

# A1633-KIT

## Parallel Shaft Gearbox Installation Instructions

The A1633-Kit will not fit valves with a Bronze Half Ball or that were built prior to 01/01/03.



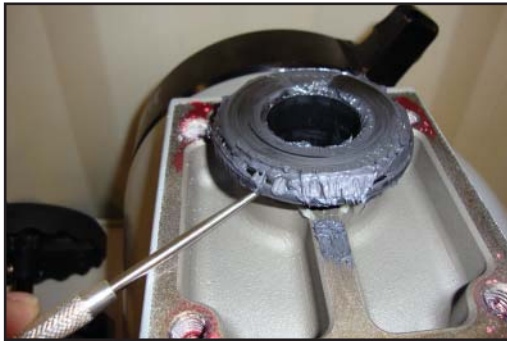
**Items Required:** Parallel Shaft Gearbox Kit (A1633-KIT)

**Kit Includes:** Parallel Gearbox Assembly, Mounting Bolts and Red Loctite® #271.

**Tools Required:** 5/16" Allen Wrench and a Pick or similar tool.



**STEP 1)** Place the ball valve to the full open position. Using the 5/16" Allen wrench remove the socket head cap screws that retain the horizontal shaft gearbox assembly to the valve body. \*\*The threads of these screws have Loctite® #271 applied, extra leverage and/or heat may be required in order to remove.



**STEP 2)** Using the seal pick carefully remove the gear spacer that is pressed into the top of the valve body. The gear spacer is not utilized in the installation of the parallel shaft gearbox.



**STEP 3)** Insure that the o-ring installed in the valve body stays in place.

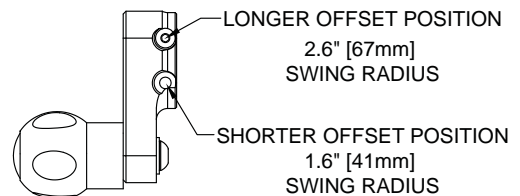
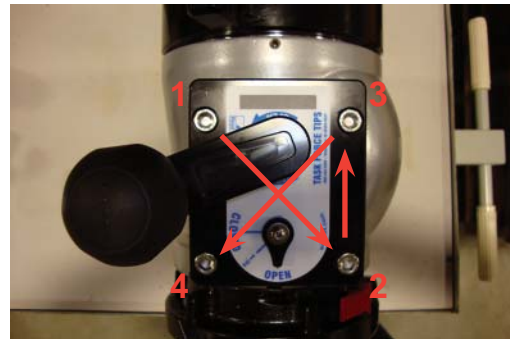
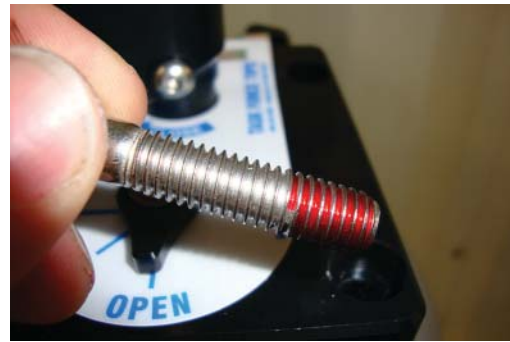


Figure 4.10

**STEP 4)** Place valve ball and the parallel shaft gearbox in the open position. Viewed from the inlet or hose side of the valve the ball should be rotated to the right or 3 o'clock position. If ball is difficult to rotate apply a light grease to the lower trunion and mating hole in the half ball.

**Note:** When equipped with a crank handle, two offset positions are available to adjust the swing radius of the crank and knob as shown in figure 4.10. The longer offset position offers reduced effort to operate the valve. The shorter offset is available to avoid interference with other equipment on the apparatus. To change the offset, remove two 3/8"-16 x 1-1/2" button head cap screws from crank. Place crank in desired position and replace screws.



**STEP 5)** Install the gearbox with the positional indicator closest to the hose side coupling of the valve. Some adjustment of the valve ball may be needed in order to properly align the gearbox trunion with the mating socket of the valve ball.

**STEP 6)** Apply Loc-tite® #271 to the first half inch of threads of the screws included with the kit. Install the four screws tightening them in a criss-cross pattern.



Original Serial Number



New Serial Number

**STEP 7)** Insure free operation of the valve and that the gearbox position indicator matches the ball position. Once assembly is complete, install the valve on your apparatus when installed on the apparatus and check for leaks before placing it back in service.

**STEP 8)** Fill out the postage paid postcard with the serial number of the original gearbox, the number of the new gearbox, and return to Task Force Tips.