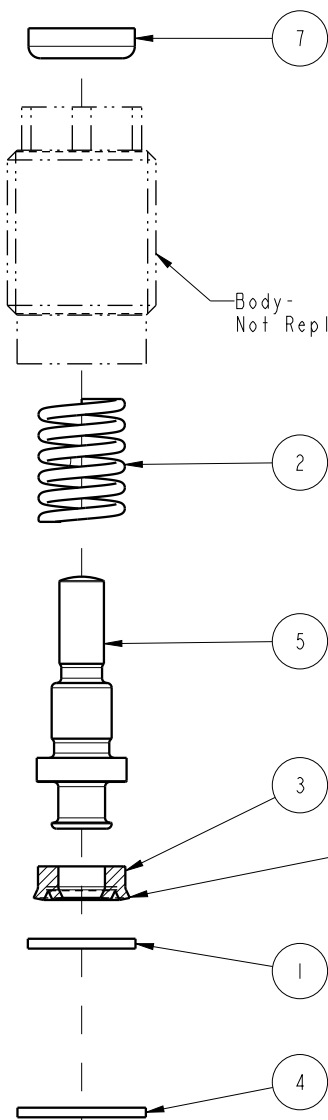


NO	QTY	PART NO	DESCRIPTION	STD SEAL KIT	FKM SEAL KIT	SPRING KIT
1	1	23050011	WASHER	X	X	X
2	1	23311015	SPRING, COMPRESSION			
3	1	39010011	SEAL, BEVEL, 3/16 X 3/32 X 3/8	X	39V10011	
4	1	39010034	GASKET, COPPER	X	X	X
5	1	82110400	PISTON, CYL, CM, 550/2.4KN.188/5mm STRK			
6	1	39T55008	GASKET. (.375 x .080 x .080)	X	X	X
7	1	39V10035	WIPER, PRESS-IN, (3/16)	X	X	
N/A	N/A	60210104	KIT, SEAL	NOTED	N/A	N/A
N/A	N/A	6V210104	KIT, SEAL, FKM	N/A	NOTED	N/A
N/A	N/A	6I210004	KIT, SPRING,	N/A	N/A	NOTED



See IS-2100 for machining and installation instructions.


Lubricate all seals with clean hydraulic oil prior to assembly.
DO NOT USE SILICONE BASED LUBRICANTS.

INSTALLATION TORQUE:

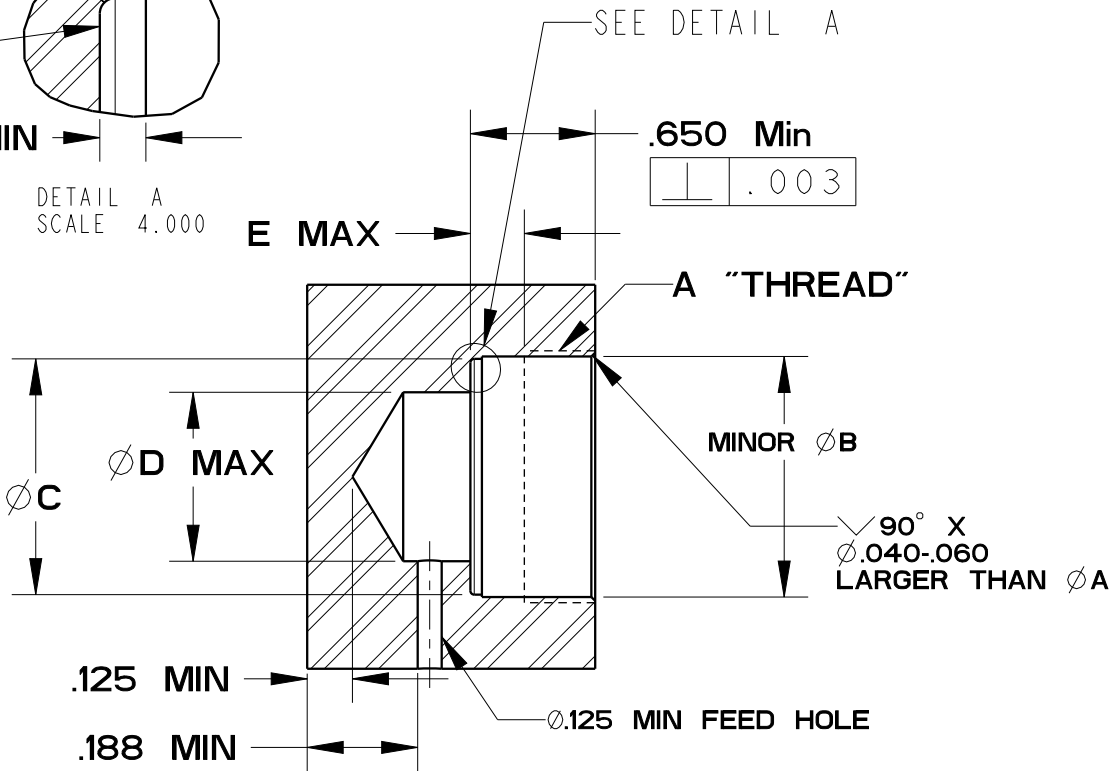
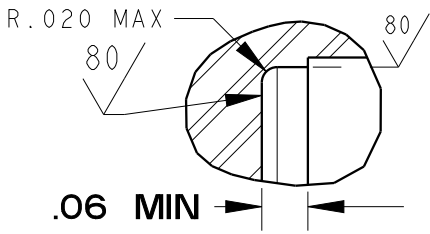
- Metal Gasket = 30 ft-lb
- Composite Gasket = 15 ft-lb
- *Cylinders may need to be re-torqued after a break-in period of 3 weeks or 2,500 cycles for both gasket styles.

