

Lubricate all seals with clean hydraulic oil prior to assembly.
Do not use silicone based lubricants.

Coat cylinder bore, outside of both pistons and inside of bearing with lithium grease.

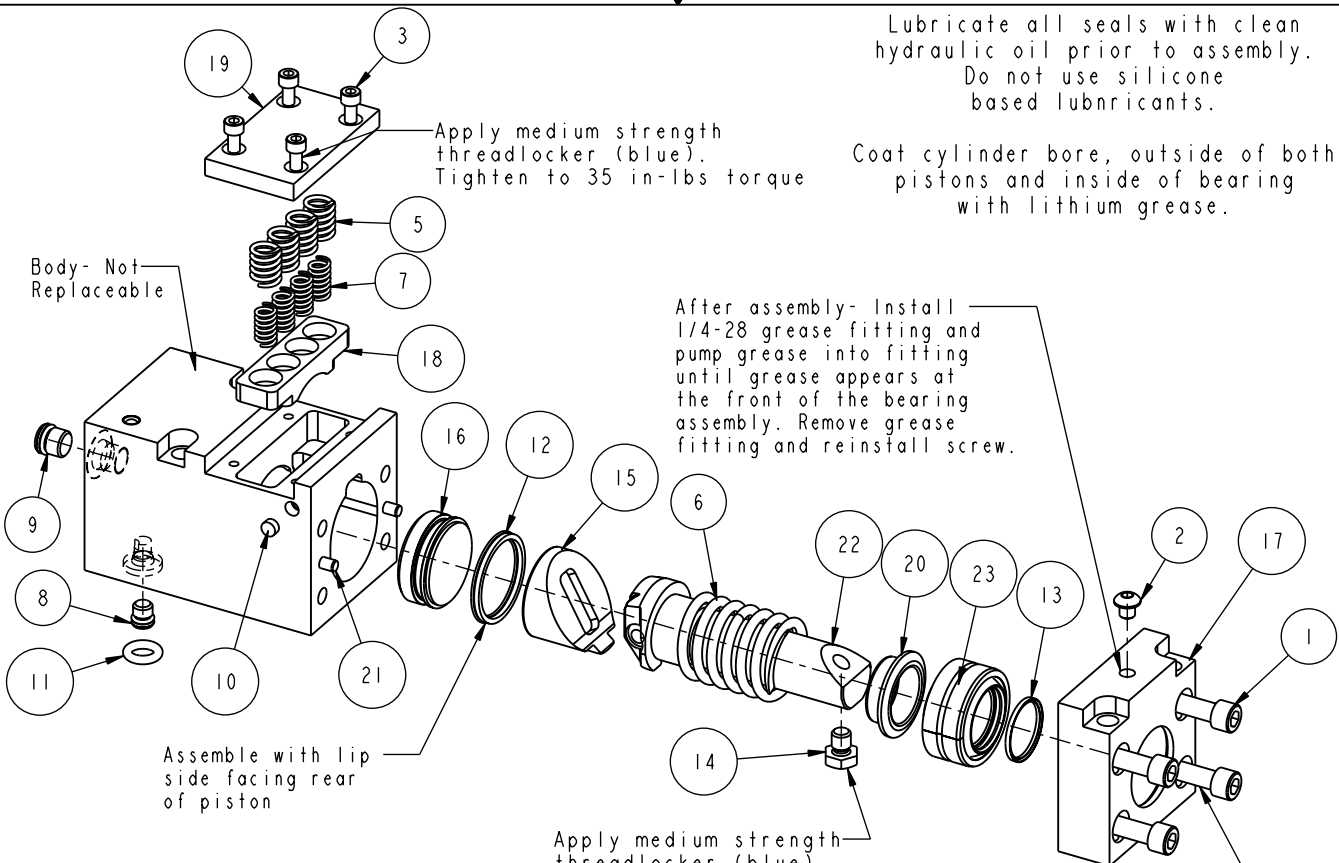
After assembly- Install 1/4-28 grease fitting and pump grease into fitting until grease appears at the front of the bearing assembly. Remove grease fitting and reinstall screw.

Apply medium strength threadlocker (blue). Tighten to 35 in-lbs torque.

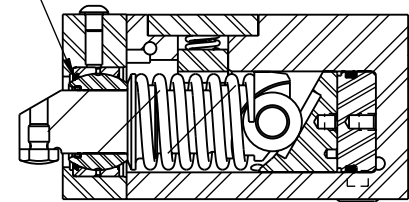
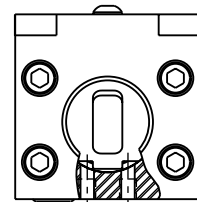
Apply medium strength threadlocker (blue). Tighten to 30 ft-lbs torque.

Wiper supplied with bearing assembly.

Thread in equally, until both screws are tight.



NO	QTY	PART NO	DESCRIPTION	STD SEAL KIT	FKM SEAL KIT	SPRING KIT
1	4	21410025	SCREW, CAP, SOCH, 5/16-24 X 3/4, ALY			
2	1	21410045	BHCS, 1/4-28 x 1/4, ALY			
3	4	21410047	SCREW, CAP, SOCH, 10-24 X 3/8, ALY			
4	2	21440018	SHSS, DOG POINT, 1/4-20x.31			
5	4	23350020	Spring, .51x.07x.721x.371,111,SST			X
6	1	23350024	Spring,1.424x.16x2.61x.89,98,SST			X
7	4	23350056	Spring,.36x.055x.69x.36,100,MW			X
8	1	30601122	PLUG, SOCH, SAE 2			
9	2	30601144	PLUG, SOCH, SAE 4			
10	2	31091006	FILTER, BRONZE, SINTERED, .250, 150µ			
11	1	39000050	O-RING, (1-204), .359x.139,70 AUD	X	39051022	
12	1	39011028	SEAL,BEV,1-5/16x3/32x1-1/2,85 AU	X	39012015	
13	1	39050064	SEAL, ROD	X	X	
14	1	64211002	END EFFECTOR, RETR CLAMP, 3300			
15	1	81511705	PISTON, FRONT, RETR CLAMP, 3300			
16	1	81511706	PISTON, REAR, RETR CLAMP, 3300			
17	1	81581302	MOUNT, CLAMP, RETRACT, 3300			
18	1	81592016	SPRING GUIDE			
19	1	81592017	COVER, CLAMP, RETRACT, 3300			
20	1	81592020	SEAT, SPRING, CLAMP, RETRACT, 3300			
21	2	90199925	PIN, DOWEL, 3/16 X 1/2, STD, STL, HDN			
22	1	91511302	ASSY, ARM, CLAMP, RETRACT, 3300			
23	1	91592014	ASSY, BEARING, CLAMP, RETR, 3300			
N/A	N/A	60156101	KIT, SEAL	NOTED	N/A	N/A
N/A	N/A	6V156101	KIT, SEAL, FKM	N/A	NOTED	N/A
N/A	N/A	46100039	KIT, SPRING	N/A	N/A	NOTED



PARTS LIST



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

ASSEMBLIES AFFECTED
15410803

PARTS LIST, ASSY, CLAMP, RETRACT, 3300

J	2364	RELEASE	JDW	2/11/12
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY:	ROMINE	DRAWING STATUS: Released		
DATE:	6/28/99	PRODUCTION APPROVED FOR RELEASED STATUS ONLY		

SIZE A PL1591 REV J