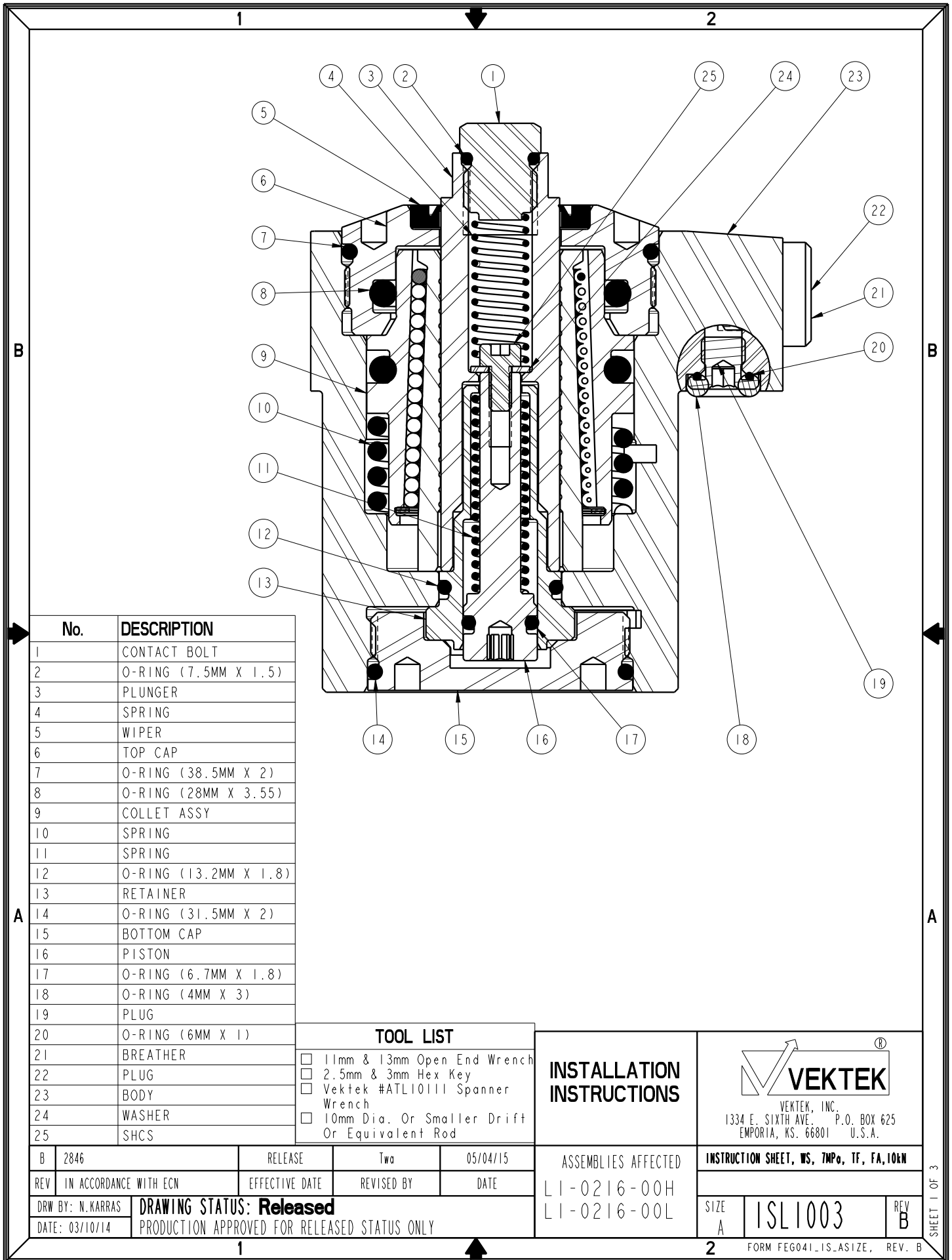
NO	QTY	PART NO	DESCRIPTION	STD SEAL KIT	LIGHT SPRING KIT	HEAVY SPRING KIT
1	1	23350089	SPRING, COMPRESSION		X	X
2	1	23350091	SPRING, COMPRESSION			X
3	2	39051079	O-RING, (6mm X 1)	X		
4	2	39051087	O-RING, (4mm X 3)	X		
5	1	39051089	O-RING, (31.5mm x 2)	X	X	X
6	1	39051090	O-RING, (6.7mm x 1.8)	X	X	X
7	1	39051091	O-RING, (7.5mm x 1.5)	X	X	X
8	1	39051094	O-RING, (13.2mm x 1.8)	X		
9	1	39053048	WIPER, PRESS-IN, 16mm	X		
10	1	81000000	CONTACT BOLT, WS, 7MPa, 5.5 & 10kN			
11	2	81400200	PLUG, MANIFOLD, 7MPa, M6			
12	1	23350090	SPRING, COMPRESSION		X	
N/A	N/A	L6010005	KIT, SEAL, WS, 7MPa, TF, FA, 10kN	NOTED	N/A	N/A
N/A	N/A	L6110008	KIT, SPRING, WS, 7MPa, TF, FA, 10kN	N/A	NOTED	N/A
N/A	N/A	L6110009	KIT, SPRING, WS, 7MPa, TF, FA, 10kN	N/A	N/A	NOTED
N/A	N/A	ISL1003	INSTRUCTION SHEET, WS, 7MPa, TF, FA, 10kN	N/A	N/A	N/A

