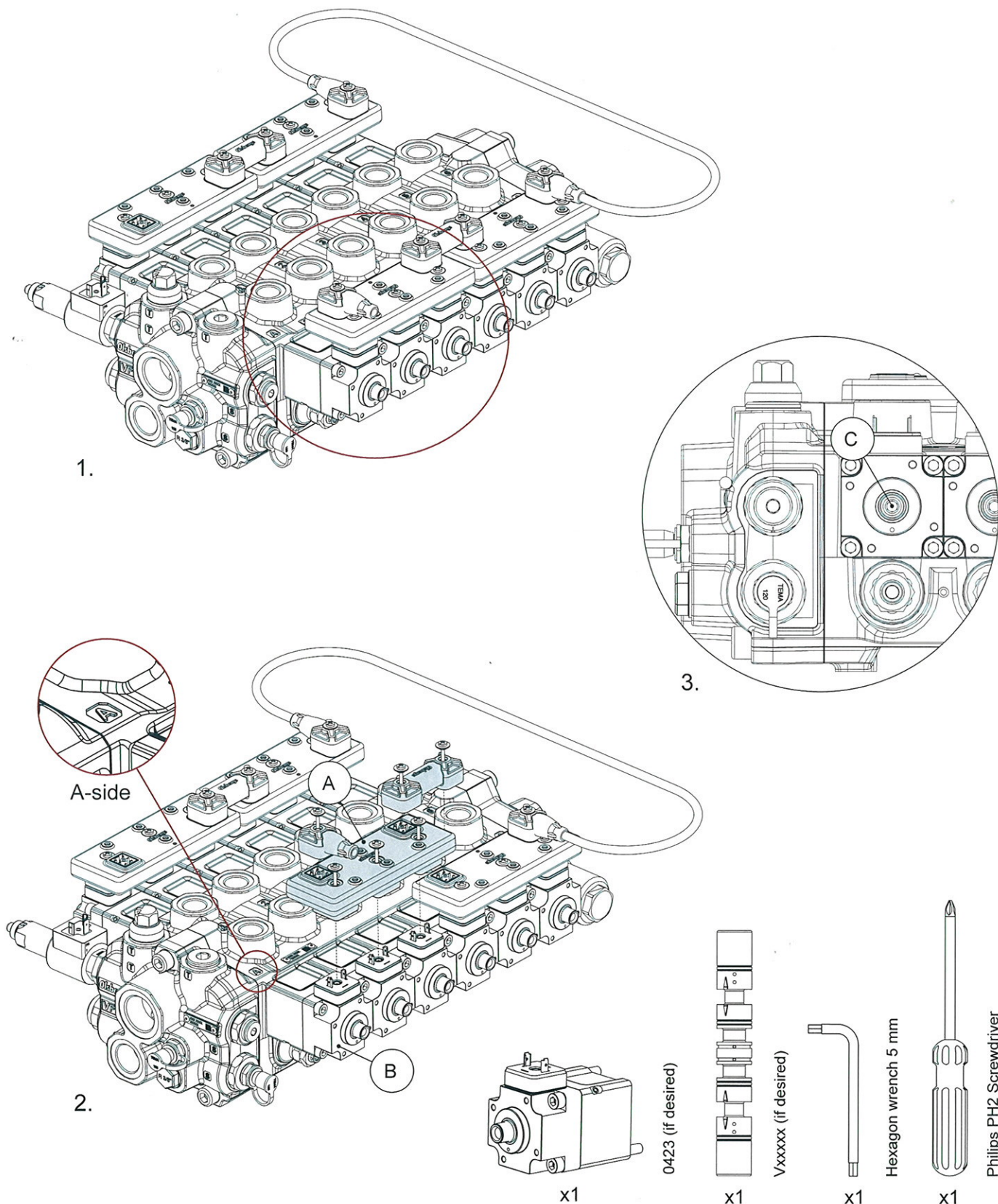


Instruction - Positioner and spool

Changing of positioner and/or spool (Page 1/7)

