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ASSEMBLY NOTES:

1. USE PARKER-O-LUBE ON ALL O-RINGS AND MATING SURFACES, UNLESS OTHERWISE SPECIFIED.
2. USE PERMABOND LM113 OR LOCTITE 222.
3. USE MOBILITH SHC460.
4. TORQUE TO "A" FT-LBS (SEE TABLE BELOW).

<table>
<thead>
<tr>
<th>SIZE OF VALVE</th>
<th>TORQUE &quot;A&quot; FT-LBS</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.5&quot;</td>
<td>18-20</td>
</tr>
<tr>
<td>2.0&quot;</td>
<td>25-30</td>
</tr>
<tr>
<td>2.5&quot;</td>
<td>25-30</td>
</tr>
<tr>
<td>3.0&quot;</td>
<td>38-40</td>
</tr>
<tr>
<td>3.5&quot;</td>
<td>38-40</td>
</tr>
</tbody>
</table>
TECHNICAL SERVICE PARTS
STYLE 8615, 8620, 8625, 8630, 8635
PRODUCT S/O VALVE

Find      Description                                Item    QTY
-----------        --------------------------------------    --------    ----
 1          BODY S/O 3.0"                                122028    1
 2          SEAT VALVE 3"                                769181    2
 3          BALL 3"                                     703933    1
 4          TRUNNION VALVE S/A 3"                        127787    1
 5          * O-RING 2-207                              757217    1
 16         12V - VALVE ACTUATOR POSITION A-C           86308002    1
 16         12V - VALVE ACTUATOR POSITION B-D           86308003    1
 16         24V - VALVE ACTUATOR POSITION A-C           86308004    1
 16         24V - VALVE ACTUATOR POSITION B-D           86308005    1
 21         SCREW SOCKET HEAD CAP LOC WELL 6-32 X 3/8"  765027    8
 30         TRUNNION S/A 8630, 8635                     127899    1
 32         SPACER INSULATION                           770395    1
 40         ** O-RING 2-115                            757009    1
 41         ** O-RING 2-214                            757010    1
 50         SCREW SOCKET HEAD CAP 10-24 X 5/8"          765028    4

2.50" VALVE - 8625

 1          BODY S/O 2.5"                                122027    1
 2          SEAT VALVE 2.5"                               769557    2
 3          BALL 2.5"                                    803132    1
 4          TRUNNION VALVE S/A 2" & 2.5"                  127786    1
 5          * O-RING 2-211                               757198    1
 16         12V - VALVE ACTUATOR POSITION A-C             86258006    1
 16         12V - VALVE ACTUATOR POSITION B-D             86258007    1
 16         24V - VALVE ACTUATOR POSITION A-C             86258008    1
 16         24V - VALVE ACTUATOR POSITION B-D             86258009    1
 21         SCREW SOCKET HEAD CAP LOC WELL 6-32 X 3/8"  765027    8
 30         TRUNNION S/A 8620, 8625                       127898    1
 32         SPACER INSULATION                           770395    1
 40         ** O-RING 2-115                            757009    1
 41         ** O-RING 2-214                            757010    1
 50         SCREW SOCKET HEAD CAP 10-24 X 5/8"          765028    4

1.50" VALVE - STYLE 8615

 1          BODY S/O 1.5" MCH CS                        106312    1
 2          SEAT VALVE 1.5" MATL HYTREL ANNEALED       769560    2
 3          BALL 1.5" MCH STSTL S/O LV 8815            119797    1
 4          TRUNNION VALVE S/A 1.5"                     127789    1
 5          * O-RING 2-212                              757180    1
 16         12V - VALVE ACTUATOR POSITION A-C           86158002    1
 16         12V - VALVE ACTUATOR POSITION B-D           86158003    1
 16         24V - VALVE ACTUATOR POSITION A-C           86158004    1
 16         24V - VALVE ACTUATOR POSITION B-D           86158005    1
 21         SCREW SOCKET HEAD CAP LOC WELL 6-32 X 3/8"  765027    8
 22         SCREW SOC HD CAP 10-24 X 1/2" ST STL        763038    4
 30         TRUNNION S/A 8615                             127897    1
 32         SPACER INSULATION COMP MYLAR                  770395    1
 33         PLATE ADAPTER ELC ACT 36000 BRASS 8615       742269    1
 40         ** O-RING 2-115                            757009    2
 50         SCREW SOC HD CAP 10-24 X 5/8*ST STL        765028    4

ADAPTERS

 6          *** HEX HEAD BOLT                              -     8
 7          *** OUTLET ADAPTER                            -     1
 8          *** INLET ADAPTER                            -     1

* INCLUDED WITH TRUNNION FIND 4
** INCLUDED WITH TRUNNION FIND 30
*** SEE AKRON BRASS CATALOG OR CONTACT AKRON BRASS CUSTOMER SERVICE FOR AVAILABLE INLET AND OUTLET ADAPTERS.

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Parts List Sheet: 127903

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