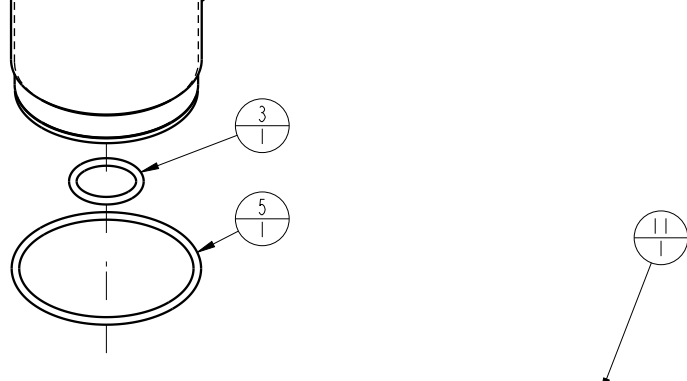
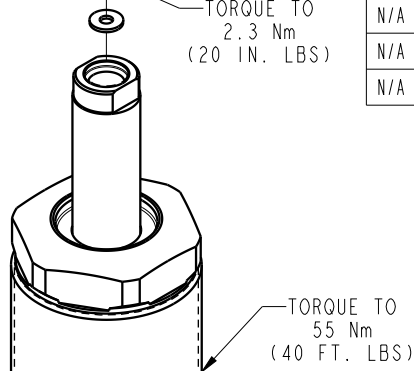
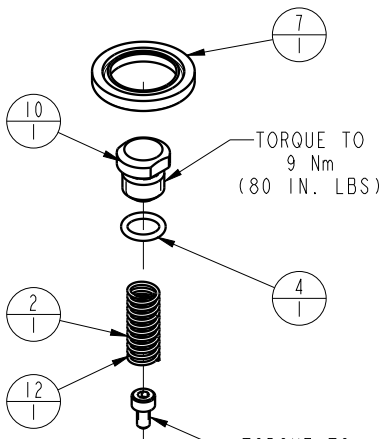



NO	QTY	PART NO	DESCRIPTION	STD SEAL KIT	LIGHT SPRING KIT	HEAVY SPRING KIT
1	2	21500019	SCREW, CAP, BTNH, M3 X 6, ALY			
2	1	23350091	SPRING, COMPRESSION			X
3	1	39000035	O-RING, (-015)	X		
4	1	39051091	O-RING, (7.5mm x 1.5)	X	X	X
5	1	39051099	O-RING, (-030)	X		
6	2	39051116	O-RING, (6.8mm X 1.9)	X		
7	1	39053048	WIPER, PRESS-IN, 16mm	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	91000040	BASE, WS, 7MPa, 10kN			
12	1	23350090	SPRING, COMPRESSION		X	
N/A	N/A	L6010001	KIT, SEAL, WS, 7MPa, CM/BM, 10kN	NOTED	N/A	N/A
N/A	N/A	L6110002	KIT, SPRING, WS, 7MPa, SPR, 10kN	N/A	NOTED	N/A
N/A	N/A	L6110003	KIT, SPRING, WS, 7MPa, SPR, 10kN	N/A	N/A	NOTED
N/A	N/A	ISL1005	INSTRUCTION SHEET, WS, 7MPa, CM/BM, SPR, 10kN	N/A	N/A	N/A