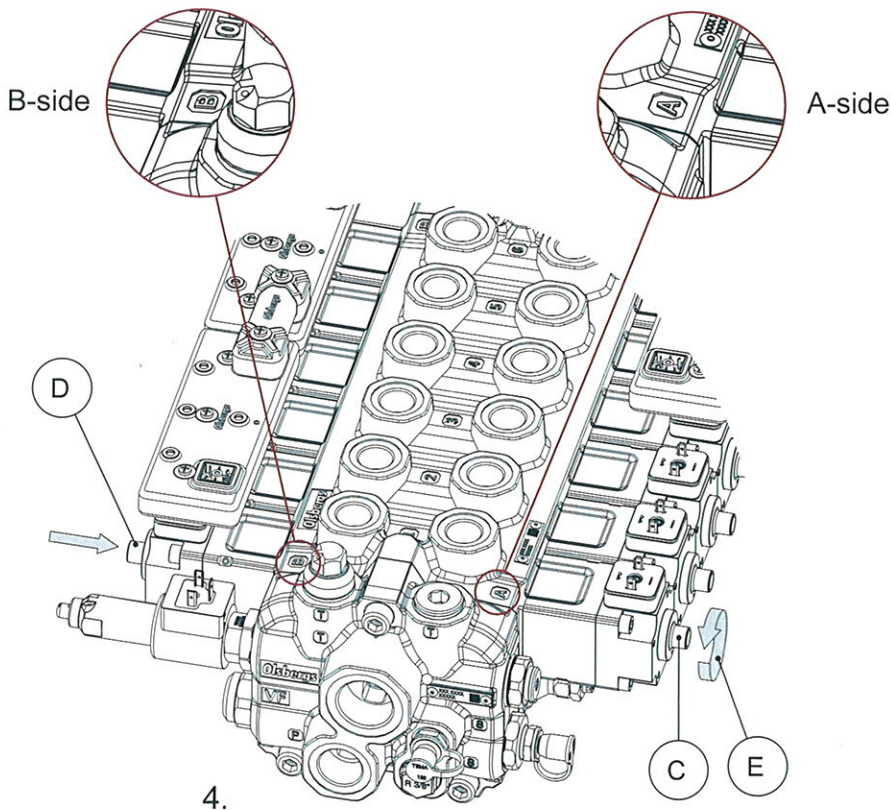


Instructions

1. Clean around the area you will be working to avoid dirt in sensitive components.
2. Dismount the DA-module (A) that is located on the positioner (B) you need to access using a Philips PH2 screwdriver or equivalent.
3. Insert the 5 mm hexagon wrench in the piston rod (C) on the positioner. Do the same on the positioner on the opposite side of the valve (in this case the B-side).

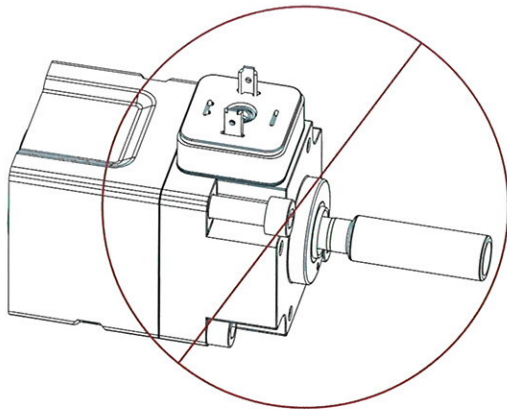
Instruction - Positioner and spool

Changing of positioner and/or spool (Page 2/7)

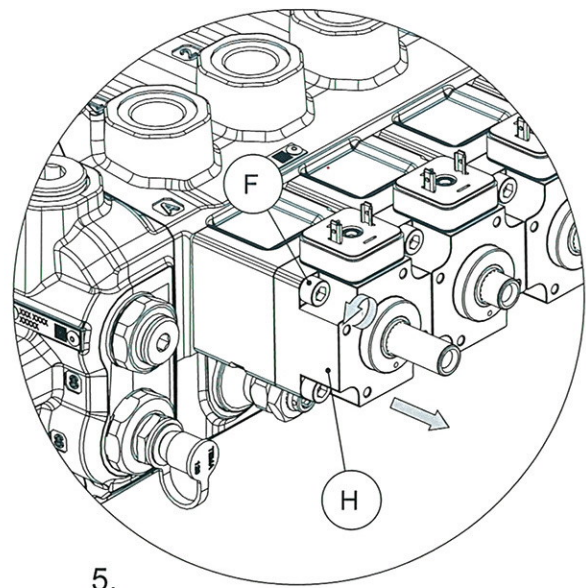


Always **prevent** the spool from turning in the valve house due to the risk of damage on the spool.

Remember that both piston rods are threaded in the same direction and if the piston rod on the B-side would loosen, **skip to step 9.**



Do not pull the piston rod too far out from the positioner because of the risk of dirt entering the positioner house.



