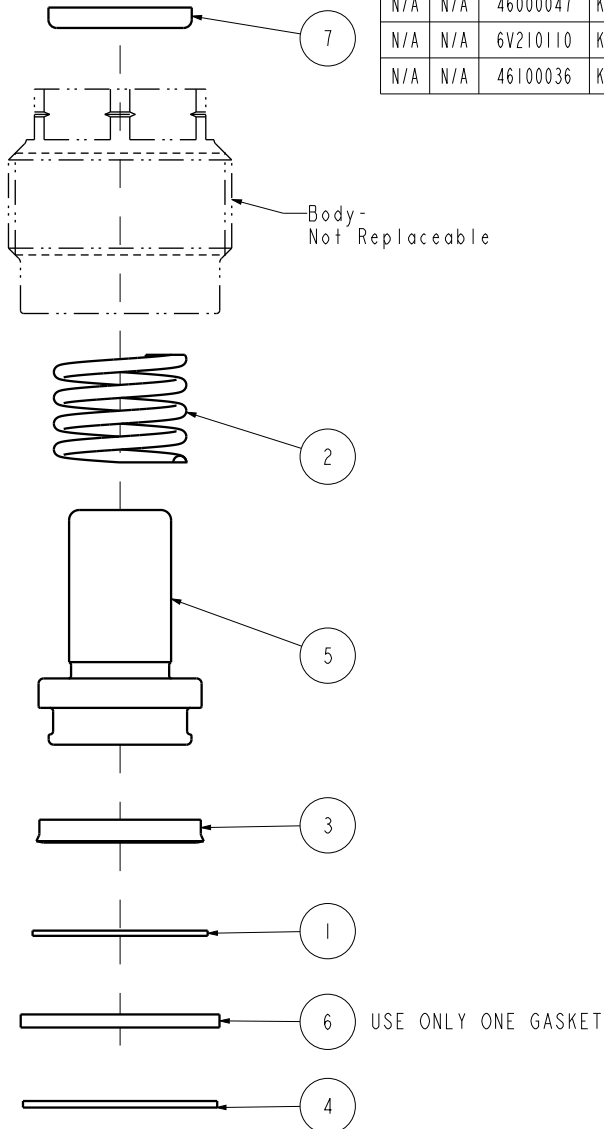


NO	QTY	PART NO	DESCRIPTION	STD SEAL KIT	FKM SEAL KIT	SPRING KIT
1	1	23050008	WASHER	X	X	X
2	1	23314005	SPRING, COMPRESSION			X
3	1	39010014	SEAL, BEVEL, 13/16 x 3/32 x 1	X	39V12001	
4	1	39055024	GASKET, COPPER	X	X	X
5	1	48111000	PISTON, CYL, CM, 17.5KN			
6	1	39T55006	GASKET, (1.004 x .107 x .080)	X	X	X
7	1	39V11020	WIPER, PRESS-IN, (5/8)	X	X	
N/A	N/A	46000047	KIT, SEAL, CYL, CM, 17.5KN, 6934-17	NOTED	N/A	N/A
N/A	N/A	6V210110	KIT, SEAL, CYL, CM, 3900, FKM	N/A	NOTED	N/A
N/A	N/A	46100036	KIT, SPRING, CYL, CM, 17.5KN, 6934-1	N/A	N/A	NOTED




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

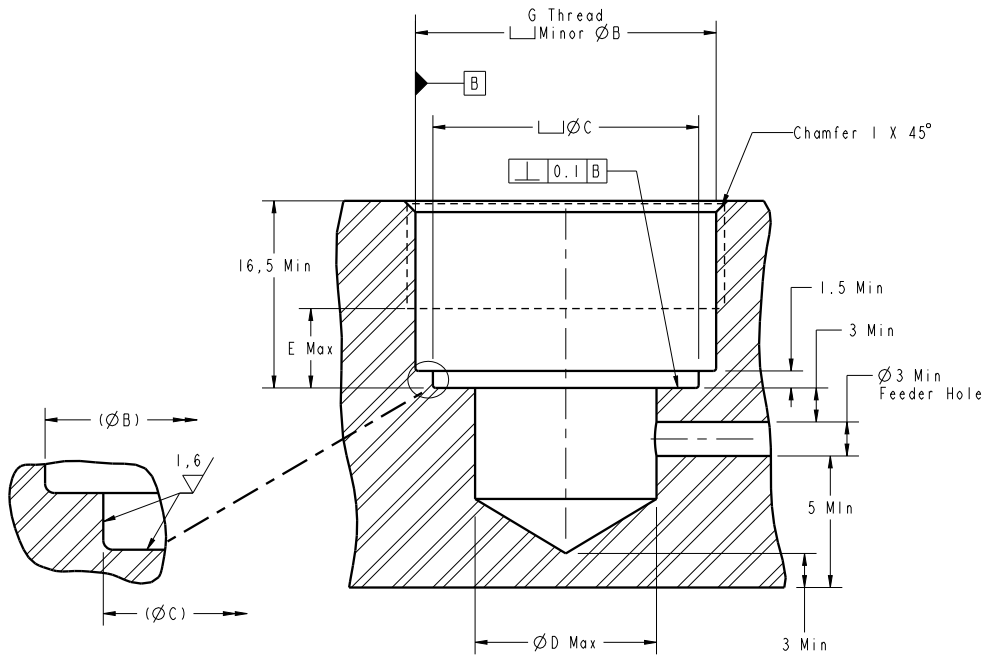
DO NOT USE SILICONE BASED LUBRICANTS.

INSTALLATION TORQUE:

- Metal Gasket = 81 Nm
- Composite Gasket = 50 Nm
- *Cylinders may need to be re-torqued after a break-in period of 3 weeks or 2,500 cycles for both gasket styles.

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.

PARTS LIST	 VEKTEK, INC. 1334 E. SIXTH AVE. P.O. BOX 625 EMPORIA, KS. 66801 U.S.A.	
	ASSEMBLIES AFFECTED 42-1010-04	PARTS LIST, ASSY, CYL, CM, 17.5 KN
K 4443 REV IN ACCORDANCE WITH ECN DATE: 12/15/94	RELEASE EFFECTIVE DATE RLK REVISED BY DATE	SIZE A MPL2103
DRAWING STATUS: Released PRODUCTION APPROVED FOR RELEASED STATUS ONLY		REV K



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	DRAWING STATUS: Released			
DATE: 8-8-11	PRODUCTION APPROVED FOR RELEASED STATUS ONLY			

FORM FEG041-1S.AS1ZE, REV. B

SHEET 1 OF 1