



NH3 Servo Head Replacement Instructions:

Operate the replacement servo gear head to the end of rotation in one direction.

Manually move the valve body butterfly to the same position.

Make sure gear head shaft's tongue and valve body shaft's groove fit together.

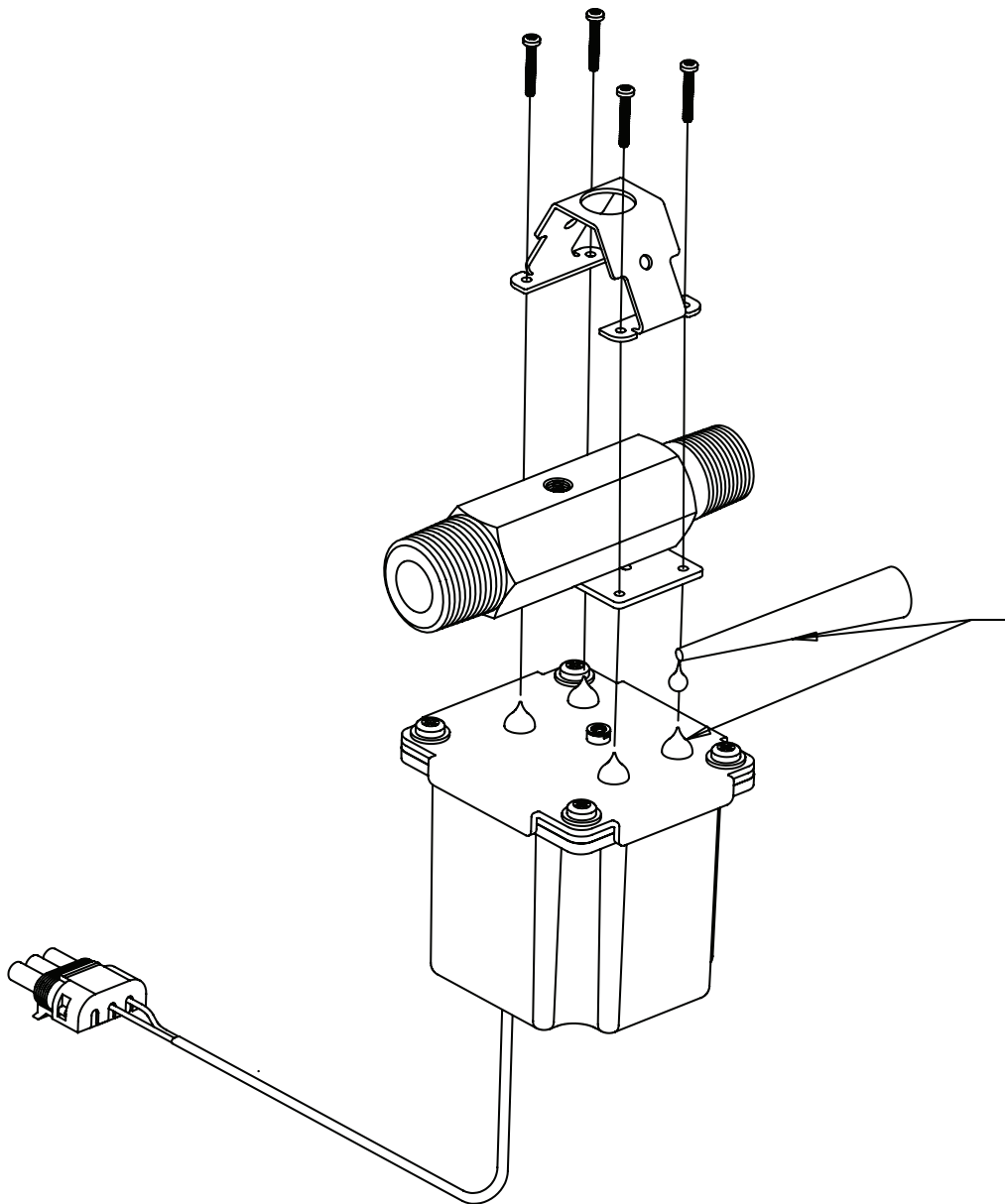
Remove the valve body from the gear head.

Apply a pea-sized amount of RTV Silicone over each of the 4 valve body mounting holes on the gear head (see below).

Fit the gear head to the valve body with the support bracket around it.

Thread in the four machine screws, tightening them in a criss-cross pattern.

Test for correct motion of the butterfly.



PLACE RTV ON
SCREW HOLES TO
SEAL SCREWS
WHEN TIGHTENED