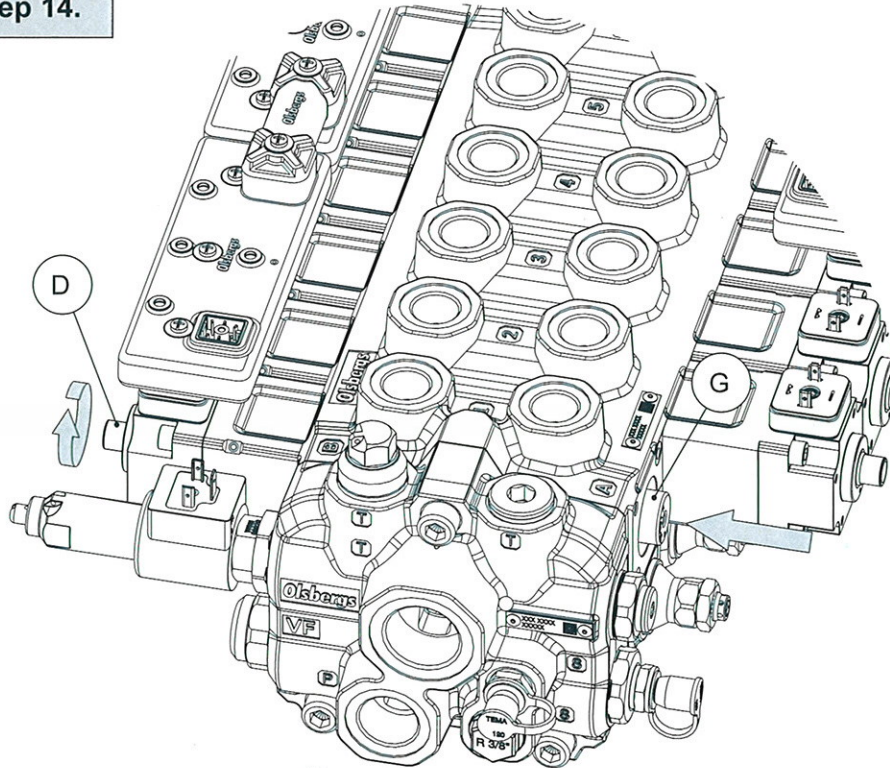
Instructions

4. In this case, we want to loosen the piston rod (C) on the A-side of the valve. So hold the piston rod (D) on the B-side steady and try with a rapid jerking motion in the direction of the arrow (E) to loosen the piston rod (C) on the A-side.
5. Unscrew the two M6 bolts (F) mounted diagonally opposite each other using the 5 mm hexagon wrench. Pull out the positioner (H) with the piston rod left inside the positioner.

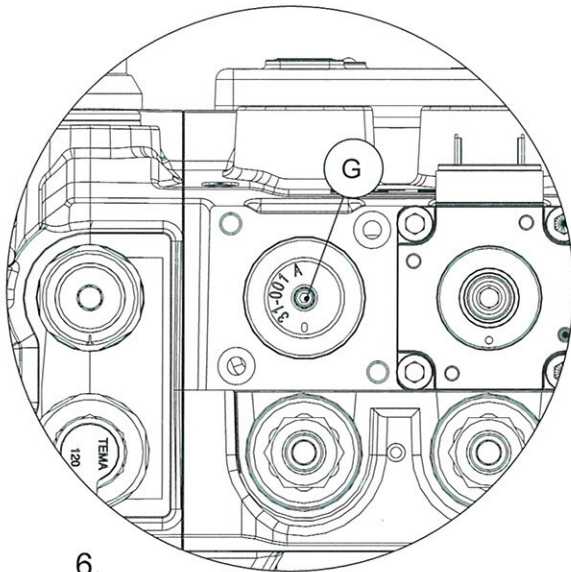
Instruction - Positioner and spool

Changing of positioner and/or spool (Page 3/7)

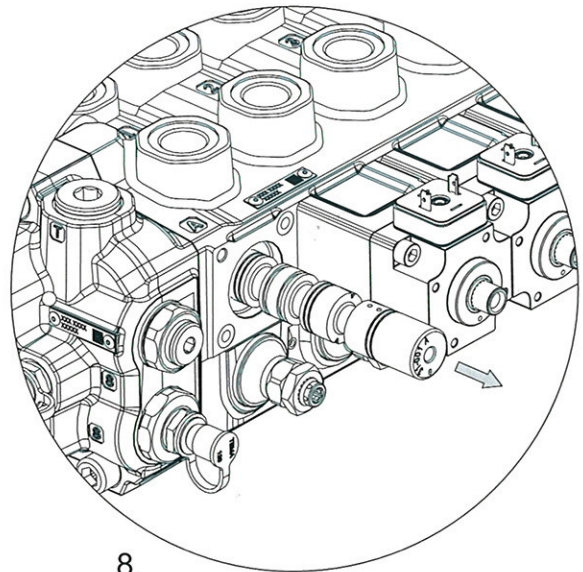
To just change
the positioner
skip to step 14.



