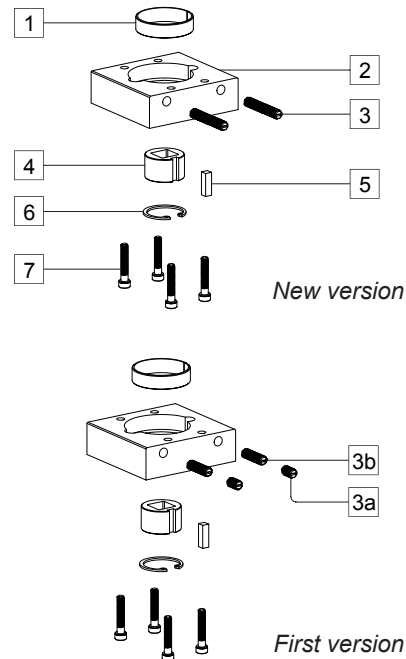




2013-06



## Body Adaptor Kit Assembly Instructions



### BODY ADAPTOR KIT DIS-ASSEMBLY

- Remove retainer circlip (6) to allow removal of insert sleeve (4) and insert key (5).
- First version: Unscrew 2 x lock screws (3a) from body adaptor and partially unscrew 2 x adjustment screws (3b).
- New version: Unscrew 2 x Nuts and partially unscrew 2 x adjustment (3) screws.
- Remove 4 x bolts (7) from body adaptor (2).
- Gently remove body adaptor (2) ensuring stop adjustment bearing (1) is also removed and placed into body adaptor (2) after disassembly.

### BODY ADAPTOR KIT ASSEMBLY

- Insert body adaptor bearing (1) into body adaptor (2) and apply a small amount of grease.
- Place body adaptor (2) over driveshaft ensuring stop screw holes is facing the front of the actuator (same position as air inlet ports).
- Insert 4 x body adaptor bolts (7) into body adaptor (2) and fasten.
- First version: Insert 2 x stop screws (3b) and adjust to required position, then secure with 2 x lock screws (3a).
- New version: Insert 2 x adjustment screws (3) with washers and nuts and adjust to required position.
- Place insert sleeve (4) and key (5) ensuring it is in the correct orientation (in-line or cross mount).
- Replace retainer circlip (6) to ensure insert sleeve (4) and key (5).

### Stop Screw Turns Required from Screw being Flush with BAK

|             | 8 F05 | 8 F07 | 12 F05 | 12 F07 | 20 F07 | 35 F07 | 35 F10 | 55 F10 | 55 F12 | 70 F10 | 70 F12 | 100/150 F14 |
|-------------|-------|-------|--------|--------|--------|--------|--------|--------|--------|--------|--------|-------------|
| 0° Closed   | 12.5  | 11.00 | 10.00  | 10.00  | 11.60  | 10.00  | 10.00  | 13.30  | 13.30  | 13.30  | 13.30  | 16.00       |
| 90° Open    | 12.5  | 11.00 | 10.00  | 10.00  | 11.60  | 10.00  | 10.00  | 13.30  | 13.30  | 13.30  | 13.30  | 16.00       |
| 0-2.5° Adj. | 1.13  | 1.20  | 1.20   | 1.20   | 0.96   | 1.06   | 1.06   | 1.25   | 1.25   | 1.25   | 1.25   | 1.22        |