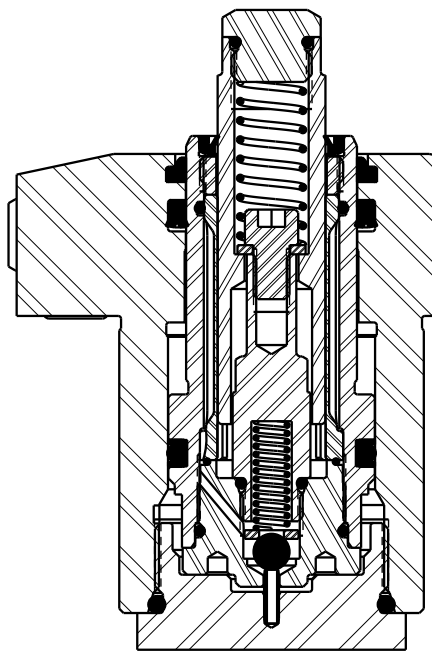


No.	QTY	PART No.	DESCRIPTION	STANDARD SEAL KIT	FKM SEAL KIT	SPRING KIT	INCLUDED IN SUB-ASM 91-0000-28
N/A	N/A	1S1015	INSTRUCTION SHEET				
N/A	N/A	61100523	KIT, SPRING				
N/A	N/A	6V100201	KIT, SEAL, FKM				
N/A	N/A	60100201	KIT, SEAL, STANDARD				
24	1	39V10022	WIPER,PRESS-IN, (3/4)	X	X		X
23	1	39H52032	SEAL,T, (1 3/16 X 1/8 X 1 7/16)	X	39V52040		X
22	1	39H52031	SEAL, BEVEL, 1 3/16 X 1/8 X 1 7/16	X	39V52039		
21	1	39F54009	BU RING,(-217)	X	X		
20	1	91000028	ASSY, SHUTTLE, WS, DA, CGS, 2750				
19	1	81071001	CAP, BODY, WS, DA, CGS, 2750				
18	1	81042003	STUD, WS, DA, CGS, 2750				X
17	1	81040608	BOLT, CONTACT, WS, DA, CGS, 2750				X
16	1	81000808	BODY, WS, DA, CGS, 2750				
15	2	39055011	SEAL, BONDED, M3				
14	1	39053031	WIPER,SNAP-IN, 1 3/16	X	X		
13	1	39051058	O-RING, (-920)	X	39V51058		
12	2	39051025	O-RING, (-011)	X	X		
11	1	39000072	O-RING, (-013)	X	39V50047		X
10	1	39000024	O-RING, (-904)	X	39V00024	X	X
9	2	30601144	PLUG, SOCH, SAE 4				
8	2	23600002	BALL, STEEL, ALLOY, .250				X
7	1	23530000	PIN, SPRING, COIL TYPE, 3/32 X 3/8, SST				
6	1	23355006	SPRING, COMPRESSION			X	X
5	1	23311016	SPRING, COMPRESSION			X	X
4	2	21500019	SCREW, CAP, BTNH, M3 X 6, ALY				
3	1	21430034	WASHER				X
2	1	21430020	WASHER				X
1	1	21411030	SCREW,CAP,SOCH,1/4-28 X 3/8,ALY,SLFLKG				X



