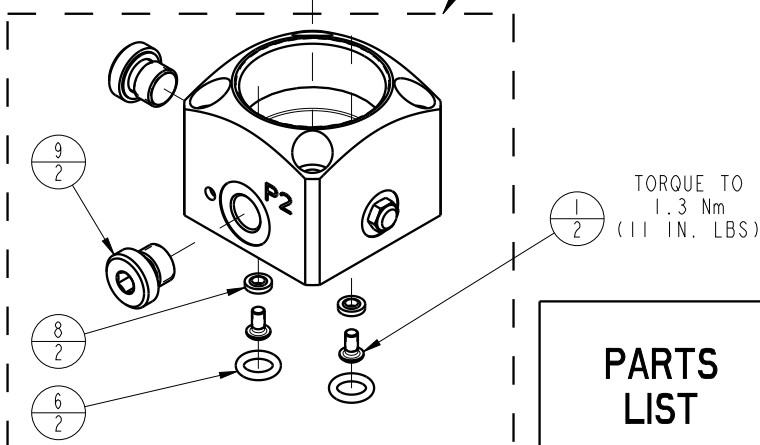
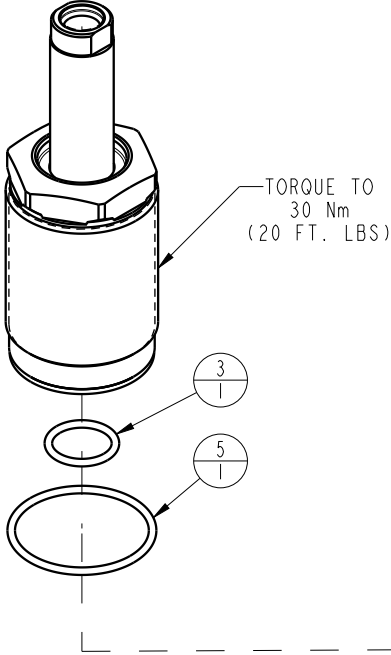
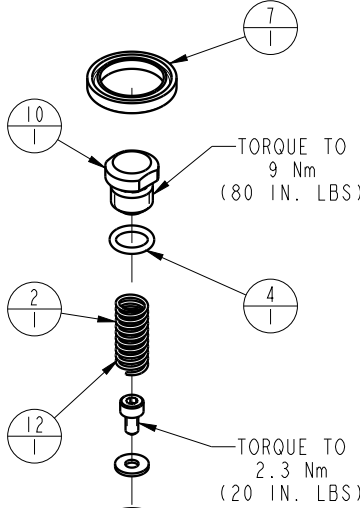


NO	QTY	PART NO	DESCRIPTION	STD SEAL KIT	LIGHT SPRING KIT	HEAVY SPRING KIT
1	2	21500019	SCREW, CAP, BTNH, M3 X 6, ALY			
2	1	23350096	SPRING, COMPRESSION			X
3	1	39000035	O-RING, (-015)	X		
4	1	39051091	O-RING, (7.5mm x 1.5)	X	X	X
5	1	39051104	O-RING, (-026)	X		
6	2	39051116	O-RING, (6.8mm X 1.9)	X		
7	1	39053049	WIPER, PRESS-IN, 15mm	X		
8	2	39055011	SEAL, BONDED, M3			
9	2	43068004	PLUG, SOCH, G1/8			
10	1	81000000	CONTACT BOLT, WS, 7MPa, 5.5 & 10kN			
11	1	91000041	BASE, WS, 7MPa, 5.5kN			
12	1	23350095	SPRING, COMPRESSION		X	
N/A	N/A	L6010000	KIT, SEAL, WS, 7MPa, CM/BM, 5.5kN	NOTED	N/A	N/A
N/A	N/A	L6110000	KIT, SPRING, WS, 7MPa, SPR, 5.5kN	N/A	NOTED	N/A
N/A	N/A	L6110001	KIT, SPRING, WS, 7MPa, SPR, 5.5kN	N/A	N/A	NOTED
N/A	N/A	ISL1004	INSTRUCTION SHEET, WS, 7MPa, CM/BM, SPR, 5.5kN	N/A	N/A	N/A

