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REBUILDING HYDRAULIC ACTUATOR

1. CAUTION!! MAKE SURE THAT HYDRAULIC FLOW TO THE VALVE HAS BEEN DISABLED AND THAT THE GATE OF THE VALVE IS FULLY CLOSED.
2. DISCONNECT HYDRAULIC HOSE FROM ACTUATOR.
3. LOOSEN JAM NUT (ITEM#1)
4. SPIN ACTUATOR FROM TOP OF VALVE HOUSING.
5. REMOVE ALLEN HEAD BOLTS THAT HOLD TOP VALVE HOUSING FROM BOTTOM VALVE HOUSING.
6. PULL ACTUATOR AWAY FROM VALVE. THE TOP VALVE HOUSING AND GATE WILL COME AWAY WITH THE ACTUATOR.
7. REMOVE GATE FROM ACTUATOR ROD BY STRIKING WITH A MALLET.
8. SPIN TOP VALVE HOUSING FROM THE ACTUATOR.
9. CLAMP ACTUATOR HOUSING TUBE (LONG ROUND PORTION) OF THE ACTUATOR IN A VICE.
10. UNSCREW ACTUATOR ADAPTER ITEM #4) FROM THE ACTUATOR AND PULL AWAY FROM HOUSING TUBE.
11. REMOVE ACTUATOR ROD (ITEM# 5) FROM ADAPTER. INSPECT ROD FOR NICKS AND AREAS OF EXCESSIVE WEAR. PAY SPECIAL ATTENTION TO THE WAY OLD SEALS ARE INSTALLED ONTO ROD AND IN ADAPTER.
12. REMOVE ROD FROM ADAPTER. REMOVE SEALS FROM ADAPTOR & ROD. CLEAN ADAPTER & ROD. INSTALL NEW SEALS ON BOTH. **PAY CLOSE SPECIAL ATTENTION TO ORIENTATION OF PISTON SEAL. THIS ITEM HAS TO BE INSTALLED WITH THE FLARE DOWN OR TOWARD ADAPTER**. REINSTALL ROD INTO ADAPTER.
13. REMOVE GAS SPRING FROM HOUSING TUBE. CLEAN GAS SPRING AND HOUSING TUBE. INSPECT HOUSING TUBE FOR SCORING AND RUST. IF THERE ARE SIGNS OF SEVERE SCORING AND RUST THEN REPLACEMENT OF THE ACTUATOR IS RECOMMENDED.
14. REINSTALL GAS SPRING INTO HOUSING TUBE. REINSTALL ADAPTER WITH ROD ONTO HOUSING TUBE.
15. SPIN TOP VALVE HOUSING ONTO ACTUATOR 2-3 TURNS. INSTALL GATE ONTO ROD.
16. REINSTALL ACTUATOR WITH VALVE TOP & GATE ONTO LOWER VALVE HOUSING. MAKE SURE FLANGES OF TOP AND BOTTOM VALVE HOUSINGS ARE FLUSH OR CLOSE TO FLUSH. REINSTALL ALLEN HEAD SCREWS.
17. TURN ACTUATOR INTO TOP VALVE HOUSING. STOPPING WHEN TURNING ACTUATOR BECOMES SLIGHTLY STIFF WITH A SMALL PIPE WRENCH. TIGHTING THE ACTUATOR TO FAR INTO TOP VALVE HOUSING WILL CAUSE GATE TO PRELOAD TOO FAR INTO LOWER VALVE SLOT AND WILL RESULT IN BINDING OF THE GATE INTO THE LOWER VALVE HOUSING.
18. TIGHTEN JAM NUT AGAINST TOP VALVE HOUSING.
19. RECONNECT HYDRAULIC HOSE. TEST OPERATION.