7.



6.



8.

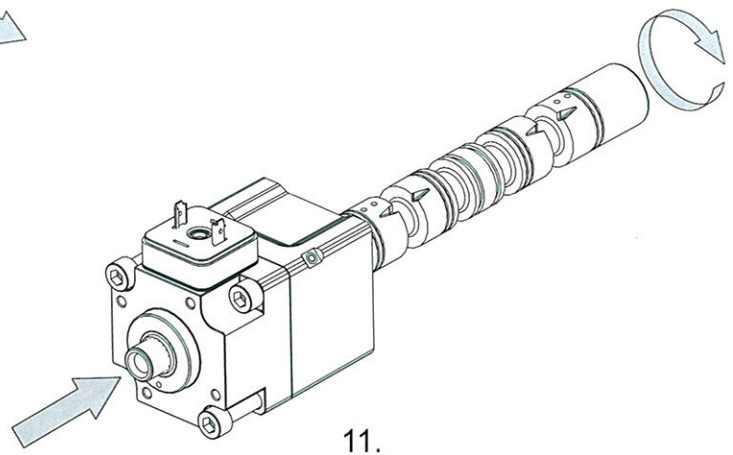
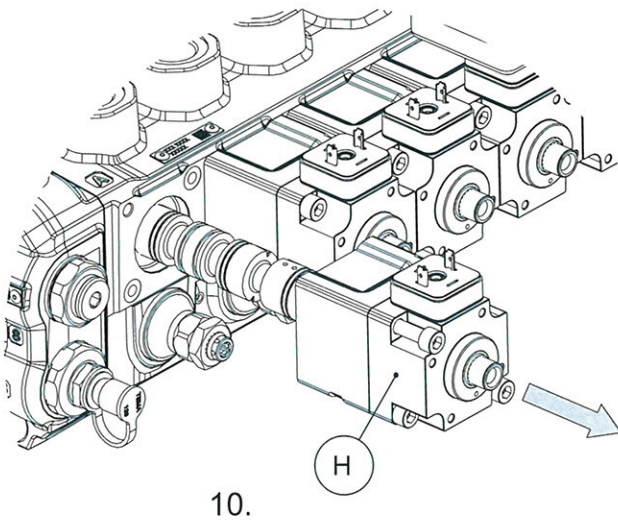
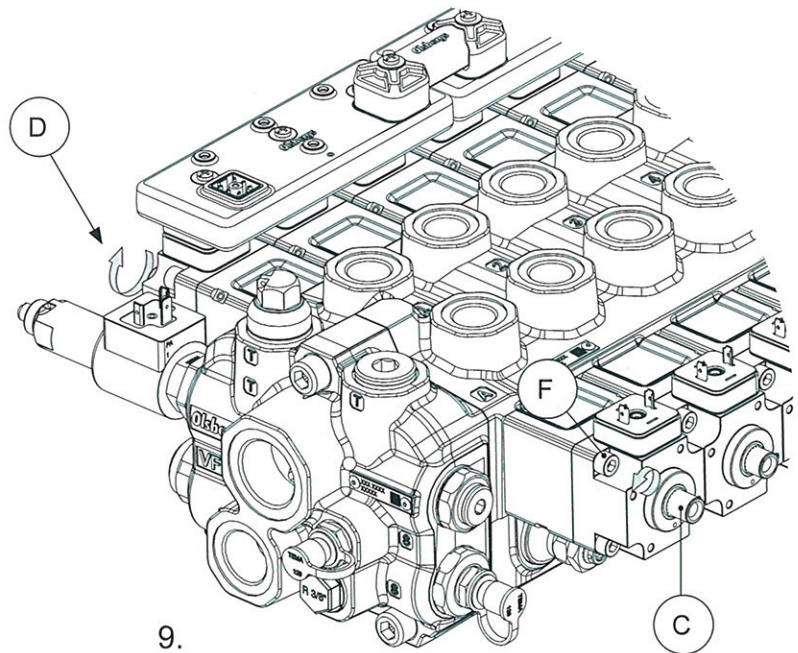
Instructions

6. Insert a 5 mm hexagon wrench in the spool end (G) on the A-side and one in the piston rod (D) on the B-side.
7. Hold the spool (G) steady (prevent it from turning) and loosen the piston rod. (D)
8. Carefully pull out the spool from the valve.

