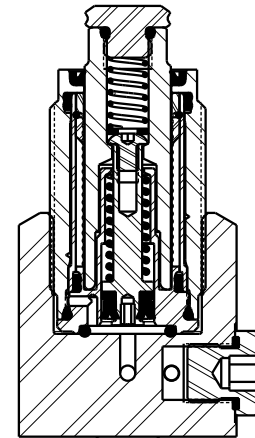




SEE ISI023 FOR SERVICE INSTRUCTIONS.
LUBRICATE ALL SEALS WITH CLEAN
HYDRAULIC OIL PRIOR TO ASSEMBLY.
DO NOT USE SILICONE BASED LUBRICANTS.



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 47.5 Nm
(35 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	21410076	BHCS, 6-32 x 3/16 SELFLOCK, SST		
2	1	21430012	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	23350060	SPRING, COMPRESSION		X
6	1	23350122	SPRING, COMPRESSION		X
7	1	39050008	O-RING, (-014)	X	
8	1	39051059	O-RING, (6mm x 1.5)	X	
9	2	39051116	O-RING, (6.8mm x 1.9)	X	
10	1	39052057	SEAL, BEVEL, 3/32 X 5/32 X 11/32	X	
11	1	39054035	BU RING, (.157 X .089)	X	
12	2	39055011	SEAL, BONDED, M3	X	
13	1	39055013	SEAL, BONDED, M5	X	
14	1	41040602	BOLT, CONTACT, WS, FA, 4.4 KN		
15	2	43068004	PLUG, SOCH, G1/8		
16	1	81010615	PISTON, WS, FA, HC, 2000		
17	1	91040616	KIT, BASE, WS, FA, MMHC, 8.9kN		
18	1	39V53003	WIPER, PRESS-IN, (9/16), VBGV	X	
N/A	N/A	60100138	KIT, SEAL, WS, FA, BM, HC, 8.9kN	NOTED	N/A
N/A	N/A	61100223	KIT, SPRING, WS, FA, HC, 2000	N/A	NOTED
N/A	N/A	ISI023	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
41080620

PARTS LIST, ASSY, WS, FA, BM, HC, 8.9kN

SIZE
A MPL1095

REV
C

FORM FEG035_PL_ASIZE, REV. B

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

SHEET 1 OF 1