

SINGLE-ACTING SWING / PULL CLAMP

Max. Capacity: 2,300 lbs. Clamping Force (with 2" lg. arm) at 5,000 PSI

100892 - Left Hand, 1/2" Stroke

100893 - Right Hand, 1/2" Stroke

100894 - Straight Pull, 1/2" Stroke

The piston rod U-cup seal (Item 13) can be easily twisted if installed incorrectly.

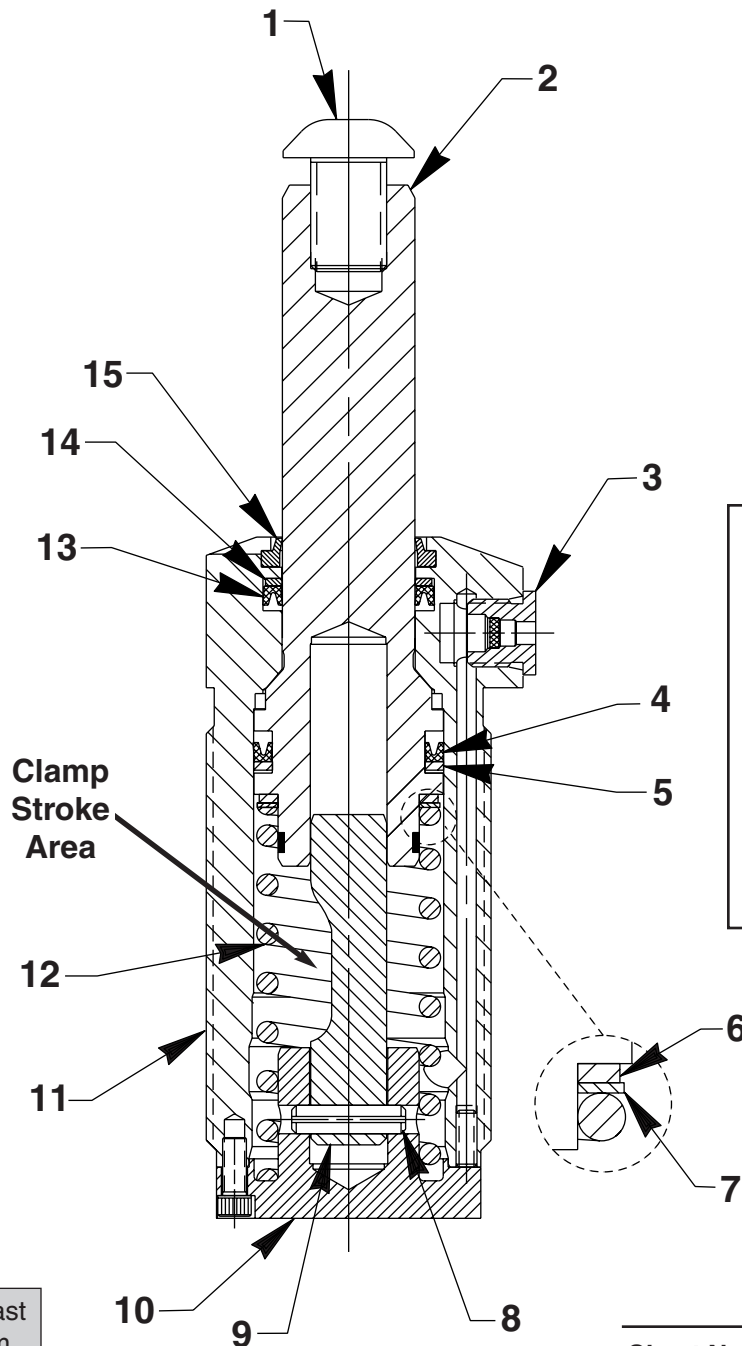
Before installing the piston rod (Item 2) lubricate the rod and all seals with hydraulic oil. Install the rod with light pressure and a twisting motion as the seal is first contacted.

