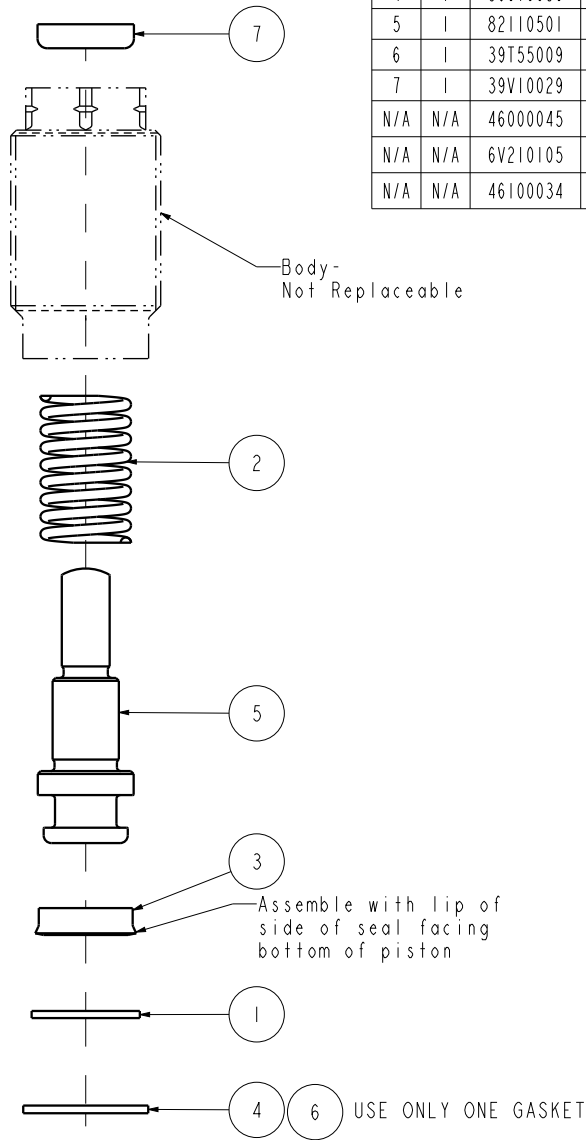


NO	QTY	PART NO	DESCRIPTION	STD SEAL KIT	FKM SEAL KIT	SPRING KIT
1	1	23050010	WASHER	X	X	X
2	1	23312003	SPRING, COMPRESSION			X
3	1	39010012	SEAL, BEVEL, 5/16 X 3/32 X 1/2	X	39V10012	
4	1	39010030	GASKET, COPPER	X	X	X
5	1	82110501	PISTON, CYL, MM, 980			
6	1	39T55009	GASKET, (.451 x .100 x .080)	X	X	X
7	1	39V10029	WIPER, PRESS-IN, (1/4)	X	X	
N/A	N/A	46000045	KIT, SEAL, CYL, CM, 4.4KN, 6934-04	NOTED	N/A	N/A
N/A	N/A	6V210105	KIT, SEAL, CYL, CM, 980, SA, FKM	N/A	NOTED	N/A
N/A	N/A	46100034	KIT, SPRING, CYL, CM, 4.4KN, 6934-04	N/A	N/A	NOTED




See ISMV-2100 for machining and installation instructions. Lubricate all seals with clean hydraulic oil prior to assembly.

DO NOT USE SILICONE BASED LUBRICANTS.

