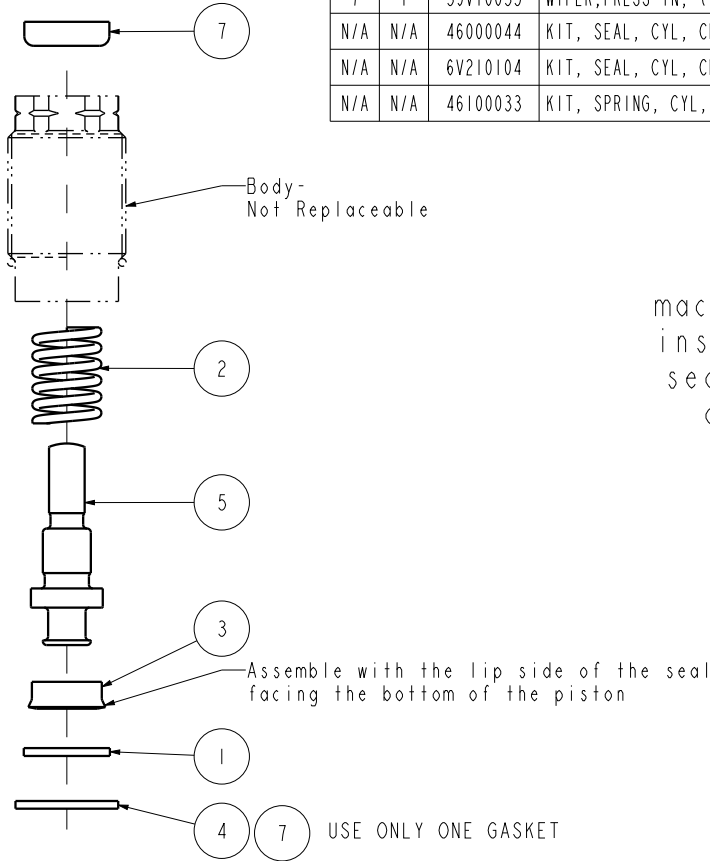



NO	QTY	PART NO	DESCRIPTION	STD SEAL KIT	FKM SEAL KIT	SPRING KIT
1	1	23050011	WASHER	X	X	X
2	1	23311015	SPRING, COMPRESSION			X
3	1	39010011	SEAL, BEVEL, 3/16 X 3/32 X 3/8	X	39V10011	
4	1	39010034	GASKET, COPPER	X	X	X
5	1	82110400	PISTON, CYL, CM, 550&2KN			
6	1	39T55008	GASKET. (.375 x .080 x .080)	X	X	X
7	1	39V10035	WIPER, PRESS-IN, (3/16)	X	X	
N/A	N/A	46000044	KIT, SEAL, CYL, CM, 2.4KN, 6934-02	NOTED	N/A	N/A
N/A	N/A	6V210104	KIT, SEAL, CYL, CM, 550,FKM	N/A	NOTED	N/A
N/A	N/A	46100033	KIT, SPRING, CYL, CM, 2.4KN, 6934-02	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 = 40 Nm
-Composite Gasket = 20 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 a very 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.

PARTS LIST	 VEKTEK, INC. 1334 E. SIXTH AVE. P.O. BOX 625 EMPORIA, KS. 66801 U.S.A.	
	ASSEMBLIES AFFECTED	PARTS LIST, ASSY, CYL, CM, 2.4KN, 5 STRK, SA, SPHR
SIZE A	MPL2102	REV L

L	3297	RELEASE	GAR	8/8/17
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY: BUSH	DRAWING STATUS: Released			
DATE: 12/15/94	PRODUCTION APPROVED FOR RELEASED STATUS ONLY			