Instruction - Positioner and spool

Changing of positioner and/or spool (Page 4/7)

Always **prevent** the spool from turning in the valve house due to the risk of damage on the spool.

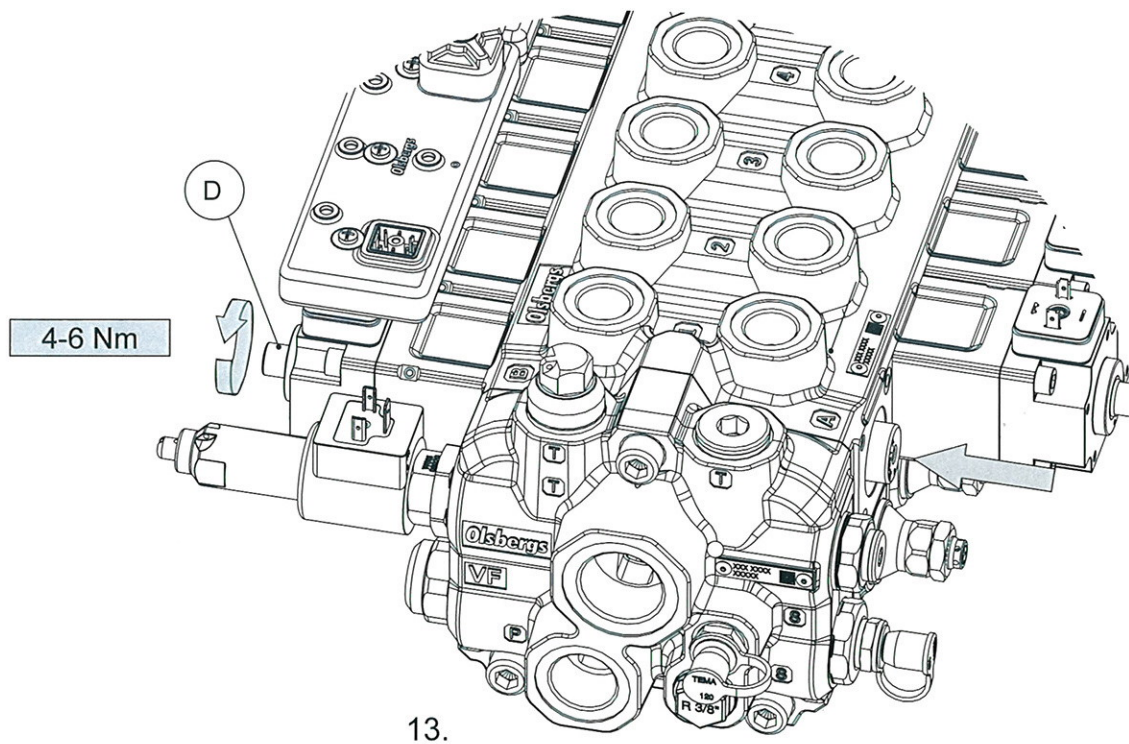
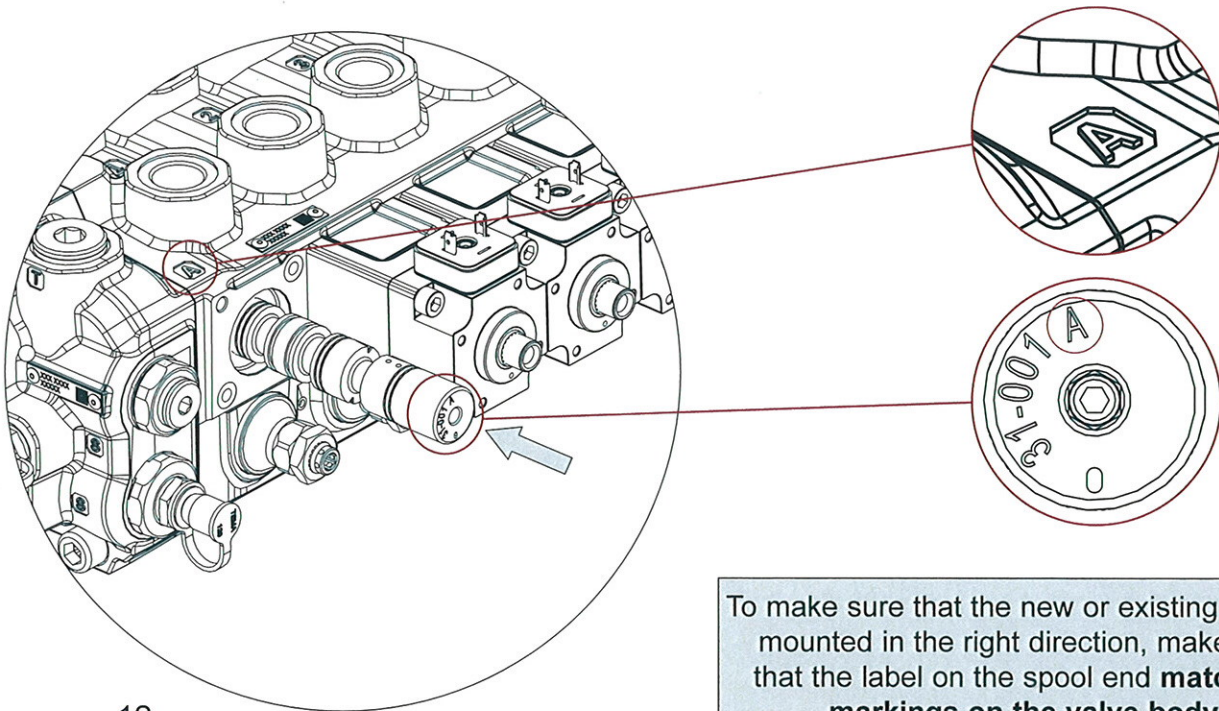


