These instructions provide the steps required to convert a TurboMaster nozzle with a blade to the version with a stem.

DISASSEMBLY
1. Remove baffle screw (24) and baffle (23).
   Note: Any plastic shims found under the baffle head will need to be used during reassembly.
2. Remove swivel plug (3) being careful not to loose the ball bearings (4), as they will be reused.
3. Remove all 38 ball bearings (4).
4. Remove swivel (2).
5. Remove set screw (8). Then unthread the swivel adapter (5) from the nozzle body.
6. Remove O-Ring (17) from the nozzle body.
7. Remove the blade (15) with roll (16).
ASSEMBLY

Note: Use Parker O-Ring lubricant or equivalent petroleum based lubricant on all O-Rings before assembly.

1. Install the roll pin (37) into the spider (16).
2. Apply Loctite 277 onto the male thread of the stem (38).
3. Thread stem (38) into the spider (16). Note: 277 Loctite must cure 24 hours before flowing the nozzle.
4. Install O-Ring (15) onto the spider (16).
5. Install O-Ring (17) onto the nozzle body (18).
6. Install spider and stem assembly into the nozzle body (18) aligning roll pin (37) with one of the slots in the inlet of the nozzle body (18).
7. Thread the new swivel adapter (5) onto the nozzle body (18) tightening with a strap wrench.
8. Install the new set screw (8) into the side of the swivel adapter (5) until tight.
9. Install the new ID band (6) onto the swivel adapter (5). Note: The 1755 band is for a 1250 gpm nozzle and the 1757 band is for a 1000 gpm nozzle.
10. Place the swivel (2) onto the swivel adapter (5) and install the 38 ball bearings (4) into the hole in the swivel.
11. Install the swivel plug (3).
12. Insert the new baffle screw (24) through the new baffle head (23) and old plastic shims (if applicable) and thread the baffle screw into the stem (38). Note: Make sure that the baffle screw is tight.
13. Flow test the nozzle to be sure it is working properly.