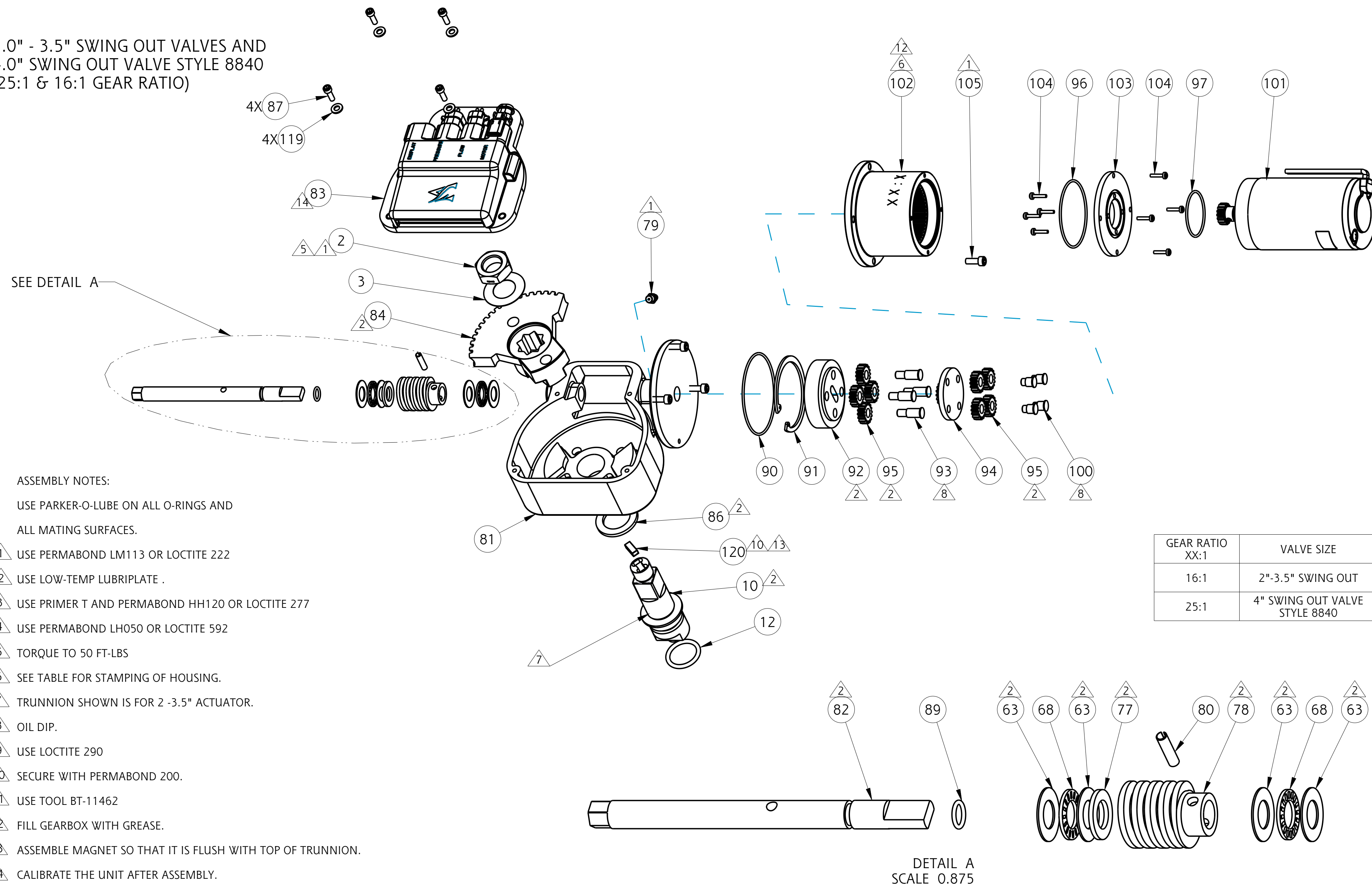


2.0" - 3.5" SWING OUT VALVES AND
4.0" SWING OUT VALVE STYLE 8840
(25:1 & 16:1 GEAR RATIO)