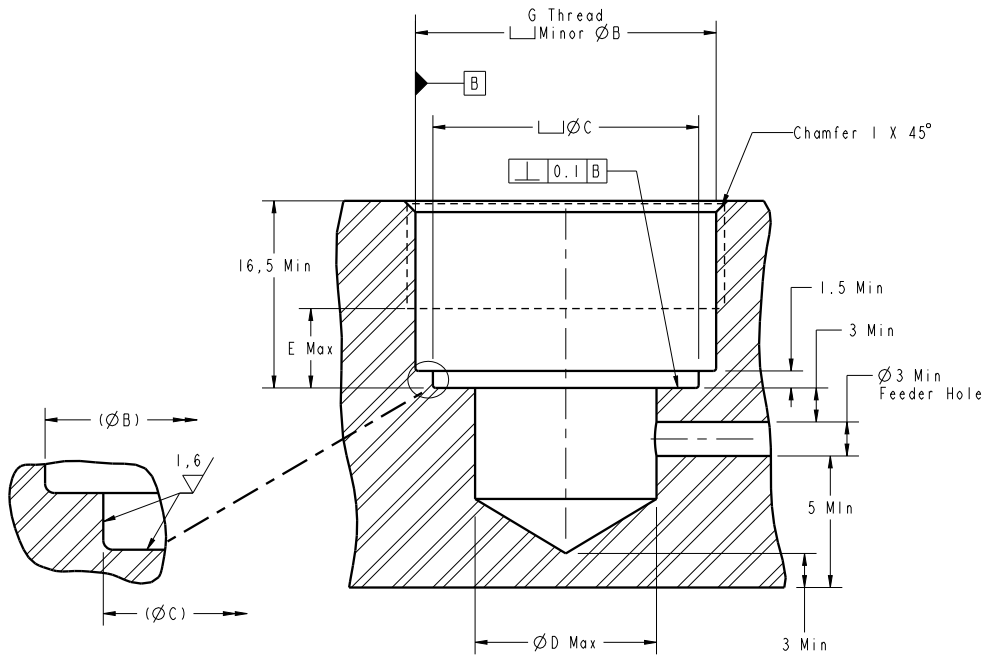
**INSTALLATION TORQUE:**

- Metal Gasket = 54 Nm
- Composite Gasket = 30 Nm
- \*Cylinders may need to be re-torqued after a break-in period of 3 weeks or 2,500 cycles for both gasket styles.

Both metal and composite gaskets are supplied. Use only one gasket. The metal gasket is recommended when the cavity seal surface has every smooth finish and is flat and perpendicular to the minor diameter. The metal gasket must be torqued to a higher value, which is more resilient to machining vibrations providing long term sealing. The composite gasket is recommended when the cavity seal surface has a rough surface finish or is not flat.

<b>PARTS LIST</b>	 VEKTEK, INC. 1334 E. SIXTH AVE. P.O. BOX 625 EMPORIA, KS. 66801 U.S.A.
	ASSEMBLIES AFFECTED 42-1010-01
PARTS LIST, ASSY, CYL, CM, 4.4KN, 7 STRK, SA, SPR	SIZE A
DRAWING STATUS: <b>Released</b> PRODUCTION APPROVED FOR RELEASED STATUS ONLY	REV L

L	3140	RELEASE	BCD	11/9/16
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY: BUSH	DRAWING STATUS: <b>Released</b> PRODUCTION APPROVED FOR RELEASED STATUS ONLY			
DATE: 12/15/94				



Cavity Dimensions (mm)							
Model No.	G	B	C	D	E	Copper Gasket Torque (Nm)	Composite Gasket Torque (Nm)
42-1010-00*	M16x1,5	14,52±0,15	13,84±0.13	8	4	40	20
42-1010-01*	M20x1,5	18,52±0,15	16,81±0.13	9,5	4	54	30
42-1010-02*	M28x1,5	26,52±0,15	23,44±0.13	16	7	68	35
42-1010-03*							
42-1010-04	M35x1,5	33,52±0,15	31,19±0.13	22	7	N/A	50

\*Cylinders may need to be re-torqued after a break-in period of 3 weeks or 2,500 cycles for both gasket styles.

### INSTALLATION INSTRUCTIONS



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

ASSEMBLIES AFFECTED

#### Cavity Dimensions

Cartridge Mounted Cylinders

-SEE CHART-

SIZE  
A

1SMV2100

REV  
B

B	3041	RELEASE	BCD	11/9/16
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY:	JDW	<b>DRAWING STATUS: Released</b>		
DATE:	8-8-11	PRODUCTION APPROVED FOR RELEASED STATUS ONLY		

FORM FEG041-1S\_ASIZE, REV. B

SHEET 1 OF 1