Instructions

9. In that case the wrong piston rod (D) has come loose from the spool, first loosen that piston rod (D) completely by clutching the piston rod (C) on the opposite side. Then unscrew the two M6 bolts (F) mounted diagonally opposite each other using the 5 mm hexagon wrench.
10. Pull out the whole positioner (H) with the spool attached to it.
11. Loosen the spool using two 5 mm hexagon wrenches.

Instruction - Positioner and spool

Changing of positioner and/or spool (Page 5/7)

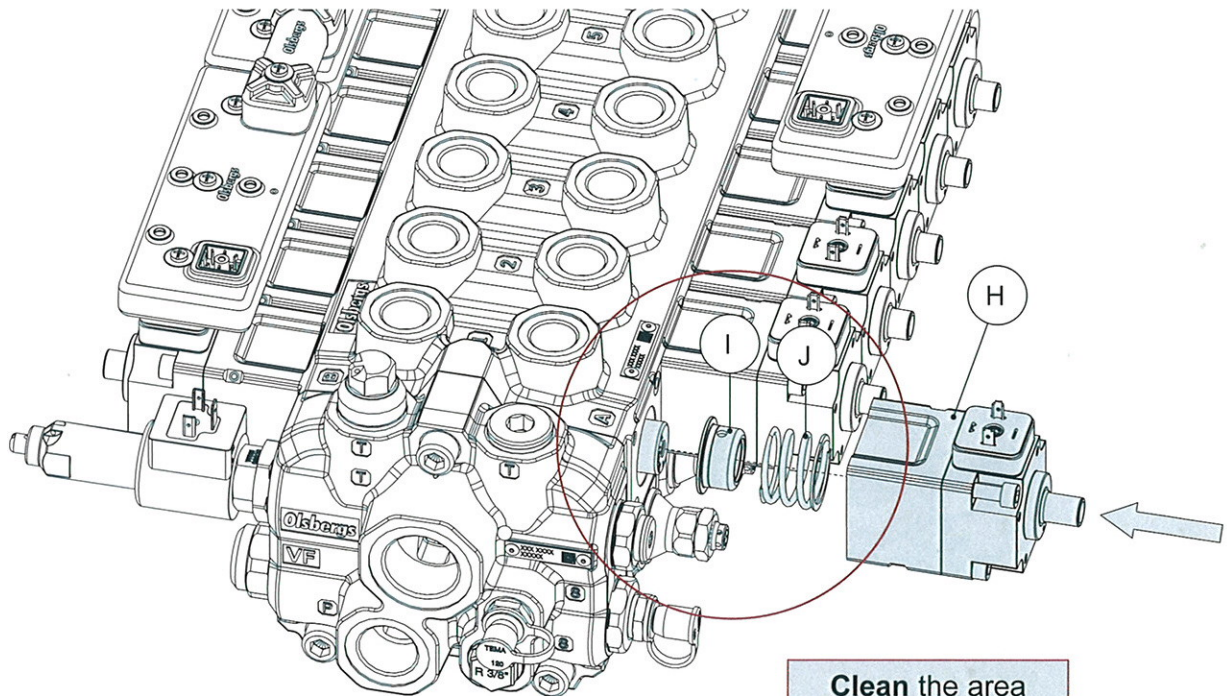


Instructions

12. Push the new or existing spool back into the valve and make sure that the label on the spool end matches the label on the valve when it's in position.
13. Use the 5 mm hexagon wrench to hold the spool **C** steady (prevent it from turning) and tighten the piston rod **D** with torque 4-6 Nm using the other 5 mm hexagon wrench .