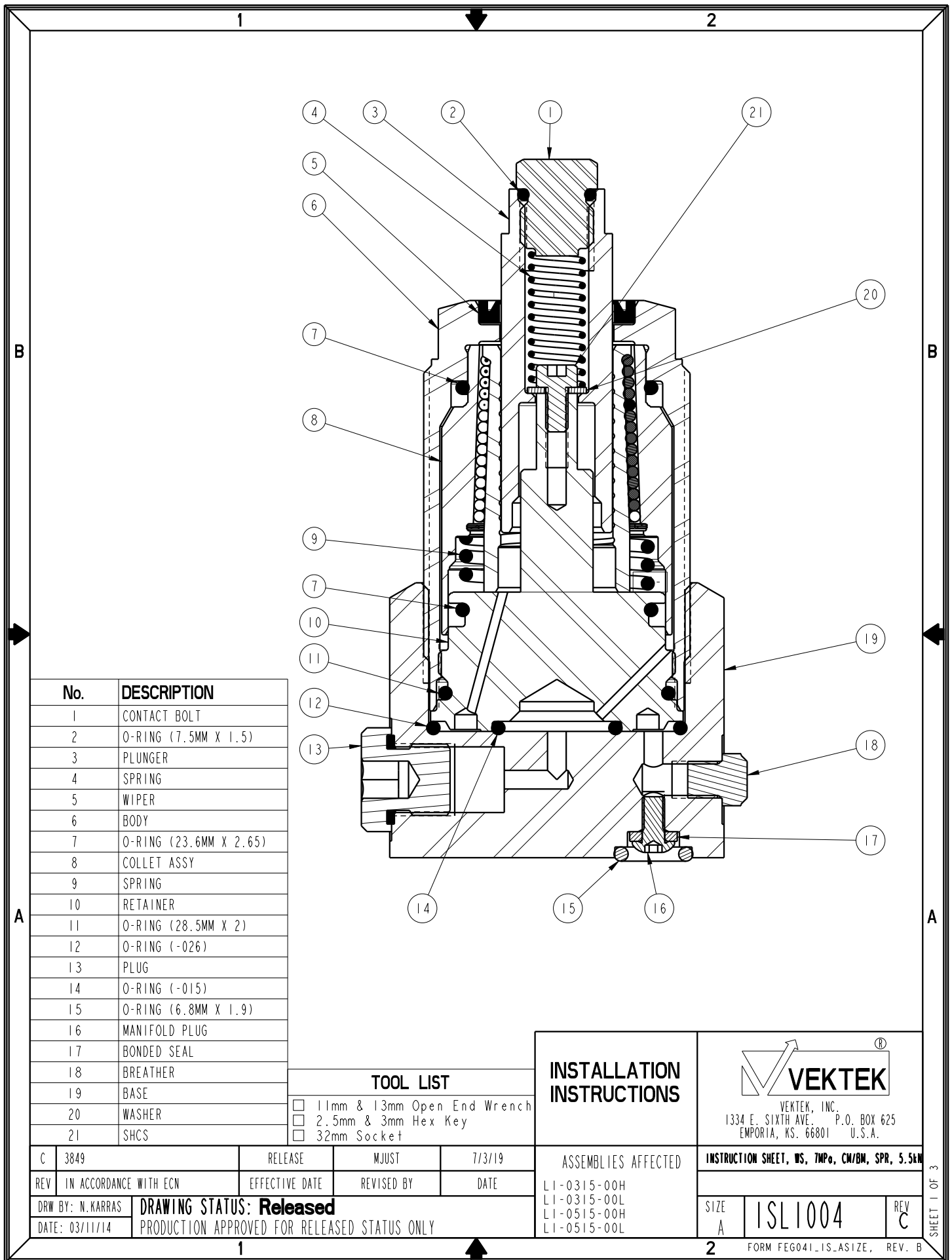


See Instruction Sheet ISL1004 For Service Instructions.
 Lubricate All Seals With Clean Hydraulic Oil Prior To Assembly.
 Do Not Use Silicone Base Lubricants.



PARTS LIST	
	VEKTEK, INC. 1334 E. SIXTH AVE. P.O. BOX 625 EMPORIA, KS. 66801 U.S.A.
ASSEMBLIES AFFECTED L1-0515-00H L1-0515-00L	PARTS LIST, ASSY, WS, 7MPa, BM, SPR, 5.5kN
SIZE A	LPL1008
	REV C

C	3849	RELEASE	MJUST	7/2/19
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY:	N. KARRAS	DRAWING STATUS: Released		
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	BODY
7	O-RING (23.6MM X 2.65)
8	COLLET ASSY
9	SPRING
10	RETAINER
11	O-RING (28.5MM X 2)
12	O-RING (-026)
13	PLUG
14	O-RING (-015)
15	O-RING (6.8MM X 1.9)
16	MANIFOLD PLUG
17	BONDED SEAL
18	BREATHER
19	BASE
20	WASHER
21	SHCS

TOOL LIST	
<input type="checkbox"/>	11mm & 13mm Open End Wrench
<input type="checkbox"/>	2.5mm & 3mm Hex Key
<input type="checkbox"/>	32mm Socket