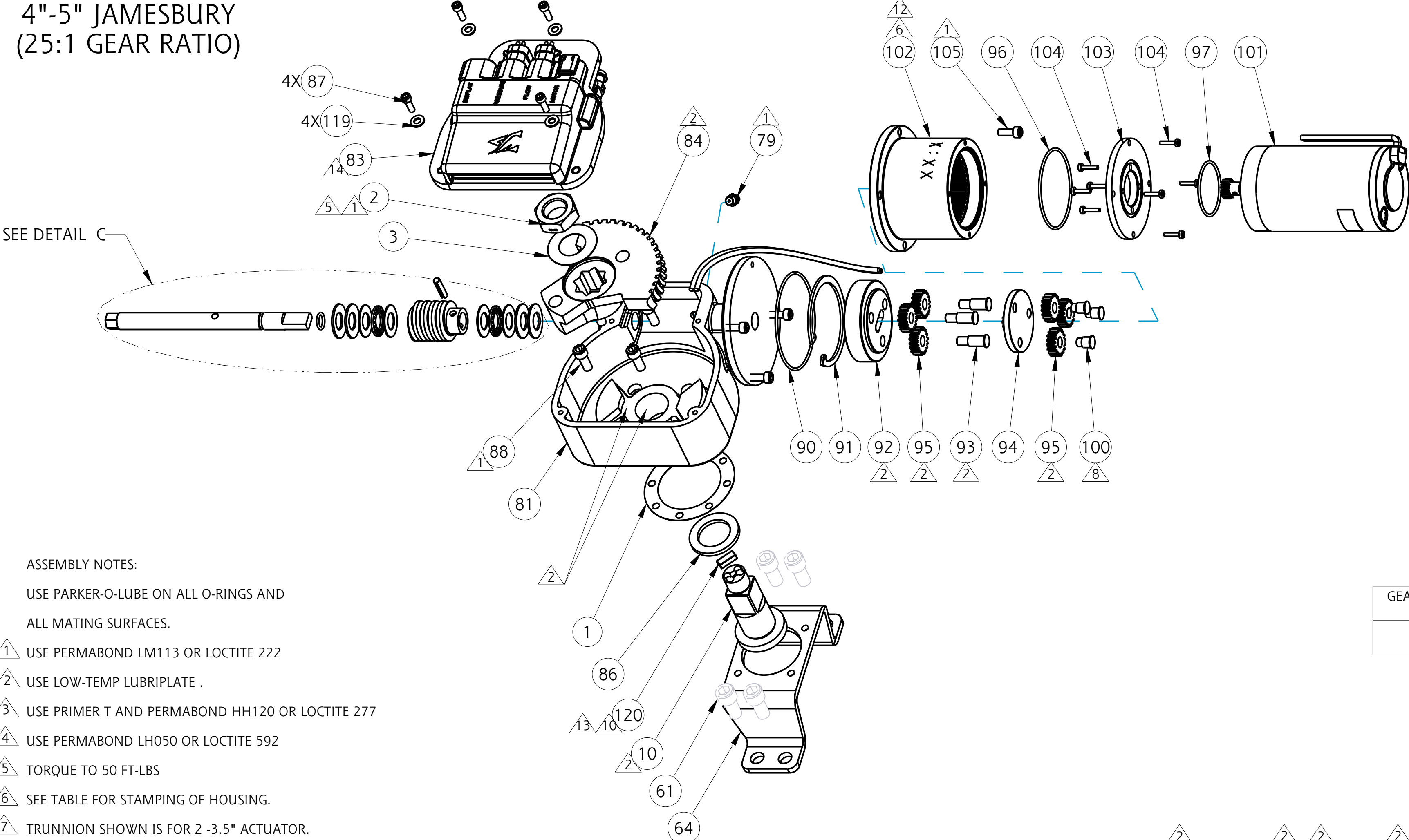
GEAR RATIO XX:1	VALVE SIZE
16:1	2"-3.5" SWING OUT
25:1	4" SWING OUT VALVE STYLE 8840

