


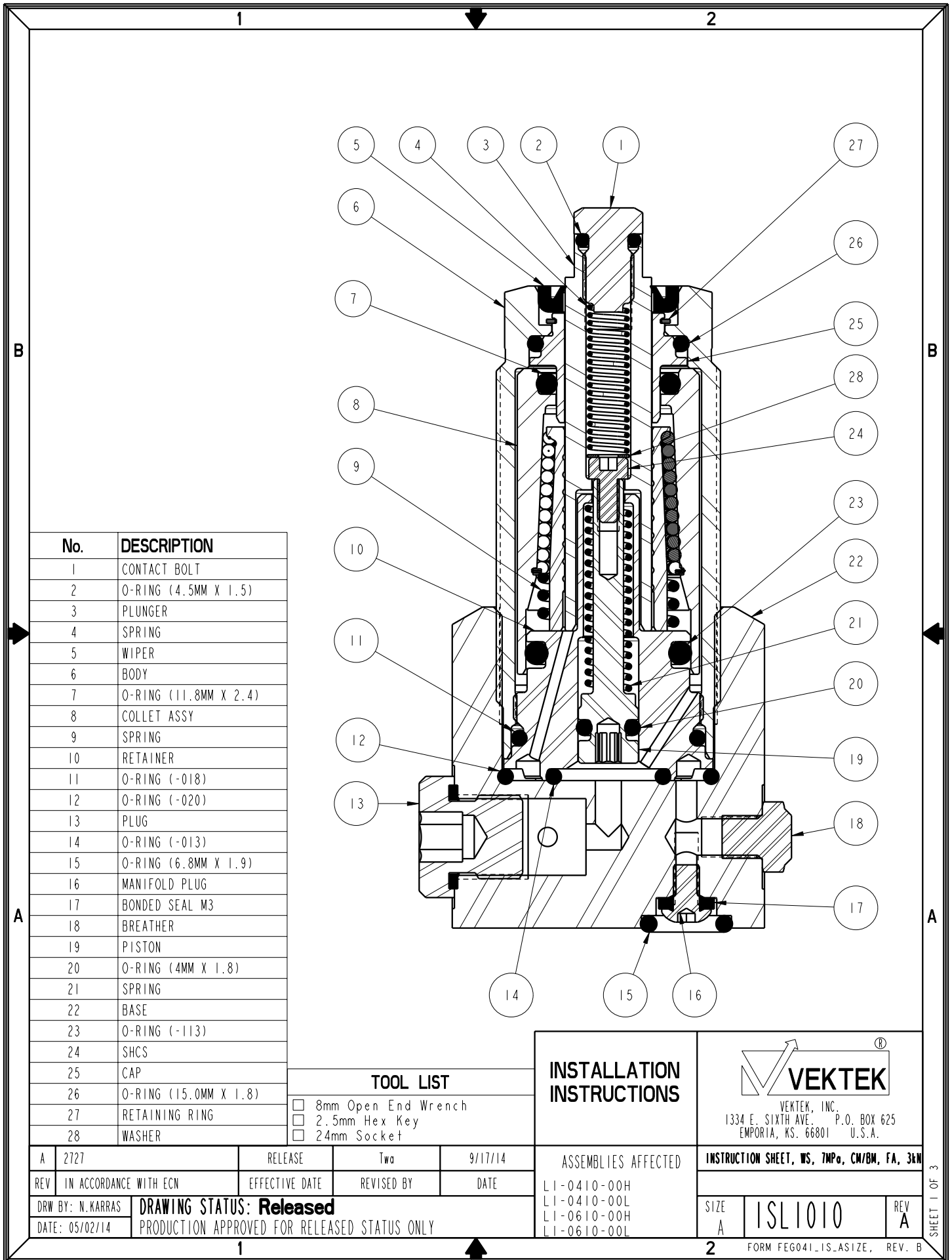
NO	QTY	PART NO	DESCRIPTION	STD SEAL KIT	LIGHT SPRING KIT	HEAVY SPRING KIT
1	1	23350102	SPRING, COMPRESSION		X	X
2	1	23350104	SPRING, COMPRESSION			X
3	1	39051117	O-RING, (3.75 X 1.8)	X	X	X
4	1	39051118	O-RING, (4.5mm X 1.5)	X	X	X
5	1	39051120	O-RING, (-020)	X	X	X
6	1	39051124	O-RING, (-013)	X	X	X
7	1	39053051	WIPER, PRESS-IN, 10mm	X		
8	1	81000032	CONTACT BOLT, WS, 7MPa, 3kN			
9	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	L6110014	SPRING, KIT, WS, 7MPa, CM/BM, FA, 3kN	N/A	NOTED	N/A
N/A	N/A	L6110015	SPRING, KIT, WS, 7MPa, CM/BM, FA, 3kN	N/A	N/A	NOTED
N/A	N/A	ISL1010	INSTRUCTION SHEET, WS, 7MPa, CM/BM, FA, 3kN	N/A	N/A	N/A