INSTALLATION INSTRUCTIONS

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

C	3849	RELEASE	MJUST	7/3/19
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY:	N. KARRAS	DRAWING STATUS: Released		
DATE:	03/11/14	PRODUCTION APPROVED FOR RELEASED STATUS ONLY		

ASSEMBLIES AFFECTED
LI-0315-00H LI-0315-00L LI-0515-00H LI-0515-00L

INSTRUCTION SHEET, WS, 7MPo, CW/BM, SPR, 5.5kN	
SIZE A	ISL1004
REV C	

Read all instructions before disassembly

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

Disassembly


Model Number L1-0315-00H & L1-0315-00L

1. Using a 32mm socket, unscrew work support from fixture or base (19). Wipe clean to remove external contaminants.
2. Remove O-ring (14) from retainer (10) surface or cavity (19). Be careful not to damage retainer (10) face.
3. Remove O-ring (12) from fixture or base cavity.
4. 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).
5. Remove contact spring (4) from inside plunger (3).
6. Insert 2.5mm hex key into cap screw (21) inside plunger (3) and unscrew cap screw (21). Remove cap screw (21) and washer (20) from inside plunger (3).
7. Gently slide plunger (3) out from top of work support.
8. Remove wiper (5) from top of body (6). Be careful not to damage wiper bore or bore below wiper (5). To assist holding body (6) during wiper (5) removal, body (6) may be threaded into base (19) or fixture, be careful not to damage the body (6) or retainer face (10).
9. Thoroughly clean contact bolt (1), contact spring (4), plunger (3), cap screw (21), washer (20) and set aside to dry.
10. Wipe clean retainer (10) face located on bottom of work support. Wipe clean wiper bore located in body at top of work support.
11. Wipe clean work support cavity in fixture.

Model Number L1-0515-00H & L1-0515-00L

13. Remove work support base (19) from fixture and complete disassembly steps 1-10.
14. If work support hydraulics or vent is manifold fed from fixture, remove O-ring (15) from manifold surface on base mounting face (2 places).
15. If work support hydraulics or vent is not manifold fed, insert 3mm hex key into plug (16) located at base (19) mounting face and unscrew plug (16) (2 places). Remove bonded seal (17) from plug (16).
16. Thoroughly clean base (19), plugs (16) and set aside to dry.

Caution: Do not expose work support clamping mechanism (8) located above retainer (10) to any type of cleaning solutions. Removal of retainer (10) or clamping mechanism (8) terminates product warranty.

		
VEKTEK, INC. 1334 E. SIXTH AVE. P.O. BOX 625 EMPORIA, KS. 66801 U.S.A.		
INSTRUCTION SHEET, WS, TWPo, CW/BM, SPR, 5.5kN		
SIZE A	ISL1004	REV C
FORM FEG041-1S.ASIZE, REV. B		

1

2


Assembly

Model Number L1-0315-00H & L1-0315-00L

1. Lubricate new O-rings (2),(12),(14) 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 of body (6) taking extra care to install squarely without excess force. CAUTION: IMPROPER INSTALLATION COULD DAMAGE WIPER (5) CAUSING EXCESS WIPER DRAG.
3. 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.
4. Install washer (20) onto cap screw (21) and drop thread side down into hole through top of plunger (3). Insert 2.5mm hex key into cap screw (21) and tighten washer (20) and screw to 2.5 N-m (20 in-lb).
5. Insert contact spring (4) into hole through top of plunger (3). Contact spring (4) will pilot onto cap screw (21).
6. Install O-ring (2) onto contact bolt (1).
7. 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).
8. Install O-ring (14) into retainer (10) s-face.
9. Install O-ring (12) into bottom of fixture cavity.
10. Using 32mm socket, screw work support into fixture cavity. Torque to 40 n-m (30 ft-lb).

Model Number L1-0515-00H & L1-0515-00L

12. Complete assembly steps 1-8.
13. Install O-ring (12) into bottom of base (19) cavity.
14. Using 32mm socket, screw work support into base (19) cavity. Torque to 40 N-m (30 ft-lb).
15. If work support hydraulics or vent is manifold fed from fixture, install new O-ring (15) into manifold s'face on base mounting face (2 places).
16. If work support hydraulics or vent is not manifold fed, install bonded seal (17) onto plug (16), insert 3mm hex key into plug (16) and torque to 3 N-m (25 in-lb) (2 places).

		
VEKTEK, INC. 1334 E. SIXTH AVE. P.O. BOX 625 EMPORIA, KS. 66801 U.S.A.		
INSTRUCTION SHEET, WS, 7MPo, CW/BM, SPR, 5.5km		
SIZE A	ISL1004	REV C
FORM FEG041-1S-ASIZE, REV. B		

SHEET 3 OF 3