


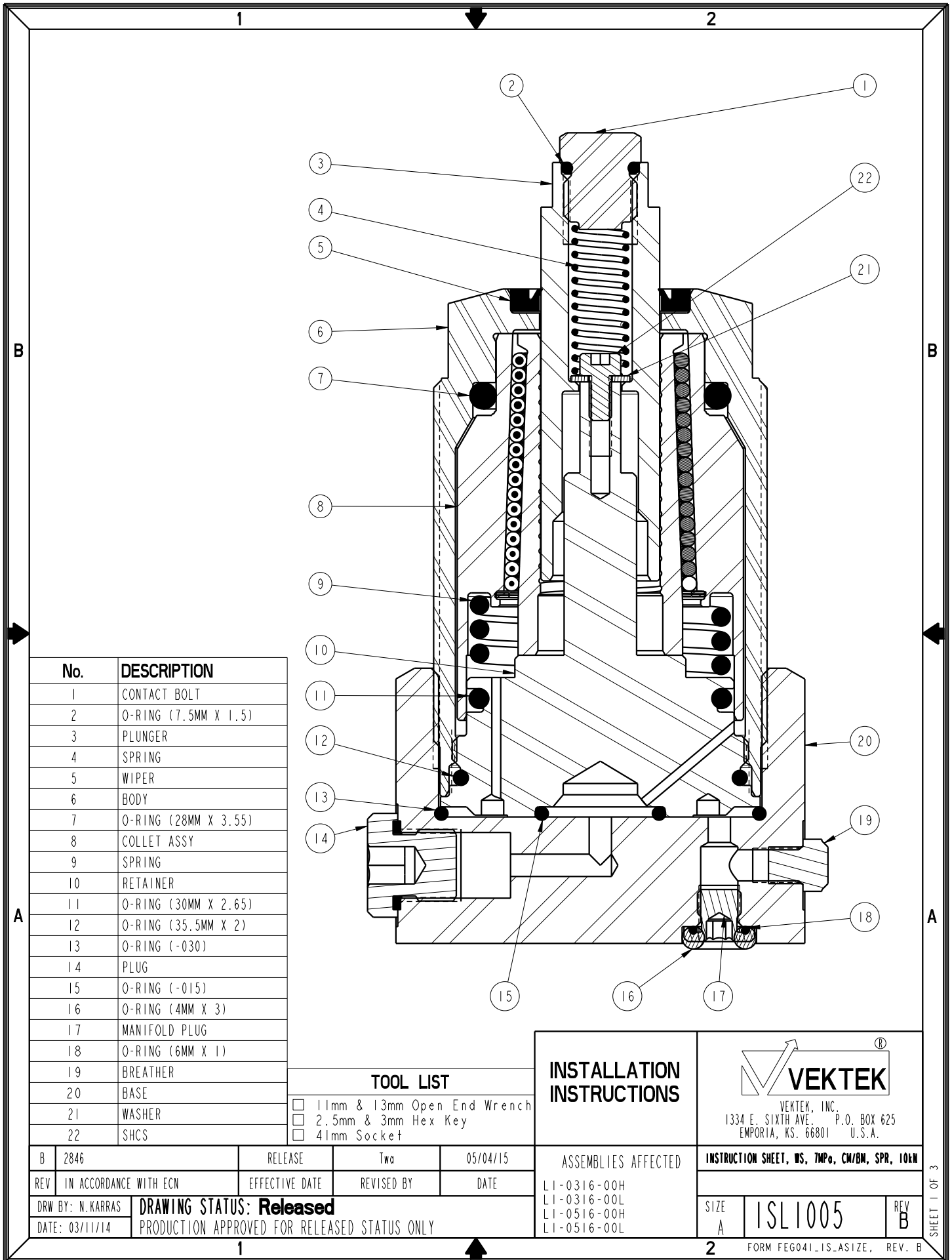
NO	QTY	PART NO	DESCRIPTION	STD SEAL KIT	LIGHT SPRING KITS	HEAVY SPRING KIT
1	1	23350091	SPRING, COMPRESSION			X
2	1	39000035	O-RING, (-015)	X		
3	1	39051091	O-RING, (7.5mm x 1.5)	X	X	X
4	1	39051099	O-RING, (-030)	X		
5	1	39051131	O-RING, (35.5mm X 2)			
6	1	39053048	WIPER, PRESS-IN, 16mm	X		
7	1	81000000	CONTACT BOLT, WS, 7MPa, 5.5 & 10kN			
7	1	23350090	SPRING, COMPRESSION		X	
N/A	N/A	L6010001	KIT, SEAL, WS, 7MPa, CM/BM, 10kN	NOTED	N/A	N/A
N/A	N/A	L6110002	KIT, SPRING, WS, 7MPa, SPR, 10kN	N/A	NOTED	N/A
N/A	N/A	L6110003	KIT, SPRING, WS, 7MPa, SPR, 10kN	N/A	N/A	NOTED
N/A	N/A	ISL1005	INSTRUCTION SHEET, WS, 7MPa, CM, SPR, 10kN	N/A	N/A	N/A

See Instruction Sheet ISL1005 For Service Instructions.
 Lubricate All Seals With Clean Hydraulic Oil Prior To Assembly.
 Do Not Use Silicone Base Lubricants.



