

L1681
 Rev. B
 10/97
 PC5354

SC-4: For Date Codes beginning with "B".
 SC-1: For Date Codes beginning with "M".
 SC-3: For Date Codes beginning with "O".

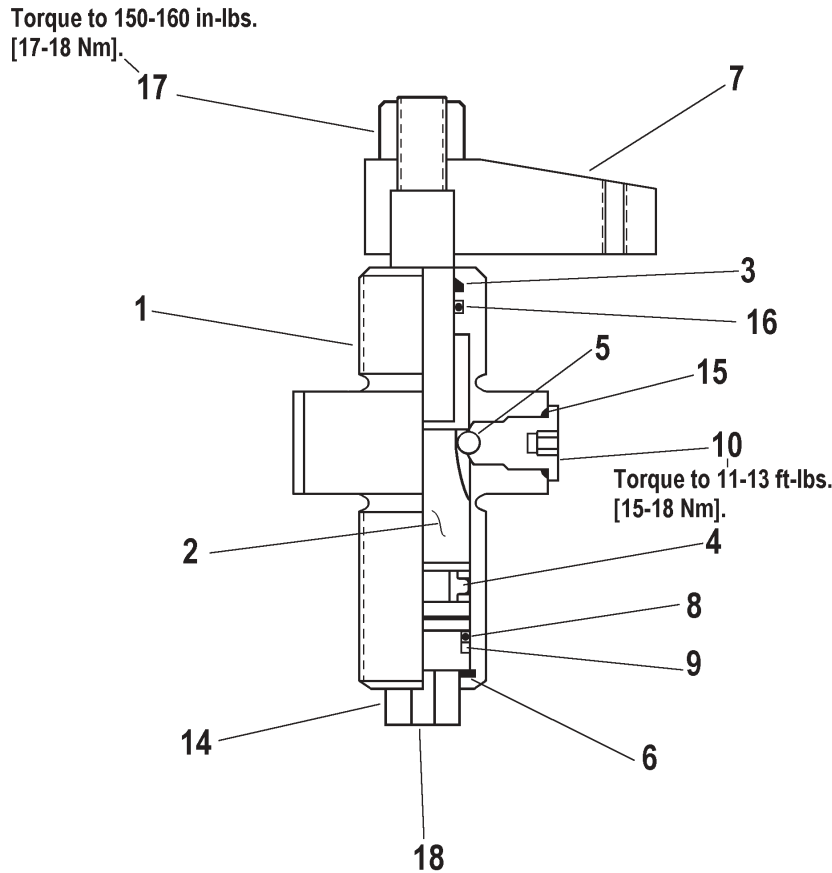


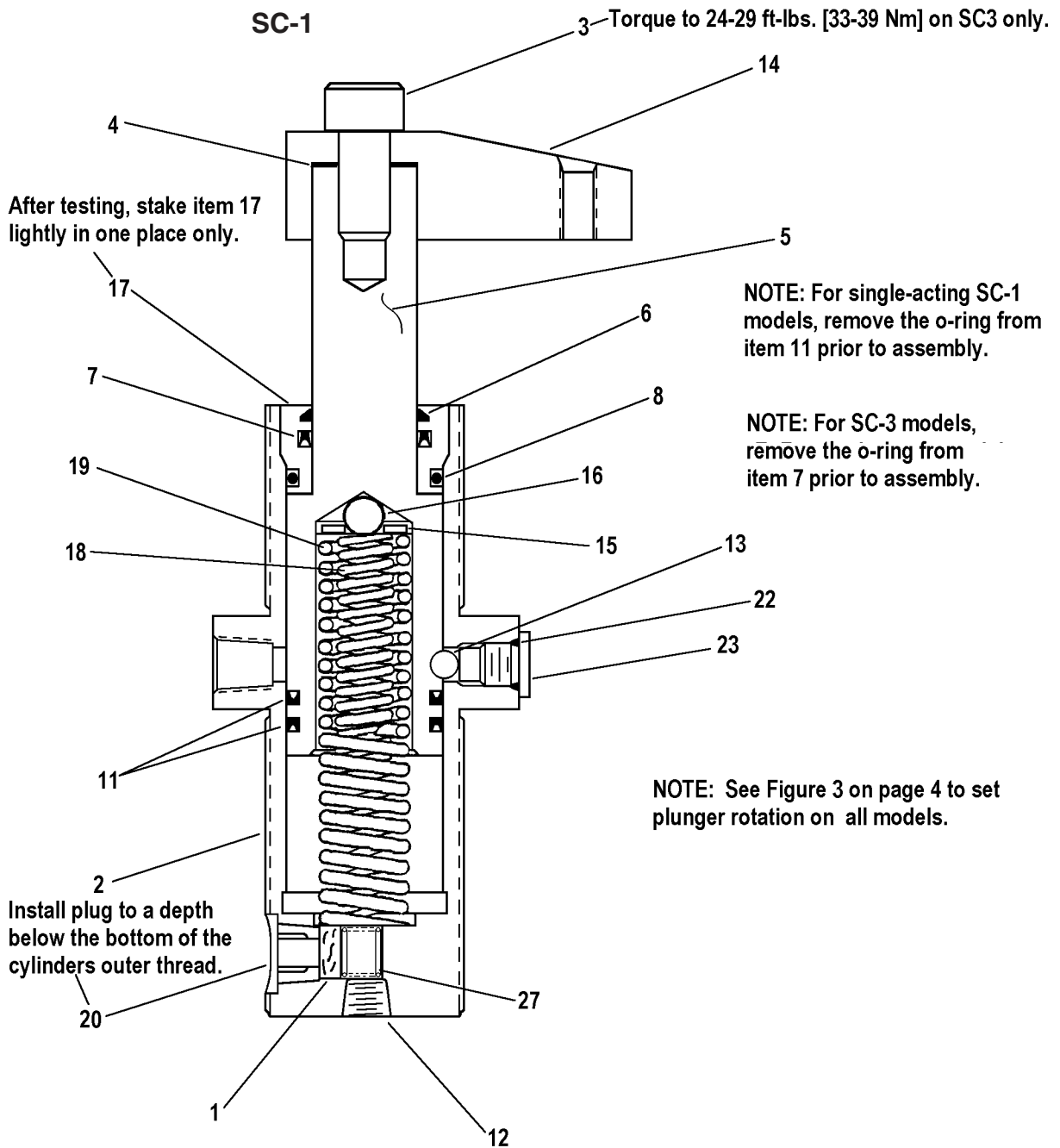
Figure 1 — SC-4

Repair Parts List for Figure 1 — SC-4

Item	Part Number	Qty.	Description	Item	Part Number	Qty.	Description
1	403058	1	Housing	9	★ B1013564	1	Back-Up Washer
2	403055	1	Plunger	10	403054	1	Plug
3	★ 403053	1	Wiper	14	403051	1	End Fitting
4	★ 403052	1	T-Seal	15	★ 300902	1	O-Ring
5	★ B1003016	1	Ball	16	★ B1007503	1	T Seal
6	★ 401633	1	Retaining Ring	17	430203	1	Nut
7	403056	1	Clamping Arm	18	A1006245	2	Pipe Plug
8	★ B1219503	1	O-Ring				

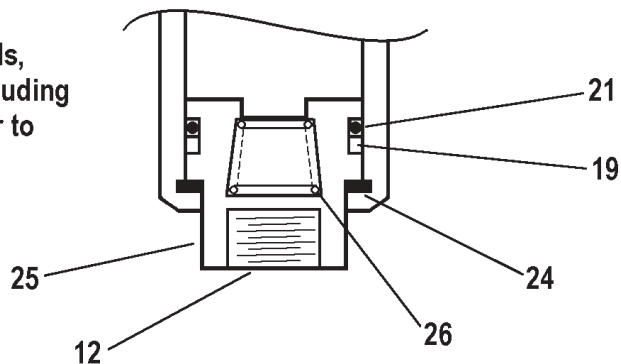
★ Indicates items included in and available only as part of Repair Kit SC4K.

Figure 2 — SC-1 and SC-3



SC-3

NOTE: For SC3 models, lubricate all seals, including SAE fitting seals, prior to assembly.



