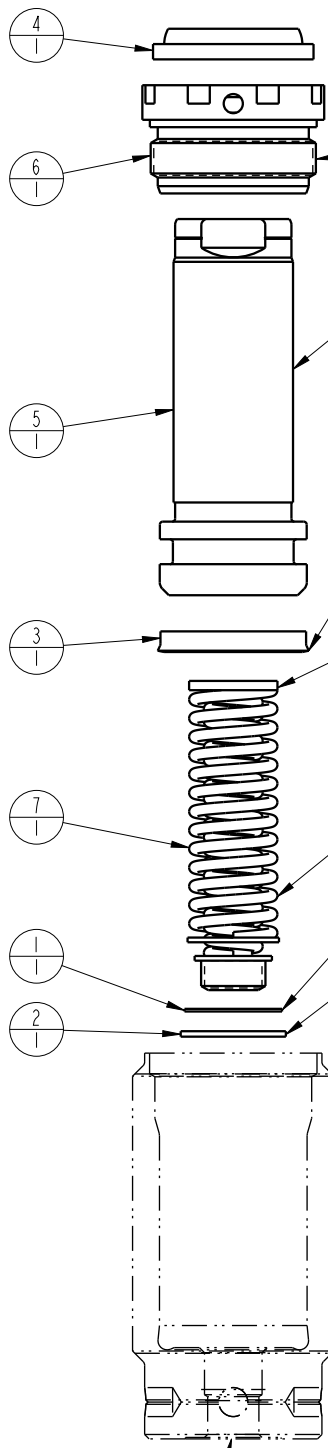


LUBRICATE ALL SEALS WITH CLEAN
HYDRAULIC OIL PRIOR TO ASSEMBLY.
DO NOT USE SILICONE BASED LUBRICANTS.



TIGHTEN TO 75 Nm TORQUE (55 FT-LBS)
USE VEKTEK TORQUE TOOL
NEW STYLE TORQUE TOOL AT200102, 8 POINTED TOOL (CIRCA 2018)
OLD STYLE TORQUE TOOL AT200100, 2 POINTED SPANNER HOLE TOOL

PISTON KIT INCLUDES PISTON
AND RETAINING RING 23050012

INSTALL WITH LIPS DOWN

SPRING PAK
REMOVAL - INSERT 1/8" INTERNAL HEX
WRENCH THRU BODY PORT INTO SPRING
PAK RETAINER AND ROTATE CLOCKWISE
AS VIEWED FROM BOTTOM.
(REINSTALL- REVERSE ABOVE PROCEDURE)

SPRING KIT 46100022
INCLUDES
SPRING PAC 92060002 AND BOTH RETAINING RINGS 23002002 & 23050012

RETAINING RING, 23002002 (NARROW GROOVE)
OLD STYLE

RETAINING RING, 23050012 (WIDE GROOVE)
CURRENT STYLE, CIRCA 08/01/2003

BODY,
NOT A REPLACEMENT PART

N/A	N/A	46100022	KIT, SPRING	N/A	N/A	NOTED
N/A	N/A	6V200110	KIT, SEAL, FKM	N/A	NOTED	N/A
N/A	N/A	46000028	KIT, SEAL, STANDARD	NOTED	N/A	N/A
7	I	92060002	SPRING PAK,CYL,3900,1.0 STRK			X
6	I	82031001	GLAND,CYL,TB,SA,3900 & 17.8KN			
5	I	62201001	Kit,Piston, Ring&Tag,17.8KN,25.5 STRK			
4	I	39012008	WIPER,SNAP-IN, (13/16)	X	X	
3	I	39010014	SEAL, BEVEL, 13/16 x 3/32 x 1	X	39012001	
2	I	23050012	SNAP RING, INTERNAL			X
1	I	23002002	SNAP RING, INTERNAL			X
No.	QTY	PART No.	DESCRIPTION	Standard Seal Kit	FKM Seal Kit	Spring Kit

PARTS LIST



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

J	4249	RELEASE	JDW	08/10/20
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY: BUSH	DRAWING STATUS: Released			
DATE: 12/13/94	PRODUCTION APPROVED FOR RELEASED STATUS ONLY			

ASSEMBLIES AFFECTED
42001004

PARTS LIST, ASSY,CYL,TB,17.8KN,25.5 STRK,SA		
SIZE A	MPL2047	REV J