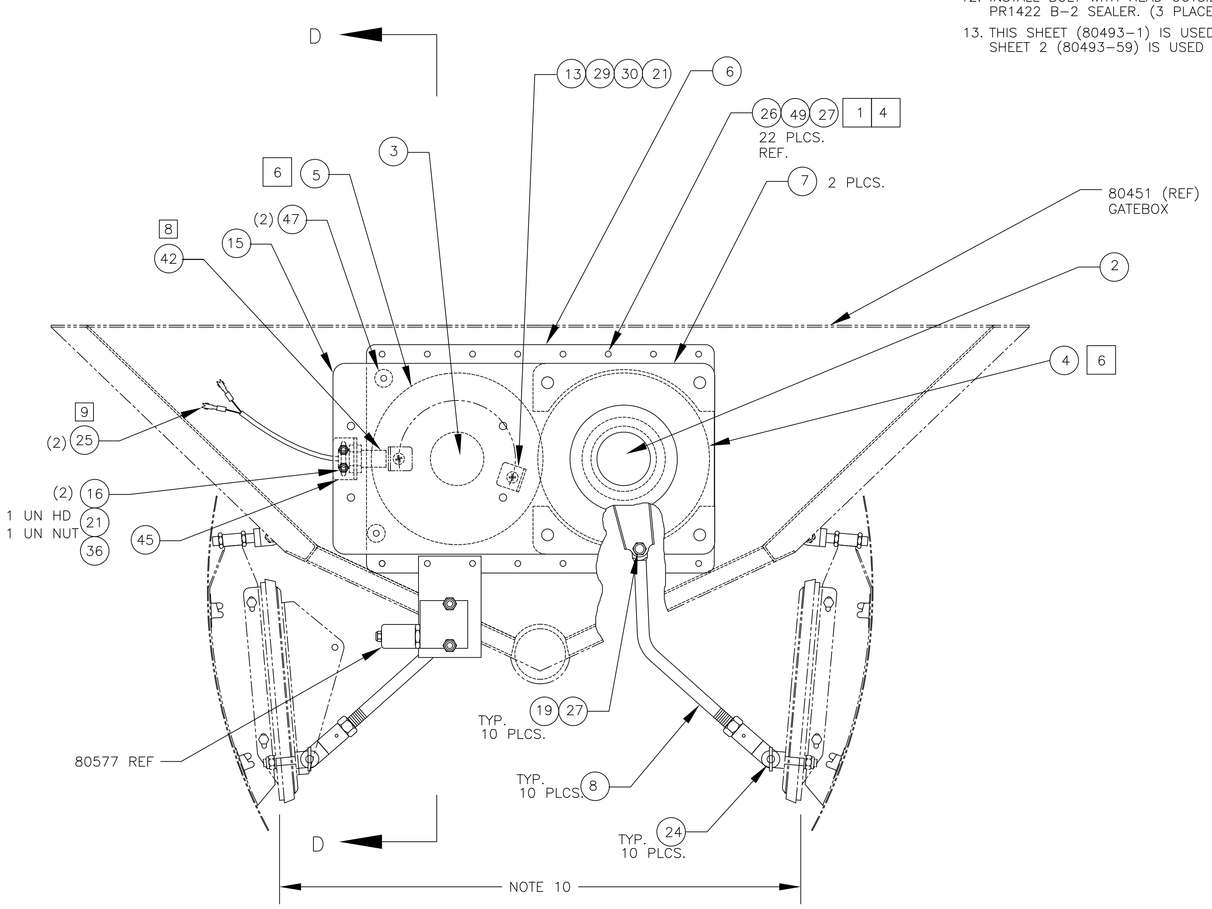
NOTES:

1. INSTALL BOLTS WITH HEAD TOWARD INSIDE OF TANK AND SEAL WITH PR1422 B-2 SEALER.
2. ADJUST GATEBOX POTENTIOMETER AS DESCRIBED IN FRDS MAINTENENCE MANUAL SECTION 1.3.12.1.
3.
4. SEAL PLATE TO GATEBOX WITH PR1422 B-2 SEALER.
5. TO INSTALL ACTUATOR #17; INSTALL GEARS AND ADJUST DOORS PER DESCRIPTION IN DETAIL "F". COMPLETELY SHUT DOORS. WHILE FACING THE OUTPUT SHAFT OF THE ACTUATOR, ROTATE THE SHAFT FULLY COUNTER-CLOCKWISE, TO THE INTERNAL STOP. HOLD THE ACTUATOR SO THE HYDRAULIC CONNECTIONS FACE DOWN. CAREFULLY INSERT THE ACTUATOR SHAFT INTO THE SHAFT #2. ROTATE ACTUATOR SLIGHTLY TO ALIGN WITH HOLES IN MOUNT #7 AND INSTALL BLOTS #22 & NUTS #23.
6. ALIGN GEARS AS SHOWN IN DETAIL "F".
7. INSTALL SPACERS AS REQUIRED TO CENTER SHAFTS IN GATEBOX AND TO PROPERLY ALIGN GEARS #4 & #5.
8. AIM -42 PROXIMITY SENSOR TOWARDS CENTER OF -13 BRKT. GAP BETWEEN PROXIMITY SENSOR AND BRKT TO BE .090.