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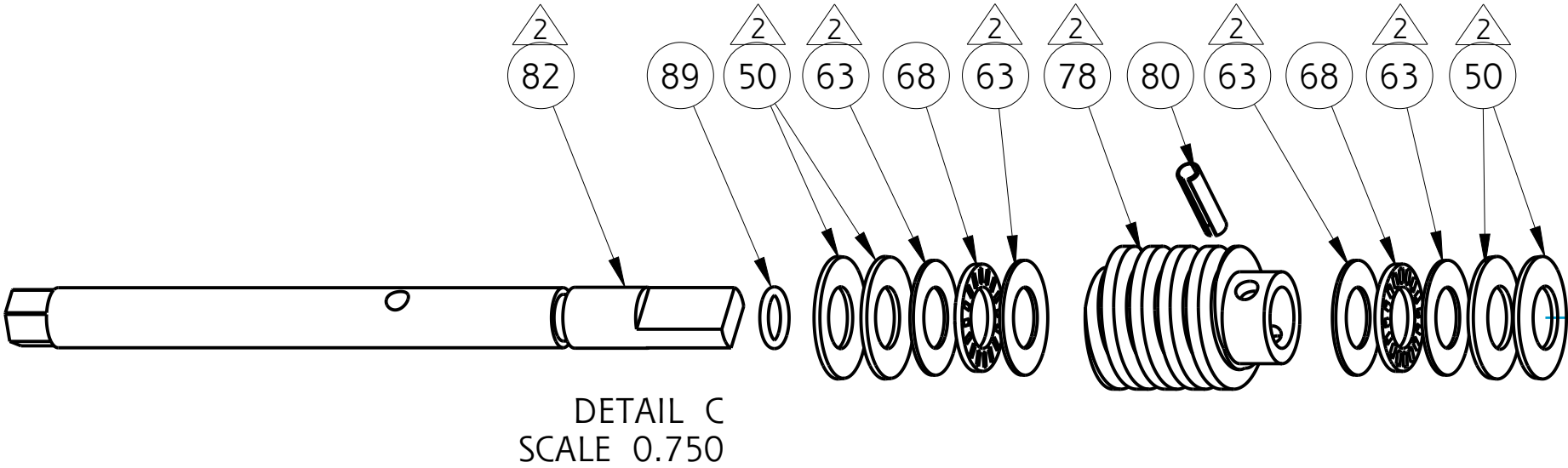
4"-5" JAMESBURY
(25:1 GEAR RATIO)



ASSEMBLY NOTES:

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

- 1 USE PERMABOND LM113 OR LOCTITE 222
- 2 USE LOW-TEMP LUBRIPLATE .
- 3 USE PRIMER T AND PERMABOND HH120 OR LOCTITE 277
- 4 USE PERMABOND LH050 OR LOCTITE 592
- 5 TORQUE TO 50 FT-LBS
- 6 SEE TABLE FOR STAMPING OF HOUSING.
- 7 TRUNNION SHOWN IS FOR 2 -3.5" ACTUATOR.
- 8 OIL DIP.
- 9 USE LOCTITE 290
- 10 SECURE WITH PERMABOND 200.
- 11 USE TOOL BT-11462
- 12 FILL GEARBOX WITH GREASE.
- 13 ASSEMBLE MAGNET SO THAT IT IS FLUSH WITH TOP OF TRUNNION.
- 14 CALIBRATE THE UNIT AFTER ASSEMBLY.



