

Parts List for:

100904
100905
100906

CARTRIDGE STYLE MOUNT SINGLE-ACTING SWING CLAMP

Capacity: 4300 lbs. (1952,2 kg) Clamping Force (with 2-1/2" [63,5 mm] lg. arm) at 5,000 PSI (350 Bar) Max.

100904 - Left Hand, .600 Stroke

100905 - Right Hand, .600 Stroke

100906 - Straight Pull, .600 Stroke

The piston rod U-cup seal (Item 15) 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.

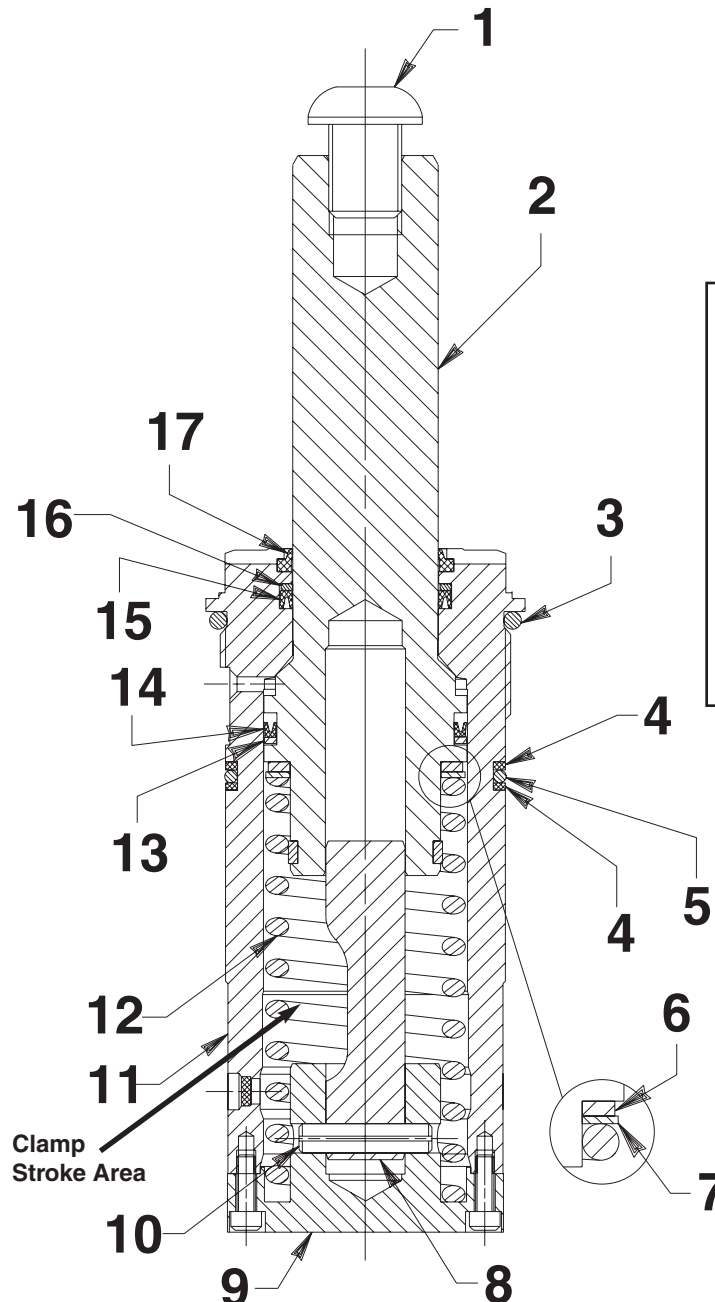
Items found in this parts list have been carefully tested and selected.

Therefore: Use only genuine Hytec replacement parts!

Additional questions can be directed to our Technical Services Department.

IMPORTANT!

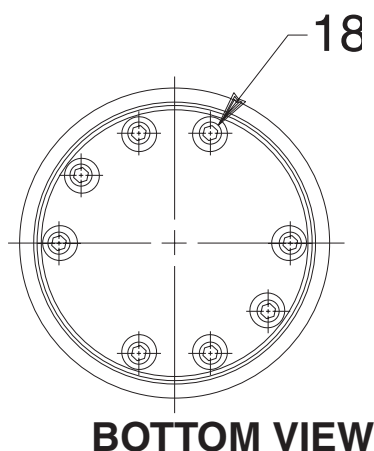
Carefully compare teflon washers (Items 6 and 13). Item 13 is the *larger* of the two washers (both inside and outside diameters). **DO NOT REVERSE!**



SECTION A-A

Sheet No. 1 of 1

Rev. 1 Date: 9 June 1998



Item No.	Part No.	No. Req'd	Description
1	251630	1	Hex. Hd. Soc. Screw (5/8-11 UNC x 1" Lg.; Torque to 50/70 ft. lbs.)
2	351057	1	Piston Assembly
3	*251781	1	O-ring (2.573 x 2.337 x .118, -932)
4	*251782	2	Backup Washer
5	*11229	1	O-ring (2-3/8 x 2-3/16 x 3/32, -139)
6	*251627	1	Backup Washer (1.678 x 1-5/16 x .070, -323)
7	*251629	1	Special Washer (Note: Assemble Washer [Item #7] with larger radii towards Teflon Washer [Item #6]. Must be grease and oil free.)
8	351045	1	Rotating Cam (Left Hand† 90° for 100904)
	350985	1	Rotating Cam (Right Hand† 90° for 100905)
	351046	1	Rotating Cam (Straight Pull for 100906)
9	420947	1	End Cap
10	11178	1	Roll Pin (1/4 Dia. x 1-1/8 Lg.)
11	351069	1	Swing Clamp Body
12	251621	1	Compression Spring (1.710 O.D. x 5-1/4 Lg.)
13	*251625	1	Backup Washer (1-3/4 x 1-1/2 x .048, -214)
14	*251623	1	U-cup Packing
15	*251624	1	U-cup Packing
16	*251626	1	Backup Washer (1.480 x 1-1/4 x .048, -218)
17	*251622	1	Rod Wiper
18	10826	8	Cap Screw (#8-32 UNC x 1/2 Lg.; Torque to 50-60 in. lbs.)

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. 300818.

† 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.

Note: Shaded areas reflect last revision(s) made to this form.