

Double-acting  
**SWING / PULL CLAMP**

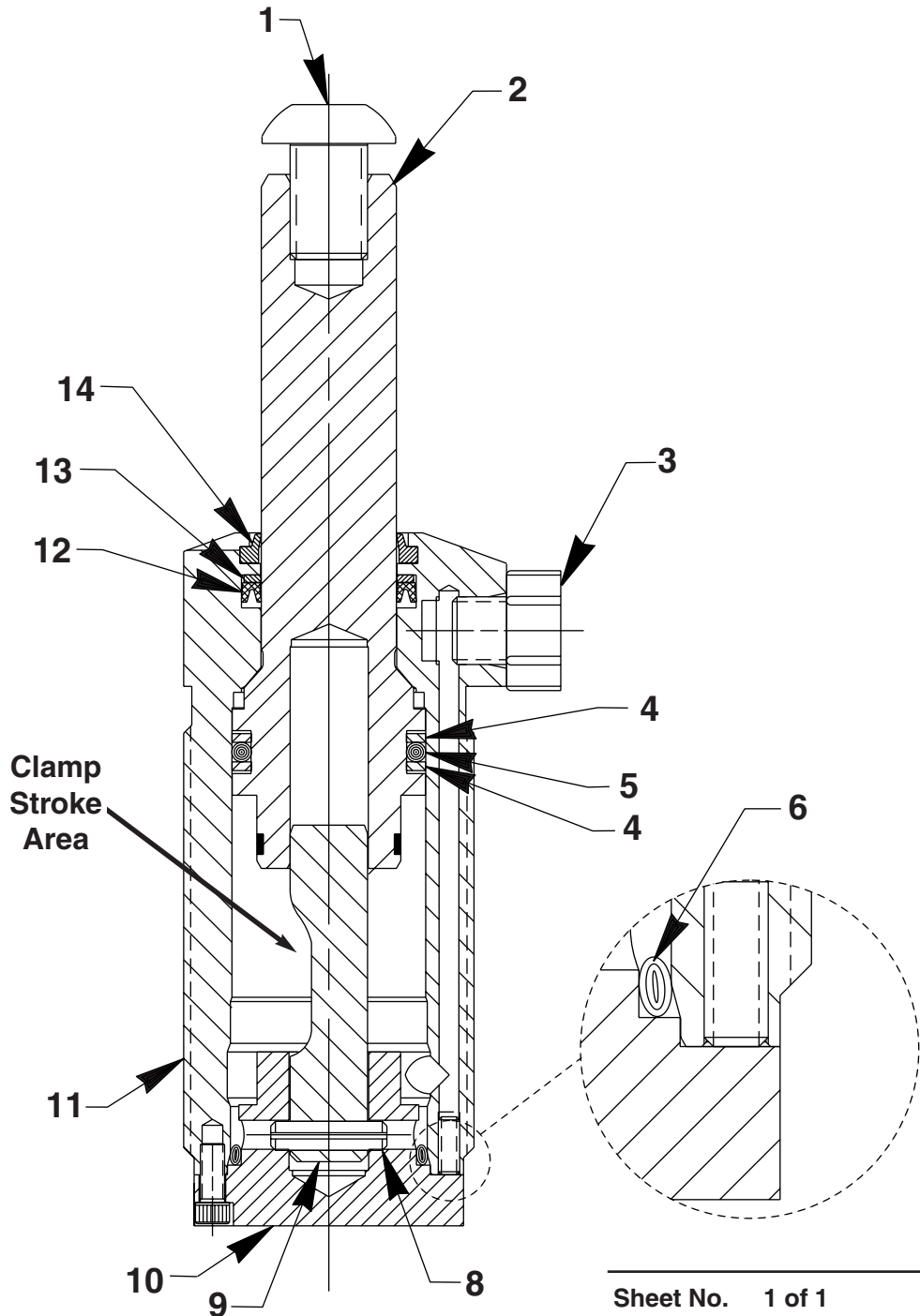
Max. Capacity: 2,400 lbs. Clamping Force (with 2" lg. arm) at 5,000 PSI

100889 - Left Hand, 1/2" Stroke

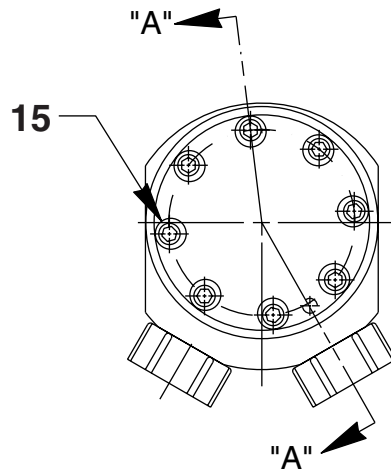
100890 - Right Hand, 1/2" Stroke

100891 - Straight Pull, 1/2" Stroke

The piston rod U-cup seal (Item 12) 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	Hex. Soc. Hd. Cap Screw (1/2-13 UNC x 3/4 Lg.; Torque to 40/60 ft. lbs.)
2	351042	1	Piston Rod
3	250961	2	O-ring Boss Plug (7/126-20 UNF)
4	*19140	2	Backup Washer (1-1/4 x 1" x .048 Thk., -214)
5	*250481	1	O-ring (-214)
6	*12598	1	O-ring (1-5/16 x 1-1/8 x .093, -122)
8	10782	1	Slotted Spring Pin (3/16 dia. x 3/4 Lg.)
9	350397	1	Rotating Cam (Right Hand† 90° for 100890)
	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 100889)
	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 100891)
10	420921	1	End Cap
11	351063	1	Swing Clamp Body
12	*250480	1	V-cup
13	*250479	1	Backup Washer (1.113 x 7/8 x .048 Thk., -212)
14	*250478	1	Rod Wiper
15	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.

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