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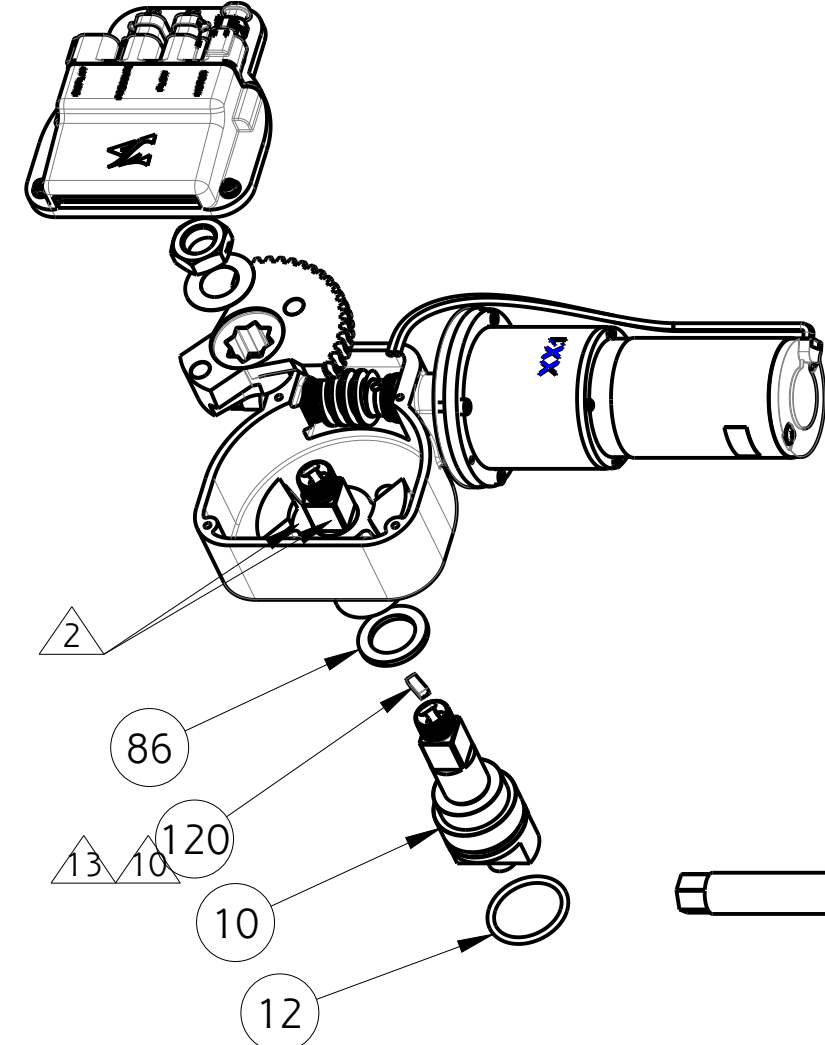
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Parts List Sheet:

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.

- 1

USE PERMABOND LM113 OR LOCTITE 222
- 2

USE LOW-TEMP LUBRIPLATE .
- 3

USE PRIMER T AND PERMABOND HH120 OR LOCTITE 277
- 4

USE PERMABOND LH050 OR LOCTITE 592
- 5

TORQUE TO 50 FT-LBS
- 6

SEE TABLE FOR STAMPING OF HOUSING.
- 7

TRUNNION SHOWN IS FOR 2 -3.5" ACTUATOR.
- 8

OIL DIP.
- 9

USE LOCTITE 290
- 10

SECURE WITH PERMABOND 200.
- 11

USE TOOL BT-11462
- 12

FILL GEARBOX WITH GREASE.
- 13

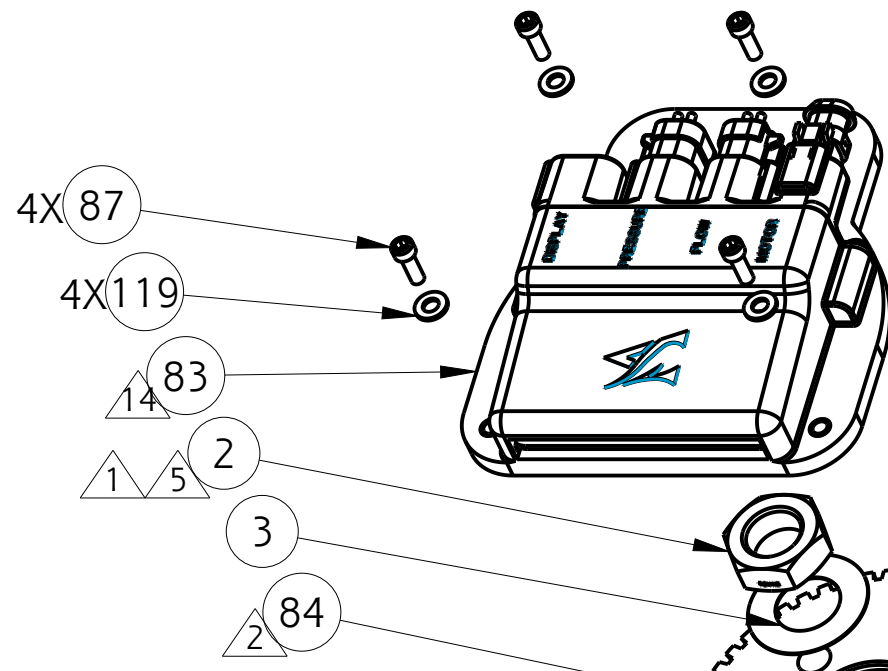
ASSEMBLE MAGNET SO THAT IT IS FLUSH WITH TOP OF TRUNNION.
- 14

CALIBRATE THE UNIT AFTER ASSEMBLY.

