TECHNICAL SERVICE PARTS

STYLE 8600,7900,8900

PRODUCT 2-4" S/O VALVES

2.0" - 3.5" SWING OUT VALVES AND
4.0" SWING OUT VALVE STYLE 8840
(25:1 & 16:1 GEAR RATIO)

ASSEMBLY NOTES:

USE PARKER-O-LUBE ON ALL O-RINGS AND
ALL MATING SURFACES.

USE PERMABOND LMI13 OR LOCTITE 222

USE LOW-TEMP LUBRIPASTE.

USE PRIMER T AND PERMABOND HH120 OR LOCTITE 277

USE PERMABOND LH50 OR LOCTITE 592

TORQUE TO 50 FT-LBS

SEE TABLE FOR STAMPING OF HOUSING.

TRUNNION SHOWN IS FOR 2 - 3.5" ACTUATOR.

OIL DIP.

USE LOCTITE 290

SECURE WITH PERMABOND 200.

USE TOOL BT-11462

FILL GEARBOX WITH GREASE.

ASSEMBLE MAGNET SO THAT IT IS FLUSH WITH TOP OF TRUNNION.

CALIBRATE THE UNIT AFTER ASSEMBLY.

ASSEMBLY NOTES:

USE PARKER-O-LUBE ON ALL O-RINGS AND
ALL MATING SURFACES.

USE PERMABOND LMI13 OR LOCTITE 222

USE LOW-TEMP LUBRIPASTE.

USE PRIMER T AND PERMABOND HH120 OR LOCTITE 277

USE PERMABOND LH50 OR LOCTITE 592

TORQUE TO 50 FT-LBS

SEE TABLE FOR STAMPING OF HOUSING.

TRUNNION SHOWN IS FOR 2 - 3.5" ACTUATOR.

OIL DIP.

USE LOCTITE 290

SECURE WITH PERMABOND 200.

USE TOOL BT-11462

FILL GEARBOX WITH GREASE.

ASSEMBLE MAGNET SO THAT IT IS FLUSH WITH TOP OF TRUNNION.

CALIBRATE THE UNIT AFTER ASSEMBLY.

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Parts List Sheet:

123292

GEAR RATIO XX:1

VALUE SIZE

16:1 2"-3.5" SWING OUT

25:1 4" SWING OUT VALVE
STYLE 8840

D46685
THE TECHNICAL SERVICE PARTS

STYLE 8600, 7900, 8900

PRODUCT 2-4" S/O VALVES

4"-5" JAMESBURY
(25:1 GEAR RATIO)

ASSEMBLY NOTES:

USE PARKER-O-LUBE ON ALL O-RINGS AND
ALL MATING SURFACES.

USE PERMABOND LM113 OR LOCTITE 222

USE LOW-TEMP LUBRIPLATE .

USE PRIMER T AND PERMABOND HH120 OR LOCTITE 277

USE PERMABOND LH050 OR LOCTITE 592

TORQUE TO 50 FT-LBS

SEE TABLE FOR STAMPING OF HOUSING.

TRUNNION SHOWN IS FOR 2-3.5" ACTUATOR.

OIL DIP.

USE LOCTITE 290

SECURE WITH PERMABOND 200.

USE TOOL BT-11462

FILL GEARBOX WITH GREASE.

ASSEMBLE MAGNET SO THAT IT IS FLUSH WITH TOP OF TRUNNION.

CALIBRATE THE UNIT AFTER ASSEMBLY.

ASSEMBLY PARTS LIST:

4X113

4X87

83

3

1

102

105

96

104

103

101

97

100

USE GEARS 1-105.

USE PRIMER T AND LOCTITE 277.

USE PERMABOND HH120.

USE PRIMER T AND PERMABOND LH050.

USE LOCTITE 290.

USE TOOL BT-11462.

FILL GEARBOX WITH GREASE.

ASSEMBLE MAGNET SO THAT IT IS FLUSH WITH TOP OF TRUNNION.

CALIBRATE THE UNIT AFTER ASSEMBLY.

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Parts List Sheet: 123292
4.0" SWING OUT VALVE STYLE 8940
64:1 GEAR RATIO

ASSEMBLY NOTES:
- USE PARKER-O-LUBE ON ALL O-RINGS AND ALL MATING SURFACES.
- USE PERMABOND LM113 OR LOCTITE 222
- USE LOW-TEMP LUBRIPASTE.
- USE PRIMER T AND PERMABOND HH120 OR LOCTITE 277
- USE PERMABOND LH050 OR LOCTITE 592
- TORQUE TO 50 FT-LBS
- SEE TABLE FOR STAMPING OF HOUSING.
- TRUNNION SHOWN IS FOR 2 - 3.5" ACTUATOR.
- OIL DIP.
- USE LOCTITE 290
- SECURE WITH PERMABOND 200.
- USE TOOL BT-11462
- FILL GEARBOX WITH GREASE.
- ASSEMBLE MAGNET SO THAT IT IS FLUSH WITH TOP OF TRUNNION.
- CALIBRATE THE UNIT AFTER ASSEMBLY.

SEE DETAIL B

8X-BTFLY ACTUATOR
4X-4" S/O VALVE ACTUATOR

4X-6" BUTTERFLY VALVE
64:1 GEAR RATIO
## TECHNICAL SERVICE PARTS

### STYLE 8600,7900,8900

### PRODUCT 2-4" S/O VALVES

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<th>QUANTITY FOR 25:1 GEAR RATIO ACTUATOR 4-5&quot; JAMESBURY</th>
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### *SEE TABLE 2*

#### **FOR 4.5" - 6.0" BTFLY VALVE ONLY**

#### **86251804 FOR ITEMS 92,93,95 (16:1)(64:1)**

#### **86251805 FOR ITEMS 94,95,100 (16:1)(64:1)**

#### **FOR 4" SWINGOUT VALVE ACTUATOR ONLY**

#### **88400840 FOR ITEMS 92,93,95 (25:1)**

#### **88400841 FOR ITEMS 94,95,100 (25:1)**

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