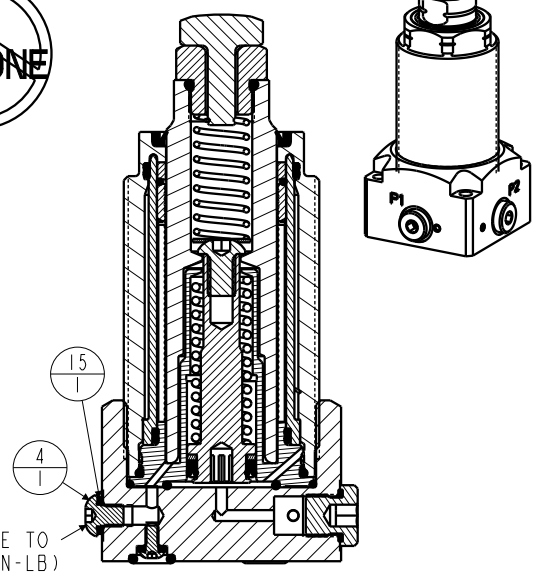
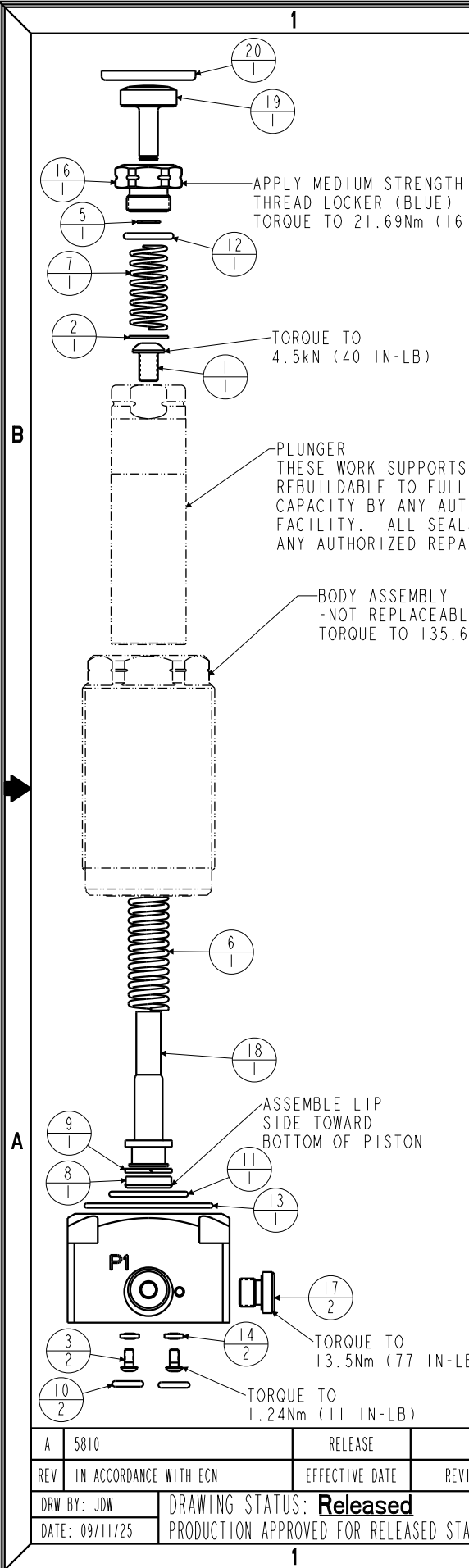


SEE IS1023 FOR SERVICE INSTRUCTIONS.  
LUBRICATE ALL SEALS WITH CLEAN HYDRAULIC OIL PRIOR TO ASSEMBLY.  
DO NOT USE SILICONE BASED LUBRICANTS.



