

DOUBLE-ACTING, MANIFOLD MOUNT SWING / PULL CLAMP

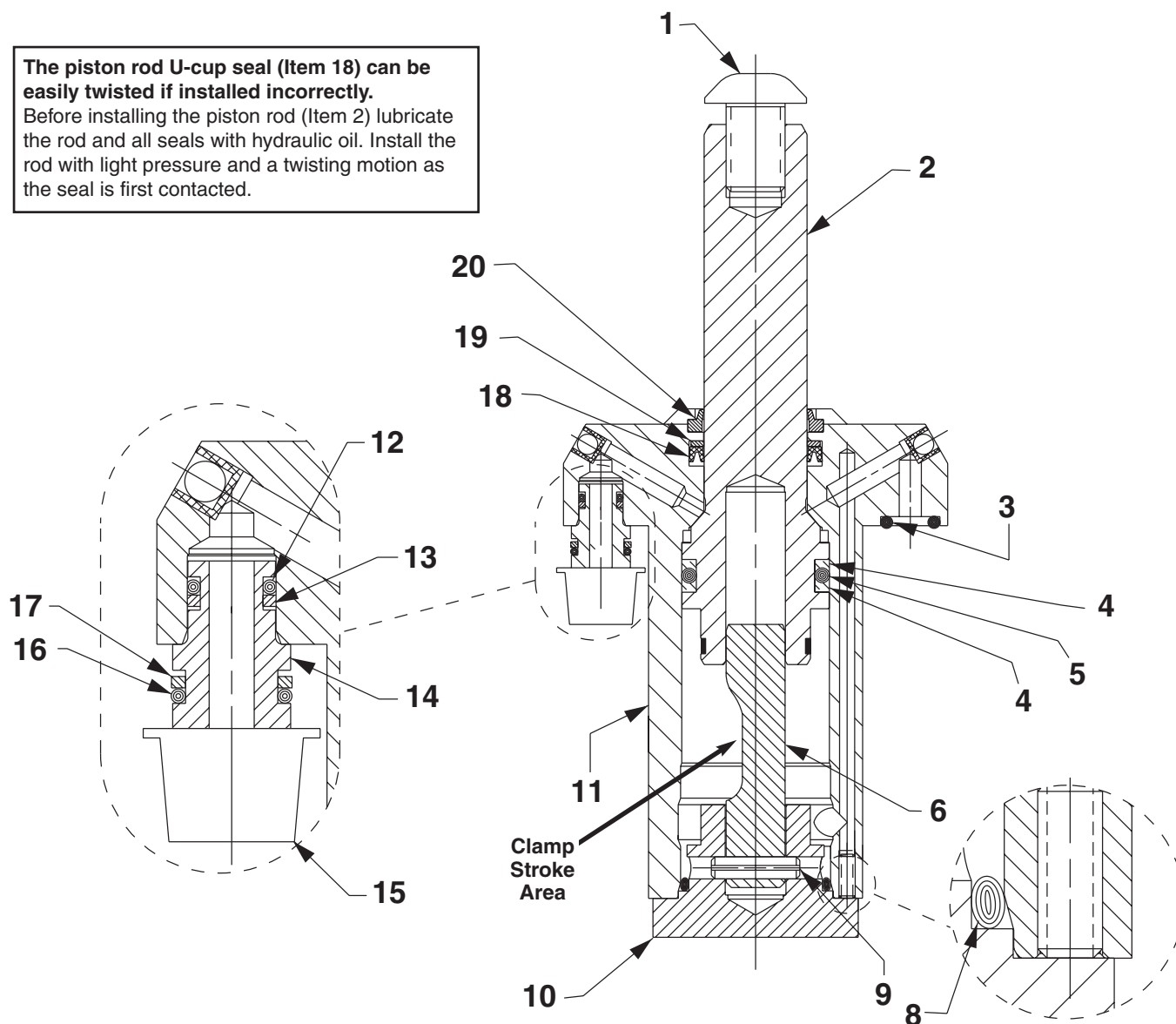
Max. Capacity: 2400 lbs. Clamping Force (with 2" lg. arm) at 5,000 PSI (350 BAR) Max.

100963 - Left Hand, 1/2" Stroke

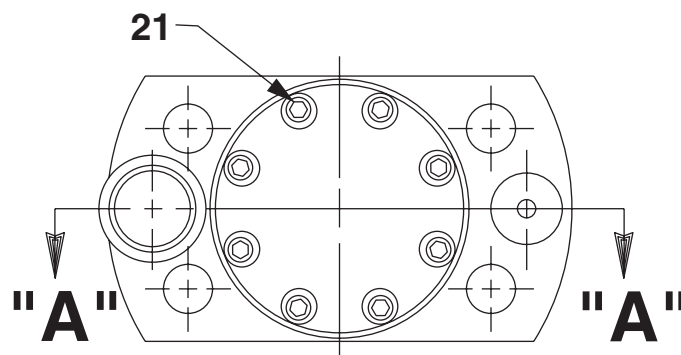
100964 - Right Hand, 1/2" Stroke

100965 - Straight Pull, 1/2" Stroke

The piston rod U-cup seal (Item 18) 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.



