



SEE IS1023 FOR SERVICE INSTRUCTIONS.  
LUBRICATE ALL SEALS WITH CLEAN  
HYDRAULIC OIL PRIOR TO ASSEMBLY.  
DO NOT USE SILICONE BASED LUBRICANTS.



APPLY MEDIUM STRENGTH  
THREAD LOCKER (BLUE)  
TORQUE TO 9 Nm  
(80 IN-LB)

TORQUE TO  
1.25 Nm  
(11 IN-LB)

**PLUNGER**  
These work supports are  
fully rebuildable to full  
factory original capacity by  
any authorized Vektek repair  
facility. All seals can be  
replaced by any authorized  
repair facility.

**BODY ASSEMBLY**  
NOT REPLACEABLE  
TORQUE TO 67.8 Nm  
(50 FT-LB)

INSTALL LIP  
SIDE TOWARD  
BOTTOM OF PISTON

TORQUE TO  
5.7 Nm  
(50 IN-LB)

TORQUE TO  
13.5 Nm  
(120 IN-LB)

TORQUE TO  
1.25 Nm  
(11 IN-LB)

FOR MANIFOLD  
MOUNTING, REMOVE  
BHCS & BONDED  
SEAL FROM BASE  
AND INSERT O-RING  
INTO COUNTERBORE

NO	QTY	PART NO	DESCRIPTION	STD SEAL KIT	SPRING KIT
1	1	21410075	BHCS, 8-32 x 3/16 SELFLOCK, SST		
2	1	21430001	WASHER		
3	2	21500019	SCREW, CAP, BTNH, M3 X 6, ALY		
4	1	21500046	SCREW, CAP, BTNH, M5-0.8 X 6, ALY		
5	1	23350002	SPRING, COMPRESSION		X
6	1	23350059	SPRING, COMPRESSION		X
7	1	39000061	O-RING, (-016)	X	
8	1	39002009	O-RING, (-012)	X	
9	1	39050028	SEAL, BEVEL, 3/16 X 7/16 X 1/8	X	
10	2	39051116	O-RING, (6.8mm X 1.9)	X	
11	1	39054039	BU RING, (-201)	X	
12	2	39055011	SEAL, BONDED, M3	X	
13	1	39055013	SEAL, BONDED, M5	X	
14	1	41060802	BOLT, CONTACT, WS, 17.8kN		
15	2	43068004	PLUG, SOCH, G1/8		
16	1	81010817	PISTON, WS, FA, HC, 4000		
17	1	91040617	KIT,BASE,WS,FA,MM,HC,17.8kN		
18	1	39V10023	WIPER,PRESS-IN, (3/4), VBGV	X	
N/A	N/A	60100133	KIT, SEAL, WS, FA, BM, HC, 17.8KN	NOTED	N/A
N/A	N/A	61100222	KIT, SPRING, WS, FA, HC, 4000	N/A	NOTED
N/A	N/A	IS1023	INSTRUCTION SHEET	N/A	N/A

**PARTS LIST**



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

ASSEMBLIES AFFECTED  
41080820

PARTS LIST, ASSY, WS, FA, BM, HC, 17.8kN

SIZE  
A MPL1090

REV  
D

D	4993	RELEASE	RLK	12/7/22
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY:	ALS	<b>DRAWING STATUS: Released</b>		
DATE:	06/10/19	PRODUCTION APPROVED FOR RELEASED STATUS ONLY		

SHEET 1 OF 1