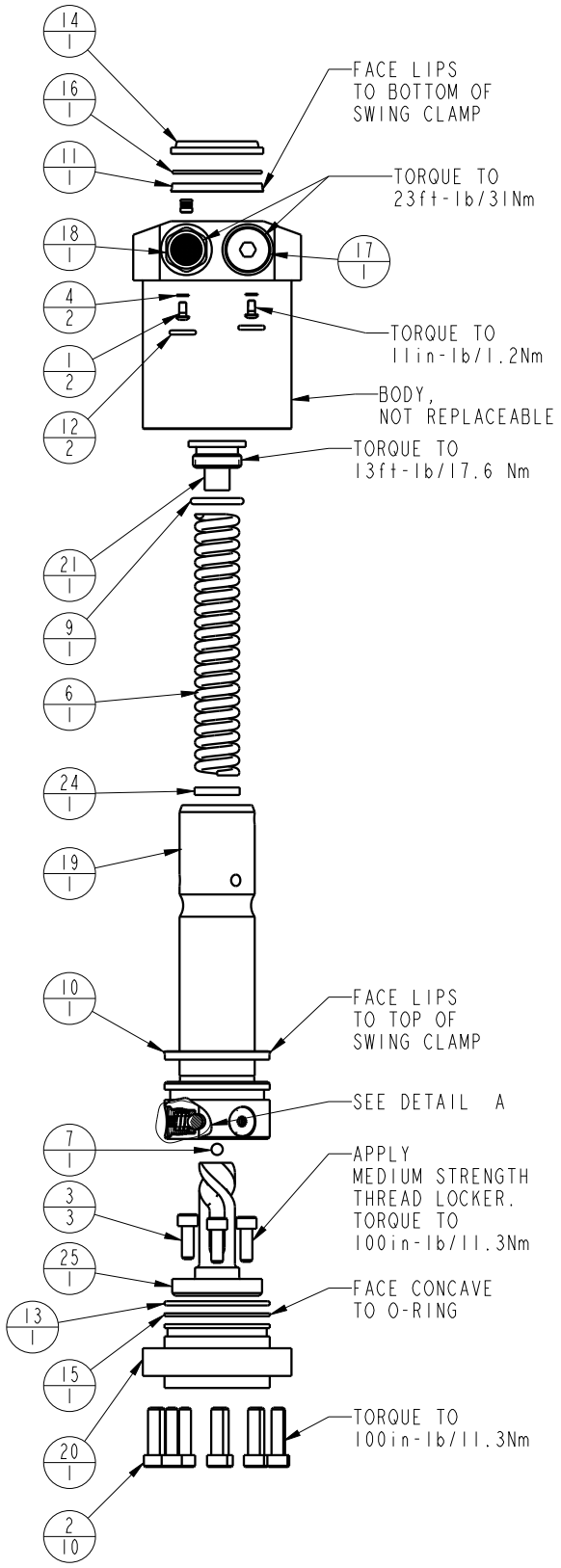
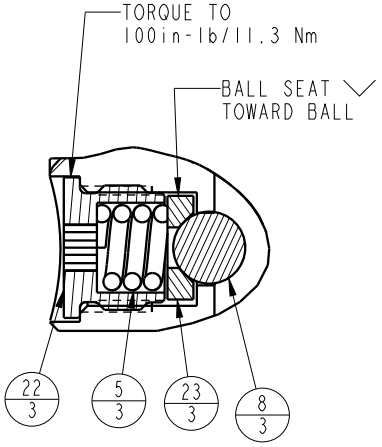
APPLY LUBRICANT TO ALL SEALS
PRIOR TO INSTALLATION.
DO NOT USE SILICONE TYPE LUBRICANTS.
FOR PROPER ARM MOUNTING SEE IS1505.