Repair Parts List for Figure 2 — SC-1 and SC-3

Item	SC-1	SC-3	Qty.	Description
1	★ F532018	—	1	Filter
2	402365	402304	1	Housing
3	B1137028	4022917	1	Capscrew
4	402368	—	1	Lock Washer
5	402364	402307	1	Plunger
6	★ 402059	★ 402043	1	Wiper
7	★ 402058	★ 402044	1	Seal
8	★ B1023503	—	1	O-Ring
9	★ 402371	★ 402322	1	Outer Spring
11	★ DA5119041	—	2	Polypac Seal
11	—	★ B1206513	1	GT Ring
12	A1007245	402324	1	Plug
13	★ 402367	★ B1004016	1	Ball
14	402363	402308	1	Clamp Arm
15	★ 402339	—	1	Flat Washer
15	—	★ 111096	1	Rivet
16	★ B1013016	B1007016	1	Ball
17	402362	—	1	End Fitting
18	★ 402370	★ 402321	1	Inner Spring
19	—	★ B1113564	1	Back-Up Washer
20	DA1016006	—	1	Vent Plug
21	—	★ B1011503	1	O-Ring
22	★ B1904503	★ 300903	1	O-Ring
23	402337	402335	1	Hex Plug
24	—	★ 401925	1	Retaining Ring
25	—	402318	1	End Fitting
26	—	★ A8013110	1	Spring
27	★ Y618110	—	1	Spring
31	—	★ A8048018	1	Breather
★	SC-1K	SC-3K		Repair Kit

★ Indicates items included in and available only as part of the Repair Kit.

