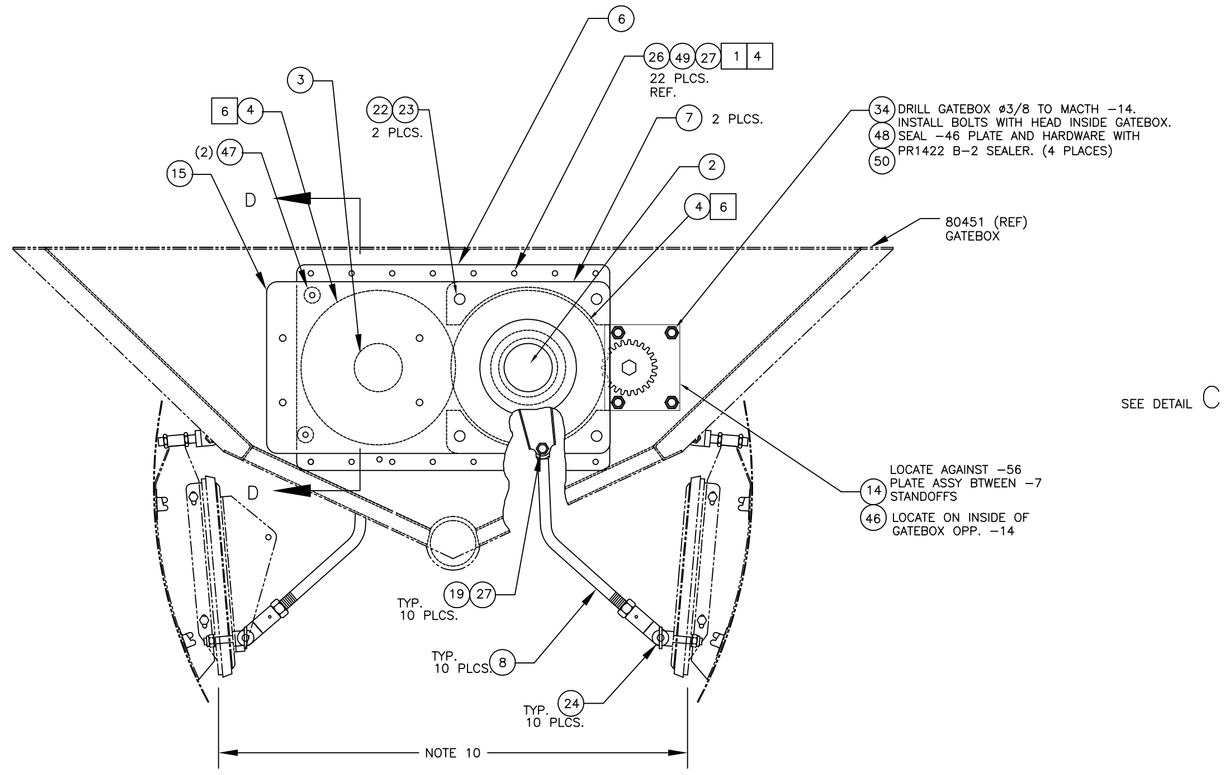
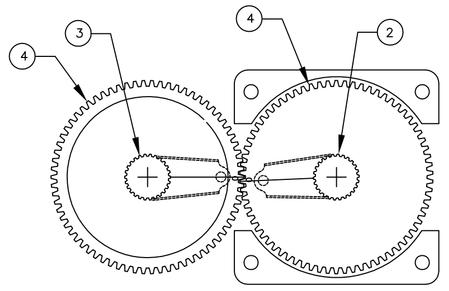
NOTES:

1. INSTALL BOLTS WITH HEAD TOWARD INSIDE OF TANK AND SEAL WITH PR1422 B-2 SEALER.
2.
3. INSTALL BOLTS WITH HEAD TOWARD OUTSIDE OF TANK AND SEAL WITH PR1422 B-2 SEALER.
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 #4 GEARS.
8.
9.
10. FULLY OPEN WIDTH IS 19 3/4 ± 1/4.
11.
12. INSTALL BOLT WITH HEAD OUTSIDE OF TANK. SEAL WITH PR1422 B-2 SEALER. (3 PLACES)
13. INSTALL WITH BLUE LOCTITE THREADLOCKER #242.
14. THESE PARTS FURNISHED WITH P/N 1001-0005 FRDS-GEN2 SYSTEM FROM TROTTER CONTROLS AS SPARES KIT 1098-0016.