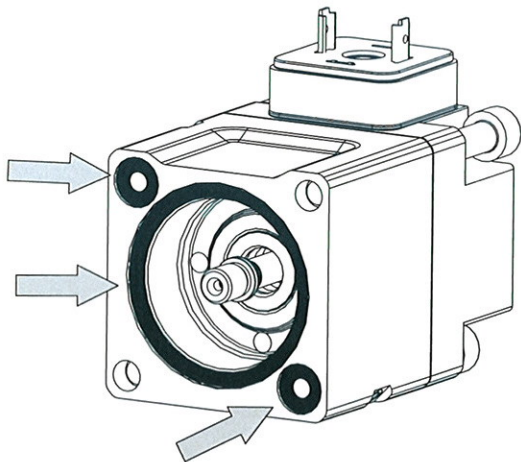
Instruction - Positioner and spool

Changing of positioner and/or spool (Page 6/7)

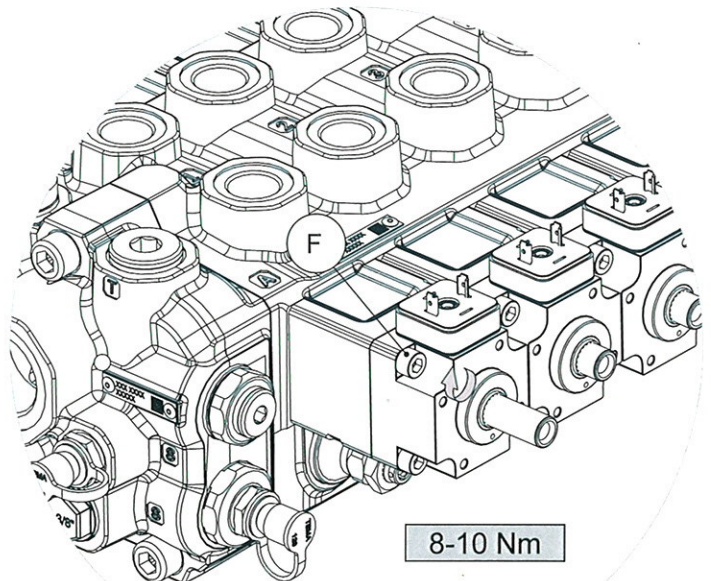


14.

Clean the area
before mounting.



Before mounting the positioner,
make sure that the three
O-rings are fitted correctly.



15.