9. TRIM -42 WIRE 6". INSTALL -25 WRISTLOCKS PER 60326.
10. FULLY OPEN WIDTH IS 19 3/4 ± 1/4.
11. ALTERNATE PROXIMITY SWITCH IS 871TM-DH5NE18-H2 (ALLEN-BRADLEY).
12. INSTALL BOLT WITH HEAD OUTSIDE OF TANK. SEAL WITH PR1422 B-2 SEALER. (3 PLACES)
13. THIS SHEET (80493-1) IS USED FOR 70588-1 MANUAL EMERGENCY DUMP. SHEET 2 (80493-59) IS USED FOR 70588-2 BLEED AIR EMERGENCY DUMP.

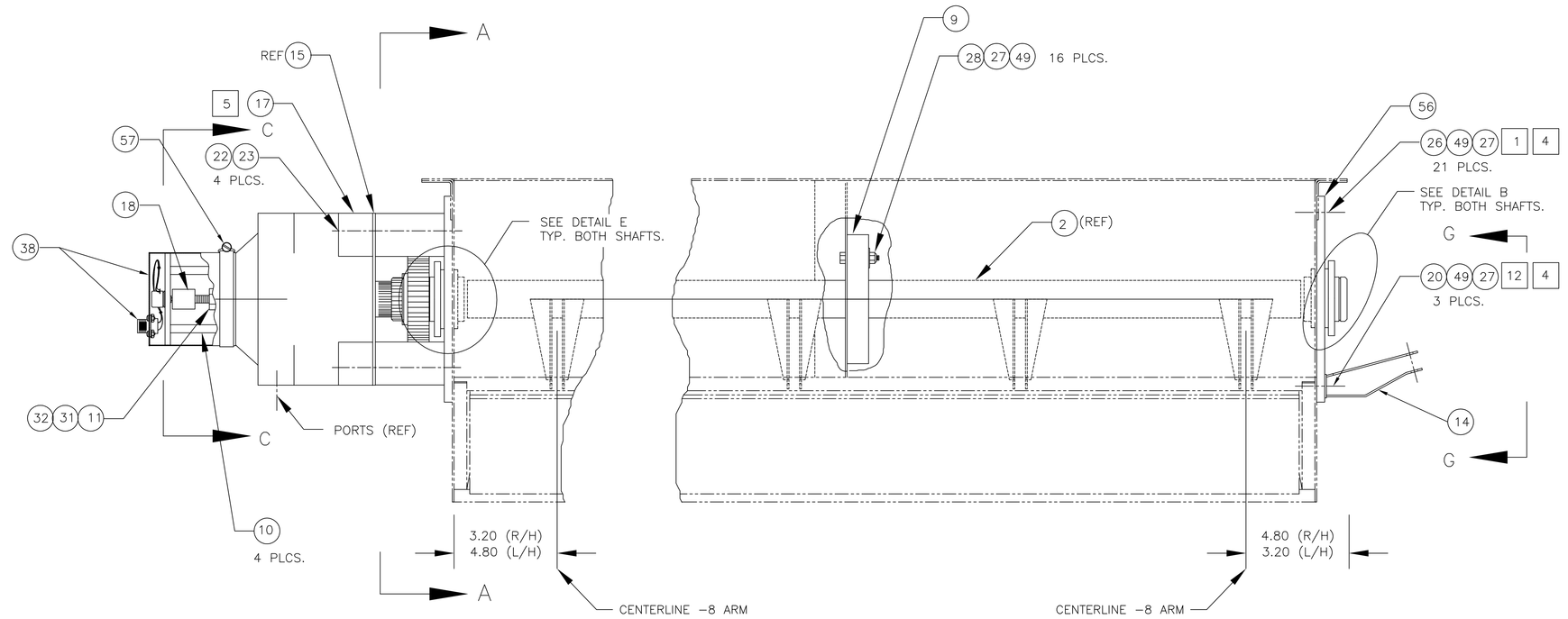
REV	LETTER	EFFECTIVITY	CHANGE	REF	DATE	BY	CHK
	A	0001	REDESIGNED GATEBOX	3	7/1/92	MS	LS
	B	0006	-42 WAS BZE6-2RN	3	11/16/94	MS	KB
	C	0020	ADDED -14 BRKT	3	7/24/95	MS	KB
	D	0001	REDESIGNED EMERGENCY				
			DUMP (ITEM -14)	5	12/21/95	MS	LS
	E	0042	DELETED -14 (70593-1 BRKT)	3	12/5/96	MS	LS
	F	0042	CANCELED "E" REV.	3	4/9/97	MS	LS
	G	0064	REDESIGNED -12 & -38	3	4/7/98	MS	LS
	H	0066	ADDED SHEET 2, NOTE 13;				
			SHEET 1 OBS	3	5/29/98	MS	LS