See Instruction Sheet ISL1003 For Service Instructions.  
 Lubricate All Seals With Clean Hydraulic Oil Prior To Assembly.  
 Do Not Use Silicone Base Lubricants.



<b>PARTS LIST</b>	 VEKTEK, INC. 1334 E. SIXTH AVE. P.O. BOX 625 EMPORIA, KS. 66801 U.S.A.	
	PARTS LIST, ASSY, WS, 7MPa, TF, FA, 10kN	
ASSEMBLIES AFFECTED	L1-0216-00H	L1-0216-00L
SIZE A	LPL1003	
		REV C

C	3849	RELEASE	MJUST	7/8/19
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY:	N. KARRAS	<b>DRAWING STATUS: Released</b>		
DATE:	03/21/14	PRODUCTION APPROVED FOR RELEASED STATUS ONLY		



No.	DESCRIPTION
1	CONTACT BOLT
2	O-RING (7.5MM X 1.5)
3	PLUNGER
4	SPRING
5	WIPER
6	TOP CAP
7	O-RING (38.5MM X 2)
8	O-RING (28MM X 3.55)
9	COLLET ASSY
10	SPRING
11	SPRING
12	O-RING (13.2MM X 1.8)
13	RETAINER
14	O-RING (31.5MM X 2)
15	BOTTOM CAP
16	PISTON
17	O-RING (6.7MM X 1.8)
18	O-RING (4MM X 3)
19	PLUG
20	O-RING (6MM X 1)
21	BREATHER
22	PLUG
23	BODY
24	WASHER
25	SHCS

TOOL LIST	
<input type="checkbox"/>	11mm & 13mm Open End Wrench
<input type="checkbox"/>	2.5mm & 3mm Hex Key
<input type="checkbox"/>	Vekttek #ATL10111 Spanner Wrench
<input type="checkbox"/>	10mm Dia. Or Smaller Drift Or Equivalent Rod

**INSTALLATION INSTRUCTIONS**

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

B	2846	RELEASE	Two	05/04/15
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY:	N. KARRAS	<b>DRAWING STATUS: Released</b>		
DATE:	03/10/14	PRODUCTION APPROVED FOR RELEASED STATUS ONLY		

