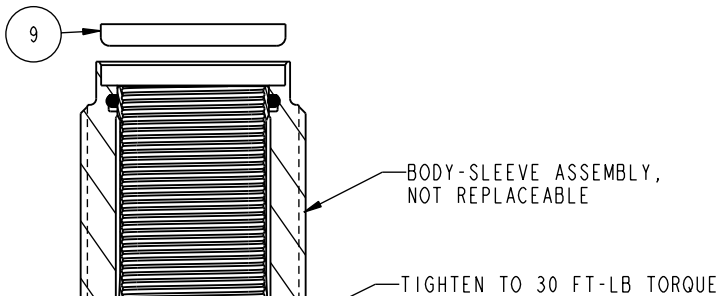
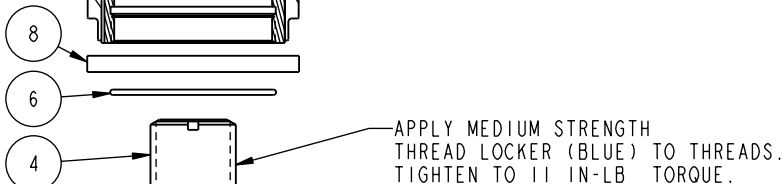


LUBRICATE ALL SEALS WITH CLEAN HYDRAULIC OIL PRIOR TO ASSEMBLY.  
DO NOT USE SILICONE BASED LUBRICANTS.



BODY-SLEEVE ASSEMBLY,  
NOT REPLACEABLE

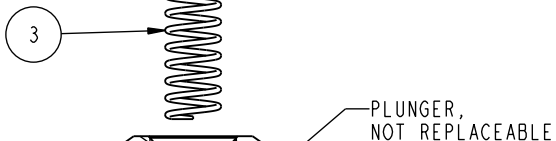
TIGHTEN TO 30 FT-LB TORQUE



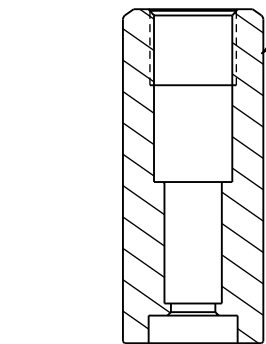
APPLY MEDIUM STRENGTH  
THREAD LOCKER (BLUE) TO THREADS.  
TIGHTEN TO 11 IN-LB TORQUE.



TIGHTEN TO 11 IN-LB TORQUE.



PLUNGER,  
NOT REPLACEABLE



APPLY MEDIUM STRENGTH  
THREAD LOCKER (BLUE) TO THREADS.  
TIGHTEN TO 80 IN-LB TORQUE.

| N/A | N/A | 1S1010   | INSTRUCTION SHEET                 |                              |                             |                           |
|-----|-----|----------|-----------------------------------|------------------------------|-----------------------------|---------------------------|
| N/A | N/A | 61100112 | KIT, SPRING                       |                              |                             |                           |
| N/A | N/A | 6V100532 | KIT, SEAL, FKM                    |                              |                             |                           |
| N/A | N/A | 60100532 | KIT, SEAL, STANDARD               |                              |                             |                           |
| 9   | 1   | 39V50030 | WIPER, PRESS-IN                   | X                            | X                           |                           |
| 8   | 1   | 39H55011 | GASKET                            | X                            | X                           |                           |
| 7   | 1   | 81060905 | STUD, SPRING, WS, AA, 2500&11KN   |                              |                             |                           |
| 6   | 1   | 39051054 | O-RING                            | X                            | 39V51054                    |                           |
| 5   | 1   | 39050035 | O-RING                            | X                            | 39V50035                    |                           |
| 4   | 1   | 30802313 | INSERT, THD, 3/8-16, WS, AA, 2500 |                              |                             |                           |
| 3   | 1   | 23350011 | SPRING                            |                              |                             | X                         |
| 2   | 1   | 21430020 | WASHER                            |                              |                             | X                         |
| 1   | 1   | 21410075 | BUTTON HEAD CAP SCREW             |                              |                             | X                         |
| No. | QTY | PART No. | DESCRIPTION                       | Included in<br>Std. Seal Kit | Included in<br>FKM Seal Kit | Included in<br>Spring Kit |

## PARTS LIST



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

ASSEMBLIES AFFECTED

10060906

10060906F

PARTS LIST, ASSY, WS, AA, CM, 2500

SIZE  
A

PL1056

REV  
A

|         |                        |  |            |          |
|---------|------------------------|--|------------|----------|
| A       | 1946                   | RELEASE                                      | JDW        | 11-19-08 |
| REV     | IN ACCORDANCE WITH ECN | EFFECTIVE DATE                               | REVISED BY | DATE     |
| DRW BY: | JDW                    | DRAWING STATUS: <b>Released</b>              |            |          |
| DATE:   | 9-23-08                | PRODUCTION APPROVED FOR RELEASED STATUS ONLY |            |          |

