



# CAVITY AND INSTALLATION INSTRUCTIONS

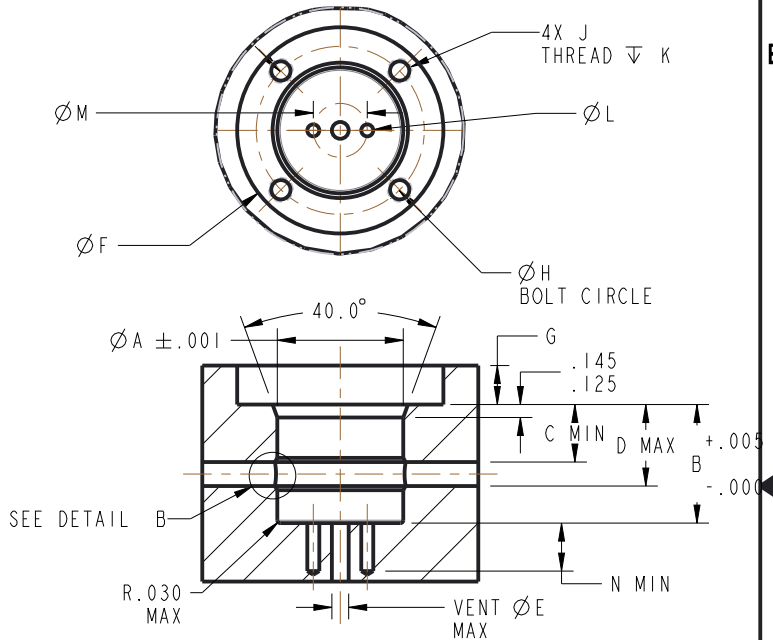
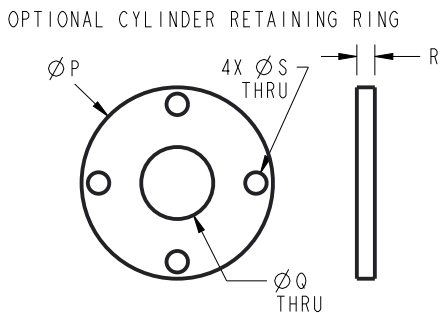
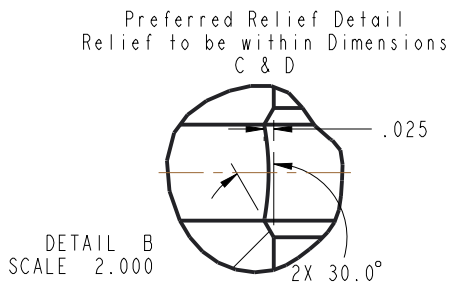
## PLEASE READ PRIOR TO OPERATION

### Cavity Forming

-It is recommended that all cavities be prepared using a ball hone such as a \*Flex-Hone™. This will deburr and round sharp edges to prevent seal damage. The honing prepares cavity for cylinder installation.

-Intersecting feed holes should be adequately deburred and chamfered to prevent seal damage.

\*Flex-hone™ is a registered trademark of:  
Brush Research Manufacturing Co. Inc.  
Los Angeles, CA, 323-261-2193  
Please Contact Brush Research for additional information.



MODEL NO.	CAPACITY	A	B	C	D	E	F	G	H	J	K	L*	M*	N*	P	Q	R	S
21-4106-XX	980	.813	1.120	.44	.72	.16	1.40	.31	1.13	8-32 UNC	.33	.13	.44	.31	1.330	.50	.125	.173
21-4109-00	2000	1.188	1.120	.44	.72	.18	1.86	.31	1.56	8-32 UNC	.33	.13	.53	.40	1.832	.75	.125	.173
21-4109-01	2000	1.188	1.245	.44	.84	.18	1.86	.31	1.56	8-32 UNC	.33	.13	.53	.40	1.832	.75	.125	.173
21-4111-XX	2950	1.313	1.245	.44	.84	.18	2.15	.41	1.75	1/4-20 UNC	.38	.13	.56	.40	2.125	.75	.125	.257
21-4113-XX	5200	1.751	1.370	.44	.97	.33	2.83	.53	2.31	5/16-18 UNC	.47	.16	.88	.40	2.782	1.00	.187	.328
21-4116-XX	9000	2.126	1.495	.44	1.09	.35	3.40	.67	2.81	3/8-16 UNC	.50	.28	1.00	.60	3.375	1.12	.250	.391
21-4121-00	17100	2.876	1.620	.44	1.22	.40	4.59	.90	3.81	1/2-13 UNC	.63	.28	1.57	.60	4.563	1.25	.375	.515

NOTE: CAVITY UTILIZES OPTIONAL RETAINING RING AVAILABLE FROM VEKTEK, INC.  
ADDITIONAL RETAINING RING INFORMATION IS CONTAINED IN SHEET 3.