8X-BTFLY ACTUATOR

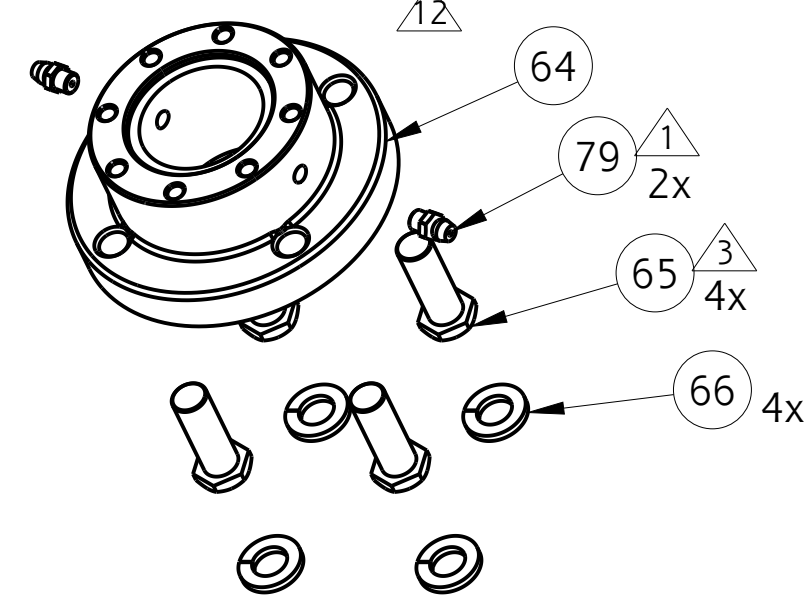
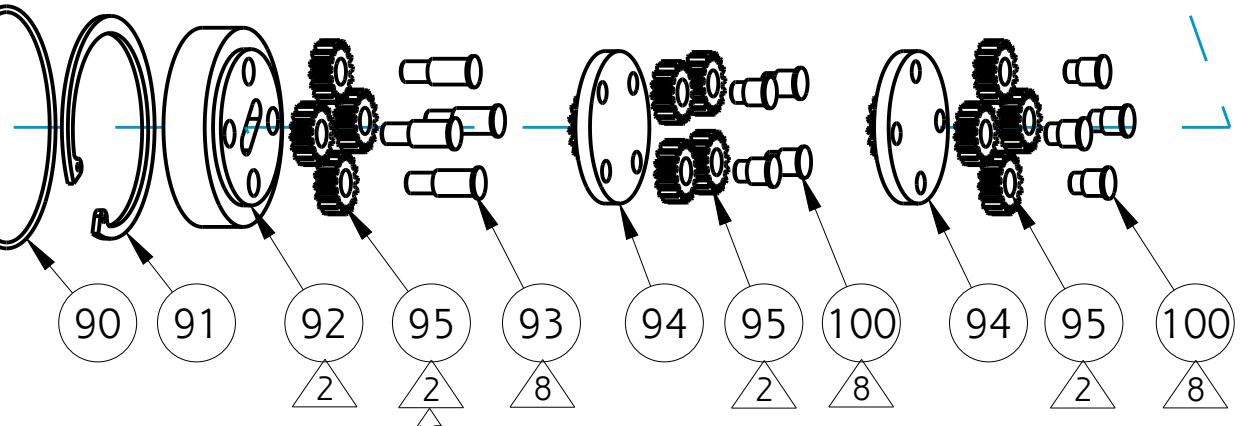