FORM FEG035\_PL\_ASIZE, REV. A

SHEET 1 OF 1

|   |                              |                   |                           |                 |
|---|------------------------------|-------------------|---------------------------|-----------------|
| Vekttek, Inc.<br>1334 East Sixth Ave.<br>P.O. Box 625<br>Emporia, Ks. 66801<br>U.S.A. | <b>Instruction<br/>Sheet</b> | <b>IS1010</b>     |                           |                 |
|   |                              | <b>REVISION:</b>  | <b>A , I.A.W. ECN1945</b> |                 |
|   |                              | <b>BY/DATE:</b>   | <b>JDW</b>                | <b>11-19-08</b> |
|   |                              | <b>APPR/DATE:</b> | <b>JAM</b>                | <b>12-15-08</b> |
| <b>TITLE: Disassembly/Assembly: 2500 lb &amp; 11 kN Air Advance Work Supports</b>     |                              |                   |                           |                 |

## Read all instructions before disassembly

Refer to the illustration on page three for component numbers and a tool list.

## Disassembly

**Notice: When disassembling multiple work supports, the plunger and body/sleeve assembly from each work support should be kept together.**

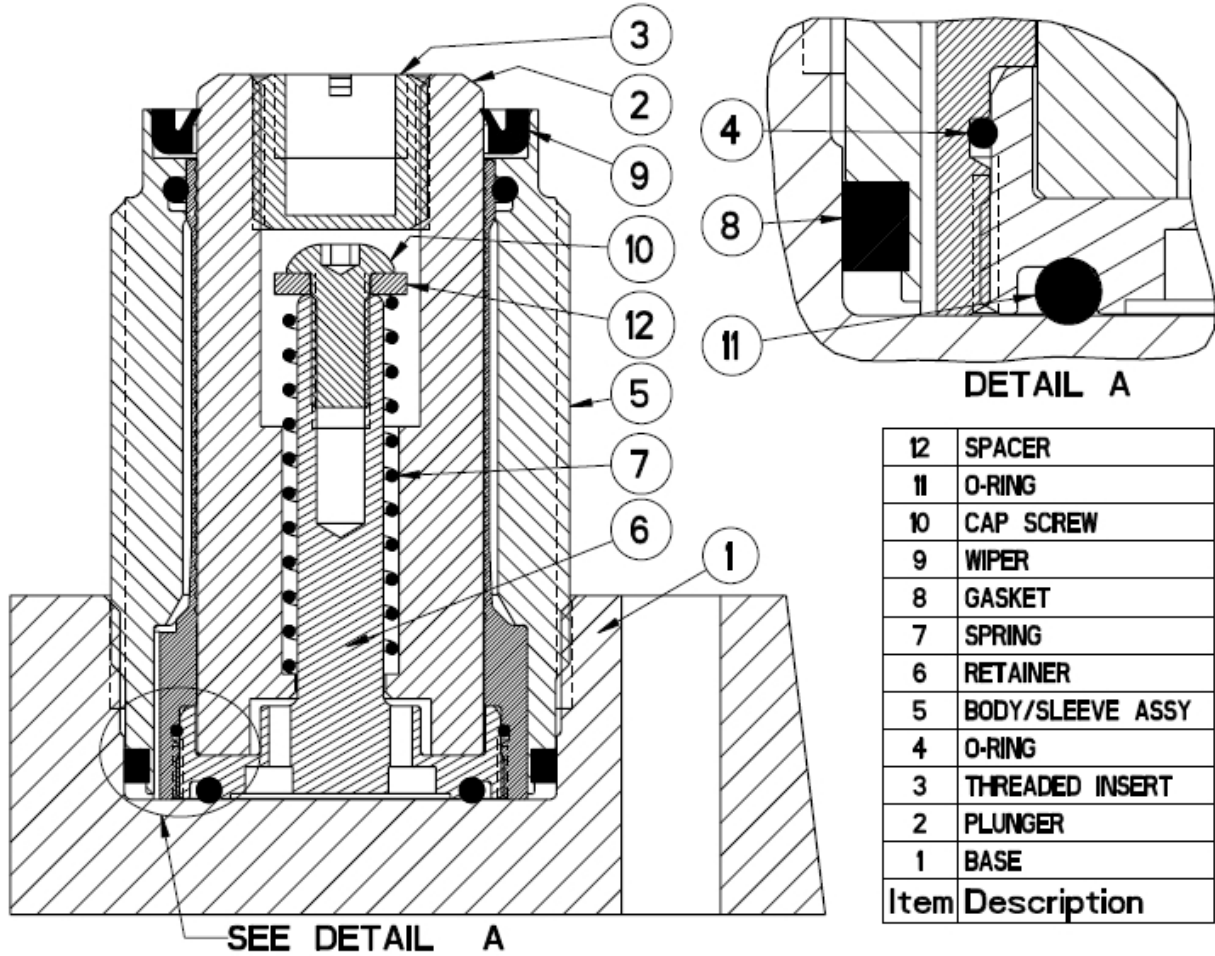
1. Clamp the work support base (1) in a vise. Cartridge mounted work supports must remain in their fixture for steps two and three.
2. Connect a hydraulic power supply to the work support. Apply hydraulic pressure (approximately 1000 psi) to lock the plunger (2) in place.
3. Remove the threaded insert (3) from the plunger (2).
4. Release the hydraulic pressure and disconnect the hydraulic line.
5. Remove the body/sleeve assembly (5) from the base (1) or fixture.  
**Caution--Use a six-point socket only. Other types of wrenches may damage the work support.**
6. Remove O-ring (11) and gasket (8).
7. Unscrew cap screw (10) and remove spacer (12) and spring (7) from the plunger (2).
8. Unscrew the retainer (6) from the body/sleeve assembly (5).
9. Slide the plunger (2) out of the body/sleeve assembly (5).
10. Remove O-ring (4) from the internal groove in the body/sleeve assembly (5).
11. Remove the wiper (9) from the body/sleeve assembly (5). **Caution--Do not damage the inner sleeve of the body/sleeve assembly (5).**
12. Clean all parts thoroughly and set aside to dry.