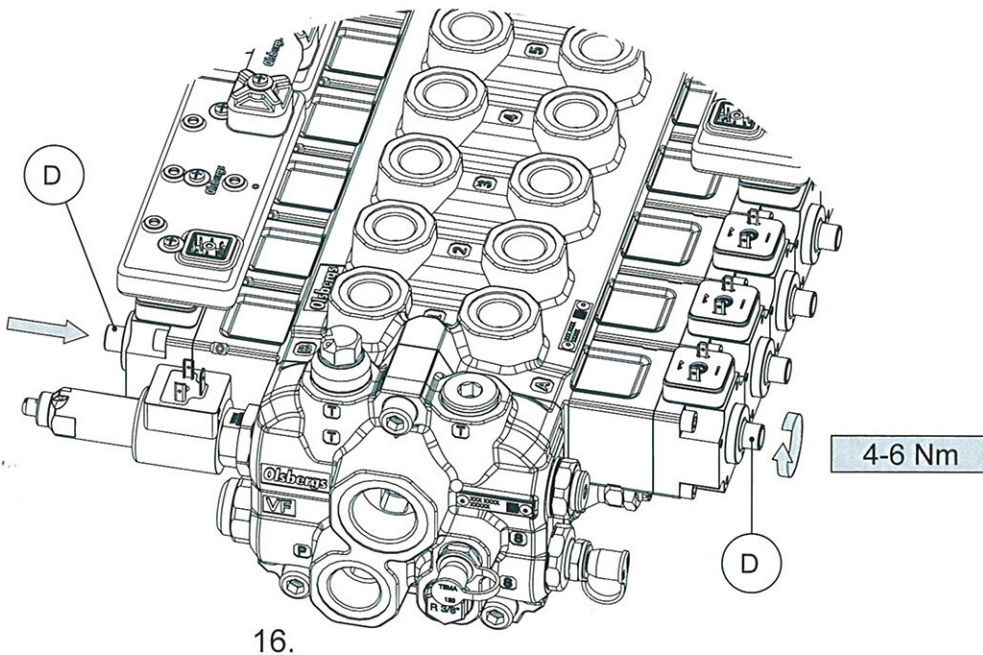
8-10 Nm

Instructions

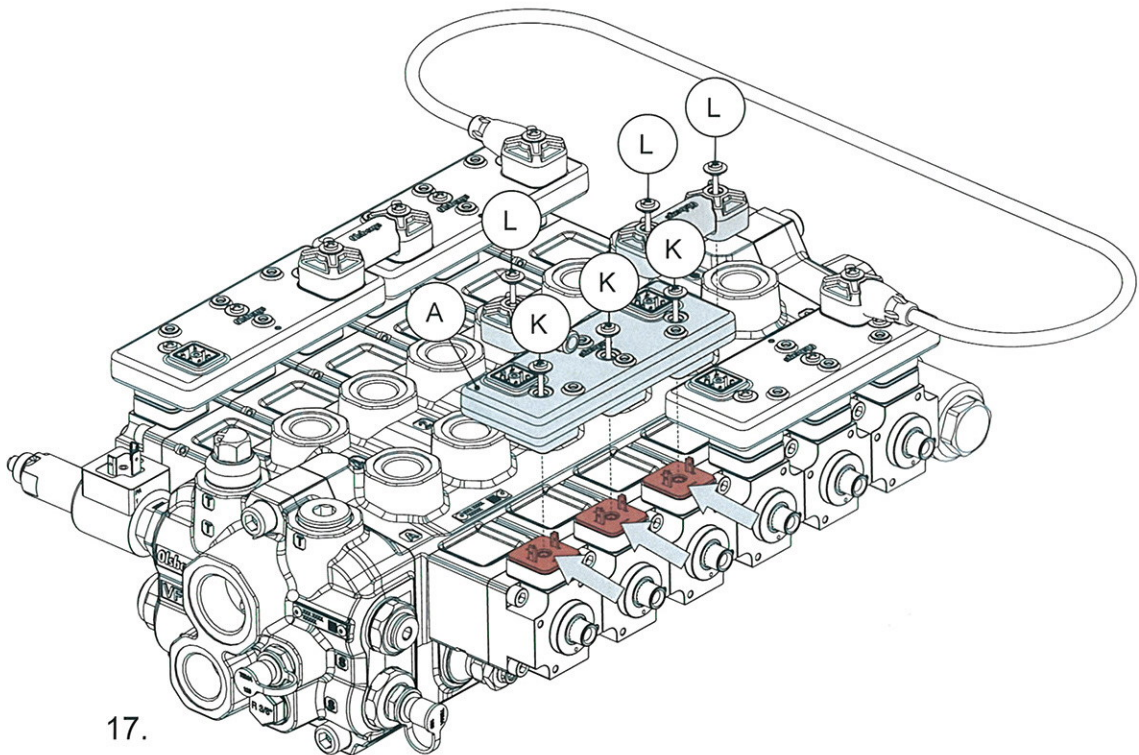
14. Mount the new or existing positioner (H), make sure that the spring holder (I) and the spring (J) inside the positioner are mounted correctly against the spool. (G)
15. Tighten the two M6 bolts (F) mounted diagonally opposite each other on the positioner with torque 8-10 Nm using the 5 mm hexagon wrench.

Instruction - Positioner and spool

Changing of positioner and/or spool (Page 7/7)



16.



17.

Instructions

16. Hold the piston rod (D) steady by using a 5 mm hexagon wrench to prevent the spool from turning inside the valve. Push in the piston rod (C) and tighten it with torque 4-6 Nm using the 5 mm hexagon wrench.
17. Before remounting DA-module (A), check the contact pins on the positioners and grease the contacts. Remount the DA-module and tighten the M3 bolts (K) very gently, using a manual screwdriver (**Do not use power tool**). Stop tightening when the resistance increases and the DA-module are tight together against the gasket on the positioner.
Grease the cable contacts / termination plugs and connector bridges before remounting. Remount the cables / termination plugs and connector bridges and tighten the M3 bolts (L) very gently, using a manual screwdriver (**Do not use power tool**). Stop tightening when the resistance increases and the cable contact / termination plug or connector bridge are tight together against the DA-module.