\*THESE FEATURES ARE ONLY NEEDED IF ANTI-ROTATION PINS ARE USED.

\*\*ANTI-ROTATE PINS AND RETURN SPRINGS INCLUDED WITH CYLINDERS.

### INSTALLATION INSTRUCTIONS



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

A	2753	RELEASE	DKC	10/1/14
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY:	DKC	<b>DRAWING STATUS: Released</b>		
DATE:	9/23/14	PRODUCTION APPROVED FOR RELEASED STATUS ONLY		

ASSEMBLIES AFFECTED  
21-4106-XX 21-4109-XX  
21-4111-XX 21-4113-XX  
21-4116-XX 21-4121-00

INSTRUCTIONS, INSTALL, CTL, CH, SLIP-IN	
SLIP IN	REV A
SIZE A	IS2102

FORM FEG041-1S.AS1Z, REV. B

SHEET 1 OF 3



1

2

## INSTALLATION INSTRUCTIONS CONTINUED

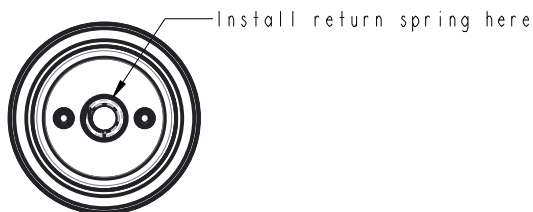
### Installation Notes

- It is recommended that all cavities be prepared using a ball hone such as a \*Flex-Hone™. This will deburr and round sharp edges to prevent seal damage and prepare cavity for cylinder installation.
- All seals should be lubricated with a non-silicone grease (recommended) or clean hydraulic oil prior to installation.

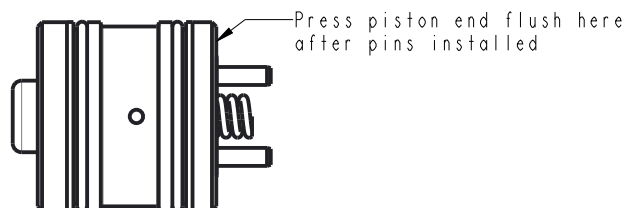
### Installation

1. Lubricate all seals with non-silicone grease (recommended) or clean hydraulic oil.
2. Install return spring in plunger cavity with a small amount of grease to hold it in place during installation. See view below. A table of return spring part numbers is included below.

Cylinder P/N	Return Spring P/N
21-4106-XX	23-3550-11
21-4109-XX	23-3550-12
21-4111-XX	23-3550-12
21-4113-XX	23-3550-14
21-4116-XX	23-3550-15
21-4121-00	23-3550-16



3. If using anti-rotate pins install a bolt and jam nut in plunger to help align pins. Press the piston end of the plunger even with end of body. See view below.



- a. Press cylinder into cavity until plunger begins to extend ensuring cylinder goes in evenly to prevent cavity or seal damage.
  - b. Using the bolt gently turn the plunger while applying slight downward force until plunger begins to retract. This ensures alignment of the anti-rotation pins.
  - c. Remove bolt and jam nut. Visually inspect spring through threaded hole in plunger to verify return spring is properly positioned.
4. Press cylinder body until flush with the start of the cavity. Stop if an increase in resistance is felt.
    - a. If using the optional retention ring, see chart below for proper torque.

MODEL NO.	RETAINER NO.	BOLT SIZE	TORQUE
21-4106-XX	64-0140-80	8-32 UNC	<b>29 IN-LBS</b>
21-4109-XX	64-0141-10	8-32 UNC	<b>29 IN-LBS</b>
21-4111-XX	64-0141-30	1/4-20 UNC	<b>63 IN-LBS</b>
21-4113-XX	64-0141-70	5/16-18 UNC	20 FT-LBS
21-4116-XX	64-0142-10	3/8-16 UNC	24 FT-LBS
21-4121-00	64-0142-80	1/2-13 UNC	62 FT-LBS

### INSTALLATION INSTRUCTIONS



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

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#### ASSEMBLIES AFFECTED

21-4106-XX 21-4109-XX  
21-4111-XX 21-4113-XX  
21-4116-XX 21-4121-00

<b>INSTRUCTIONS, INSTALL, CTL, CN, SLIP-IN</b>	
SLIP IN	
SIZE A	<b>IS2102</b>
REV A	

FORM FEG041-1S.AS1ZE, REV. B

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SHEET 3 OF 3