

**To Protect Your Warranty, Use Only ENERPAC Hydraulic Oil.**

Enerpac recommends that all kit components be installed to insure optimum performance of the repaired product.

**1.0 Remove Swing Clamp from Hydraulic System**

1. Shut down operation and release hydraulic pressure at the power source and holding valve (if used).
2. Disconnect the hydraulic line from the swing clamp. Wipe off excess oil.
3. Detach the swing clamp from its mounting by removing two bolts.

**2.0 Disassemble the Swing Clamp**

1. Remove one retaining ring from the fulcrum pin and pull pin out to free the clamping arm.
2. Remove clamping arm and spring from swivel fulcrum. Mark the position of the spring on the fulcrum for future reference.
3. Loosen set screw enough to remove cover.



**WARNING:** Cover is installed under slight spring pressure. Remove cover carefully to avoid injury.

4. Unscrew end plug and remove o-ring. Tap body lightly to remove plunger. Remove retaining ring, washer, plunger spring, o-ring, and back-up ring from the plunger. Discard o-ring and back-up ring.
5. Remove closure disc from the swivel fulcrum by tapping sharply on the fulcrum until the disc comes off. Remove swivel fulcrum through hole at bottom of swing clamp body.
6. Unscrew plunger housing from the swing clamp body. (For ASC-100: Remove snap ring from the plunger housing.) Remove plunger housing, internal spring, external spring, clamp plunger, and spring washer from the body.
7. Remove retaining ring to free check valve assembly, return spring, and o-ring. Do not discard retaining ring.
8. Remove felt ring (ASC-100 only), o-rings, and back-up rings and discard.



**3.0 Clean and Inspect the Parts**

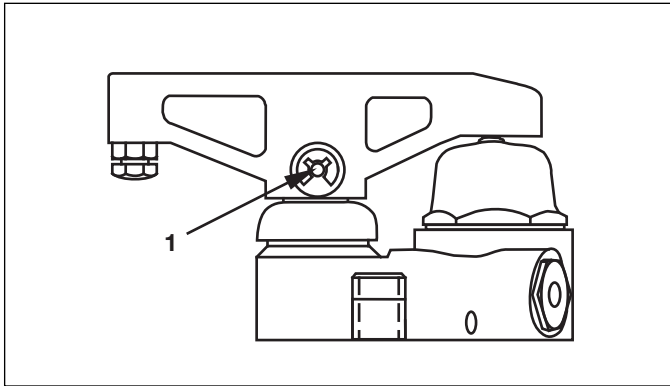
1. Use OSHA approved degreasing solvent to clean the parts thoroughly. Blow them dry with clean moisture-free air and place them on a lint-free area
2. Inspect all parts for wear. Replace if necessary.
3. Replace the felt ring, o-rings, and back-up rings with new ones from the Repair Kit.

**4.0 Re-Assemble the Swing Clamp**

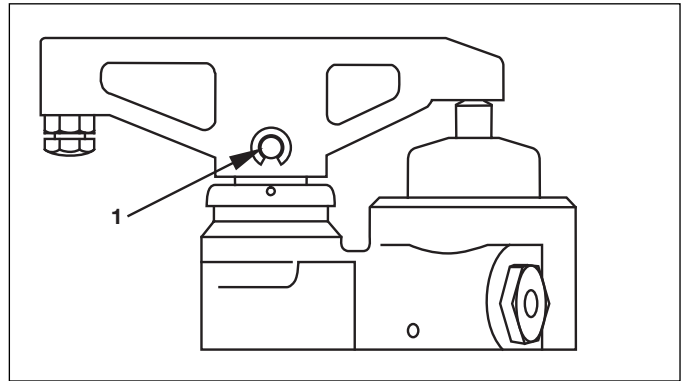
1. Re-assemble the unit. It may require slight hammering when installing the closure disc.
2. Use new parts from the Enerpac Repair Kit. Use all parts in the Repair Kit. DO NOT reinstall used seals.
3. Be sure all parts to be assembled are clean. Do not allow debris or contaminants to enter the unit.  
See notes on page 2.

