

### TO REPLACE GEAR HEAD

#### 1. DISASSEMBLY / PREP

Remove the 4 screws that fasten the gear head to valve body mounting flange. *See Illustration 1.* Remove gear head from valve body. **DO NOT** misplace the stainless-steel seal retaining washer that sits over the shaft seal in the valve body. This washer will need to be reused. Remove silicone residue from valve body mounting flange. Be certain the keyhole shaped cutout area is completely clear of debris and residue. *See Illustration 2.*

#### 2. RE-ASSEMBLY

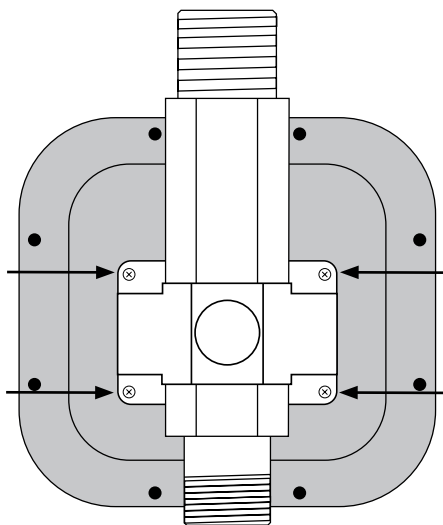
Place stainless-steel washer over shaft seal in valve body (if it was removed in Step 1).

Place Nylon Washer, then Seal Retainer Sleeve onto shaft of Servo Valve Power Head. *See Illustration 3 & 4 next page.*

Carefully place new gear head onto valve body making sure the groove in the valve body shaft and the tongue on the gear head shaft properly engage. If necessary, rotate the gear head back and forth until they fit together. (*See Illustration 2*).

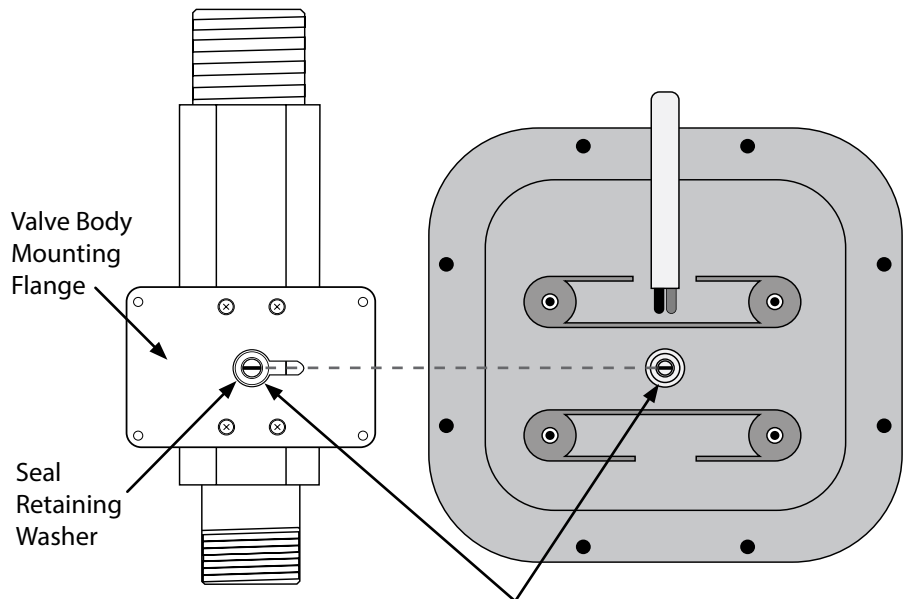
3. Make sure mounting flange support bracket is in place, then start all four valve body to gear head mounting screws. Securely tighten them in a crossing pattern.