See Instruction Sheet ISL1009 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	PARTS LIST, ASSY, WS, 7MPa, CM, FA, 3kN
L1-0410-00H	L1-0410-00L	SIZE A
		LPL1014
		REV B

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> PRODUCTION APPROVED FOR RELEASED STATUS ONLY		
DATE:	4/24/14			



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	PISTON
20	O-RING (4MM X 1.8)
21	SPRING
22	BASE
23	O-RING (-113)
24	SHCS
25	CAP
26	O-RING (15.0MM X 1.8)
27	RETAINING RING
28	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-0410-00H  
 LI-0410-00L  
 LI-0610-00H  
 LI-0610-00L

INSTRUCTION SHEET, WS, 7MPo, CW/BM, FA, 3kN			
SIZE	ISL1010	REV	A

SHEET 1 OF 3

Read all instructions before disassembly  
Refer to the illustration on page 1 for component descriptions and tool list


**Disassembly**  
**Model Number L1-0410-00H & L1-0410-00L**

1. Using a 24mm socket, unscrew work support from fixture or base (22). Wipe clean to remove external contaminants.
2. Remove O-ring (14) from retainer (10) surface or cavity. Be careful not to damage retainer (11) face.
3. Remove O-ring (12) from fixture or base (22) 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 (28) from inside plunger (3).
6. Insert 2.5mm hex key into piston (19) from bottom of work support to prevent turning. Insert 2.5mm hex key into cap screw (24) inside plunger (3) and unscrew cap screw (24). Remove cap screw (24) from inside plunger (3). NOTE: PISTON (19) IS LOOSE AND NO LONGER FASTENED TO THE ASSEMBLY.
7. Remove piston (19) and return spring (21) from inside retainer (10). Remove O-ring (20) from piston (19). CAUTION: RETURN SPRING (21) 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 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 (22) or fixture, be careful not to damage the body (6) or retainer (10) face.
10. Thoroughly clean contact bolt (1), contact spring (4), plunger (3), cap screw (24), piston (19), return spring (21), washer (28) and set aside to dry.
11. Wipe clean retainer (10) face located on bottom of work support. Wipe clean wiper bore located in body at top of work support.
12. Wipe clean work support cavity in fixture.

**Model Number L1-0610-00H & L1-0610-00L**

13. Remove work support base (22) from fixture and complete disassembly steps 1-11.
14. If work support hydraulics or vent is manifold fed from fixture, remove O-ring (15) from manifold surface on base (22) 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 (22) mounting face and unscrew plug (16) (2 places). Remove bonded seal (17) from plug (16).
16. Thoroughly clean base (22), 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, 7MPo, CW/BM, FA, 3kN		
SIZE A	ISL1010	REV A
FORM FEG041-1S-ASIZE, REV. B		