SECTION A-A

SEE 1S1015 FOR SERVICE INSTRUCTIONS

LUBRICATE ALL SEALS WITH CLEAN HYDRAULIC OIL PRIOR TO ASSEMBLY

DO NOT USE SILICONE BASED LUBRICANTS



**PARTS LIST**



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

ASSEMBLIES AFFECTED

PARTS LIST, ASSY, WS, DA, CGS, TF, 2750

10-0208-00

10-0208-00F

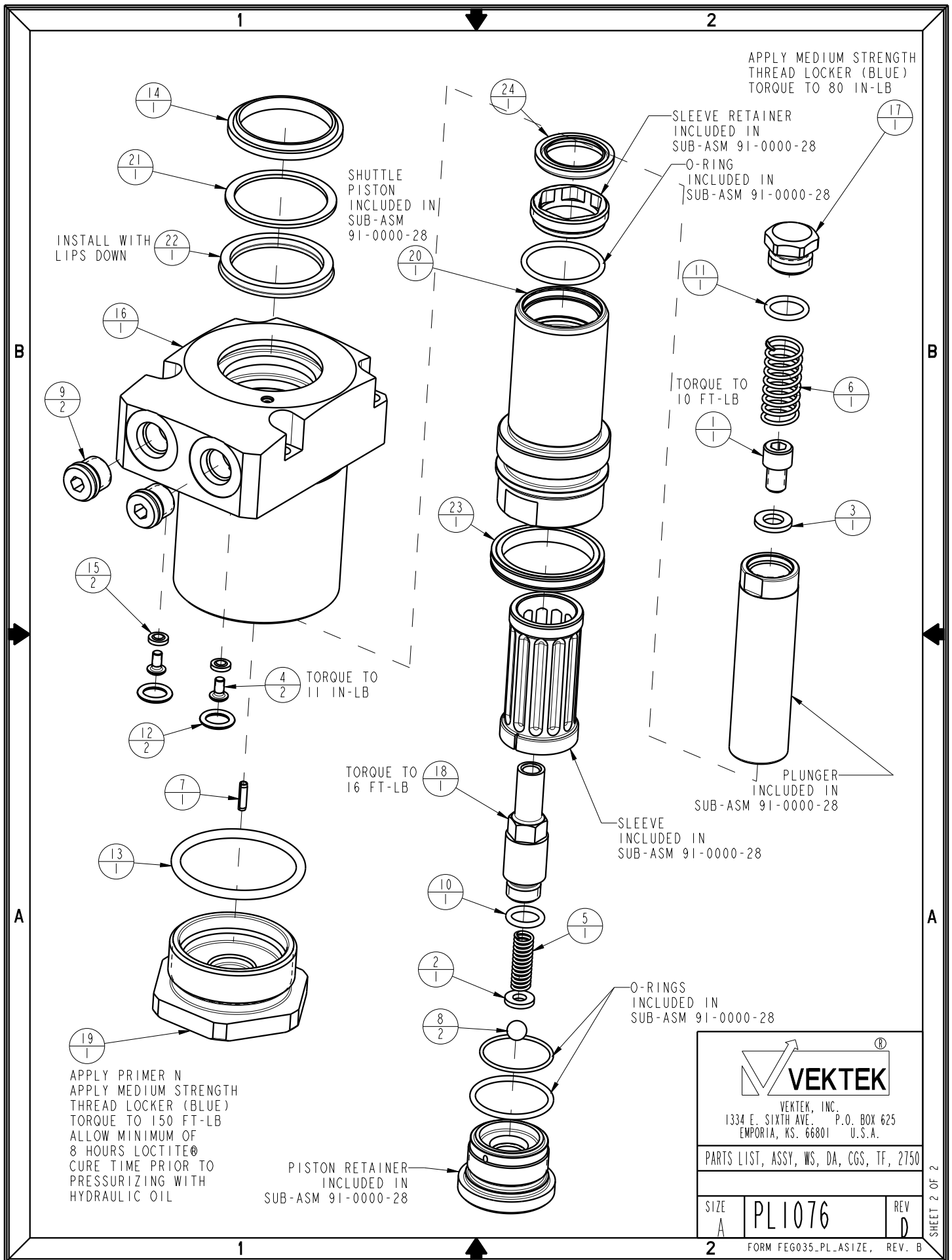
SIZE  
A

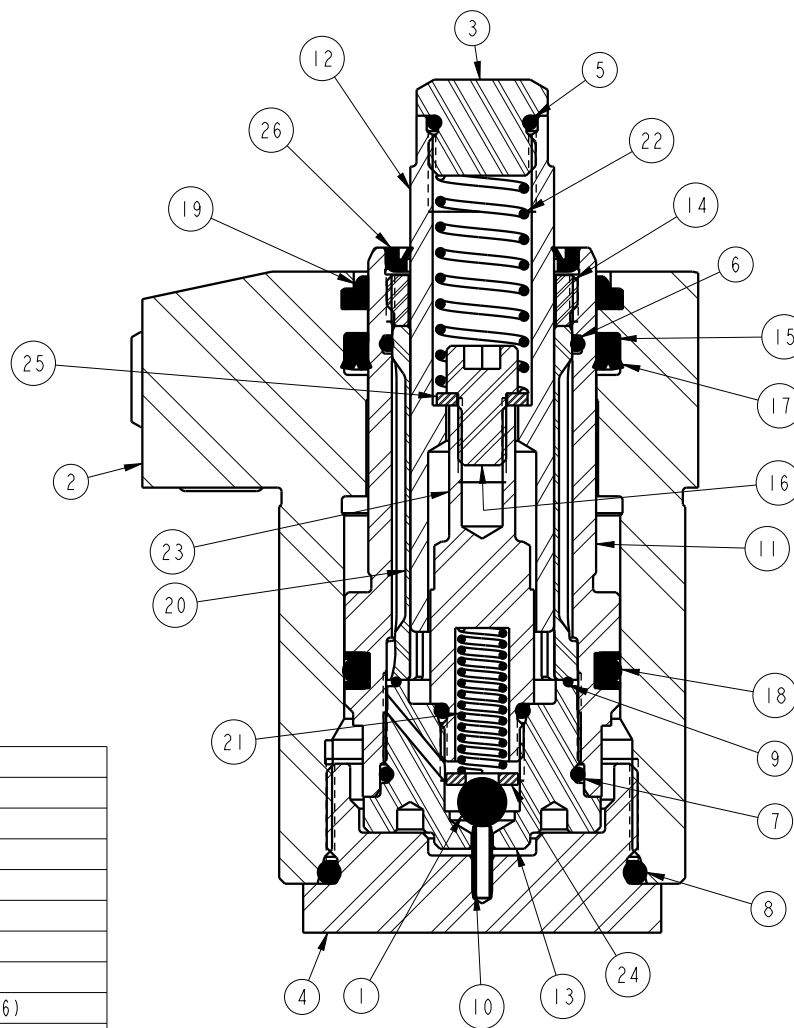
PL1076

REV  
D

D	3060	RELEASE	DLG	7/18/16
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY: ALUTHI	<b>DRAWING STATUS: Released</b>			
DATE: 10-9-09	PRODUCTION APPROVED FOR RELEASED STATUS ONLY			

SHEET 1 OF 2





SECTION A-A

26	WIPER,PRESS-IN, (3/4)
25	WASHER
24	WASHER
23	STUD, WS, DA, CGS, 2750
22	SPRING, COMPRESSION
