


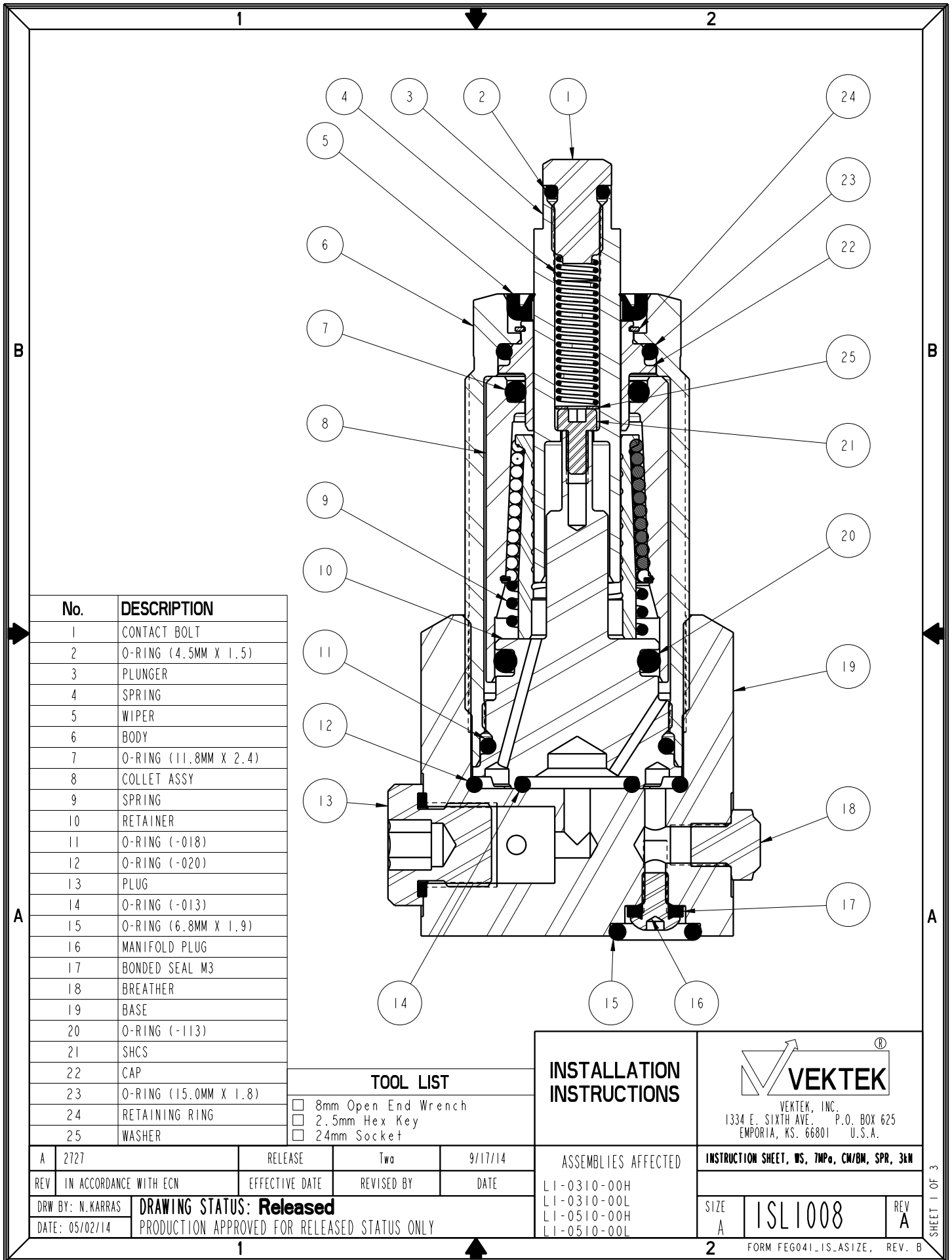
NO	QTY	PART NO	DESCRIPTION	STD SEAL KIT	LIGHT SPRING KIT	HEAVY SPRING KIT
1	1	23350104	SPRING, COMPRESSION			X
2	1	39051118	O-RING, (4.5mm X 1.5)	X	X	X
3	1	39051120	O-RING, (-020)	X		
4	1	39051124	O-RING, (-013)	X		
5	1	39053051	WIPER, PRESS-IN, 10mm	X		
6	1	81000032	CONTACT BOLT, WS, 7MPa, 3kN			
7	1	23350103	SPRING, COMPRESSION		X	
N/A	N/A	L6010007	KIT, SEAL, WS, 7MPa, CM/BM, 3kN	NOTED	N/A	N/A
N/A	N/A	L6110018	KIT, SPRING, WS, 7MPa, SPR, 3kN	N/A	NOTED	N/A
N/A	N/A	L6110019	KIT, SPRING, WS, 7MPa, SPR, 3kN	N/A	N/A	NOTED
N/A	N/A	ISL1008	INSTRUCTION SHEET, WS, 7MPa, CM/BM, SPR, 3kN	N/A	N/A	N/A