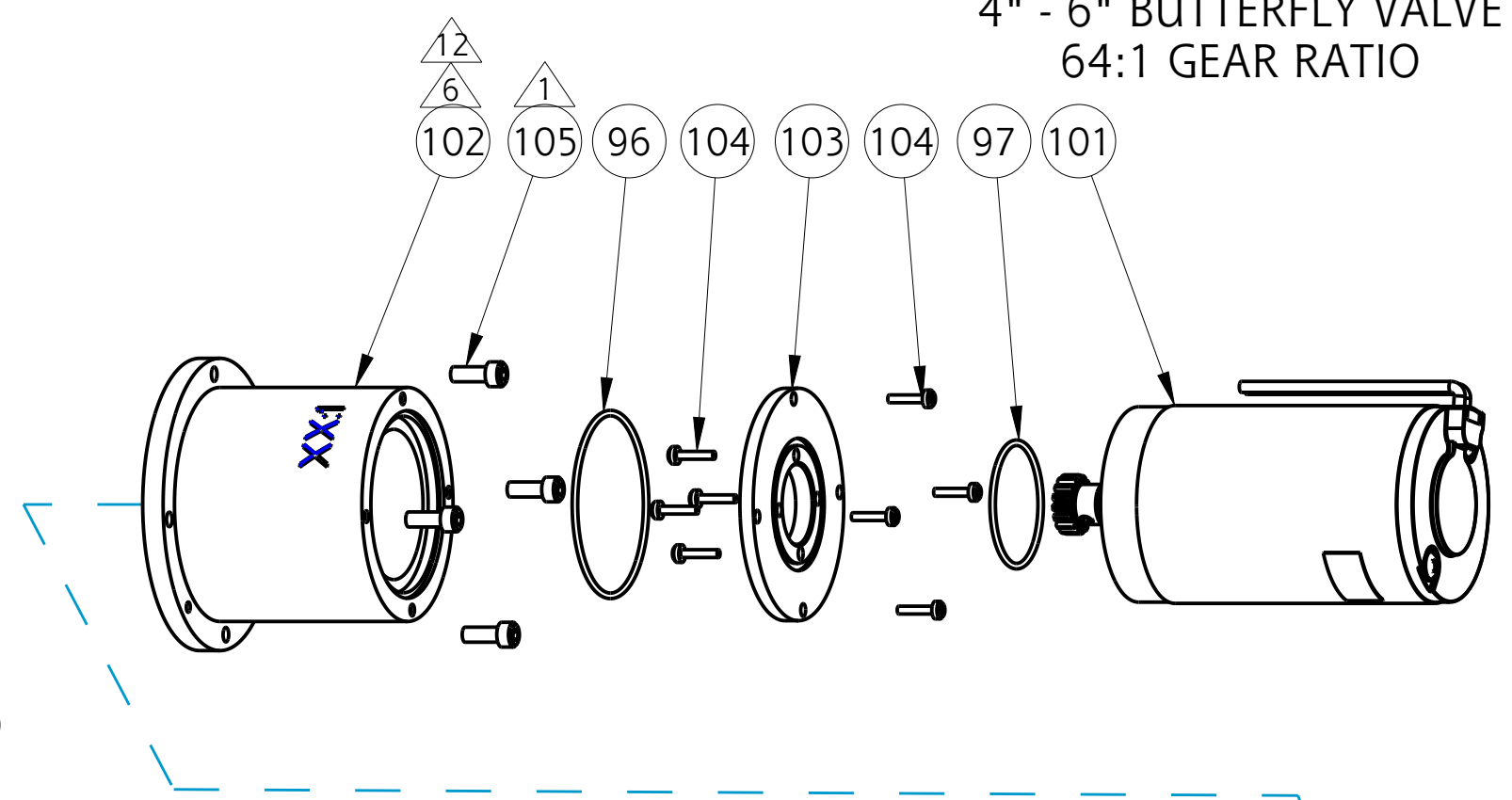
4X-4" S/O VALVE ACTUATOR