21	SPRING, COMPRESSION
20	SLEEVE, WS, DA, CGS, 2750
19	WIPER,SNAP-IN, 1 3/16
18	SEAL,T, (1 3/16 X 1/8 X 1 7/16)
17	SEAL, BEVEL, 1 3/16 X 1/8 X 1 7/16
16	SCREW,CAP,SOCH,1/4-28 X 3/8,ALY,SLFLKG
15	BU RING, (-217)
14	RETAINER, SLEEVE, WS, DA, CGS, 2750
13	RETAINER, PISTON, WS, DA, CGS, 2750
12	PLUNGER, WS, DA, CGS, 2750
11	PISTON, SHUTTLE, WS, DA, CGS, 2750
10	PIN, SPRING, COIL TYPE, 3/32 X 3/8, SST
9	O-RING, (5-708)
8	O-RING, (-920)
7	O-RING, (-904)
6	O-RING, (-021)
5	O-RING, (-013)
4	CAP, BODY, WS, DA, CGS, 2750
3	BOLT, CONTACT, WS, DA, CGS, 2750
2	BODY, WS, DA, CGS, 2750
1	BALL, STEEL, ALLOY, .250
<b>No.</b>	<b>DESCRIPTION</b>

MODEL NUMBER	TOOL LIST
10-0208-00 10-0208-00F	1-7/8 SOCKET (6 pt.) 5/8 & 11/16 wrenches 3/16 hex key 7/16 deep well socket