Refer to any operating instructions included with this product for detailed information about operation, testing, disassembly, reassembly, and preventive maintenance.

Items found in this parts list have been carefully tested and selected.
Therefore: Use only genuine Hytec replacement parts!

Additional questions can be directed to our Technical Services Department.

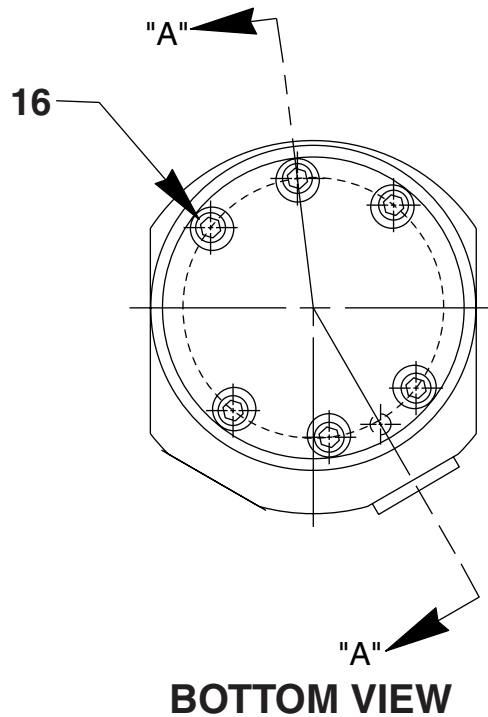
Note: Graphics updated at last revision(s) made to this form.



IMPORTANT!

Carefully compare teflon washers (Items 5 and 6). Item 5 is the *larger* of the two washers (both inside and outside diameters). **DO NOT REVERSE!**

SECTION A-A



Item No.	Part No.	No. Req'd	Description
1	251648	1	Soc. Hd. Cap Screw (1/2-20 UNC X 3/4 Lg.; Torque to 40/60 ft. lbs.)
2	351042	1	Piston Rod
3	251738	1	Vented Plug Assembly
4	*250620	1	Vee Block Packing
5	*250621	1	Teflon Backup Washer
6	*210364	1	Teflon Backup Washer
7	*251100	1	Special Steel Washer (NOTE: Assemble washer with larger radii towards teflon washer (Item No. 6); Must be grease and oil free.)
8	10782	1	Slotted Spring Pin (3/16 dia. x 3/4 Lg.)
9	350397	1	Rotating Cam (Right Hand† 90° for 100893)
	350912	1	Rotating Cam (Right Hand† 30°)
	350913	1	Rotating Cam (Right Hand† 45°)
	350914	1	Rotating Cam (Right Hand† 60°)
	350398	1	Rotating Cam (Left Hand† 90° for 100892)
	350915	1	Rotating Cam (Left Hand† 30°)
	350916	1	Rotating Cam (Left Hand† 45°)
	350917	1	Rotating Cam (Left Hand† 60°)
	350343	1	Rotating Cam (Straight Pull for 100894)
10	420922	1	End Cap
11	351063	1	Swing Clamp Body
12	250619	1	Compression Spring (1.210 O.D. x 3.540 Lg.)
13	*250480	1	V-cup
14	*250479	1	Teflon Backup Washer
15	*250478	1	Rod Wiper
16	15139	6	Hex Soc. Hd. Cap Screw (6-32 UNC X 1/2 Lg.; Torque to 30-40 in. lbs.)

NOTE: Flat of cam (clamp stroke area) to be opposite of body port.
Grease roller in piston rod (Item #2) and cam with a light coating of CDM Extreme Pressure Lube #3.

Part numbers marked with an asterisk (*) are contained in Repair Kit No. 300611.

† Right hand rotation is clockwise rotation when viewed from the piston rod end.
Left hand is counterclockwise rotation. To reverse clamp rotation, order the appropriate rotating cam.