SEE DETAIL B



4" - 6" BUTTERFLY VALVE

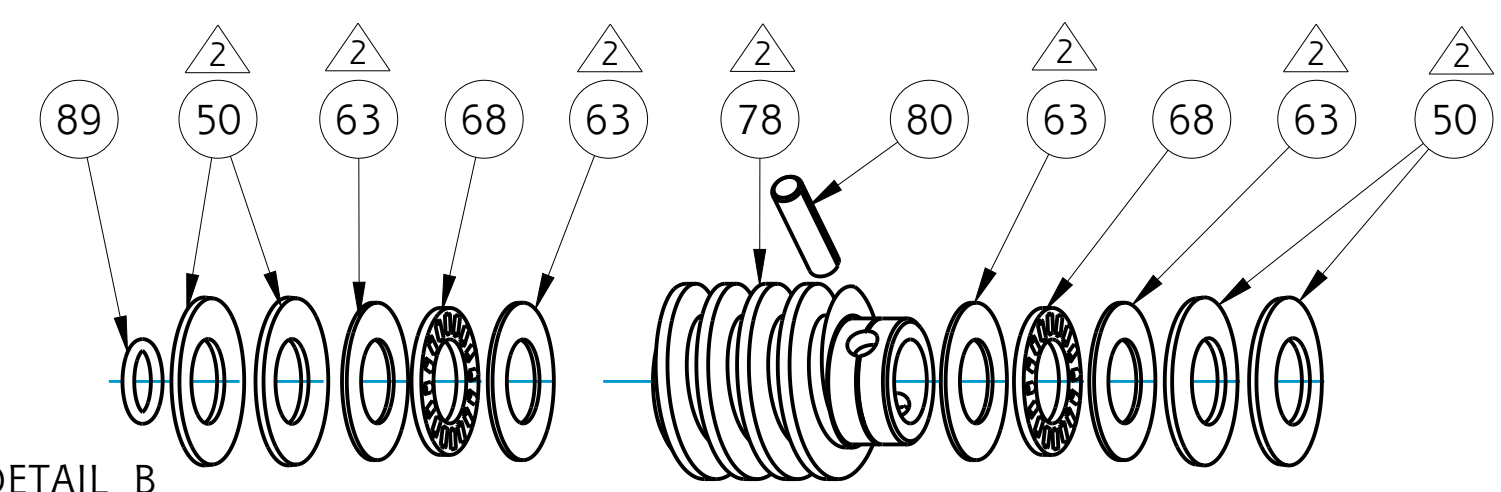
64:1 GEAR RATIO




GEAR RATIO XX:1	VALVE SIZE
64:1	4-6" ABZ BUTTERFLY VALVE
64:1	4" S/O VALVE

DETAIL B

SCALE 0.875



		TECHNICAL SERVICE PARTS			
		STYLE 8600,7900,8900			
		PRODUCT 2-4" S/O VALVES			
FIND NO:	DESCRIPTION	ITEM NO:	QUANTITY FOR 16:1 GEAR RATIO ACTUATOR, 2"-3.5" SWINGOUT	QUANTITY FOR 25:1 GEAR RATIO ACTUATOR, 4"-5" JAMESBURY	QUANTITY FOR 64:1 GEAR RATIO ACTUATOR, 4"-6" ABZ BUTTERFLY, 4" S/O VALVE
1	SPACER	770395	-	1	1
2	NUT 3/4 - 16 x27/64	734116	1	1	1
3	WASHER	784231	1	1	1
10	TRUNNION	*	1	1	1
12	O-RING 2-214	757010	1	-	-
12	O-RING 2-222	757006	-	-	1
50	SPRING BELLEVILLE	769276	-	4	4
61	SOCKET HEAD CAP SCREW 3/8-16 x 3/4"	765160	-	4	4
63	WASHER	784111	4	4	4
64	BRACKET MOUNT	703541	-	1	-
64	ADPT BTFLY	116281	-	-	1
65	HEX BOLT 7/16-14 x 1-1/4"	761024	-	-	4**
66	LOCK WASHER	784116	-	-	4**
68	BEARING NEEDLE	703453	2	2	2
77	THRUST WASHER	784103	1	-	-
78	WORM GEAR	784190	1	1	-
78	WORM GEAR	784190	-	-	1
79	GREASE FITTING	713034	1	1	3
80	GROOVE PIN	741058	-	-	1
80	ROLL PIN	744068	1	1	-
81	ACTUATOR HOUSING	721717	1	-	-
81	ACTUATOR HOUSING	721716	-	1	1
82	SHAFT	769510	1	1	1
83	MOTOR DRIVER	128423	1	1	1
84	SECTOR GEAR	123261	-	1	1**
84	SECTOR GEAR	126667	1	-	-
85	SET SCREW	765117	1~	-	1#
85	SET SCREW	765082	-	1^	-
86	WASHER THRUST	784104	1	1	1
87	SCREW 8-32 X 1/2	765155	4	4	4
88	SCREW 1/4-20 x 5/8	765029	-	4	-
88	SCREW 10-24 x 5/8	765028	4	-	-
88	SCREW 1/4-20 X 3/4	765030	-	-	8**
88	SCREW 1/4-20 X 3/4	765030	-	-	4++
89	O-RING 2-012	757282	-	1	1
90	O-RING 2-039	757263	1~~	1^^	1##
91	RETAINING RING	758172	1~~	1^^	1##
92	OUTPUT CARRIER PLATE	742118	-	1^	-
92	PLATE CARRIER	742121	1~	-	1#
93	RIVET LONG	754051	4~	3^	4#
94	CARRIER PLATE	718346	-	1^	-
94	PLATE CARRIER SHORT	718345	1~	-	2#
95	GEAR PLANET 18 TOOTH	718341	-	6^	-
95	GEAR PLANET 16 TOOTH	718339	8~	-	12#
96	O-RING 2-035	757280	1~~	1^^	1##
97	O-RING 2-029	757056	1~~	1^^	1##
99	GEAR MOTOR	718343	1~	-	1#
99	GEAR MOTOR	718344	-	1^	-