DETAIL A
SCALE 1.500

No.	QTY	PART No.	DESCRIPTION	Std. Seal Kit	FKM Seal Kit	Spring Kit
N/A	N/A	IS1505	INSTRUCTION SHEET, ARM INSTALLATION			
N/A	N/A	61704022	SPRING KIT			
N/A	N/A	6V711031	SEAL KIT, FKM			
N/A	N/A	60711031	SEAL KIT, STANDARD			
25	1	81591823	CAM,SC,LP,5000/22KN,LH,TC			
24	1	81591302	DISK, Ø.75 X .12			X
23	3	81532108	SEAT, BALL, SC, LP, TC			
22	3	81532107	RETAINER, SC, LP, TC			
21	1	81531811	PLUG, SC, LP, 5000&22KN, SA, TC			
20	1	81531809	CAP, END, SC, LP, 22kN/5000			
19	1	81511810	PLUNGER,SC,LP,5000&22KN,SA,TC			
18	1	49001905	BREATHER, 1/4 BSPP			
17	1	43068006	PLUG, 1/4 BSPP MALE			
16	1	39054008	BU RING,(-218)	X	X	
15	1	39054007	BU RING,(-030)	X	39054021	
14	1	39053005	WIPER,SNAP-IN,(1-1/4)	X	X	
13	1	39051042	O-RING, (-030)	X	39V01021	
12	2	39050042	O-RING, (-011)	X	39051025	
11	1	39011060	SEAL,BEVEL W/WHEEL INSERT,1-1/4 x1/8 x1-1/2	X	39052015	
10	1	39011055	SEAL, BEVEL, 1-9/16 x 3/32 x 1-3/4	X	39052013	
9	1	39000029	O-RING, (-115)	X	39V00029	X
8	3	23650004	BALL,TUNGSTEN-CARBIDE.250			
7	1	23600011	BALL, STEEL, ALLOY, .187			X
6	1	23350067	SPRING, COMPRESSION			X
5	3	23350066	SPRING, COMPRESSION			
4	2	21500200	WASHER			
3	3	21500031	SHCS, M5 x 0,8 x 14, ALY			
2	10	21500022	SHCS, M5 x .8-6G x 20, ALY			
1	2	21500019	SCREW, CAP, BTNH, M3 X 6, ALY			

PARTS LIST

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

REV				
C	5922	RELEASE	JDW	03/23/26
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE

ASSEMBLIES AFFECTED
41462212
41462212F

PARTS LIST, ASSY,SC,LP,TC,TF,22KN,SA,LH

DRW BY: JDW
DATE: 6-7-11

DRAWING STATUS: Released
PRODUCTION APPROVED FOR RELEASED STATUS ONLY

SIZE A | MPL7142 | REV C

SHEET 1 OF 1

FORM FEG035_PL_ASIZE, REV. B

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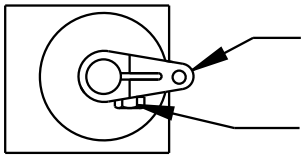
READ ALL INSTRUCTIONS BEFORE INSTALLING ARMS
FAILURE TO FOLLOW INSTALLATION INSTRUCTIONS WILL VOID PRODUCT WARRANTY !

–Installing or Positioning of Low Profile Swing Clamp Arms–

NOTE: If the arm is already installed on the plunger, loosen the cap screw.

CAUTION: Never attempt to rotate the arm before loosening the cap screw. This can damage the plunger rotating mechanism.



1. Rotate the arm to the desired radial position.
2. Tighten to the torque specification listed below.

MODEL	TORQUE ft-lb	TORQUE N-m
5000lb & 22Kn	115 ft-lb	156 N-m
7500lb & 33Kn	225 ft-lb	305 N-m

IT IS RECOMMEND THE CROSS BOLT BE REPLACED IF THE ARM NEEDS REMOVED AFTER IT HAS BEEN IN SERVICE.			
CROSS BOLT 5000 & 22KN SHORT LONG DOUBLE	CROSS BOLT 5000 & 22KN UPREACH	CROSS BOLT 7500 & 33KN SHORT LONG DOUBLE	CROSS BOLT 7500 & 33KN UPREACH
21-5000-24	21-5000-25	21-5000-28	21-5000-25

Instruction Sheet

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

REV				
C	2799	RELEASE	JDW	01/29/15
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE

DRW BY: MES
DATE: 08/01/05

DRAWING STATUS: **Released**
PRODUCTION APPROVED FOR RELEASED STATUS ONLY

Arm Installation Instruction Sheet
Low Profile Swing Clamps

SIZE A | IS1505 | REV C

SHEET 1 OF 1

FORM FEG041_IS_ASIZE, REV. B

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