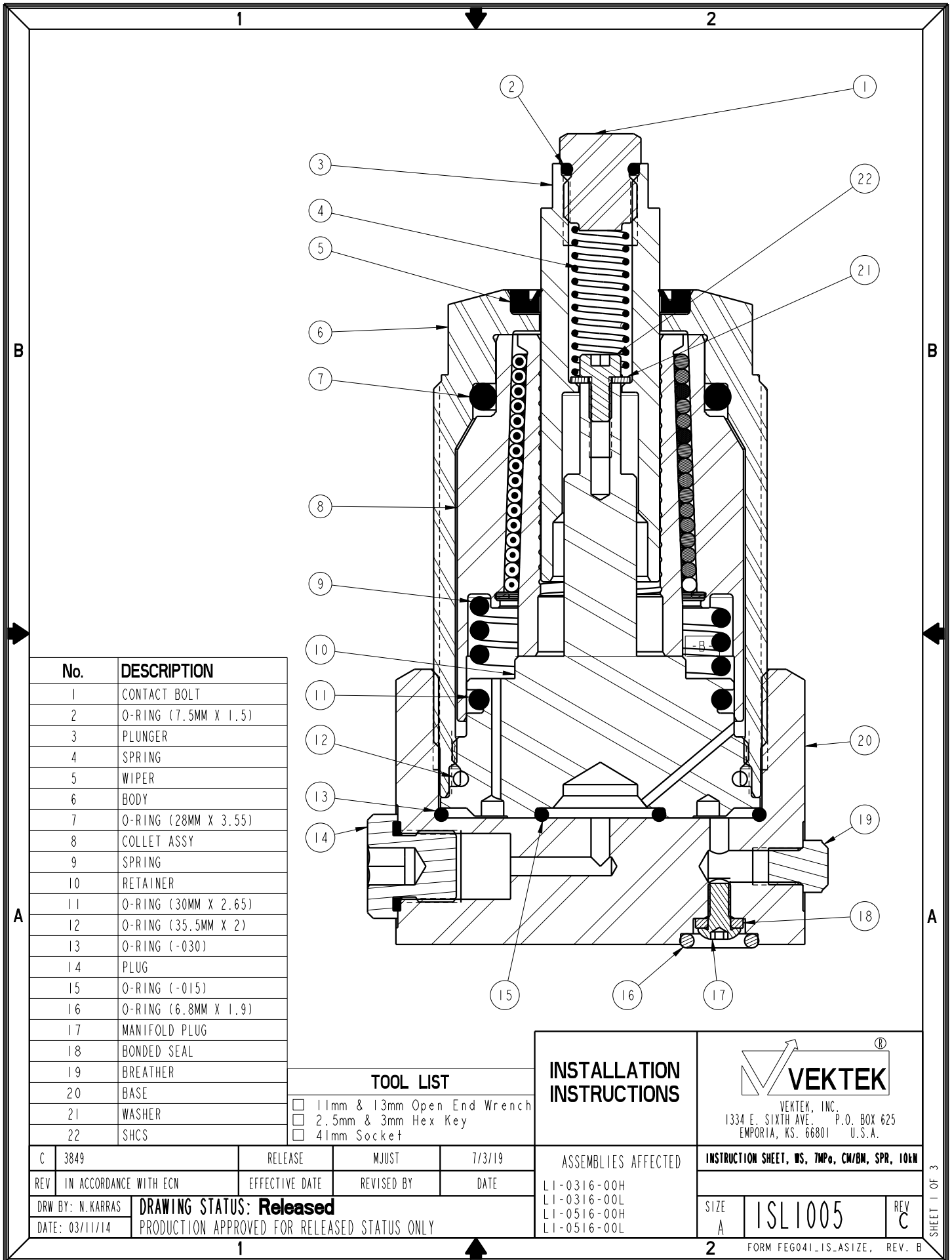
See Instruction Sheet ISL1005 For Service Instructions.
Lubricate All Seals With Clean Hydraulic Oil Prior To Assembly.
Do Not Use Silicone Base Lubricants.