Disassembly of the Swing Clamp

WARNING

Hold the clamp arm in a vice or with a wrench before exerting torque on the nut or capscrew. Failure to do so could cause excessive torque of the rotation track of the plunger, resulting in premature failure of the clamp.

1. Hold arm in a vice. Unscrew the nut or capscrew to remove the clamping arm.
2. Unscrew the bearing plug and remove the ball. Remove the o-ring from the bearing plug.
3. On the SC-1, unthread the end fitting using an adjustable spanner wrench. Remove the end fitting. On the SC-3 and SC-4, remove the end fitting by holding the housing upside-down at its flange in a vise, pushing the end fitting down into the body about ¼", and removing the retaining ring using a small screwdriver. Remove the end fitting.
4. Push the plunger out of the housing. Remove o-rings, back-up ring, T-seal and wiper.
5. Clean and dry all parts.
6. Inspect plunger, shaft, and track for damage. Also look for scratches in the bore. Polish the bore if required.
7. Inspect all parts for wear or damage. Replace as required.

NOTE: If the bore of the cylinder body is scratched due to excessive burrs on the plunger track, the cylinder is no longer repairable. The cause of such burrs is usually excessive rotation speed of the clamping arm, especially when the cylinder is equipped with a modified clamping arm or is being used as a pneumatic cylinder. As with any swing clamp, a needle valve or flow control valve (preferably free-flow return) is recommended to slow arm rotation speed. Contact Enerpac if you have any questions.

Re-assembling the Swing Clamp

1. Replace individual parts with new parts from the repair kit.

NOTE: While reassembling, make sure that contaminants do not enter the unit. Use clean grease and exercise care when installing o-rings, seals, back-up rings and springs, so that they do not become disfigured, cut, or twisted.

2. Coat bearing surfaces with clean grease to ease installation. Insert plunger into housing. On SC-1, thread end fitting into body. On SC-3 and SC-4, install end fitting and retaining ring into body.
3. Turn plunger until the desired groove (counterclockwise or clockwise rotation, or straight pull) is lined up with the bearing plug opening. See Figure 3.
4. Install ball and bearing plug, making sure bearing plug is seated in groove. See Figure 4.
5. Install clamping arm and nut or capscrew, holding clamping arm in a vise before exerting torque on nut or capscrew.

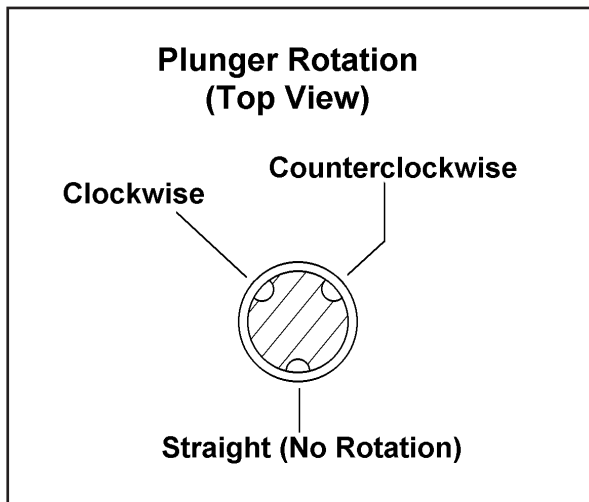


Figure 3

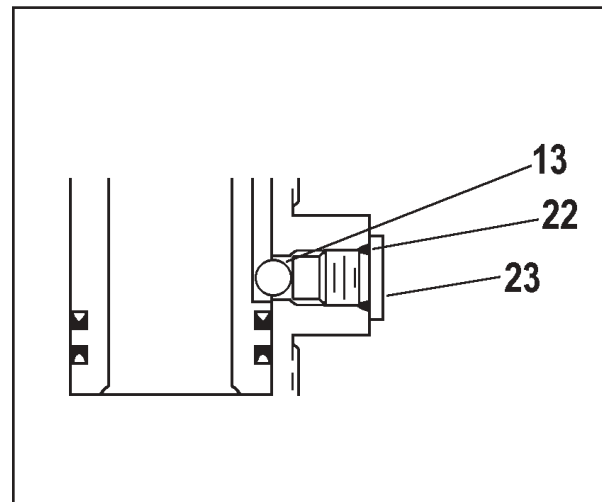


Figure 4

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