



EIM CONTROLS

Assembly to Valves Thrust Spool without Threaded Stem Nut

REMOVAL OF STEM NUT FROM THRUST SPOOL

Use Exploded View Drawing Number 90870 for reference.

- 1) Locate Thrust Mounting Bolts (Item 101).
- 2) Remove the eight mounting bolts and separate the spool (Item 100) from the unit.
- 3) Remove Set Screw from Lock Nut (Item 55).
- 4) Remove Lock Nut (Item 55) from spool (Item 100).
- 5) Remove Bearing Cup (Item 105).
- 6) Remove Stem Nut (Item 54) from Spool (Bearings will be attached).

REMOVAL OF BEARINGS FROM STEM NUT

- 7) Use a Draft and a Ball Pen Hammer to tap the bearings off the Stem Nut (Item 54).

CAUTION: Be careful not to mar up the seal area on the stem nut when removing bearings. Marring will cause leakage of lubricant and void the EIM Warranty.

- 8) The Stem Nut is now ready for tapping.

INSTALLATION OF STEM NUT

- 9) Place the Stem Nut and Bearings back into the spool.

CAUTION: When installing the Stem Nut, be careful of Lip Seal on Bottom Side (Use a flat screwdriver to shape the seal around the Stem Nut).

- 10) Using grease fitting (Item 102), lubricate the cavity in the spool; rotate the Stem Nut (item 54) so that an adequate amount of lubrication is spread to cover the bearings (Item 104). See: Lubricant on EIM Job Spec Sheet.
- 11) Re-install Bearing Cap (Item 105) onto the spool.
- 12) Re-install the Lock Nut (Item 55). *CAUTION: Be careful not to cut the O-Ring inside the Lock Nut.*
- 13) **Secure the Lock Nut (Item 55) to original position so that the Set Screw can be re-installed.** NOTE: If Set Screw was never installed perform the following: Drill Set Screw after securing Lock Nut (Item 55). Center punch between Spool and Lock Nut. Use a Letter "I" drill bit and go ½" deep, tap with a 5/16-24. Install Set Screw (109).
- 14) Re-install the Set Screw. (Use Locktite Sealant)
- 15) Refer to installation of the **Thrust Spool with Threaded Stem Nut** for remainder of the installation procedure.

4/30/09



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Assembly to Valves Thrust Spool with Threaded Stem Nut

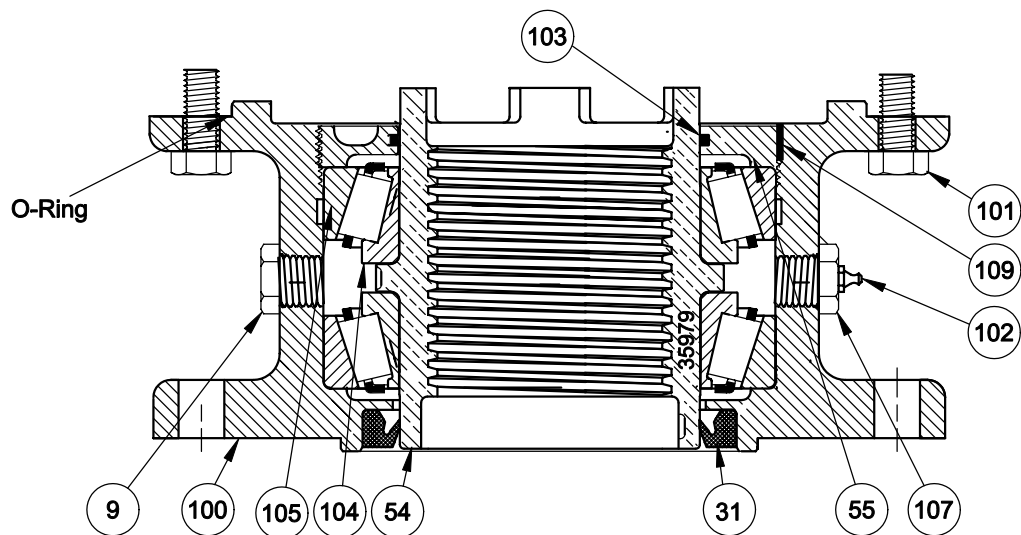
INSTALLATION

Use Exploded View Drawing Number 90870 for reference.