IF AN ITEM IS NOTED AS "NOT FIELD REPAIRABLE", OR YOU WISH TO RETURN AN ITEM TO AKRON BRASS FOR SERVICE PLEASE GO ONLINE TO, **ONLINEREPAIR.AKRONBRASS.COM**

Chg.	Date
16	11-24
17	01-25

FIND NO:	DESCRIPTION	ITEM NO:	QUANTITY FOR 16:1 GEAR RATIO ACTUATOR, 2"-4" SWINGOUT	QUANTITY FOR 25:1 GEAR RATIO ACTUATOR, 4" DISCHARGE 4"-5" JAMESBURY	QUANTITY FOR 64:1 GEAR RATIO ACTUATOR, 4"-6" ABZ BUTTERFLY
100	RIVET SHORT	754052	4~	3^	8#
101	MOTOR S/A 12V	86255006	1	-	1
101	MOTOR S/A 24V	86255007	1	-	1
101	MOTOR S/A 12V	86255008	-	1	-
101	MOTOR S/A 24V	86255009	-	1	-
102	GEAR HOUSING	109296	1	-	-
102	GEAR HOUSING	118161	-	1	-
102	GEAR HOUSING	120268	-	-	1
103	MOTOR FACE PLATE	745100	1	1	1
104	SCREW 6-32 X 1/2	765052	8~ ~	8^^	8##
105	SCREW 10-24 X 1/2	763038	4	4	4
119	WASHER 3/8 X .188 X .04	784123	4	4	4
120	MAGNET	*	1	1	1
-	GEAR ASSEMBLY 16:1 KIT	86252501	~ ~	-	-
-	GEAR ASSEMBLY 16:1 KIT W/ACCS	86252502	-	-	-
-	GEAR ASSEMBLY 25:1 KIT	86252503	-	^^	-
-	GEAR ASSEMBLY 25:1 KIT W/ACCS	86252504	-	-	-
-	GEAR ASSEMBLY 64:1 KIT	86252505	-	-	##
-	GEAR ASSEMBLY 64:1 KIT W/ACCS	86252506	-	-	-

- * SEE TABLE 2
- ** FOR 4" - 6" ABZ BUTTERFLY VALVE ONLY
- + + FOR 4" SWINGOUT VALVE ACTUATOR ONLY
- ^ INCLUDED IN GEAR ASSEMBLY 25:1 KIT
- ^^ INCLUDED IN GEAR ASSEMBLY 25:1 KIT W/ACCS
- ~ INCLUDED IN GEAR ASSEMBLY 16:1 KIT
- ~ ~ INCLUDED IN GEAR ASSEMBLY 16:1 KIT W/ACCS
- # INCLUDED IN GEAR ASSEMBLY 64:1 KIT
- ## INCLUDED IN GEAR ASSEMBLY 64:1 KIT W/ACCS

TABLE: 2		
FIND NO:10 TRUNNION ITEM NO. *	SIZE OF VALVE	QTY
86255075	2.5"	1
86305074	3.0"	1
89405009	4.0"	1
79405010	4.0" JAMESBURY	1
79405504	4" ABZ	1
79505504	5" & 6" ABZ	1

GEAR RATIO XX:1	VALVE SIZE
16:1	2"-3.5" SWING OUT
25:1	4" DISCHARGE & 4"-5" JAMESBURY
64:1	4"-6" ABZ BUTTERFLY 4" SWINGOUT

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Parts List Sheet:

123292

D46595