SECTION A-A



BOTTOM VIEW

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 Assembly (For 100963, 100964, 100965 & 970798=7)
	--	1	Piston Assembly (Note: The piston assembly for 970797=1, 970797=2, 970797=3, 970797=4, 970797=5, 970797=6, 970797=7, 970797=8, 970797=9, 970797=10, 970797=10, 970797=11, 970797=12, 970798=1, 970798=2, 970798=3, 970798=4, 970798=5, 970798=8, 970798=9, 970798=10, 970798=11, 970798=12, 970798=13, 971632=1, 970798=16 970798=17 & 970798=18 is not a serviceable part!)
	351478	1	Piston Assembly (For 971991)
3	*252104	1	O-ring (1/2 x 5/16 x 3/32)
4	*19140	2	Teflon Backup Washer
5	*250481	1	O-ring (1-1/4 x 1" x 1/8)
6	350397	1	Rotating Cam (Right Hand† 90° for 100964)
	350398	1	Rotating Cam (Left Hand† 90° for 100963)
	350343	1	Rotating Cam (Straight Pull for 100965, 971632=1 & 971991)
	350913	1	Rotating Cam (Right Hand† 45° for 970798=13)
	350912	1	Rotating Cam (Right Hand† 30° for 970798=6 & 970798=7)
8	*12598	1	O-ring (1-5/16 X 1-1/8 X 3/32)
9	10782	1	Slotted Spring Pin (3/16 dia. x 3/4 Lg.)
10	420921	1	End Cap
11	351237	1	Swing Clamp Body
12	*10266	1	O-ring (3/8 X 1/4 X 1/16)
13	*12184	1	Backup Washer
14	351041	1	Connector Bushing
15	11967	1	Tapered Cap Plug
16	*10268	1	O-ring (1/2 X 3/8 X 1/16)
17	*11863	1	Backup Washer
18	*250480	1	V-cup
19	*250479	1	Backup Washer
20	*250478	1	Rod Wiper
21	15139	8	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.

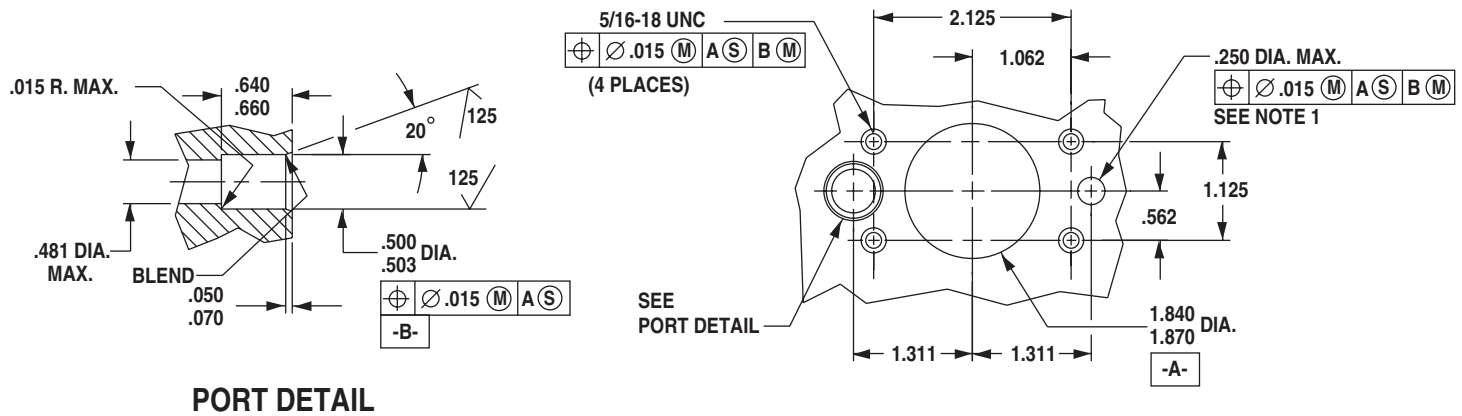
Part numbers marked with an asterisk (*) are contained in Repair Kit No. 300610.

† 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: Removed Item #7 at last revision(s) made to this form.

INSTALLATION INSTRUCTIONS



NOTE:
1. SURFACE FINISH TO BE $\sqrt{63}$.
CONCENTRIC TOOL MARKS ONLY.
FINISH AREA TO BE .500 DIA. MIN.
CENTERED ON .250 DIA. MAX. HOLE.

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.