See Instruction Sheet ISL1008 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.
	ASSEMBLIES AFFECTED L1-0310-00H L1-0310-00L
PARTS LIST, ASSY, WS, 7MPa, CM, SPR, 3kN	SIZE A LPL1012
REV B	SHEET 1 OF 1

B	2846	RELEASE	Twa	05/01/15
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY:	Twa	<b>DRAWING STATUS: Released</b>		
DATE:	4/24/14	PRODUCTION APPROVED FOR RELEASED STATUS ONLY		



No.	DESCRIPTION
1	CONTACT BOLT
2	O-RING (4.5MM X 1.5)
3	PLUNGER
4	SPRING
5	WIPER
6	BODY
7	O-RING (11.8MM X 2.4)
8	COLLET ASSY
9	SPRING
10	RETAINER
11	O-RING (-018)
12	O-RING (-020)
13	PLUG
14	O-RING (-013)
15	O-RING (6.8MM X 1.9)
16	MANIFOLD PLUG
17	BONDED SEAL M3
18	BREATHER
19	BASE
20	O-RING (-113)
21	SHCS
22	CAP
23	O-RING (15.0MM X 1.8)
24	RETAINING RING
25	WASHER

TOOL LIST	
<input type="checkbox"/>	8mm Open End Wrench
<input type="checkbox"/>	2.5mm Hex Key
<input type="checkbox"/>	24mm Socket

**INSTALLATION INSTRUCTIONS**

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

A	2727	RELEASE	Two	9/17/14
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY:	N. KARRAS	<b>DRAWING STATUS: Released</b>		
DATE:	05/02/14	PRODUCTION APPROVED FOR RELEASED STATUS ONLY		

ASSEMBLIES AFFECTED  
LI-0310-00H  
LI-0310-00L  
LI-0510-00H  
LI-0510-00L

INSTRUCTION SHEET, WS, 7MPa, CW/BM, SPR, 3kN	
SIZE A	ISL1008
REV A	

Read all instructions before disassembly

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

### Disassembly


#### Model Number L1-0310-00H & L1-0310-00L

1. Using a 24mm 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 8mm wrench at plunger (3) and 8mm 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) and washer (25) 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) 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 (25), 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 L1-0510-00H & L1-0510-00L

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, 7MP, CW/BM, SPR, 3&M		
SIZE A	ISL1008	REV A

1

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## Assembly

### Model Number L1-0310-00H & L1-0310-00L

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 cap screw (21) thread side down through the top of plunger (3). Insert 2.5mm hex key into cap screw (21) and tighten to 2.5 N-m (20 in-lb).
5. Insert washer (25) into hole through top of plunger (3), followed by the contact spring (4).
6. Install O-ring (2) onto contact bolt (1).
7. Screw contact bolt (1) into top of plunger (3). With 8mm wrench at plunger (3) and 8mm wrench at contact bolt (1) torque to 9 N-m (80 in. lbs.).
8. Install O-ring (14) into retainer (10) s-face.
9. Install O-ring (12) into bottom of fixture cavity.
10. Using 24mm socket, screw work support into fixture cavity. Torque to 34 N-m (25 ft-lb).

### Model Number L1-0510-00H & L1-0510-00L

12. Complete assembly steps 1-8.
13. Install O-ring (12) into bottom of base (19) cavity.
14. Using 24mm socket, screw work support into base (19) cavity. Torque to 9 N-m (25 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).

		
<small>VEKTEK, INC. 1334 E. SIXTH AVE. P.O. BOX 625 EMPORIA, KS. 66801 U.S.A.</small>		
<b>INSTRUCTION SHEET, WS, 7MP, CW/BM, SPR, 3&amp;M</b>		
<small>SIZE A</small>	<b>ISL1008</b>	<small>REV A</small>
<small>FORM FEG041-1S-ASIZE, REV. B</small>		

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