NO	QTY	PART NO	DESCRIPTION	STD SEAL KIT	SPRING KIT
1	1	21410130	BHCS, 1/4-20 x 3/8, SELFLOCK, SST		
2	1	21430011	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	23010006	RETAINING RING, C, EXT		
6	1	23350143	SPRING, COMPRESSION		X
7	1	23350144	SPRING, COMPRESSION		X
8	1	39010038	SEAL, BEVEL, 7/16 x 3/32 x 5/8	X	
9	1	39010072	BU RING, (-111)	X	
10	2	39051116	O-RING, (6.8mm X 1.9)	X	
11	1	39051175	O-RING, (-021)	X	
12	1	39051176	O-RING, 12mm X 2.0mm	X	
13	1	39051177	O-RING, 40mm X 1.5mm		
14	2	39055011	SEAL, BONDED, M3		
15	1	39055013	SEAL, BONDED, M5		
16	1	41010840	BOLT, ADAPTER, WS, 35.6kN, PPS		
17	2	43068004	PLUG, SOCH, G1/8		
18	1	81011002	PISTON, WS, FA, HC, 8000		
19	1	81061002	BOLT, CONTACT, WS, 8000, PPS		
20	1	39V53005	WIPER, PRESS-IN, (1), VBGV	X	
N/A	N/A	60100157	KIT, SEAL, WS, FA, BM, HC, 35.6kN	NOTED	N/A
N/A	N/A	61100227	KIT, SPRING, WS, FA, HC, 35.6kN	N/A	NOTED
N/A	N/A	IS1023	INSTRUCTION SHEET	N/A	N/A

### PARTS LIST

WEIGHT 2.38 LBS

ASSEMBLIES AFFECTED  
41081020PS

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

REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY
DATE: 09/11/25	DRAWING STATUS: <b>Released</b>		
PRODUCTION APPROVED FOR RELEASED STATUS ONLY			

SIZE  
A

MPL1099

REV  
A

FORM FEG035\_PL\_ASIZE, REV. B

Vekttek LLC 1334 East Sixth Ave. P.O. Box 625 Emporia, Ks. 66801 U.S.A.	<b>Instruction Sheet</b>	<b>IS</b>	<b>1023</b>	
		<b>REV:</b>	<b>D, I.A.W ECN4133</b>	
		<b>REV. BY/DATE:</b>	<b>ALS</b>	<b>5/11/20</b>
		<b>APPR/DATE:</b>	<b>TDK</b>	<b>5/11/20</b>
<b>TITLE: Disassembly/Assembly Instructions: Inch and Metric High Capacity Fluid Advance Work Supports</b>				

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

**Read all instructions prior to disassembling!**

**Refer to the illustration on page three for component part numbers and tool list.**

## **Disassembly**

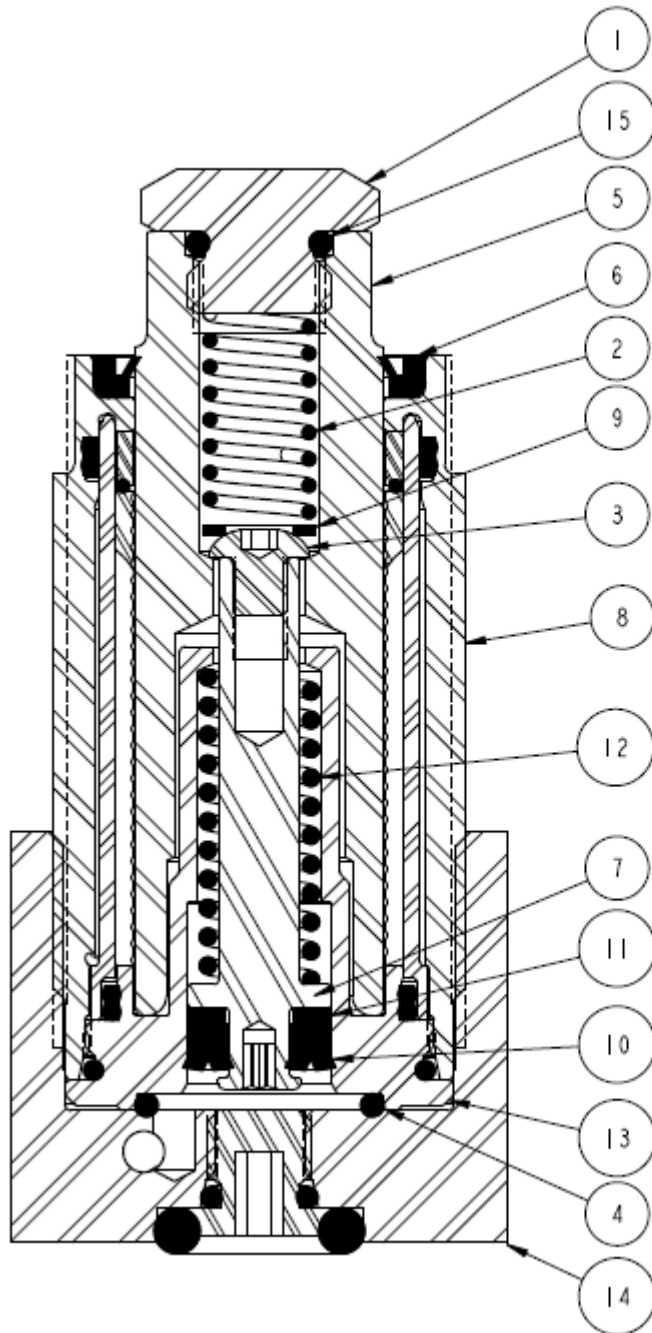
1. Unscrew the cartridge assembly (8) from the base (14) or fixture. **Caution- Use a six-point socket only. Other types of wrenches may damage the work support.**
2. Hold the plunger (5) stationary and unscrew the contact bolt (1). Remove contact o-ring (15) from contact bolt (1).
3. Remove the spring (2) and spacer (9) from inside the plunger (5).
4. Hold the piston (7) stationary and unscrew the cap screw (3).
5. Slide the plunger (5) out of the top of the cartridge assembly (8) and then push the piston (7) and spring (12) out of the retainer (13).
6. Remove the wiper (6) from the cartridge assembly (8).
7. Remove the piston seal (10) and piston seal back-up ring (11) from the piston (7), and the seal (4) from the base (14) or fixture.
8. Clean all parts thoroughly and set aside to dry.