*Illustration 1*



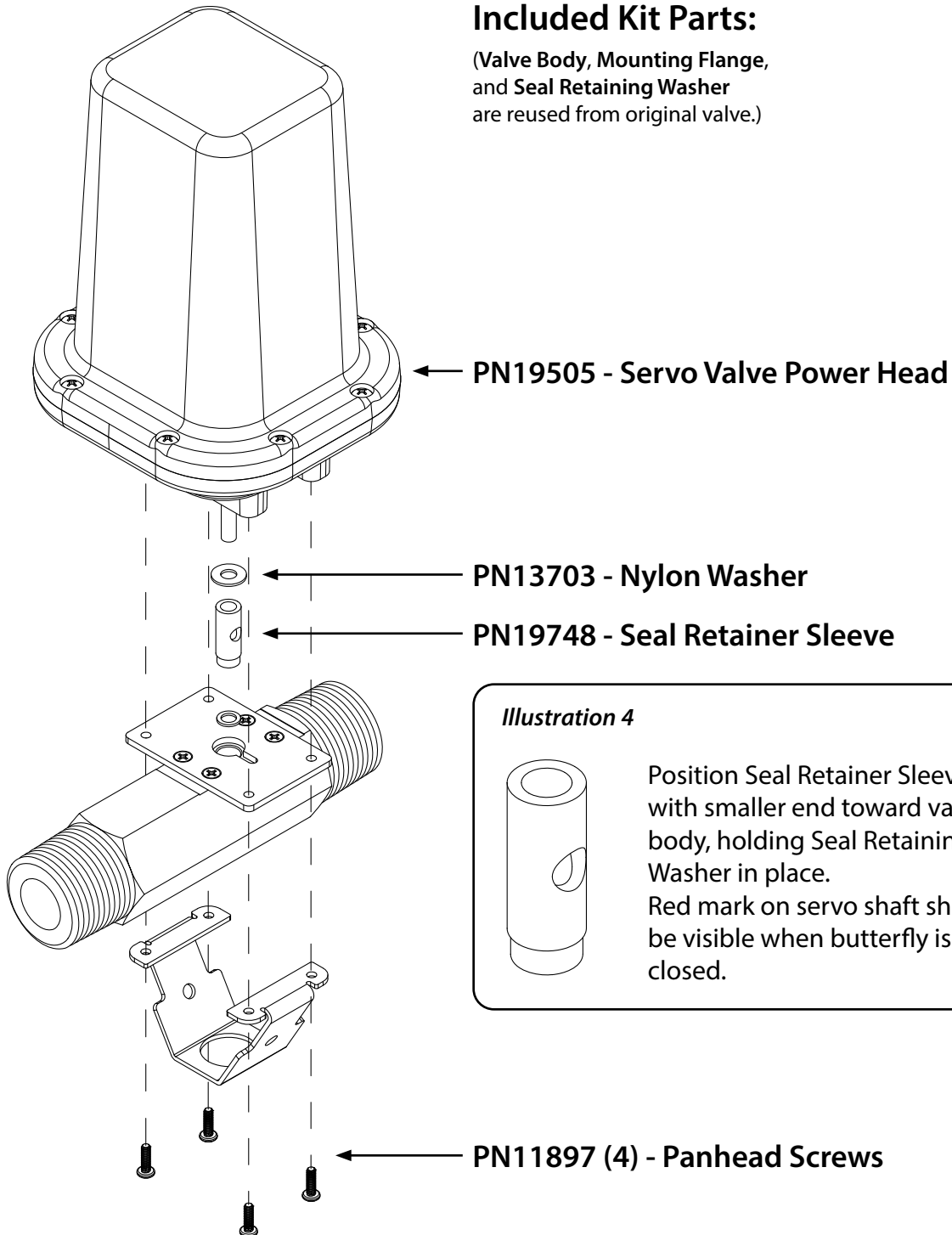
Remove 4 screws on valve body mounting plate to release gear head assembly.

*Illustration 2*

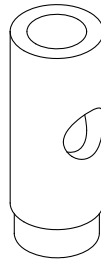


These parts must engage together on re-assembly.

**Illustration 3**



**Illustration 4**



Position Seal Retainer Sleeve with smaller end toward valve body, holding Seal Retaining Washer in place. Red mark on servo shaft should be visible when butterfly is closed.