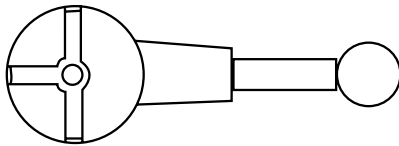


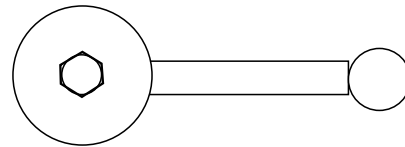


CONVERSION OF OLD TORK-LOK® TO NEW TORK-LOK FOR WYE & SIAMESE VALVES STYLES 1582, 1583, 2582, 2583, 625, 1828

These instructions are written to assist in converting the old style Tork-Lok handle assembly to the current design as shown in Figure 2.



Old Style Tork-Lok
Handle Assembly
Figure 1



Current Style New Tork-Lok
Handle Assembly
Figure 2

TOOLS REQUIRED

$\frac{3}{16}$ " (4.76 mm) allen wrench

$\frac{5}{32}$ " (3.97 mm) allen wrench

$\frac{3}{4}$ " (19.05 mm) socket wrench or an adjustable type wrench

Heavy-duty snap ring wrench for I.D. ring.

⚠ CAUTION: Eye protection should be used during assembly and disassembly.

DISASSEMBLY OF OLD TORK-LOK

1. Using $\frac{3}{16}$ " (4.76 mm) allen wrench, remove socket head cap screw from handle housing.
2. Lift off handle housing, rod and ball.
3. Using snap ring wrench remove large I.D. snap ring. Care must be taken to maintain complete engagement of wrench pins in holes.
4. Remove Teflon shim and drive bearing.
5. Using $\frac{5}{32}$ " (3.97 mm) allen wrench, remove socket head cap screw from trunnion.
6. Lift off washer and (4) locking dogs.
7. Lift out drive plate and additional Teflon shims.
8. Using $\frac{5}{32}$ " (3.97 mm) allen wrench, remove (4) socket head screws.
9. Lift off trunnion bearing and remove trunnion.

REASSEMBLY OF NEW TORK-LOK

1. Using $\frac{3}{4}$ " (19.05 mm) socket, remove hex head screw from handle sub-assembly.
2. Lift off fiber washer, handle cover, handle assembly and stop plate.
3. Using $\frac{3}{16}$ " (4.76 mm) allen wrench, remove (4) socket head screws and lift off trunnion

retaining plate.

4. Remove ball trunnion, being careful not to lose (4) socket head cap screws remaining in adapter.
5. Install adapter onto old valve body and tighten down (4) socket head screws using $\frac{3}{16}$ " (4.76 mm) allen wrench.
6. Install ball trunnion, aligning pilot on trunnion with hole in top of the ball.
7. Install trunnion retaining plate. Be careful to align spring tabs with cut-out in ball trunnion. If misaligned, tork feature will not work effectively.
8. Install (4) socket head cap screws and, using $\frac{3}{16}$ " (4.76 mm) allen wrench, tighten down.
9. Install stop plate and position so that open and close position of the ball meets requirements.
10. Install handle assembly, handle cover, and fiber washer.
11. Using $\frac{3}{4}$ " (19.05 mm) socket wrench, install and tighten down hex head cap screw. Check function and make sure stop limits of handle provide rotation desired on the ball. If not, disassemble following Steps 1 and 2. Reposition stop plate as desired and reassemble following Steps 9 through 11.



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REVISED 09/00

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