

A1630-KIT

Side Shaft Gearbox Installation Instructions

The A1630-Kit will not fit valves with a Bronze Half Ball or that were built prior to 01/01/03.

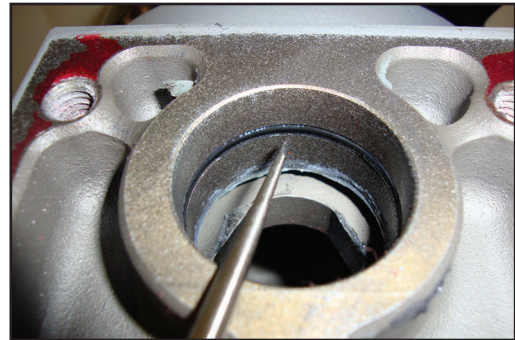
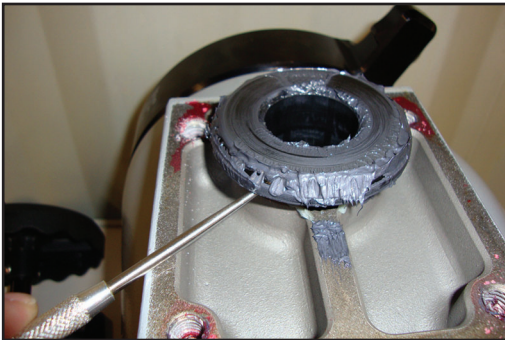


Items Required: Gearbox Retrofit Kit (A1630-KIT)

Kit Includes: Gearbox Assembly, Mounting Bolts, and blue Loctite #242.

Tools Required: 5/16" Allen wrench and a pick or similar tool.

STEP 1) Place the ball valve into the full open position. Using the 5/16" Allen wrench, remove the socket head cap screws that retain the existing gearbox assembly to the valve body.



STEP 2) Using the seal pick, carefully remove the Gear Spacer that is pressed into the top of the valve body.

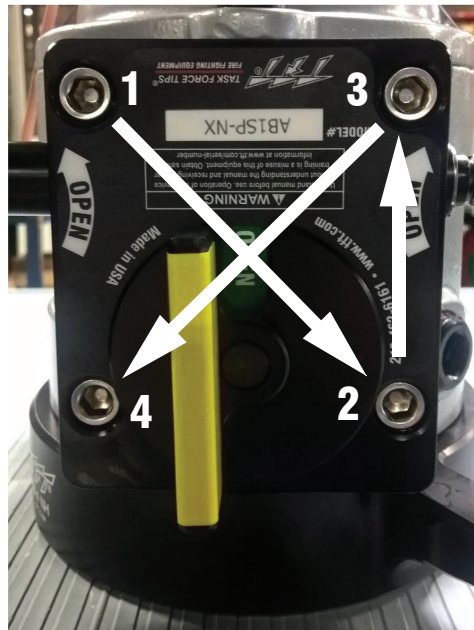
STEP 3) Visually inspect the O-ring that is in the valve body. Verify that it is not worn or damaged. Replace with 128 O-ring if necessary.



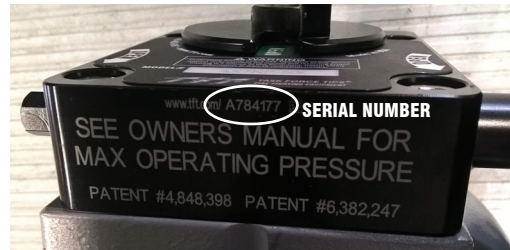
STEP 4) Place the Valve Ball and the new Gearbox in the open position. Viewed from the inlet or hose side of the valve, the Valve Ball should be rotated to the right or 3 o'clock position. If ball is difficult to rotate, lightly apply grease to the lower trunnion and mating hole in the half Valve Ball.



STEP 5) Press the new Gearbox onto the valve, making sure to align the Trunnion on the Gearbox to the Trunnion hole on the Valve Ball. Some adjustment of the Valve Ball may be needed in order to properly align the Gearbox Trunnion with the mating socket of the Valve Ball.



STEP 6) Apply the included Loctite #242 to the first half inch of threads on the socket head cap screws included with the kit. Install the four screws, tightening them in a crisscross pattern.



STEP 7) Ensure free operation of the valve and that the Gearbox position indicator matches the ball position. Once assembly is complete, install the valve on your apparatus. When installed on the apparatus, check for leaks before placing back in to service.

STEP 8) Fill out the postage paid postcard with the serial number of the original Gearbox and the number of the new Gearbox. Return this card to Task Force Tips.