SECTION A-A



DETAIL F
(NOT TO SCALE)
(ALL ITEM #'S FOR REFERENCE ONLY)

GEAR ADJUSTMENT PROCEDURE:

A. INSTALL RH GEAR #4 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

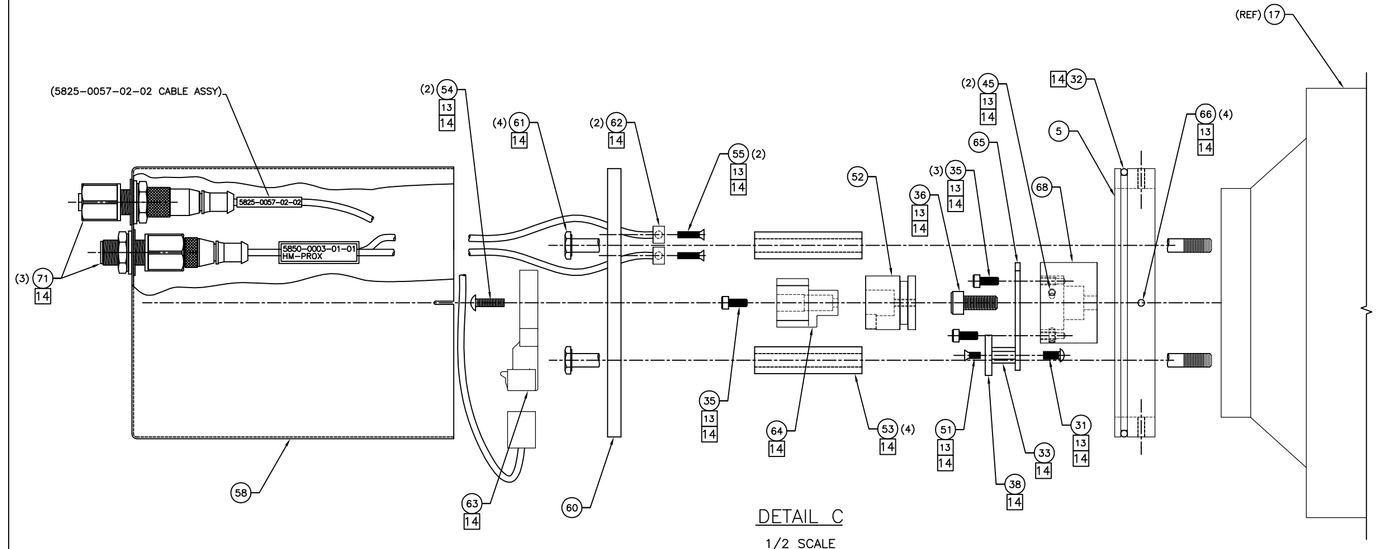
D. ROTATE LH SHAFT #2 UNTIL ARMS ARE SLIGHTLY BELOW HORIZONTAL AS SHOWN.

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

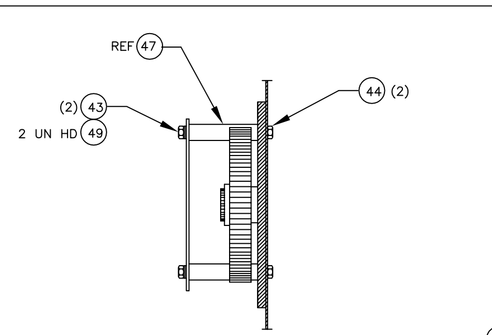
F. INDEX MARKS SHOULD BE SEPARATED BY ONE TOOTH AS SHOWN.