PARTS LIST	 VEKTEK VEKTEK, INC. 1334 E. SIXTH AVE. P.O. BOX 625 EMPORIA, KS. 66801 U.S.A.
	PARTS LIST, ASSY, WS, 7MPa, CM, SPR, 10kN ASSEMBLIES AFFECTED L1-0316-00H L1-0316-00L
SIZE A	LPL1005
	REV C

C	2846	RELEASE	Twa	05/01/15
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY: N.KARRAS	DRAWING STATUS: Released			
DATE: 03/21/14	PRODUCTION APPROVED FOR RELEASED STATUS ONLY			



No.	DESCRIPTION
1	CONTACT BOLT
2	O-RING (7.5MM X 1.5)
3	PLUNGER
4	SPRING
5	WIPER
6	BODY
7	O-RING (28MM X 3.55)
8	COLLET ASSY
9	SPRING
10	RETAINER
11	O-RING (30MM X 2.65)
12	O-RING (35.5MM X 2)
13	O-RING (-030)
14	PLUG
15	O-RING (-015)
16	O-RING (4MM X 3)
17	MANIFOLD PLUG
18	O-RING (6MM X 1)
19	BREATHER
20	BASE
21	WASHER
22	SHCS

TOOL LIST	
<input type="checkbox"/>	11mm & 13mm Open End Wrench
<input type="checkbox"/>	2.5mm & 3mm Hex Key
<input type="checkbox"/>	41mm Socket

INSTALLATION INSTRUCTIONS

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

B	2846	RELEASE	Two	05/04/15
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY:	N. KARRAS	DRAWING STATUS: Released		
DATE:	03/11/14	PRODUCTION APPROVED FOR RELEASED STATUS ONLY		

ASSEMBLIES AFFECTED
 LI-0316-00H
 LI-0316-00L
 LI-0516-00H
 LI-0516-00L

INSTRUCTION SHEET, WS, 7MPo, CW/BM, SPR, 10xW	
SIZE A	ISL1005
REV B	

Read all instructions before disassembly

Refer to the illustration on page 1 for component part numbers and tool list

Disassembly


Model Number L1-0316-00H & L1-0316-00L

1. Using a 41mm socket, unscrew work support from fixture or base (20). Wipe clean to remove external contaminants.
2. Remove O-ring (15) from retainer (10) s'face or cavity. Be careful not to damage retainer (10) face.
3. Remove O-ring (13) from fixture or base (20) cavity.
4. With 13mm wrench at plunger (3) and 11mm wrench at contact bolt (1), unscrew contact bolt (1) from plunger (3). Remove O-ring (2) from contact bolt (1).
5. Remove contact spring (4) from inside plunger (3).
6. Insert 2.5mm hex key into cap screw (22) inside plunger (3) and unscrew cap screw (22). Remove cap screw (22) and washer (21) from inside plunger (3).
7. Gently slide plunger (3) out from top of work support.
8. Remove wiper (5) from top of body (6). Be careful not to damage wiper bore or bore below wiper (5). To assist holding body (6) during wiper (5) removal, body (6) may be threaded into base (20) or fixture, be careful not to damage the body (6) or retainer (10) face.
9. Thoroughly clean contact bolt (1), contact spring (4), plunger (3), cap screw (22), washer (21) and set aside to dry.
10. Wipe clean retainer (10) face located on bottom of work support. Wipe clean wiper bore located in body at top of work support.
11. Wipe clean work support cavity in fixture.

Model Number L1-0516-00H & L1-0516-00L

13. Remove work support base (20) from fixture and complete disassembly steps 1-10.
14. If work support hydraulics or vent is manifold fed from fixture, remove O-ring (16) from manifold s'face on base (19) mounting face (2 places).
15. If work support hydraulics or vent is not manifold fed, insert 3mm hex key into plug (17) located at base (19) mounting face and unscrew plug (17) (2 places). Remove O-ring (18) from plug (17).
16. Thoroughly clean base (20), plugs (17) and set aside to dry.

Caution: Do not expose work support clamping mechanism (8) located above retainer (10) to any type of cleaning solutions. Removal of retainer (10) or clamping mechanism (8) terminates product warranty.

		
VEKTEK, INC. 1334 E. SIXTH AVE. P.O. BOX 625 EMPORIA, KS. 66801 U.S.A.		
INSTRUCTION SHEET, WS, 7MPo, CW/BM, SPR, 10&N		
SIZE A	ISL1005	REV B
FORM FEG041-1S-ASIZE, REV. B		