PARTS LIST	 VEKTEK VEKTEK, INC. 1334 E. SIXTH AVE. P.O. BOX 625 EMPORIA, KS. 66801 U.S.A.
	ASSEMBLIES AFFECTED L1-0516-00H L1-0516-00L
SIZE A	LPL1009

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		

SHEET 1 OF 1



No.	DESCRIPTION
1	CONTACT BOLT
2	O-RING (7.5MM X 1.5)
3	PLUNGER
4	SPRING
5	WIPER
6	BODY
7	O-RING (28MM X 3.55)
8	COLLET ASSY
9	SPRING
10	RETAINER
11	O-RING (30MM X 2.65)
12	O-RING (35.5MM X 2)
13	O-RING (-030)
14	PLUG
15	O-RING (-015)
16	O-RING (6.8MM X 1.9)
17	MANIFOLD PLUG
18	BONDED SEAL
19	BREATHER
20	BASE
21	WASHER
22	SHCS

TOOL LIST

- 11mm & 13mm Open End Wrench
- 2.5mm & 3mm Hex Key
- 41mm Socket

INSTALLATION INSTRUCTIONS

ASSEMBLIES AFFECTED

- LI-0316-00H
- LI-0316-00L
- LI-0516-00H
- LI-0516-00L



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

INSTRUCTION SHEET, WS, TWPo, CW/BM, SPR, 10kN

SIZE
 A ISL1005

REV
 C

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		

SHEET 1 OF 3

Read all instructions before disassembly

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

Disassembly


Model Number L1-0316-00H & L1-0316-00L

1. Using a 41mm socket, unscrew work support from fixture or base (20). Wipe clean to remove external contaminants.
2. Remove O-ring (15) from retainer (10) s'face or cavity. Be careful not to damage retainer (10) face.
3. Remove O-ring (13) from fixture or base (20) 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 (22) inside plunger (3) and unscrew cap screw (22). Remove cap screw (22) and washer (21) 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 (20) or fixture, be careful not to damage the body (6) or retainer (10) face.
9. Thoroughly clean contact bolt (1), contact spring (4), plunger (3), cap screw (22), washer (21) 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 L1-0516-00H & L1-0516-00L

13. Remove work support base (20) from fixture and complete disassembly steps 1-10.
14. If work support hydraulics or vent is manifold fed from fixture, remove O-ring (16) from manifold s'face on base (19) mounting face (2 places).
15. If work support hydraulics or vent is not manifold fed, insert 3mm hex key into plug (17) located at base (19) mounting face and unscrew plug (17) (2 places). Remove bonded seal (18) from plug (17).
16. Thoroughly clean base (20), plugs (17) 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 <small>VEKTEK, INC. 1334 E. SIXTH AVE. P.O. BOX 625 EMPORIA, KS. 66801 U.S.A.</small>		
INSTRUCTION SHEET, WS, 7MPo, CW/BM, SPR, 10kN		
SIZE A	ISL1005	REV C
FORM FEG041-1S-ASIZE, REV. B		

1

2


Assembly

Model Number L1-0316-00H & L1-0316-00L

1. Lubricate new O-rings (2),(13),(15) 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 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 (21) onto cap screw (22) and drop thread side down into hole through top of plunger (3). Insert 2.5mm hex key into cap screw (22) and torque 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 (22).
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 (15) into retainer (10) s'face.
9. Install O-ring (13) into bottom of fixture cavity.
10. Using 41mm socket, screw work support into fixture cavity. Torque to 55 N-m (40 ft-lb).

Model Number L1-0516-00H & L1-0516-00L

12. Complete assembly steps 1-8.
13. Install O-ring (13) into bottom of base (20) cavity.
14. Using 41mm socket, screw work support into base (20) cavity. Torque to 55 N-m (40 ft-lb).
15. If work support hydraulics or vent is manifold fed from fixture, install new O-ring (16) into manifold s'face on base (20) mounting face (2 places).
16. If work support hydraulics or vent is not manifold fed, install bonded seal (18) onto plug (17), insert 3mm hex key into plug (17) 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, 7MP, CW/BM, SPR, 10&N		
SIZE A	ISL1005	REV C
<small>FORM FEG041-1S-ASIZE, REV. B</small>		

SHEET 3 OF 3