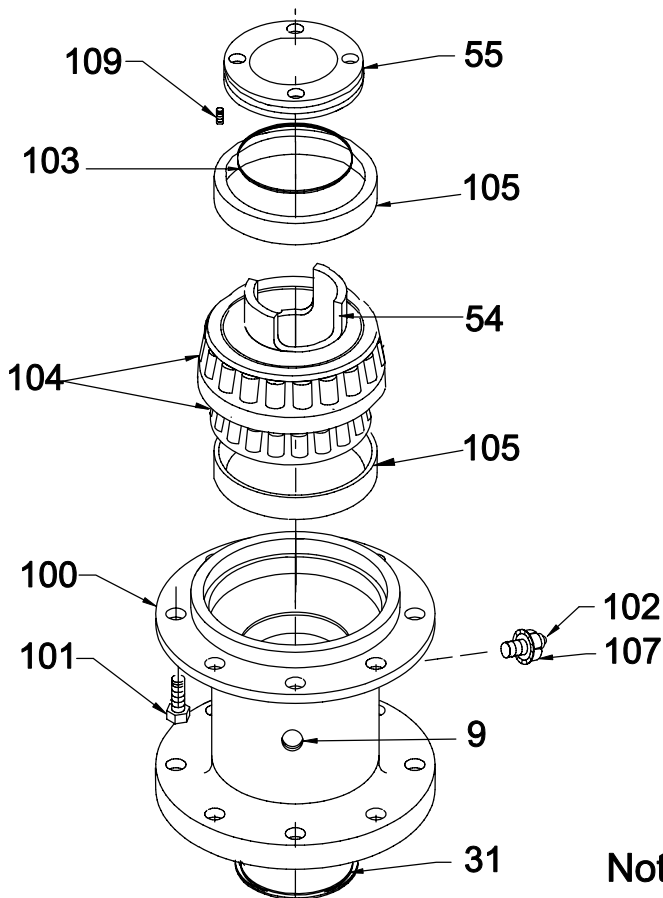
- 1) Locate Thrust Mounting Bolts (Item 101).
- 2) Remove the eight mounting bolts and separate the spool (Item 100) from the unit.
- 3) Position the spool (Item 100) over the valve stem. Thread the spool (Item 100) onto the valve stem until it meets the valve plate.
- 4) Bolt and secure the spool (Item 100) onto the valve.
- 5) Position the actuator above spool. Lower the actuator onto the spool while manually rotating the unit until the ears on the stem nut (Item 54) and the ears on the main drive sleeve mesh.
- 6) Grease the Flange Face if needed before securing unit to spool.
- 7) Re-Install thrust plate mounting bolts. Tighten to proper torque.

- NOTE: Reverse procedure if the stem nut needs to be replaced. Unit does not need to be returned to factory for this procedure.

4/30/09



Cut-Away View



Exploded View

Thrust Base Parts

Item	Description
9	Plug 1/2 NPT
31	Lip Seal
54	Stem Nut
55	Bearing Lock Nut
100	Thrust Base
101	Mounting Screw
102	FTG 1/8 PTS
103	O-Ring
104	Thrust Base Cone
105	Thrust Base Cup
107	RDR 1/2 x 1/8 NPT
109	Set Screw

Note: Secure the Lock Nut with Set Screw
(See: Installation of Stem Nut, Instruction #13)

ERO 16614



EIM COMPANY, INC.
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Thrust Base

DESCRIPTION

THRUST BASE ASSY

DWN LHE/CL	ORIG DATE 10/27/04	APRD	REVISED DATE 4/30/09
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