Both metal and composite gaskets are supplied. Use only one gasket. The metal gasket is recommended when the cavity seal surface has every smooth finish and is flat and perpendicular to the minor diameter. The metal gasket must be torqued to a higher value, which is more resilient to machining vibrations providing long term sealing. The composite gasket is recommended when the cavity seal surface has a rough surface finish or is not flat.

USE ONLY ONE GASKET

PARTS LIST	 VEKTEK, INC. 1334 E. SIXTH AVE. P.O. BOX 625 EMPORIA, KS. 66801 U.S.A.	
	ASSEMBLIES AFFECTED	PARTS LIST, ASSY, CYL, CM, 550, .18 STRK, SA
21-0104-02		
21-0104-02F	SIZE A	REV S
	PL2102	

S	3997	RELEASE	JDW	01/28/20
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY:	JACOB	DRAWING STATUS: Released PRODUCTION APPROVED FOR RELEASED STATUS ONLY		
DATE:	10-05-90			




Tighten cylinders with a six point socket only !

Model No.	A	Metal Gasket Torque	Composite Gasket Torque	ØB	ØC	D	E
21-0102-00	3/8-24 UNF-2B	10 ft lb	NA	.335±.003	.325±.005	.13	.100
21-0104-02	5/8-18 UNF-2B	30 ft lb	15 ft lb	.572±.003	.545±.005	.31	.156
21-0105-03	3/4-16 UNF-2B	40 ft lb	20 ft lb	.690±.003	.662±.005	.38	.156
21-0105-04	3/4-16 UNF-2B	40 ft lb	20 ft lb	.690±.003	.662±.005	.38	.156
21-0105-05	3/4-16 UNF-2B	40 ft lb	20 ft lb	.690±.003	.662±.005	.38	.156
21-0105-06	3/4-16 UNF-2B	40 ft lb	20 ft lb	.690±.003	.662±.005	.38	.156
21-0108-04	1 1/16-16 UN-2B	50 ft lb	25 ft lb	1.002±.003	.923±.005	.63	.281
21-0108-05	1 1/16-16 UN-2B	50 ft lb	25 ft lb	1.002±.003	.923±.005	.63	.281
21-0108-08	1 1/16-16 UN-2B	50 ft lb	25 ft lb	1.002±.003	.923±.005	.63	.281
21-0110-04	1 5/16-16 UN-2B	NA	35 ft lb	1.253±.003	1.228±.005	.88	.281

*Cylinders may need to be re-torqued after a break-in period of 3 weeks or 2,500 cycles for both gasket styles.

Instruction Sheet



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

Model number -See Chart-

Cavity Dimensions

Cartridge Mounted Cylinders

SIZE A **IS-2100** REV G

G	3041	RELEASE	BCD	11/9/16
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY:	VANDALSEM			
DATE:	04-13-93			
DRAWING STATUS: Released PRODUCTION APPROVED FOR RELEASED STATUS ONLY				