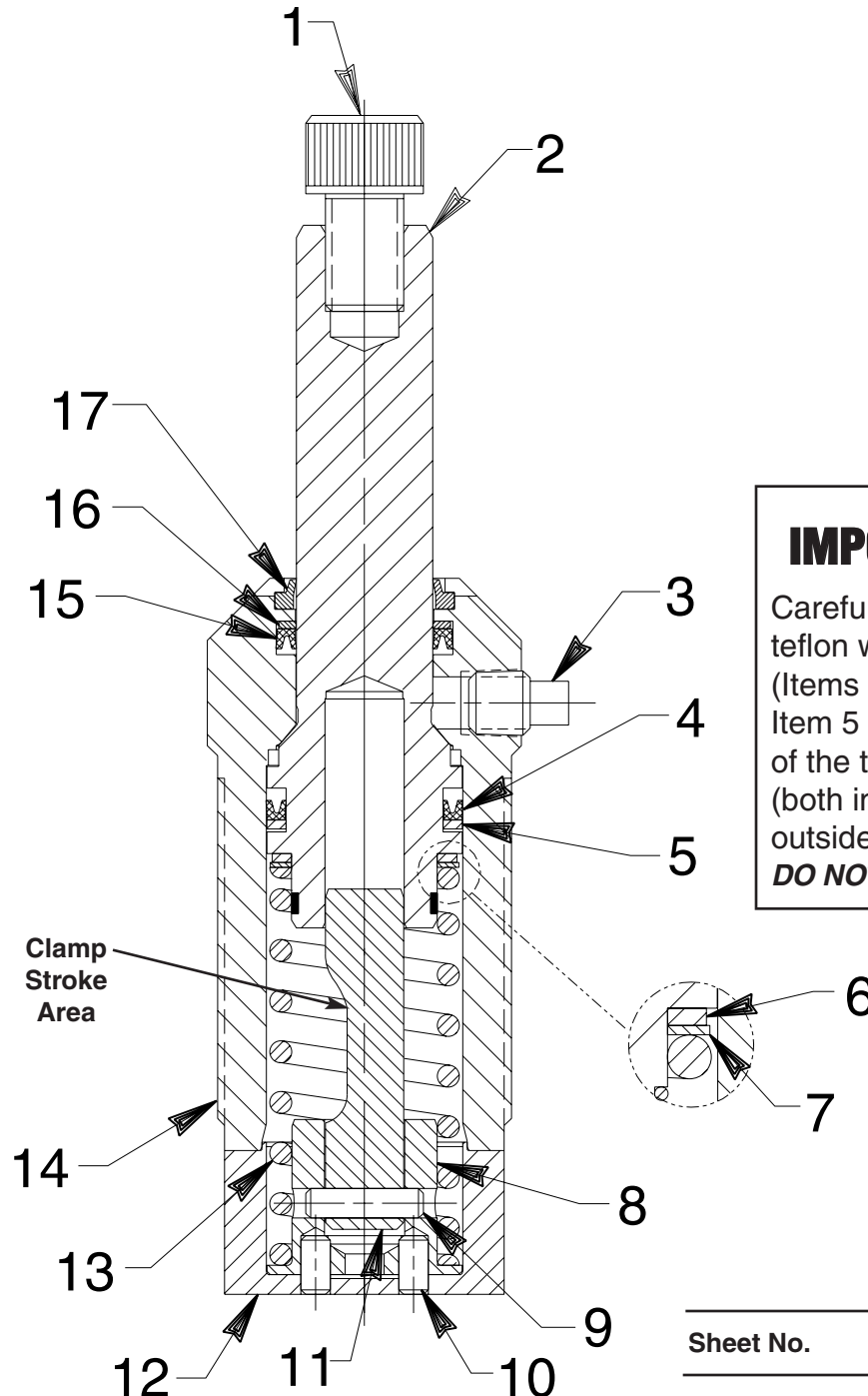


MODEL B
SINGLE-ACTING SWING CLAMP**Max. Capacity: 2,300 lbs. Clamping Force (with 2" lg. arm) at 5,000 PSI****100853 - Left Hand, 1/2" Stroke****100854 - Right Hand, 1/2" Stroke****100869 - Straight Pull, 1/2" Stroke**

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

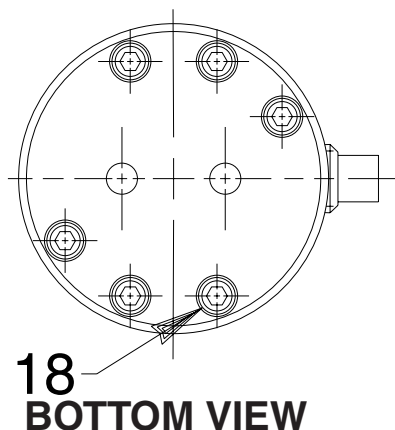
Items found in this parts list have been carefully tested and selected.

Therefore: Use only genuine Hytec replacement parts!

Additional questions can be directed to our Technical Services Department.

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!**



Item No.	Part No.	No. Req'd	Description	
1	213836	1	Soc. Hd. Cap Screw (1/2-20 UNF x 3/4 Lg.; Torque to 50 ft. lbs.)	
2	351025	1	Piston Rod, Roller and Retainer Assembly	
3	11048	1	Square Drive Plug Fitting	
4	*250620	1	Vee Block Packing	
5	*250621	1	Teflon Backup Washer (-214)	
6	*210364	1	Teflon Backup Washer (-213)	
7	*251100	1	Special Steel Washer (NOTE: This washer was not a standard part on clamps manufactured before 3/93. It should be added to all clamps during a routine repair.)	
8	350294	1	Cam Adapter	
9	10782	1	Slotted Spring Pin (3/16 dia. x 3/4 Lg.)	
10	250622	2	Spring Pin (3/16 dia. x 3/8 Lg.; NOTE: Assemble flush to bottom of end cap [Item 10])	
11	350397	1	Rotating Cam (Right Hand† 90° for 100854)	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.
	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 100853)	
	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 100869)	
12	350293	1	End Cap	
13	250619	1	Compression Spring (1.210 O.D. x 3.540 Lg.)	
14	64166	1	Swing Clamp Body	
15	*250480	1	V-cup	
16	*250479	1	Backup Washer (-212)	
17	*250478	1	Rod Wiper	
18	250618	6	Hex Soc. Hd. Cap Screw (#6-32 UNC x 1" Lg.; Torque to 30-40 in. lbs.)	

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.