**INSTALLATION INSTRUCTIONS**



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

ASSEMBLIES AFFECTED  
10-0208-00  
10-0208-00F

INSTRUCTION SHEET, WS, DA, CGS, TF, 2750

SIZE  
A 1S1015

REV  
D

FORM FEG041-IS-ASIZE, REV. B

SHEET 1 OF 2

1

2

READ ALL INSTRUCTIONS BEFORE DISASSEMBLY


REFER TO THE ILLUSTRATION ON PAGE ONE FOR COMPONENT NUMBERS AND TOOL LIST

## DISASSEMBLY

1. Clamp work support body (2) in vise and using 1 7/8" six point socket remove bottom cap (4). Cap is installed with Loctite® and tightened to 150 ft-lbs so will require high torque to remove cap. Remove o-ring (8) from cap (4) and clean Loctite® off threads using a wire brush. CAUTION: USE 6 POINT SOCKET ONLY, OTHER TYPES OF WRENCHES MAY DAMAGE THE WORK SUPPORT.
2. Slide shuttle piston (11) sub-assembly out of body (2). Remove wiper (19), back-up ring (15), and bevel seal (17) from body (2). Remove T-seal (18) from shuttle piston (11).
3. Using 5/8 and 11/16 wrenches remove contact bolt (3) from plunger. Remove spring (22) and o-ring (5).
4. Clamp shuttle piston (11) in vise clamping on the flats near the bottom. Remove SHCS (16) and washer (25), plunger can now be removed.
5. Using 7/16 deep well socket remove stud (23) from piston retainer (13) and remove o-ring (7) from stud. Remove spring (21), washer (24), and ball (1).
6. Using small flat blade screw driver, remove wiper (26) from shuttle piston (11). CAUTION: DO NOT DAMAGE INSIDE OF SLEEVE (20) OR SLEEVE RETAINER (14).
7. DO NOT REMOVE SLEEVE RETAINER (14) OR PISTON RETAINER (13) FROM SHUTTLE PISTON (11). DOING SO WILL VOID PRODUCT WARRANTY!
8. Clean all parts thoroughly and set aside to dry.

## ASSEMBLY

1. Lubricate o-rings (5), (8) & (7), T-seal (18), bevel seal (17), back-up ring (15) and wiper (19) with clean hydraulic oil (Vektek 65-0010-01 or equivalent). Apply Loctite® primer N or equivalent to the threads of the cap (4), threads of body (2) and contact bolt (3), then allow to dry.
2. Install ball (1), washer (24), spring (21) into piston retainer (13) through top of shuttle piston (11). Install o-ring (7) on SAE 4 boss of stud (23). Torque stud into piston retainer, 16 ft-lb.
3. Press wiper (26) into top of shuttle piston (11) using only enough force to seat wiper into counterbore. CAUTION: EXCESS FORCE MAY CAUSE DAMAGE TO WIPER.
4. Slide plunger (12) into sleeve (20). Install washer (25) and SHCS (16), torque to 10 ft-lb. Install spring (22) into plunger (12). Install o-ring (5) onto contact bolt (3) and apply medium strength Loctite® (blue) to threads. Thread contact bolt (3) into plunger (12) and torque to 80 in-lb. Plunger should freely move up and down in sleeve without binding or dragging. Spring force should return plunger to full stroke without sticking.
5. Install T-seal (18) onto shuttle piston (11) with round bulb facing out. Install back-up rings on each side of T-seal bulb. Make sure back-up rings are seated.
6. Install bevel seal (17) into body (2) with lips facing piston bore, push to bottom of groove, then install back-up ring (15). Install snap-in wiper (19) into body (2). Make sure seals are not rolled.
7. Slide shuttle piston (11) subassembly into body (2) bore and ensure that piston seal back-up rings do not catch in threads. Shuttle piston should slide smoothly up and down in bore.
8. Install o-ring (8) onto cap (4) and apply medium strength Loctite® (blue) to threads. Immediately thread cap (4) into body (2) and torque to 150 ft-lb. Allow 8 hours of Loctite® cure time before pressurizing device with hydraulic oil.

		
VEKTEK, INC. 1334 E. SIXTH AVE. P.O. BOX 625 EMPORIA, KS. 66801 U.S.A.		
INSTRUCTION SHEET, WS, DA, CGS, TF, 2750		
SIZE A	1S1015	REV D
FORM FEG035_PL_ASIZE, REV. B		

1

2