**NOTES:**

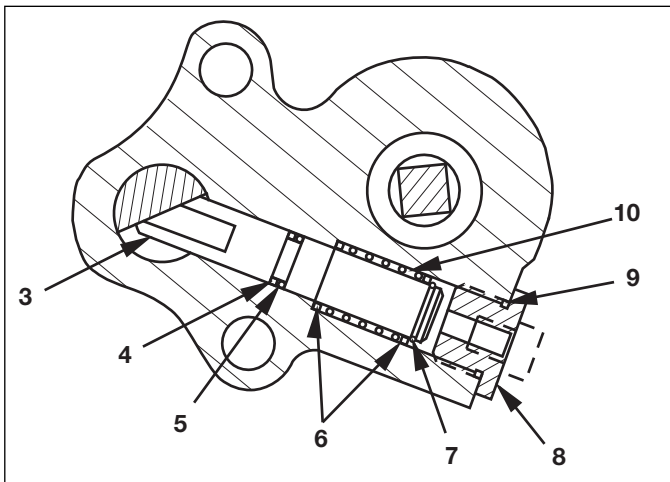
1. Operating pressure is 1200 to 2500 psi.
2. ASC-30 only: Use thread sealant on plunger housing threads (Item 24).



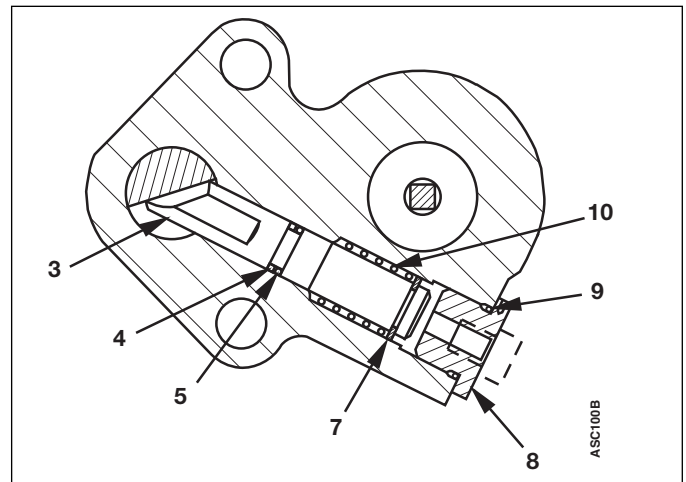
**ASC-30 - Side View Cutaway**



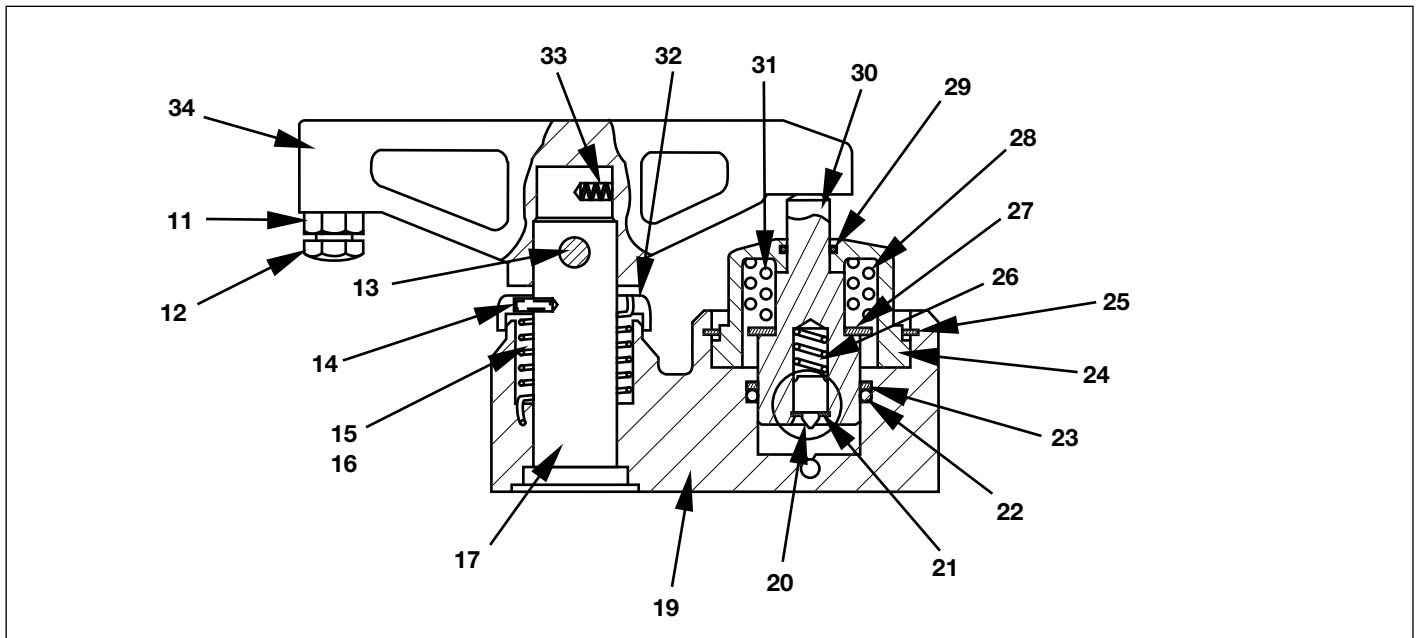
**ASC-100 - Side View Cutaway**



**ASC-30 - Top View Cutaway**



**ASC-100 - Top View Cutaway**



**ASC-30 - Swing Clamp Side View Cutaway**

| Repair Parts List                             |              |               |      |                      |
|---|--------------|---------------|------|----------------------|
| Item  | Model ASC-30 | Model ASC-100 | Qty. | Description          |
| 1   | 401809       | 401499        | 2    | Retaining Ring       |
| 3   | 401816       | 401807        | 1    | Plunger              |
| 4   | ★ B1110564   | ★ B1113564    | 1    | Back-Up Washer       |
| 5   | ★ B1008503   | ★ B1011503    | 1    | O-ring               |
| 6   | 401483       |               | 2    | Washer               |
| 7   | 401815       | DA1985044     | 1    | Retaining Ring       |
| 8   | 401465       | 403046        | 1    | End Plug             |
| 9   | ★ B1908503   | ★ B1912503    | 1    | O-ring               |
| 10  | 401226       | 404001        | 1    | Plunger Spring       |
| 11  | B1009123     | B1009123      | 1    | Jam Nut              |
| 12  | 4015121      | 4015122       | 1    | Bolt                 |
| 13  | 401810       | 401507        | 1    | Fulcrum Pin          |
| 14  | 401485       | 401513        | 1    | Set Screw            |