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

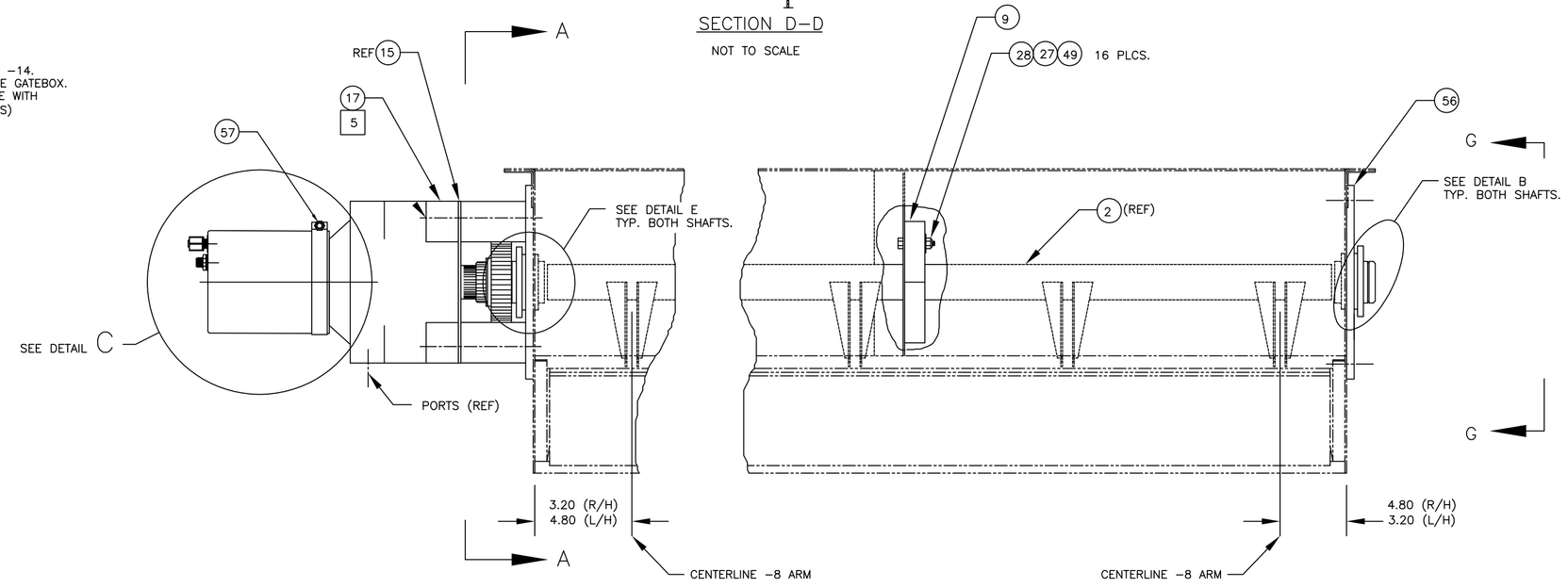
H. ADJUST ARM ASSEMBLY #8 TO OBTAIN PROPER CLOSING ACTION OF DOORS.



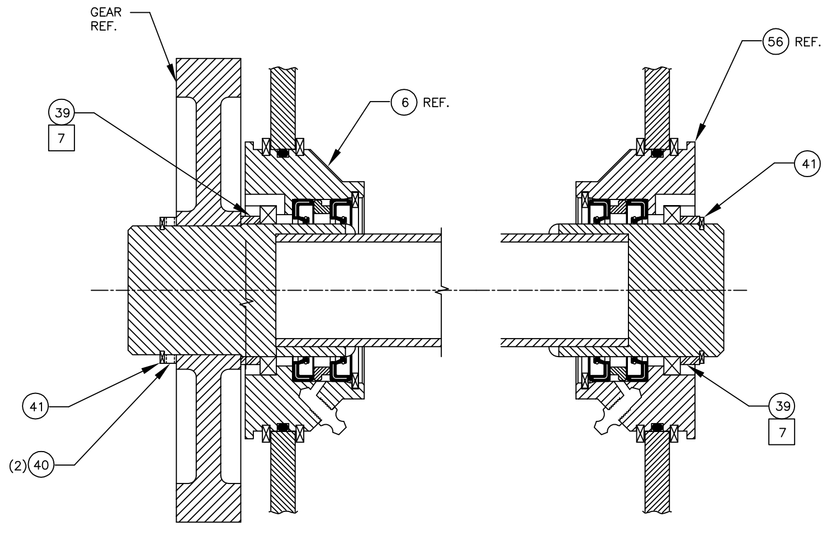
DETAIL C
1/2 SCALE



SECTION D-D
NOT TO SCALE

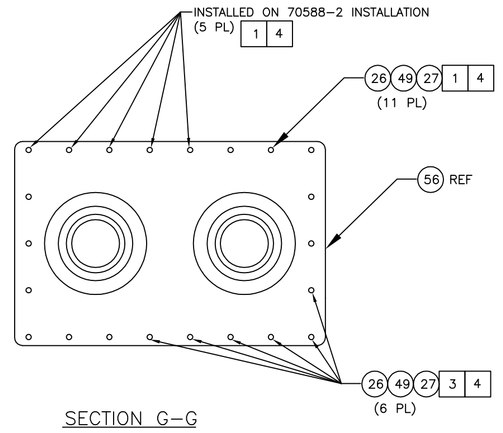


L/H SIDE VIEW
(DOORS NOT SHOWN)



DETAIL E
FULL SCALE
TYP. 2 PLCS.

DETAIL B
FULL SCALE
TYP. 2 PLCS.



