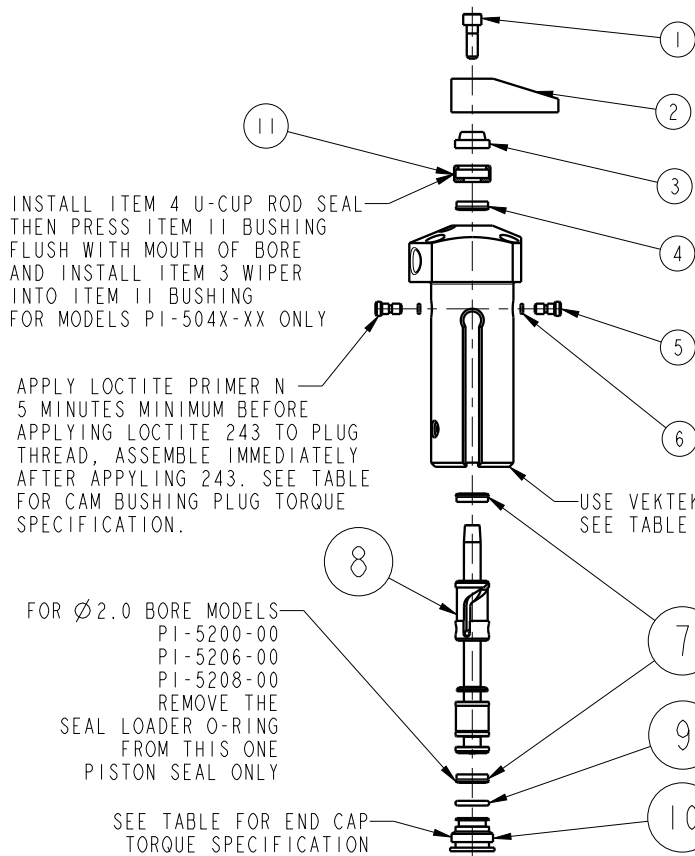


NO.	QTY.	DESCRIPTION	MODEL NUMBER						INCLUDED IN SEAL KIT
			PI-5040-00 PI-5046-00 PI-5048-00 (1/2 bore)	PI-5070-00 PI-5076-00 PI-5078-00 (7/8 bore)	PI-5110-00 PI-5116-00 PI-5118-00 (1 1/8 bore)	PI-5140-00 PI-5146-00 PI-5148-00 (1 1/2 bore)	PI-5200-00 PI-5206-00 PI-5208-00 (2 bore)	PI-5240-00 PI-5246-00 PI-5248-00 (2 1/2 bore)	
1	1	SOCKET HEAD CAP SCREW	21-4100-55	21-4100-53	21-4100-53	21-4100-54	21-4100-54	21-4100-54	NO
2	1	ARM	91-5005-03	91-5009-03	91-5009-03	91-5015-03	91-5015-03	91-5025-03	NO
3	1	ROD WIPER, SNAP-IN	39-0530-07	39-0530-08	39-0530-08	39-0530-06	39-0530-06	39-0530-09	YES
4	1	ROD SEAL, U-CUP	39-0520-20	39-0520-21	39-0520-21	39-0520-18	39-0520-18	39-0520-26	YES
5	2	PLUG, CAM BUSHING	81-5905-04	81-5915-08	81-5915-08	81-5915-08	81-5915-08	81-5915-11	NO
6	2	O-RING, PLUG	39-0000-32	39-0000-53	39-0000-53	39-0000-53	39-0000-53	39-0000-53	YES
7	2	PISTON SEAL, U-CUP/LOADED LIP	39-0520-20	39-0520-18	39-0520-24	39-0520-22	39-0520-73	39-0520-19	YES
8	1	ROD ASSEMBLY, RIGHT HAND (SHOWN)	P9-1504-01	P9-1507-01	P9-1511-01	P9-1514-01	P9-1520-01	P9-1524-01	NO
	1	ROD ASSEMBLY, LEFT HAND	P9-1504-02	P9-1507-02	P9-1511-02	P9-1514-02	P9-1520-02	P9-1524-02	NO
	1	ROD ASSEMBLY, STRAIGHT	P9-1504-03	P9-1507-03	P9-1511-03	P9-1514-03	P9-1520-03	P9-1524-03	NO
9	1	O-RING, END CAP	39-0000-31	39-0500-26	39-0500-85	39-0510-46	39-0510-47	39-0511-97	YES
10	1	END CAP	81-5305-03	81-5309-04	81-5311-00	81-5315-00	81-5320-00	81-5325-00	NO
11	1	BUSHING, SC, 1/2	81-5905-07	N/A	N/A	N/A	N/A	N/A	YES
N/A	N/A	TORQUE FOR CAM BUSHING PLUG	1-2 IN LB	3-4 IN LB	3-4 IN LB	3-4 IN LB	3-4 IN LB	3-4 IN LB	N/A
N/A	N/A	TORQUE FOR END CAP	4-6 IN LB	48-52 IN LB	48-52 IN LB	15-17 FT LB	15-17 FT LB	15-17 FT LB	N/A
N/A	N/A	SEAL KIT	60-1522-01	60-1522-02	60-1522-03	60-1522-04	60-1522-05	60-1522-06	N/A
N/A	N/A	VEKTEK SEAL INSERTION TOOL	AT-5015-01	AT-5015-02	AT-5015-03	AT-5015-04	AT-5015-05	AT-5015-06	N/A