1 OK TO USE PARTS MADE | 2 PARTS MAY BE REWORKED | 3 RECORD CHANGE | 4 NOW SHOP PRACTICE | 5 SCRAP EXISTING PARTS | NOTED

80493 SHEET 1

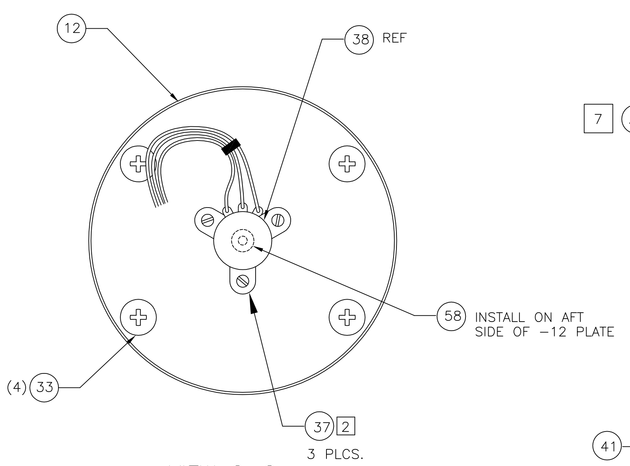


SECTION A-A



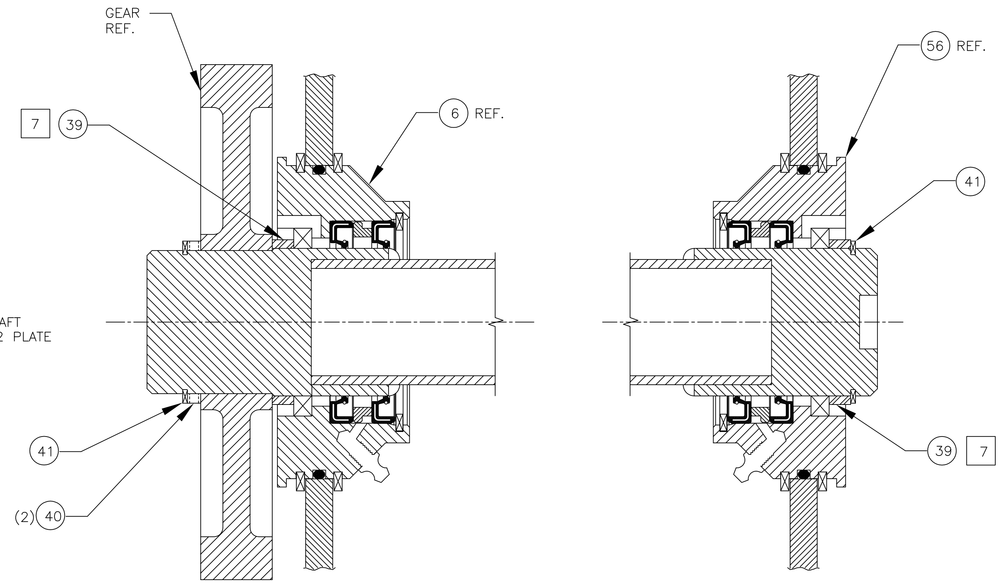
L/H SIDE VIEW

(DOORS NOT SHOWN)



VIEW C-C

FULL SCALE



DETAIL E

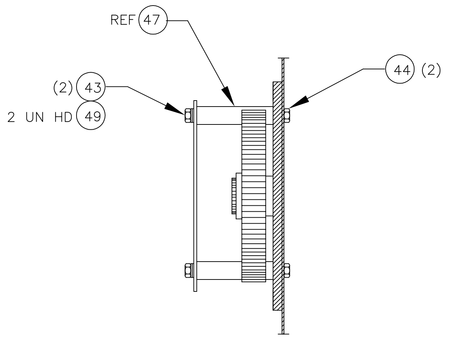
FULL SCALE

TYP. 2 PLCS.

DETAIL B

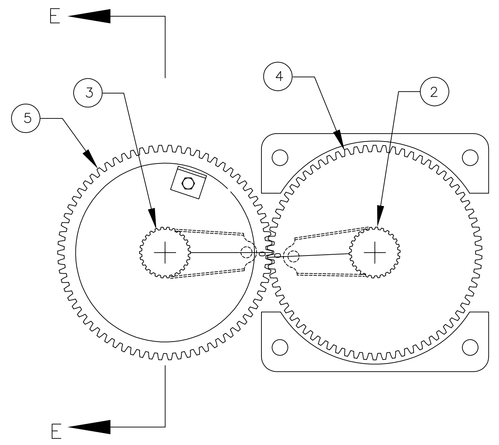
FULL SCALE

TYP. 2 PLCS.



SECTION D-D

NOT TO SCALE



DETAIL F

(NOT TO SCALE)

(ALL ITEM #'S FOR REFERENCE ONLY)

GEAR ADJUSTMENT PROCEDURE:

A. INSTALL RH GEAR #5 ON SHAFT #3, ALIGNING INDEX MARKS ON GEAR WITH ARMS ON SHAFT (INSIDE BOX) AS SHOWN. DO NOT INSTALL WAVESPRINGS OR SNAPRING AT THIS TIME.

B. INSTALL LH GEAR #4 ON SHAFT #2 AND ALIGN INDEX MARK ON GEAR WITH ARMS ON SHAFT (INSIDE GATEBOX) AS SHOWN. DO NOT ENGAGE GEARS AT THIS TIME.

C. ROTATE RH SHAFT #3 UNTIL ARMS ARE HORIZONTAL

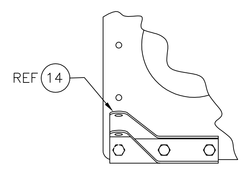
D. ROTATE LH SHAFT #2 UNTIL ARMS ARE SLIGHTLY BELOW HORIZONTAL AS SHOWN.