SECTION G-G

LETTER	EFFECTIVITY	CHANGE	REF	DATE	BY	CHK

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

80493 SHEET 4 REV

ITEM	PART NUMBER	REQ. QUAN.	PART NUMBER	REQ. QUAN.	DESCRIPTION	SIZE	SPEC.	ZONE	REQ. QUAN.	NEXT ASSEMBLY	MODEL
	OPPOSITE ASSEMBLY		SHOWN ASSEMBLY		MATERIAL						
14	71		FK-FS-4.5/M12	3	FEED-THRU RECEPTACLE (TUROX)(SUPPLIED BY TROTTER CONTROLS)						
	70		80493-70	✓	ASSY				1	80473	802F
	69		80493-69	X	SEE SHEET 3				OBS	80473	802F
	68		61362-1	1	ANGLE ADJUSTER						
	67										
14	66		90289A191	4	8-32 X 5/16" SET SCREW (McMASTER-CARR)						
	65		61361-1	1	STANDOFF PLATE						
14	64		5850-0005	1	SENSOR MAGNET (TROTTER CONTROLS)						
14	63		5850-0004	1	ANGLE SENSOR (TROTTER CONTROLS)						
14	62		61583-1	2	PROX SENSOR						
14	61		91257A556	4	BOLT (McMASTER-CARR)(1/4-20 X 3 1/2)						
	60		61359-1	1	SENSOR MOUNT PLATE						
13	59		80493-59	X	SEE SHEET 2				OBS	80473	802F
	58		61363-1	1	COVER						
	57		9400-0500	1	CLAMP (CLAMPCO)						
	56		80492-2	1	PLATE ASSY (AFT)						
14	55		92210A108	2	SCREW (McMASTER-CARR)						
14	54		91772A819	2	SCREW (McMASTER-CARR)						
14	53		92320A926	4	SPACER (McMASTER-CARR)						
	52		61360-1	1	MAGNET HOLDER						
14	51		92210A192	1	SCREW (McMASTER-CARR)						
	50		MS21044C6	4	NUT						
	49		AN960C416	AR	WASHER						
	48		AN960C616	AR	WASHER						
	47		80787-1	2	BUSHING						
	46		81766-1	1	PLATE						
14	45		91375A146	2	6-32 X 3/8 SET SCREW (McMASTER-CARR)						
	44		AN4C6A	2	BOLT						
	43		AN4C5A	2	BOLT						
	42										
	41		5108-200	4	SNAPRING (WALDES "TRUARC")						
	40		W2645-028	4	WAVE SPRING (ASSOCIATED SPRING)						
	39		80491-AR	AR	SPACER						
14	38		92908A130	1	WASHER (McMASTER-CARR)						
	37										
14	36		92200A539	1	SCREW (McMASTER-CARR)						
14	35		92200A146	3	SCREW (McMASTER-CARR)						
	34		AN6C33A	4	BOLT						
14	33		91115A197	1	STANDOFF (McMASTER-CARR)						
14	32		9464K548	1	O-RING (McMASTER-CARR)						
14	31		92949A190	1	SCREW (McMASTER-CARR)						
	30										
	29										
	28		NAS501-4-14A	16	BOLT						
	27		MS21044C4	67	LOCKNUT						
	26		NAS501-4-7A	36	BOLT						
	25										
	24		D5-06T-303	10	FASPIN						
	23		MS21044C8	4	NUT						
	22		AN8C56A	4	BOLT						
	21										
	20		AN4C10A	3	BOLT						
	19		NAS501-4-10A	10	BOLT						
	18										
	17		80784-1	1	ACTUATOR						
	16										
	15		82072-1	1	PLATE						
	14		81767-1	1	CLOSURE GEARBOX						
	13										
	12										
	11										
	10										
	9		80487-1	2	SUPPORT						
	8		80478-1	10	ARM ASSY.						
	7		80486-1	2	STANDOFF						
	6		80492-1	1	PLATE ASSY (FWD)						
	5		61364-1	1	ANGLE SENSOR ENCLOSURE						
	4		80490-1	2	GEAR						
	3		80484-5	1	SHAFT (R/H)						
	2		80483-5	1	SHAFT (L/H)						
	1		80493-1	X	SEE SHEET 1				OBS	80473	802F

REMOVE ALL BURRS AND SHARP CORNERS
WELD
FINISH NONE
HEAT TREAT
ACT. WT. CALC. WT.

DRAWN MS DATE 1/23/08 CHECKED LS
APPROVED EFFECTIVITY 802-0307

TOLERANCES EXCEPT AS NOTED
ANGLES ± 1 1/2° FRACTIONS ± 1/16 .XX ± .03 .XXX ± .005

SNOW ENGINEERING CO.
WICHITA FALLS, TEXAS

TITLE ASSY- GATEBOX ACTUATOR

SCALE 1/5 REV
SIZE D
DRAWING NUMBER 80493 SHEET 4