Vekttek LLC 1334 East Sixth Ave. P.O. Box 625 Emporia, Ks. 66801 U.S.A.	Instruction Sheet	IS	1023	
		REV:	D, I.A.W ECN4133	
		REV. BY/DATE:	ALS	5/11/20
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<b>TITLE: Disassembly/Assembly Instructions: Inch and Metric High Capacity Fluid Advance Work Supports</b>				

## Assembly

1. Lubricate all O-rings, gaskets, back-up rings and seals with clean hydraulic fluid (Vekttek 65-0010-01 or equivalent). Apply Loctite primer N® or equivalent to the threads of the contact bolt (1) and the retainer (13) and set aside to dry.
2. First install the back-up ring (11) then the piston seal (10) onto the piston (7) with the sealing lips of the piston seal (10) toward the piston (7) base.
3. Slide the spring (12) onto the piston (7) and insert both parts into the retainer (13).
4. Insert the plunger (5) into the top of the cartridge assembly (8).
5. While holding the piston (7) stationary insert the cap screw (3) into the top of the plunger (5) and thread the cap screw (3) into the piston (7). Tighten to the specification on the parts list.
6. Insert the flat washer (9) and the spring (2) into the top of the plunger (5).
7. Install contact o-ring (15) onto contact bolt (1). Apply one drop of Loctite 243® or equivalent to the threads of the contact bolt (1). While holding the plunger (5) stationary tighten the contact bolt (1) to the plunger (5). Tighten to the torque specification on the parts list.
8. If using o-ring, place the o-ring (4) flat in the bottom of the retainer (13). Insert the work support assembly into the base (14) or mounting cavity and tighten it to the torque specification on the parts list.  
**Caution- Use a six-point socket only. Other types of wrenches may damage the work support. Note- Use o-ring if cavity abides by ILS100730 or ILMV100723. Use o-ring OR gasket, not both.**
9. If using gasket, place the gasket (4) flat in the bottom of the base (14) or mounting cavity. Insert the work support assembly into the base (14) or mounting cavity and tighten it to the torque specification on the parts list.  
**Caution- Use a six-point socket only. Other types of wrenches may damage the work support.**

<b>Vekttek LLC</b> 1334 East Sixth Ave. P.O. Box 625 Emporia, Ks. 66801 U.S.A.	<b>Instruction Sheet</b>	<b>IS 1023</b>	
		<b>REV: D, I.A.W ECN4133</b>	
		<b>REV. BY/DATE: ALS</b>	<b>5/11/20</b>
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<b>TITLE: Disassembly/Assembly Instructions: Inch and Metric High Capacity Fluid Advance Work Supports</b>			



15	CONTACT O-RING
14	BASE
13	RETAINER
12	CONTACT SPRING
11	BACK-UP RING
10	PISTON SEAL
9	FLAT WASHER
8	CARTRIDGE ASSY
7	PISTON
6	WIPER
5	PLUNGER
4	SEAL
3	CAP SCREW
2	CONTACT SPRING
1	CONTACT BOLT
<b>Item</b>	<b>Description</b>