E. SLIDE LH GEAR #4 INTO ENGAGEMENT WITH RH GEAR #5.

F. INDEX MARKS SHOULD BE SEPARATED BY ONE TOOTH AS SHOWN.

G. INSTALL WAVE SPRING #40 & SNAPRING #41 PER NOTE #7.

H. ADJUST ARM ASSEMBLY #8 TO OBTAIN PROPER CLOSING ACTION OF DOORS.



SECTION G-G

13	59			SEE SHEET 2		1	80473	802F
	58		B9-1	1	BUSHING (BERG)			
	57		QS200M64S	1	CLAMP (BREEZE)			
	56		80492-2	1	PLATE ASSY (AFT)			
	55							
	54							
	53							
	52							
	51							
	50							
	49		AN960C416	AR	WASHER			
	48							
	47		80787-1	2	BUSHING			
	46							
	45		80859-1	1	PLATE			
	44		AN4C6A	2	BOLT			
	43		AN4C5A	2	BOLT			
11	42		FL7M-5J6D-M	1	PROXIMITY SWITCH (MICROSWITCH)			
	41		5108-200	4	SNAPRING (WALDES "TRUARC")			
	40		W2645-028	4	WAVE SPRING (ASSOCIATED SPRING)			
	39		80491-AR	AR	SPACER			
	38		60430-1	1	POT. ASSY.			
	37		L3-3	3	CLEAT/SCREW (P.I.C.)			
	36		MS21044C3	2	NUT			
	35							
	34							
	33		———	4	SCREW 1/4 X 20 X 3			
	32		———	1	NUT (MS35649-2252)			
	31		———	1	LOCKWASHER (MS35338-25)			
	30		———	1	LOCKWASHER (MS35338-24)			
	29		AN3C4A	1	BOLT			
	28		NAS501414A	16	BOLT			
	27		MS21044C4	72	LOCKNUT			
	26		NAS50147A	41	BOLT			
	25		RA18-D	2	WRISTLOCK			
	24		D5-061-303	10	FASPIN			
	23		MS21044C8	4	NUT			
	22		AN8C54A	4	BOLT			
	21		AN960C10	5	WASHER			
	20		AN4C10A	3	BOLT			
	19		NAS501410A	10	BOLT			
	18		T15-7	1	COUPLING			
	17		80784-1	1	ACTUATOR			
	16		AN3C5A	2	BOLT			
	15		80786-1	1	PLATE			
	14		70593-1	1	BRKT ASSY			
	13		80510-1	1	BRACKET			
	12		80495-1	1	PLATE			
	11		80498-1	1	ADAPTER			
	10		80497-1	4	STANDOFF			
	9		80487-1	2	SUPPORT			
	8		80478-1	10	ARM ASSY.			
	7		80486-1	2	STANDOFF			
	6		80492-1	1	PLATE ASSY (FWD)			
	5		80490-2	1	GEAR			
	4		80490-1	1	GEAR			
	3		80484-1	1	SHAFT (R/H)			
	2		80483-1	1	SHAFT (L/H)			
13	1		80493-1	✓	ASSY		OBS 80473	802F

ITEM	PART NUMBER	NO. REQ.	PART NUMBER	NO. REQ.	DESCRIPTION	SIZE	SPEC.	ZONE	NO. REQ.	NEXT ASSEMBLY	MODEL
	OPPOSITE ASSEMBLY		SHOWN ASSEMBLY		MATERIAL						

REMOVE ALL BURRS AND SHARP CORNERS | DRAWN CSL | DATE 2/4/91 | CHECKED MS | APPROVED | EFFECTIVITY 802-0001

WELD | FINISH NONE | HEAT TREAT | ACT. WT. | CALC. WT.

TOLERANCES EXCEPT AS NOTED

ANGLES	X	1	1/2°
FRACTIONS	X	1/64	
.XX	±	.010	
.XXX	±	.010	
.XXXX	±	.001	

DRILLED HOLES

.060 TO .124 DIA.	+ .002 - .001
.134 TO .228 DIA.	+ .003 - .001
.234 TO .500 DIA.	+ .004 - .001
.515 TO .750 DIA.	+ .005 - .001

SNOW ENGINEERING CO.
WICHITA FALLS, TEXAS

TITLE ASSY-
GATEBOX ACTUATOR

SCALE 1/3 | REV H | SIZE 36 X 44

DRAWING NUMBER 80493 SHEET 1