ASSEMBLIES AFFECTED  
L1-0216-00H  
L1-0216-00L

INSTRUCTION SHEET, WS, 7MPo, TF, FA, 10&N	
SIZE A	ISL1003
REV B	


Read all instructions before disassembly

Refer to the illustration on page 1 for component part numbers and tool list

### Disassembly


1. Remove work support from fixture. Wipe clean to remove external contaminants.
2. With 13mm wrench at plunger (3) and 11mm wrench at contact bolt (1), unscrew contact bolt (1) from plunger (3). Remove O-ring (2) from contact bolt (1).
3. Remove contact spring (4) from inside plunger (3).
4. Clamp work support body (23) in vise with bottom side facing up.
5. Using Vektek #ATL10111 spanner wrench unscrew bottom cap (15) from work support body (23). Remove O-ring (14) from bottom cap (15).
6. Remove work support body (23) from vise. Insert 3mm hex key into piston (16) from bottom of work support to prevent turning. Insert 2.5mm hex key into cap screw (25) inside plunger (3) and unscrew cap screw (25). Remove cap screw (25) and washer (24) from inside plunger (3). NOTE: PISTON (16) IS LOOSE AND NO LONGER FASTENED TO THE ASSEMBLY.
7. Remove piston (16) and return spring (11) from inside retainer (13). Remove O-ring (17) from piston (16). CAUTION: RETURN SPRING (11) AND CONTACT SPRING (4) ARE NOT INTERCHANGEABLE, NOTE LOCATION AND KEEP SEPARATE FOR REASSEMBLY.
8. Gently slide plunger (3) out from top of work support.
9. Remove wiper (5) from top cap (6). Be careful not to damage wiper bore or bore below wiper (5).
10. From top of work support place drift or equivalent rod on top of retainer (13) and push downward till retainer (13) comes free from body (23). Remove retainer (13) from body (23). Remove O-ring (12) from retainer (13).
11. If work support hydraulics or vent is manifold fed from fixture, remove O-ring (18) from manifold s'face on work support body (23) mounting flange (2 places).
12. If work support hydraulics or vent is not manifold fed, insert 3mm hex key into plug (19) located at work support body (23) mounting flange and unscrew plug (19) (2 places). Remove O-ring (20) from plug (19).
13. Thoroughly clean contact bolt (1), contact spring (4), plunger (3), cap screw (25), washer (24), retainer (13), bottom cap (15), piston (16), plugs (19), return spring (11) and set aside to dry.
14. Wipe clean bottom cap seal bore and retainer seal bore located in bottom of body (23). Wipe clean wiper bore located in top cap (6) at top of work support. Wipe clean manifold s'face located on body (23) mounting flange.

**Caution: Do not expose work support clamping mechanism (9) located underneath the top cap (6) to any type of cleaning solutions. Removal of top cap (6) or clamping mechanism (9) terminates product warranty.**

		
<small>VEKTEK, INC. 1334 E. SIXTH AVE. P.O. BOX 625 EMPORIA, KS. 66801 U.S.A.</small>		
<small>INSTRUCTION SHEET, WS, 7MPo, TF, FA, 10&amp;N</small>		
<small>SIZE A</small>	<b>ISL1003</b>	<small>REV B</small>
<small>FORM FEG041-IS-ASIZE, REV. B</small>		

## Assembly

1. Lubricate new O-rings (2), (12), (14), (17), (18), (20) and outside diameter of new wiper (5) with clean hydraulic oil (Vektek 65-0010-01 or equivalent). Also, apply light film of hydraulic oil to outside surface of plunger (3)
2. Press wiper (5) into top cap (6) taking extra care to install squarely without excess force. CAUTION: IMPROPER INSTALLATION COULD DAMAGE WIPER (5) CAUSING EXCESS WIPER DRAG.
3. Install O-ring (12) onto retainer (13).
4. Install retainer (13) into bore through bottom of body (23). For proper install depth retainer (13) should shoulders against body (23).
5. Gently install plunger (3) into work support through wiper (5) taking care not to damage wiper (5). Plunger (3) should move freely without binding. Lightly push plunger (3) downward until bottoms.
6. Install O-ring (17) onto piston (16).
7. Slide return spring (11) onto piston (16) and insert piston (16) and return spring (11) into retainer (13) bore. Insert 3mm hex key into piston (16) and push inward to compress return spring (11). While holding piston (16) and return spring (11) in compressed position place washer (24) onto cap screw (25) and drop thread side down into hole through top of plunger (3). Insert 2.5mm hex key into cap screw (25) and torque to 2.5 N-m (20 in-lb). CAUTION: CONTACT SPRING (4) AND RETURN SPRING (11) ARE NOT INTERCHANGEABLE.
8. Install O-ring (14) onto bottom cap (15)
9. Clamp work support body (23) into vise with bottom side facing up.
10. Screw bottom cap (15) into bottom of work support body (23). Using Vektek #ATL10111 spanner wrench torque bottom cap (15) to 55 N-m (40 ft-lb).
11. Remove work support body (23) from vise and position with plunger (3) upward. Insert contact spring (4) into hole through top of plunger (3). Contact spring (4) will pilot onto cap screw (25).
12. Install O-ring (2) onto contact bolt (1).
13. Screw contact bolt (1) into top of plunger (3). With 13mm wrench at plunger (3) and 11mm wrench at contact bolt (1) torque to 9 N-m (80 in-lb).
14. If work support hydraulics or vent is manifold fed from fixture, install new O-ring (18) into manifold surface on work support body (23) mounting flange (2 places).
15. If work support hydraulics or vent is not manifold fed, install O-ring (20) onto plug (19), insert 3mm hex key into plug (19) and torque to 3 N-m (25 in-lb) (2 places).

		
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INSTRUCTION SHEET, WS, TWP, TF, FA, 10&N		
SIZE A	ISL1003	REV B

FORM FEG041-IS-ASIZE, REV. B

SHEET 3 OF 3