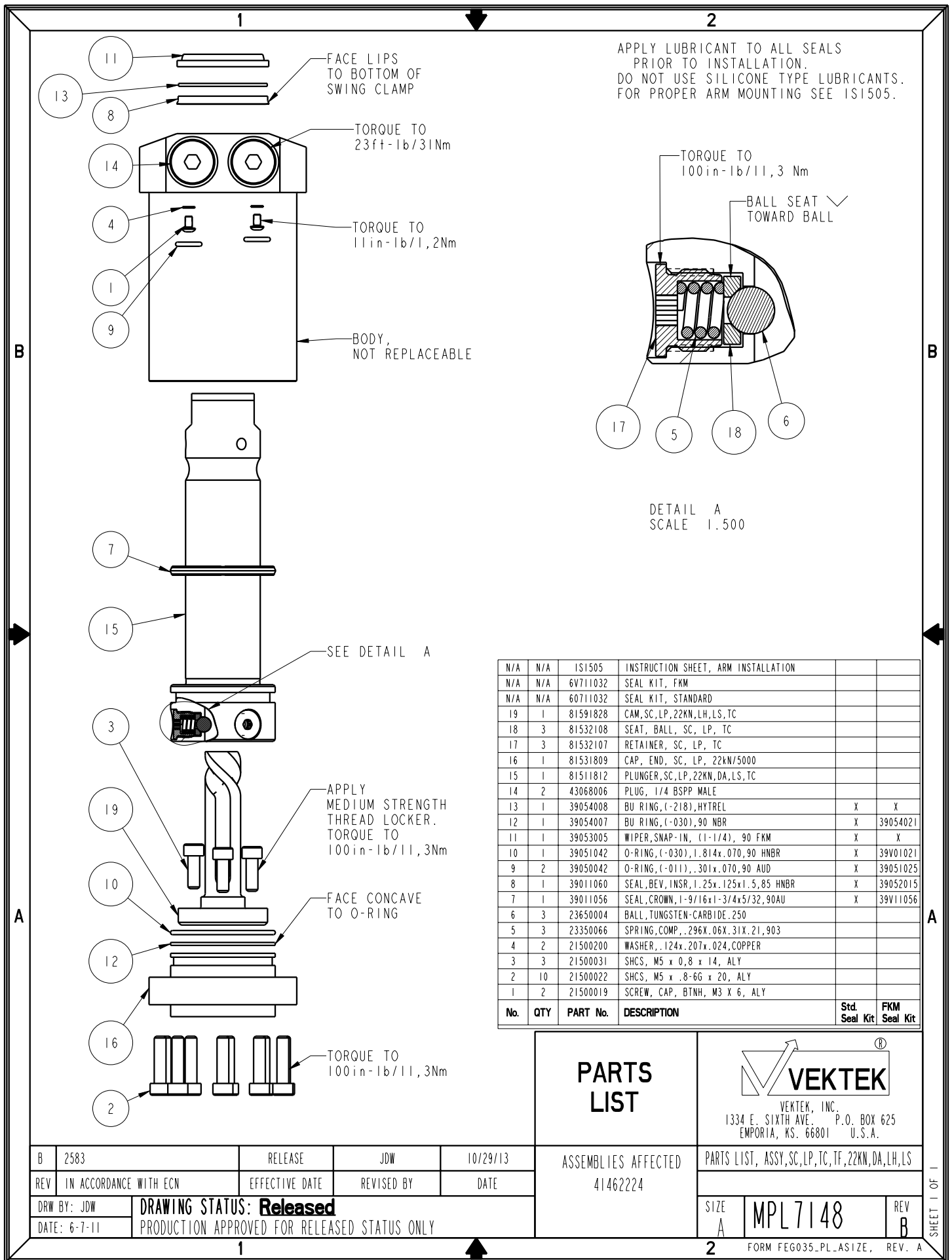




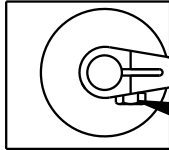
SHEET 1 OF 1

# READ ALL INSTRUCTIONS BEFORE INSTALLING ARMS FAILURE TO FOLLOW INSTALLATION INSTRUCTIONS WILL VOID PRODUCT WARRANTY !

## –Installing or Positioning of Low Profile Swing Clamp Arms–

**NOTE:** If the arm is already installed on the plunger,  
loosen the cap screw.

**CAUTION:** Never attempt to rotate the arm before loosening  
the cap screw. This can damage the plunger rotating mechanism.



1. Rotate the arm to the desired radial position.
2. Tighten to the torque specification listed below.

| MODEL         | TORQUE<br>ft-lb | TORQUE<br>N-m |
|---------------|-----------------|---------------|
| 5000lb & 22Kn | 115 ft-lb       | 156 N-m       |
| 7500lb & 33Kn | 225 ft-lb       | 305 N-m       |

IT IS RECOMMEND THE CROSS BOLT  
BE REPLACED IF THE ARM NEEDS  
REMOVED AFTER IT HAS BEEN IN SERVICE.

| CROSS BOLT              | CROSS BOLT  | CROSS BOLT              | CROSS BOLT  |
|-------------------------|-------------|-------------------------|-------------|
| 5000 & 22KN             | 5000 & 22KN | 7500 & 33KN             | 7500 & 33KN |
| SHORT<br>LONG<br>DOUBLE | UPREACH     | SHORT<br>LONG<br>DOUBLE | UPREACH     |
| 21-5000-24              | 21-5000-25  | 21-5000-28              | 21-5000-25  |

## Instruction Sheet



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

**Arm Installation Instruction Sheet**

**Low Profile Swing Clamps**

SIZE A 1S1505 REV C

FORM FEG041-1S.A.SIZE, REV. B

|                |                                              |                |            |          |
|----------------|----------------------------------------------|----------------|------------|----------|
| C              | 2799                                         | RELEASE        | JDW        | 01/29/15 |
| REV            | IN ACCORDANCE WITH ECN                       | EFFECTIVE DATE | REVISED BY | DATE     |
| DRW BY: MES    | DRAWING STATUS: <b>Released</b>              |                |            |          |
| DATE: 08/01/05 | PRODUCTION APPROVED FOR RELEASED STATUS ONLY |                |            |          |

SHEET 1 OF 1