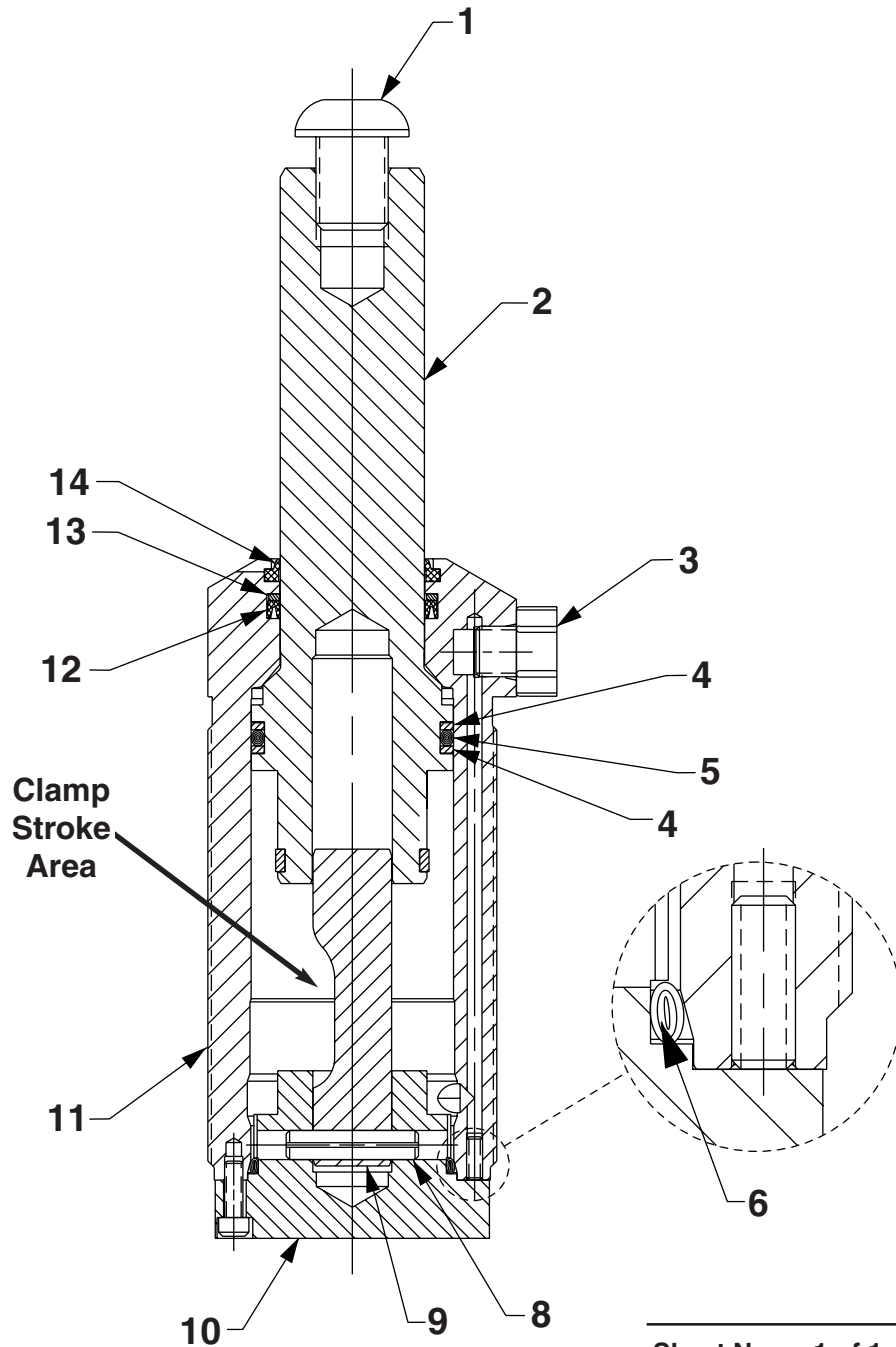


Double-acting
SWING / PULL CLAMP

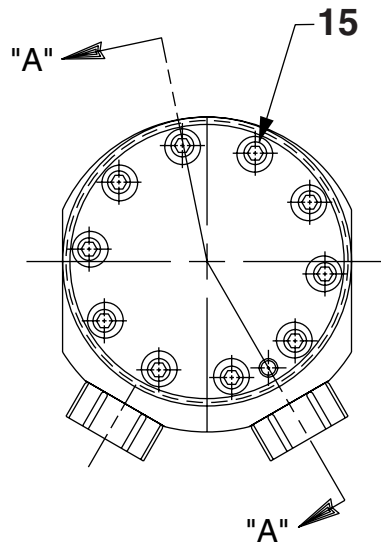
Max. Capacity: 4,500 lbs. (2043 kg) Clamping Force (with 2-1/2"[63,5 mm] lg. arm) at 5,000 PSI (350 Bar)

100898 - Left Hand, .600 Stroke
100899 - Right Hand, .600 Stroke
100900 - Straight Pull, .600 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 | 251630 | 1 | Hex. Soc. Hd. Cap Screw (5/8-11 UNC x 1" Lg; Torque to 50/70 ft. lbs.) |
| 2 | 351057 | 1 | Piston Rod (Note: The piston assembly for 972154=1 is not a serviceable part) |
| 3 | 250961 | 2 | O-ring Boss Plug (7/126-20 UNF) |
| 4 | *19144 | 2 | Backup Washer (1-3/4 X 1/2 X .048, -222) |
| 5 | *251636 | 1 | O-ring (1-3/4 x 1-1/2 x .125, -222) |
| 6 | *15125 | 1 | O-ring (1-13/16 x 1-5/8 x .094, -130) |
| 8 | 11178 | 1 | Slotted Spring Pin (1/4 dia. x 1-1/8 Lg.) |
| 9 | 350985 | 1 | Rotating Cam (Right Hand† 90° for 100899) |
| | 351045 | 1 | Rotating Cam (Left Hand† 90° for 100898) |
| | 351046 | 1 | Rotating Cam (Straight Pull for 100900) |
| 10 | 420946 | 1 | End Cap |
| 11 | 351068 | 1 | Swing Clamp Body |
| 12 | *251624 | 1 | V-cup |
| 13 | *251626 | 1 | Backup Washer (1.113 x 7/8 x .048 Thk., -212) |
| 14 | *251622 | 1 | Rod Wiper |
| 15 | 10826 | 8 | Socket Hd. Cap Screw (8-32 UNC X 1/2 Lg.; Torque to 50-60 in. lbs.) |

Part numbers marked with an asterisk (*) are contained in Repair Kit No. 300821.

†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.