INSTALL ITEM 4 U-CUP ROD SEAL THEN PRESS ITEM 11 BUSHING FLUSH WITH MOUTH OF BORE AND INSTALL ITEM 3 WIPER INTO ITEM 11 BUSHING FOR MODELS PI-504X-XX ONLY

APPLY LOCTITE PRIMER N 5 MINUTES MINIMUM BEFORE APPLYING LOCTITE 243 TO PLUG THREAD, ASSEMBLE IMMEDIATELY AFTER APPLYING 243. SEE TABLE FOR CAM BUSHING PLUG TORQUE SPECIFICATION.

FOR Ø2.0 BORE MODELS  
PI-5200-00  
PI-5206-00  
PI-5208-00  
REMOVE THE SEAL LOADER O-RING FROM THIS ONE PISTON SEAL ONLY

SEE TABLE FOR END CAP TORQUE SPECIFICATION

DURING ASSEMBLY BE SURE THAT AS THE CAM BUSHING PLUGS (ITEM 5) ARE BEING TORQUED INTO THE BODY THAT THEY ENGAGE THE RETAINING HOLES IN THE CAM BUSHING LOCATED ON THE ROD ASSEMBLY (ITEM 8).

- NOTES:  
1. APPLY LUBRICANT TO ALL SEALS PRIOR TO INSTALLATION.  
2. SEE EN6000 FOR SEAL KITS.

USE VEKTEK SEAL INSERTION TOOL SEE TABLE

ASSEMBLIES AFFECTED		
PI-5040-00,	PI-5046-00,	PI-5048-00
PI-5070-00,	PI-5076-00,	PI-5078-00
PI-5110-00,	PI-5116-00,	PI-5118-00
PI-5140-00,	PI-5146-00,	PI-5148-00
PI-5200-00,	PI-5206-00,	PI-5208-00
PI-5240-00,	PI-5246-00,	PI-5248-00

### PARTS LIST



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

ASSEMBLIES AFFECTED  
SEE ABOVE FOR LIST

PARTS LIST, ASSY, SC, TF, PNEU

SIZE A PPL1501

REV F

F	5908	RELEASE	JDW	02/20/26
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY:	JDW	DRAWING STATUS: <b>Released</b>		
DATE:	04/04/05	PRODUCTION APPROVED FOR RELEASED STATUS ONLY		

SHEET 1 OF 1