| 15  | 401472       | 401841        | 1    | R.H. Torsion Spring  |
| 16  | DD3114310    | 401278        | 1    | L.H. Torsion Spring  |
| 17  | PA2662010    | 401519        | 1    | Swivel Fulcrum       |
| 19  | PA2663005    | DC1520005     | 1    | Swing Clamp Body     |
| 20  | 430106       | 430106        | 1    | Check Valve Assembly |
| 21  | 401481       | 401481        | 1    | Retaining Ring       |
| 22  | ★ B1117903   | ★ B1028503    | 1    | O-ring               |
| 23  |              | ★ B1325564    | 1    | Back-Up Washer       |
| 24  | 401389       | 401511        | 1    | Plunger Housing      |
| 25  | 401503       |               | 1    | Retaining Ring       |
| 26  | 401230       | 401230        | 1    | Return Spring        |
| 27  | 401288       | 401680        | 1    | Spring Washer        |
| 28  | 401229       | 401266        | 1    | External Spring      |
| 29  | ★ B1114203   |               | 1    | O-ring               |
| 30  | 401811       | 401804        | 1    | Clamp Plunger        |
| 31  | 401227       | 401265        | 1    | Internal Spring      |
| 32  | 401476       | 401506        | 1    | Cover                |
| 33  | 401238       | 401238        | 1    | AMR Spring           |
| 34  | 401929       | 401931        | 1    | Clamping Arm         |
| ★   | ASC30K       | ASC100K       |      | Repair Kit           |
| ★ Indicates items included in the Repair Kit. |              |               |      |                      |

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