|   |                              |                   |  |
|---|------------------------------|-------------------|--|
| Vekttek, Inc.<br>1334 East Sixth Ave.<br>P.O. Box 625<br>Emporia, Ks. 66801<br>U.S.A. | <b>Instruction<br/>Sheet</b> | <b>IS1010</b>     |  |
|   |                              | <b>REVISION:</b>  | <b>A , I.A.W. ECN1945</b>                  |
|   |                              | <b>BY/DATE:</b>   | <b>JDW                      11-19-08</b>   |
|   |                              | <b>APPR/DATE:</b> | <b>JAM                        12-15-08</b> |
| <b>TITLE: Disassembly/Assembly: 2500 lb &amp; 11 kN Air Advance Work Supports</b>     |                              |                   |  |

## Assembly

1. Before assembly, lubricate the gasket (8) and O-rings (4) & (11) with clean hydraulic oil (Vekttek 65-0010-01 or equivalent). Apply Loctite primer N® or equivalent to the threads of the threaded insert (3), retainer (6) and allow to dry.
2. Press the wiper (9) into the body/sleeve assembly (5), using only enough force to seat the wiper in the counterbore. **Caution--Excess force may cause the inner sleeve to collapse.**
3. Insert the retainer (6) into the plunger (2).
4. Install the spring (7) and then spacer (12) onto the retainer (6). Apply one drop of low strength Loctite 222® or equivalent, to the cap screw (10) threads and tighten to the torque specification on the parts list.
5. Place the O-ring (4) into the internal groove in the body/sleeve assembly (5). Apply one drop of medium strength Loctite 243® or equivalent, to the retainer (6) threads and insert the plunger (2) and retainer (6) assembly into the body/sleeve assembly (5). Tighten to the torque specification on the parts list.
6. Install the O-ring (11) on the retainer (6), and the gasket (8) onto the body/sleeve assembly (5).
7. Insert the body/sleeve assembly (5) into the base (1) or fixture cavity and tighten to the torque specification on the parts list. **Caution--Use a six-point socket only. Other types of wrenches may damage the work support.**
8. Connect the hydraulic power supply to the work support. Apply hydraulic pressure (approximately 1000 psi) to lock the plunger (2) in place.
9. Apply one drop of medium strength Loctite 243® or equivalent to the threaded insert (3) and tighten to the torque specification on the parts list.
10. Release the pressure and disconnect the hydraulic line.

|   |                          |     |           |                   |
|---|--------------------------|-----|-----------|-------------------|
| Vekttek, Inc.<br>1334 East Sixth Ave.<br>P.O. Box 625<br>Emporia, Ks. 66801<br>U.S.A. | <b>Instruction Sheet</b> |     | IS1010    |                   |
|   |                          |     | REVISION: | A, I.A.W. ECN1945 |
|   | BY/DATE:                 | JDW | 11-19-08  |                   |
|   | APPR/DATE:               | JAM | 12-15-08  |                   |
| <b>TITLE: Disassembly/Assembly: 2500 lb &amp; 11 kN Air Advance Work Supports</b>     |                          |     |           |                   |



| Model Number                                     | Tool List   |
|--|---|
| 10060906<br>10060907<br>10060908                 | 3/32 hex key, spanner wrench,<br>screwdriver, 1-1/8 socket (6 pt) |
| 41006106<br>41006006<br>6964L-11-1<br>6964L-11-2 | 3/32 hex key, spanner wrench,<br>screwdriver, 30mm socket (6 pt)  |